

Multi Clad welding machines represent the last development in PTAW e GTAW technology for anti-wear and anti-corrosion cladding.

These welding units are an evolution of the traditional and tested Commersald Impianti Plasma welding generators with several N.C. equipments for PTAW cladding sold in the world: Multiclad machines upgraded the penetration control with a more precise modulation of the pilot gas.

This feature, impossible to obtain with any other welding process, gives the possibility to act synergistically on all the welding parameters to obtain a low penetration into base metal in every condition : this makes the process extremely flexible, high productive and totally reliable.

The Multi clad project brings together some of the most updated cladding technologies that individually or combined give us the possibility to purpose the best customized solutions at the lowest price

The remote control panel is made by a graphic PLC with 9" touch screen and function of programming and monitoring of welding parameters and make possible the use of both welding units in 3 working methods:

Manual: with external pedal controller to regulate the working current and/or another remote controller for the powder or the wire feeding rate. This option is made for manual repair operations

Semi-auto: with set-up of internal programs and use of the consolle as remote controller for max 4 axis and oscillator. This configuration is mainly designed for external moving systems and in case of use of Commersald Impianti Oscillator the remote consolle is suitable to manage also the oscillation parameters. This configuration is designed for complex shapes, for long productions without the operator's presence.

Automatic: interfaced with a CN or an external robot managing movements and welding parameters.

Power generator Inverter technology is composed by different modules 100 Amps in continuous each, for max 600 or 900 Amps according to the welding unit. The current is correctly rectified to warrant the integrity of the electrode continuously for the 8 working hours.

The cooling unit, high efficiency is integrated in the machine and provides the cooling of the power unit as the welding torch

The process feeding of PTAW clad welding equipments can be powder or wire. In powder feeding the atomized metallic alloy coming from a feeder with pressure controlled by the torch is injected into

the melting pool through converged holes
The powder feeder designed by Commersald Impianti has adjustable rate from 0,5 to 5 kg/h and a capacity of 5-7 kg. A larger capacity version of 15-20 kg is available upon request. The external wire feeding - heated to increase the deposit range - comes from standard spools, drums or reels. Is also possible to send all the parameters to an external device for managing a welding report.



PTAW MULTICLAD



IN TWO WELDING UNITS THE MOST ADVANCED PROCEDURES FOR OIL & GAS CLADDING



PTAW POWDER
PTAW HOT WIRE
GTAW HOT WIRE
TANDEM PTAW POWDER + TIG HOT WIRE



PTAW POWDER
PTAW HOT WIRE
TIG HOT WIRE
PTAW DUBLE HOT WIRE
GTAW DUBLE HOT WIRE
TANDEM PTAW POWDER + PTAW POWDER
TANDEM PTAW POWDER + TIG DOUBLE HOT WIRE

COMMERSALD IMPIANTI

www.commersald.com

Via Labriola,42
41123 Modena - Italy
Tel.+ 39 059 822374
Fax+ 39 059 333099

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PTAW MULTICLAD 600

VERSATILITY

This word led Commersald Impianti in the construction of the welding MULTICLAD 600; in the same welding unit are in fact placed different systems that give the possibility to use PTAW technology or GTAW cold wire, hot wire or both techniques in tandem for cladding operations.

All this thanks to the modular configuration of the power section, that by a PLC selects one of the following operating modes:

- 1) PTAW with powder filler material
- 2) PTAW with hot wire filler material
- 3) GTAW with hot wire filler material
- 4) PTAW + GTAW cold wire with powder filler material (PTAW method) and hot wire filler material (GTAW method).

MULTICLAD 600 welding machine is supplied with the following standard equipment:

- N°1 torch for external parts PTAW 250,
- N°1 torch for external parts GTAW 300,
- N°1 standard powder feeder
- N°1 push-pull system
- N°1 HW delivery system

Optionals

- Torch for external parts PTAW 500
- Torch for internal parts PTAW 250
- Torch for internal parts PTAW 500
- Manual torch PTAW 125 for repairs
- Manual torch GTAW (Tig) for repairs
- Torch for internal parts from 2" PTAW 125
- Torch for internal parts GTAW 300
- Software for electronic oscillator
- Software for automatic stick-out



TECHNICAL FEATURES

Power installed	30 kVA
Max welding current at 100%	600 A @36V
Supply voltage	3F + N + E 400V
Frequenze	50/60 Hz
Protection grade	IP 54
Electro-valves for the regulation of 3 gas	
Gas pressure	3 bar
Recorded file programs	150
Dimensions l/h/p mm.	800 x 1850 x 1000
Weight	400 kg
Deposit rate according the specifications	Until 4,0 Kg/ora

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POWER

This is the key-word for the MULTICLAD 900 welding unit, with total power until 900 A for heavier cladding operations, possibility to operate in tandem with double PTAW or combined with GTAW hot wire.

MULTICLAD 900 is the top as for power as for deposit range capability in Commersald Impianti welding machines range.

Also this version can be setted with PLC according to the following configurations

- 1) PTAW with powder filler material
- 2) PTAW with hot wire filler material
- 2) PTAW with double hot wire filler material
- 4) GTAW with hot wire filler material
- 5) PTAW + PTAW both with powder filler material
- 6) PTAW with powder filler material + GTAW with double hot wire filler material

MULTICLAD 900 is supplied complete with the standard following configuration:

- N°1 torcia per esterni PTAW 500,
- N°1 torcia per esterni GTAW 600,
- N°1 alimentatore polvere standard
- N°1 trainafile
- N°1 sistema di veicolazione HW

Optionals

- Torch for external parts PTAW 250
- Torch for internal parts PTAW 250
- Torch for internal parts PTAW 500
- Manual torch PTAW 125 for repairs
- Manual torch GTAW (Tig) for repairs
- Torch for internal parts from 2" PTAW 125
- Torch for internal parts GTAW 300
- Software for electronic oscillator
- Double powder feeder
- Double push-pull
- Software for automatic stick-out

TECHNICAL FEATURES

Power installed	40 kVA
Max welding current at 100%	900 A @36V
Supply voltage	3F + N + E 400V
Frequenze	50/60 Hz
Protection grade	IP 54
Electro-valves for the regulation of 3 gas	
Gas pressure	3 bar
Recorded file programs	150
Dimensions l/h/p mm.	800 x 1850 x 1200
Weight	480 kg
Deposit rate according the specifications	Until 8,0 Kg/ora

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PTAW MULTICLAD 900

