Horizontal weld overlay pipe solutions



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: πσ⁴



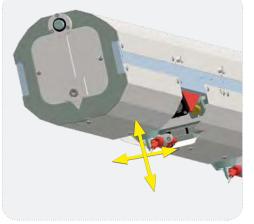
Set of PC 600-3 smart welding stations

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



28

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 •

Systems Control Centre

Delivered with the installation

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Weld overlay programming software (weld overlay parameters)





Video system: Wide dynamic video for real time monitoring



CNC operator programming interface

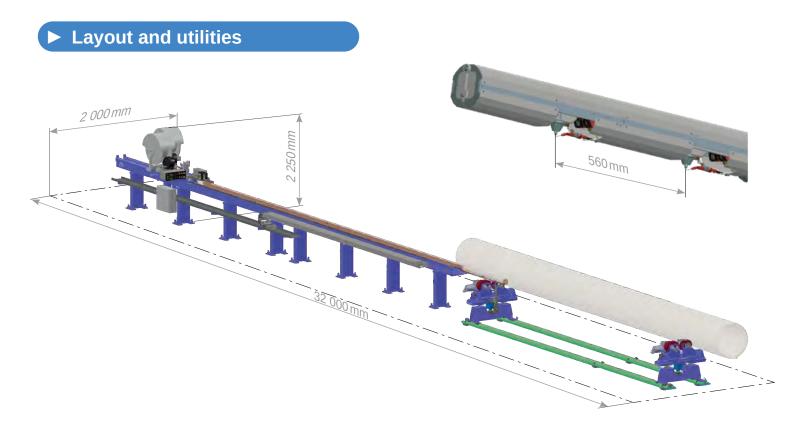
Tube O.D. max. 580 mm (24") ID min * 180 mm (6 1/2")

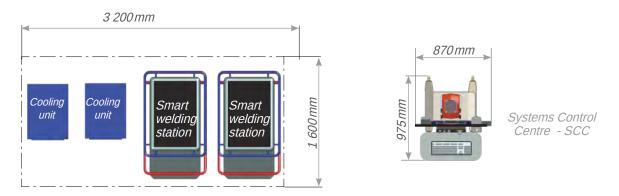
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Length	12 m
Width of the seam to be cladded	10 to 25 mm
Distance between torches 1 & 2	560 mm
AVC stroke (independant for each torch)	15 mm
OSC stroke (independant for each torch)	40 mm (± 20 mm)
Wire feeder	0.4 to 14 m/min
Compatible with wire spool	Ø760mm - 250kg or Ø300mm - 15kg
Video	1 camera per torch

* Before weld overlay considering 2 layers



Technical data





Utilities					
Smart welding stations - TIG ^{er}	400 V - three-phase - 2 x 33 kVA				
Pipe support and lance carriage	400 V - three-phase - 16 kVA				
Control panel	230 V - single phase - 6 kVA				
Cooling unit	230 V - single phase - 7 kVA				

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

