

Submerged Arc Welding Products

"MOGORA" make Submerged Arc welders are suitable for heavy duty, longitudinal as well as circular seam welding and fillet welding of heavy plates and structures offering consistent quality weld and higher productivity at increased rate of metal deposition.

The equipment can be ideally employed for thick plates and heavy sections in mild steel, low alloy or stainless steel pressure vessels, penstock pipes, water mains, boiler shells, crane girders, LPG cylinders, structural members in ship building, lock aids, bridge girders etc. They can be used for hard facing as well.



Thyristorised Power Sources
Thyrosaw 801/1201



Conventional SAW Power Sources
WRCP 600/800/1201/1202

Standard Equipment Consists of

Submerged arc welding head	1 Set
Fabricated track 2 mtrs (for carriage mounted type only)	1 No.
Welding cable of suitable capacity	10 Mtr
Earthing Cable with Clamp	5 Mtr
Control Cable	10 Mtr

Special Features

- Simple, rugged and modular construction, easy to adopt any where and suited to rough shop floor conditions.
- Lowest no load current in its class.
- Current & Voltage setting from one position.
- In built compensation for input voltage variation.
- Multi process selection: SAW, MMAW (above 4mm electrode), Carbon Arc Gouging & MIG / MAG.
- Stable arc characteristics due to feed back system.
- "Burn Back" control prevent freezing of wire in the weld pool.
- Thyristor controlled DC drive for both wire feeder as well as carriage to give step less precise control of current/speed.
- Programmable sequential operation of power source, wire feeder and carriage through inbuilt solid state circuitry.

Technical Specifications of Power Source

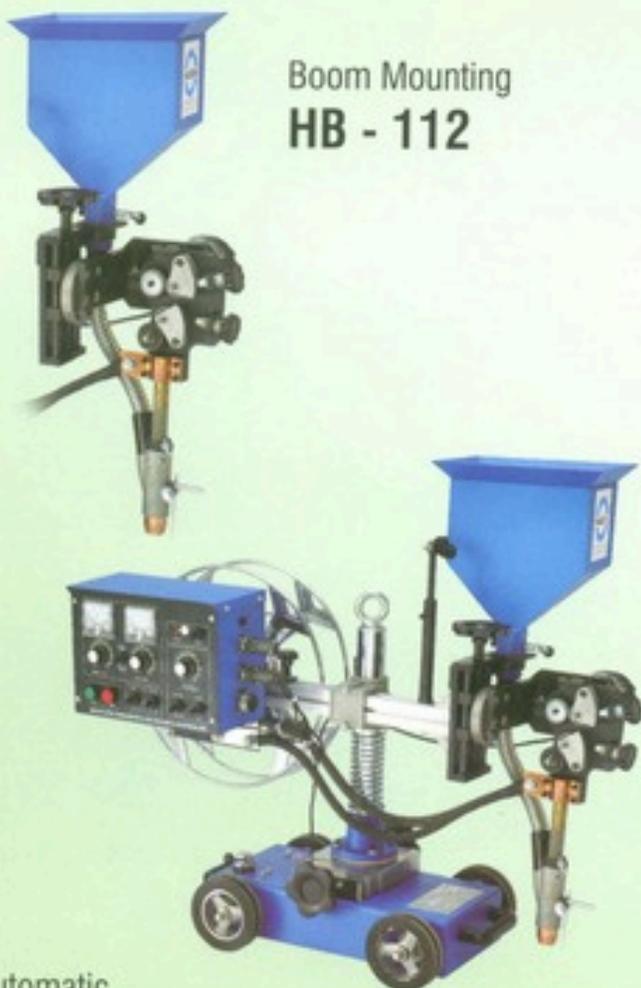
Parameters	Thyrosaw 801	Thyrosaw 1201
Characteristics	CV & CC	
Rated Input Supply	3 phase, 415 VAC \pm 10%, 50/60Hz	
Rated Input Power (KVA)	60	98
Rated Input Current (A)	80	115
Welding Current Range (A)	150 - 800	200 - 1200
Rated Duty Cycle @ 100%	630	1000
Rated No-load Voltage VDC	72	
Insulation Grade	H	
Cooling Method	Forced Air	
Dimensions L X W X H(mm)	1000 X 585 X 675 _{approx.}	1000 X 580 X 960
Weight (kg)	480	550

Technical Specifications of Power Source

Model	WRCP-600	WRCP- 800	WRCP-1201/1202
Input Supply	3 phase, 415 VAC, 50/60Hz		
Type	Constant Potential (CV)		
OCV (Voltage)	19 - 56	20 - 66	35 - 63
Current (AMPS)			
@ 60 % Duty Cycle	600	800	1200
@ 100 % Duty Cycle	470	620	1000
Rating (KVA)			
@ 60% Duty Cycle	33	49	68
@ 100% Duty Cycle	27	33	57
Input Current (Max.) AMP	55	60	100
Insulation	"H"		
Cooling	Forced Air		
Switch Fuse Rating	TP - 60	TP - 80	TP - 100
Weight (Kg)	225	290	550
Dimension (L x W x H) (mm)	950 x 520 x 800	1000 x 590 x 900	1150 x 770 x 900

Excellent Welding for Higher Performance...

Boom Mounting HB - 112



Automatic Submerged Arc Welding Head HC - 112

Special Feature

- Fit for different welding positions, especially deep groove and fillet joints and easily can be fitted for automation.

Items	HC - 112 / HB 112
Voltage of tractor and wire feeder	DC110V
Welding speed range	0.2-2.2 mtr / min
Wire feeding speed range	0.3-3.0 mtr / min
Rated current of power source	600A - 1250A
Wire diameters	2.0 - 6.0
Adjustable distance of tractor head	100x70 mm
Volume of flux container	6L
Wire spool capacity	54 kg

Automatic Submerged Arc Welding Head HC 12



HB 12 (Boom Mounted) SAW Head is also available.

Technical Specifications of Welding Head

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 - 4.0
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)	6

Optional Accessories at extra cost

Spot Light Attachment
Flux Drying Oven
Flux Recovery Unit
Additional fabricated track - 2Mtr length
Motorised cross slides
Power Cable
Control Cable