

SUBMERGE ARC WELDING MZ-630 THYRISTOR

Processes / Application

Processes: SAW, Stick, Gauging, MIG, ESW

Application: Mainly used on welding the sheet steel structures. Widely applied to a variety of materials such as carbon steel, stainless steel, heat-resistant steel, etc. and used popularly in the industries of shipbuilding, boiler, chemical containers, bridge-building lifting machinery and metalurgical machinery manufacturing.

Superior Performance

- ◆ **Excellent welding properties:** CC/CV arc characteristics combined with two adaptive welding modes (Stick & SAW) delivers excellent welding performance, meeting the different requirements of various SAW processes. PWM control technology provides optimal constant output current and superior dynamic characteristics, and assures the consistency of the weld penetration and width even for a long welding bead. As a result, its welding quality is much better than the traditional thyristor submerged arc welding equipments.
- ◆ **Durable reliability:** DSP digital phased-shifted soft switch inverter technology against various damaged risks such as overload of voltage, overload of current, voltage shortage, overheat delivers high reliability during operating, and makes it can be safely used in various hash enviroment.
- ◆ **High energy and low feeding speed program:** assures one-time successful arc starting capability. Unique crater control circuitry significantly eliminates the welding defects in both the starting and the ending position of the welding bead.
- ◆ **Degitizing tractor:** can achieve various wires' welding such as filament, flux-cored wire, twin-wire single arc. And it can save 10 sets of welding data, which saves time. Both the wire feeding and the tractor moving speed are stable, which provides a excellent welding.

Specification of the power source

Item	Model
	MZ-630
Input Power Voltage/Phase/Hertz	± 380V 15%, 3-Phase, 50/60Hz
Rated Input Current	50A
Rated Input	33KVA
Max. OCV	75V
Rated Output Current	630A
Rated Output	100A/24V~630A/44V
Rated Duty Cycle	60%
For Wire Diameter	Ø2/Ø3/Ø4
Net Weight	60Kg



Specitications of the tractor

Rate Input Voltage	ACC110V (Supplied by Power Source)
Suitable Welding Current	630A
Wire Diameters	Ø 2.0 / Ø 3.0 / Ø 4.0
Wire Type	Copper-Coated Solid Steel
Feeding Wire Speed Range	0.3~3m/min
Feeding Mode	Automatic transmission/constant speed
Welding Speed Range	0.2~1.5m/min
Adjustable Height of Torch (mm)	70mm
Adjustable Height of Tractor Head (mm)	80m
Adjustable Longitudinal Distance of Tractor Head Around Cross Beam (mm)	±30mm
Rotatable Angle of Tractor Head Around Cross Beam	≥ ±90°
Adjustable Longitudinal Distance of Tractor Head (mm)	100mm
Torch Inclination	45°
Tractor Head Inclination	±45°
Wire Spool Capacity (Kg)	25Kg
Flux Container Volume (L)	6L
Net Weight (Kg)	55Kg (not including w/o flux & wire)
Suitable SAW Power Source Model	MZ-630A