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CATALOGUE

Longitudinal Seam Welder





Introduction:

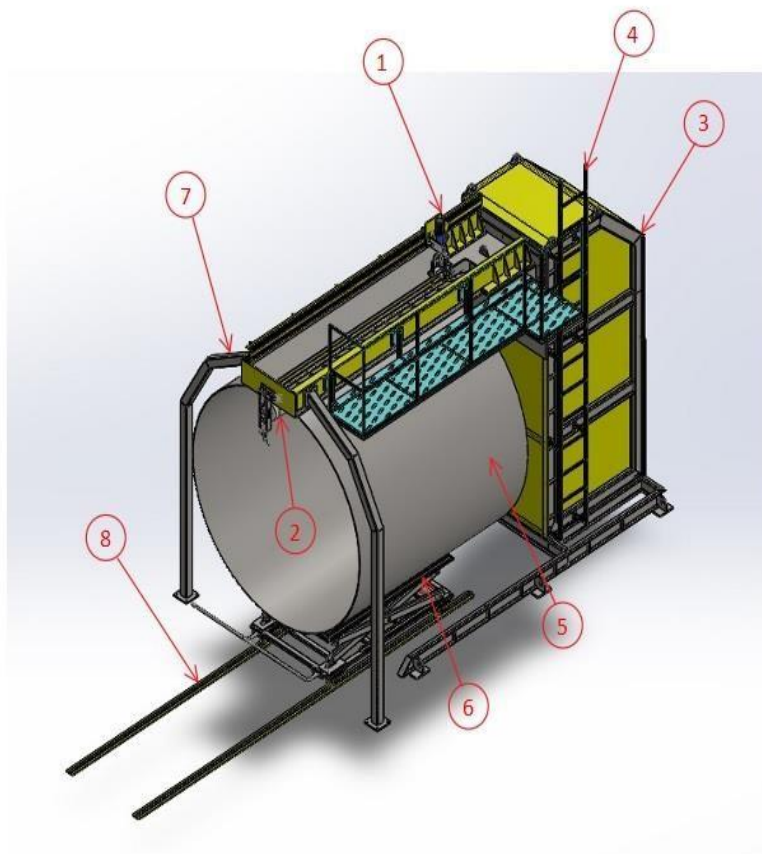
Longitudinal seam welding is a process in which a piece of sheet metal that is fully rolled is welded along the seam of its two ends. welding process could be either MIG_MAG or TIG depending to the customer order.

This process easily enables the joining of two flat plates of material together to form a cylinder. Longitudinal seam welding can be used on smooth plates, sheets, pipes, and tank sections to make cylindrical workpieces.

Seam welder machines in KARA Group company are manufactured in three different sizes. From small size to medium and finally large size , the capacity of workpiece dimensions and weight increases.

Workpiece is completely fixed on seam welder machine by pneumatic clamping mechanism. Precise movement of welding torch along its longitudinal move via linear sliding guide and step motor guaranties high quality of welding joints.

Due to heavy weight of workpiece a hydraulic lifting scissors is used to easily lift and mount workpiece in large size seam welder machine.



| | |
|---|-------------------------------|
| 1 | Mig Torch & Motor and Gearbox |
| 2 | Mandrel Tube |
| 3 | Main Structure |
| 4 | Ladder |
| 5 | Work Piece |
| 6 | Hydraulic lifting Scissors |
| 7 | Supporting Column |
| 8 | Angle Iron Railway |

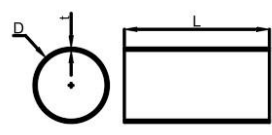


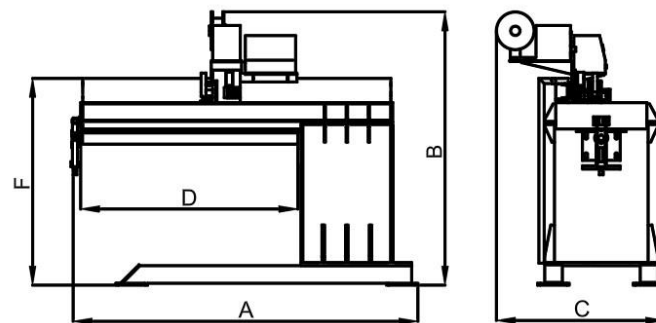
Technical specifications

| | Item | Small Size Machine | Medium Size machine | Large Size Machine |
|----|---------------------------------|---|---|--|
| 1 | Max work piece Diameter(mm) | 800 | 1300 | 2500 |
| 2 | Min Work Piece Diameter | 120 | 200 | 300 |
| 3 | Work Piece thickness (mm) | 0.5 – 4 | 0.5 – 4 | 1 – 12 |
| 4 | Max Workpiece length (mm) | 1500 | 2000 | 2500 |
| 5 | Max Longitudinal Torch Speed | 1200 mm/min | 1200 mm/min | 1200 mm/min |
| 6 | Longitudinal torch Course | 1600 | 2100 | 2600 |
| 7 | Longitudinal Movement Mechanism | Sliding linear guide& stem motor | Sliding linear guide& stem motor | Sliding linear guide& stem motor |
| 8 | Welding process type | MIG or TIG | MIG or TIG | MIG or TIG |
| 9 | Clamping Mechanism | Clamping plates actuated by Compressed Air hose 6 bar (2000 kg/meter) | Clamping plates actuated by Compressed Air hose 6 bar (2000 kg/meter) | Clamping plates actuated by Compressed Air hose 6 bar(2000 kg/meter) |
| 10 | Hydraulic Lifting scissors | — | — | included |
| 11 | Water Cooling Unit | included | included | included |
| 12 | Weight | 1400 KG | 2000 KG | 5000 Kg |






| Small Machine Dimensions | | | | | |
|--------------------------|------|------|------|--|------|
| | A | B | C | D | F |
| (mm) | 2500 | 2000 | 1300 | 1600 | 1500 |
| Workpiece Dimensions | | | | | |
| (mm) | D | L | t |  | |
| Min | 120 | | 0.5 | | |
| Max | 750 | 1500 | 4 | | |

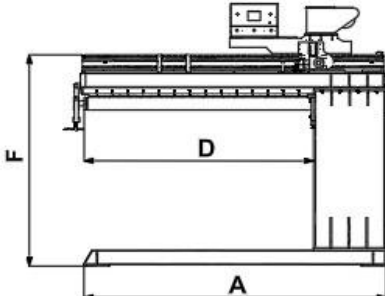
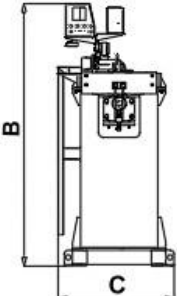


Overall Dimensions of small size seam welder

| Medium Machine Dimensions | | | | | |
|---------------------------|------|------|------|------|------|
| | A | B | C | D | F |
| (mm) | 2900 | 2200 | 1200 | 2200 | 2100 |

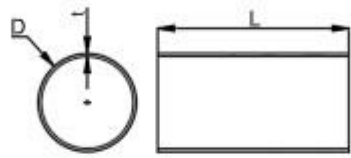
| Workpiece Dimensions | | | |
|----------------------|------|------|-----|
| (mm) | D | L | t |
| Min | 200 | | 0.5 |
| Max | 1300 | 2900 | 4 |

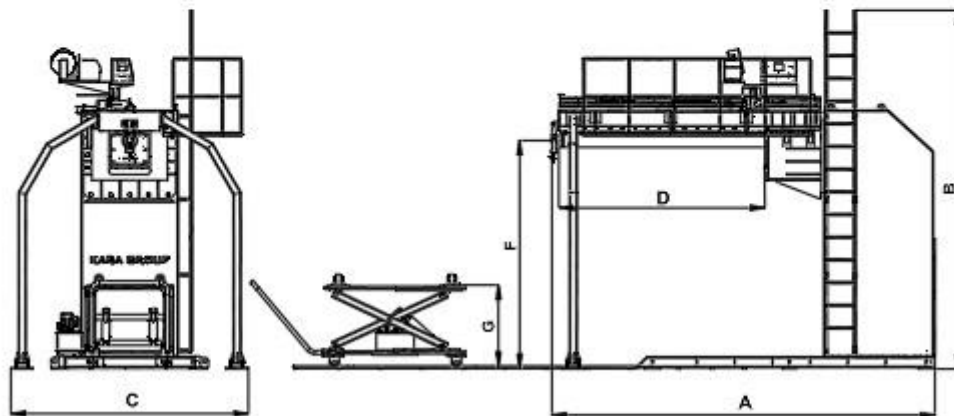


Overall Dimensions of medium size seam welder



| Large Machine Dimensions | | | | | | | |
|--------------------------|------|------|------|--|------|------------------|------------------|
| | A | B | C | D | F | G _{min} | G _{max} |
| mm | 5070 | 4740 | 3140 | 2700 | 3000 | 620 | 1560 |
| Workpiece Dimensions | | | |  | | | |
| | D | L | t | | | | |
| Min | 300 | | 1 | | | | |
| Max | 2500 | 2500 | 12 | | | | |



Overall Dimensions of large size seam welder