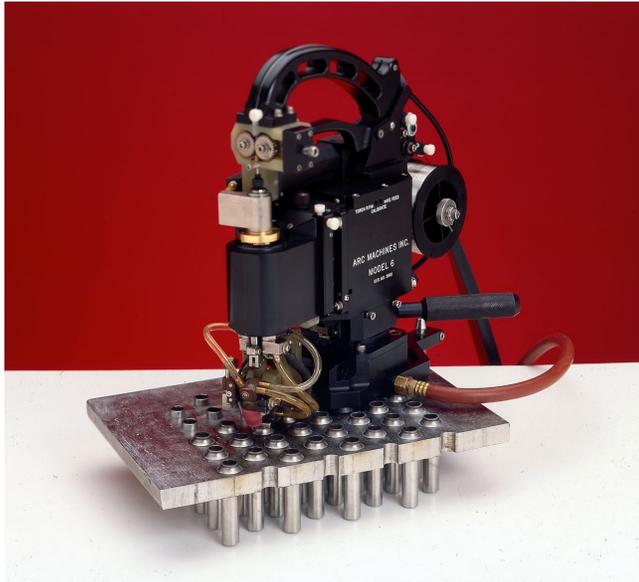


# MODEL 6

## SELF-SUPPORTING TUBE-TO-TUBESHEET GTAW (TIG) WELD HEAD



*The widest range of orbital welding equipment in the world*



### FEATURES

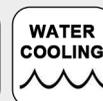
- Rugged, reliable tube-to-tubesheet weld head with 200 A torch.
- Unlimited torch rotation.
- Welds in any position, including overhead.
- Can weld projected or recessed tubes with filler wire, or flush joints without filler wire.
- Makes multiple-pass welds without stopping.
- Air-operated fixtures speed up production.
- Servo-controlled AVC, rotation and synchronized wire feed.
- Water-cooled torches.
- Adjustable torch tilt.
- Automatically sets distance between electrode and tubesheet before arc initiation.
- Non-linear vertical tungsten travel prevents tube-end burn-off.
- Pulsed current welding and synchronized pulsed wire-feed.

The Model 6 is a rugged, field-proven weld head for high-production welding of tube-to-tubesheet using the GTAW process. The Model 6 has exceptionally fast mount and dismount times for ease of operation and productivity. The torch is positioned on the tube to be welded by a pneumatically operated locating fixture. With the touch of a button, the locating fixture precisely locates itself over the tube to be welded.

### QUICK SPECS

<b>Weld Current</b> 200 A	<b>Arc Voltage Control (AVC)</b> Automatic	<b>Rotation Speed</b> 0.1 - 10.0 RPM	<b>Wire Feed Speed</b> 5 - 100 IPM (13 - 254 cm/min.)
<b>Tungsten Size</b> 1/16" or 3/32" (1,6 mm or 2,4 mm ø)	<b>Travel/Rotation Speed</b> 0.1 - 9.9 RPM	<b>Wire Manipulator (manual adj.)</b> vertical, horizontal and angular	
<b>Filler Wire</b> 0.030" recommended (0,8 mm ø)	<b>Wire Spool</b> 2 lbs, 4" standard (1 kg, 100 mm)	<b>Weight (less cables)</b> 16 lbs. (7,3 kg)	

➔ Several torch options are available.



[www.arcmachines.com](http://www.arcmachines.com)

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# MODEL 6

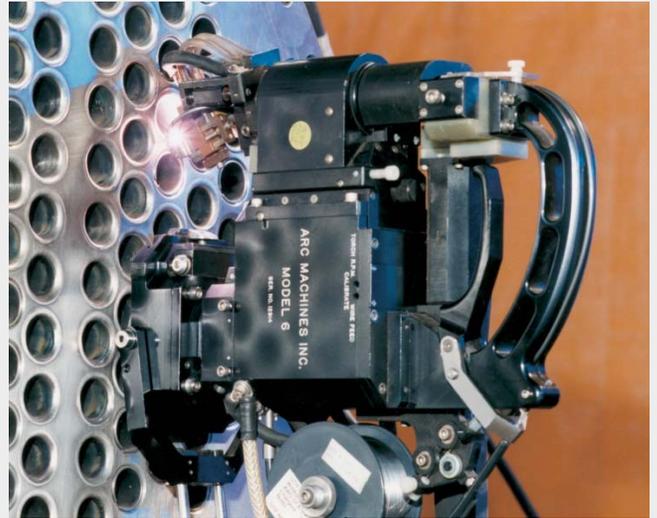
# TUBE-TO-TUBESHEET WELD HEAD

## ● TORCH OPTIONS ●

- "C" torch - for fillet welding of projected tubes
- "D" torch - for fillet welding of projected tubes with minimum spacing between tubes
- "E" torch - for welding flush or recessed tubes

The "C" and "D" torches (for fillet welds) are spring-loaded torches with a chill follower. The chill follower is located on the inside of the tube to be welded and contacts the tube wall exactly opposite the electrode, thus minimizing the possibility of burn-through on thin-wall tubes. The mechanics of the spring-loaded torch allows it to perfectly track the shape of the tube regardless of minor ovality.

*Gas chamber for welding titanium available.*



## ● COMPATIBLE AMI POWER SUPPLIES ●

The Model 6 is compatible with the following AMI Power Supplies:

### Model 227

The #1 Power Supply  
for Heavy Wall  
Pipe Welding



Model 415 WDR  
The Industry's Most  
Advanced Power  
Supply and Controller



## The Global Welding Company

For further information please visit our website  
or contact us at 1-818-896-9556



*Dynamic. Growing. Integrated.*

[www.arcmachines.com](http://www.arcmachines.com)

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