

APPLICATION SHEET : MECHANISED WELDING

REFERENCE: INF_C0004 / M_CLA / 0706

SUBJECT: VERTICAL SURFACE CLADDING OF VALVES
GTAW/TIG HOT WIRE

APPLICATION: **INTERNAL SURFACE CLADDING OF VALVES**

Ring grooves, pockets and intersecting scallops
- Diameter range (I.D.): 50 – 2300 mm
- Max. pipe length: 3 m
- Welding process: GTAW/TIG twin hot wire
- Material deposited: Inconel 625

EQUIPMENT:

- 600 PC-DC hot wire power source with POW Windows®-based software
- 3 m diagonal rotating table
- Column & boom with tollo slide assembly
- Polysoude twin wire feeder

GENERAL DESCRIPTION AND UNIQUE FEATURES

- The process involves surface cladding of well heads & valves for off-shore and oil related companies. Depositing 2 or 3 layers of corrosive resistant materials such as Inconel 625 or Stellite.
- 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 4 kg/hour.

*Internal surface
cladding of valves*

