

Longitudinal seam welding machine

LINEARWELD INEX 6200



Figure 1: LINEARWELD INEX 6200 with elevating unit (option)

The new machine series LINEARWELD is the current pinnacle in the development of longitudinal seam welding machines at Schnelldorfer Maschinenbau. These are the result of over 25 years of experience in high class welding.

LINEARWELD INEX 6200 is our large scale seam welder providing an overall welding length of 6200 mm. The special INEX configuration with sloping clamping elements and a compact torch carriage design is designated for internal and external tube welding. With its high clamping pressure the machine is designed for a material thickness of up to 15 mm.

Due to its highly modular model structure and a selection of customizing features, the machine can be configured to your specific production requirements.

HIGHLIGHTS



Figure 2: Mandrel latch, pneumatic actuated



Figure 3: LOTO points, compressed air, cooling water, welding gases, electric power



Figure 4: Easily accessible pneumatic control unit



Figure 5: LINEARWELD INEX 6200 with elevating unit (option), internal tube welding



Figure 6: Electrical cabinet

TECHNICAL DATA

Machine Type	LINEARWELD INEX 6200
Welding length	6200 mm
Tube-Ø	600 mm – 1600 mm
External welding	
Tube-Ø	1600 mm – 6000 mm
Internal welding	
Material thickness	1,5 mm - 15,0 mm
Material	Stainless Steel, Mild Steel, Galvanized Steel, Aluminum, Copper, Brass, Titanium
Welding process	TIG / GTAW, Plasma, Plasma keyhole, MIG/MAG, InFocus
Forming gas	Welding gas, Backing gas, Trailing gas
Torch travel speed	10 cm/min – 770 cm/min
Mandrel latch	Pneumatically, Position control
Backing bar	CuCrZr or Stainless Steel
Clamping fingers	CuCrZr or Stainless Steel
Clamping system	Pneumatically with pre-clamp feature
Arc length	Consistently over the entire welding length
Cooling circuit	Backing bar (mandrel), Torch
Control unit	Siemens S7 ET200S
Operator interface	Siemens Comfort Panel 7"
Motor	Siemens Simodrive
Interface current source	Profibus
Standard	CE-Mark
Electrical supply	400/230 Volt / 3 / N / PE 50 Hz
Pneumatic supply	6 bar, dry, filtered
Ambient temperature	+ 10°C to + 35°C
Colour	On customer request

OPERATOR INTERFACE



Figure 7: Automatic menu

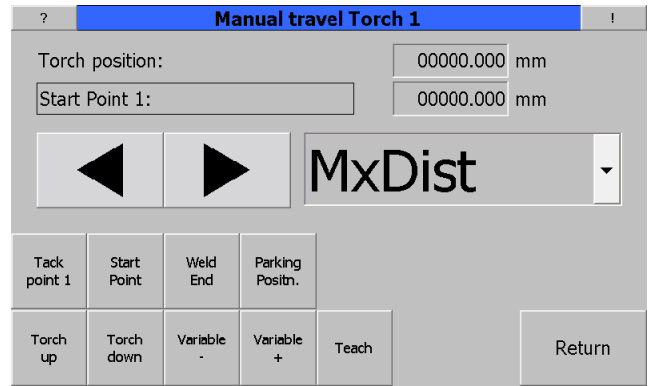


Figure 8: Manual drive menu

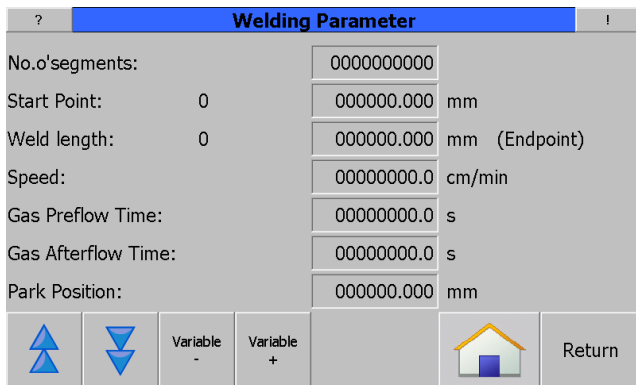


Figure 9: Movement setting menu

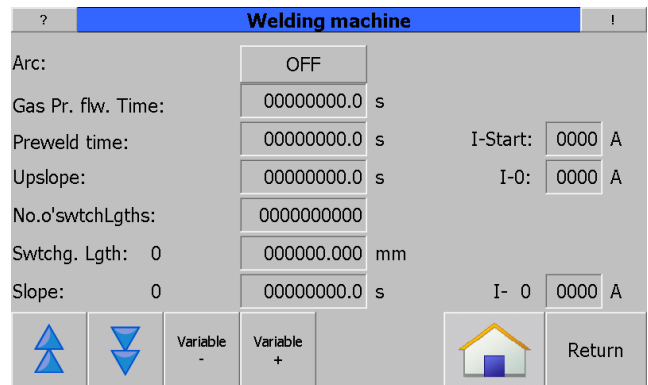


Figure 10: Welding parameter setting menu

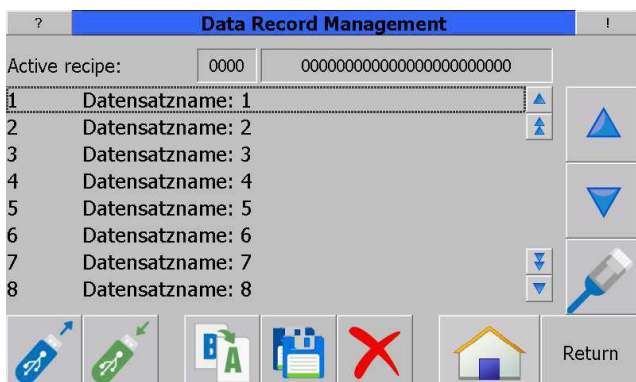


Figure 11: Data storage management for welding procedures, password protected (optional)

EQUIPMENT (OPTION)



Figure 12: Retracting backing bar, down



Figure 13: Retracting backing bar, up



Figure 14: Machine Control, Remote unit

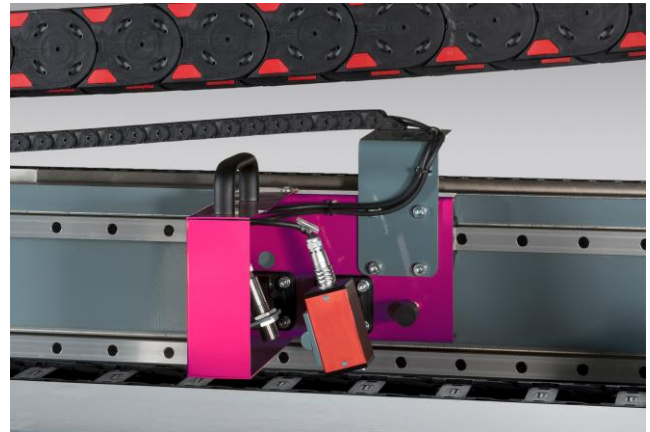


Figure 15: Welding / Support CAM



Figure 16: InFocus-Torch

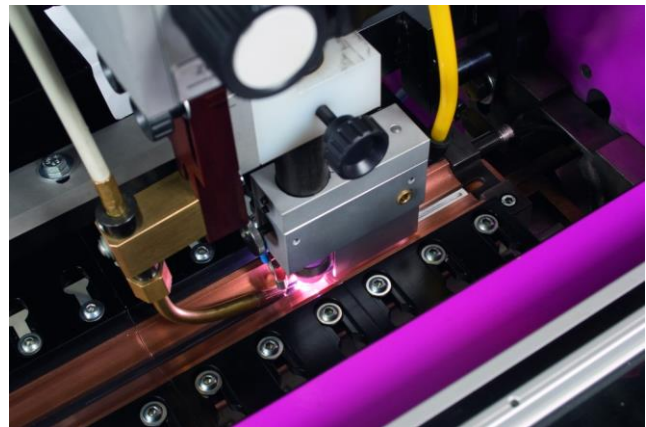


Figure 17: Coldwire unit with wire guidance

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Figure 18: Centre mark with laser pointer



Figure 19: Pneumatic centre stop movable



Figure 20: electrical elevating unit, lower position



Figure 21: electrical elevating unit, upper position



Figure 22: HKS Welding data monitoring system

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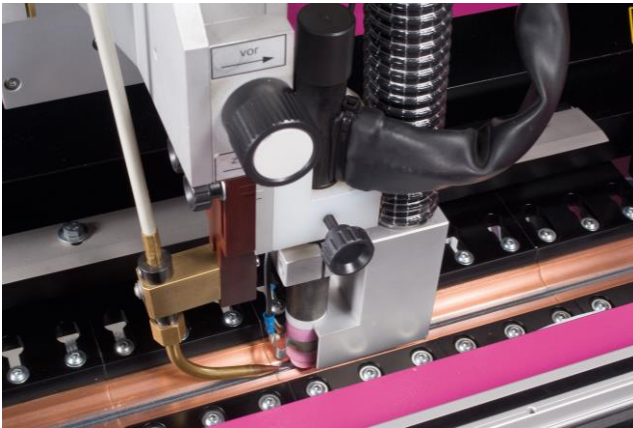


Figure 23: Welding fume extraction

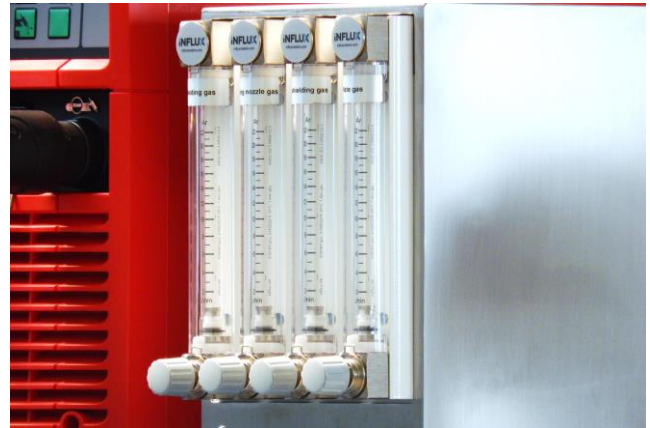


Figure 24: Calibrated flowmeter (rotameter)

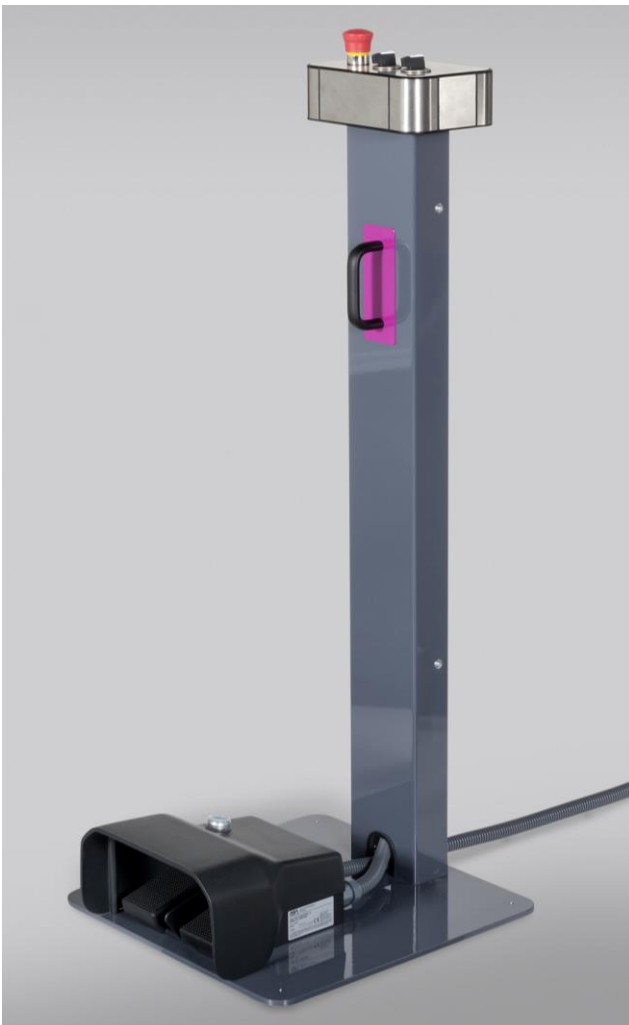


Figure 25: Foot pedals with operator panel



Figure 26: Bumper bar



Figure 27 Insertion fit up truck with LINEARWELD INEX 6200

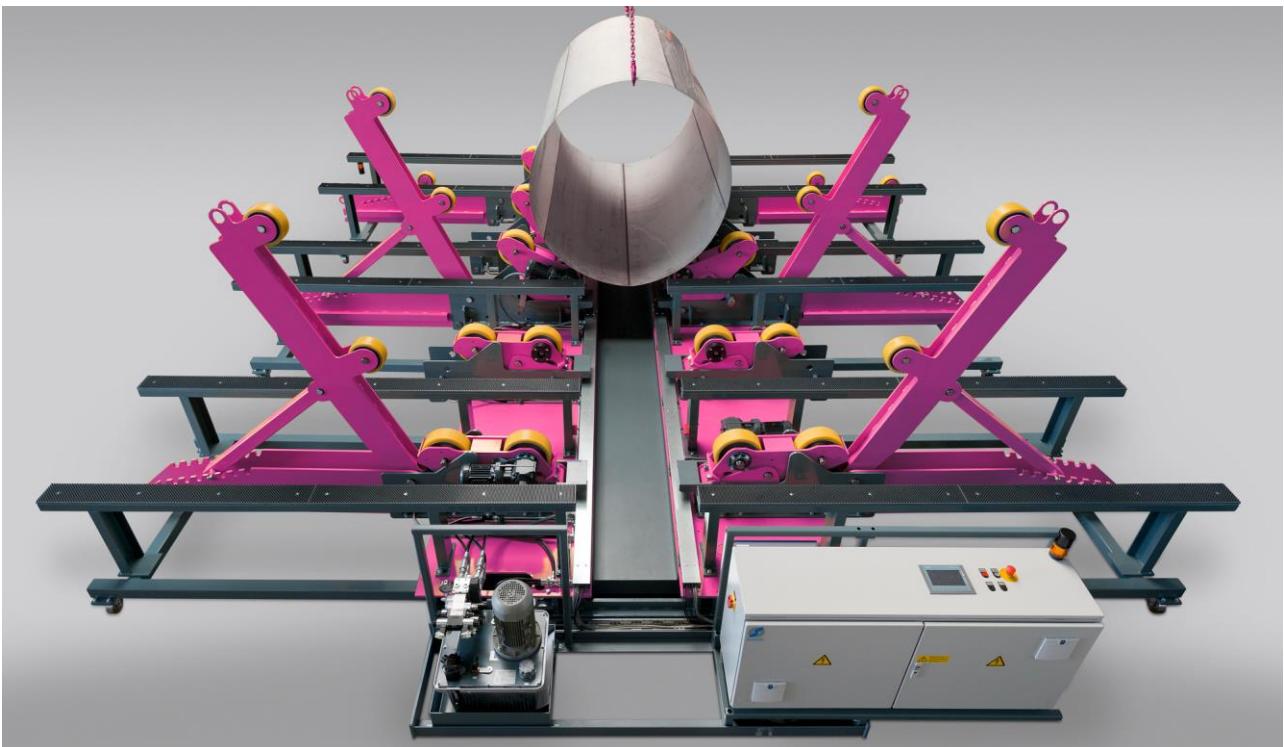


Figure 28 Insertion fit up truck

REFERENCES



LINEARWELD Longitudinal welding machine



NOTES

WELDED COMPONENTS

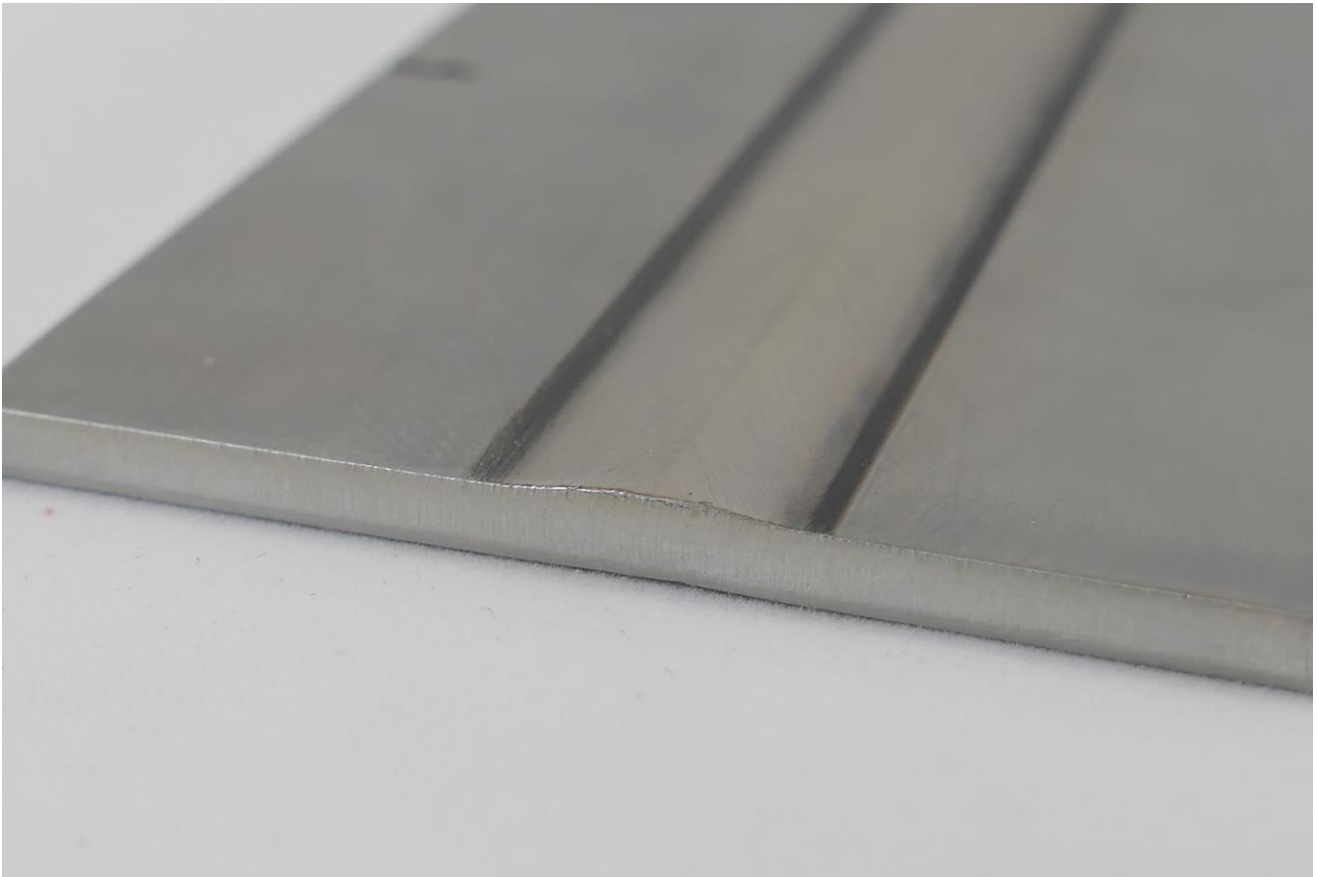


Figure 29: InFocus, High Performance TIG weld, Stainless Steel $t = 6$ mm

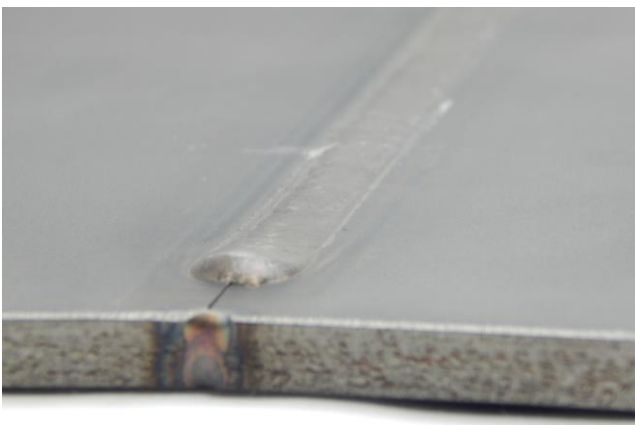


Figure 30: Plasma-Keyhole weld,
 $t = 8$ mm



Figure 31: Plasma-Keyhole micrograph, $t = 8$ mm