

Automation – Longitudinal Seams

Longitudinal Seam Welding Unit Model OL



 **Productvideo on**
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1

- Central control panel with digital display for welding speed and welding length.
- Presetting is possible.

2

- Linear chassis for torch mounting, max. load 50 kg.
- Adjustable sensor - switch for start and stop position.

3

- Copper chuck jaws are pressed pneumatically via pressure hose.
- Clamping force of copper chuck jaws 150N/cm at 3 bar pre-pressure.
- Chuck jaws are adjustable via adjusting screws from 5-25 mm to the middle of the welding seam.

4

- Lower beam equipped with a copper bearing rail.
- Prepared for water cooling and bottom formation.
- Turnbuckle for locking the lower beam is equipped with a safety switch.

5

- Adjustable height of lower beam according to material thickness.
- Manually adjustable torch mounting on X-Y-Z axis.
- Pivotal torch axis up to max. 60°.
- Enough space for the inclusion of a cold wire feeder.

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Model	OL-04	OL-06	OL-08	OL-10	OL-12
Supply voltage	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz
Workpiece length	460 mm	660 mm	860 mm	1060 mm	1260 mm
Workpiece diameter	65 – 600 mm	90 – 780 mm	110 – 780 mm	145 – 780 mm	160 – 780 mm
Wall thickness	0,6 – 6,0 mm	0,6 – 6,0 mm	0,6 – 6,0 mm	0,6 – 10,0 mm	0,6 – 10,0 mm
Lower beam	turnbuckle for locking				
Torch movement	ballscrew and linear slide				
Torch speed	100 – 1500 mm/min				
Clamping	pneumatically via pressure hose				
Gas	automatic control				
Cooling	water circulation				
Middle stop collar	pneumatically				
Arc type	Standard/crater				
Timer	0 – 9,9 sec				
Start Arc	0 – 9,9 sec				
Crater filling	0 – 9,9 sec				
Length adjustment	2 sensor switches (start position sensor + stop position sensor)				
HF-protection	96 %				
Item no.	02.32.20.01400 (old: 71080304)	02.32.20.01600 (old: 71080306)	02.32.20.01800 (old: 71080308)	02.32.20.01100 (old: 71080310)	02.32.20.01100 (old: 71080312)

Model	OL-15	OL-18	OL-20	OL-25	OL-30
Supply voltage	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz	V1: AC 230V/60Hz V2: AC 400V/50Hz
Workpiece length	1560 mm	1860 mm	2060 mm	2560 mm	3060 mm
Workpiece diameter	200 – 1000 mm	230 – 1000 mm	250 – 1000 mm	300 – 1000 mm	350 – 1000 mm
Wall thickness	0,6 – 10,0 mm	1,0 – 12,0 mm	1,0 – 12,0 mm	1,0 – 12,0 mm	1,0 – 12,0 mm
Lower beam	turnbuckle for locking				
Torch movement	ballscrew and linear slide				
Torch speed	100 – 1500 mm/min.				
Clamping	pneumatically via pressure hose				
Gas	automatic control				
Cooling	water circulation				
Middle stop collar	pneumatically				
Arc type	Standard/crater				
Timer	0 – 9,9 sec				
Start Arc	0 – 9,9 sec				
Crater filling	0 – 9,9 sec				
Length adjustment	2 sensor switches (start position sensor + stop position sensor)				
HF-protection	96 %				
Item no.	02.32.20.01500 (old: 71080315)	02.32.20.01800 (old: 71080318)	02.32.20.02000 (old: 71080320)	02.32.20.02500 (old: 71080325)	02.32.20.03000 (old: 71080330)