




PolyClad TWIN-TIG^{er} L TIG^{er} rig: Longitudinal internal weld overlay

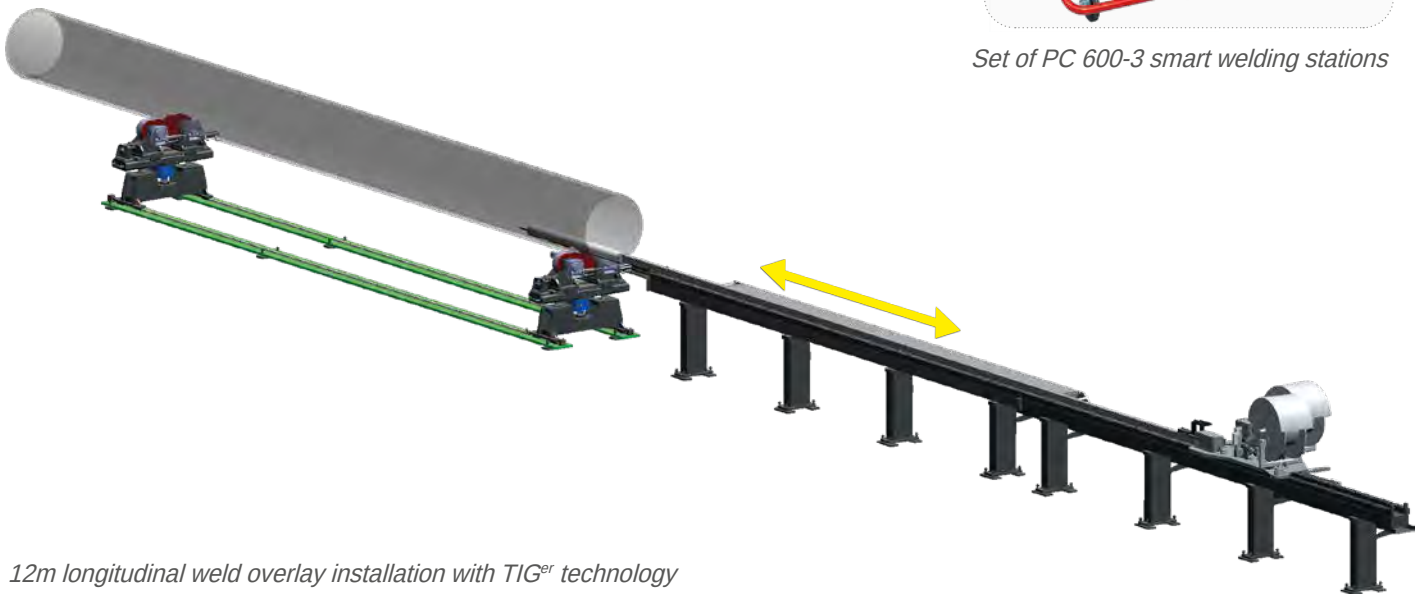


▶ Advantages

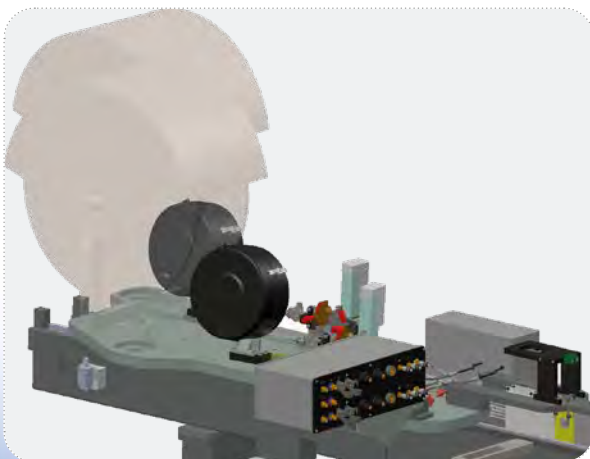
- A unique solution for the longitudinal seam weld overlay of metallurgically bonded pipes from the inside (after welding from outside and remachined root ⁽¹⁾)
- Perfectly smooth quality of the cladded surface
- Integrated compensation management of the welded joint twist
- Reduced deformation
- Full-length weld overlay
- TIG^{er} high deposition rate & high productivity
- Very low dilution rate
- Process: 



Set of PC 600-3 smart welding stations

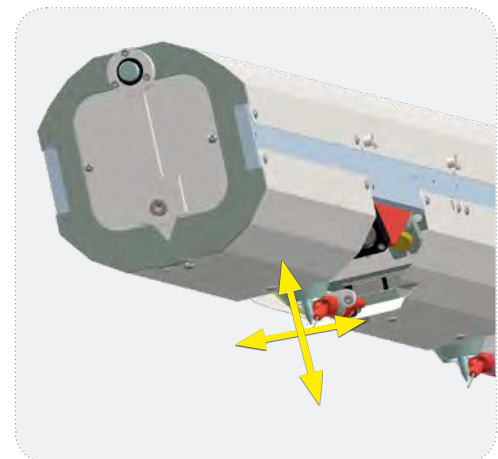


12m longitudinal weld overlay installation with TIG^{er} technology



Travel carriage, wire feeding assembly and connection plate

(1) Not part of Polysoude supply



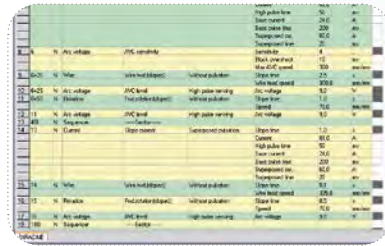
AVC/OSC slides for each torch

► Systems Control Centre

Delivered with the installation

► Equipment includes

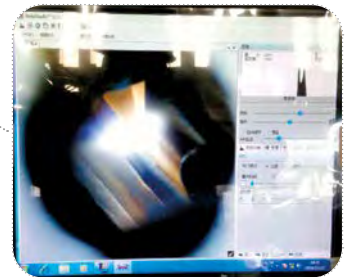
- Installation main frame
- 12m TWIN-TIG^{er} lance
- Travel carriage
- Pipe orientation roller assembly
- Set of two PC 600-3 smart welding stations
- Systems Control Centre - SCC



Weld overlay programming software (weld overlay parameters)



CNC operator programming interface



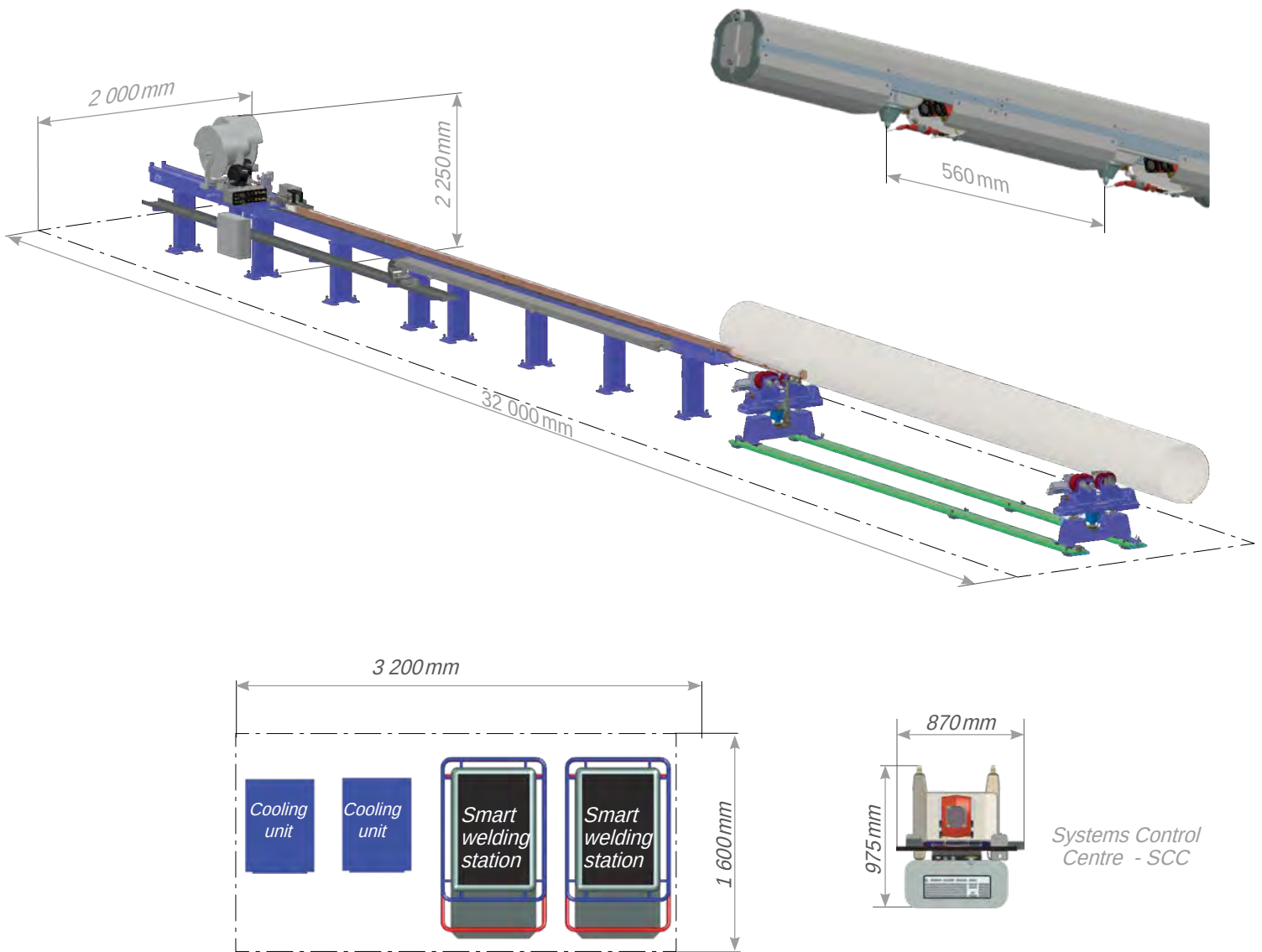
Video system: Wide dynamic video for real time monitoring

► Technical data

Tube	
O.D. max.	580 mm (24")
I.D. min.*	180 mm (6 1/2")
Length	12 m
Width of the seam to be clad	10 to 25 mm
Distance between torches 1 & 2	560 mm
AVC stroke (independant for each torch)	15 mm
OSC stroke (independant for each torch)	40 mm (± 20mm)
Wire feeder	0.4 to 14 m/min
Compatible with wire spool	Ø 760 mm - 250 kg or Ø 300 mm - 15 kg
Video	1 camera per torch

* Before weld overlay considering 2 layers

► Layout and utilities



Utilities	
Smart welding stations - TIG ^{er}	400V - three-phase - 2x33kVA
Pipe support and lance carriage	400V - three-phase - 16kVA
Control panel	230V - single phase - 6kVA
Cooling unit	230V - single phase - 7kVA

► Product item numbers

	12 m
PolyClad TWIN-TIG ^{er} L-2 - Longitudinal TIG ^{er} weld overlay installation (including TIG ^{er} -2 weld overlay lance, pipe orientation roller assembly, sets of smart welding stations, cooling unit, SCC)	0033950001