

APPLICATION SHEET : MECHANISED WELDING

REFERENCE: INF_C0003 / M_CLA / 0706

SUBJECT: HORIZONTAL SURFACE CLADDING OF PIPES
GTAW/TIG HOT WIRE

APPLICATION: **INTERNAL BORE CLADDING OF PIPES**
- Diameter range (I.D.): 100 – 600 mm
- Max. pipe length: 10 m
- Welding process: GTAW/TIG twin hot wire
- Material deposited: Inconel 625-825

EQUIPMENT:
- 600 PC-DC hot wire power source with POW Windows[®]-based software
- Specially designed hollow shaft rotator
- Longitudinal carriage
- Polysoude twin wire feeder

GENERAL DESCRIPTION AND UNIQUE FEATURES

- The process involves surface cladding of pipes for off-shore and oil related companies. An extremely economical method to replace very expensive solid Inconel pipes.
- High deposition is achieved by the twin hot-wire cladding process with dilution levels as low as 5 % in a single pass.
- Bead geometry 8 mm wide & 5 mm din depth. Weld deposit in excess of 6 kg/hour.

*Internal bore surface
cladding of pipes*

