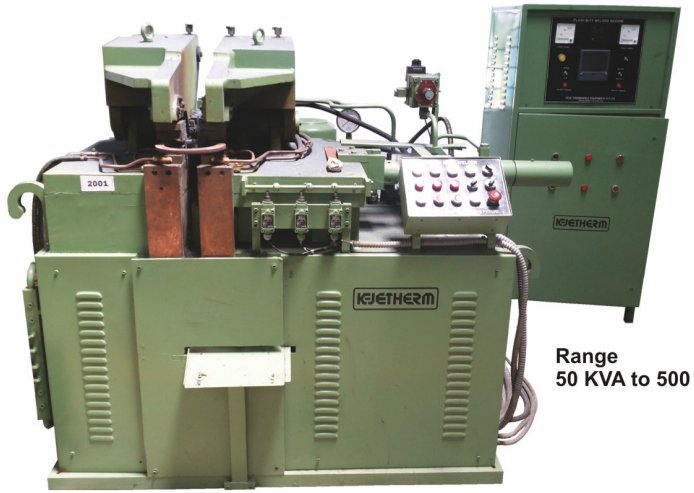
KEJETHERM

The Innovative People

FLASH BUTT WELDER



Range
50 KVA to 500 KVA

KEJE THERMOWELD
EQUIPMENTS PVT. LTD.

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INTRODUCTION

Flash Butt Welding is a modern technique of joining low carbon steel, alloy steel and other dissimilar metals in various tubular or solid sections. Weld quality obtained gives similar properties (mechanical or metallurgical) of the parent metal. Because of shorter weld times the process is suited for higher production than other conventional methods. No additional items such as rods or gas are required. Thus this is highly economical process. High consistency of weld parameters can be obtained and quality is maintained using process recorders. The flash butt welding machine can be connected to computer for data logging through special software. With KEJETHERM machine ISO/ TS 16949 certification can be applied giving better system integration.

APPLICATIONS

- Continuous coil strips in Pipe mfg.
- Ring gears for automobiles & other applications
- Window sections
- Boiler tubes and tubular parts
- Welding HSS to En9 tools
- Moped & Bicycle wheel rims
- Bottom rings of Cylinders
- Construction steel bars upto 0.25% C in Civil industries
- Whole lot of Automobile components such as
- Steering column, Engine valve, Gear shifter and Axles etc.

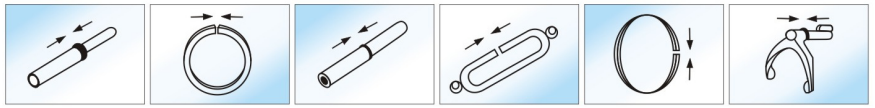
SALIENT FEATURES

- Fully hydraulically operated
- Forced cooled Transformer having core of high grade silicon steel conforms to IS 4804, Part II
- Precision control on initial die opening, flash off length, time, length and final die opening (Optional servo drive)
- Interlinked sequentially for prolonged trouble-free operation with safety features
- Pre-heat and Post-heat cycles available
- High rigid structure, duly stress relieved after welding to counter the flashing and upset forces
- Basic Machine can be fitted with wide range of toolings engineered for the application and to suit individual components

Technical Data

↓ Specifications / Model ⟶	Units	TFH-50	TFH-75	TFH-100	TFH-150	TFH-200	TFH-250	TFH-350	TFH-500
Supply Voltage at 1 ph. 50 Hz.	V	415	415	415	415	415	415	415	415
Continuous Rating of transformer	KVA	35	55	70	105	140	175	245	350
Nominal Rating at 50% duty cycle	KVA	50	75	100	150	200	250	350	500
Swicth Fuse	A	125	200	250	400	500	630	1000	1250
Current Taps	Nos.	3	3	3	3	4	4	4	4
Insulation Class		F	F	F	F	F	F	F	F
Cooling		Forced Air Cooled							
Clamping Force (Hydraulic)	Tonnes	5	8	10	15	20	25	35	50
Upset Force (Hydraulic)	Tonnes	3	4	7	10	13	15	20	35
Welding Capacity Mild Steel	mm^2	340	400	750	960	1120	1420	2000	2850
Welding Capacity Alloy Steel	mm^2	280	340	650	800	950	1200	1700	2430
Cooling Water required	LPM	15	20	25	25	40	40	55	80
I/P Cable cross-section in Copper	mm^2	50	70	95	125	200	200	300	400

MODELS WITH HIGHER KVA NOMINAL RATING AND OTHER SPECIAL KVAs CAN BE DESIGNED ON REQUEST.



Cutting Tools | Gear Rings/ Steering Rings | Boiler Tubes | Chain Links | Cycle Rims | Fork Shifter

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