
TIG^{er} Performance Feedback

1. Overall weld overlay cladding station operation stability evaluation

Good stability, and after some adjustment of grounding problem at the positioner everything has worked quite good.

2. Defect rate & type status

We have had very few welding deviations, but a few smaller deviations (bound integrity) has occurred after welding 10 tons of wire.

In the beginning there were a bit more faults, but after some adjustment and learning/trimming the machines, it has been very few deviations.

3. AVC performance during weld overlay cladding for smallest size pipe.(as for the travelling speed is quite high, I'd like to know if there will be any problem for AVC control)

The AVC in our two machines has functioned very good.

4. Wire feeding stability, how long you need to change the conduit and Nozzle. (as the wiring speed is quite high, I want to know the status of conduit under high speed feeding, for the nozzle as you have water cooling, I agree it will be good)

Normally we change the nozzle after 5-8 hours (this is equal to 20-30hours of welding at traditional speed).

The conduit we normally change once a week.

5. Fe Dilution Status for Inconel 625.

With our wire in our pipe (F65) cladding we have achieved less than 3% Fe measured 3mm from base material.

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