

Strip Cladding for Larger areas



Strip Cladding Applications



Pressure vessel

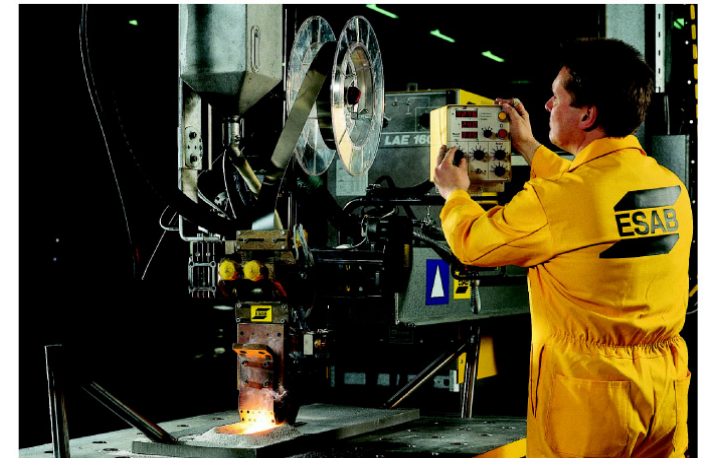
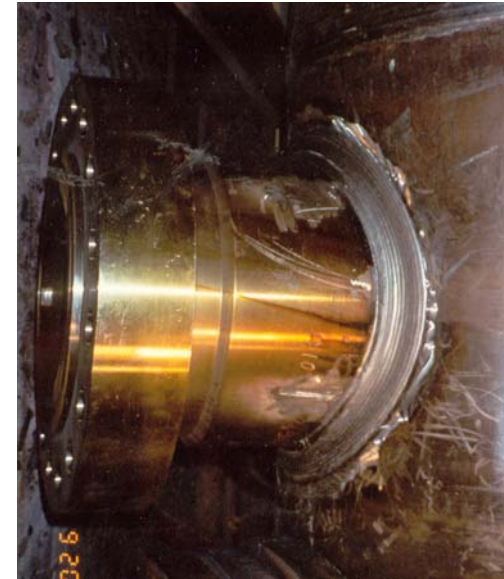
Nozzles

Dish ends

Plates

Pistons

Shafts



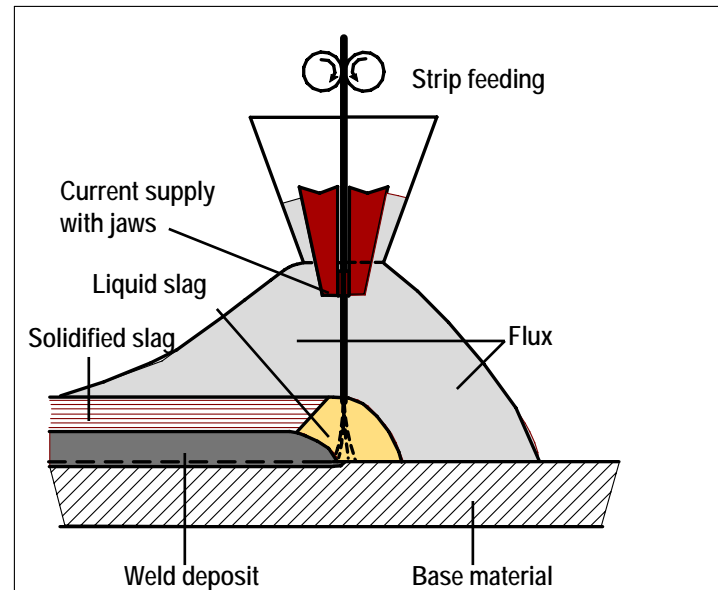
Submerged Arc Strip Cladding



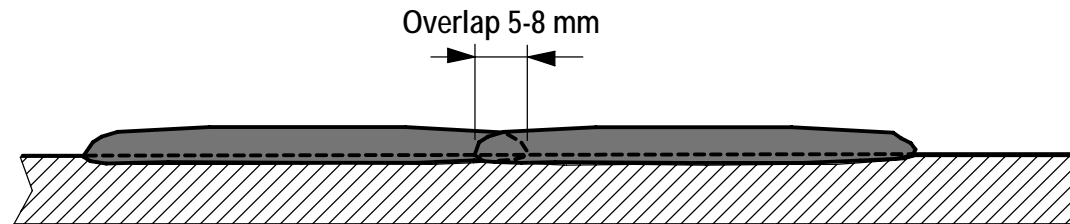
Conventional Method for Cladding of larger areas

Features with Submerged arc cladding

- Increased deposition rate and area coverage compare to other arc processes
- A6 standard modular system available for SAW cladding



HC Strip cladding head



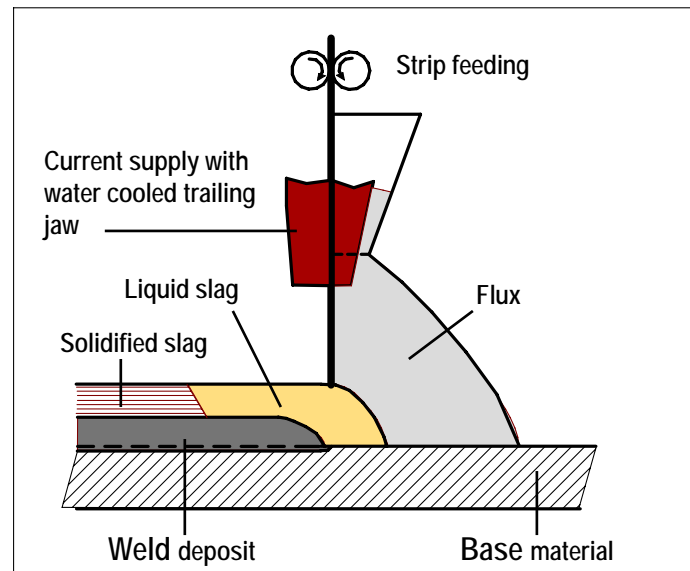
Resistance Electroslag Strip Cladding



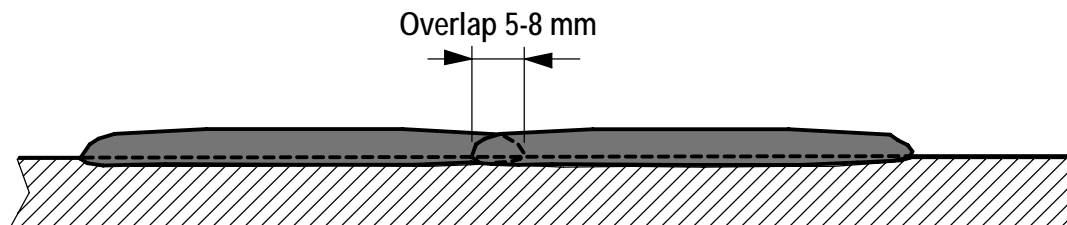
High Productive Cladding of larger areas

Features with the RES cladding process compared with SAW cladding

- Increased deposition rate by 60 to 80 %
- Increased cladding speed (50-100%) resulting in a larger area coverage per hour
- Less dilution from from base material due to less penetration
- Less risk for porosity due to lower solidification rate of the weld metal



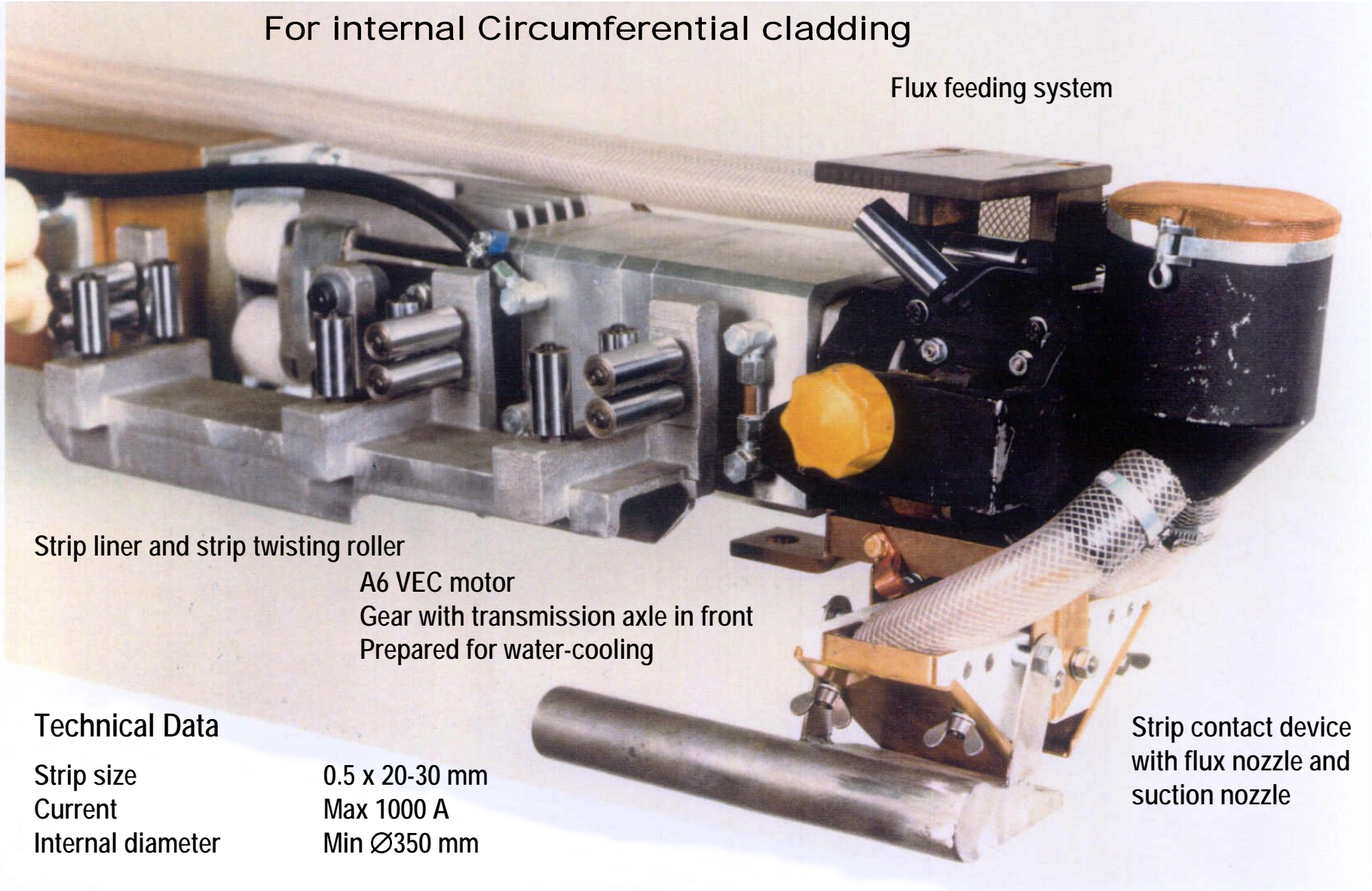
A6 - RES Strip cladding head



Compact Cladding head

For internal Circumferential cladding

Flux feeding system



Strip liner and strip twisting roller

A6 VEC motor

Gear with transmission axle in front

Prepared for water-cooling

Technical Data

Strip size

0.5 x 20-30 mm

Current

Max 1000 A

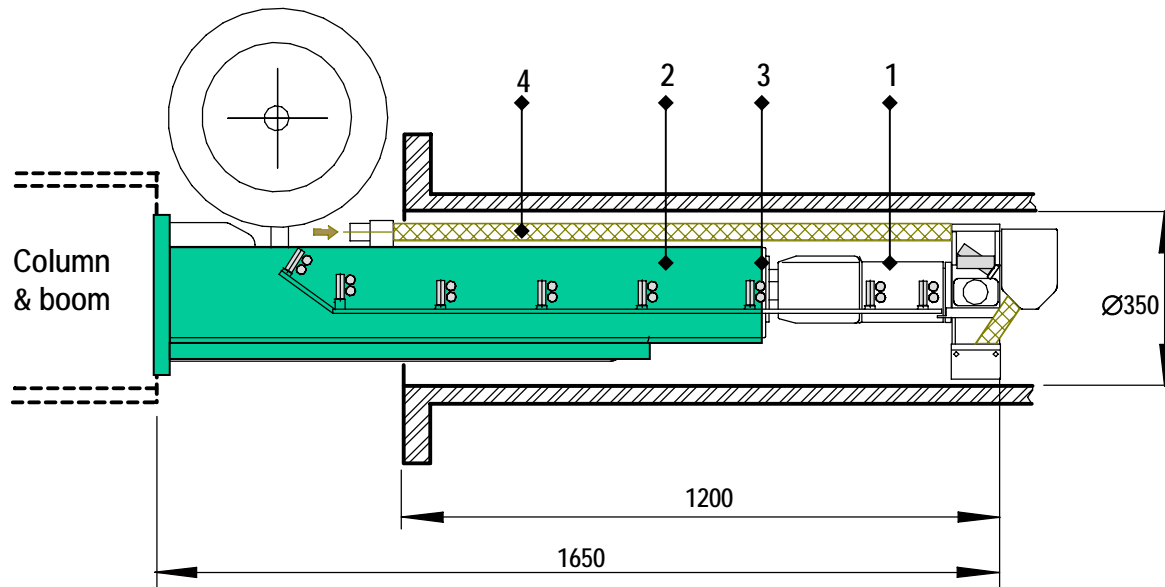
Internal diameter

Min \varnothing 350 mm

Strip contact device
with flux nozzle and
suction nozzle

HC350 Compact Cladding head

For internal Circumferential cladding



1. HC 350 Strip Cladding head consisting of:

- Strip contact device and strip twisting roller
- 1 L flux hopper, flux and suction nozzle
- A6 VEC motor, gear with transmission axle in front
- Prepared for water-cooling
- Strip liner length 1.5 m
- Strip reel 30 kg

2. Extension boom

- For reach 1.2 m inside 350 mm

3. Joystick controlled motorized cross slide

- Range 60x60 mm permit access ID 500 mm
- *Not shown on the sketch*

4. Flux handling system

- 4.1 Flux feeding system with TPC 75 flux tank
- *The 1L-flux hopper requires continuous flux feeding*

- Complete Flux feeding and Recovery system, see separate data sheet FFRS 1200

Technical Data

Strip size	0.5 x 20-30 mm
Current	Max 1000 A
Internal diameter	Min Ø350 mm

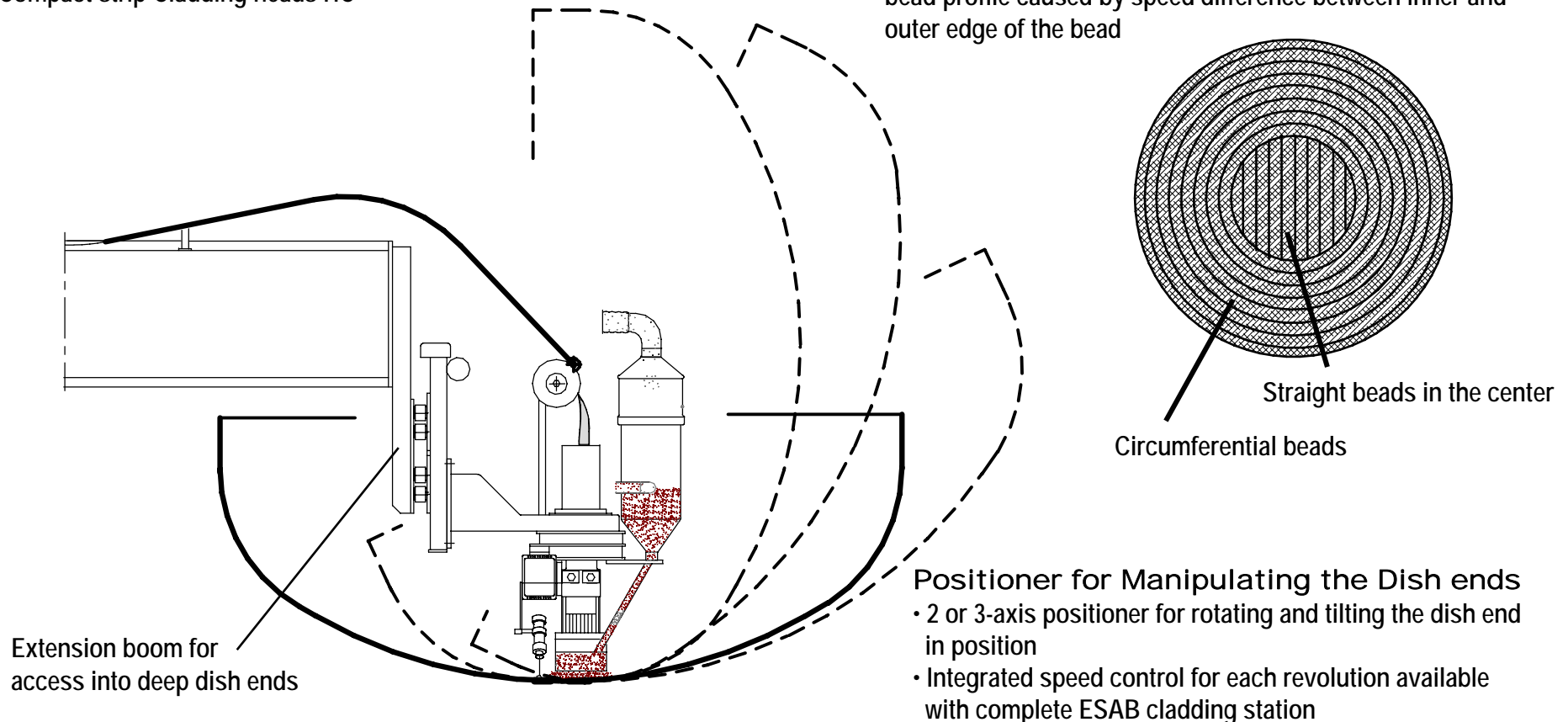
Strip Cladding of Dish ends

Welding & Strip Cladding Station

- Column & Boom with integrated welding and cladding equipment and work piece manipulator
- Basic standard Cladding heads A6
- Compact strip Cladding heads HC

Strip Cladding of Spherical Dish ends

- Start in the center with straight beads, cladding a diameter of approx. \varnothing 500 mm
- Note! Correspond to strip width 60 mm, to avoid uneven bead profile caused by speed difference between inner and outer edge of the bead



Positioner for Manipulating the Dish ends

- 2 or 3-axis positioner for rotating and tilting the dish end in position
- Integrated speed control for each revolution available with complete ESAB cladding station