

MAGNATECH

ORBITAL WELDING SYSTEMS

REDHEAD WELD HEADS

Models 427A, 428A, 429A

Orbital Weld Heads for Fusion
and Wire Feed GTAW Pipe Welding



Use with

- *Tubemaster Model 514 Power Source*
- *Pipemaster Model 515 Power Source*
- *Pipemaster Model 516 Power Source*

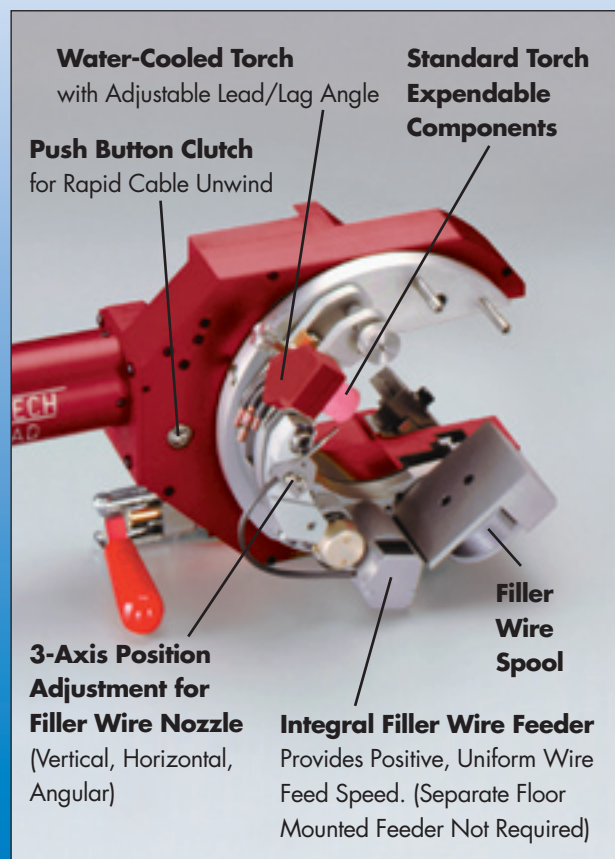
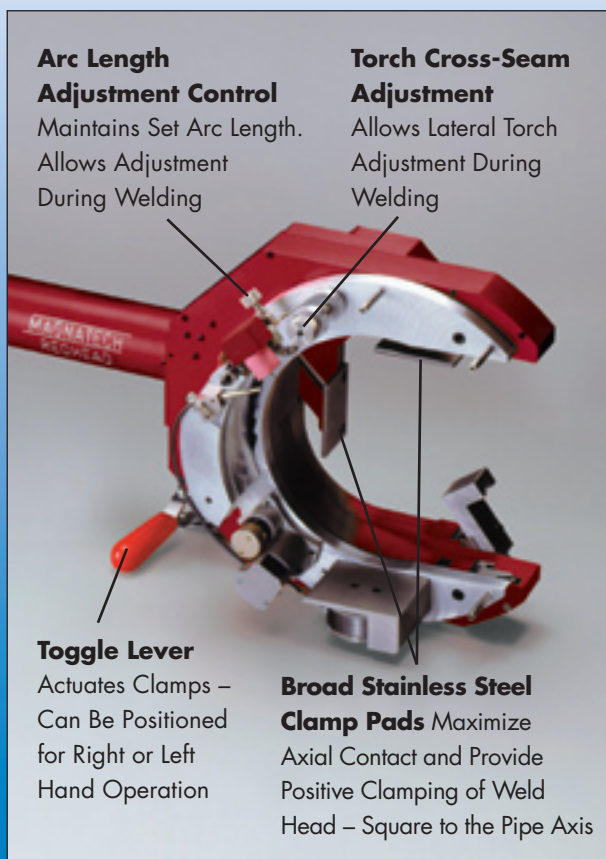
REDHEAD Weld Heads

Orbital Weld Heads for Fusion and Wire Feed Welding of Pipe

Precision Tools for Perfect, Repeatable Welds

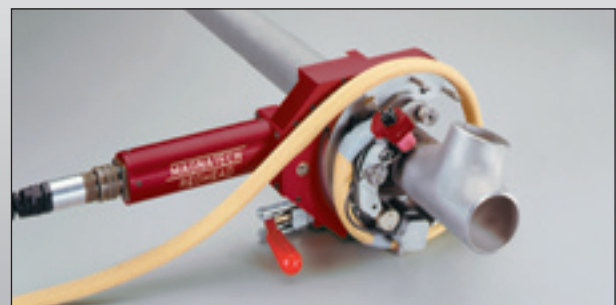
Magnatech Redheads are designed to make pipe-to-pipe and pipe-to-fitting welds with precision and repeatability. Redheads can be used for fusion welding, or with filler wire addition – an integral Head-mounted feeder is standard on all models. Three models cover the size range of 12.7 to 168mm (0.5 to 6.625") OD. Digital technology forever eliminates the need for periodic calibration – rotation and wire speed remain accurate regardless of wear, and Heads can be interchanged without time-consuming recalibration. These weld Heads improve productivity by increasing duty cycle, reducing repair rates and producing welds of consistent quality.

Features



Mounting

The Weld Head mounts entirely on one side of the joint, allowing use on pipe-to-pipe and pipe-to-fitting welds.



Clamping

Micrometer Fine Adjustment on Clamp

Provides rapid Adjustment for Pipe O.D. Variation

Engraved Scale

Clamp Adjustment for Pipe O.D. (metric or inch)



Torch Rotation

Uniform torch rotation is ensured by a chain and sprocket drive using a precision stainless steel bearing assembly that is immune to heat.

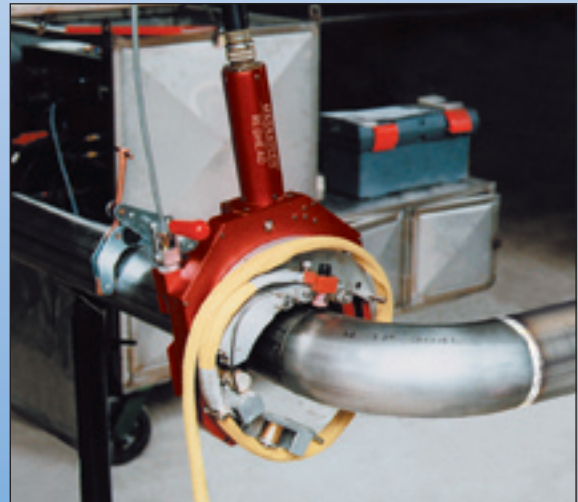


Options

- Extension Cables
- Fillet/Socket Weld Kit
- Extended Clamping Range Kit R-2 allows welding down to 21mm (0.84 inch) OD
- Extended Clamping Range Kit R-3 allows welding down to 50mm (2 inch) OD

Applications

- Pharmaceutical
- Sanitary (Hygienic) Process Piping
- Food Processing/Dairy
- Brewery Tubing
- Power Generation
- Chemical

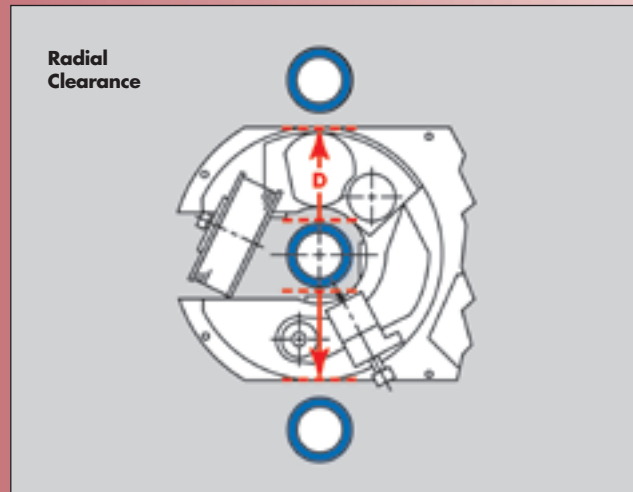
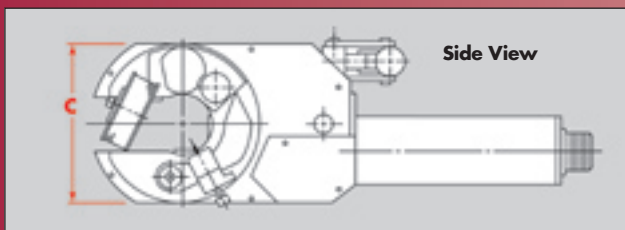
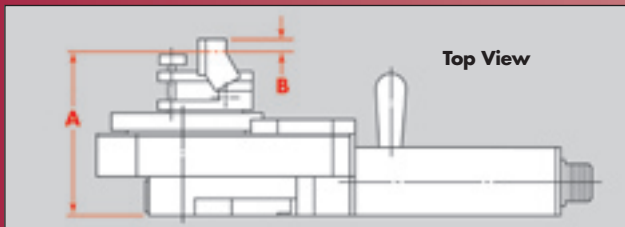


Specifications

	R-1 (Model 427A)	R-2 (Model 428A)	R-3 (Model 429A)
Application	Orbital GTAW welding of pipe-to-pipe, pipe-to-fittings. Fusion/Wire Feed capable.		
Pipe (Tube) OD Size Range	13 – 38mm (0.5 – 1.5")	33 – 90mm (1.315 – 3.5")	90 – 168mm (3.5 – 6.625")
Filler Wire Module	Wire Size: 0.8mm (0.03") Max. Speed Capability: 190cm/minute (75 IPM) Spool Size: 0.16 kg (0.35 lbs)		
Arc Gap Control Module	Mechanical, Adjustable		
Torch Propulsion Module	0 – 4.0 rpm	0 – 1.5 rpm	0 – 0.6 rpm
Water-Cooled Torch	200 A Continuous		
Torch Adjustment Capability	Torch Lead/Lag Adjustment: ±15 Degrees (manual) Torch Tilt Adjustment: Requires optional socket weld kit		
Cable Length	8m (25') Standard. Extension cables available.		
Power Supply Compatibility	Tubemaster Model 514, Pipemaster 515, Pipemaster 516		

Dimensions/Weights

	R-1 (Model 427A)	R-2 (Model 428A)	R-3 (Model 429A)
Weight	3.9 kg (8.5 lbs.)	5.4 kg (12 lbs.)	9.0 kg (20 lbs.)
Axial Clearance (Torch C/L to Rear Extremity) (A)	127mm (5.0")	127mm (5.0")	127mm (5.0")
Axial Clearance (Torch C/L to Front Extremity) (B)	10mm (0.41")	10mm (0.41")	10mm (0.41")
Width (C)	140mm (5.5")	191mm (7.5")	280mm (11.0")
Radial Clearance Requirement (D)	[140mm (5.5") – Pipe O.D.] ÷ 2 = Radial Clearance	[191mm (7.5") – Pipe O.D.] ÷ 2 = Radial Clearance	[280mm (11") – Pipe O.D.] ÷ 2 = Radial Clearance



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