

**BP2226E5, FOR TIG WELDING WITH  
AVC, SPECIAL EXECUTION FEATURING:**

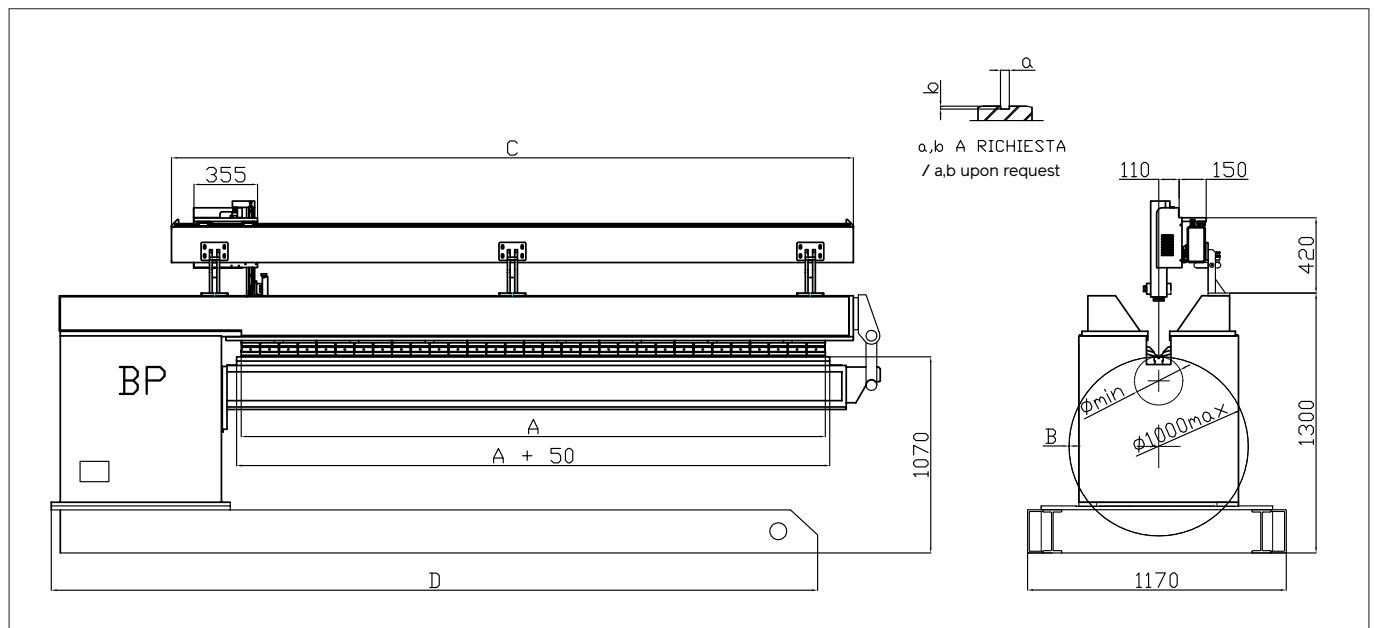
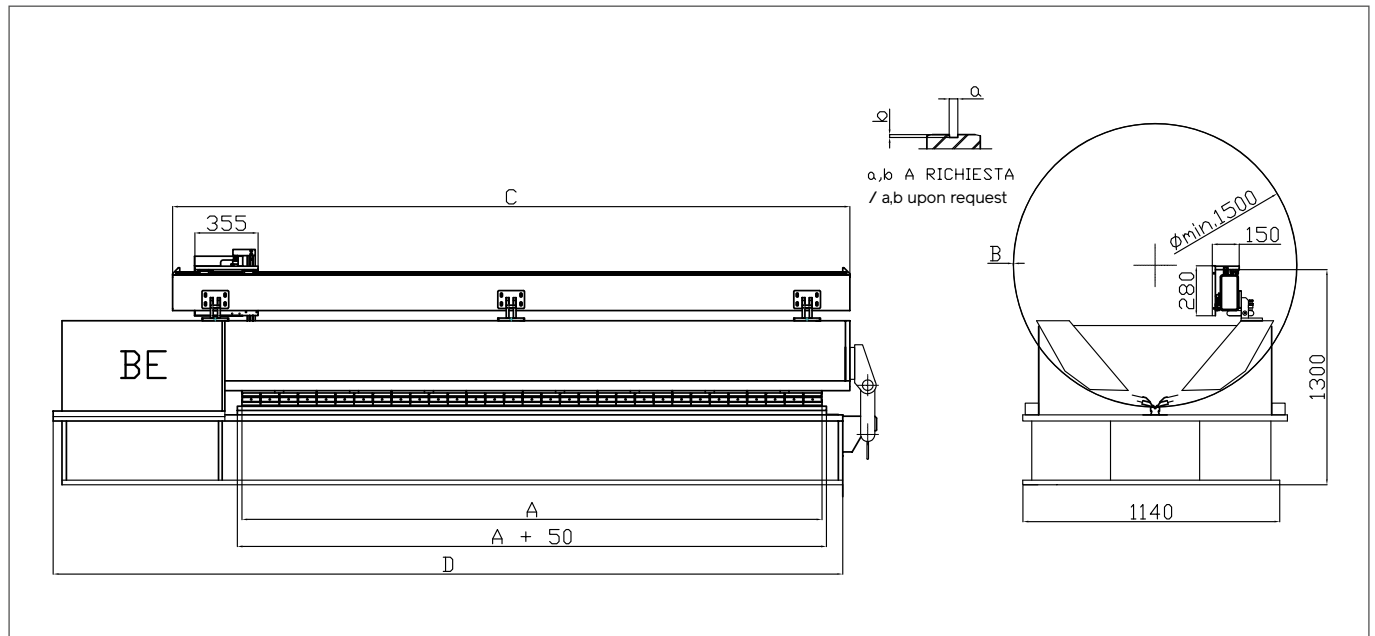
- Operator platforms hanging from both sides
- Platform provided of Teflon guides and of clamps for rounding the cylinder, height adjustable and motorized for automatic load/unload



**BP3131D3, FOR PLASMA WELDING,  
STANDARD EXECUTION, WITH OPTIONALS:**  
AVC, CNC and pendant swivel control cabinet.  
In the background: straightening machine, spec.  
exec.



# BANCO DE SOLDADURA HORIZONTAL



## BANCO DE SOLDADURA HORIZONTAL

| Description               | BE341005 | BE391005 | BE451505 | BE501505 | BE551504 | BE601504 |
|---------------------------|----------|----------|----------|----------|----------|----------|
| A                         | 3570     | 4095     | 4725     | 5250     | 5775     | 6300     |
| Ø min                     | 1500     | 1500     | 1500     | 1500     | 1500     | 1500     |
| B min                     | 1        | 1        | 1        | 1        | 1        | 1        |
| B max without stitching 5 |          | 5        | 5        | 5        | 4        | 4        |
| B max with stitching      | 10       | 10       | 10       | 10       | 8        | 8        |
| C                         | 5220     | 5745     | 6375     | 6900     | 7425     | 7950     |
| D                         | 5090     | 5615     | 6245     | 6770     | 7295     | 7820     |
| a                         | 1        | 1        | 1        | 1        | 1        | 1        |
| b                         | 2        | 2        | 2        | 2        | 2        | 2        |
| c                         | 1        | 1        | 1        | 1        | 1        | 1        |
| d                         | 1        | 1        | 1        | 1        | 1        | 1        |
| e                         | 1        | 1        | 1        | 1        | 1        | 1        |
| f                         | 2        | 2        | 2        | 2        | 2        | 2        |
| g                         | 2        | 2        | 2        | 2        | 2        | 2        |
| h                         | 2        | 2        | 2        | 2        | 2        | 2        |
| i                         | 1        | 1        | 1        | 1        | 1        | 1        |
| l                         | 2        | 2        | 2        | 2        | 2        | 2        |
| Kg.                       | 5520     | 5850     | 6390     | 6840     | 7300     | 7760     |

| Code | Description          | TYPE             | TYPE               |
|------|----------------------|------------------|--------------------|
| a    | CLAMPING MODE        | (1) PNEUMATIC    | (2) HYDRAULIC      |
| b    | ALIGNMENT JIGS       | (1) MANUAL       | (2) PNEUMATIC      |
| c    | BAR COOLING          | (1) FIT FOR      | (2) SEALED CIRCUIT |
| d    | GAS BACK UP          | (1) UPON REQUEST | (2) INCLUDED       |
| e    | LATCH                | (1) MANUAL       | (2) PNEUMATIC      |
| f    | CARRIAGE BACK STROKE | (1) MANUAL       | (2) MOTORIZED      |
| g    | PNEUMATIC SLIDE      | (1) UPON REQUEST | (2) INCLUDED       |
| h    | CABLES ARRANGEMENT   | (1) FESTOON      | (2) CABLE BELT     |
| i    | MM/MIN               | (1) 100/1900     | (2) 50/2500        |
| l    | HF SHIELDING         | (1) UPON REQUEST | (2) INCLUDED       |

| Description               | BP0512G3 | BP0717B5 | BP1012G2 | BP1213A3 | BP1217B4 | BP1221C5 | BP1517H3 | BP2221C3 | BP2221D4 | BP2226E5 | BP2521D3 | BP2526E5 | BP3121D3 | BP3126E4 | BP3131F5 |
|---------------------------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|
| A                         | 525      | 735      | 1050     | 1260     | 1260     | 1260     | 1575     | 2310     | 2310     | 2310     | 2625     | 2625     | 3255     | 3255     | 3255     |
| Ø min                     | 120      | 170      | 120      | 130      | 170      | 210      | 170      | 210      | 210      | 260      | 210      | 260      | 210      | 260      | 310      |
| B min                     | 0,5      | 1        | 0,5      | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| B max without stitching 3 | 5        | 2        | 3        | 4        | 5        | 3        | 3        | 4        | 5        | 3        | 5        | 3        | 4        | 5        |          |
| B max with stitching      | 6        | 10       | 4        | 6        | 8        | 10       | 6        | 6        | 8        | 10       | 6        | 10       | 6        | 8        | 10       |
| C                         | 1470     | 1850     | 2000     | 2380     | 2380     | 2630     | 2520     | 3675     | 3675     | 3675     | 3990     | 3990     | 4620     | 4620     | 4620     |
| D                         | 1100     | 1800     | 1400     | 1800     | 1800     | 2025     | 1800     | 2930     | 2930     | 2930     | 3170     | 3170     | 3690     | 3690     | 3690     |
| a                         | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| b                         | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        |
| c                         | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| d                         | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| e                         | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| f                         | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        |
| g                         | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        |
| h                         | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        |
| i                         | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        | 1        |
| l                         | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        | 2        |
| Kg.                       | 1100     | 1250     | 1450     | 2600     | 2630     | 2650     | 2820     | 3815     | 3830     | 3840     | 3950     | 3970     | 4100     | 4120     | 4160     |

# BANCO DE SOLDADURA VERTICAL 1500 o 2000 mm



## STANDARD FEATURES

It's designed for automatic vertical seam welding of flat sheets or of cylinders Ø 500 mm or greater, thickness 0.8 to 3 mm without stitch welding, up to 10 mm with stitches, clamping lengths 1550 or 2050 mm.

Thanks to the robust structure of the mandrel, it doesn't need to install any AVC sensor.

After welding, a gear motor lifts the mandrel to allow unloading the job.

## Description

- Base structure made of steel profiles and machined
- Steel mandrel with back-up copper bar
- Back-up copper bar fit for cooling (cooling unit not included)
- Back-up gas flow
- Pneumatic clamping by independent foot switches
- Side beam carriage driven by DC gear motor and rack&pinion transmission;
- The carriage is made of aluminium and it moves on linear ball bearing linear guides. On demand: wire feeder support
- 2-axis CNC cabinet with 5" touch screen complying with CE norms
- Pneumatic slide to release the torch after welding
- Cross slide (stroke 80 mm) for micrometric adjustment of the torch
- Centring jigs driven by pneumatic cylinders

## Work cycle

### MANUAL work cycle:

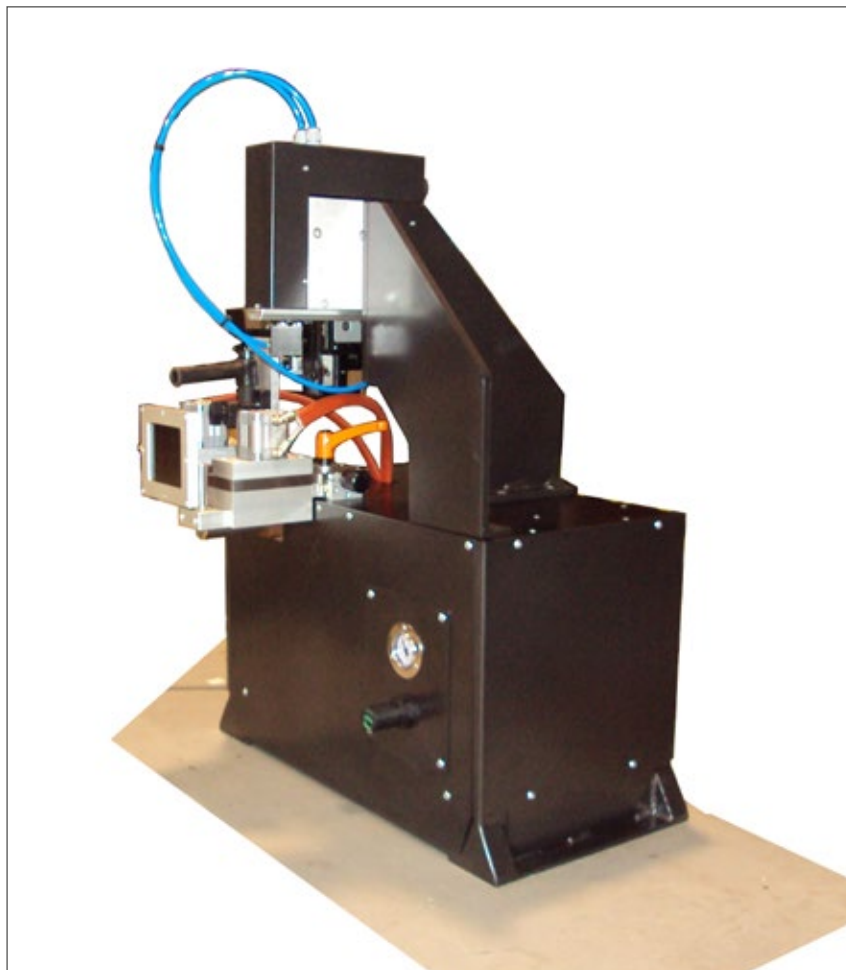
- Positioning of the left edge
- Clamping of left edge
- Positioning of the right edge
- Clamping of right edge

### AUTOMATIC work cycle:

- Carriage onward from home to weld start position
- Down stroke of pneumatic slide and arc ignition
- Start delay and cold wire start (if any)
- Welding to recorded weld end position
- Arc extinction and post gas time
- Upstroke of pneumatic slide
- Carriage backward to home position



# PARALLELO DESK SEAMER



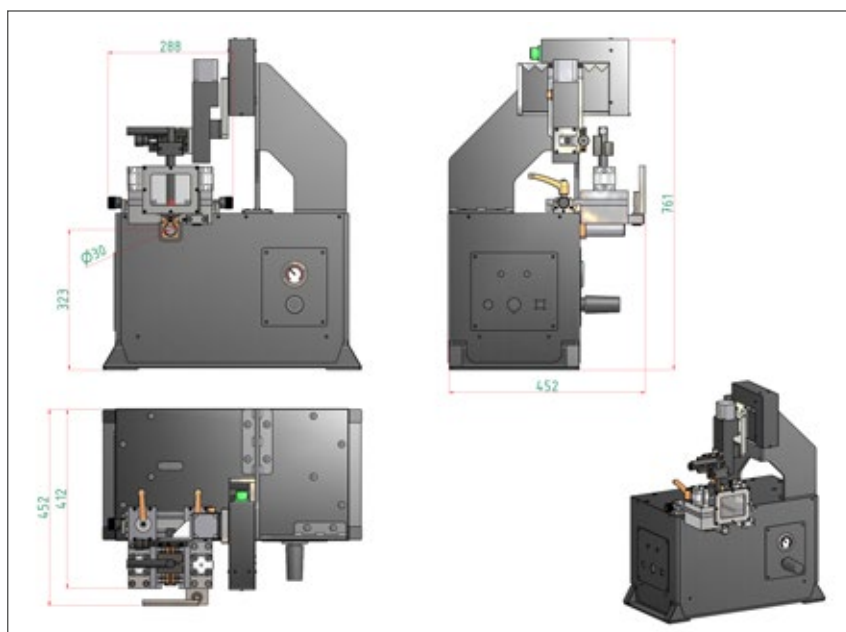
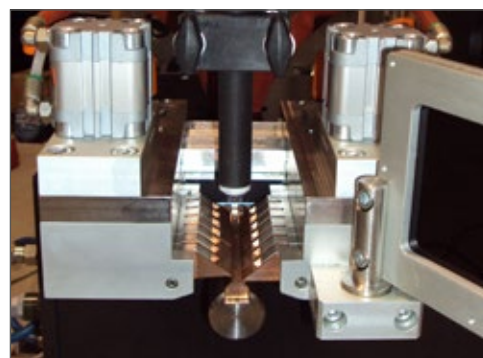
### High precision for thin walls

Provided of pneumatic clamping fingers, it is suitable for vessel walls and for flat plates as thin as 0.2 mm.

Micrometric adjustment of fingers in-between distance is made by high precision slides.

Torch longitudinal traversing by MM MINI 180 motorized by DC motor with encoder and driven by ball screw on ball linear guides.

Torch up/down strokes by JD PNEUMO 80 pneumatic slide.



Work cycle stepped by PLC with 3.5" soft touch screen, which allows setting of:

- Weld start point.
- Weld longitudinal stroke mm.
- Speed mm/min.
- Start delay sec.
- Torch up stroke delay in sec.

| PARALLELO DESK   |               |
|------------------|---------------|
| Ø min -max       | 35 - 300      |
| L min - max      | 10 - 150      |
| Thickness        | 0,2 - 3 mm    |
| Gas back up      | yes           |
| Bar cooling      | no            |
| Feeding          | 230 V - 50 Hz |
| Working pressure | 2 - 6 bar     |