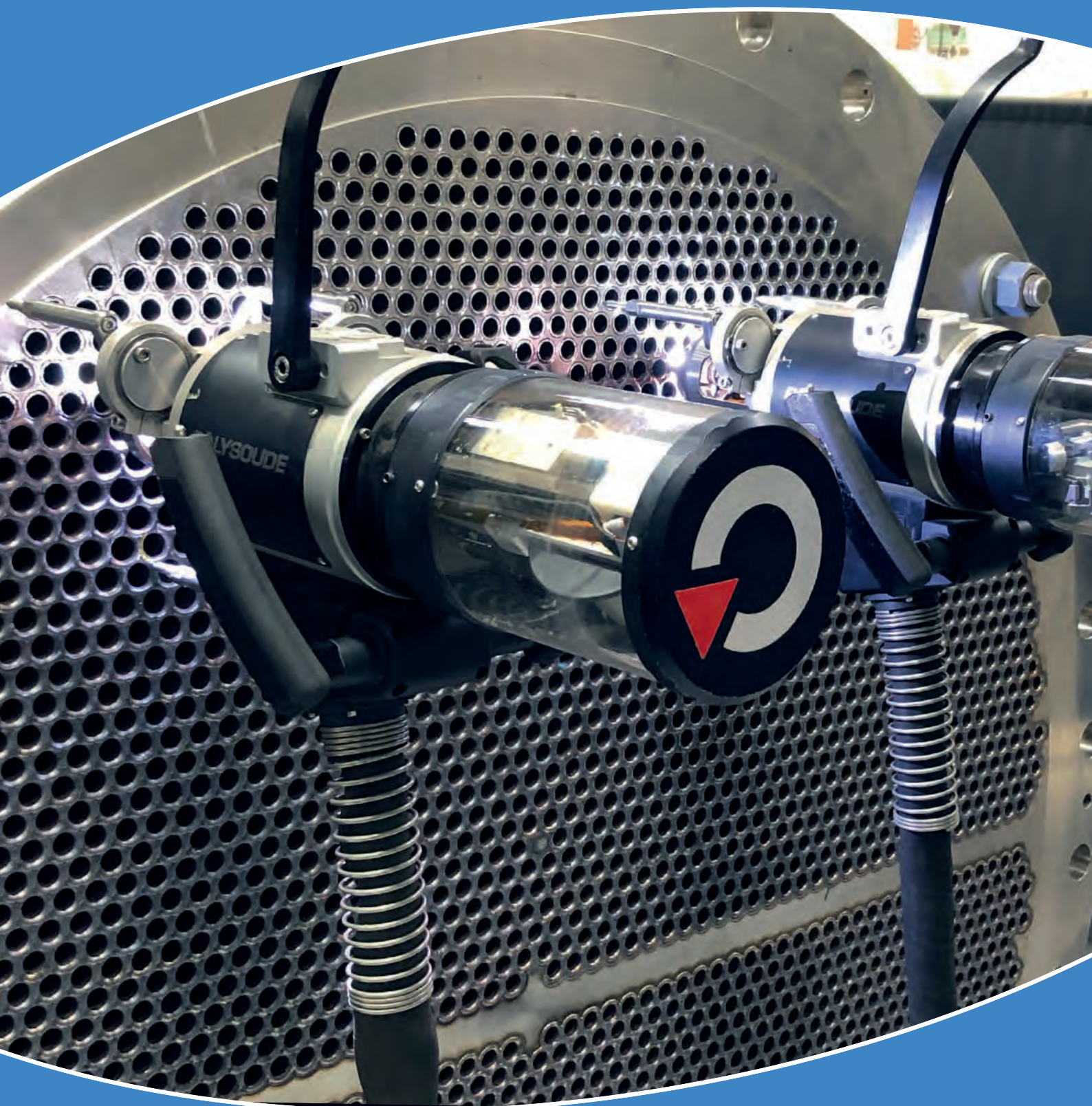


TS 8/75

TIG - With or without filler wire, A V C

Open welding head
for welding of tube-to-tube sheet joints



OTS 8/75

Open welding head for welding of tube-to-tube sheet joints

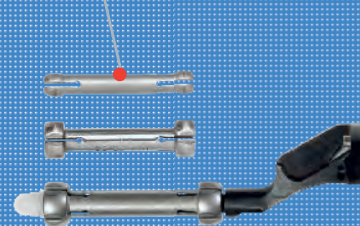
Cutting-edge design using the latest materials and engineering technologies

Advantages

- **Compact & ergonomic:**
Lightweight and very easy to manoeuvre thanks to handles with integrated controls for clamping and welding.
- **Increased productivity:**
Simultaneous use of multiple heads with integrated pneumatic clamping
- **Practical:** Standard version with AVC (arc voltage control)
- **Intuitive use:** Simple adjustments, in particular of the wire and supporting feet, making operator training fast
- **Ultra accurate:** Fixed or rotating on-board wire feeder to supply filler wire without speed or impact position variation

Resulting from 60 years' experience in mastering of welding technologies

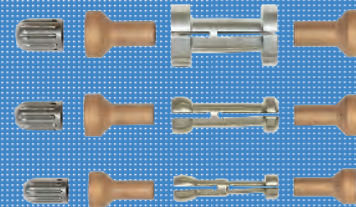
Optional: Centering shafts and mandrels for specific tube diameters



Designed for high duty cycle applications with high temperature resistant materials and closed loop water cooling

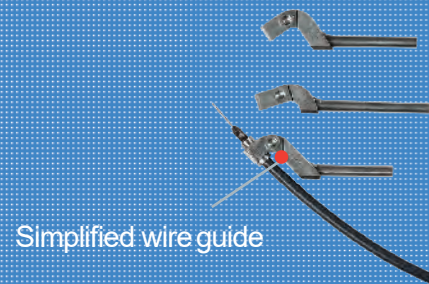
A wide variety of tooling is available to accommodate all existing tubesheet joint designs

Clamping/centering mandrel for all tube I.D.'s



Standard version with pneumatic clamping/centering system

Torch with ceramic nozzle and diffuser for laminar gas protection



Return-to-home feature: the electrode automatically returns to its initial position

Adjustable stand-off legs for every pitch

Simplified wire guide

General characteristics

Optional: Pneumatic clamping and centering tooling dedicated for low protruding tubes

Uniquely rotating collector for welding current, shielding gas and cooling liquid

Motorised Arc Voltage Control (AVC) or programmable electrode height

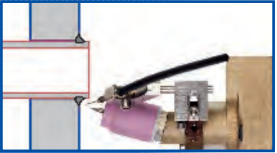
Rotating on-board wirefeeder

Closed loop regulation to ensure precise, constant or pulsed welding speed

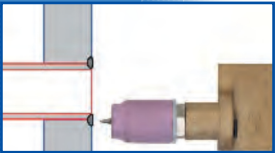
Encoder for position based control of the welding program

Integrated remote control, for clamping and welding

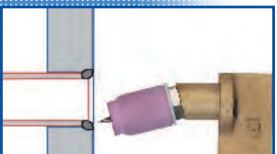
Different types of weld joint configurations:



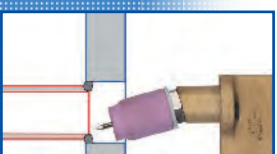
Protruding tube welding



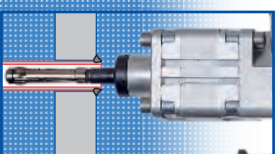
Flush tube welding



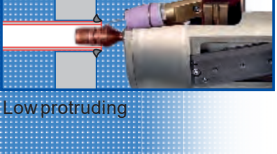
Recessed tube welding



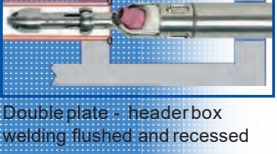
Back plate tube welding



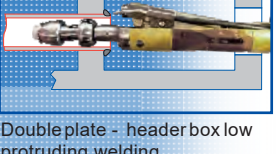
Low protruding



Double plate - header box welding flushed and recessed



Double plate - header box low protruding welding



Internal tube welding

Smart
Welding
Station



► P6

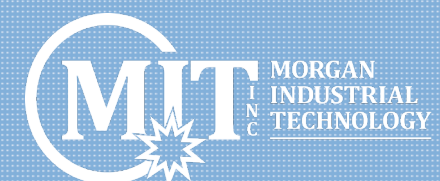
300A, "all applications", programming by Plug & Play software for wired or wireless touch controllers, with Arc Voltage Control (AVC), three-phase power supply

Wire feeders



► Polyfil Series

External portable wire feeders with 5 or 15kg spool protection

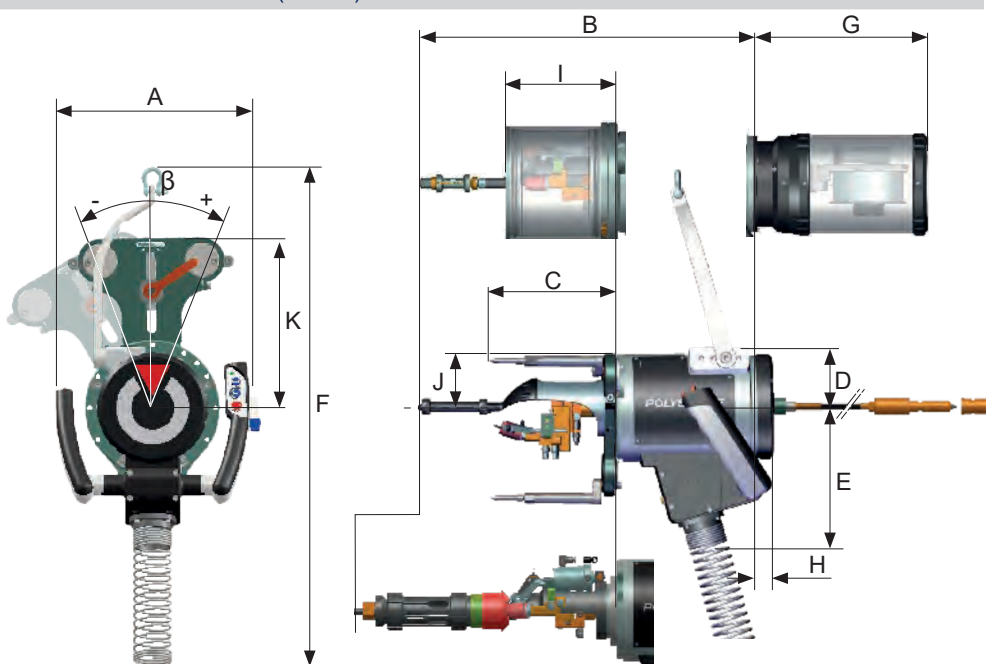




Technical specifications

Min. tube I.D.	8mm (0.315")
Max. tube O.D.	75mm (2.95") [O.D.s> 60mm (2.36") on request]
Duty cycle	250A / 60%- 190A/100%
Cooling of welding head	Closed loop, water with Glycol
Arc Voltage Control (AVC)	Stroke 20mm (0.79")
Centring system with 2 ball-centring mandrel	10.5mm(0.41") ≤ I.D. ≤ 60mm (2.36")
Pneumatic centring and clamping system	15mm(0.59") ≤ I.D. ≤ 40mm (1.57")
Reinforced pneumatic centring and clamping device	40mm (1.57") ≤ I.D. ≤ 60mm (2.36")
Wire feeder	
• external	POLYFILcompact or POLYFIL-3
• on-board	Rotating
Wire feed speed - max	1154mm/min (PC series) or 2085mm/min (P6series)
Wire spool compatibility	
• on-board	1.5kg(3.3lbs)/Ø100mm (4")
• external	15kg(33 lbs)/Ø300mm (POLYFIL-3) or 1.5kg/Ø100mm (4") (POLYFILcompact)
Tube joint designs:	
• flush	Standard
• recessed	-2mm (0.08") max
• low protruding	3 to 4mm (0.16") max
• protruding	5 to 13mm(0.51") max
• internal bore welding	Option
• back plate - header box welding	Option
Weight	7.5kg (15.43lbs) – without bundle and wire spool
Cable length	9 m (29.53 ft)

Dimensions in mm (in)		
A	229 (9.02")	
B	408 (16.06")	Centring shaft with centring mandrel
	412 (16.22")	Pneumatic centring / clamping mandrel
	502 (19.76")	Reinforced pneumatic centring / clamping mandrel
C	152 (5.98")	
D	75 (2.95")	
E	170 (6.70")	
F	583 (22.95")	
G	223 (8.78")	
H	20 (0.79")	
I	135 (5.31")	
J	66 (2.60")	
K	210 (8.27")	
β	± 0, 30, 45, 60, 90, 120°	



Options and accessories

- Clamping/centering mandrels for all tube I.D.'s
- Rotating on-board wirefeeder for precise and constant wirefeeding
- Pneumatic clamping/centering system for improved quality and productivity
- Accessories for all types of applications
- Extension cable (15m/49.2 ft)
- Compact shipping-case for transport and storage
- Pre-sharpened and pre-cut tungsten electrodes
- Tooling



Adapted for all your applications!





POLYSOUDE: Related services

► Guidance and technical support

A welding application specialist in your area will advise you on the welding process and appropriate equipment for your application.

► Commissioning/ Training

A complete training program will enable you to start using the equipment immediately and in the best way possible.

► Maintenance / Repair

Maintenance and repair operations can be carried out at the Polysoude plant as well as on site by our service network.

► Rental service

Increase the flexibility of your production! A large range of equipment is available for rental from our hire fleet.



Your partners worldwide

ARGENTINA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

AUSTRALIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

AUSTRIA

POLYSOUDE AUSTRIA GmbH
☎ +43 (0) 3613200 36
austria@polysoude.at

BAHRAIN

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae

BELGIUM

POLYSOUDE BENELUX BV
☎ +31 (0) 653 84 23 36
benelux@polysoude.com

POLYSOUDE BENELUX BV

(SERVICE)
☎ +31 (0) 653 84 23 36
service.benelux@polysoude.com

BRAZIL

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

BULGARIA

KARWELD EOOD
☎ +359 (0) 29 73 32 15
Karweld@bg400.bg

CANADA

MAGTool - West
EDMONTON - ALBERTA
☎ +1 800 661 9983
magtool@magtool.com

MAGTool - East

TORONTO - ONTARIO
☎ +1 905 699 - 5016
ray@magtool.com

CHINA

POLYSOUDE SHANGHAI CO. Ltd
☎ +86 (0) 2164 09 78 26
jm.pah@polysoude.com.cn

CROATIA

EUROARC D.O.O.
☎ +385 (0) 12 40 60 77
euroarc@euroarc.hr

CZECH REPUBLIC

POLYSOUDE CZ
☎ +420 602 60 28 55
m.matousek@polysoude.cz

DENMARK

HALL & CO. INDUSTRI
☎ +45 (0) 39 56 06 76
p.lorenzen@polysoude.com

EGYPT

STEEL TECH
☎ +202 22 02 99 79
info@steeltecheg.com

ESTONIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

FINLAND

SUOMEN TEKNOHAUS OY
☎ +358 (0) 927 47 2 10
info@teknohaus.fi

FRANCE

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

GERMANY

POLYSOUDE DEUTSCHLAND GmbH
DUSSLINGEN
☎ +49 (0) 7072 60076 0
info@polysoude.de

GREECE

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

JAPAN

GMT COLTD - KAWASAKI
☎ +81 (0) 44 222 6751
gmt@e-gmt.co.jp

GMT COLTD - OSAKA

☎ +81 (0) 798 35 6751
gmt.kansai@e-gmt.co.jp

JORDAN

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

KUWAIT

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae

LATVIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

OMAN

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae

PAKISTAN

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

PHILIPPINES

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

POLAND

UNIDAWELD - BEDZIN
☎ +48 (0) 32 267 05 54
dariusz.szota@unidaweld.pl

SUPRA ELCO

☎ +48 500 004 804
jacek.szulc@supraelco.waw.pl

SINGAPORE

POLYSOUDE SINGAPORE OFFICE
☎ +65 0734 8452
Jmpa@singnet.com.sg

SLOVAKIA

POLYSOUDE CZ
☎ +420 602 60 28 55
m.matousek@polysoude.cz

SOUTH AFRICA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

SOUTH KOREA

CHEMIKO CO Ltd
☎ +82 (0) 2 567 5336
chemiko@chemiko.net

SPAIN

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

SWEDEN

HALL & CO. INDUSTRI
☎ +45 (0) 39 56 06 76
p.lorenzen@polysoude.com

SWITZERLAND

POLYSOUDE (SWITZERLAND) Inc.
☎ +41 (0) 43 243 50 80
contact@polysoude.ch

TAIWAN R.O.C.

FIRST ELITE ENT. CO. Ltd
☎ +886 (0) 287 97 88 99
auto.pipe@msa.hinet.net

THAILAND

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

TURKEY

EGEMAKINE
☎ +90 (0) 212 237 40 40
info@egemakine.com

UNITED ARAB EMIRATES

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae

UNITED KINGDOM

POLYSOUDE UK
☎ +44 (0) 1942 820 935
admin.uk@polysoude.com

UKRAINE

POLYSOUDE RUSSIA
☎ +7 495 564 86 81
info@polysoude.ru

UNITED STATES

ASTRO ARC POLYSOUDE Inc.
☎ +1 818 (859) 7600
sales@astroarc.com

VENEZUELA

ENRIVA C.A.
☎ +58 (0) 41234 82 602
enriva@gmail.com

VIETNAM

ANH DUONG IT Ltd
☎ +84 22 159 532
an@anhduongco.com



HUNGARY

POLYWELD Kft.
☎ +36 (0) 20 29 88 708
polyweld@polyweld.hu

INDIA

POLYSOUDE INDIA
☎ +91 (0) 20 27127 678
ab.kulkarni@polysoude.in

INDONESIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

IRAN

STD CO
☎ +98 2188525206-7
najco_ir@hotmail.com

ISRAEL

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

ITALY

POLYSOUDE ITALIA SRL
☎ +39 02 9379 90 94
info@polysoude.it

LITHUANIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

MALAYSIA

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

NETHERLANDS

POLYSOUDE BENELUX BV
☎ +31 (0) 653 84 23 36
benelux@polysoude.com

POLYSOUDE BENELUX BV

(SERVICE)
☎ +31 (0) 653 84 23 36
service.benelux@polysoude.com

NEW ZEALAND

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

NORWAY

TEMA NORGE AS
☎ +47 (0) 5169 25 00
tema@tema-norge.no

PORTUGAL

POLYSOUDE S.A.S.
☎ +33 (0) 2 40 68 1100
info@polysoude.com

QATAR

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae

REPUBLIC OF IRELAND

POLYSOUDE UK
☎ +44 (0) 1942 820 935
admin.uk@polysoude.com

ROMANIA

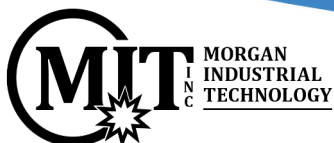
DEBISUD CONCEPT S.R.L.
☎ +40 (0) 255 2157 85
office@debisud.ro

RUSSIA + C.I.S.

POLYSOUDE RUSSIA
☎ +7 495 564 86 81
info@polysoude.ru

SAUDI ARABIA

SALWO TRADING Ltd.
☎ +971 (0) 48 8105 91
salwo@emirates.net.ae



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