



# POLYCAR 60-2

TIG - Cold Wire, Hot Wire, AVC, OSC

**Open Type Carriage Welding Head**  
for welding of tube and pipe joints



**POLYSOUDE**  
THE ART OF WELDING

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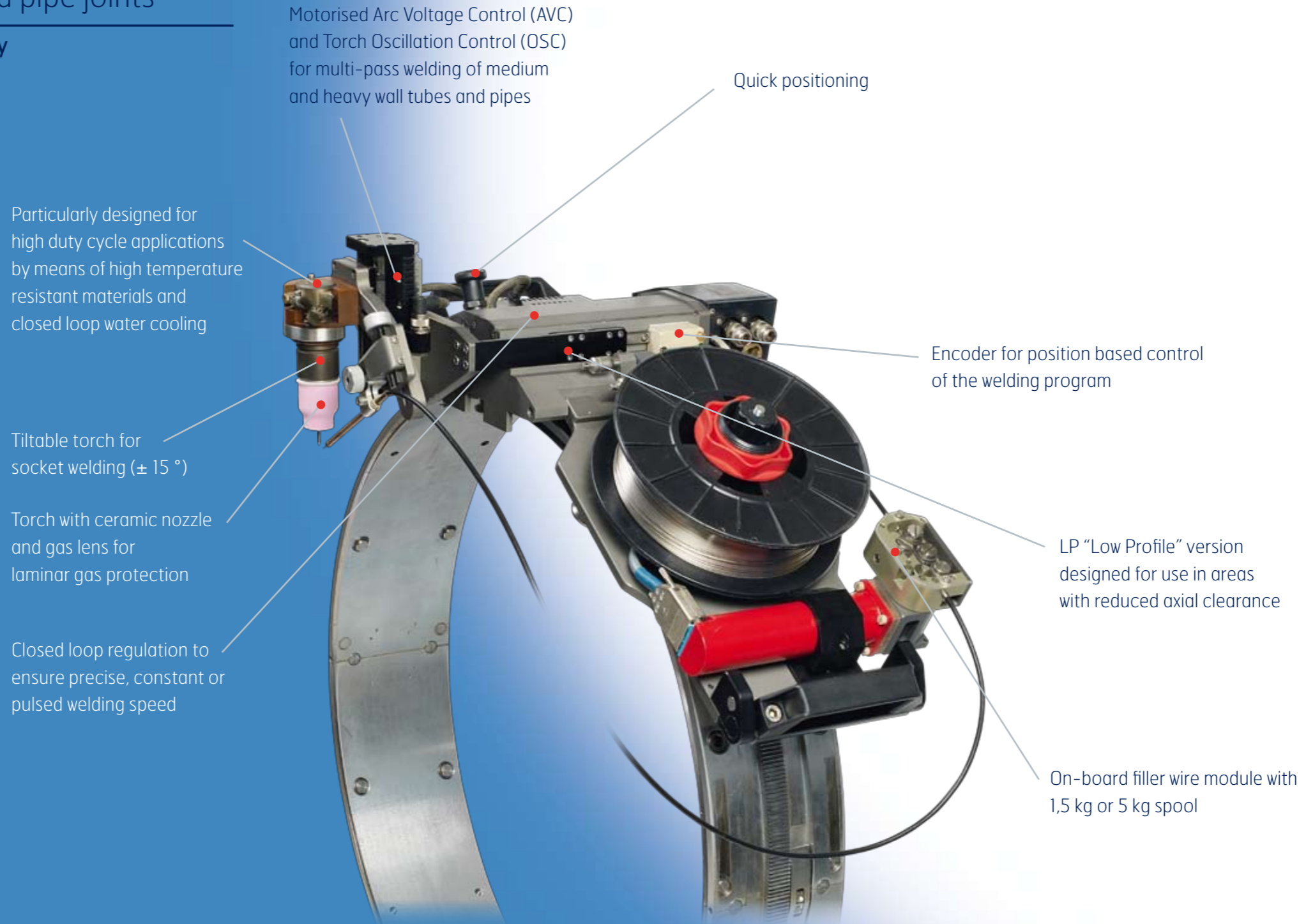
Highest flexibility and quality

### Advantages

- ▶ Minimal radial and axial clearance
- ▶ Modular design for orbital TIG Cold Wire and Hot Wire welding
- ▶ Perfectly adapted to tube and pipe welding of medium-sized and heavy wall thicknesses
- ▶ Reproduces all movements of a manual welder and completes the weld in a series of passes
- ▶ Especially designed for welding under difficult conditions in workshop or on site
- ▶ Narrow Gap Welding for further productivity increase

Resulting from 50 years' experience in mastering welding technologies

## General Characteristics



Torch block with AVC/OSC cross slides and adjustable wire guide



On-board wire feeder with straightening device



Chromium guide rings for all tube and pipe O.D.s



Torch module "V2 Narrow Gap", for wall thicknesses up to 75 mm

### Associated Power Sources



#### ▶ PS 406-2

400 A, "all inclusive", with Arc Voltage Control (AVC) and Torch Oscillation Control (OSC), three-phase power supply



#### ▶ P6

300 A, "all applications" programming by PC or touch screen, with Arc Voltage Control (AVC) and Torch Oscillation Control (OSC), three-phase power supply



#### ▶ PC Series

300 to 600 A, modular design for perfect adaptation to your application. Interface for mechanised and robotic peripherals, three-phase power supply

 Adapting to all your applications!

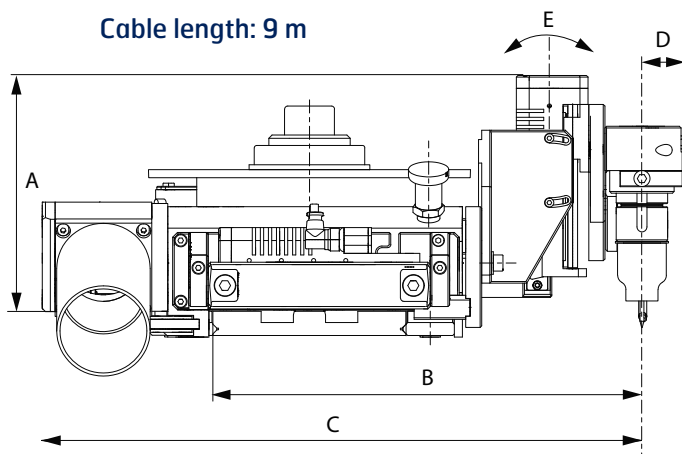


*"Thanks to the automatic welding process we have the guarantee that our welding procedure is perfectly respected."*

# Technical Specification

Welding process / Version	CW - TIG Cold Wire	HW - TIG Hot Wire	LP - TIG Cold Wire
Tube / pipe O.D.	≥ 168 mm / 6"		
• A (min. radial clearance) without offset	167 mm	167 mm	135 mm
• A (min. radial clearance) with offset	190 mm	190 mm	146 mm
• AVC – Arc Voltage Control	60 mm	60 mm	30 mm
• OSC - Oscillation Control	60 mm		
• B (axial clearance for guide ring)	146,5 mm		
• C (overall axial clearance)	375 to 435 mm (OSC = 60 mm)		
Drive motor (AVC/OSC slides)	Stepper motor		
AVC axis speed range	10 - 500 mm / min		
OSC axis speed range	20 - 1000 mm / min		
• E Torch tilting	± 15°		
Max. welding current (A)	300 A		
Electrode diameter	2,4 (standard) / 3,2 / 4,0 mm		
Carriage drive	DC motor, closed loops		
Welding speed range	20 - 400 mm / min		
On-board wire spool diameter	200 mm / 5 kg	200 mm / 5 kg	100 mm / 1,5 kg
Wire feeder drive	DC motor, closed loops		
Wire feed range	95 - 2068 mm / min	360 - 7929 mm / min	95 - 2408 mm / min
Wire diameter	0,8 mm (other dia. on request)		
Welding carriage weight (excl. cable)	9 kg		

Cable length: 9 m



Type	Dimensions in mm					
	Amin without offset	Amin with offset	Bmin	Cmax	D	E
TIG FF	167	190	266,5	435	27	± 15°
TIG FC	167	190	266,5	435	27	± 15°
TIG LP	135	146	266,5	435	27	± 15°

## Options and Accessories

- Guide rings for all tube and pipe O.D.'s
- TIG Hot Wire version for highest deposition rates
- Extension cable (15 m)
- Compact brief-case for transport and storage
- Tungsten electrodes, pre-sharpened and pre-cut
- Tool kit for daily operation
- On-board camera system

# 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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