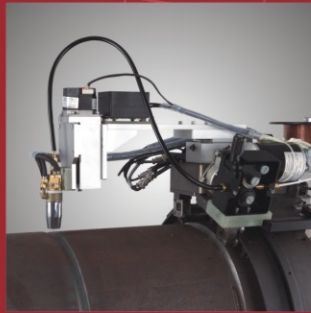
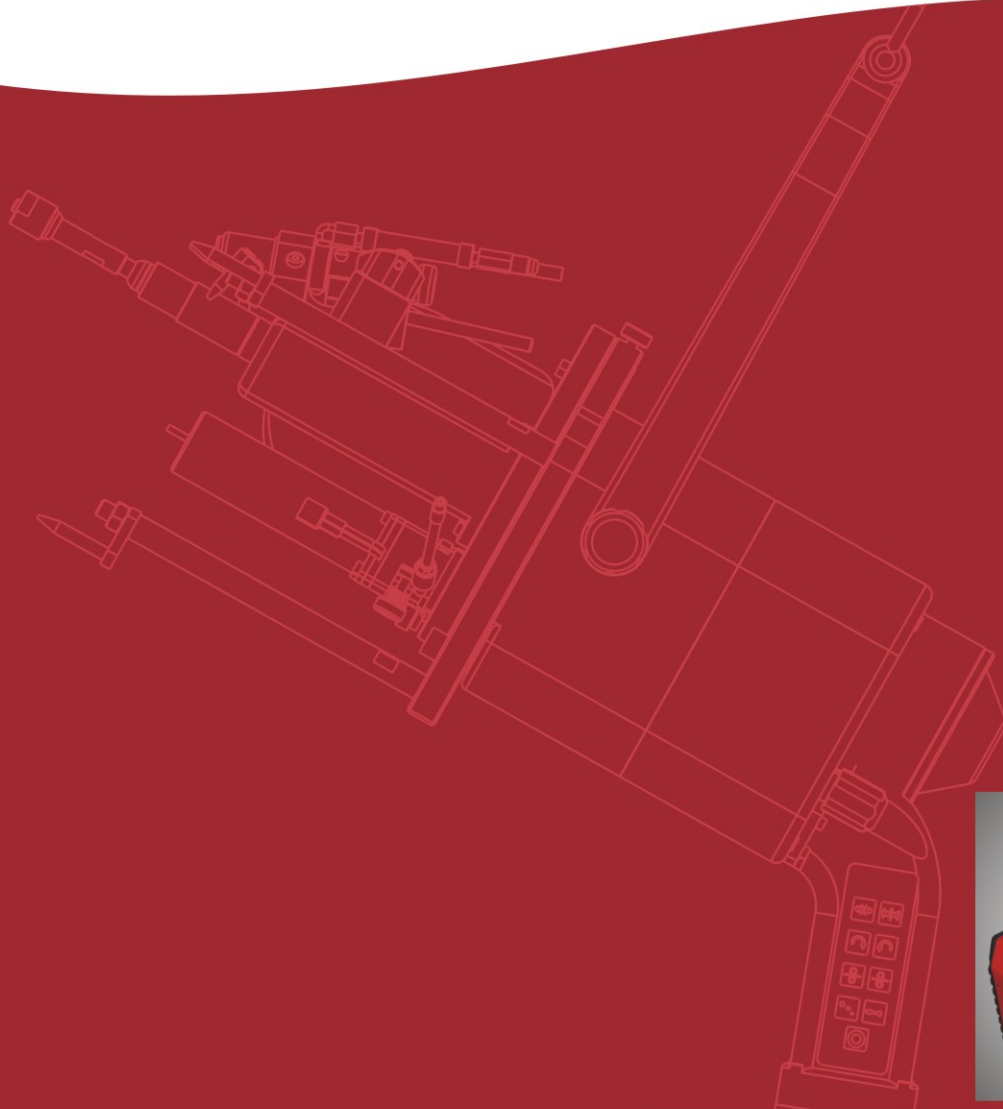


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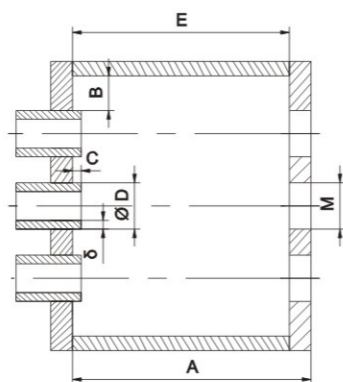
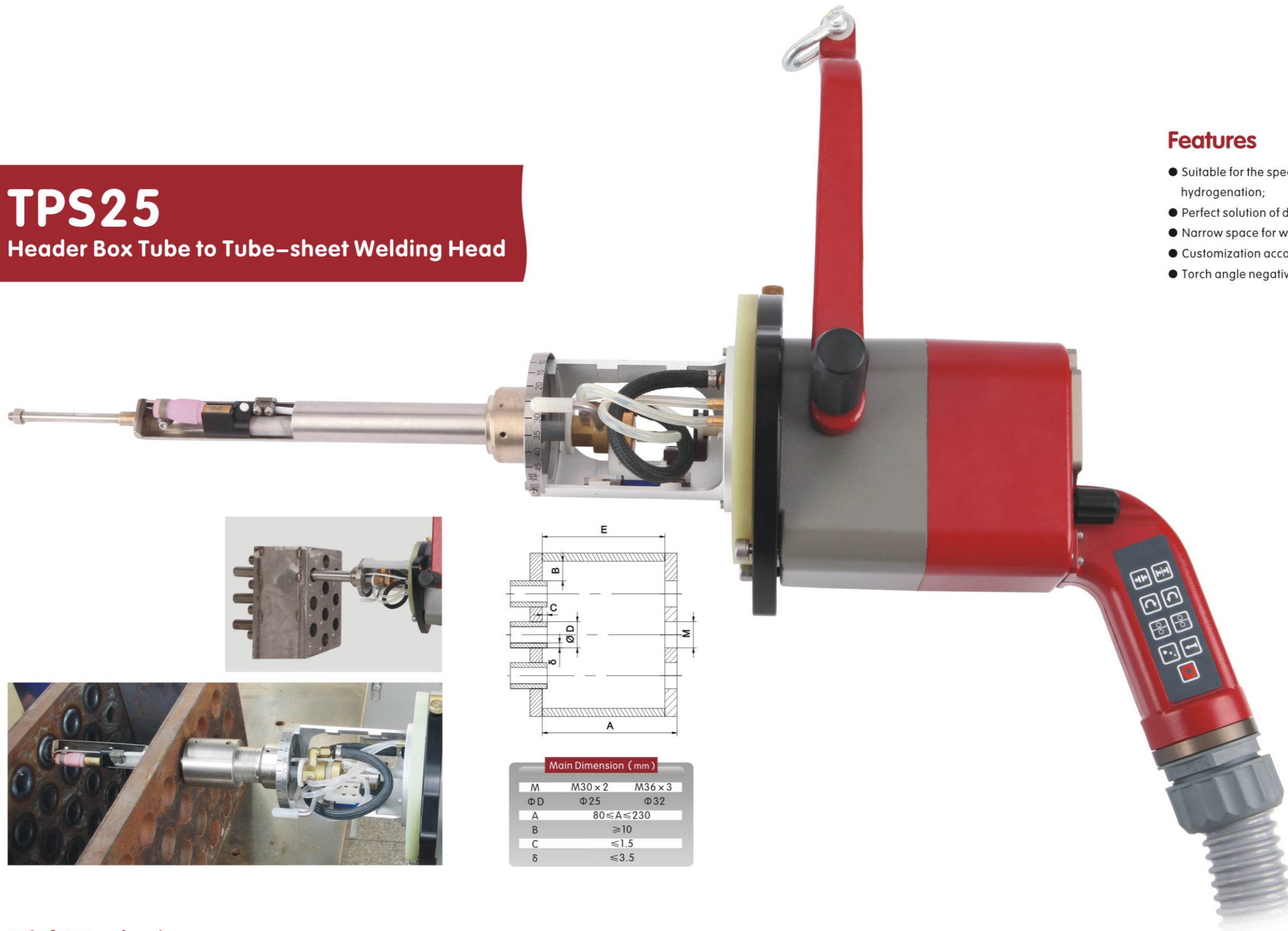


ORBITAL Welding System

HUAHENG WELDING CO., LTD.

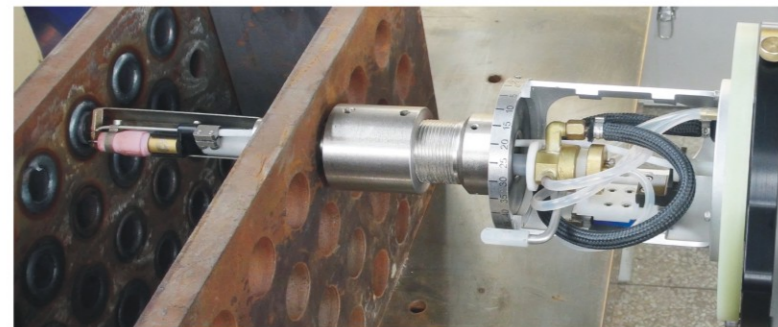
TPS25

Header Box Tube to Tube-sheet Welding Head



Main Dimension (mm)

M	M30 x 2	M36 x 3
ΦD	$\Phi 25$	$\Phi 32$
A	$80 \leq A \leq 230$	
B	≥ 10	
C	≤ 1.5	
δ	≤ 3.5	



Features

- Suitable for the special heat exchanger in chemical industry, e.g. air cooler with hydrogenation;
- Perfect solution of deep hole welding with wire feeding;
- Narrow space for welding with screw thread hole to reach depth of 120~220mm;
- Customization according to specific requirements;
- Torch angle negative degree application.

Technical Specification

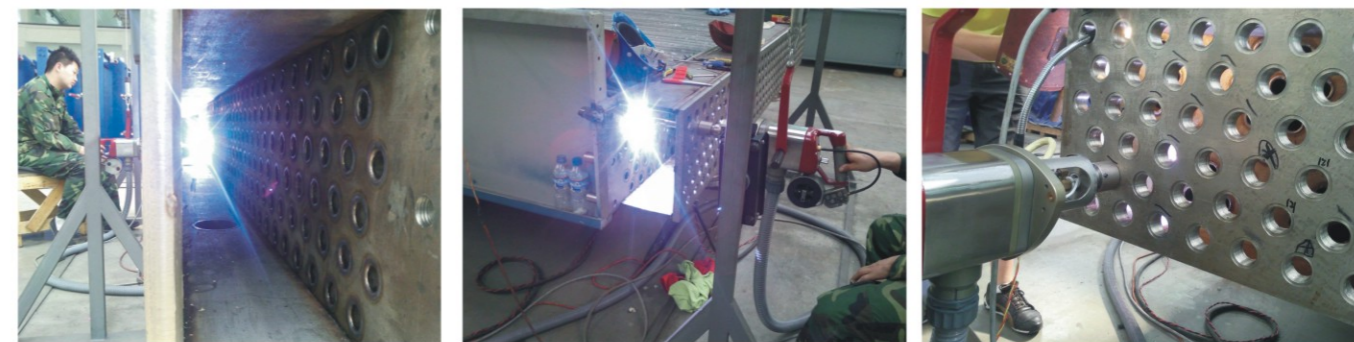
Material	Carbon steel, stainless steel
Tube OD (mm)	$\Phi 25$ or $\Phi 32$ (standard $\Phi 25$)
Max Depth for Inner Tube (mm)	230 (including plate thickness)
Connection	Flush tube
Tungsten diameter (mm)	$\Phi 2.4$
Rotation speed (rpm)	0.37 ~ 7.39
Torch Angle	-3°
Arc adjusting distance (mm)	18
Max wire feeding speed (mm/min)	1800
Tungsten diameter (mm)	$\Phi 0.8$
Protective gas	Ar
Cooling	Water
Cooling flow (ml/min)	≥ 600
Duty cycle	200A 60%
Weight (kg)	13 (no cable)
Dimension (mm)	780 x 290 x 310

Brief Introduction

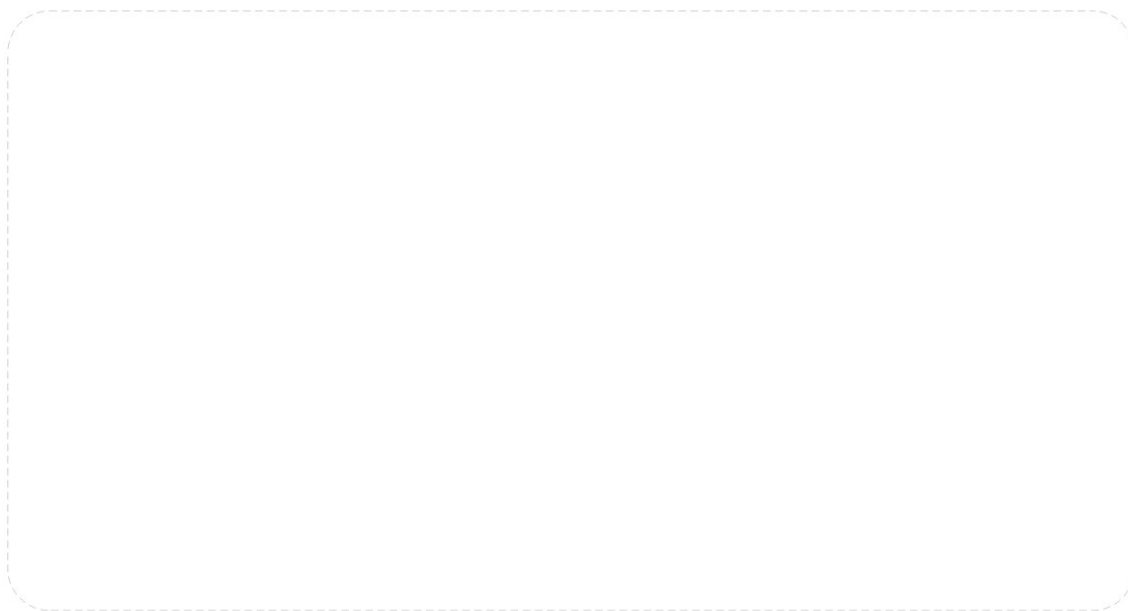
This welding head is specially designed TIG welding head for deep hole tube to tube-sheet, especially suitable for special tube to tube-sheet welding. It could weld carbon steel, stainless steel flush tube to tube-sheet connection, and suitable tube diameter is $\Phi 25\text{mm}$ and $\Phi 32\text{mm}$ with wire feeding or self-fusion.

Support equipment: i-Arc400 Programmable Orbital Welding Power Source.

Application: Boiler, heat exchanger, power plant, petrochemical and so on.



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