



for Welding Excellence

INVERTER TECHNOLOGY BASED SAW WELDING MACHINE

INVA SAW 600 | INVA SAW 800 | INVA SAW 1000 | INVA SAW 1200

Consistency in quality & service **30** Years



EXCELLENT FEATURES

- ▶ Heavy Duty Welding machines (Rated at 100% duty cycle)
- ▶ Auto recognition of short circuiting, wire retract facility.
- ▶ Welding parameter can be preset.
- ▶ Available with both CC and CV modes.
- ▶ Excellent SAW / GOUGING / SMAW
- ▶ Protection for : Over load, Under voltage, Over voltage, single phasing.
- ▶ Wide current range is available to work with any sort of application.

Technical Specifications For Power Source :

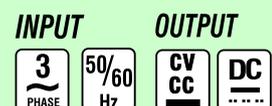
Model	INVA SAW 600	INVA SAW 800	INVA SAW 1000	INVA SAW 1200
Rated Input Voltage	3 Phase, 415 VAC, ± 10%			
Rated Input current (A)	48	64	80	100
Rated Input Power (KVA)	32	42	52	65
No-load voltage (OCV)	90 VDC			
Voltage Range (VDC)	22-44	22-44	22-44	22-44
Current Range (A)	160-600	160-800	160-1000	160-1250
Duty Cycle	100%	100%	100%	100%
Wire Dia.(mm)	1.6 - 3.2	2.4 - 5.0	3.2 - 6.0	3.2 - 6.0
Efficiency	≥ 85%			
Power Factor	≥ 0.90			
Insulation Grade	Class H			
Protection class	IP 23			
Dimension (L x W x H) (mm)	680 x 320 x 630		780 x 390 x 800	
Net Wt. of Power source (kg)	68	90	125	125



AUTOMATIC SUBMERGED ARC WELDING HEAD
FOR BOOM MOUNTING, **MODEL: HB - 110 B**
FOR CARRIAGE MOUNTING, **MODEL: HC 110**

- ▶ Fit for different welding positions, especially deep groove & fillet joints.
- ▶ Compatible for automation.

Sr.no	Items	HC - 110 / HB - 110 B
1.	Voltage of tractor and wire feeder	DC110V
2.	Welding speed range	0.2-2.2 mtr / min
3.	Wire feeding speed range	0.3-3.0 mtr / min
4.	Rated current of power source	600A - 1250A
5.	Wire diameters	2.0 - 4.0
6.	Adjustable distance of tractor head	100×100×70 mm
7.	Volume of flux container	6L
8.	Wire spool capacity	25 kg



Excellent Welding for Higher Performance...

TECHNICAL SPECIFICATIONS OF HC 12

Welding Head	HC - 12
Max. welding current (Amps)	1200
Wire dia(mm)	2.5, 3.2, 4 & 5
Wire feed speed range (Mtr / min)	0.5 - 5.0
Carriage speed range (Mtr / min)	0.1 - 1.5
Control voltage (VAC)	42 V
Slide Stroke (Y-Axis)	80mm
Slide Stroke (Z-Axis)	80mm
Standard O.D. of spool	300mm
Wire spool capacity (kg)	25
Flux hopper capacity (kg)	10

AUTOMATIC SUBMERGED ARC WELDER FOR INTERNAL WELDING. MODEL: HC - 110 C

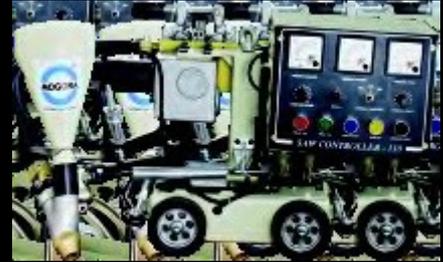
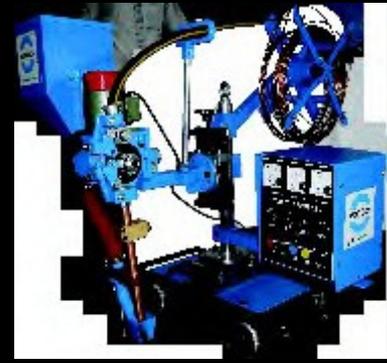
- ▶ It is most compact.
- ▶ Can also be used for internal welding of pipe upto min. dia 700mm.
- ▶ New style, light weight and user-friendly.
- ▶ Suitable with wire diameters from 1.6 –2.4mm.
- ▶ Most suitable for fillet welding of I-section, Channel and Beam - section steel.

AUTOMATIC SUBMERGED ARC WELDER DECK TYPE. MODEL: HC - 110 D

- ▶ Does not require rails.
- ▶ Can be used for welding seams of lap, butt and fillet joints.
- ▶ Most suitable with wire diameters from 2.0 to 5.0 mm.
- ▶ Besides Linear welding, the Tricycle tractor can weld around Circular seam, deck welder for shipyard.
- ▶ Easily adjustable flux container for fillet joints.

AUTOMATIC SUBMERGED ARC WELDER FOR DEEP GROOVE JOINT. MODEL: HC - 110 A

- ▶ Fit for different welding positions, especially deep groove and fillet joints.
- ▶ Wide welding range, compatible for wires ϕ 2.0 to ϕ 5.0.
- ▶ Vertical column 0-45° inclinable and welding possible on inclined plate surface.



Sr.no	Parameters	Specifications	
		HC-110 A / D	HC-110 C
1.	Voltage of tractor and wire feeder	DC110V	
2.	Welding speed range	0.2-2.2m/min	
3.	Wire feeding speed range	0.3-3.0mtr/min	0.3-6.0mtr/min
4.	Rated current of power source	600A - 1250A	600A
5.	Wire diameters	2.0 - 6.0	1.6 - 2.4
6.	Rotatable angle of cross beam	±90°	NOT APPLICABLE
7.	Welding torch inclination	±45°	NOT APPLICABLE
8.	Welding head inclination	±90°	NOT APPLICABLE
9.	Adjustable distance of tractor head	100×100×70mm	
10.	Volume of flux container	6L	2L
11.	Wire spool capacity (kg)	25	12.5
12.	Dimension (L×W×H) in mm	1020×470×700	800×370×500
13.	Weight (kg)	58	50

