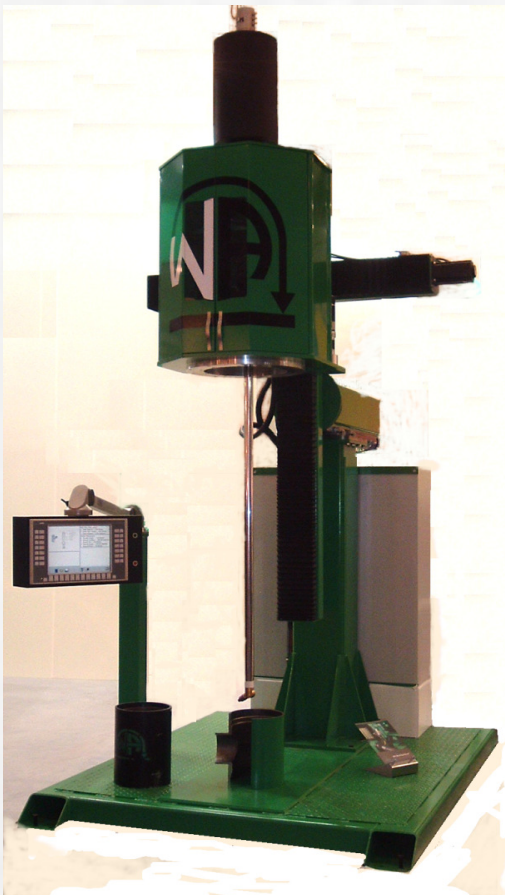


## Welding Alloys - MultiSurfacer XT™ Orbital Welder

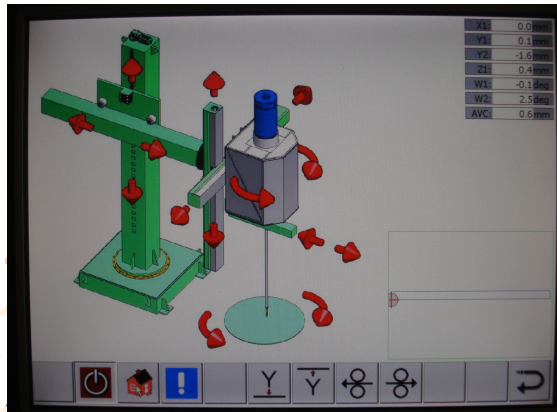
The XT Orbital Welder is a high technology machine capable of cladding internal and external bores, pipes, rings and grooves in the oil/gas and petrochemical sector. The design comes through Welding Alloys continued product development programme and in-depth product knowledge.



### Internal Orbital Cladding

The standard MultiSurfacer XT has been developed for TIG welding using a hot wire process for cladding.

The MultiSurfacer XT machine can clad internal bores, blocks and valves by the TIG welding process from 80mm to 400mm in diameter. Custom machines are capable of welding even larger bores, up to 800mm.



MultiSurfacer™ XT – main screen console panel

### MultiSurfacer XT™ Key Features

The innovative design of the MultiSurfacer XT machine features a touch screen control panel with intuitive graphics, self-centering function and bore-to-bore programming enabling fully automatic operation.

In addition, the MultiSurfacer XT control system provides off-line programming of component geometries.



Completed bore-to-bore welding using MultiSurfacer XT

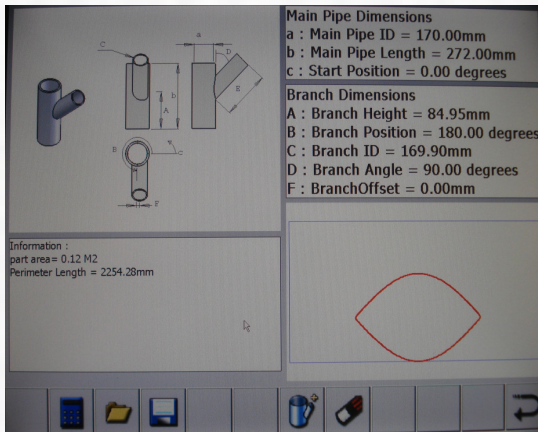


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# MultiSurfacer XT™ Orbital Welder



**Welding  
Alloys  
Group**



## WA MultiSurfacer XT Programming

For internal cladding of bores the component dimensions are entered from the drawing, and the weld paths automatically calculated taking into account component geometry.

The weld path calculated will take into consideration the stop and start points of the bore intersections. The XT control system can be programmed for a maximum of ten bores on any one weld run.

*Entering the bore dimensions & welding parameters*

**The touch screen console gives the operator total control of:**

- The TIG Power Source – enabling the optimisation of parameters for superior weld deposits
- The Wire Feed – gives programme control of ramp up, down & feed rates during the full programme cycle
- All movement axis – controls surface speed, rotation and all torch movements.



*Internal cladding of oil pipe in progress using MultiSurfacer XT orbital welder*

## Machine Technical Specification

<b>Pulse TIG Power Source:</b>	350A 100% duty cycle
<b>Hot Wire Source:</b>	150A 100% duty cycle
<b>Water Cooler</b>	
<b>Gas Argon Cylinder</b>	
<b>Weld Process (Wires):</b>	Hot Wire TIG (1 or 2 feed) $\phi$ 1,2 / 0.045"
<b>Wire Feed speed:</b>	Max: 20m per min / 787" per min
<b>Bore Diameter Size:</b>	Max: 400mm / 16"
	Min: 60mm (Gun & Torch required <45mm) / 2.5"
<b>Bore Depth:</b>	Max: 2,000mm
<b>Rotation of cage speed:</b>	Max: 10 rpm
	Min: 0.05 rpm
<b>Y Speed:</b>	3,000 mm per min / 118" per min
<b>X Axis Speed:</b>	3,000 mm per min / 118" per min
<b>Z Axis Speed:</b>	3,000 mm per min / 118" per min
<b>Cage tilt angle:</b>	+ / - 60 degrees
<b>TurnTable:</b>	2 rpm

## About Welding Alloys Group

Welding Alloys Group offers a 'complete package' of welding products, services and solutions to all of its customers globally. WA MultiSurfacer machines are in service in over 60 countries across the world, in many different industries. We also offer a comprehensive customer support, spares & warranty package.



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