

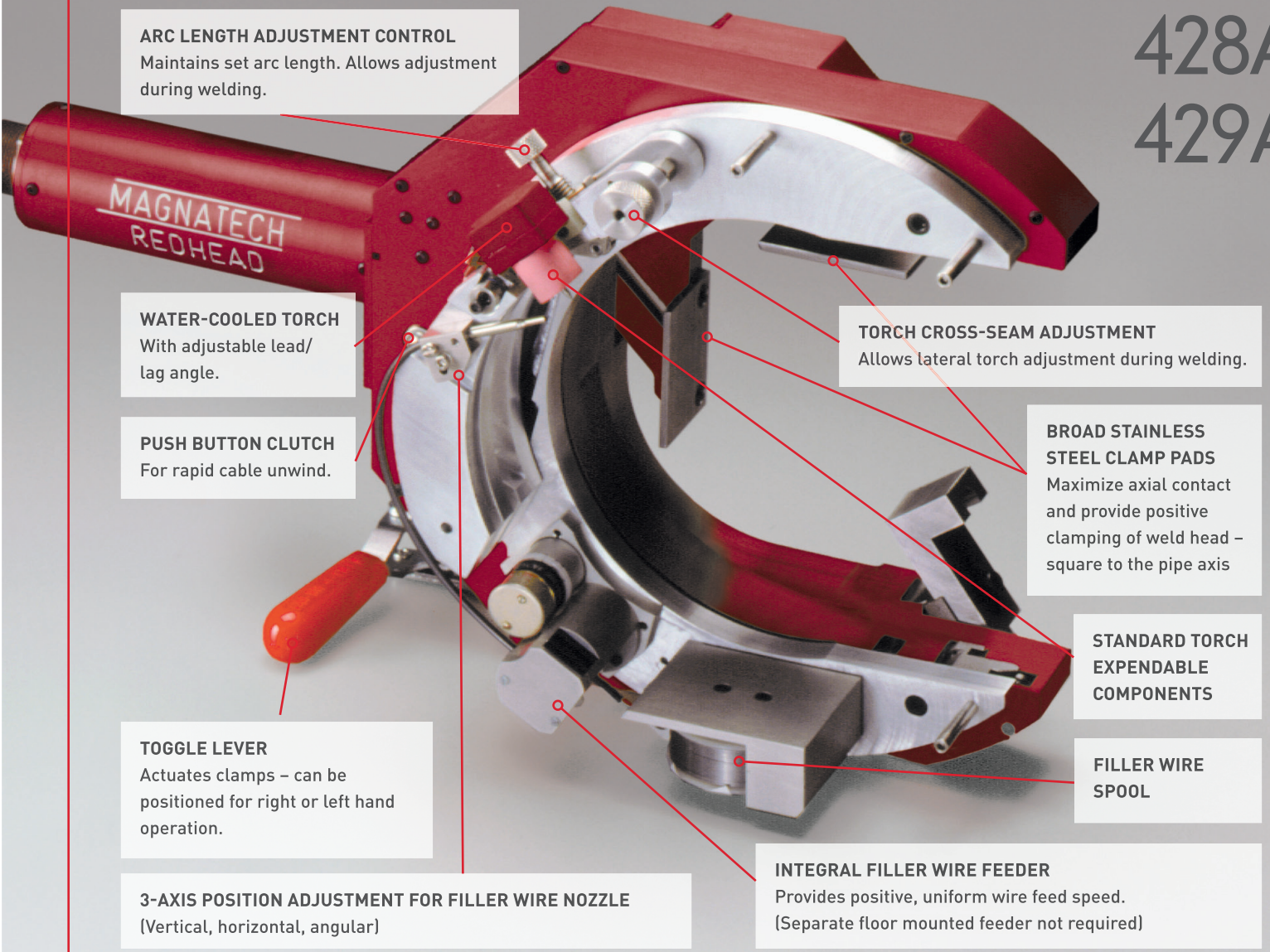
**REDHEAD  
WELD HEADS  
427A  
428A  
429A**

**ORBITAL WELD HEADS FOR FUSION  
AND WIRE FEED WELDING OF PIPE**

Magnatech Redheads are designed to make pipe-to-pipe and pipe-to-fitting welds with precision and repeatability. Redheads can be used for fusion welding, or with filler wire addition – an integral head-mounted feeder is standard on all models. Three models cover the size range of 12.7 to 168 mm (0.5 to 6.625”) OD. Digital technology forever eliminates the need for periodic calibration – rotation and wire speed remain accurate regardless of wear, and heads can be interchanged without time-consuming recalibration.

- Chain drive system guarantees long life time
- Rugged design
- Generates high quality welds

# REDHEAD WELD HEADS 427A 428A 429A



**ARC LENGTH ADJUSTMENT CONTROL**  
Maintains set arc length. Allows adjustment during welding.

**WATER-COOLED TORCH**  
With adjustable lead/lag angle.

**PUSH BUTTON CLUTCH**  
For rapid cable unwind.

**TOGGLE LEVER**  
Actuates clamps – can be positioned for right or left hand operation.

**3-AXIS POSITION ADJUSTMENT FOR FILLER WIRE NOZZLE**  
(Vertical, horizontal, angular)

**TORCH CROSS-SEAM ADJUSTMENT**  
Allows lateral torch adjustment during welding.

**BROAD STAINLESS STEEL CLAMP PADS**  
Maximize axial contact and provide positive clamping of weld head – square to the pipe axis

**STANDARD TORCH EXPENDABLE COMPONENTS**

**FILLER WIRE SPOOL**

**INTEGRAL FILLER WIRE FEEDER**  
Provides positive, uniform wire feed speed. (Separate floor mounted feeder not required)

## SPECIFICATIONS

	R-1 (model 427A)	R-2 (model 428A)	R-3 (model 429A)
Application	Orbital GTAW welding of pipe-to-pipe, pipe-to-fittings Fusion/wire feed capable		
Pipe (tube) OD size range	13 – 38 mm (0.5 – 1.5")	33 – 90 mm (1.315 – 3.5")	90 – 168 mm (3.5 – 6.625")
Filler wire module	Wire size: 0.8 mm (0.03") Max. speed capability: 1900 mm/min. (75 IPM) Spool size: 0.16 kg (0.35 lbs)		
Arc gap control module	Mechanical, adjustable		
Torch propulsion module	0 – 4.0 rpm	0–1.5 rpm	0–0.6 rpm
Water-cooled torch	200 A continuous		
Torch adjustment capability	Torch lead/lag adjustment: ± 15 degrees (manual) Torch tilt adjustment: Requires optional socket weld kit		
Cable length	7.6 m (25') standard. Extension cables available.		
Power supply compatibility	Tubemaster 514, Pipemaster 515, Pipemaster 516		



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