

P6 SERIES

TIG - DC - Cold Wire / Hot Wire

Mobile power source for orbital tube welding



POLYSOUDE
THE ART OF WELDING

PL6 SERIES

Mobile power source for orbital tube welding

Compatible with all Polysoude™ welding heads particularly with those equipped with Arc Voltage Control (AVC) and Torch Oscillation Control (OSC)

Advantages

- ▶ Automatic welding procedure generation with an intelligent and intuitive user interface combined with the latest most reliable industrial electronics
- ▶ Help for optimising welding procedures
- ▶ Real time welding data acquisition
- ▶ High precision inverter power source, compact design with built-in water cooling system for welding head and torch

Resulting from 50 years' experience in mastering welding technologies



General characteristics

Program control by time or angular degrees calibrated in mm/min or inch/min

Comprehensive real-time welding data acquisition

Error-diagnostic system

Automatic welding head recognition

Built-in printer for welding procedure archiving and documentation

Ethernet compatible

Closed loop regulation of torch rotation and wire speed

Built-in Arc Voltage Control (AVC) and Torch Oscillation Control (OSC)

Torch gas control with safety valve and flow detection

Built-in closed loop water cooling system with safety valve for welding head and torch



Offline & online programming with standard PC as well as optional touch screen



USB memory stick for saving, loading and archiving of welding programs and monitored welding data



Compatible with standard peripheral equipment: printer, bar code reader, oxygen indicator etc.



Full function remote control 4-axes or 6-axes with welding program selection

Associated welding heads



▶ MU Series

Open welding heads with or without AVC and OSC for TIG tube-to-tube welding with filler wire



▶ TS Series

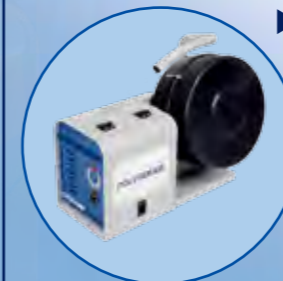
Open and closed welding heads with or without AVC for TIG tube-to-tubesheet welding with or without filler wire



▶ Polycar Series

Open-type carriage welding heads with AVC and OSC for welding of large diameter tubes and pipes, with filler wire

Wire feeders



▶ Polyfil series

External portable wire feeders with spool protection

Welding solutions



▶ Automated welding systems

TIG – Cold Wire, Hot Wire Plasma



Technical specifications

Welding method	TIG - Cold Wire	TIG - Hot Wire
Input power	Three phase 400 V / 415 V \pm 10 % - 50 / 60 Hz incl. multi voltage kit option from 200 V to 480 V	Three phase 400 V / 415 V \pm 10 % - 50 / 60 Hz
Open circuit voltage	98 V	78 V
Insulation class	F	
Protection class	IP 23S (touch screen closed)	
Welding current range Hot Wire current range	5 to 300 A - constant or pulsed	5 to 520 A - constant or pulsed 3 to 140 A
Welding current precision	\pm 1 A when $I \leq 100$ A and \pm 1% when $I > 100$ A	
Duty cycle welding current Duty cycle Hot Wire	300 A / 60 % - 240 A / 100 %	\geq 520 A / 60 % - 420 A / 100 % 140 A / 100 %
Motion controls	Torch rotation: constant or pulsed Wire feeder: constant or pulsed / automatic wire retract AVC - Arc Voltage Control OSC - Torch Oscillation Control	
Shielding gas control	Welding gas, backing gas, with flow safety valve	
Power source cooling	Forced ventilation	
Welding torch cooling	Built-in closed loop water cooling system with flow safety valve	External cooling system with internal flow safety valve
Display / recording (non-volatile) of real values during welding	Arc Voltage, welding current, electrode position in angular degrees, welding speed and wire speed	
Real time data acquisition	Hard disc / USB memory stick	
Dimensions L x W x H	630 x 470 x 795 mm 630 x 470 x 970 mm (incl. multi voltage option) 950 x 560 x 1130 mm (incl. multi voltage + trolley option)	800 x 470 x 950 mm 1060 x 530 x 1145 mm (incl. trolley option)
Weight	75 kg 115 kg (incl. multi voltage option)	138 kg 154 kg (incl. trolley option)
Standards	EN 60974-1 / EN 60974-10	



Options and accessories

- Large 10.4" colour touch screen with multilingual, graphically assisted welding software
- Laptop
- Full function remote control 6-axes
- Wire feeder
- AVC - Arc Voltage Control
- OSC - Torch Oscillation Control
- Interface for welding manipulators for mechanised welding (positioner, column and boom, seam welder...)
- Hot Wire capability
- Multi voltage kit 200 V to 480 V (not for Hot Wire version)
- Control kit for other than POLYSOUDE™ welding heads
- Extension cable (15 m) for welding heads
- Kit for backing gas
- 2nd integrated cooling unit
- Dual welding head switch box (only for Cold Wire version)
- Trolley

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

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