

PTA200 VALVES

*automatic machine
for P.T.A.
welded coatings on valves*

PTA200VALVES is an automatic machine for welded coatings with Plasma Transferred Arc technology **ON VALVES** and valves seat of small/mid size (max weight of the piece 30 kg).

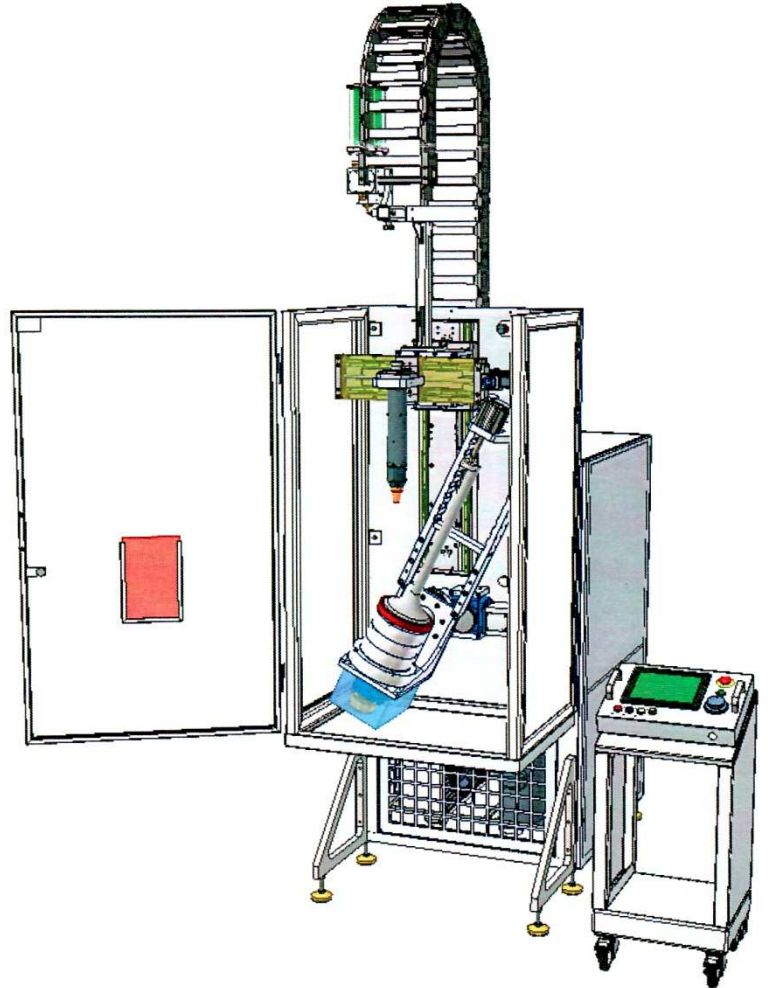
This compact machine is formed by:

- the PTA welding machine
- the cartesian motion system
- the operator's console.

PTA WELDING MACHINE

It's about the type PTA200i produced by Commersald (see the related technical sheet), complete of cooled welding torch and powder feeder.

The welding machine gives an output current of 200A at 100% and it can be used in single pass for **welding thickness from 1 to 3,5 mm, till 40 mm wide, and deposition rate till 2 kg/h**, respecting severe metallurgical parameters.



MOTION SYSTEM

It's about a simple four axis system (two cartesian axis to move the torch and two rotating axis for the workpiece) that grants:

- **smooth powder outlet** thanks to the possibility to place the powder feeder closed to the welding point and in axis with the torch
- **high precision in positioning**, even after years of use.
- **quick shifts** thanks to the reduced motion
- **nearness of the operator** to the welding point and consequent good visibility of the plasma arc, even with closed barriers.

The system is completed by a tailstock to support the valve steam during the tilting of the table.

OPERATOR'S CONSOLE

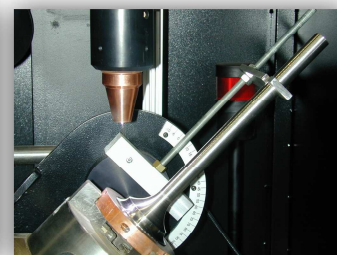
The motion of the axis is programmed and managed by the software of the Mitsubishi PLC in the console in English language. The programming is easy and intuitive and 100 welding cycles, complete of motion and welding parameters, can be saved.



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| TECHNICAL FEATURES PTA200VALVES | | | |
|--|-----------------------------|-----------------------|---------------|
| MAIN FEATURES OF THE PLANT | | | |
| Overall size (closed door) | Dimensions (lxdxh) | mm | 950x1900x3050 |
| | Weight | Kg | 500 |
| Workpiece | Max diameter of the coating | mm | 350 |
| | Max height of the coating | mm | 800 |
| | Max weight of the workpiece | Kg | 30 |
| Deposition rate | | Kg/h | 0,5 - 2,0 |
| FEATURES OF THE WELDING MACHINE PTA200i | | | |
| Pilot arc generator | Output current | A | 70 at 100% |
| Transferred arc generator | Output current | A | 200 at 100% |
| Powder feeder | Delivery | Kg/h | 0,5 - 3,5 |
| | Capacity | Kg | 7 |
| Welding torch YZR250 | Tungsten electrode Ø | mm | 4 |
| Cooler | Given power (water at 20°C) | W | 8700 |
| Power | | KVA | 16,7 |
| FEATURES OF THE MOTION SYSTEM | | | |
| Structure | Vertical axis stroke | mm | 500 |
| Oscillator | Max oscillation amplitude | mm | 40 |
| | Useful stroke | mm | 300 |
| Rotating table | Tilting | deg. | 0° - 90° |
| Power | | KVA | 0,525 |
| Tension | | 400V 50/60Hz (3F+N+T) | |



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