



Catalogue

Weld Overlay Solutions

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Icons & Legends



TIG Cold Wire technology



TIG Hot Wire technology



TIG^{er} technology



Computer Numerical Controller (CNC)



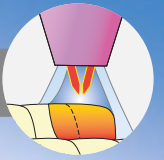
Conventional Controller



Programmable motion (motorised)



Non-programmable motion (manual or motorised)



GTAW/TIG & TIG^{er}

The main advantages of TIG CW/HW compared to other processes: all position use, excellent surface quality, clean without spatter... Zero defects.

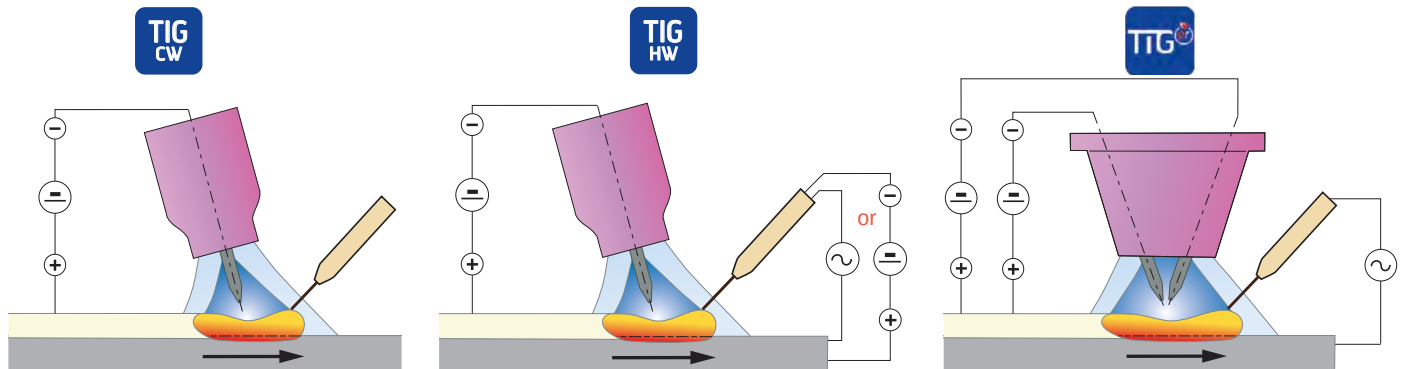
The TIG^{er} technology is a Polysoude innovation based on the TIG (GTAW) process. It is designed to guarantee quality, to increase significantly the deposition rate and to reduce dilution.



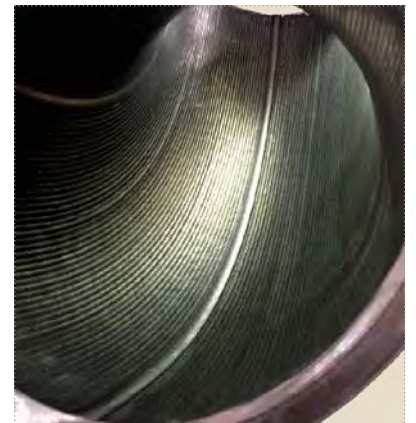
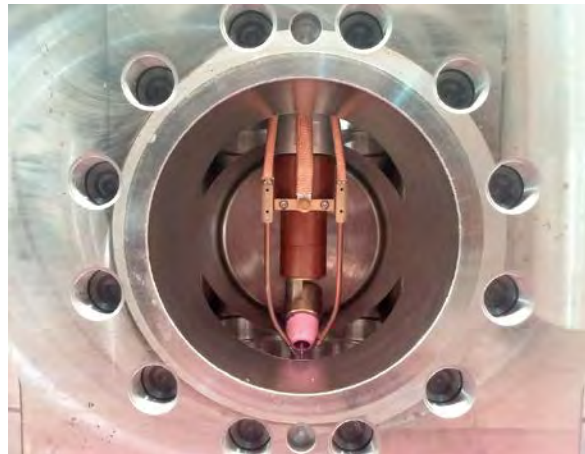
	TIG CW	TIG HW	TTG
Electrode	1	1	2
Wire	CW	HW - DC or AC	HW - AC
Arc type	Single arc	Single arc	Two arcs in one
Deposition rate			
Single torch (*)	up to 1 kg/h	up to 2.5 kg/h	up to 6 kg/h
Twin torch (#)	-	up to 4 kg/h	up to 9 kg/h
Minimum I.D. before weld overlay considering 2 layers	28 mm	34 mm	100 mm

(*) Maximum deposition rate given for reference, produced under optimal conditions (welding position, application type, base material, surface and filler wire)

(#) The deposition rate in "Twin" configuration is a balance between the optimal characteristics for the first layer (the lowest possible thickness and therefore dilution) and the weld overlay speed for the simultaneous execution of the first and second layer.



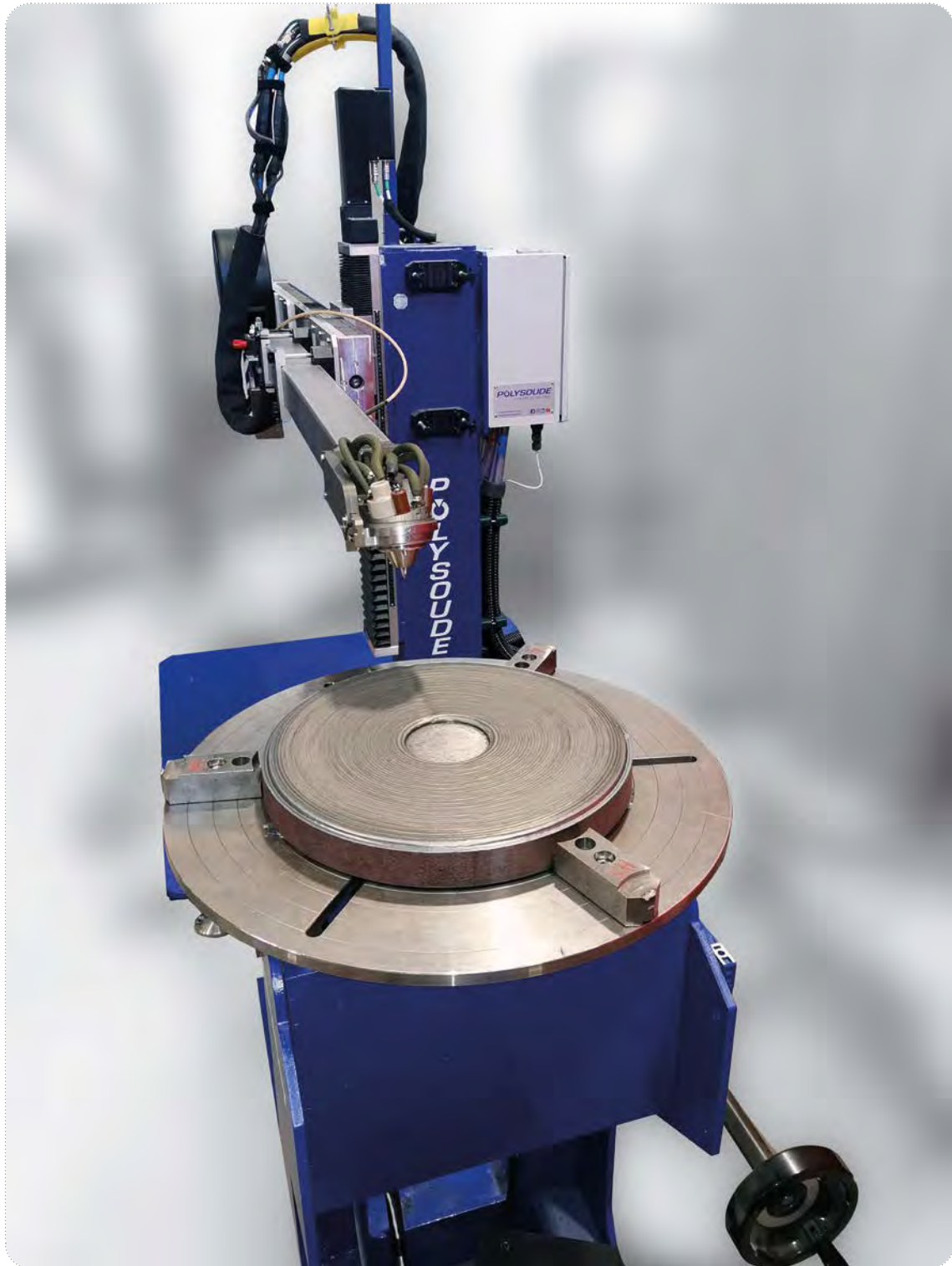
Workpieces and application examples






Courtesy of CFHI, Newtesol, NVO, AMPO, Paiju, RocMaster and Subsea Services

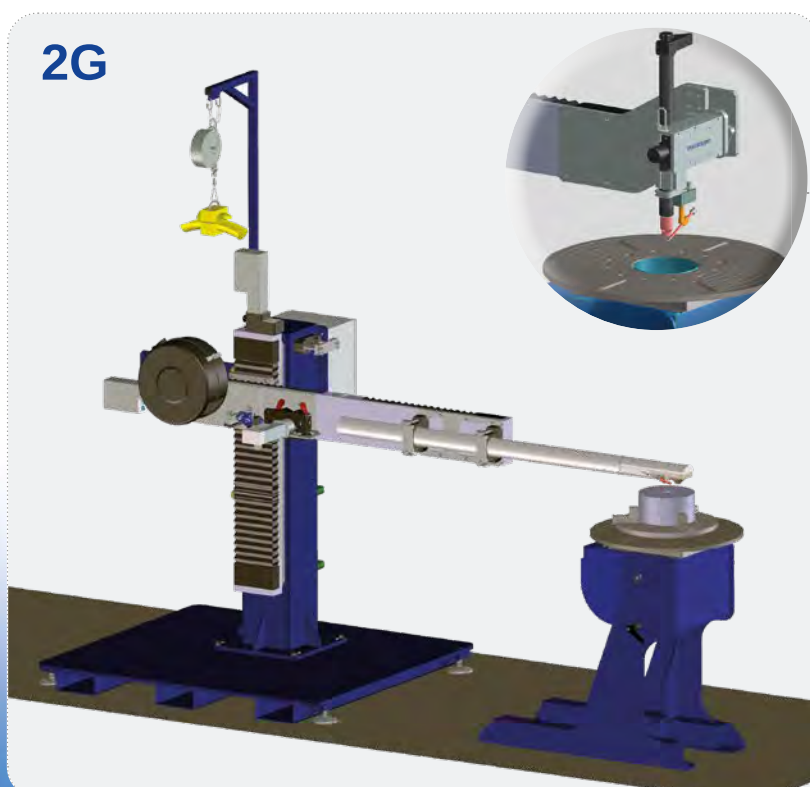
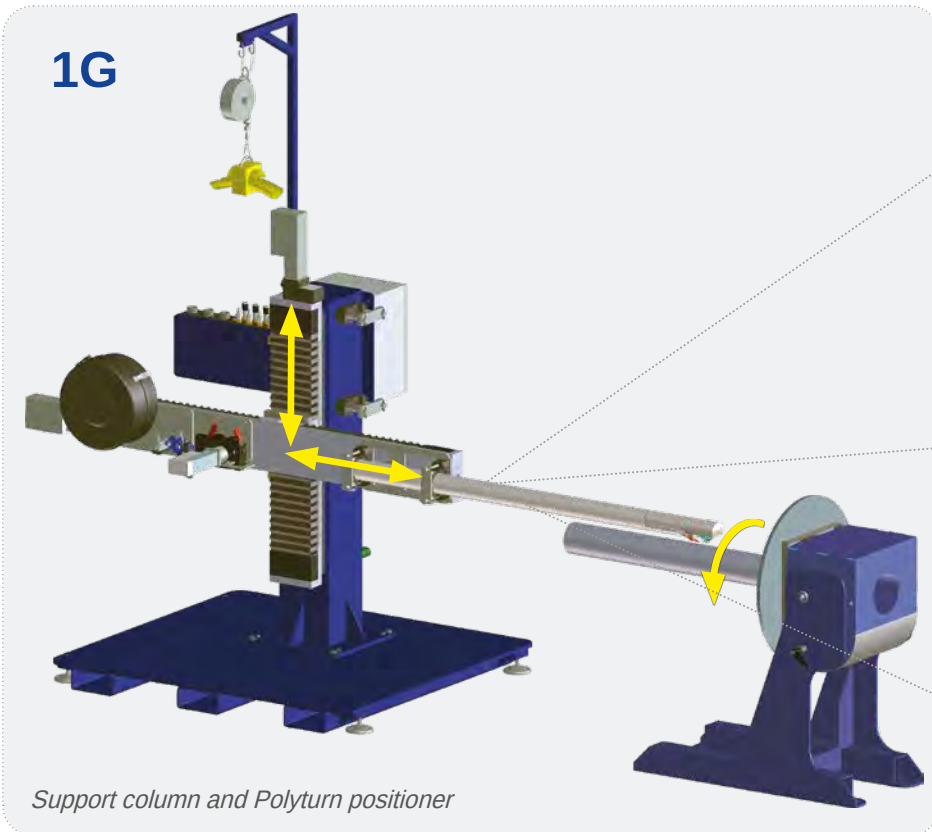


PolyClad Easy



► Advantages

- Ease of setup
- Extra compact
- Versatility: vertical and horizontal overlay positions
- Delivered with a library of typical weld overlay programmes
- Flexibility: wide range of lances and torches
- Multiprocesses:   

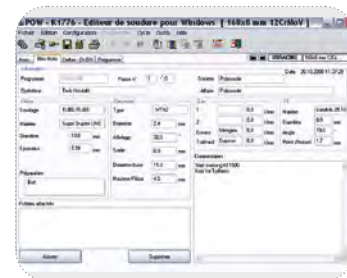


► Programming software

Solution with conventional controller:

Main items

- Support column
- Cross slides (AVC/Step-over)
- Wire feeder
- Lance/torch
- Titable positioner Polyturn
- Smart welding station



► Variants / options - accessories

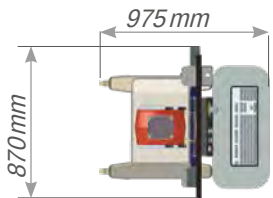
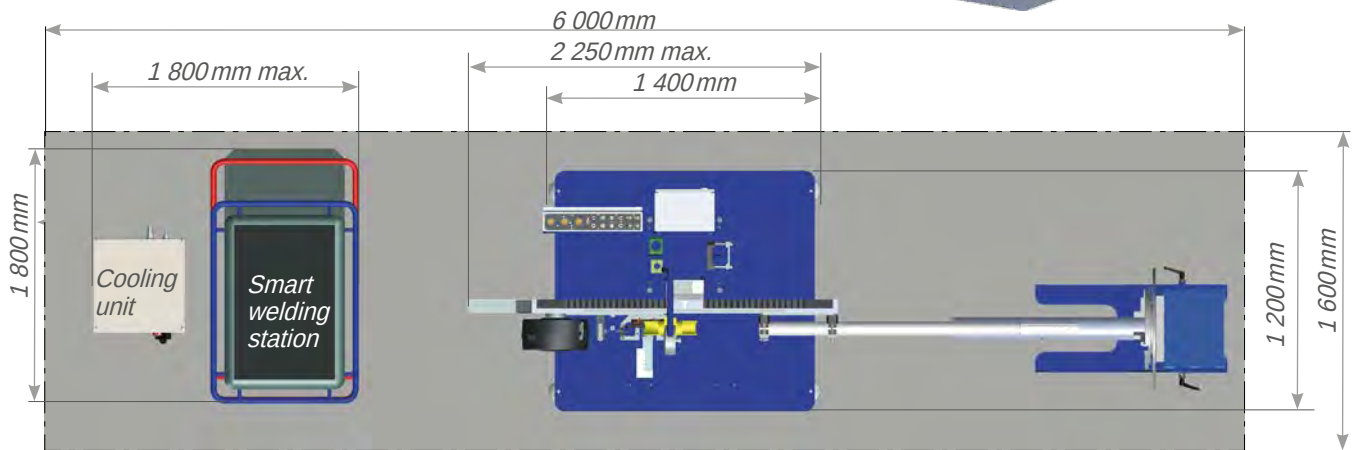
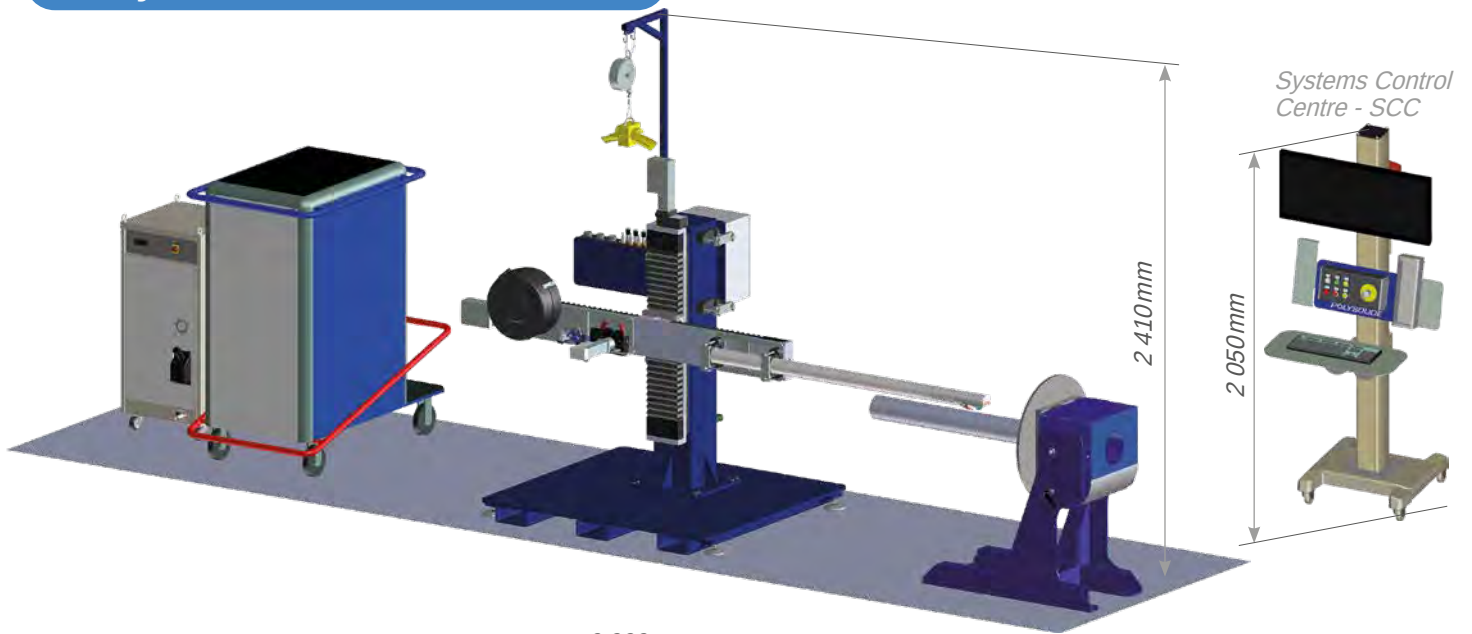
- High resolution video monitoring
- TIG HW or TIG^{er}
- DAQbox - tool for productivity management and data acquisition
- Systems Control Centre (◆)



► Technical data

Cross slides stroke	1.0 m x 0.6 m
Wire feeder	0.5 to 14m/min
Compatible with wire spool	Ø 300 mm - 15 kg
Capacity of the positioner	
Maximum load	300 kg (welding position 2G) 200 kg (welding position 1G) with roller support
Workpiece diameter	Ø 50 to Ø 300 mm
Maximum length of weld overlay lance	Up to 1.5 m

► Layout and utilities



Utilities

Smart welding station - TIG HW	400V - three-phase - 33kVA
Video container or SCC	230V - single phase - 6kVA
Cooling unit	230V - single phase - 4kVA

► Product items numbers

PolyClad Easy - weld overlay installation (including support column, cross slides, wire feeder, smart welding stations and cooling unit)

TIG **POW_{in}**

TTG **POW_{in}**

0038300005

0038300006

Tiltable positioner (max load 300 kg) :

Polyturn positioner with chuck O.D. 600 mm (hollow shaft Ø 170 mm)

0038001517

P0 285 motor drive (ratio 1:285)

0038850301

Chuck O.D. 200 mm, hollow shaft Ø170 mm - $20 \leq OD \text{ tube} \leq 210 \text{ mm}$

0038004020

Chuck O.D. 400 mm, hollow shaft Ø170 mm - $120 \leq OD \text{ tube} \leq 380 \text{ mm}$

0038004019

Digital display for torch position and step-over

0033842401

DAQbox - Data acquisition system

0033249101

Systems Control Centre (optional)

On request

Torches and lances

See Torches and lances on page 39

Video system (optional)




On request

Vertical weld overlay solutions

PolyClad 3C Compact Cladding Center



▶ Advantages

- Ready to use
- Wide range of use for both simple and complex workpieces
- Compact and transportable
- Prewired on platform
- Flexibility
- Multiprocesses:   



TIG^{er} torch



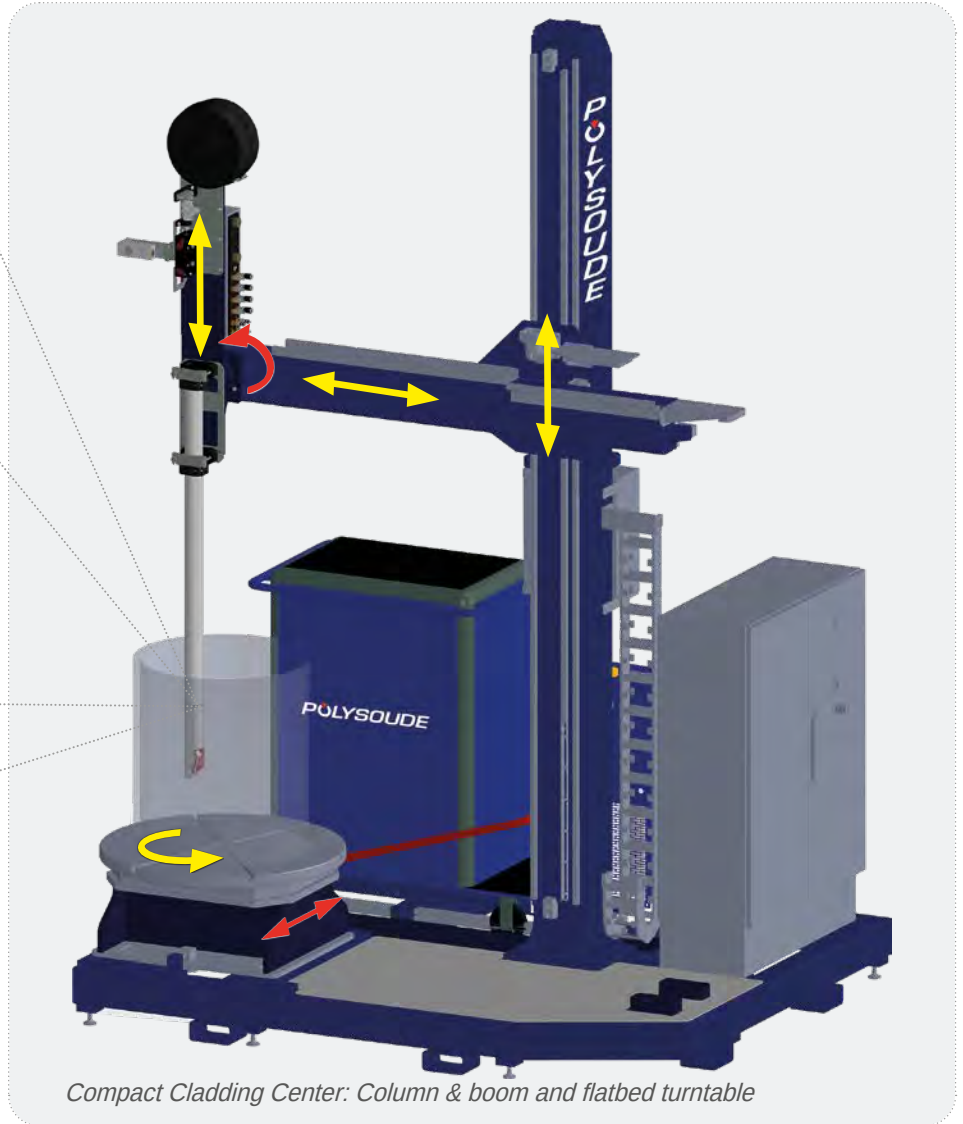
Tiltable TIG^{er} torch



TIG CW/HW lance with tiltable torch



TIG WP27 CW/HW torch



Compact Cladding Center: Column & boom and flatbed turntable



Manual swivel bracket on the boom end

Compact Cladding Center ready to transport

► Programming software

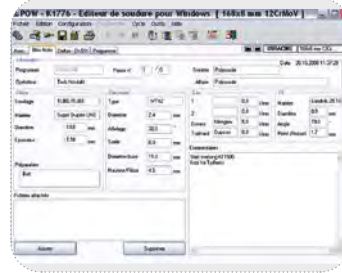
Two solutions depending on the workpieces complexity to be cladded:

► Main items

- High accuracy column & boom
- Flatbed turntable
- Lance/torch
- Smart welding station



POWin Conventional controller

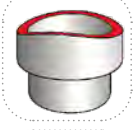
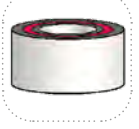


► Variants / options - accessories

- High resolution video monitoring
- TIG HW or TIG^{er}
- Systems Control Centre (◆)
- DAQbox - tool for productivity management and data acquisition



CNC CN Controller

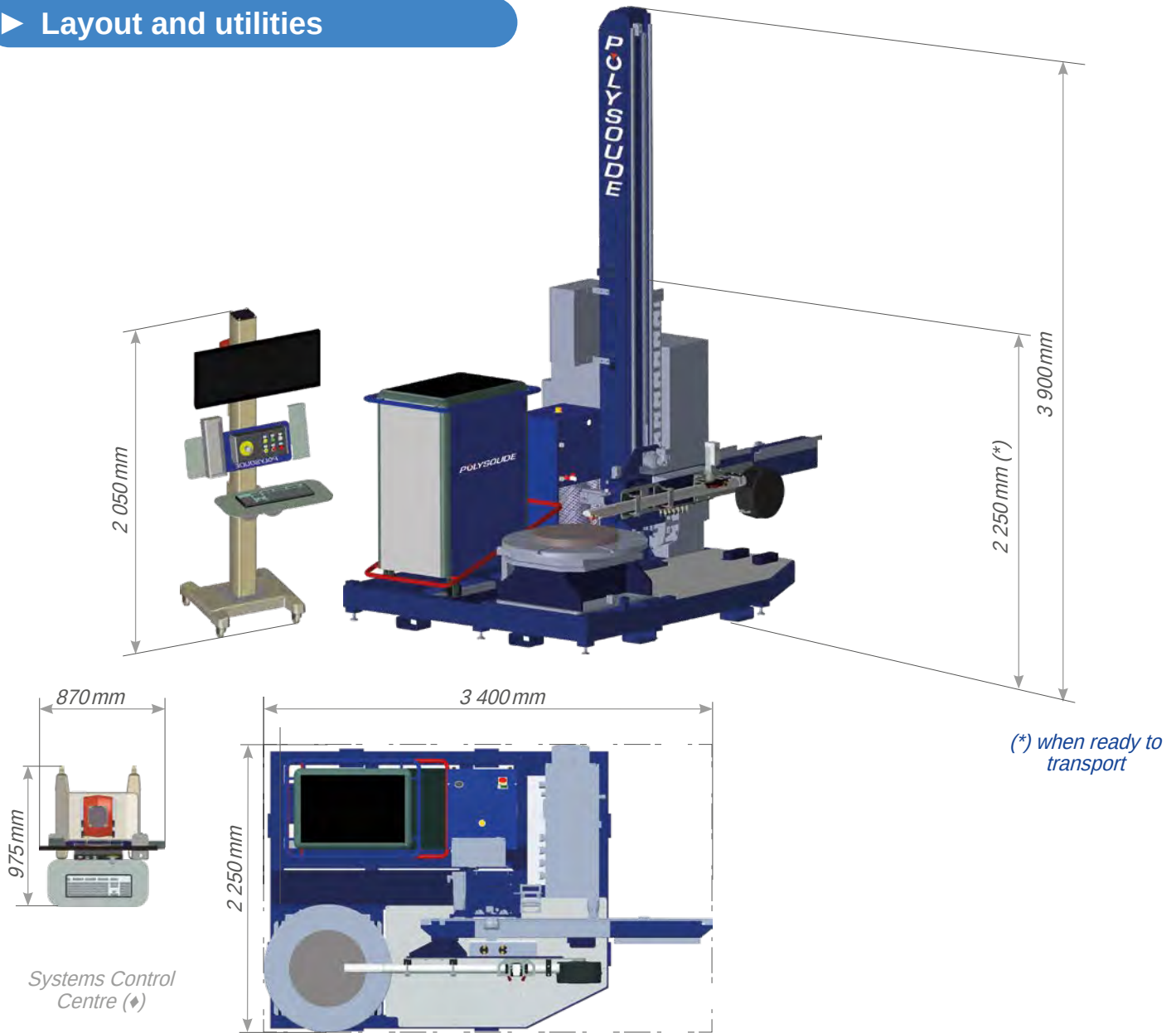


► Technical data

Column & boom	
Maximum height under boom	3m
Vertical stroke (max.)	2.5m
Horizontal stroke (max.)	1.5m
Maximum load on boom end	70kg
Wire feeder	0.5 to 14 m/min
Compatible with wire spool	Ø 300 mm - 15 kg
Capacity of the flatbed turntable	4.5t - Ø 1 m
Maximum length of weld overlay lance	1 m
Workpiece length	Up to 1.5 m

Other sizes of C&B and flatbed turntable are available on request.

► Layout and utilities



Utilities

Column & Boom	400 V - three-phase - 3 kVA
Smart welding stations - TIG CW/HW	400 V - three-phase - 33 kVA
Video container (optional) or SCC	230 V - single phase - 6 kVA
Cooling unit	230 V - single phase - 4 kVA
Flat turntable	400 V - three-phase - 3 kVA

► Product item numbers




	TIG POW _{in}	TTG POW _{in}	TIG CNC	TTG CNC
PolyClad 3C - Compact Cladding Center (including C&B, HD cross slides, welding head, smart welding station, flatbed turntable and cooling unit)	On request	On request	0034870001	0034870002
DAQbox - Data acquisition system (Accessory)	0033249101		Included	
Systems Control Centre (optional)	On request		Included	
Torches and lances	See Torches and lances on page 39			
Video system (optional)	On request			

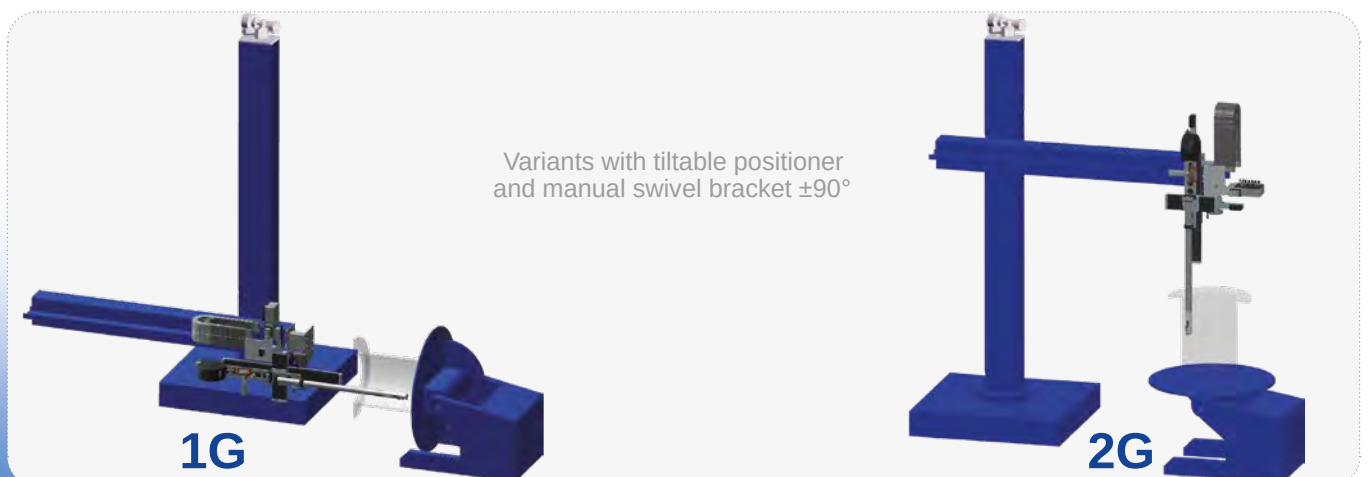
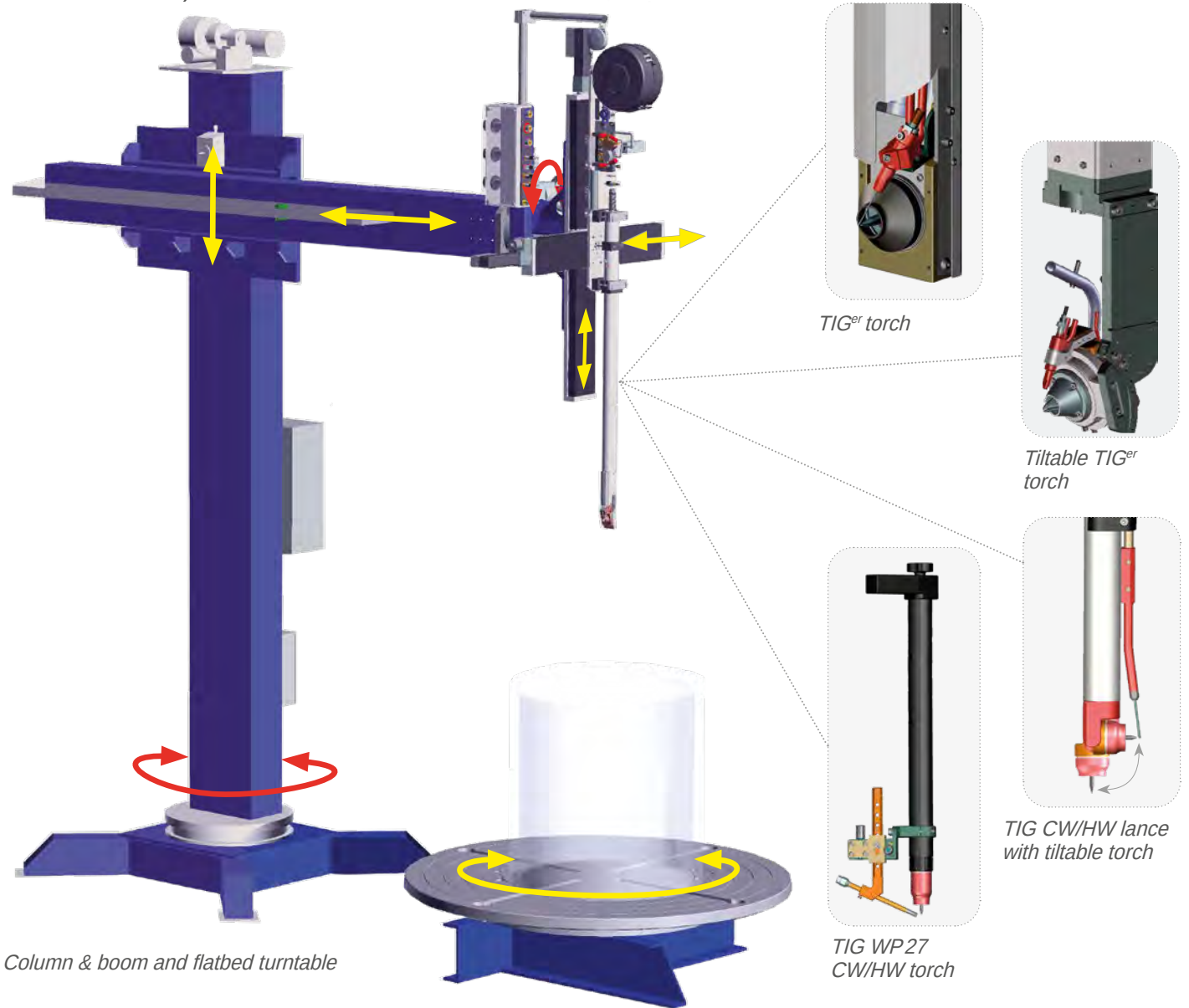
Vertical weld overlay solutions

PolyClad C&B Column & boom and flatbed turntable



► Advantages

- Ease of setup
- Compact, modular standard design
- Versatility: vertical and all other weld overlay positions
- Two possibilities of cross slide mounting (front or side mounted)
- Delivered with a library of typical weld overlay programmes
- Flexibility: wide range of lances and torches
- Multiprocesses:   



► Programming software

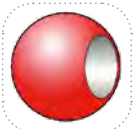
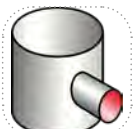
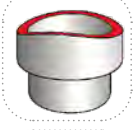
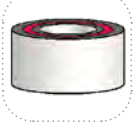
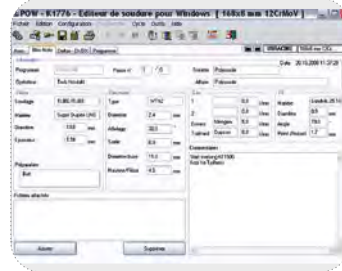
Two solutions depending on the workpieces complexity to be clad:

► Main items

- Column and boom
- Cross slides
- Wire feeder
- Lance/torch
- Flatbed turntable
- Smart welding station

► Variants / options - accessories

- High resolution video monitoring
- Tilttable positioner
- TIG HW or TIG^{er}
- Manual swivel bracket $\pm 90^\circ$ (cross slide tilting)
- High temperature bellows
- Systems Control Centre (◆)
- DAQbox - tool for productivity management and data acquisition

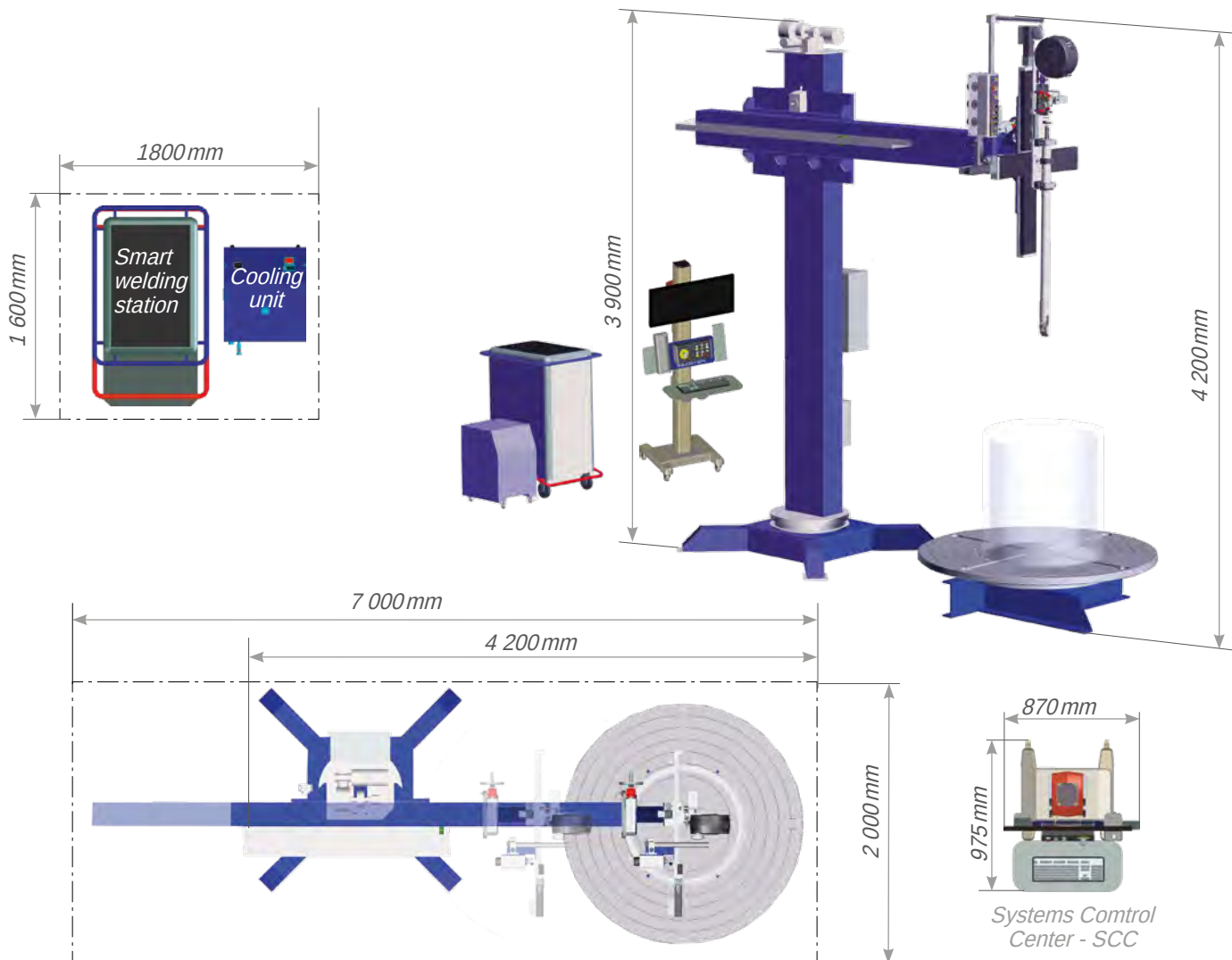


► Technical data

Column & boom	3 m x 2 m
Maximum height under boom	3 m
Vertical stroke (max.)	2 m
Horizontal stroke (max.)	2 m
Maximum load on boom end	150 kg
Cross slides stroke	1 m x 0.6 m
Wire feeder	0.5 to 14m/min
Compatible with wire spool	Ø300 mm - 15 kg
Capacity of the flatbed turntable	3t - Ø1.5 m
Capacity of the positioner	2t - Ø1 m
Maximum length of weld overlay lance	1 m

Other sizes of C&B, flatbed turntable and positioner are available on request

► Layout and utilities



Utilities	
C&B with flatbed turntable/positioner	400 V - three-phase - 24 kVA
Smart welding stations - TIG CW/HW	400 V - three-phase - 33 kVA
Video container or SCC	230 V - single phase - 6 kVA
Cooling unit	230 V - single phase - 4 kVA

► Product item numbers




	TIG POW _{in}	TIG POW _{in}	TIG CNC	TIG CNC
PolyClad C&B - Standard vertical weld overlay installation (including C&B, cross slides, wire feeder, smart welding station and cooling unit)	0033260002	0033260003	On request	On request
Flatbed turntable 3t	0038002002			
Tiltable positioner 2t	0038001506			
Manual swivel bracket ±90° for cross slides	0033260101			
Digital display set for torch position and step-over (including digital display, torch slide encoder, position counter and cable)	0033842401			
Systems Control Centre	On request			
DAQbox - Data acquisition system	0033249101			
High temperature bellows for cross slides	0033380580			
Torches and lances	See Torches and lances on page 39			
Video system (optional)	On request			



PolyClad SPX SPX endless rotation head



▶ Advantages

- Ease of setup
- Wide range of use for both simple and complex workpieces
- Increased productivity due to endless rotating head
- Flexibility
- Multiprocesses:   
- Autocentring programme for the lance



► Programming software

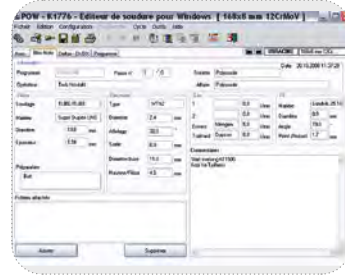
Two solutions depending on the workpieces complexity to be cladded:

► Main items

- Column & boom
- Heavy Duty cross slides
- SPX endless rotation head equipped with wire feeder and AVC cross slides
- Lance/torch
- Smart welding station

► Variants / options - accessories

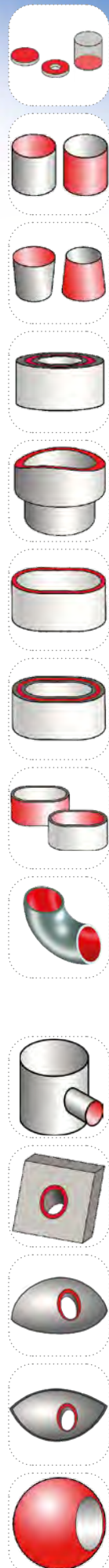
- High resolution video monitoring
- Flatbed turntable
- C&B platform (smart welding station, control cabinet...)
- Manual swivel bracket $\pm 90^\circ$ (SPX head tilting)
- Extension bracket for large workpiece diameters
- Systems Control Centre (◆)
- DAQbox - tool for productivity management and data acquisition



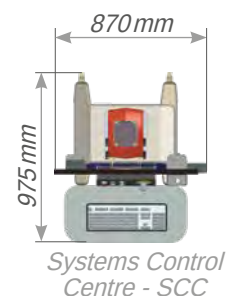
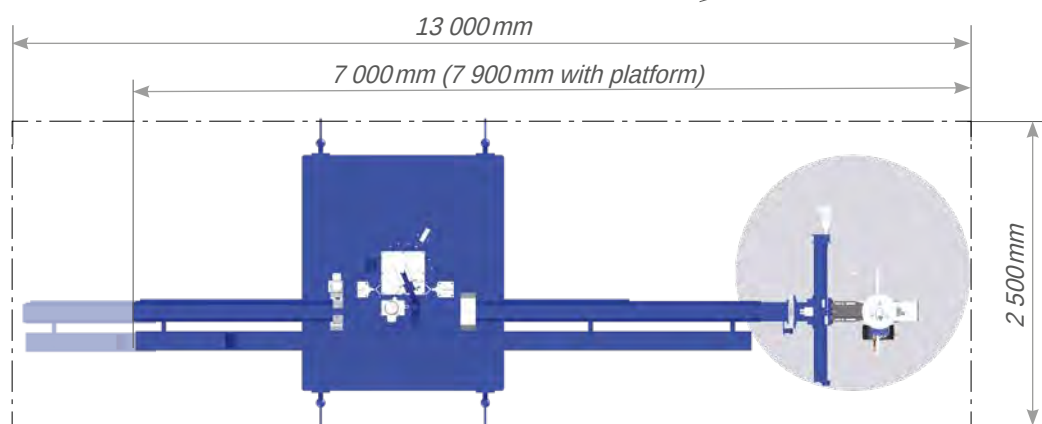
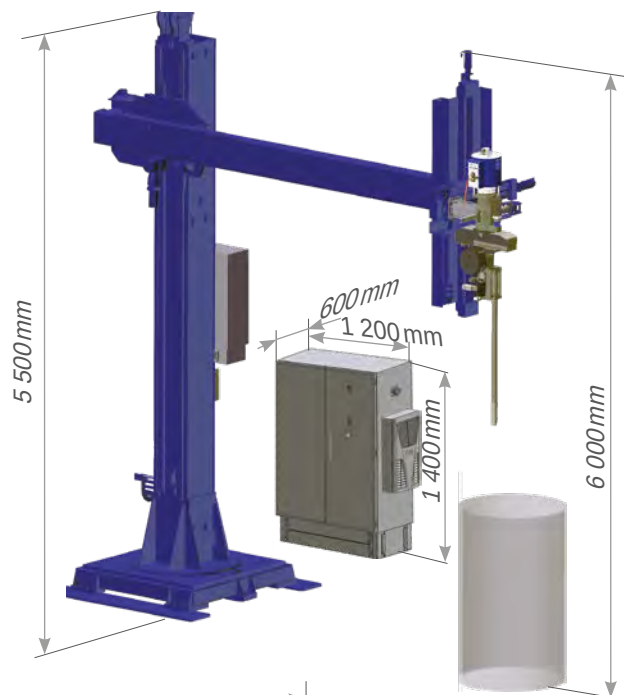
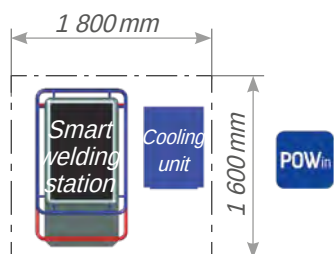
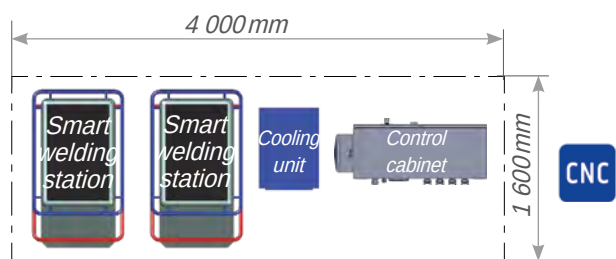
► Technical data

Column & boom	4 m x 4 m - Heavy Duty
Maximum height under boom	4 m
Vertical stroke (max.)	3 m
Horizontal stroke (max.)	4 m
Maximum load on boom end	400 kg
SPX head - workpiece diameter (max.)	600 mm 1200 mm with optional extension bracket
SPX head - AVC slide stroke	300 mm
HD cross slide strokes	2 m x 1 m
Wire feeder	0.5 to 14 m/min
Compatible with wire spool	Ø 300 mm - 15 kg
Capacity of the flatbed turntable (option)	15t - Ø 2.4m
Maximum length of weld overlay lance	1.5m

Other sizes of C&B and flatbed turntable are available on request.



► Layout and utilities



Utilities	
Column & Boom	400 V - three-phase - 16 kVA
Smart welding stations - TIG CW/HW POW_{in}	400 V - three-phase - 33 kVA
Smart welding stations - TIG ^{er} CNC	400 V - three-phase - 1x33 kVA + 1x28 kVA
Video container	230 V - single phase - 6 kVA
Cooling unit	230 V - single phase - 4 kVA
Systems Control Centre (POW_{in} option)	230 V - single phase - 4 kVA
Flat turntable (optional)	400 V - three-phase - 6 kVA

► Product item numbers

PolyClad SPX-2 - Standard vertical weld overlay SPX installation (including C&B, HD cross slides, SPX head, smart welding station(s), cooling unit)

Flatbed turntable 15t - Ø2.4 m

C&B platform

Manual swivel bracket ±90° for SPX cross slides

Extension bracket for SPX large diameter

DAQbox - Data acquisition system

Systems Control Centre

High temperature bellows for SPX cross slides

Torches and lances

Video system

	TIG POW_{in}	TTG POW_{in}	TIG CNC	TTG CNC
PolyClad SPX-2 - Standard vertical weld overlay SPX installation (including C&B, HD cross slides, SPX head, smart welding station(s), cooling unit)	0033690001	0033690005	On request	0033690004
Flatbed turntable 15t - Ø2.4 m	0038002003		0038002003	
C&B platform	0038001007		0038001007	
Manual swivel bracket ±90° for SPX cross slides	0038001006		0038001006	
Extension bracket for SPX large diameter	0032800201		0032800201	
DAQbox - Data acquisition system	0033249101		On request	
Systems Control Centre	On request	On request	Included	
High temperature bellows for SPX cross slides	0033380581		0033380581	
Torches and lances	See Torches and lances on page 39			
Video system	On request		Included	



PolyClad TWIN-TIG^{er} C **TWIN-TIG^{er}-12m: 360° full length I.D. weld overlay**

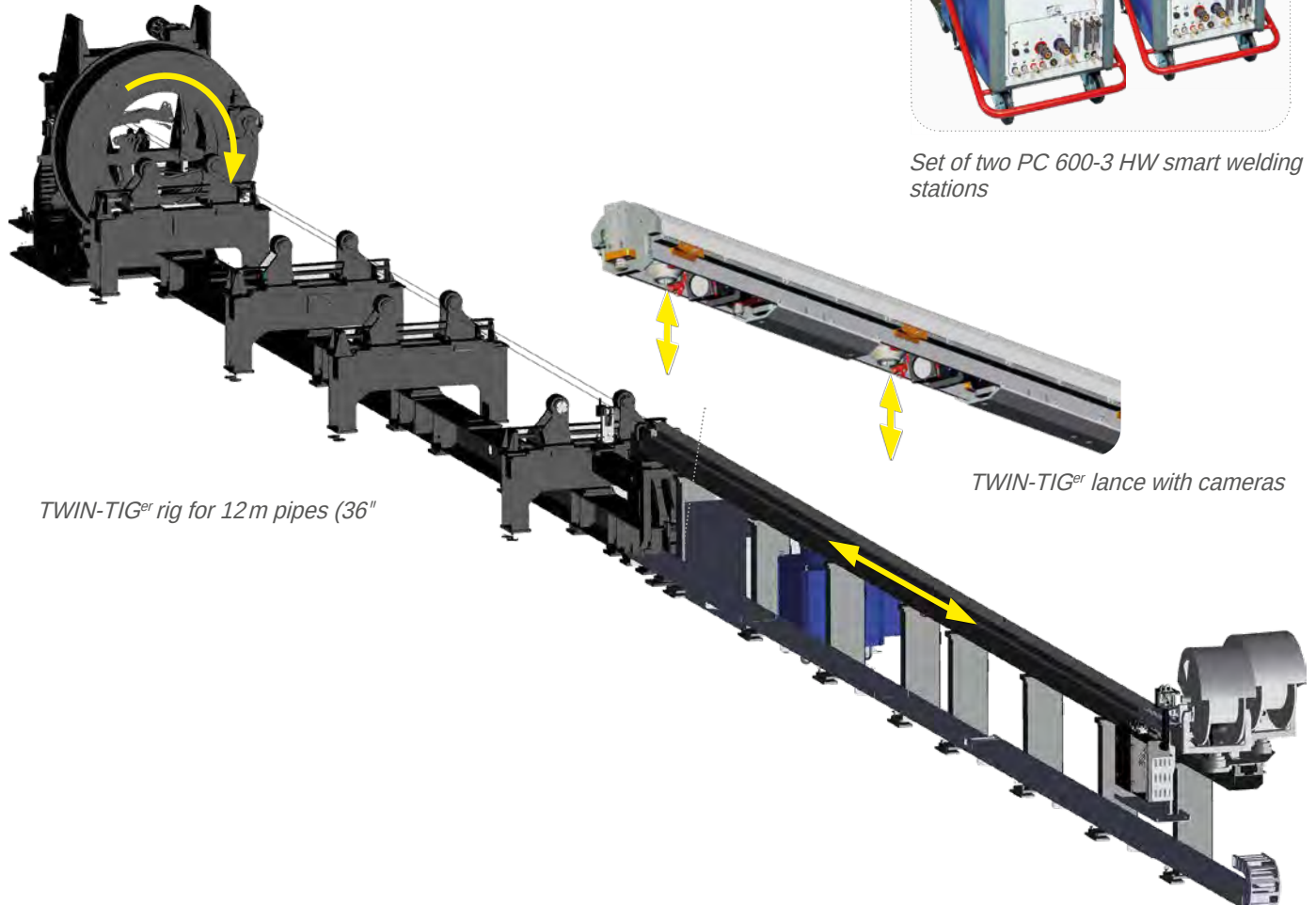


▶ Advantages

- Ease of setup
- Two simultaneous layers
- AVC control (independent for each torch)
- Video for continuous monitoring and relocation
- High deposition rate & high productivity

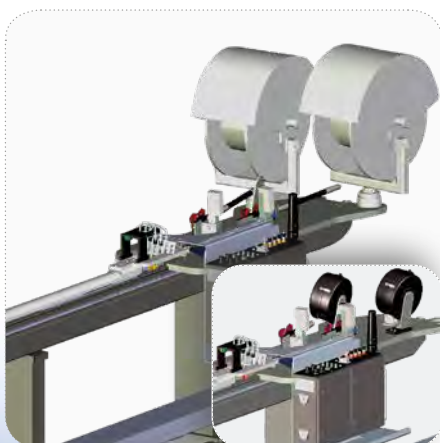


Set of two PC 600-3 HW smart welding stations

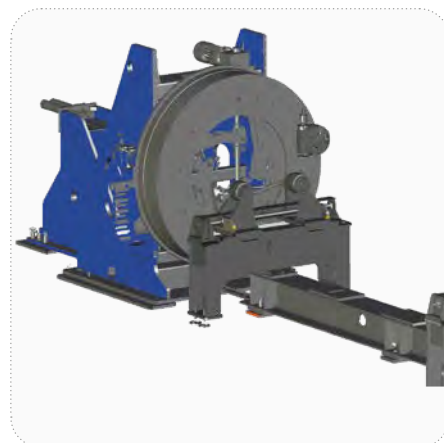


TWIN-TIG^{er} rig for 12m pipes (36")

TWIN-TIG^{er} lance with cameras



Carriage with 2x250 kg or 2x15 kg wire spools



Rotator with special clamping chuck

► Systems Control Centre

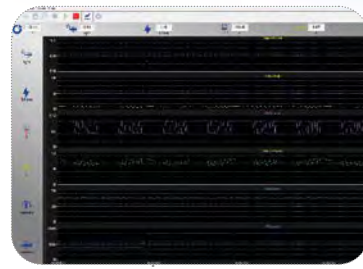
Delivered with the machine

► Main items

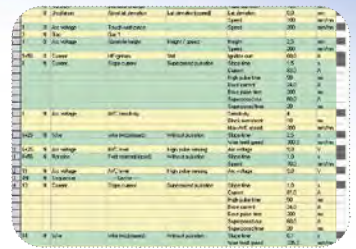
- Horizontal guiding beam - travel carriage - wire feeder units
- Weld overlay lance with two TIG^{er}-2 torches "TWIN-TIG^{er}"
- Head stock rotator
- Special clamping chuck
- Pipe supports
- Rope tensioning system
- Set of PC 600-3 smart welding stations

► Variants / options - accessories

- Extra travel carriage for preheating/cooling devices
- DAQbox - tool for productivity management and data acquisition
- Interpass temperature measurement



DAQbox (optional)



Weld overlay programming software (weld overlay parameters)



Video 1



Video 2



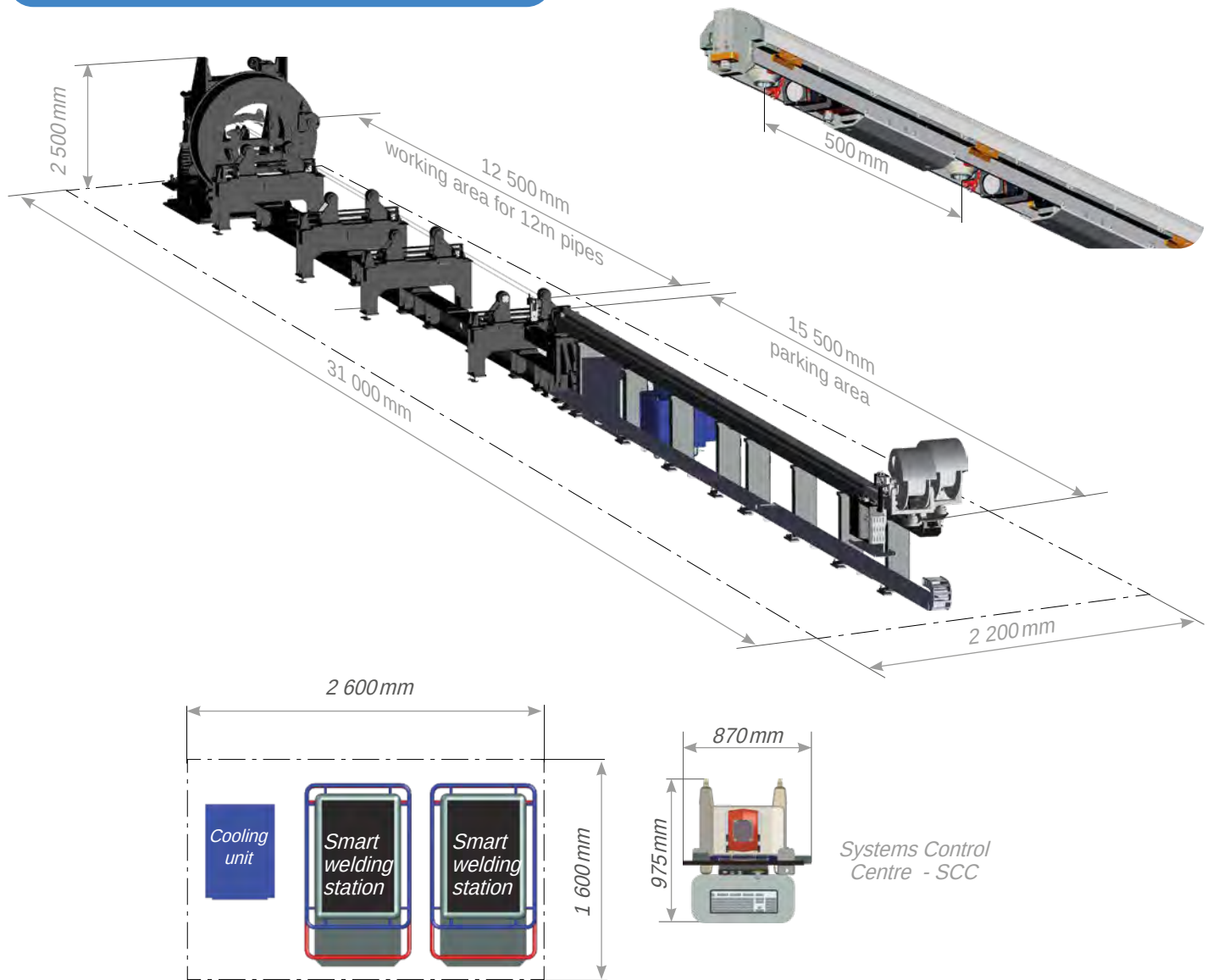
Operator programming interface

► Technical data

Pipe	
I.D. min. (pipe length 12 m)*	150 mm (5 29/32")
Clamping chuck	36" - 6" ≤ O.D. _{tube} ≤ 36" or 72" - 16" ≤ O.D. _{tube} ≤ 72"
Distance between torches 1 & 2	500 mm
AVC stroke (independant for each torch)	40 mm
Wire feeder (x2)	0.5 to 14 m/min
Compatible with wire spool	Ø 760 mm - 250 kg or Ø 300 mm - 15 kg
Video	1 camera per torch

* Before weld overlay considering 2 layers

► Layout and utilities



Utilities

Smart welding stations	400 V - three-phase - 33 kVA
Electrical cabinet	400 V - three-phase - 13 kVA

► Product item numbers

PolyClad TWIN-TIG^{er} C-2 - Standard horizontal weld overlay installation
(including horizontal guiding beam, head stock rotator, weld overlay lance with one motorised camera per torch, smart welding stations, cooling units, Systems Control Centre)

Extra travel carriage for preheating/cooling devices

DAQbox - Data acquisition system, electrical cabinet model

Interpass temperature measurement (optional)

Gas and power consumption measurements (optional)

Wire level control kit (optional)


	6" ≤ O.D. ≤ 36"	16" ≤ O.D. ≤ 72"
	0039170001	0039170002
		0038009005
		0039179200
		0039178100
		0039179201
		0039178101



PolyClad TWIN-TIG^{er} L TIG^{er} rig: Longitudinal internal weld overlay

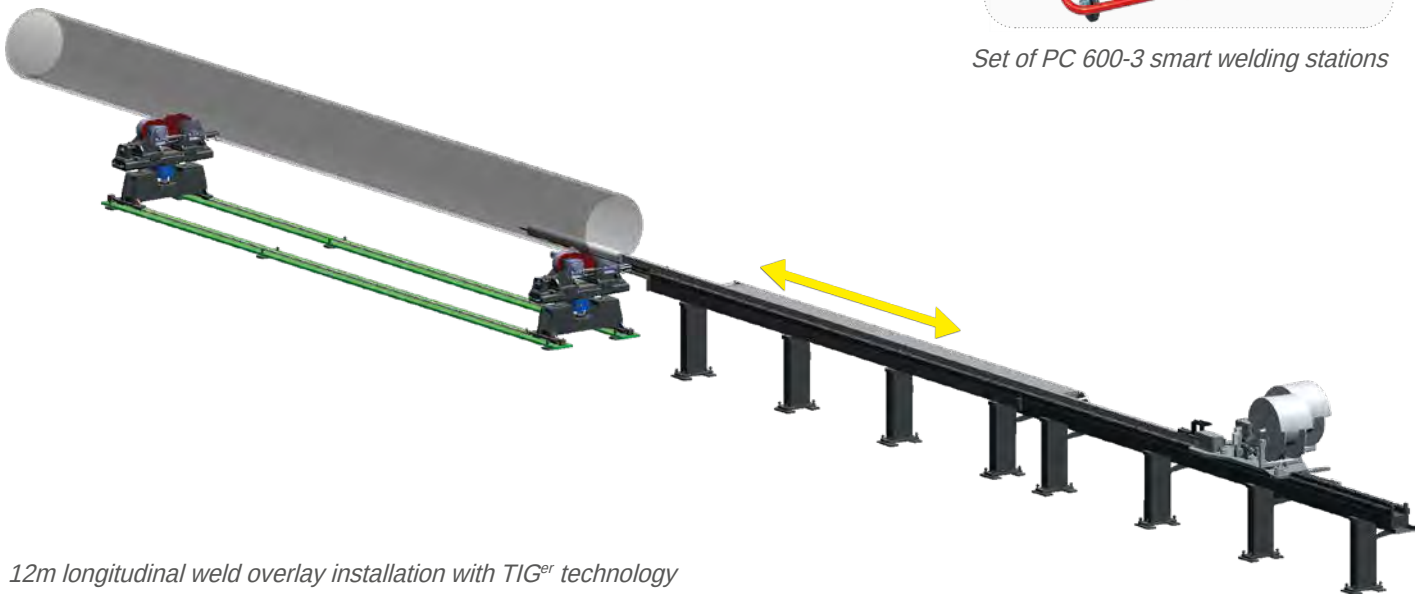


▶ Advantages

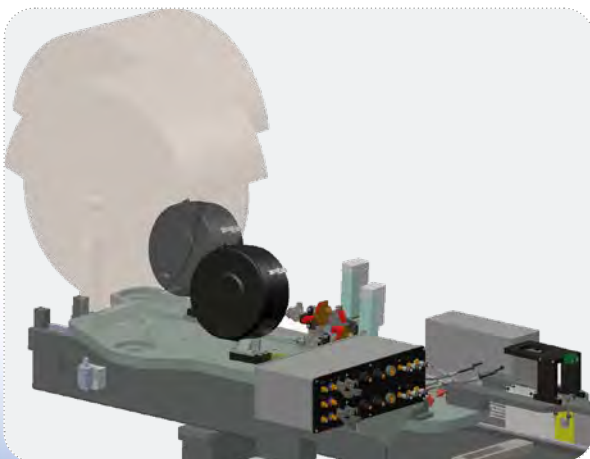
- A unique solution for the longitudinal seam weld overlay of metallurgically bonded pipes from the inside (after welding from outside and remachined root ⁽¹⁾)
- Perfectly smooth quality of the cladded surface
- Integrated compensation management of the welded joint twist
- Reduced deformation
- Full-length weld overlay
- TIG^{er} high deposition rate & high productivity
- Very low dilution rate
- Process: 



Set of PC 600-3 smart welding stations

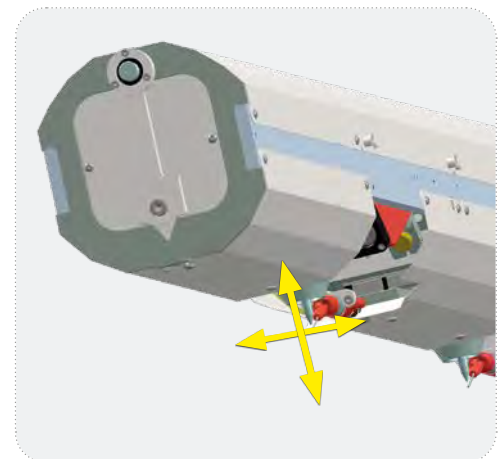


12m longitudinal weld overlay installation with TIG^{er} technology



Travel carriage, wire feeding assembly and connection plate

(1) Not part of Polysoude supply



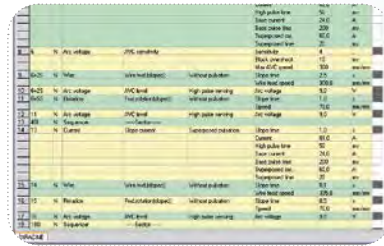
AVC/OSC slides for each torch

► Systems Control Centre

Delivered with the installation

► Equipment includes

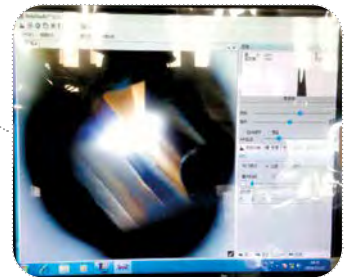
- Installation main frame
- 12m TWIN-TIG^{er} lance
- Travel carriage
- Pipe orientation roller assembly
- Set of two PC 600-3 smart welding stations
- Systems Control Centre - SCC



Weld overlay programming software (weld overlay parameters)



CNC operator programming interface



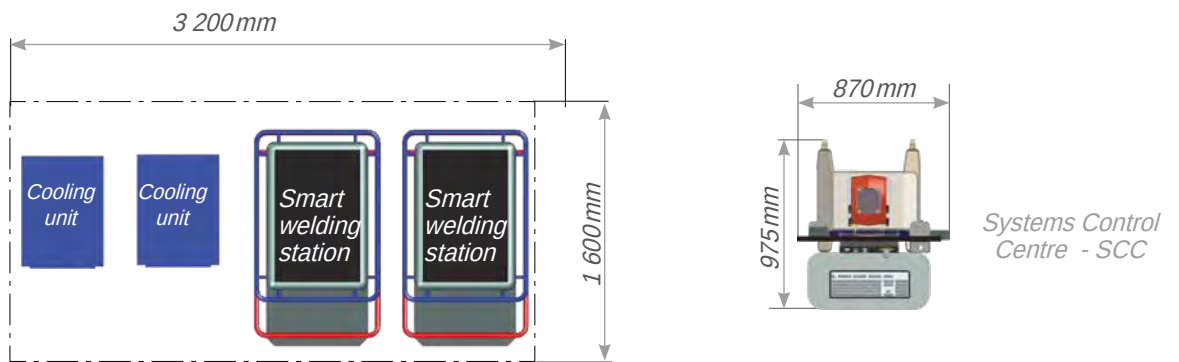
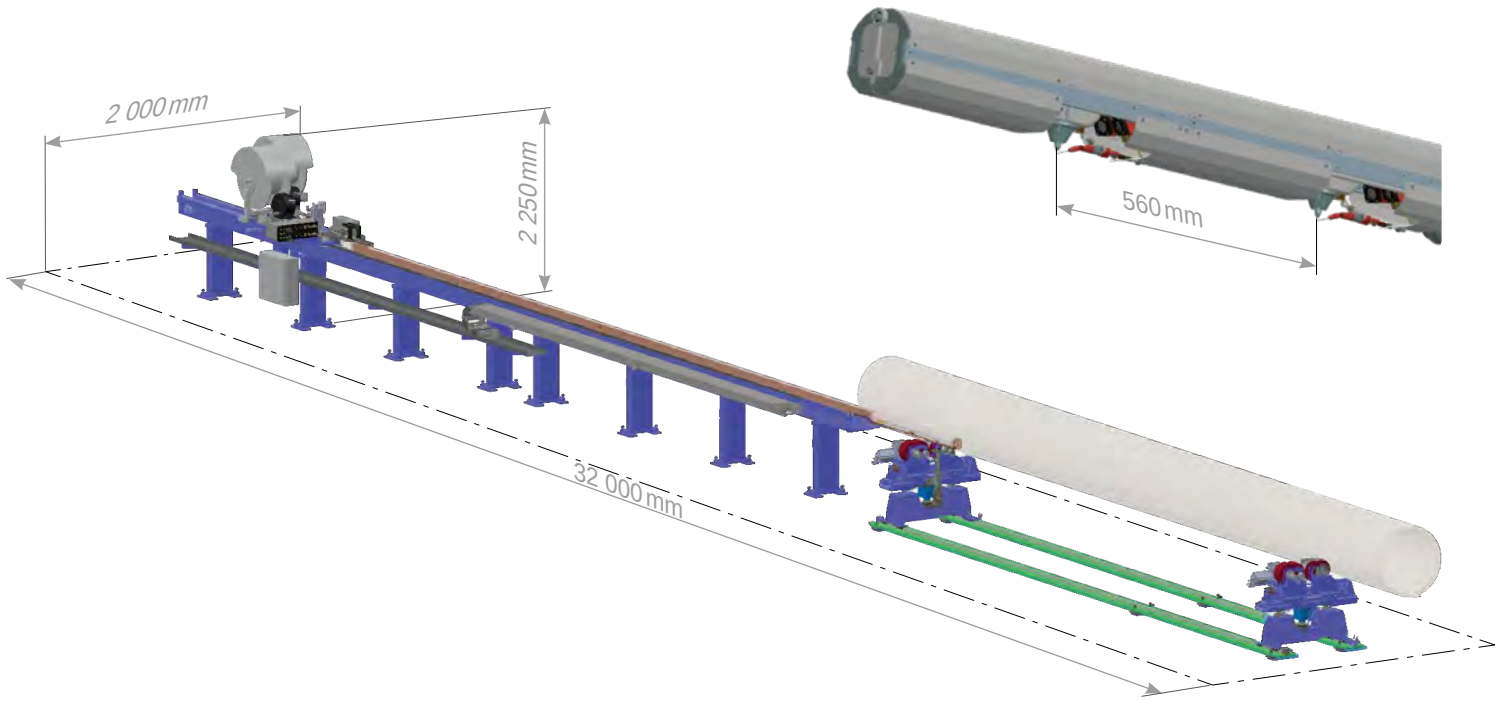
Video system: Wide dynamic video for real time monitoring

► Technical data

Tube	
O.D. max.	580 mm (24")
I.D. min.*	180 mm (6 1/2")
Length	12 m
Width of the seam to be clad	10 to 25 mm
Distance between torches 1 & 2	560 mm
AVC stroke (independant for each torch)	15 mm
OSC stroke (independant for each torch)	40 mm (± 20mm)
Wire feeder	0.4 to 14 m/min
Compatible with wire spool	Ø 760 mm - 250 kg or Ø 300 mm - 15 kg
Video	1 camera per torch

* Before weld overlay considering 2 layers

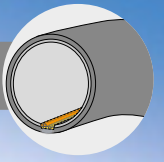
► Layout and utilities



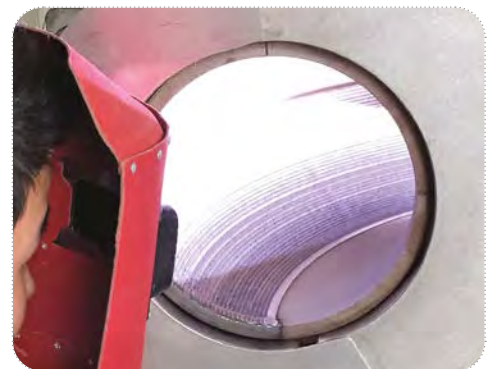
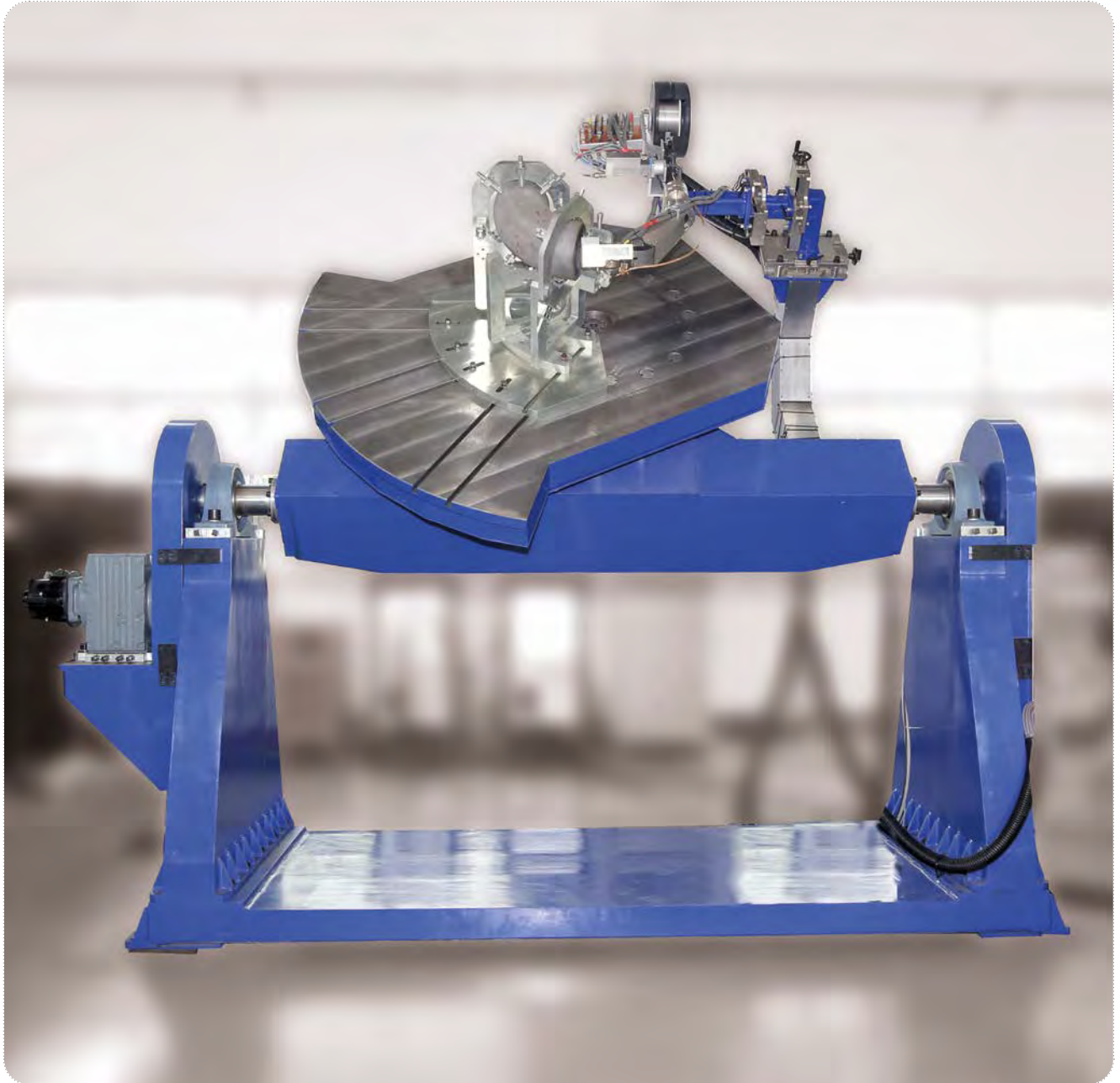
Utilities	
Smart welding stations - TIG ^{er}	400V - three-phase - 2x33kVA
Pipe support and lance carriage	400V - three-phase - 16kVA
Control panel	230V - single phase - 6kVA
Cooling unit	230V - single phase - 7kVA

► Product item numbers


	12 m
PolyClad TWIN-TIG ^{er} L-2 - Longitudinal TIG ^{er} weld overlay installation (including TIG ^{er} -2 weld overlay lance, pipe orientation roller assembly, sets of smart welding stations, cooling unit, SCC)	0033950001



PolyClad Elbow L TIG^{er} 8" to 30" (1.5D)

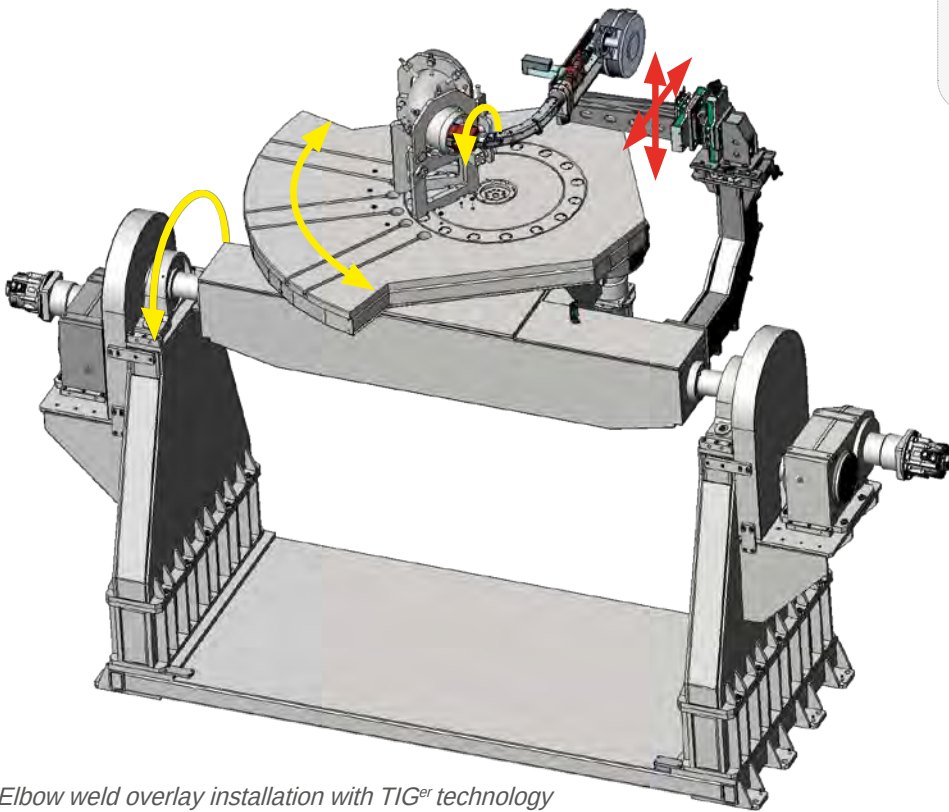


▶ Advantages

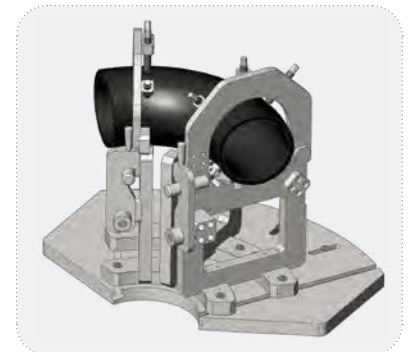
- Quick installation of the elbow elbow
- Consistent smooth surface after weld overlay in longitudinal direction
- Reduced deformation
- No start-stop points inside the elbow
- TIG^{er} high deposition rate/high productivity
- Automated cladding sequence
- Process: 



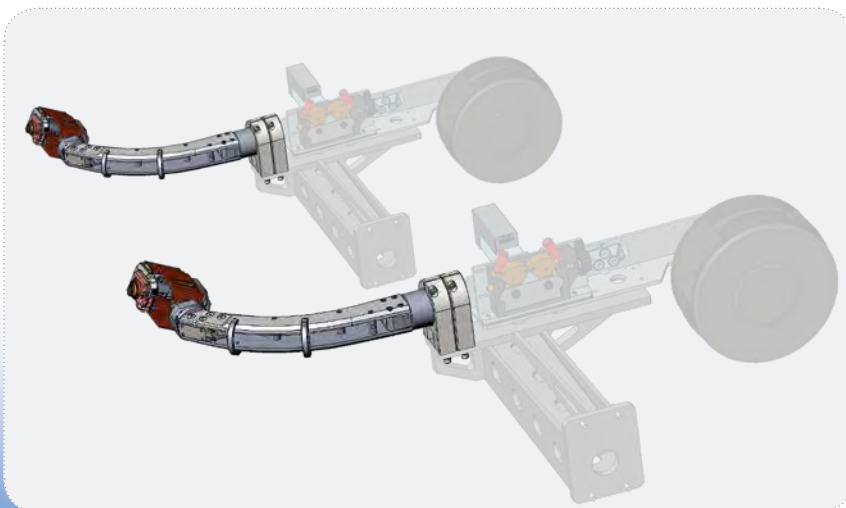
Set of PC 600-3 smart welding stations
- 1 master and 1 slave



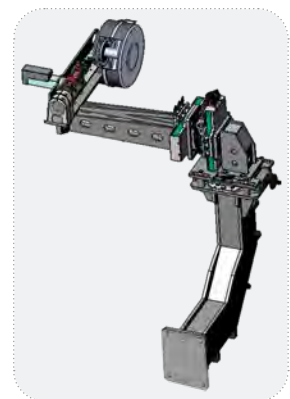
Elbow weld overlay installation with TIG^{er} technology



Clamping unit



Weld overlay lances with wire feeder



Weld overlay head interface

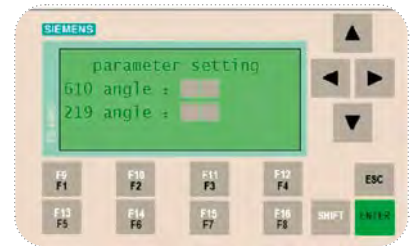
▶ Control cabinet

▶ Main items

- Tilting positioner for longitudinal weld overlay - 8" to 30"
- Welding head interface with cross slides & wire feeder
- Set of PC 600-3 smart welding stations (1 master & 1 slave)
- CN control cabinet



Weld overlay programming software (weld overlay parameters)



Operator touchscreen

▶ Variants / options - accessories

- TIG^{er} weld overlay lance with torch rotation and fixtures according to the elbow size
- Elbow clamping unit
- DAQbox - tool for productivity management and data acquisition

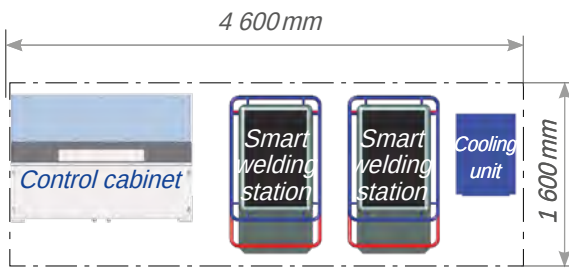


▶ Technical data

Elbow	
O.D. max.	762 mm (30")
I.D. min.*	189 mm (7 7/16")
Elbow radius	1.5 D
AVC stroke	25 mm
Wire feeder	0.5 to 14 m/min
Compatible with wire spool	Ø 300 - 15 kg

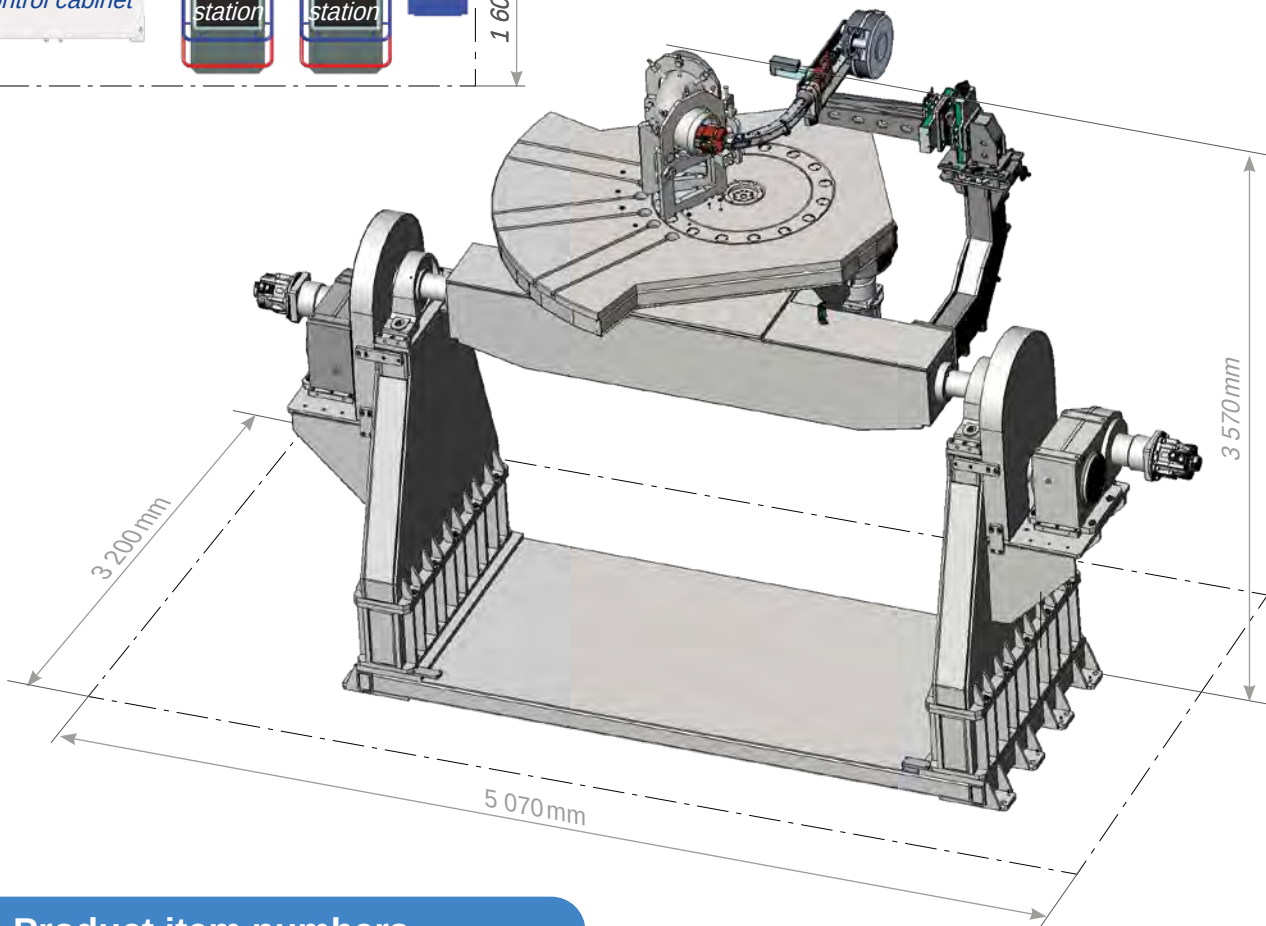
* Before weld overlay considering 2 layers

► Layout and utilities



Utilities

Smart welding stations - TIG ^{er}	400 V - three-phase - 1x33 kVA + 1x28 kVA
Control cabinet	230 V - single phase - 15 kVA
Cooling unit	230 V - single phase - 4 kVA



► Product item numbers

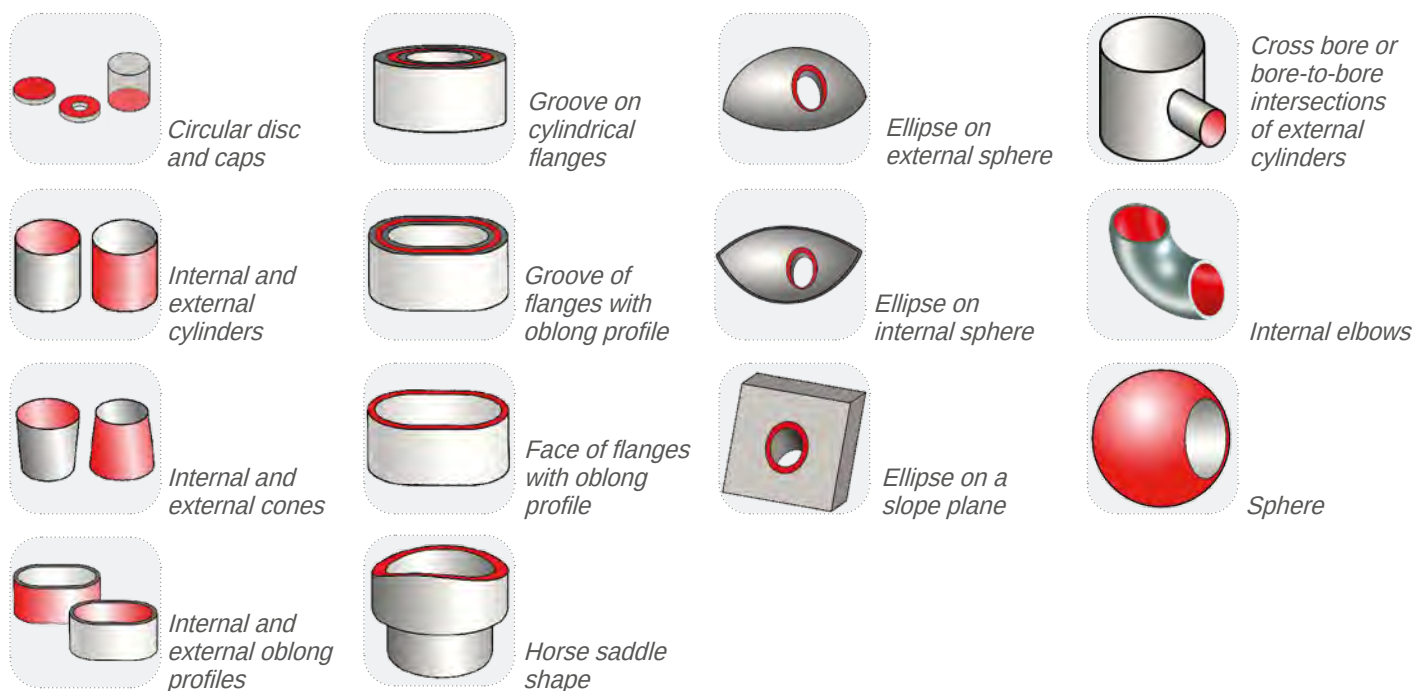
	8" ≤ I.D. ≤ 30"
PolyClad Elbow L - Standard elbow weld overlay installation (including positioner, cladding lance interface, set of smart welding stations, cooling unit, control cabinet)	0033960001
DAQbox - Data acquisition system	0033249101
TIG ^{er} lance for elbow 90° diameter 8"	0033960101
Fixture for elbow 90° diameter 8"	0033960201
TIG ^{er} lance for elbow 90° diameter 16"	0033960301
Fixture for elbow 90° diameter 16"	0033960401
TIG ^{er} lance for elbow 90° diameter 20"	0033960501
Fixture for elbow 90° diameter 20"	0033960601
TIG ^{er} lance for elbow 90° diameter 24"	0033960701
Fixture for elbow 90° diameter 24"	0033960801
TIG ^{er} lance for elbow 90° diameter 30"	0033960901
Fixture for elbow 90° diameter 30"	0033961001



Workpiece geometries

Weld overlay machines with conventional or CN Controller?

The choice of equipment and software depends on the shape complexity of the workpieces. Therefore, each surface to be cladded must be identified as cylinder, flat base, cap, truncated cones or an intersection of cylinders.



POW_{in} Conventional controller

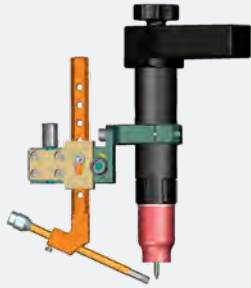
- Dedicated to less complex surfaces such as cylinders, bases and caps (circular trajectories of the torch)
- Sequential programme
- Each programming step controls the movement along one of the axes (X, Y or Z, no interpolation)
- Programming, archiving and transfer of on-line and off-line programmes

CNC axes CN Controller

- Dedicated to circular and non-circular or interrupted surfaces such as sealing surfaces, intersection of cylinders and spheres (complex trajectories of the torch)
- Programmed to manage the movement of the torch along several axes, with interpolation
- A simulator allows the previewing of predefined trajectories and the evaluation of associated cycle times and deposition rates
- Unique user-friendly GUI (graphical user interface)
- Programming, archiving and transfer of on-line and off-line programs
- Data monitoring system with alarm functions

Torches and lances

Examples



Standard HW welding torch



Extended HW welding torch



HW lance, fixed angle



HW lance, adjustable angle



TIG^{er}-2 lance



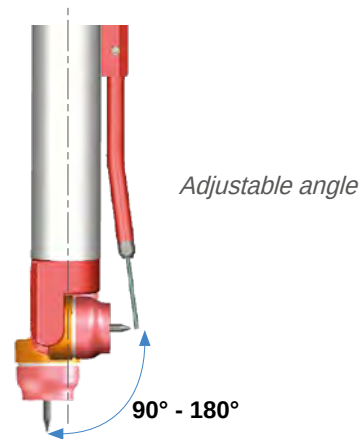
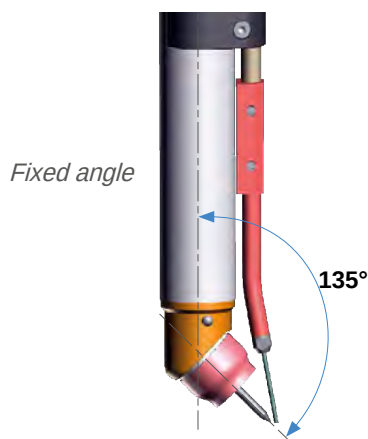
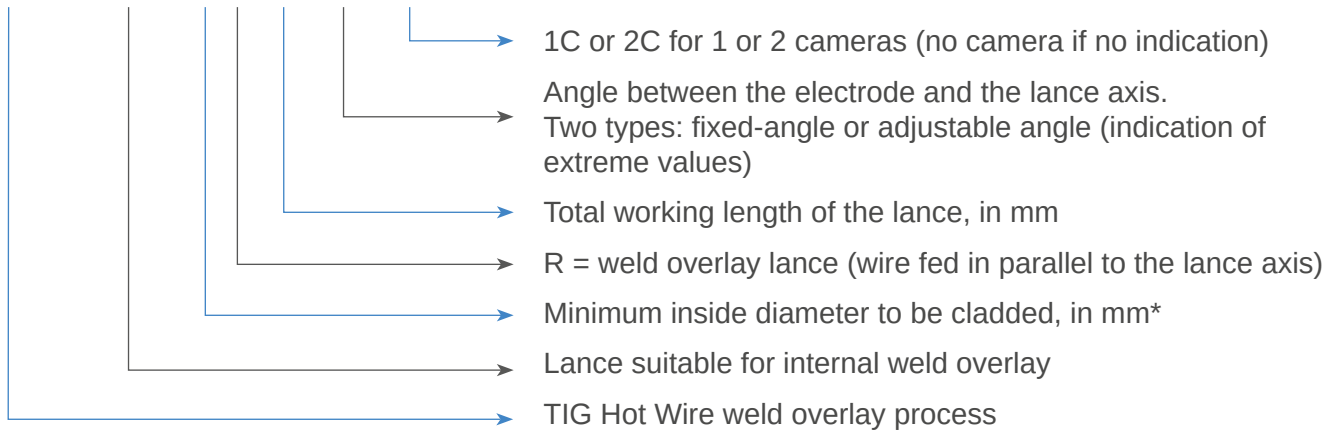
Tiltable TIG^{er}-2 lance

Torches and lances

▶ Lance designations

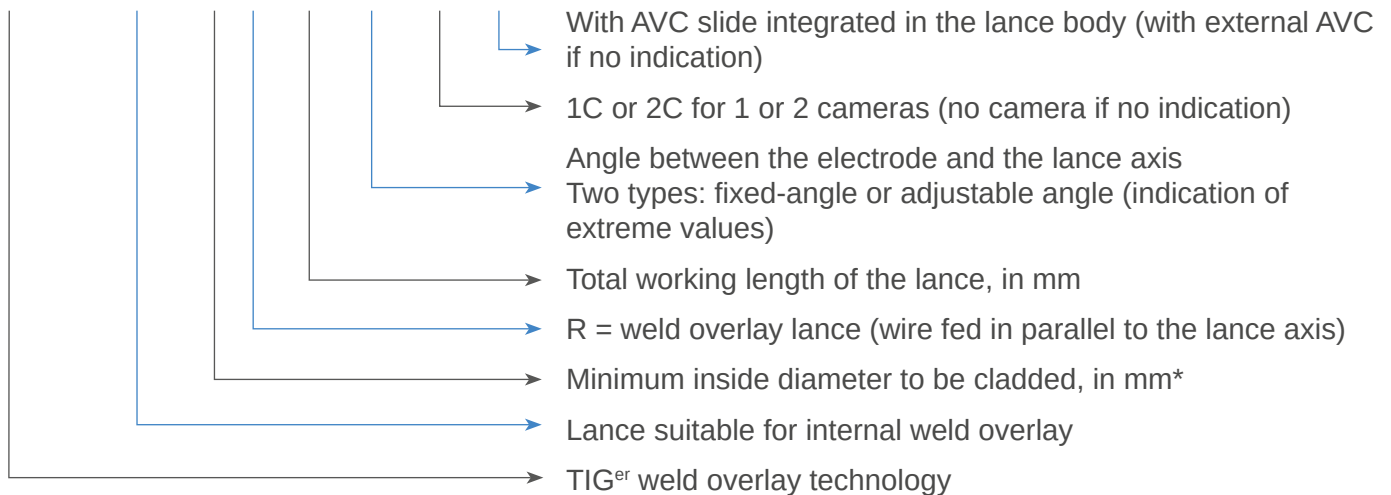
- TIG HW Lance designations

TIG HW lance ID 35-R-700-135°-XC

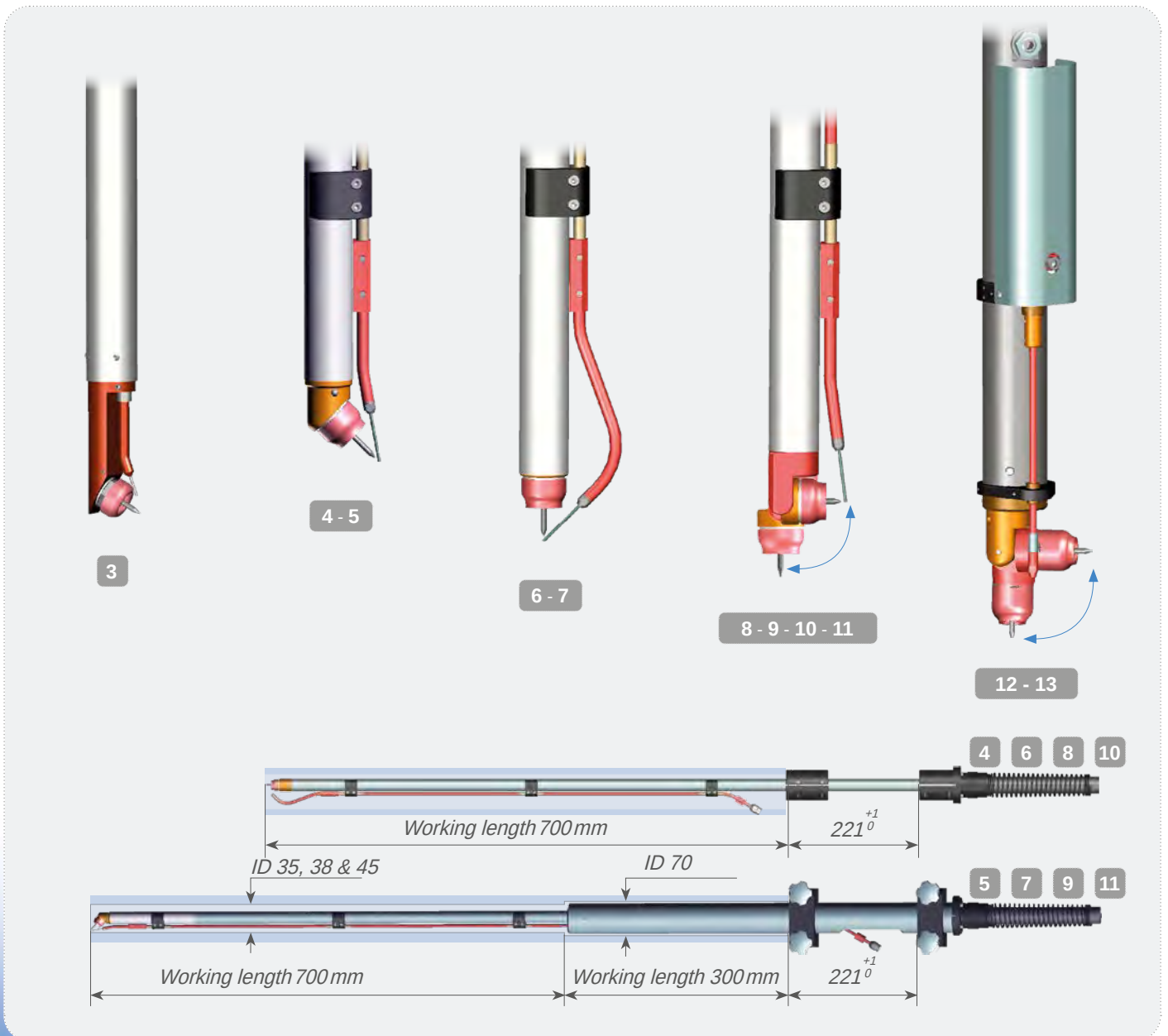
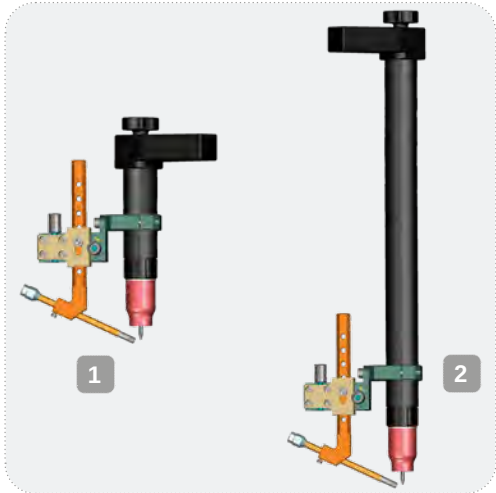


- TIG^{er} lance designations

TIG^{er} Lance ID 100-R-1000-135°-XC-AVC



* Before weld overlay considering 2 layers

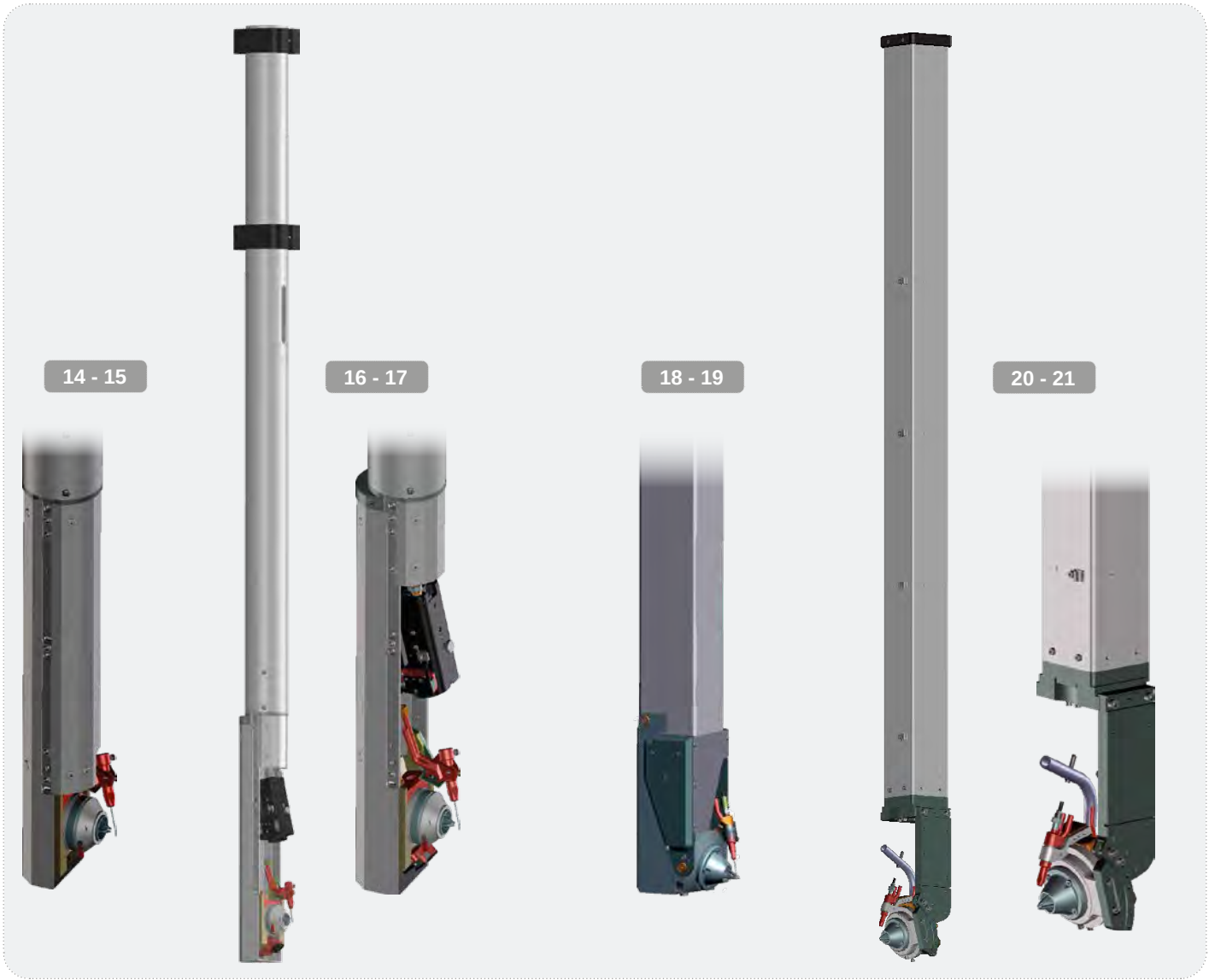


► Torches and lances




N°	TIG Torches		Duty cycle		Compatibility PolyClad			
			Average current - 100%	Max peak current - 60%	Easy	3C	C&B	SPX
1	WP 27 A	0033263310	500A	500A	✓	✓	✓	✓
2	WP 27 B	0033263410	500A	500A	✓	✓	✓	✓

N°	TIG HW Lances		Duty cycle		Compatibility PolyClad			
			Average current - 100%	Max peak current - 60%	Easy	3C	C&B	SPX
3	ID 34-R-1000-120°	0030740013	300A	350A	✓	✓	✓	✓
4	ID 35-R-700-135°	0030740007	170A	200A	✓	✓	✓	✓
5	ID 35-R-1000-135°	0030740006	170A	200A	✓	✓	✓	✓
6	ID 35-R-700-180°	0030740009	170A	200A	✓	✓	✓	✓
7	ID 35-R-1000-180°	0030740008	170A	200A	✓	✓	✓	✓
8	ID 38-R-700-90/180°	0030740005	170A	200A	✓	✓	✓	✓
9	ID 38-R-1000-90/180°	0030740004	170A	200A	✓	✓	✓	✓
10	ID 45-R-700-90/180°	0030740003	200A	250A	✓	✓	✓	✓
11	ID 45-R-1000-90/180°	0030740001	200A	250A	✓	✓	✓	✓
12	ID 100-R-1000-90/180°	0030740020	300A	350A	✓	✓	✓	✓
13	ID 100-R-1500-90/180°	0030740021	300A	350A	-	-	-	✓

Video option on request for all torches and TIG HW lances




► Torches and lances

N°	TIG ^{er} -2 lances		Duty cycle		Compatibility PolyClad			
			Average current - 100%	Max peak current - 60%	Easy	3C	C&B	SPX POW _{in}
14	ID 100-R-1000-90°	0039230001	420A	500A	✓	✓	✓	✓
15	ID 100-R-1500-90	0039230003	420A	500A	✓	✓	✓	✓
16	ID 120-R-1000-90°-1C/HD	0039230002	420A	500A	✓	✓	✓	✓
17	ID 120-R-1500-90°-1C/HD	0039230004	420A	500A	✓	✓	✓	✓
18	ID 150-R-1000-105°	0034540011	420A	500A	✓	✓	✓	✓
19	ID 150-R-1500-105°	0034540012	420A	500A	✓	✓	✓	✓
20	ID 150-R-1000-90/180°	0039010005	420A	500A	✓	✓	✓	✓
21	ID 150-R-1500-90/180°	0039010006	420A	500A	✓	✓	✓	✓
	Accessory box for TIG ^{er} -2 lance ID 100	0039230999	-	-	-	-	-	-
	Accessory box for TIG ^{er} -2 lance ID 120-1C/HD	0039230998	-	-	-	-	-	-
	Accessory box for ID 150 TIG ^{er} -2 lance ID 150-90/180°	0039010999	-	-	-	-	-	-

P1: Areas 1 & 4
P2: All areas
P3: Areas 3 & 6



N°	TIG ^{er} Lances		Duty cycle		Compatibility PolyClad
			Average current - 100%	Max peak current - 60%	SPX CNC
22	ID 100-R-1000-105°	0032281001	2x250A	2x350A	✓
23	ID 100-R-1500-105°	0032281501	2x250A	2x350A	✓
24	ID 150-R-1000-105°	0034540009	2x250A	2x350A	✓
25	ID 150-R-1500-105°	0034540010	2x250A	2x350A	✓
26	ID 150-R-1000-90/180°	0039010007	2x300A	2x300A	✓
27	ID 150-R-1500-90/180°	0039010008	2x300A	2x300A	✓
	Accessory box for TIG ^{er} -1 lance	0033842901	-	-	-

Video monitoring

▶ Advantages

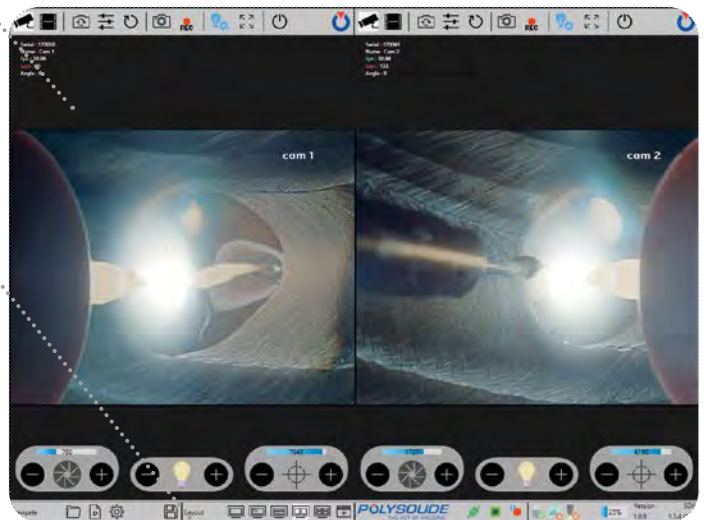
- The operator can easily monitor and follow the process remotely
- Resistant to high temperature
- Proven reliability
- Repositioning and/or inspection
- Outstanding image quality
- Perfect picture with and without arc
- Viewing/recording in real time



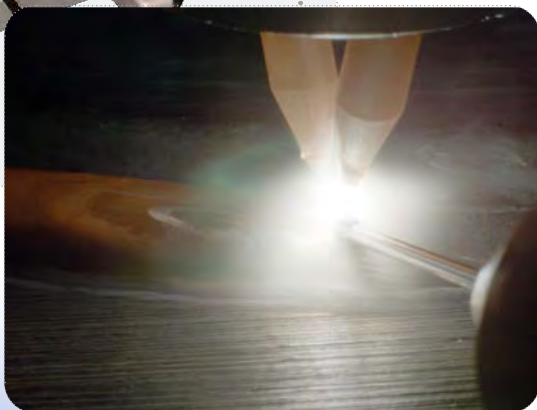
Systems control centre - SCC



Video container with 1 to 3 displays



All video controls on the same screen



Real time monitoring

► Complementary information

To monitor the weld overlay process, the operator can be assisted by a video system.

This supplementary feature consists of cameras mounted near the torches (or integrated in more complex cases), umbilicals and a rack or container with the instrumentation and control functions (lighting and filter control, focal distance adjustment and viewing monitors).

A single camera per torch viewing the melting of the wire is usually sufficient for weld overlay or buttering.

Depending on the level of integration, the camera may be external with their own cooling circuit or replaced by a micro-camera installed in the body of the torch adapted to the application.

For cameras, it is usual to be faced with severe heat conditions combined with space constraints. That is why the equipment is water-cooled.



TIG WP 27 torch with external camera and light



TIG lance with integrated camera and light



TIG^{er} lance with integrated camera

Administrative, packing and logistics costs

▶ Order processing & administrative fees

Order processing & administrative fees for France, E.U. countries, Switzerland, Norway	100088347
Order processing & administrative fees for Algeria, Azerbaijan , Libya, Russia, Ukraine, Belorussia	100088348
Order processing & administrative fees for Japan, Canada, US, China	100088349
Order processing & administrative fees for Korea, Taiwan, Singapore, Malaysia, Vietnam, Morocco, Tunisia, Turkey	100088350
Order processing & administrative fees for South America (except Brazil), Argentina, Chile, Mexico, Venezuela	100088351
Order processing & administrative fees for South America, Pakistan, Indonesia, the Philippines, Africa (except South Africa, Morocco, Tunisia)	100088352
Order processing & administrative fees for The Middle East (Saudi Arabia, Egypt, UAE, Qatar, Oman, Kuwait, Jordania, Israel, Iran, etc.)	100088353
Order processing & administrative fees for India	100088354
Order processing & administrative fees for Other countries	Contact us

▶ Additional costs

Additional costs for letter of credit treatment	100062317
Certificates on documents	100062318
Certificates of conformity - VERITAS type	100083958

▶ Specific loading costs for trucks, containers & oversized cargo

Loading cost for partial loading - over 5 standard equipment	100062319
Loading cost for full truck	100062327
Loading cost for full container 20ft Dry or Open Top	100062329
Loading cost for full container 40ft Dry or Open Top	100062332
Additional charges for loading oversized cargo or Open Top container with heavy or bridge crane	100062334
Additional charges for wedging/lashing any package over 3 tons on truck or container	100062337

▶ Packing costs

Packing cost for PC Smart Welding Station (except AC/DC and MIG MAG)	100063024
Packing cost for RFC 30 type cooling unit	100063028

Sales conditions

Our prices are quoted

- In euros (€)
- Per unit
- Ex-works Nantes (EXW Nantes INCOTERMS ICC 2010)
- Administrative, packing and logistics costs not included
- Excluding French VAT

Warranty

Twelve months from delivery date, against all construction defects (for second hand equipment, six months from delivery date). The warranty is limited to the exchange of parts acknowledged as defective.

Extract from Polysoude general sales conditions:

- Application of warranty terms

Vendor guarantees that all goods sold will be free from malfunctioning resulting from defects in material, workmanship or design for a period of twelve (12) months from delivery and where the product is used for the intended purpose. Warranty is void where malfunctioning results from unauthorised servicing to the product by the purchaser, normal wear and tear, carelessness or lack of maintenance, caused by a third party or force majeure occurrence.

- Performance of warranty

Under the warranty, the vendor shall replace free of charge any components acknowledged as defective by its technical department. The warranty shall not include labour and costs resulting from the following operations: disassembly, reassembly, shipping to site, etc. Replacement of components shall not be construed as an extension of warranty period.

Repairs, commissioning and training

These services will be invoiced as per lump-sum prices stipulated in the valid price list.

Technical documentation

At the date of delivery, one free copy on USB stick is supplied to you. Additional copies will be supplied at additional costs.

Minimum amount of invoice

For each order (for example spare parts) with a net total amount inferior to 150 € (exclusive of packing and transportation costs), we will invoice an additional fee of 30 € to cover the administrative costs for such small orders.

Payment terms

Within the limits of agreed total running:

30% payable with the order placement - due immediately

65% once notified that the machine is ready for shipment; due 30 days from the date of notification - payable before shipment

5% on commissioning or at the latest 2 months after being notified that the machine is ready for shipment (whichever occurs first)

Reserve of ownership

Polysoude retains the title of the goods until paid for in full. This clause also applies if payment is subject to security or bank warranty.

Any modification of sales terms and conditions must in all cases be confirmed by Polysoude.

Notes

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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