



## CLADDING

### CNC cladding machine model PC600-3 - NEW TIGer technology.

The TIGer technology is the outcome of a technological development, a variant of TIG Hot wire welding. The characteristic of this bi-cathode arc makes this process extremely well adapted to cladding applications.

Depending on the applications, classic HW TIG or TIGer (bi cathode) process can be used.

### Areas of application

Horizontal and vertical cladding : internal and external cladding and anti-corrosion weld overlay of tubes, pipes, rings, flanges, nozzles, fittings, valves, manifolds etc.

<b>Minimum inner diameter after cladding</b>		
	HW TIG	TIGer
Without camera	ID min 35 mm	//
With camera	//	ID min 100 mm
<b>Maximum inner diameter : 1500 mm</b>		
<b>Maximum weight : 5000 kgs</b>		

<b>Dimensions of lances</b>	
ID 38	L 1000 mm for min ID 35 mm
TIGer	L 1500 mm for min ID 100 mm
WP27	//

<b>Thickness of the layer: between 1.5 and 3.5 mm</b>
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WELDING FORGING SERVICE SRL

Sede Legale: Via Galleria al duomo, 11 - 36015 Schio (VI)

Sede Amm.va: Piazza Martiri della Libertà, 3/B - 36011 Arsiero (VI)

Sede Operativa: Via Dell'industria, 8 - 36030 Caltrano (VI)

Telefono: 0445-1920874 - Indirizzo email: info@wfservice.it - C.F./P.I. 03945990244 - R.E.A. VI 366805



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## MATERIAL

Workpiece material: carbon steel

Wire material: Inconel, stainless steel...

Wire diameter: 1.2 mm

## EQUIPMENT

The cladding machine is equipped with:

**System control:** the machine itself is micro-processor based supported by a high precision “quartz clock” time base and has on-board memory capacity to store up to 100 individual welding cycles depending on size and complexity.

**Positioner:** to rotate the work pieces. Capacity 5000 kgs, faceplate 600 mm , T-slotted. Rotation motor and drive controlled by the power source. Included in the positioner, 1 off simple pipe support to suit positioner centre height, with ball bearing rollers & adjustable height.

**Video camera:** a camera is installed in the machine, with possibility to get a video of of welding operations.

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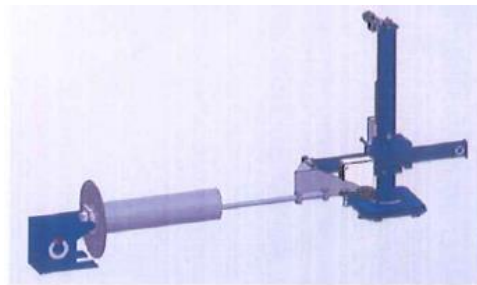


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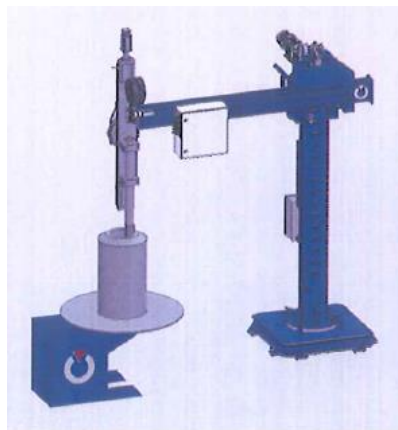
## Welding positions

Welding position: rotating workpiece – 1G / PA & 2G / PC. Workpiece axis can be in horizontal & vertical position.

Horizontal position 1G:



Vertical position 2G :



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## QUALIFICATIONS

TIGer:

PQR – WPS : ASTM A694 F52 / F60 / F65  
ASTM A105 / LF2  
SA266

TIG:

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