

WELDCRAFT BUTT WELDING MACHINES

WELDCRAFT takes pleasure in introducing for the benefit of the entire wire and cable processing industry as well as metal working industry a new series of efficient machines for Butt-welding of all profile wires of Iron, Steel, Alloy and Carbon Steel, Copper, Aluminum, Brass and other light metals and their alloys. Our machines specially designed for the Butt-welding of ferrous and non-ferrous wires in the range of 0.5 -16 mm diameters to withstand subsequent drawing. These machines are designed as portable models mounted on a movable stand with foot operation.



GENERAL: 'WELDCRAFT' Butt Welding Machines eliminate the outdated method of Brazing over – lapped joints for Band-Saw Blades, Wires, Strips, etc. It avoids the use of solder, flux and foreign material at the joint. The process is quick and automatic giving the perfect and strong weld. Butt Welding is the most modern resistance welding process which gives joint strength even 25% higher than the parent metal.

WELDING PROCESS: The ends of the Blade/Wire to be joined are cut straight exactly at right angle and free of burrs. Welding Pressure, Current & Upsetting (Initial opening gap) are set accordingly to size of the job. The blade ends are then rigidly clamped in the center of the gap. (Ends should be in touch)

WELDING CYCLE: The cycle starts by turning the Upsetting – Way Switch clockwise and depressing the switch 'Welding' marked position by pressing switch downwards the welding cycle starts and the two ends are heated up to forging temperature in few seconds and automatically forged. At this instant the welding current switches off automatically and the job is welded.

ANNEALING OPERATION: The Upsetting – Way switch or cam is turned to ‘Annealing’ position marked, the welded job is again clamped in the centre of extended jaw distance, and here jaws are opened maximum. Now press the push button / annealing switch, the job is annealed, in order to normalize the brittleness in welded zone. Depending upon the type of material and the hardness the annealing process must be repeated several times, if needed.

CAUTION: NEVER PRESS BOTH WELDING SWITCH AND ANNEALING SWITCH SIMULTANEOUSLY.

SHEARING & GRINDING ATTACHMENTS: Available at EXTRA COST.

TECHNICAL SPECIFICATION: WIRE BUTT WELDING MACHINES

TYPE	MB					BW		WB	UBW				
Model	0515	825	0720	830	0130	15	154	5	8	12	15	20	25
Weld ability MS/HCS	0.5 – 2.0	0.8 – 2.5		0.8 – 3.0	1.0 – 3.5	1.5 – 4.5	1.5 – 5.5	2 – 8	2 – 10	2 – 8.0	3 – 12	4 – 13	5 – 16
Copper/ Brass	0.5 – 1.5		0.7 - 2.0		1.0 – 2.0	1.5 – 3.0	1.5 – 3.5	2 – 5		2 – 5.5	2 – 6.5	3 – 8	4 – 10
Aluminum & Alloy	0.5 – 1.5		0.7 - 2.0		1.0 – 3.0	1.5 – 4.0	1.5 – 4.5	2 – 5		2 – 6.0	2 – 7.0	4 – 10	5 – 12
Mains Supply	Single Phase 220 / 240 Volts, 50C/s.							415 Volts, 2 Lines of 3 Phases, 50C/s.					
KVA - Rating	1		2	3	3	4	5	8	12	15	20	25	
Fuse Amps	7		10	15	13	15	20	15	20	25	40	50	
Output Taping	16					6			6				
Net Weight	15.5		20		25	30	60	75	80	85	150	170	

TECHNICAL SPECIFICATION: BUTT WELDING MACHINES (FOR SPECIAL PURPOSE – STRIPS AND BLADES)

TYPE	MB	BW	WB	UBW	
Model	515	325	7.5	15	30
WELD MATERIAL	HCS Metallic Carding Blades Reed Wires.	Blades / Flat Strips 3 – 25 mm in Width	G.I. Strips and Bi – Metal Blades Up to 40 mm	G.I. Strips and Bi – Metal Blades Up to 50 mm	G.I. Strips Up to 80 mm
Mains Supply	Single Phase 220 / 240 Volts, 50C/s.		415 Volts, 2 Lines of 3 Phases, 50C/s.		
KVA - Rating	1	3	7.5	15	30
Fuse Amps	7	13	15	20	30
Output Taping	16	6	6	6	6
Net Weight	15.5	25	65	85	95

Other Products:

- AC/DC Transformers
- Rectifiers
- Stud Welders
- Butt Welders
- Accessories / Spares
- Spot Welders
- Cr Cu Electrodes / Tips



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