



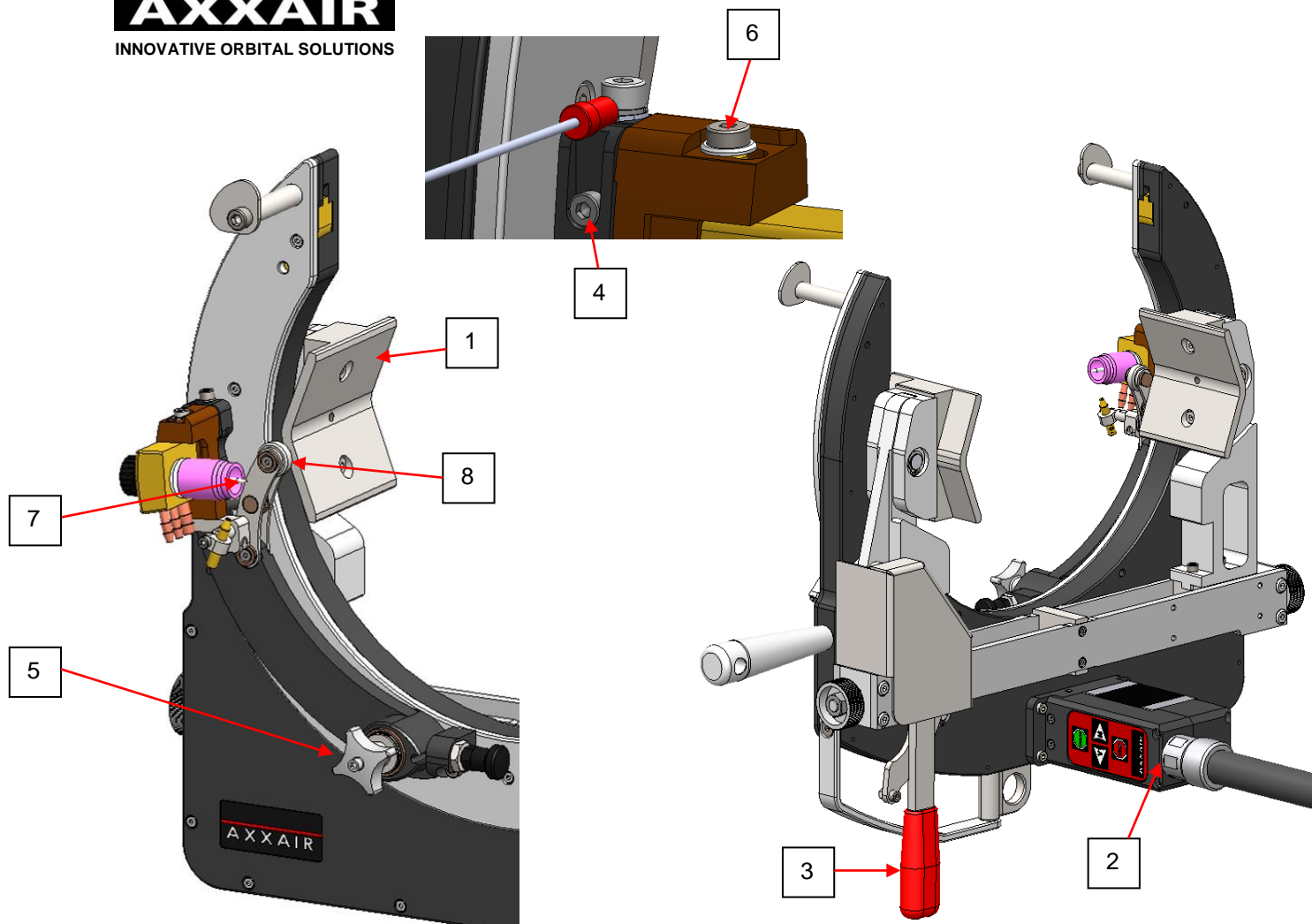
SATO-115E41 / SATO-115E42 / SATO-115E43 / SATO-115E44

User instructions: 16

Modo de empleo:..... 40

The operator must read and keep this manual on its working station . this document is not contractual.
El operario deberá leer este manual y guardarlo cerca del puesto de trabajo. Documento no contractual.






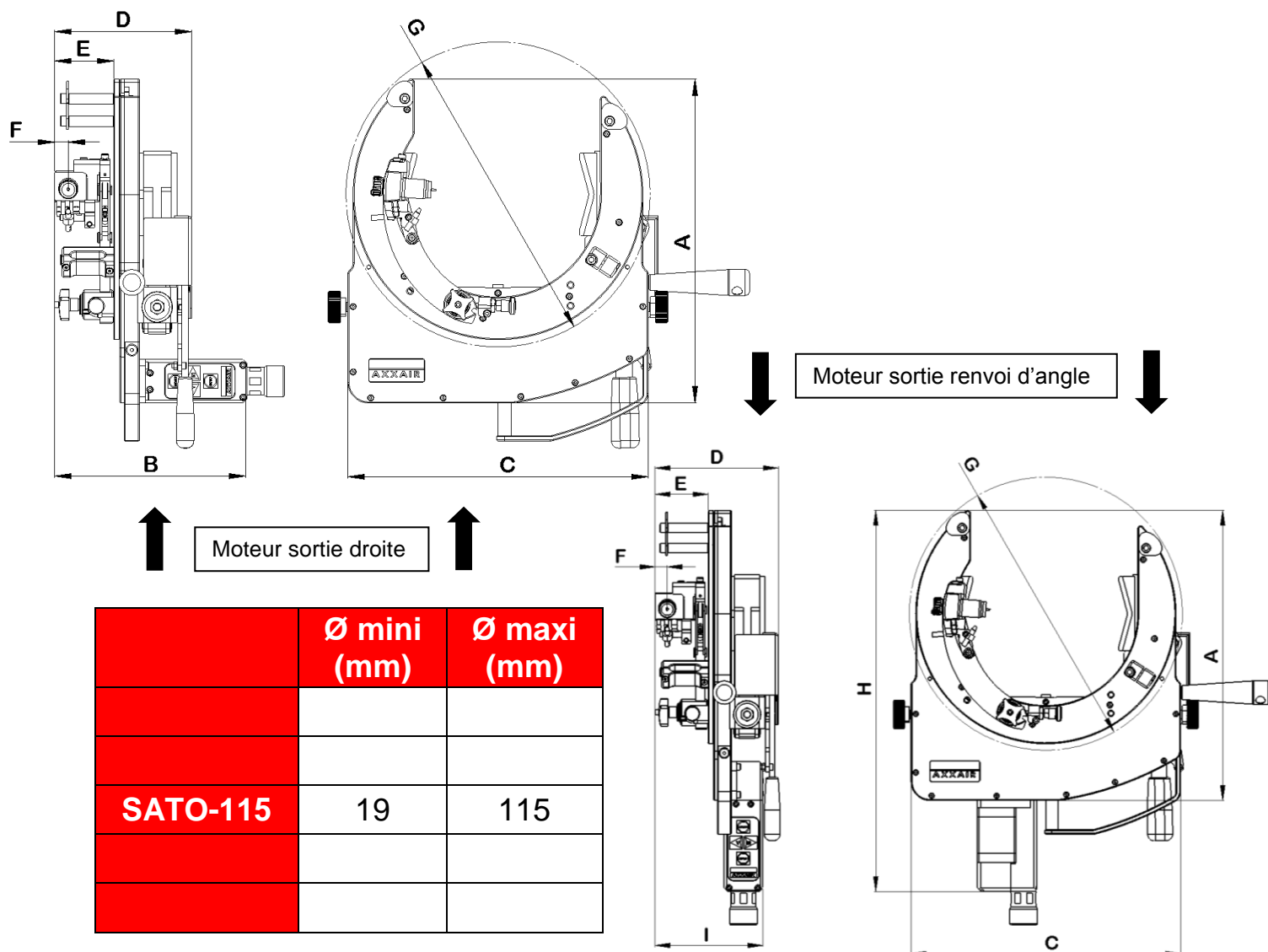
REP	ENGLISH	ESPAÑOL
1	Stainless steel clamp	Mordaza de apriete de acero inoxidable
2	Electric feed motor	Motor eléctrico de avance
3	Clamping jaw handle	Empuñadura de apriete de mordazas
4	Torch arm weld diameter control	Ajuste del brazo en función del diámetro que hay que soldar
5	Electrode axial control	Ajuste axial del electrodo
6	Electrode angular control	Ajuste angular del electrodo
7	1.6 or 2.4 electrode diameter	Electrodo diámetro 1,6 o 2,4
8	Profile track roller	Rodillo de control de perfil



Join **experience**

330B Route de Portes Les Valence - ZI Les Bosses - 26800 Etoile sur Rhône
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SAS au capital de 135 720 € - RCS Romans B414 581 363 - Code APE 2841 Z - Siret 414 581 363 00028 - TVA FR13414 581 363

	A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	
SATO-115	265	186 à 196	230	133 à 143	57 à 67	13	Ø224	363	113 à 121	6.7 kg



	Ø mini (mm)	Ø maxi (mm)
SATO-115	19	115



IEC/EN 60204-1
IEC/EN 12100-2
IEC/EN 60974-10

M. LEGRAND
AXXAIR Manager

ZI Les Bosses 26800 ETOILE-SUR-RHONE



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User instructions:

General Safety Instructions:

WARNING! To avoid the risk of electric shock, injury or fire when using electrical equipment, follow the following basic safety instructions. Read and follow these instructions before using the machine. Keep these safety instructions in a safe place!

The operator should ensure his own safety and that of persons nearby when using AXXAIR welding equipment. Consult the regulations relating to operation of this type of equipment and workplace safety so that the appropriate safety measures can be taken.

Only qualified personnel may use this equipment; they must follow the operating instructions. Failure to implement these safety precautions can endanger the operator and damage the equipment.

Before using this type of equipment, the operator must be well-acquainted with turning on and operating this equipment as well as with the welding process. The operator must be aware of safety regulations in force. It is essential that the operator is aware of the location of the emergency shutoff switch.

Prior to each use, the operator must ensure that there are no personnel in the work zone and that all personnel (including the operator) present during arcing are wearing appropriate protective gear: safety goggles or protective helmet, flame-resistant clothing, protective gloves, etc. Avoid wearing loose-fitting clothing or personal accessories that can become tangled in the equipment.

There should be no draughts in the working area. A well-identified fire extinguisher must be located within easy reach of the equipment.

To avoid all risk of fire, do not leave flammable objects or products near the work station.

Before conducting maintenance operations, disconnect the electrical power supply. Maintenance of the electrical system must be performed by specially qualified and trained personnel.

DANGER. To avoid potential electrical shock that could lead to loss of life: obey all rules in force related to the installation and grounding of the equipment. Never touch live parts or electrodes with bare hands or wet gloves. Insulate yourself from the workpiece and from the ground.

Do not inhale gas and fumes emitted by the welding process.

Use ear protection or any other device to protect hearing.

WARN all nearby persons of the potential risks.

The operator must always use the recommended personal protective gear, safety goggles, gloves and flame-resistant clothing.

Warning:

Arc-welding can be dangerous for the operator as well as for all persons in the vicinity. Take all appropriate safety precautions before using the welding machine. Observe and obey the safety procedures imposed by your employer; these procedures should be based on the rules and regulations in force as well as on the manufacturer's recommendations.

Electric Shock = Potential loss of life.

- Install and earth the welding equipment, following the rules and regulations in force.
- Do not touch live parts. Do not touch electrodes with bare hands or wet gloves.
- Insulate yourself from the ground and from the workpiece.
- Ensure that the work position adopted is safe both for the operator and for persons nearby.

Fumes and gas = Potential health hazard:

- Keep your face as far away from welding fumes as possible.
- Provide ventilation and evacuation of welding fumes using a suitable device that provides a safe working environment.

Light rays from the arc = These can damage your eyes and burn your skin.

- Protect your eyes and skin. Use a protective visor and wear safety clothing and protective gloves.
- Protect nearby persons from injury due to welding by providing protective curtains.

In the event of a malfunction, contact qualified service personnel only.



Contents:

General Safety Instructions Warning

Contents

1. Declaration of conformity
2. Presentation
3. Machine handing and storage
4. HF antenna
5. Connecting the weld head
6. Mounting the electrodes
7. Adjusting the machine based on tube diameter
8. Mounting the work piece
9. Step-by-step welding

Preparing for welding

Securing the pipe

Welding

Welding parameters:

10. Welding machine maintenance

1. Declaration of conformity:

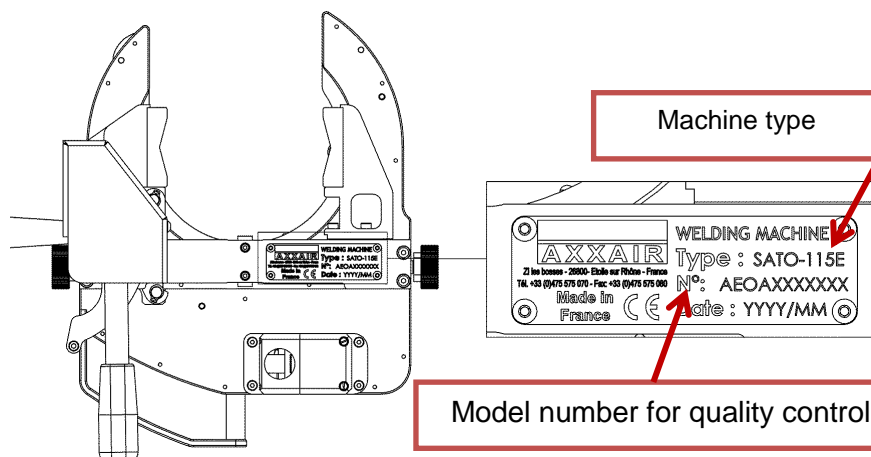
We declare at our risk and liability that this product conforms with the norms and guidelines found on specification page.

2. Presentation:

These machines are used for open arc TIG welding. This range of products may be used for tube-to-tube, tube-to-elbow, tube-to-ferrule and T-joint welding, as well as SMS connectors and other work pieces.

The weld heads are powered by a **SAXX** welding generator.

					SATO-115E					
					41/42	43/44				
Maximum welding current for an operating factor of 100%:					200A	100A				
Tube outside diameter:					19 à 115 mm					
Electrode diameters:	1.6 mm ou 2.4 mm									
Cooling unit:				No	Yes	No				
Operating temperature:	Ambient temperature must be within the range of -10°C to +40°C									

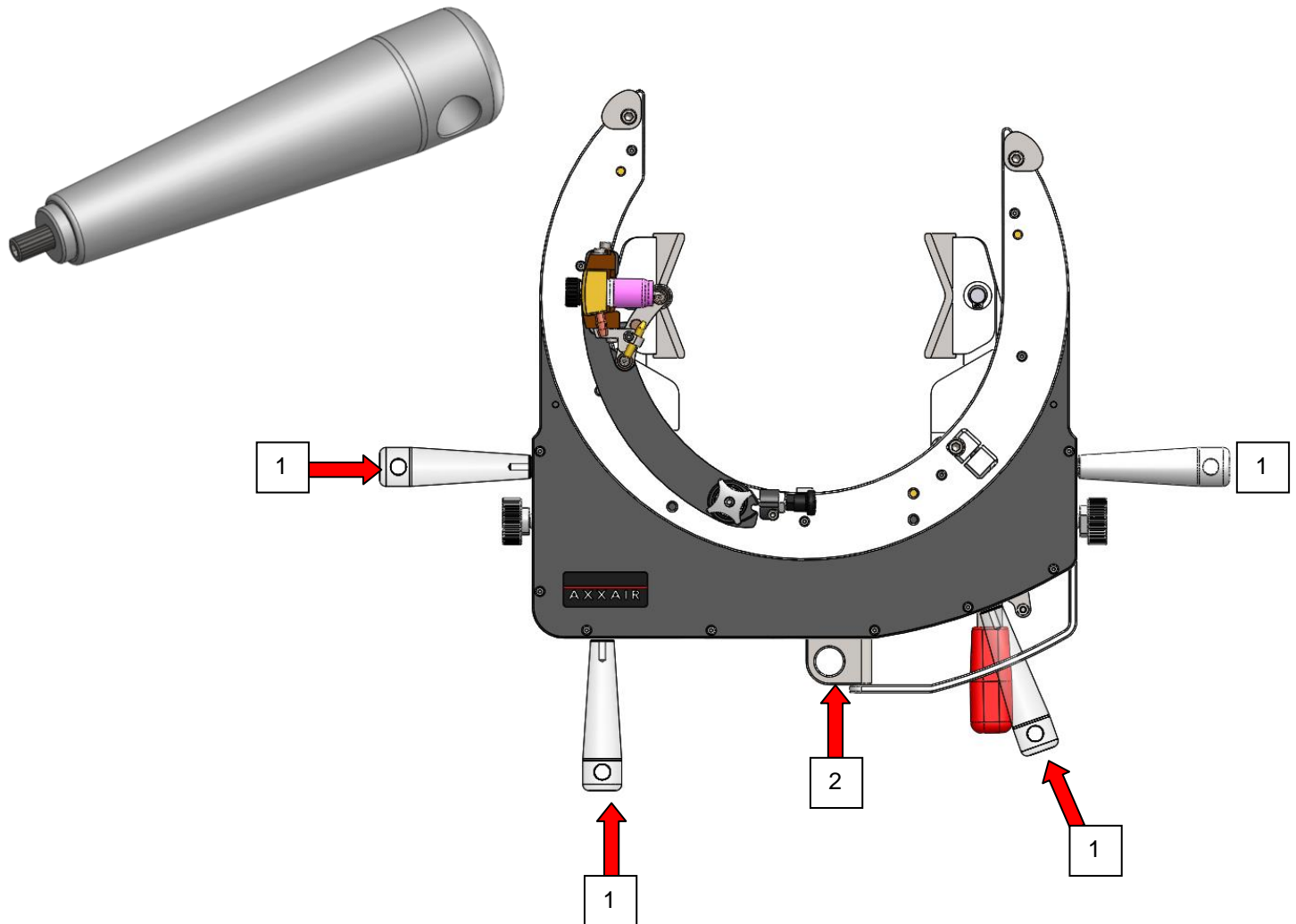


3. Machine handing and storage:

Handling:

SATO welding machines are portable and do not require any special handling. However, care should be taken so that the torch arm and hose are not damaged when the machine is moved or transported.

- 1- A removable handle can be positioned in various places around the head, following the preference of the user.

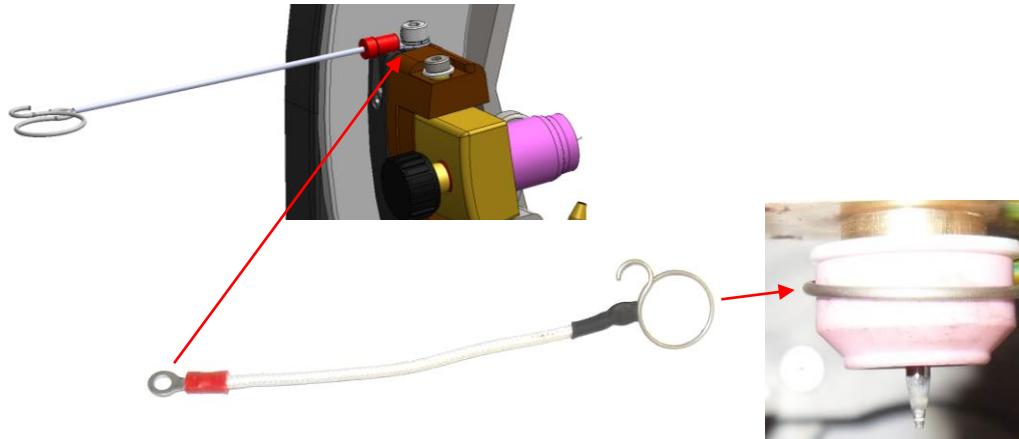


Storage:

If the weld head is not to be used for a long time period, store the machine in its original packaging. Before packaging, clean the weld head and empty any coolant. Do not expose weld heads to corrosion. Place a desiccant in the storage case if needed.

4. HF antenna:

The HF antenna helps the electric arc ignition. If the HF antenna is not well installed, it is possible that the power supply will not be able to create the electric arc. You have to put the spring on the ceramic nozzle and to fix the lug on a part linked to the ground. Pay attention that the electric arc does not ignite between the antenna and a part linked to the electrode.

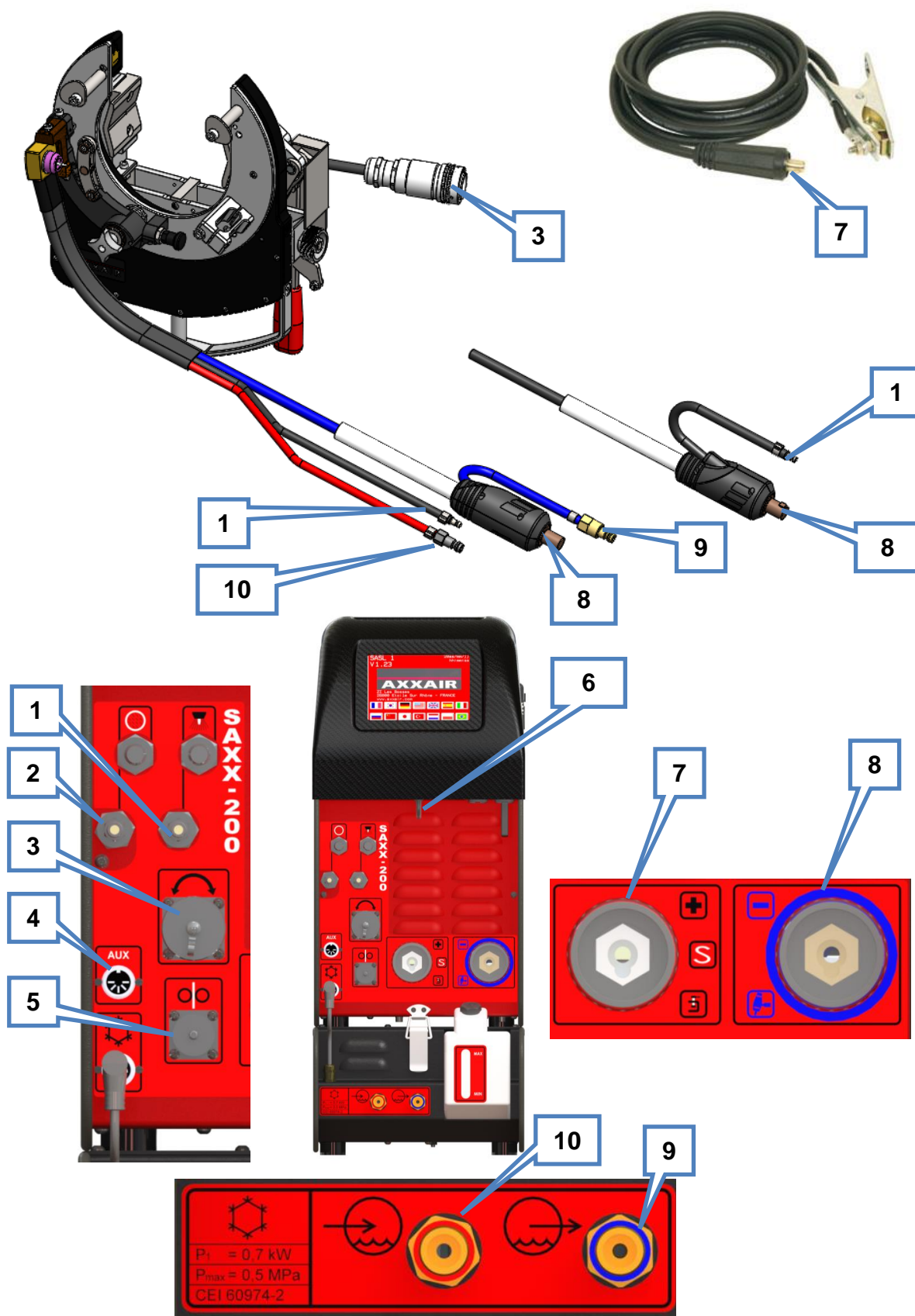


5. Connecting the weld head:

Ensure that the welding station is not activated before making these connections. SATO weld heads are connected using a hose pack that includes:

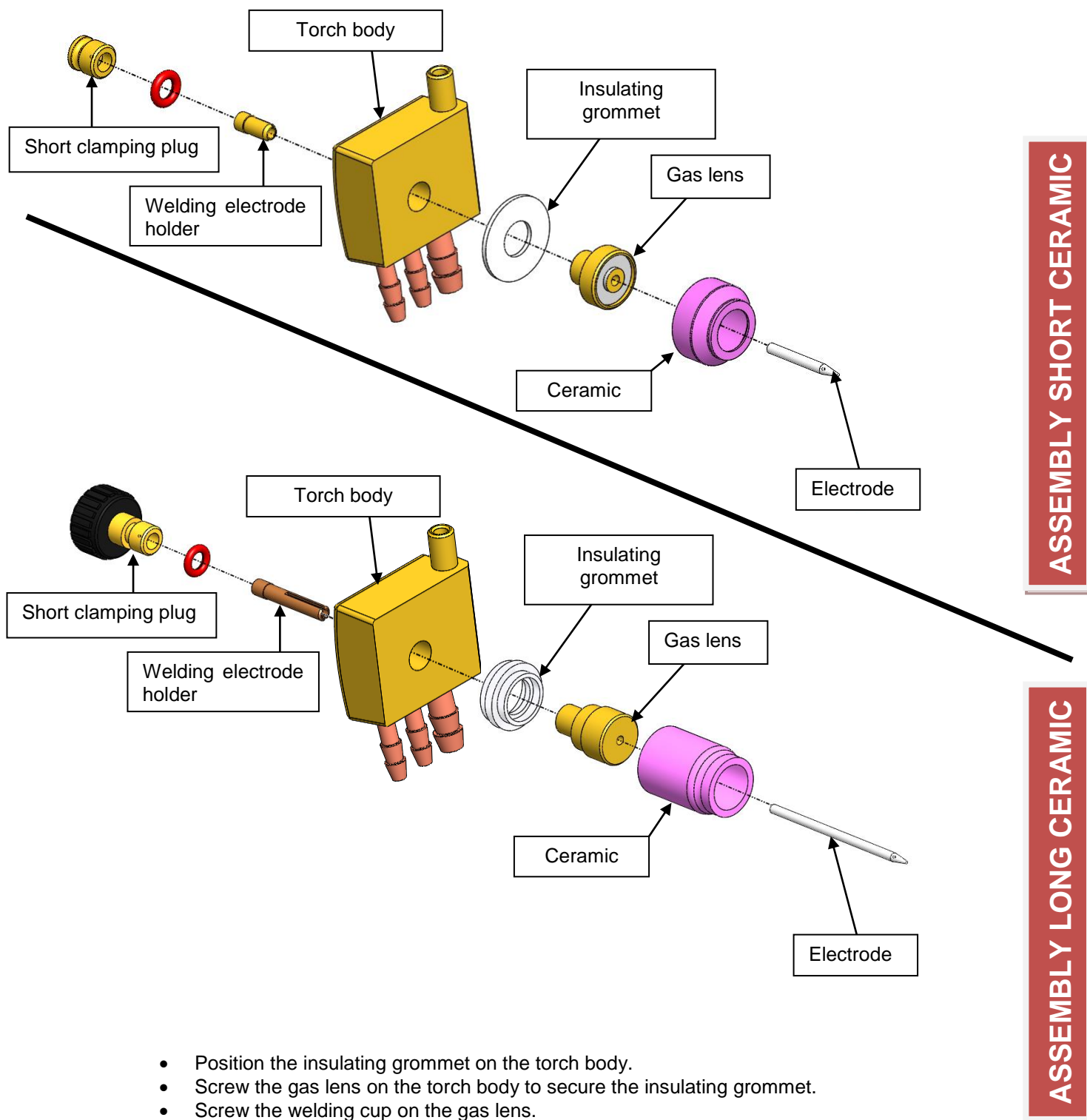
- A quick-release gas hose for connection at the front of the welding station.
- Blue colour-coded (cold water) braided hose for the welding current with water coupling.
- A red hose for hot water return.
- A control cable for the feed motor.
- A power cable for the feed motor.
- An earthing cable.





Warning: All connections must be made with the power off, i.e. with the ON/OFF switch set to OFF.

6. Mounting the electrodes:



- Position the insulating grommet on the torch body.
- Screw the gas lens on the torch body to secure the insulating grommet.
- Screw the welding cup on the gas lens.
- Mount the electrode using the electrode tongs and the short coupling.
- Push the electrode through the gas lens.
- Tighten the short clamping plug to secure the electrode.

Warning, use the proper gas lens and electrode holder depending on the diameter of the electrode

SATO machines are delivered with a kit of consumables including:

Product references:	Item:
SAGRL-24	11 mm flat wrench
SATMA-Co01	1.6 mm electrode holder, width 25
SATMA-Co02	2.4 mm electrode holder, width 25
SATMA-Co15	Insulating grommet type 9/20
SATMA-Co16	Series 9/20 short clamping plug
SCBC-06	N°4 ceramic cup dia. 6.3 mm
SCBC-08	N° 5 ceramic cup dia. 8 mm
SCBC-09	N° 6 ceramic cup dia.9.5 mm
SCBC-11	N° 7 ceramic cup dia.11
SCBC-12	N° 8 ceramic cup dia. 12.5 mm
SCDA-16	Series 9/20 gas lens dia. 1.6 mm
SCDA-24	Series 9/20 gas lens dia. 1.6 mm
SCE16-50	Box of 10 electrodes dia. 1.6 x 50
SCE24-50	Box of 10 electrodes dia. 2.4 x50
PDIN963-M03X012	DIN9 plastic slotted flat-head screw
SATOB-P110	Electrode clamping plug
SATOB-P111	2.4 mm electrode holder, width 12
SATD-13-01	Silicone O-ring
SATC-Co120	Short ceramic cup Ø12.5mm
SATC-Co121	Insulating grommet for short ceramic
SATC-Co123	Short gas lens Ø 2.4 mm
SCE246G	Electrode Ø2.4x22
SATD-12	Insulating grommet
SATC-Co124	Short gas lens Ø 1.6 mm
SATOB-P112	1.6 mm electrode holder, width 12
SATO-OUT1	Hexagonal 2.5mm screwdriver
SCE166G	Electrode Ø1.6x22

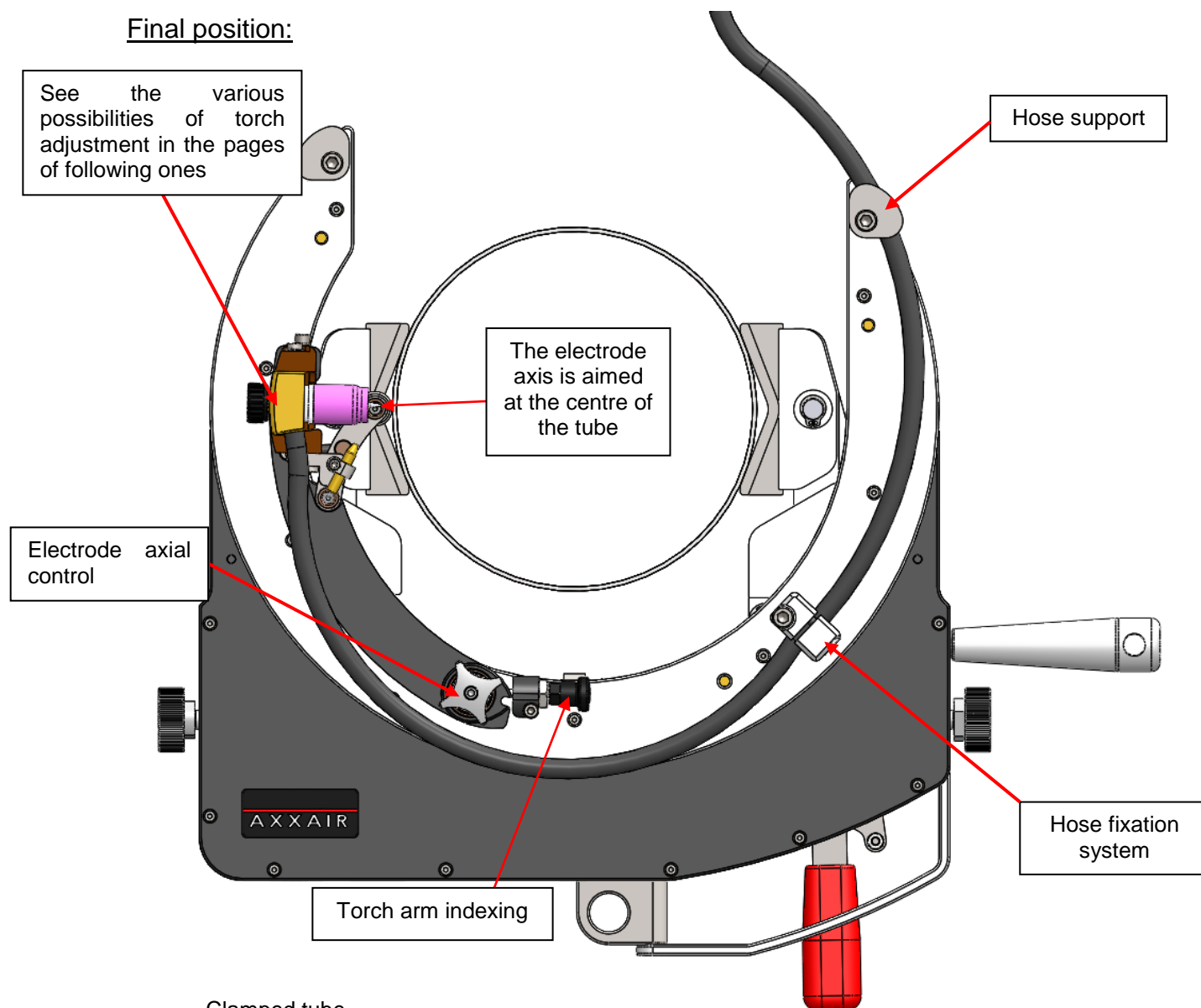


Note: The electrode selection for orbital welding is essential for the satisfactory performance of equipment. AXXAIR has tested all standard electrodes available on the market and from several suppliers in order to provide the best quality/cost trade-off. It is recommended that you use only AXXAIR electrodes.



7. Adjusting the machine based on tube diameter:

Final position:



Clamped tube.

The electrode axis aimed at the centre of the pipe.

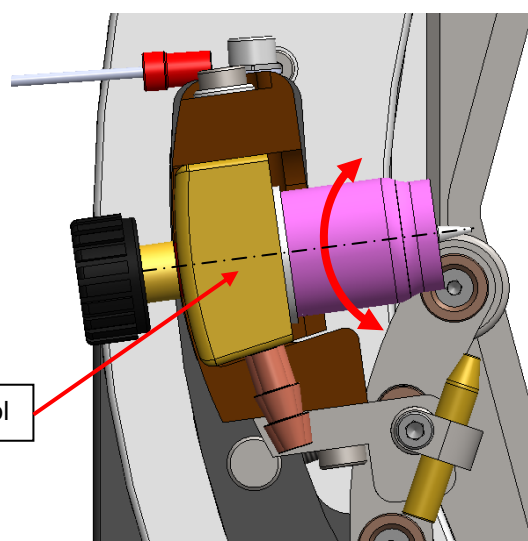
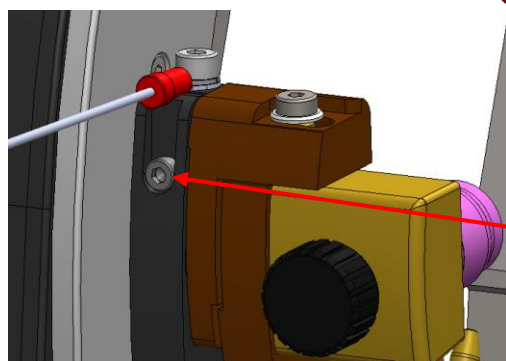
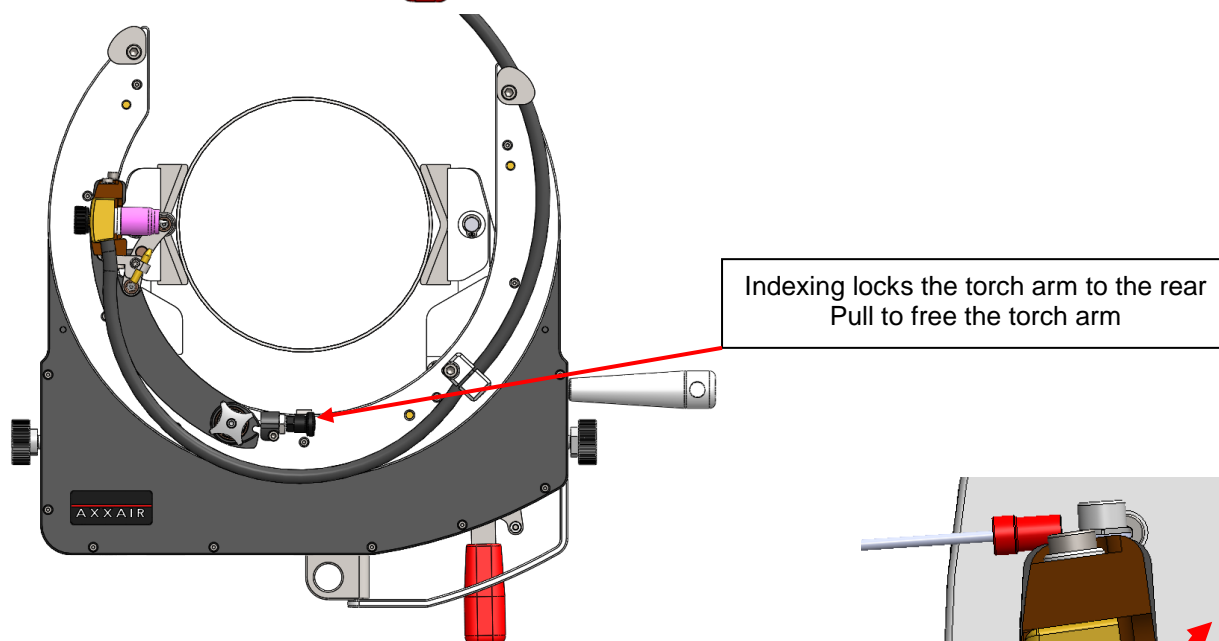
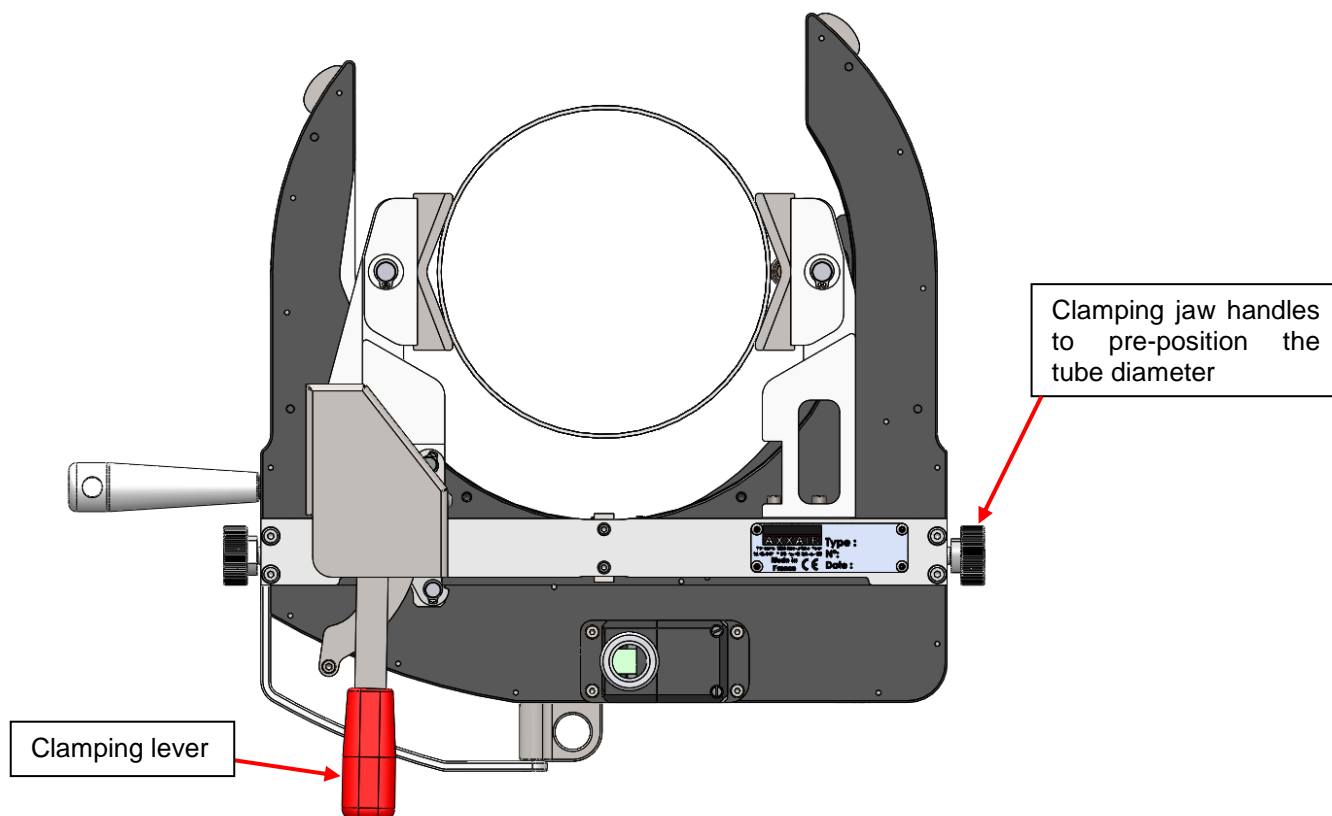
H = distance between the tube and the electrode

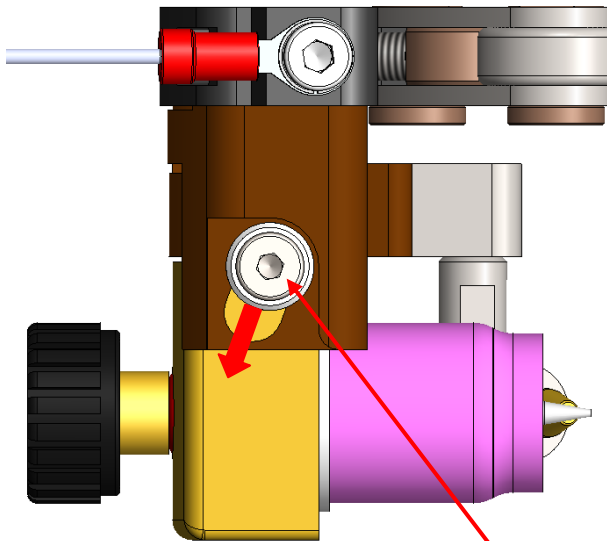
Electrode positioning with reference to the weld joint.

Note: For accurate adjustment, set several parameters simultaneously and repeat the operation if necessary.

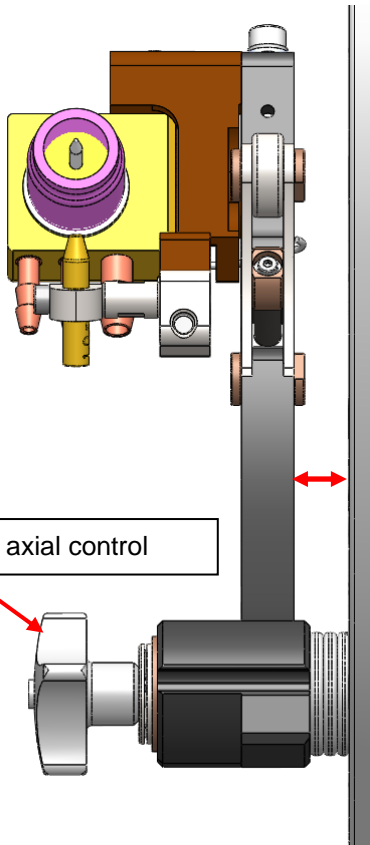
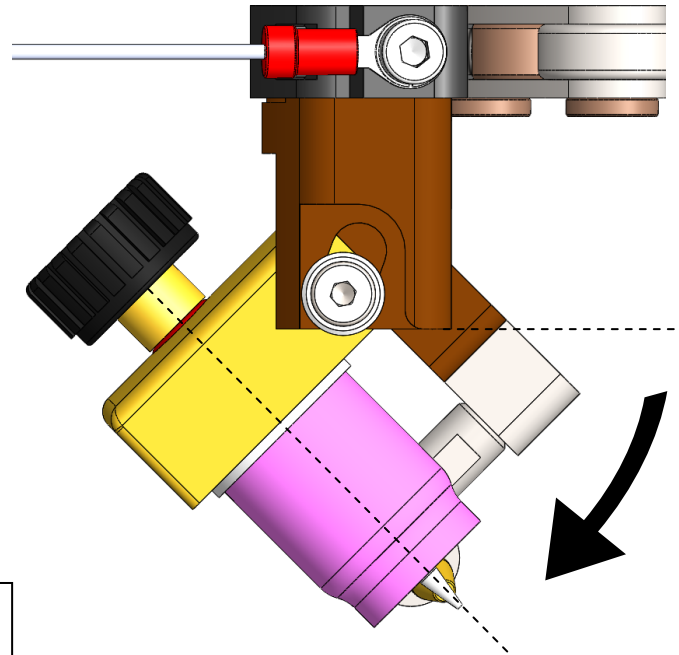
IMPORTANT: Arc height adjustment should be carried out with care. In fact, most welded pipes have a slight ovalisation deformity. Depending on the selected tube, make sure the adjustment is done properly so that the electrode does come into contact with the weld pool. If in doubt, increase the tube-electrode distance by a few tenths. The standard adjustment is the wall thickness.

It is easier to make this adjustment more accurately using a spacer between the pipe and the flat end of the electrode.

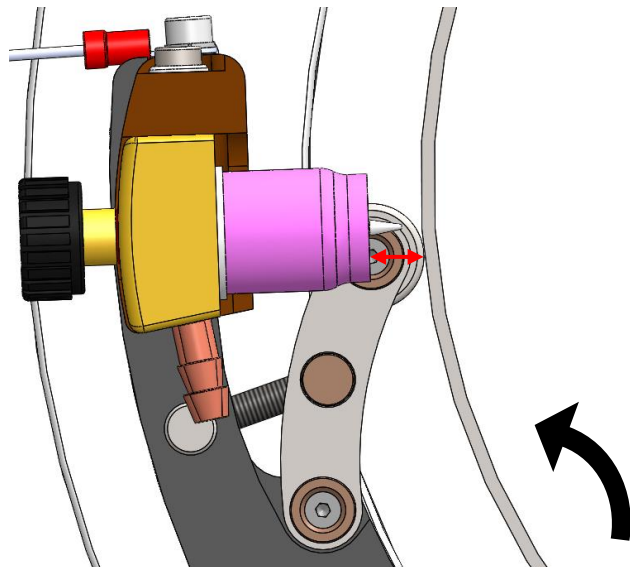




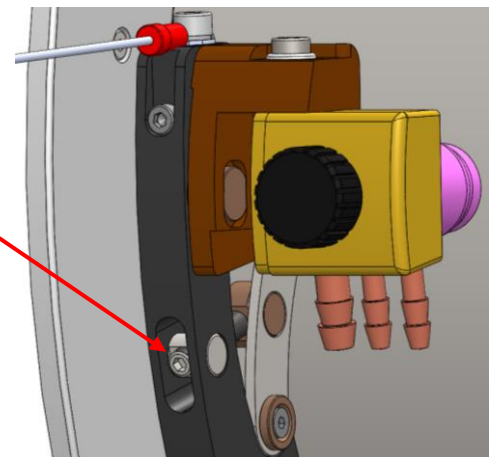
Electrode angular control
(45° maximum)



Electrode axial control

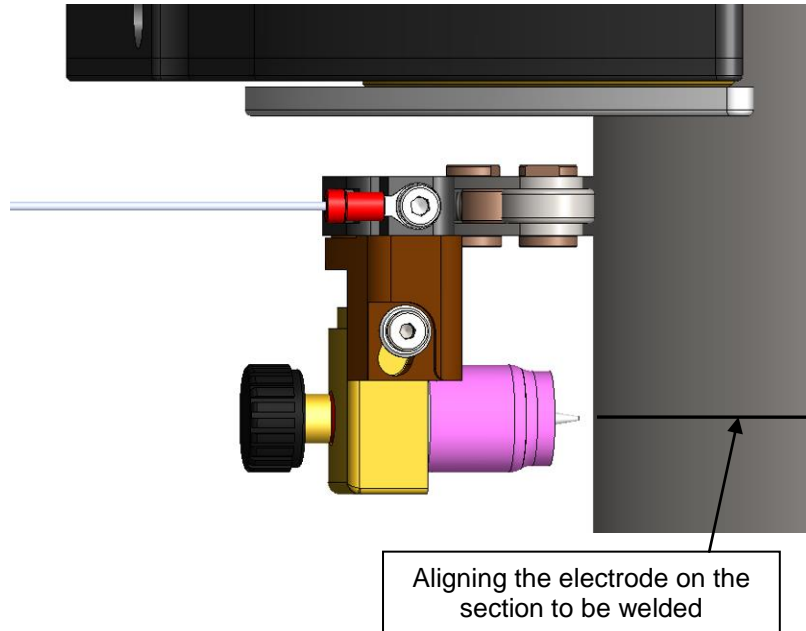


Adjustment of the
distance between the
tube and the electrode
: use the screwdriver
supplied



8. Mounting the work piece:

This operation requires aligning the electrode with the surfaces to be welded. This alignment must be done accurately so that the weld can be made in the section of the joint plane.



9. Step-by-step welding:

Preparing for welding:

Preparations for open arc welding are essential to obtain a satisfactory weld. The cut must be perpendicular to the axis. Refer to the CC-series orbital cutting machine.



Depending on the quality required, the surface may be prepared using a form working tool to ensure that the section surface is perfectly smooth and streak-free.

Securing the pipe:

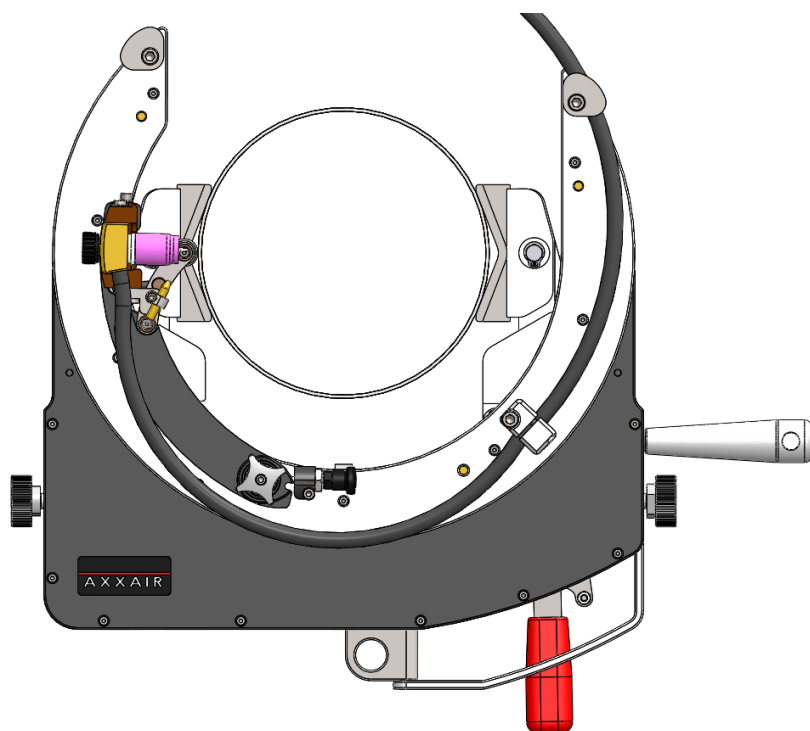
To ensure proper geometric alignment, manually tack weld the work pieces prior to welding using the weld head in tack weld mode.



Welding:

Welding is performed as follows:

- Position the tube.
- Position and tack weld on the two elements to be welded.
- Align the surfaces to be welded and the electrode.
- Purge the system to evacuate any oxygen in the hoses and the weld head (perform this step when using the machine for the first time or when the system has not been in service for a long period of time).
- Ensure internal tube inertisation (refer to the systems recommended by AXXAIR).
- The starting position is "the initial position".
- Choose the appropriate welding program.



Welding parameters:

The AXXAIR SXXX series has an automatic welding parameter calculation mode. When choosing the weld head, you must use **SATO-XXXE**.
Refer to the generator user's manual.

10. Welding machine maintenance:

Prior to each use of the machine, visually inspect the electric/water hose pack. Replace if necessary.

- Maintenance operations should be performed by qualified personnel using original replacement parts.
- Before any maintenance operation, disconnect all power sources.
- Store and transport the machine, including all accessories, using the original shipping case.
- Always keep the machine clean for optimum performance.

Never insert any foreign bodies into the machine rotation system.

Inspect the condition of the rotor contact surface on the horseshoe housing. If needed, clean surfaces using red Scotchbrite™ pads.

It is important to check the condition of the hoses connecting the weld head to the welding station to avoid any water or gas leaks.

WARNING:

Only use coolants recommended by axxair. Never add water to the coolant tank because this may result in chemical reactions that may damage the machine and void the warranty!

