



ORBITAL WELDING

Orbital welding systems and accessories for high-purity process installations





News



OWX 3.0 | Closed orbital weld head

As the follow-up to the OWS series, the OWX weld heads offer a wide range of innovative developments. The slim and futuristic design, combined with the latest smart features, make the OWX heads a must-have in modern pipeline construction.

- Simple operation
- Modern smart features
- Easy to service and maintain
- Compatible with Orbitalum products
- Optional: Table mount for greater safety

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Food & Beverage Package | Mobile Welder + MH 4.5

Orbital welding has become indispensable in many sectors. Whether in the food and beverage industry or in railing construction, the demands on weld seams are high. With the Food & Beverage Package, automated tube welding is possible for anyone and anywhere. The Food & Beverage Package contains everything needed for orbital welding: Mobile Welder, MH 4.5 welding head, and all necessary connecting cables and hoses. It is ideal for installation and repair work on construction sites in the area of thin-walled stainless steel tubes. The Food & Beverage Package also offers a price advantage over the individual components and makes entry into orbital welding particularly attractive.

- Mobile Welder as portable orbital welding power source with lightweight and compact design
- Open, gas-cooled MH 4.5 welding head with integrated remote control in the handle
- Covers tube dimensions in the range 20 - 114.3 mm (0.787" - 4.500")
- MH 3.0 and MH 6.6 welding heads are available for other tube dimensions
- Upgrade possibilities allow the Mobile Welder to grow with the challenges

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News

ORBIWELD 19 HD | Closed orbital weld heads

Precise, robust and powerful - that's the OW 19 HD micro welding head. As a continuation of the proven OW 19 orbital welding head, the HD version has a high load capacity. The use of a robust clamping mechanism guarantees a long service life with consistently precise weld seam quality. The OW 19 HD is particularly suitable for the installation and hook-up of pipes in the semiconductor industry. Conversion between OW 19 and OW 19 HD is possible at any time.

- Liquid-cooled
- Robust clamping mechanism
- Covers pipe dimensions in the range 3.0 - 19.05 mm (0.118 - 0.750 inch)
- Long service life
- Flip-up weld head cover "Flip Cover"
- Optimized welding gas guidance
- Integrated control panel
- 7.5 m (24.6 ft) hose package
- OW 19 HD conversion kit for easy changeover between OW 19 and OW 19 HD

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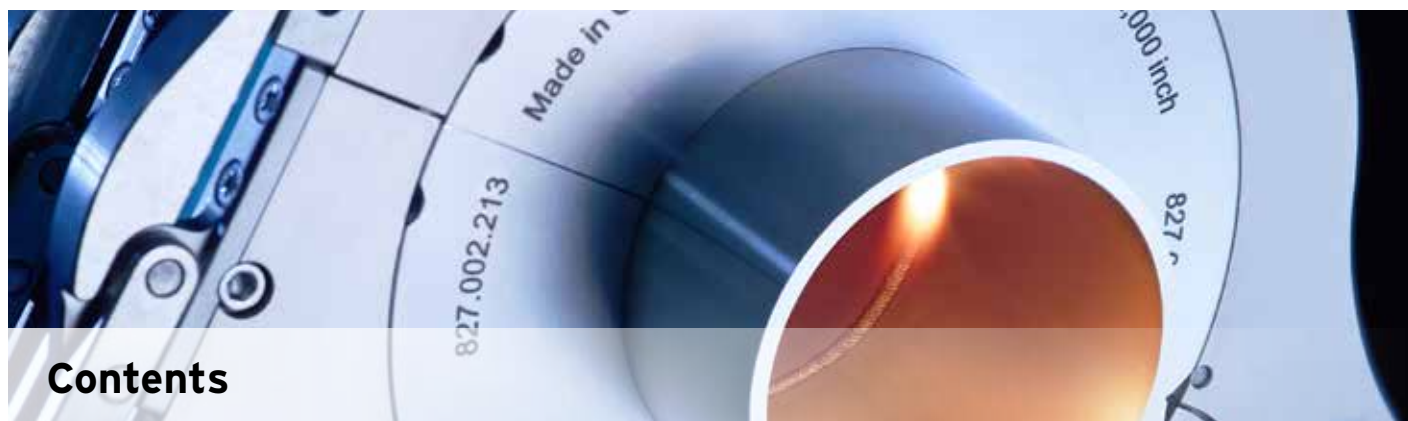
ORBIWELD 25 GC | Closed orbital weld heads

With its slim design, seamless parts supply thanks to fast customer service and proven compatibility with existing systems, the ORBIWELD 25 GC sets standards in high-precision tube welding. Specially developed for the semiconductor industry, it enables the simple, fast and reliable welding of thin-walled tubes - even in confined spaces.

- Compatibility with market standards makes it easy to switch to the latest Orbitalum technology
- Extremely narrow design for use in confined spaces, e.g. in the semiconductor industry
- Removable clamping cassettes especially for inline assembly or prefabricated production of modules
- For small tube diameters 6.0 mm - 34.0 mm (0.236" - 1.339")
- Integrated control panel for controlling the power source

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Markets and applications

Orbitalum is a global leader for portable, powerful pipe cutting, squaring and beveling machines for industrial weld seam preparation. In addition Orbitalum offers a wide range of orbital welding systems for high-purity, process as well as heat exchanger applications. Orbitalum products have a wide range of applications in the following fields:

Application	e.g.	Products
Boilers & heat exchangers	<ul style="list-style-type: none"> • Pipe bundle heat exchangers • Box headers • Boilers • HVAC blade heat exchangers 	<ul style="list-style-type: none"> • RPG tube squaring machines • ORBIWELD/OWX weld heads • P16/TX, pipe-in-sheet weld heads • ORBmax residual oxygen meter
Pharmaceuticals & chemical industry	<ul style="list-style-type: none"> • HP High-Purity • Process lines • Mixing valves • CIP "Cleaning in Place" lines 	<ul style="list-style-type: none"> • GF, PS, RA & GFX pipe cutting and beveling machines • RPG tube squaring machines • ORBIWELD/OWX weld heads • ORBmax residual oxygen meter
Semi-conductor	<ul style="list-style-type: none"> • HP High-Purity • UHP Ultra High-Purity • Process lines • Gas cabinets • Component production • CFOS gas supply • PCW cooling water supply 	<ul style="list-style-type: none"> • RPG tube squaring machines • ORBIMAT welding power sources • ORBIWELD/OWX weld heads • ORBmax residual oxygen meter
Aerospace technology	<ul style="list-style-type: none"> • Hydraulic • Fuel supply • Engine components • Air conditioning 	<ul style="list-style-type: none"> • GF, PS, RA & GFX pipe cutting and beveling machines • RPG tube squaring machines • ORBIWELD/OWX weld heads • ORBmax residual oxygen meter
Food processing, dairy and beverage industries	<ul style="list-style-type: none"> • HP High-Purity • Process lines • Mixing valves • CIP "Cleaning in Place" lines 	<ul style="list-style-type: none"> • GF, PS, RA & GFX pipe cutting and beveling machines • RPG tube squaring machines • ORBIWELD/OWX weld heads • ORBmax residual oxygen meter • Mobile Welder power source • MH weld heads

Orbital welding power sources & accessories



Compatibility overview power sources and weld heads

This quick reference shows the different combination possibilities of our power sources and weld heads and makes it easier for you to combine the correct orbital welding systems. Interested in a personal consultation? Then contact us at +49 (0) 77 31 792-0 or send an email to tools@orbitalum.com. Our team is happy to find a suitable product for your individual requirements.

	Mobile Welder 854 000 001	Mobile Welder OC PLUS 854 000 011	Smart Welder 850 000 001	Power Welder 852 000 001	ORBITWIN SW 853 000 001
ORBIWELD 12 821 000 010	↑	●	●	●	●
ORBIWELD 17 817 000 010	↑	●	●	●	●
ORBIWELD 19 822 000 010	↑	●	●	●	●
ORBIWELD S 826 000 001 827 000 001 828 000 001 825 000 001	↑	●	●	●	●
HX 847 000 010 848 000 010 845 000 010	↑	●	●	●	○
MH 803 000 001 804 000 001 805 000 001	●	●	●	●	●
TP 811 000 001 811 000 005 812 000 011 813 000 010 813 000 011 814 000 001 814 000 005	↑	●	●	●	●
TP AVC/OSC 812 000 012 813 000 012 814 000 002	○	○	○	○	○
TX 38P 830 000 005	↑	●	●	●	●
P16 831 000 001 831 000 003	↑	●	●	●	●
P16 AVC 831 000 002	○	○	○	○	○
Manual torch SW 890 013 01S	○	○	●	●	●
Manual torch MW 854 030 200	●	●	○	○	○

● = Compatible







↑ = Upgrade option

○ = Not compatible

Overview power sources

This overview of our power sources should simplify the selection of the right orbital welding system for you. Interested in a personal consultation? Then contact us at +49 (0) 77 31 792-0 or send an email to tools@orbitalum.com. Our team is happy to find a suitable product for your individual requirements.

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	Mobile Welder 854 000 001	Mobile Welder OC PLUS 854 000 011	Smart Welder 850 000 001	Power Welder 852 000 001
	TECHNICAL DATA			
Control range	5 - 140 A 	5 - 180 A	5 - 180 A	5 - 300 A
Welding current type	DC	DC	DC	DC
Duty cycle	100 % - 140 A	60 % - 180 A 100 % - 140 A	60 % - 180 A 100 % - 160 A	40 % - 300 A 60 % - 260 A 100 % - 220 A
Supply voltage	1~ 100-230 V 50/60 Hz	1~ 100-230 V 50/60 Hz	1~ 100-230 V 50/60 Hz	3~ 400-480 V 50/60 Hz
Machine weight with cooling unit	-	21 Kg (46.30 lbs)*	26 Kg (57.32 lbs)*	-
Machine weight without cooling unit	15,6 Kg (33.06 lbs)	15,6 Kg (33.06 lbs)	-	35,4 Kg (78,04 lbs)
Cooling	-	0,4 kW	0,4 kW	-
Dimensions (WxDxH)	264 x 540 x 376 mm (9.7 x 21.3 x 14.8 in)	273 x 546 x 513 mm (10.8 x 21.5 x 20.2 in)	600 x 400 X 310 mm (23.6 x 15.7 x 12.2 in)	600 x 400 X 480 mm (23.6 x 15.7 x 18.9 in)
IP standard	7.0"	7.0 "	12.4 "	12.4 "
Screen size	IP23S	IP23S	IP23S	IP23S
Touch	●	●	●	●
Soft keys	●	●	●	●
Rotary knob	●	●	●	●
Digital welding gas control		●	●	●
Gas flow sensor	●	●	●	●
Cooling unit		Stackable cooler	Internal	External
Coolant flow sensor		●	●	●
Coolant tank capacity		2,1 L	2,2 L	○
System printer	Thermal	Thermal	Dot Matrix	Dot Matrix
	CONNECTIONS/INTERFACES			
Power connection	Pluggable	Pluggable	Pluggable	Fix
Weld head/torch	●	●	●	●
USB	2	2	4	4
LAN	●	●	●	●
HDMI	○	○	●	●
BUP	○	○	●	●
ORB	○	○	●	●
External cooling unit		●	●	●
Remote control	○	○	○	○
VGA	○	○	●	●
LPT	○	○	○	○
PS2	○	○	○	○
CF/SD-Karten	○	○	○	○

	Mobile Welder	Mobile Welder OC PLUS	Smart Welder	Power Welder
	854 000 001	854 000 011	850 000 001	852 000 001
	FUNCTIONS			
Software interface orbital welding	●	●	●	●
Software interface TIG manual welding	●	●	○	○
Multilingual	●	●	●	●
Metric and imperial measuring units	●	●	●	●
User levels	↑	●	●	●
Password protection	↑	●	●	●
Weld head recognition	●	●	●	●
Flow Force function	↑	●	●	●
Permanent gas function	↑	●	●	●
Cold wire	↑	●	●	●
Auto Programmierung Advanced	↑	●	●	●
Auto Programmierung Basic	●	●	●	●
Welding program manager	●	●	●	●
Protokol manager	↑	●	●	●
Welding data documentation	↑	●	●	●
Input screen process details	↑	●	●	●
Orbital tacking function	↑	●	●	●
Weld gas overview	↑	●	●	●

	Mobile Welder	Mobile Welder OC PLUS	Smart Welder	Power Welder
	854 000 001	854 000 011	850 000 001	852 000 001
Welding process resumption	↑	●	●	●
Return delay	↑	●	●	●
Electrode replacement warning	↑	●	●	●
Cross-sector parameter transfer	↑	●	●	●
Cooling lag time	↑	●	●	●
AMI parameter import	↑	●	●	●
IoT/Industry 4.0 over MQTT	↑	●	●	●
Programmable documentation fields	↑	↑	↑	↑
VNC remote access	↑	↑	↑	↑
Control commands via QR scan	↑	↑	↑	↑
Power source data exchange via LAN	↑	↑	↑	↑
	COMPATIBILITY			
Liquid-cooled weld heads	↑	●	●	●
Gas-cooled weld heads	●	●	●	●
Turning gear	↑	●	●	●
AVC/OSC	○	○	○	○
TIG manual torch liquid-cooled	○	○	●	●
TIG manual torch gas-cooled	●	●	○	○
Hose package extension	●	●	●	●
ORBICAR W	○	○	●	●
ORBICOOL Active	○	○	●	●
ORBICOOL MW	↑	●	○	○
ORBITWIN	○	○	●	●
ORBMax	○	○	●	●
Remote control	○	○	●	●
USB keyboard	●	●	●	●
USB code scanner	●	●	●	●
USB storage media	●	●	●	●
USB printer	●	●	●	●
LAN printer	↑	●	●	●
Welding programs	SW/MW + ↑	CB/CA/SW/MW	CB/CA/SW/MW	CB/CA/SW/MW
	UPGRADE OPTIONS			
UPGRADE Option - ORBICOOL MW	●	Incl.		
UPGRADE Option - Software MW+	●	Incl.		
UPGRADE Connectivity LAN/IoT/VNC	●	●	●	●
	APPLICATION AREA			
Main application area	Assembly/installation	Assembly/installation	Preproduction/mass production	Preproduction/mass production
Portability	+++	+++	++	+
Ease of use	++	++	+++	+++
	MARKETS			
Foods	+++	+++	++	+
Pharmaceutics	+	++	+++	+
Semi-conductor	+	+++	+++	+
Aerospace technology	+	++	+++	+
Oil and gas	+	+	+	+++
Heat exchanger	+	+	++	+++
HVAC heat exchanger	+	+	+++	+
Railing construction	+++	++	+	+

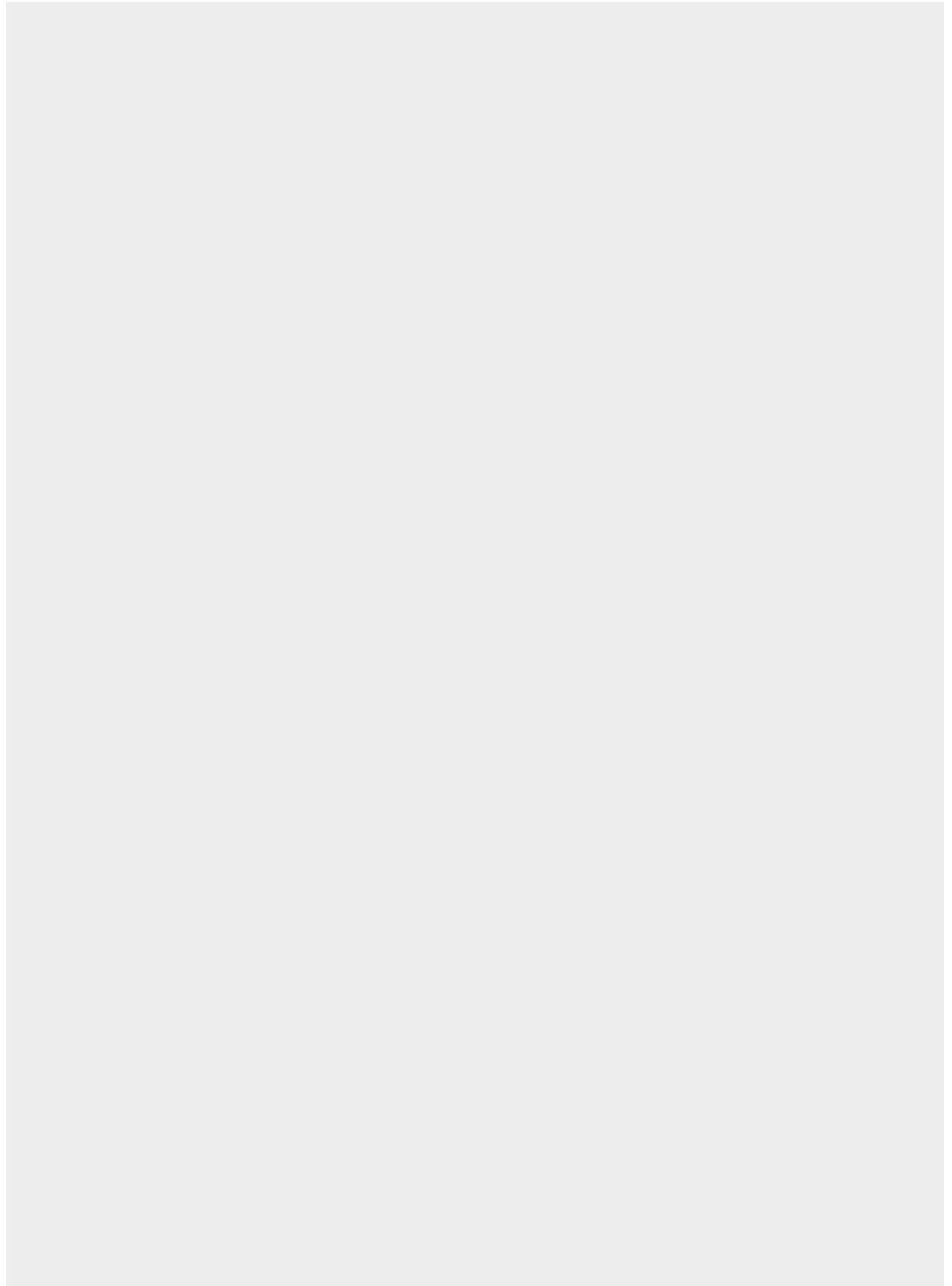
● = Compatible

↑ = Upgrade Option

○ = Not compatible

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*Without tank capacity



Mobile Welder

The entry-level model among the orbital welding power sources - the Mobile Welder. The portable orbital welding power source impresses with intuitive and simple operation and is equipped with all relevant functions required for orbital welding. The Mobile Welder enables automated welding of tubes for anyone and anywhere.



NEW. Mobile Welder

The Mobile Welder is a portable orbital welding power source designed specifically for tube construction in the area of thin-walled stainless steel tubes. It is ideally suited for use on construction sites and enables the usual high and consistent quality of orbital welding even in hard-to-reach work areas.

Lightweight and robust construction

The Mobile Welder is equipped with a carrying handle and shoulder strap and can be easily transported with a weight of approx. 15 kg. In addition, it convinces with a compact design.

Intuitive and simple operation

The Mobile Welder has the same intuitive operating concept as the Smart Welder series and is therefore equipped with a rotary dial, a touch display and soft keys. Clear and focused menu navigation allows the operator to create a welding program in just a few steps and then start the welding process. He is supported in this by the integrated auto-programming function. The Mobile Welder is equipped with all the important functions required for orbital welding. Together with our open, gas-cooled orbital welding heads, orbital welding can be carried out very easily and flexibly.

Manual TIG welding

The use of a "manual welding mode" is also possible in combination with a TIG hand torch, thus extending the application possibilities of the Mobile Welder. Tacking work can be carried out flexibly and manual welding can be carried out easily in places that are difficult to access with orbital welding heads (see "TIG manual torch for Mobile Welder" on page 109). The simple and flexible changeover of the user interface between orbital and manual welding eliminates the need for an additional manual power source. The Mobile Welder offers the ideal 2-in-1 solution.

Upgrade options

It is possible to expand the Mobile Welder's range of functions at any time via upgrade options, should, for example, the requirements and areas of application of the welding work change. These upgrade options are available:

- **UPGRADE - ORBICOOL MW:** If the external cooling unit ORBICOOL MW is connected to the Mobile Welder, liquid-cooled welding heads can be operated in addition to gas-cooled welding heads.
- **UPGRADE - Software MW+:** With the software upgrade, a wide range of smart functions is available, such as welding data logging and digital welding gas management.

With these two upgrade options, the Mobile Welder is able to evolve into a Mobile Welder OC Plus and grow with the challenges.

Food & Beverage Packageage

Don't wait - get started right away with the Food & Beverage Packageage. The package contains everything needed for orbital welding: Mobile Welder, open MH welding head, and all the necessary connecting cables and hoses. In addition, the package offers an attractive price advantage over the individual components (see "Food & Beverage Package" on page 14).



Shapely and practical case with carrying handle and shoulder strap.

Mobile Welder



Foldable protective cover for display and controls.



Interface
Orbital welding



Interface
Manual welding



Gas-cooled TIG manual torch MW
with 6 m hose package (optional)

Orbital welding power source




Mobile Welder

ITEM	VERSION	CODE	MACHINE WEIGHT KG
Mobile Welder	1~ 110-230 V 50/60 Hz	854 000 001	15,60

WELDING POWER SOURCE	MOBILE WELDER
CODE	854 000 001
TECHNICAL SPECIFICATIONS	
Control range	5 - 140 A
Welding current type	DC
Duty cycle	100 % - 140 A
Supply voltage (Supply voltage > 160 V)	1~ 110-230 V 50/60 Hz
Weight	15,6 Kg*
Dimensions (WxDxH)	264 x 540 x 376 mm (9.7 x 21.3 x 14.8 in)
IP standard	IP23S
Screen size	7"
Touch	●
Soft keys	●
Rotary knob	●
USB ports	2
Internal printer	Thermal

SCOPE OF DELIVERY	MOBILE WELDER
Shoulder strap MW	●
Power cable DE	●
Hose connection set	●
Quick Start Guide	●
General safety instructions welding power sources	●
Calibration certificate	●
FURTHER FEATURES	
Wide Range input power range	●
Welding gas monitoring	●
Auto programming	●
Multi lingual	●
Metric and imperial measuring units	●
Multifunctional rotary control and soft keys	●
7" Touch Display	●
Welding program manager	●
Welding program exchange via USB	●
Upgradeable	●

Available upgrade options:

-  ORBICOOL MW (854 030 301)
-  Software MW+ (854 030 321)
-  Connectivity LAN/IoT/VNC (850 080 001)*

*Requires upgrade option software MW+.

The technical data are non-binding.
They do not contain any assurance of properties.

Detailed information on our upgrade options can be found on our home page at

<https://www.orbitalum.com/en/products/product-details/mobile-welder.html>



Suitable accessories (optionally available):

- Gas-cooled TIG manual torch MW, see page 109
- Upgrade options
- Bar code/QR code scanner, see page 26
- ORBmax residual oxygen meter, see page 104
- Double pressure reducer, see page 108
- Ground cable, see "Ground cable" on page 107
- Electrode grinders ESG, see page 100
- "USB WLAN stick" on page 26

Food & Beverage Package

for Mobile Welder

The cost-effective entry into orbital welding - with the Food & Beverage Package. The Food & Beverage Package contains everything needed for orbital welding: Mobile Welder, open MH welding head, and all required connecting cables and hoses. It is ideal for installation and repair work on construction sites in the area of thin-walled stainless steel tubes.



Orbital welding has become indispensable in many areas. Whether in the food and beverage industry or in railing construction, the demands on weld seams are high. With the Food & Beverage Package, automated tube welding is possible for anyone and anywhere.

Food & Beverage Package

The Food & Beverage Package includes the Mobile Welder, the MH 4.5 welding head and all necessary connecting cables and hoses. The Mobile Welder (see page 12) is a portable orbital welding power source specially developed for modern tube construction. It has a lightweight and compact design and impresses with its simple and intuitive operation. The open, gas-cooled MH 4.5 welding head (see page 66) included in the scope of delivery covers the most common pipe dimensions in the range 20 - 114.3 mm (0.787" - 4.500") with its continuously adjustable tube diameter. A remote control is integrated in the handle so that all welding-related functions can be

operated directly from the welding head. The Food & Beverage Package enables high and reproducible orbital welding quality even under difficult conditions.

Ready to weld immediately

The Mobile Welder is supplied ready to weld together with the MH 4.5 welding head in the Food & Beverage Package.

Everything at one price

The Food & Beverage Package also offers a price advantage over the individual components and makes entry into orbital welding particularly attractive.

Areas of application

The areas of application for the Food & Beverage Package range from breweries and dairies to railing construction. In the food and beverage industry, the focus is on the reliability and cost-effectiveness of equipment and compliance with high hygiene standards. In railing construction, the visually demanding

appearance of weld seams also comes into play. The associated welding requirements can be easily met with the Food & Beverage Package.

Get started now with the Food & Beverage Package. The MH 3.0 and MH 6.6 welding heads are available for other tube dimensions (see page 66). Optional upgrade options enable the Mobile Welder to grow with the challenges at any time, for example, if the requirements and areas of application of the welding work change.



Formely and practical case with carrying handle and shoulder strap.

Mobile Welder



MH 4.5 open orbital weld head, front view



MH 4.5 open orbital weld head, rear view

Food & Beverage Package

Mobile Welder + Mobile Head MH 4.5 including control line and ground cable




ARTICLE	COMPONENTS	CODE	MACHINE WEIGHT KG
Food & Beverage Package	Mobile Welder + MH 4.5 WELD HEAD	854 001 001	15,60

SCOPE OF DELIVERY FOOD & BEVERAGE PACKAGE

SCOPE OF DELIVERY	FOOD & BEVERAGE PACKAGE
Mobile Welder	●
Shoulder strap MW	●
Power cable DE	●
Hose connection set	●
Quick Start Guide	●
General safety instructions welding power sources	●
Calibration certificate	●
MH 4.5 weld head	●
Transport box	●
Consumables/ Tool kit	●
MH 4.5 Reduction jaws 20 - 40 mm (0.787 - 1.575 in)	●
MH 4.5 Reduction jaws 40 - 80 mm (1.575 - 3.150 in)	●
Ground cable	●
Control line	●
General safety instructions open weld heads	●

For detailed information on the Mobile Welder and Mobile Head, see "Mobile Welder" on page 12 and "Mobile Head MH" on page 66.

Available upgrade options:

-  ORBICOOL MW (854 030 301)
-  Software MW+ (854 030 321)
-  Connectivity LAN/IoT/VNC (850 080 001)*

*Requires upgrade option software MW+.

Detailed information on our upgrade options can be found on our home page at

<https://www.orbitalum.com/de/produkt/mobile-welder.html>



Suitable accessories (optionally available):

- Gas-cooled TIG manual torch MW, see page
- Upgrade options
- Bar code/QR code scanner, see page 26
- ORBmax residual oxygen meter, see page 104
- Double pressure reducer, see page 108
- Hose assembly extensions, see page 108
- ORBIPURGE Forming set, see page 107
- WS2 tungsten electrodes, see page 108
- Electrode grinders ESG, see page 100
- USB WLAN stick, see page 26

Laboratory Package

for Mobile Welder

The Laboratory Package is optimally tailored to the needs of the semiconductor industry. In this industry, where the highest demands are placed on the quality of weld seams, precision and reliability, the package offers the ideal solution. The Laboratory Package combines the Mobile Welder with the gas-cooled ORBIWELD 17 GC and was developed specifically for the installation and hook-up of thin-walled pipes.



Orbital welding plays an important role in the semiconductor industry. High demands are placed on welding work in this industry. With the Laboratory Package, automated tube welding is possible anytime and anywhere. The required precision, reliability and high quality of the weld seams can be easily achieved.

Laboratory Package

The Laboratory Package includes the Mobile Welder and the ORBIWELD 17 GC welding head. The Mobile Welder (see page 13) is a portable orbital welding power source that has been specially developed for modern pipeline construction. It has a lightweight and compact design and impresses with its simple and intuitive operation. The enclosed, gas-cooled ORBIWELD 17 GC welding head (see page 36) is particularly suitable for small pipe dimensions in the range 3.0 - 17.2 mm (0.118" - 0.677"). The welding head

impresses with its extremely narrow design and can be used particularly in confined spaces, as is common in the semiconductor industry. The OW 17 GC has a removable clamping cassette that can be easily positioned around the tubes to be welded during inline assembly on the construction site as well as in the prefabrication of modules in the workshop. The welding head is also equipped with an integrated control panel for controlling the power source.

All for one price

The Laboratory Package offers a price advantage over the individual components and makes getting started with orbital welding particularly attractive.

OPTIONAL: Documentation

The Mobile Welder's range of functions can be expanded at any time via upgrade options. Especially in the semiconductor industry, it makes sense to activate software upgrades in order to have a wide range of smart functions available, such as welding

data logging and digital welding gas management. Comprehensive documentation is crucial for checking and ensuring compliance with quality standards. It also provides traceability of materials, welding parameters and other relevant information to ensure weld seam quality.

Get started now with the Laboratory Package. Weld high-quality pipe joints simply and easily, anytime and anywhere. With optional upgrade options, the Mobile Welder is able to grow with the challenges at any time.



Mobile Welder

Formely and practical case with carrying handle and shoulder strap.



Mico weld head OW 17 GC with clamping cassette

Interface
orbital weldingInterface
manual weldingMW gas-cooled manual TIG torch
with 6 m hose package (optional)

Clamping cassette OW 17 (not included in the scope of delivery)

Laboratory Package




Mobile Welder + Orbiweld 17 (GC)

ITEM	COMPONENTS	CODE
Laboratory Package	Mobile Welder + micro weld head OW 17 GC	854 001 005

SCOPE OF DELIVERY	LABORATORY PACKAGE	
Mobile Welder	●	• 1 micro weld head ORBIWELD 17 GC ●
Shoulder strap MW	●	• 1 transport box ●
Power cable DE	●	• 1 tool set ●
Hose connection set	●	• 1 safety clamp hose assembly ●
Quick Start Guide	●	• 1 electrode distance gage ●
General safety instructions welding power sources	●	• 1 General safety instructions ●
Calibration certificate	●	• Operating instructions and spare parts list (PDF) ●

For detailed information on Mobile Welder, see page 12 and on OW 17 GC, see page 34

Available upgrade options:

-  ORBICOOL MW (Code 854 030 301)
-  Software MW+ (Code 854 030 302)
-  Connectivity LAN/IoT/VNC* (Code 850 080 001)

*Requires upgrade option software MW+.

Detailed information on our upgrade options can be found on our home page at

<https://www.orbitalum.com/en/products/product-details/mobile-welder.html>



Suitable accessories (optionally available):

- Clamping cassette OW 17, see page 36
- Gas-cooled TIG manual torch MW, see page 109
- Upgrade options
- Bar code/QR code scanner, see page 26
- Double pressure reducer, see page 108
- Hose assembly extensions, see page 108
- ORBIPURGE Forming set, see page 107
- ORBmax residual oxygen meter, see page 104
- Ground cable, see page 107
- Electrode grinders ESG, see page 100
- USB WLAN stick, see page 26

Mobile Welder OC PLUS

Consistently high quality of the welded seams independently of the point of use -

The Mobile Welder OC Plus is the first portable orbital welding power source by Orbitalum Tools which can be used in mobile as well as stationary situations. The power source is based on the established Smart Welder and convinces with its compact and rugged design.



Simple and intuitive
can be operated with minimum training and instruction requirements ✓

Portable - lightweight and ready for any tasks and any location ✓

Modular - flexible and with a wide range of applications through extendable components ✓

Future oriented connectivity
through IoT/Industry 4.0 technology (Connectivity IoT/4.0 Package 1 required) ✓

NEW.

Mobile Welder OC PLUS

The Mobile Welder OC Plus is the first portable orbital power welding source by Orbitalum Tools which has been developed specifically for tube installations. The Mobile Welder OC Plus allows the usual high and consistent quality of the orbital welding to be maintained even in work areas which are difficult to access.

Light and rugged construction

The light and rugged construction is equipped with state-of-the-art information and communications technology and is based on the strengths of our established Smart Welder.

Intuitive and easy operation

Furthermore the Mobile Welder OC Plus convinces with its easy handling and with minimum training and instruction requirements. The Mobile Welder OC Plus is based on the same software platform as our Smart Welder. This allows immediate transition of trained person-

nel and furthermore makes seamless program exchange between the machines possible.

Cooling unit ORBICOOL MW

The Mobile Welder OC Plus is delivered together with the cooling unit ORBICOOL MW which is connected with just a few simple steps and thus can be used in mobile and stationary situations in manufacturing with the efficiency of liquid-cooled weld heads.

When using gas-cooled weld heads the cooling unit can be removed to reduce the weight of the machine and to increase mobility.

Manual TIG welding

The usage of a "Manual welding mode" is also possible in combination with a TIG manual torch thus extending the application possibilities in order to perform flexible tacking work and to easily produce manual welding connections with orbital weld heads at inaccessible parts -

one power source for all challenges in modern tube installation.



Mobile Welder OC PLUS
Front and rear view



Elegant and practical housing with carrier handle and shoulder strap.

Mobile Welder OC PLUS



The liquid cooling system keeps connected weld heads and heads constantly at the right temperature.



Hinged protective cover for display and control elements.



Interface
Orbital welding



Interface
Manual welding



Gas-cooled TIG manual torch
with 6 m hose package (optional)

Orbital welding power supply

Mobile Welder OC PLUS

Properties, application area, technical specifications and delivery scope, see from page 8.

ITEM	VERSION	CODE	MACHINE WEIGHT KG
Mobile Welder OC PLUS	1~ 110-230V 50/60Hz , 1-phase	854 000 011	21,00

WELDING POWER SOURCE	MOBILE WELDER OC PLUS
CODE	854 000 011
TECHNICAL SPECIFICATIONS	
Control range	5 - 180 A
Welding current type	DC
Duty cycle	60% - 180 A 100% - 140 A
Supply voltage (Supply voltage > 160 V)	1~ 110-230 V 50/60 Hz
Weight	20.9 kg*
Dimensions (WxDxH)	273 x 546 x 513 mm (10.8 x 21.5 x 20.2 in)
IP standard	IP23S
Screen size	7 "
Touch	●
Soft keys	●
Rotary knob	●
Gas flow sensor	●
Cooling liquid sensor	●**
USB ports	2
LAN	●
Internal printer	Thermal

LIQUID COOLING UNIT	ORBICOOL MW
TECHNICAL SPECIFICATIONS	
Compatibility	Mobile Welder
Supply voltage	24 V DC
Weight*	5.5 kg
Dimensions (WxDxH)	273 x 539 x 149 mm (10.8 x 21.2 x 5.9 in)
IP standard	IP23S
Cooling type	Recirculation cooler
Max. pump pressure	7.5 bar
Max. feed rate	0.9 l/min
Tank volume	2.1 L
Flow sensor	●
Temperature sensor	●

SCOPE OF DELIVERY	MOBILE WELDER OC PLUS
ORBICOOL MW	●
Connection line MW-OCMW	●
Cooling liquid OCL-30 3.5 l/118.3 fl oz	●
Shoulder strap MW	●
Power cable DE	●
Hose connection set	●
Quick Start Guide	●
General safety instructions welding power sources	●
Calibration certificate	●

FURTHER FEATURES	MOBILE WELDER OC PLUS
Wide Range input power range	●
Cooling liquid and welding gas monitoring	●
Fully digital welding gas management	●
Auto programming	●
Welding data logging	●
Multi lingual	●
Metric and imperial measuring units	●
User levels	●
Access control	●
LAN/IoT/VNC Ready	●

Technical specifications are non-binding.
They do not constitute any assurance of properties.


* = Without tank capacity (2.1 L)

** = ORBICOOL MW

Suitable accessories (optionally available):

- Gas-cooled TIG manual torch MW, see page 109
- Connectivity upgrade LAN/IoT/VNC, see page 23
- Bar code/QR code scanner, see page 26
- ORBmax residual oxygen meter, see page 104
- Double pressure reducer, see page 108
- Ground cable, see page 107
- USB WLAN stick, see page 26

Available upgrade options:

-  Connectivity LAN/IoT/VNC (850 080 001)*

*Requires upgrade option software MW+.

Detailed information on our upgrade options can be found on our home page at

<https://www.orbitalum.com/de/produkt/mobile-welder.html>



SW orbital welding power sources

Intelligent welding power sources

More quality and flexibility through Industry 4.0 technology during orbital welding: This intelligent power source connects the orbital welding process with state-of-the-art information and communication technology, and makes for the best welding results, high efficiency and sustainable quality management.

The Smart Welder (here with weld head ORBIWELD 76S) – an innovative welding power supply, which sets new standards in the matter of welding result, handling and communication



Future-oriented connectivity through IoT-/Industry 4.0 technology (Connectivity IoT/4.0 Package 1 required)



Longer-term welding data documentation thanks to centralized data storage



100% data storage - available at any time and at any place



Cost-saving through digital and precise "PERMANENT-GAS" welding gas control



Intuitive and easy operation via 12,4" color touch display or rotary knob



Auto programming via entry of pipe diameter, wall thickness, material and weld gas



Integrated liquid cooling for constantly low weld head temperatures



The SW orbital welding power supplies combines the known and successful characteristics of the predecessor models with the newest technical innovations:

Centralized access to projects and parameters

With the integrated LAN interface the SW power sources can be integrated into the network: All welding data and programs for each individual welding process can be called up and documented in full, analyzed and used and optimized for future welding processes. This way, production sequences can be planned better and are also safer and less time-consuming.

Intuitive operation and a multilingual menu interface

The SW power sources are operated using the 12.4" color touch display screen, or alternatively with the multifunctional rotary knob. The multilingual menu interface with graphic support makes operation and

parametrization of the welding power supply simple and intuitive. Soft keys provide direct access to important commands.

More quality

The SW power sources achieve more quality thanks to the digital and precise welding gas control, the "PERMANENT-GAS" function. It makes it possible to perform welding processes with the highest level of purity and a low gas requirement, reducing the costs for each welding process. The gas quantity values saved with the welding program thus make for easily reproducible welding results.

Shorter welding cycles and more productivity

In order to minimize the gas pre-flow and post-flow times, ORBITALUM has incorporated the unique Flow-Force function. It shortens the welding process considerably when using closed weld heads: The digital gas control supplies protective gas at a very high volumetric flow rate directly from the pressure

reducer to the weld head - the unwanted residual oxygen is flushed out abruptly in the process. The resultant reduced pre-flow and post-flow times make for much shorter processing times and thus a higher level of productivity and an increased duty cycle. The high volumetric flow rate in the post-flow time and the optionally activatable cooling circuit delay reduce the temperature of the weld head - ideal for a high duty cycle. The benefits include a longer service life for the welding electrode. The optionally activatable permanent gas function prevents the penetration of oxygen in the weld head, even during secondary processing times. As a result, the system achieves almost completely oxidation-free seams with simultaneously short processing times.



Elegant and practical housing (IP23) with carrier handles integrated at the side



* The integrated liquid cooling system keeps connected weld heads constantly at the right temperature



Hinged lid with display protects the control elements, the system printer and the rotary knob

Elegant housing for good handling

The SW power supplies feature an elegant as well as practical housing with carrier handles integrated at the side. The ports on the front of the device are set back for protection from mechanical damage. The hinged lid with display screen, when closed, protects the operating controls, the system printer and the control dial if the device is offline or is being transported.

*The Smart Welder operates with a wide input voltage range of 110 V to 230 V AC 50/60 Hz, and offsets mains fluctuations of 90 V to 260 V AC. At 180 A, the output welding current is suitable for most applications.

The power supply automatically detects and includes the connected system components. The integrated liquid cooling system keeps connected weld heads and heads constantly at the right temperature.

Upgradeable with "LAN/IoT/VNC connectivity UPGRADE"

The optionally available "Connectivity Package" allows saving and calling up of welding programs via a central network storage location. To increase the process security of the documentation the log files can be stored centrally.

Detailed information on "Connectivity package" starting on page 23.

TECHNICAL SPECIFICATIONS	SMART WELDER
ORBIMAT 180 SW	Code 850 000 001
LAN/IoT/VNC connectivity UPGRADE	Code 850 080 001
Supply voltage	1~ 110 - 230 V, 50/60 Hz
Control range (Supply voltage > 160 V)	5 - 180 A
Duty cycle	60 % at 180 A 100 % at 160 A
Dimensions	600 x 400 x 310 mm 23.6 x 15.7 x 12.2 in
Weight	26.0 kg 57.32 lbs
SCOPE OF DELIVERY	SMART WELDER
Orbital welding power supply ORBIMAT 180 SW	1 PIECE
Hose connection set ORBIMAT	1 PIECE
External keyboard	1 PIECE
Dummy plug for remote control socket	1 PIECE
3.5 liter OCL-30 cooling liquid	1 canister
Operating instructions with calibration certificate	1 set
Quick Start guide	1 PIECE

TECHNICAL SPECIFICATIONS	ORBIMAT 300 SW
ORBIMAT 300 SW	Code 852 000 001
Connectivity UPGRADE LAN/IOT/VNC	Code 850 080 001
Supply voltage	3~ 400 - 480 V, 50/60 Hz
Control range (Supply voltage > 160 V)	5 - 300 A
Duty cycle	40 % at 300 A 60 % at 260 A 100 % at 220 A
Dimensions	600 x 400 x 480 mm 23.6 x 15.7 x 18.9 in
Weight	35,40 kg 78.04 lbs
SCOPE OF DELIVERY	ORBIMAT 300 SW
Orbital welding power supply ORBIMAT300 SW	1 PIECE
Hose connection set ORBIMAT	1 PIECE
External keyboard	1 PIECE
Dummy plug for remote control socket	1 PIECE
Operating instructions with calibration certificate	1 set

Technical specifications are non-binding.
They do not constitute any assurance of properties.

* Only ORBIMAT 180 SW



SW orbital welding power sources

Smart Welder

Properties, application area, technical specifications and delivery scope, see from page 8.


ITEM	VERSION	CODE	MACHINE WEIGHT KG
ORBIMAT 180 SW*	1 ~ 110 - 230 V 50/60 Hz	850 000 001	26.00

* Smart Welder with functionality "External Interface" on request.

Suitable accessories (optionally available):

- ORBICAR S, see page 24
- ORBICAR W cart with integrated liquid cooling, see page 24
- Rugged transport case, see page 25
- ORBICOOL Active compressor cooling unit, see page 24
- ORBITWIN SW switching unit, see page 25
- Remote control with cable, see page 26
- Bar code/QR code scanner, see page 26
- ORBmax residual oxygen meter, see page 104
- SW manual torch, see page 110
- Double pressure reducer, see page 108
- "USB WLAN stick" on page 26

Available upgrade options:

-  Connectivity LAN/IoT/VNC (850 080 001)

Detailed information on our upgrade options can be found on our home page at

<https://www.orbitalum.com/de/produkt/mobile-welder.html>



ORBIMAT 300 SW

Properties, application area, technical specifications and delivery scope, see from page 8.

ITEM	VERSION	CODE	MACHINE WEIGHT KG
ORBIMAT 300 SW *	3 ~ 400 - 480 V, 50/60 Hz	852 000 001	35.400

* A external cooling unit is mandatory for the use of the orbital welding power source and must be ordered separately.

Suitable accessories (optionally available):

- ORBICAR W cart with integrated liquid cooling, see page 24
- ORBICOOL Active compressor cooling unit, see page 24
- ORBITWIN SW switching unit, see page 25
- Remote control with cable, see page 26
- Bar code/QR code scanner, see page 26
- ORBmax residual oxygen meter, see page 104
- SW manual torch, see page 110
- Double pressure reducer, see page 108

ORBITAL WELDING POWER SOURCES & ACCESSORIES

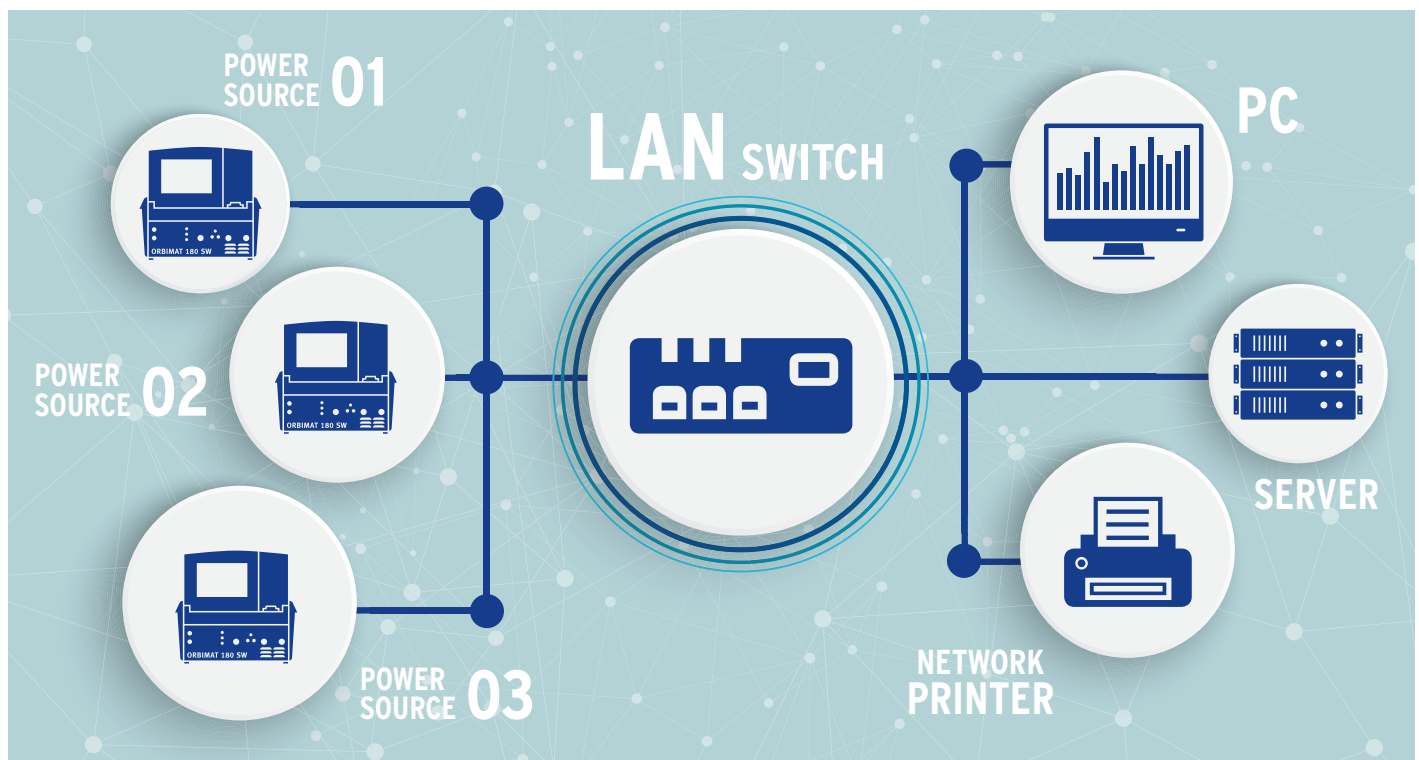
Connectivity upgrade

for SW and MW power sources

Welding parameters
in local network environments

Backing up and further processing

The optionally available connectivity upgrade enables integration of the ORBIMAT SW and MW power sources into a local network environment (LAN). Welding programs can thus be saved to centralized network storage locations and managed & backed up for the long term there. Power supplies integrated into the network can access the centrally saved programs and their folder structure at the same time. This ensures that all power supplies always have access to the latest version of the data, even if subsequent adjustments are made to programs.



The SW and MW power sources feature an extensive, user-supporting documentation solution for digitally recording documentation parameters ahead of the welding process, e.g. the material and gas batch number, isometric number, weld seam position and the welder ID.

The documentation parameters to be entered are queried before the respective start of the welding process. Whether a parameter value can or must be entered once or for each weld can be individually defined.

This entry can be made either using the virtual keyboard, an external USB keyboard or efficiently using the separately available bar code/QR code scanner. The option of documentation of the general conditions applicable for the welding programs, e.g. forming and welding gas types and volumes, elec-

trode geometries, weld head alignment and operator comments round out the documentation process.

All recorded parameters can be recorded together with the generated welding data in a welding data log and saved digitally. These welding data logs can then be saved at the network storage location automatically, backed up for the long term and edited from there.

This makes it possible to considerably reduce and simplify the documentation effort for users.

In addition to network storage locations, other network resources like network printers can also be accessed. In this way, welding logs and programs can be directly output locally via a printer over the network upon request.

Using the "Industry 4.0/IoT" data protocol "MQTT", the SW and MW power sources can be integrated into

industrial environments 4.0 and "Machine-to-Machine" (M2M) communication can be established between devices and controllers. In this way, subscribers can exchange various different telemetry data, measurement values and parameters with one another and receive control commands for automation solutions.

The connectivity upgrade is activated using a license key which can be entered directly into the power source software. In this way, all relevant functions and interfaces can be immediately activated. A separate connectivity package is required for the release of each welding power source.



ORBICAR W trolley with integrated liquidcooling

Cooling systems for Smart Welder and Power Welder

ORBICAR W cart with integrated liquid cooling

Thanks to its integrated liquid cooling function, the ORBICAR W cart is the perfect complement to Orbitalum power sources. Beside the liquid cooling, the cart is equipped with a practical holder for gas bottles. On delivery the tank already includes 8 liters (2.11 gal) of the OCL-30 cooling liquid (see page 27).

TECHNICAL SPECIFICATIONS	ORBICAR W TROLLEY
Input voltage	400 V, 50 Hz, 3-phase
Rated output	450 VA
Cooling type	Circulation cooling
Tank volume	8 l/2.11 gal
Water pressure max.	3.1 bar / 45 PSI
Dimensions (LxDxH)	96 x 54 x 113 cm / 37.8 x 21.3 x 44.5 in
Dimensions storage area (LxDxH)	65 x 38 x 65 cm / 26.6 x 15 x 26.6 in

ITEM	SUITABLE FOR	CODE	KG
ORBICAR W 300 trolley	Power Welder	884 000 002	58.200
ORBICAR W 180 trolley	Smart Welder	884 000 005	58.200

* ORBIMAT 165 power source must be modified in the factory.

ORBICOOL Active

Very efficient compressor cooling device. Particularly suitable for welding units in series production.

Including:

- Stainless steel housing
- Adjustable digital thermostat with temperature hysteresis
- Low-noise
- Metal filter cell
- Water level indicator
- Pump protection
- Flow rate monitoring in combination with ORBIMAT and Smart Welder welding power supplies

2 canisters each 3.5 liters (0.92 gal) are included in the scope of delivery of the OCL-30 cooling liquid (see page 27). Suitable for all* ORBIMAT and Smart Welder orbital welding power supplies. Not usable in combination with the ORBICAR S trolley.



ORBICOOL Active (front view)



ORBICOOL Active (rear view)

TECHNICAL SPECIFICATIONS	ORBICOOL ACTIVE
Cooling (at ambient temp. +32 °C/water +20 °C)	1.025 kW / 1.37 hp
Setting range inlet temperature	18 - 25 °C
Input voltage	230 V, 50 Hz
Connected load (at ambient temp. +42 °C/water +20 °C)	900 W / 1.21 hp
Maximum current consumption (depending on the design)	4.6 A
Tank volume	6 l/1.59 gal
Water pressure max.	2.2 bar
Pump output	2.3 l/min
Air output	800 m³/h
Sound pressure	65 dB(A)
Cooling type	Compressor cooling
Dimensions (LxDxH)	560 x 475 x 355 mm / 22.0 x 18.7 x 14.0 in

ITEM	VERSION	CODE	KG
ORBICOOL Active for ORBIMAT 300	230 V, 50 Hz	889 000 012	42.000
ORBICOOL Active for ORBIMAT 180 SW	230 V, 50 Hz	889 000 015	42.000

Other accessories for ORBIMAT and Smart Welder

Welding current connection adapter set

See page 109.



Welding current connection adapter set

ORBITWIN SW Switching Unit

To increase productivity, the ORBITWIN Switching Unit is available which allows the alternately operation with 2 weld heads on the ORBIMAT/Smart Welder. By pressing the respective Start button of the used weld head the previously assigned program is called up from the memory. The respective weld head which is not being used is locked and can be prepared for the next welding task in advance.

Incl. all connecting lines and hoses.



ORBITWIN SW Switching Unit

ITEM	SUITABLE FOR	CODE	KG
ORBITWIN SW Switching Unit	Smart Welder	853 000 001	15.00

ORBICAR S cart

The ORBICAR S is a practical cart with shelf and fastening possibility for a gas bottle and the ideal supplement for the Smart Welder power sources.

Not usable in combination with ORBICOOL Active compressor cooling unit.



ORBICAR S carriage

TECHNICAL SPECIFICATIONS	ORBICAR S CARRIAGE
Dimensions (LxDxH)	96 x 54 x 113 cm/37.8 x 21.3 x 44.5"
Dimensions storage area (LxDxH)	65 x 38 x 65 cm/26.6 x 15 x 26.6"

ITEM	CODE	KG
ORBICAR S carriage	884 000 001	19.100

Rugged transport case

With roles. Protects the power source during transport. Ideal for construction site usage.

ITEM	SUITABLE FOR	CODE	KG
180 SW transport case	Smart Welder	850 030 020	18.700



Smart Welder transport case



USB WLAN stick

USB WLAN stick

The USB WLAN stick can be used to wirelessly connect a power source from the Smart Welder or Mobile Welder series to a network.

- Requires software version 2.4.0 or higher

ARTIKEL	CODE	KG
USB WLAN stick, ORBITALUM	850 030 015	0,008



Remote control with cable

Remote control with cable

Suitable for all Power Welder/Smart Welder orbital welding power supplies. It is not required when working with enclosed orbital weld heads.

ITEM	CABLE LENGTH [M]	CABLE LENGTH [INCH]	CODE	KG
Remote control with cable	7.5	24.6	875 050 001	1.350



Bar code/QR code scanner

Bar code/QR code scanner

Compatible with the Smart Welder and MW power sources.
For welding data documentation or recording.
Rapid scanning in of the parameters stored in the bar code/QR code (e.g. weld seam number, isometry number, welder ID, etc.) into the power source.

ITEM	CODE	KG
Bar code/QR code scanner	850 030 005	0.250

Consumables for ORBIMAT, Smart Welder and Mobile Welder

Replacement paper rolls and ribbon cartridges

For internal system printer.

1 paper roll and 1 ribbon cartridge (only SW) are already included in the scope of delivery of the ORBIMAT/Smart Welder power sources.

ITEM	CODE	KG
Panel printer paper rolls CA/SW, 3-pack	875 050 017	0.150
Panel printer ink ribbon cartridge CA/SW	875 030 004	0.010
Panel printer paper rolls MW, 3-pack	854 030 001	0.150



Replacement paper rolls and ribbon cartridges

OCL-30 cooling liquid

Anti-freeze pre-mix for ORBIMAT/Smart Welder/Mobile Welder power sources and cooling units to prevent the cooling water from freezing. Protects up to -30 °C (-22 °F) outside temperature. Increased service life of components of the cooling system through very high corrosion protection and high pH-value. Excellent ignition characteristics due to low conductivity. Clear cooling liquid.

Usable with ORBICAR W, Smart Welder, ORBICOOL Active and ORBICOOL MW.

ITEM	VERSION	CODE	KG
OCL-30 cooling liquid	Canister each 3.5 l (0.92 gal)	850 030 010	3.715



OCL-30 cooling liquid

Hose connection set ORBIMAT/Smart Welder/Mobile Welder

1 connection set is already included in the scope of delivery of the ORBIMAT/Smart Welder/Mobile Welder power sources.

Consisting of every hose and connection piece required for operation.

ITEM	CODE	KG
Hose connection set SW	875 030 018	0.445
Hose connection set MW	854 030 003	

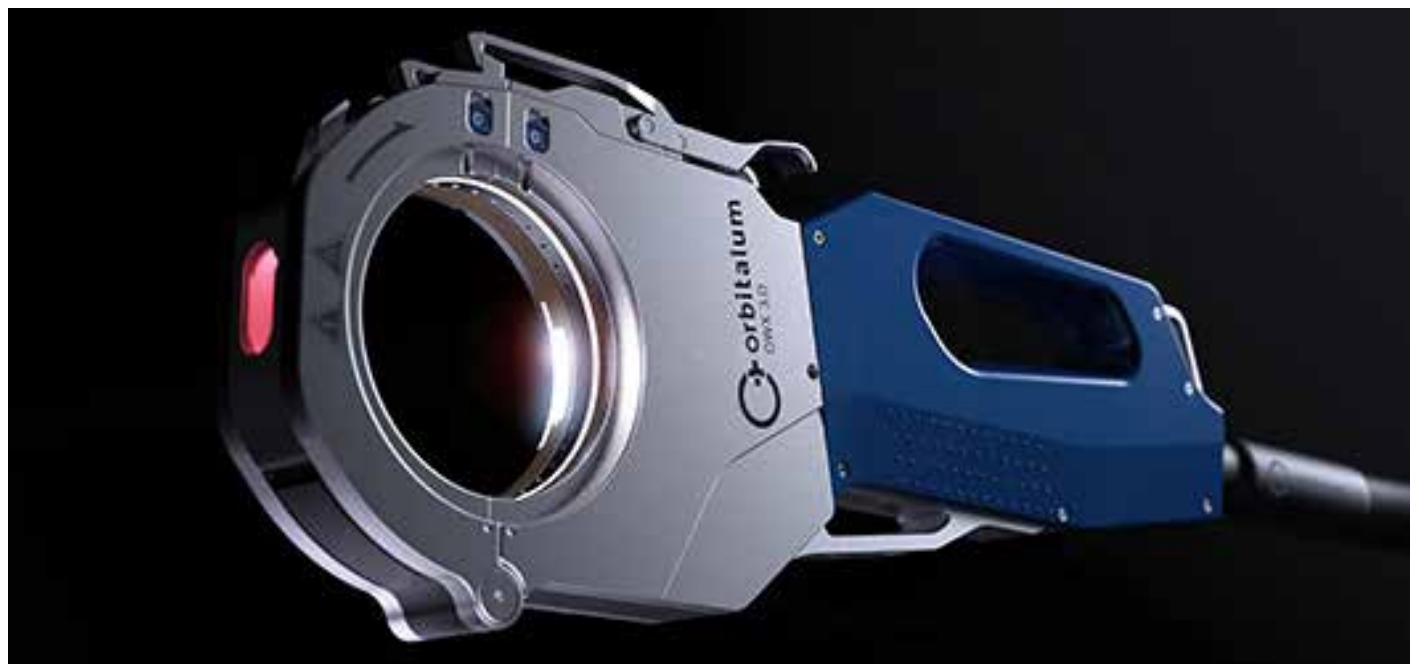


Hose connection set ORBIMAT

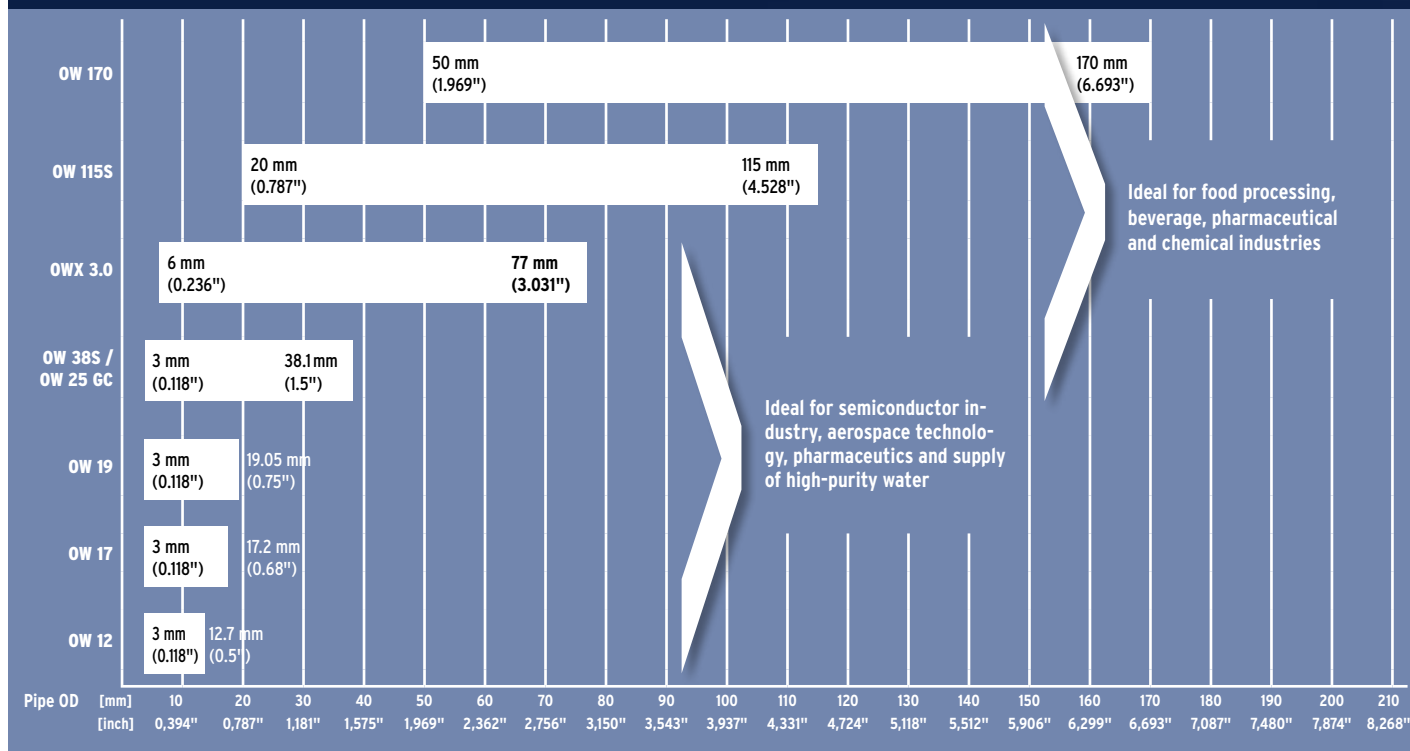
Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- ORBIPURGE forming set, see page 107
- Double pressure reducer, see page 108
- WS2 tungsten electrodes, see page 108
- TIG manual torch for ORBIMAT/Smart Welder, see page 110
- Welding current connection adapter set, see page 109

Closed orbital weld heads



Overview of closed orbital weld heads



Electrode lengths/Ø for closed orbital weld heads

WELD HEAD ►		OW 12		OW 17		OW 19		OW 38S		OW 76S/OWX 3.0		OW 115S		OW 170	
ROTOR Ø ►		40.0 MM/1.575"		51.2 MM/2.016"		55.0 MM/2.165"		79.0 MM/3.110"		116.4 MM/4.583"		180.2 MM/7.094"		245.6 MM/9.669"	
PIPE Ø ▼															
[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]
3.17	0.125	13.90	0.547	19.52	0.768	21.40	0.843	33.40	1.315						
6.00	0.236	12.50	0.492	18.10	0.713	20.00	0.787	32.00	1.260	50.70	1.996				
6.35	0.250	12.30	0.484	17.93	0.706	19.80	0.780	31.80	1.252	50.50	1.988				
8.00	0.315	11.50	0.453	17.10	0.673	19.00	0.748	31.00	1.220	49.70	1.957				
9.53	0.375	10.70	0.421	16.34	0.643	18.20	0.717	30.20	1.189	48.90	1.925				
10.00	0.394	10.50	0.413	16.10	0.634	18.00	0.709	30.00	1.181	48.70	1.917				
10.20	0.402	10.40	0.409	16.00	0.630	17.90	0.705	29.90	1.177	48.60	1.913				
12.00	0.472	9.50	0.374	15.10	0.594	17.00	0.669	29.00	1.142	47.70	1.878				
12.70	0.500	9.20	0.362	14.75	0.581	16.70	0.657	28.60	1.126	47.30	1.862				
13.00	0.512			14.60	0.575	16.50	0.650	28.50	1.122	47.20	1.858				
13.50	0.531			14.35	0.565	16.30	0.642	28.20	1.110	46.90	1.846				
15.88	0.625			13.16	0.518	15.10	0.594	27.00	1.063	45.70	1.799				
16.00	0.630			13.10	0.516	15.00	0.591	27.00	1.063	45.70	1.799				
17.20	0.677			12.50	0.492	14.40	0.567	26.40	1.039	45.10	1.776				
18.00	0.709					14.00	0.551	26.00	1.024	44.70	1.760				
19.00	0.748					13.50	0.531	25.50	1.004	44.20	1.740				
19.05	0.750					13.50	0.531	25.40	1.000	44.20	1.740				
20.00	0.787							25.00	0.984	43.70	1.720	75.60	2.976		
21.30	0.839							24.30	0.957	43.00	1.693	75.00	2.953		
22.00	0.866							24.00	0.945	42.70	1.681	74.60	2.937		
23.00	0.906							23.50	0.925	42.20	1.661	74.10	2.917		
25.40	1.000							22.30	0.878	41.00	1.614	72.90	2.870		
26.90	1.059							21.50	0.846	40.20	1.583	72.20	2.843		
28.00	1.102							21.00	0.827	39.70	1.563	71.60	2.819		
29.00	1.142							20.50	0.807	39.20	1.543	71.10	2.799		
30.00	1.181							20.00	0.787	38.70	1.524	70.60	2.780		
31.75	1.250							19.10	0.752	37.80	1.488	69.70	2.744		
33.70	1.327							18.10	0.713	36.80	1.449	68.80	2.709		
35.00	1.378							17.50	0.689	36.20	1.425	68.10	2.681		
38.10	1.500							15.90	0.626	34.60	1.362	66.60	2.622		
40.00	1.575									33.70	1.327	65.60	2.583		
41.00	1.614									33.20	1.307	65.10	2.563		
42.40	1.669									32.50	1.280	64.40	2.535		
44.50	1.752									31.40	1.236	63.40	2.496		
48.30	1.902									29.50	1.161	61.50	2.421		
50.80	2.000									28.30	1.114	60.20	2.370	92.90	3.657
51.00	2.008									28.20	1.110	60.10	2.366	92.80	3.654
52.00	2.047									27.70	1.091	59.60	2.346	92.30	3.634
53.00	2.087									27.20	1.071	59.10	2.327	91.80	3.614
54.00	2.126									26.70	1.051	58.60	2.307	91.30	3.594
60.30	2.374									23.50	0.925	55.50	2.185	88.20	3.472
63.50	2.500									21.90	0.862	53.90	2.122	86.60	3.409
70.00	2.756									18.70	0.736	50.60	1.992	83.30	3.280
76.10	2.996									15.60	0.614	47.60	1.874	80.30	3.161
76.20	3.000									15.60	0.614	47.50	1.870	80.20	3.157
85.00	3.346											43.10	1.697	75.80	2.984
88.90	3.500											41.20	1.622	73.90	2.909
101.60	4.000											34.80	1.370	67.50	2.657
104.00	4.094											33.60	1.323	66.30	2.610
108.00	4.252											31.60	1.244	64.30	2.531
114.30	4.500											28.50	1.122	61.20	2.409
127.00	5.000													54.80	2.157
129.00	5.079													53.80	2.118
139.70	5.500													48.50	1.909
152.40	6.000													42.10	1.657
154.00	6.063													41.30	1.626
163.00	6.417													36.80	1.449
165.10	6.500													35.80	1.409
168.30	6.626													34.20	1.346

FORMULA:

Electrode length =

$\frac{\text{Rotor } \varnothing - \text{Hose } \varnothing}{2}$

- Electrode gap
(as a rule 1.5 mm)

- 3

ORBIWELD 12

Compact TIG weld head
- ideal for tight spaces

Micro weld head

It doesn't get any smaller or more effective than this: Thanks to its extremely narrow construction the OW 12 offers a unique diversity of functions as well as a high duty cycle previously unknown in weld heads of this size through its liquid cooling. This micro weld head is a compact space-saving marvel and guarantees continually reproducible, high-quality weld seams, even with high currents. Ideal for welding all common micro fittings!

Small-sized modules – base machine, clamping cartridges and clamping inserts – specially for applications in very tight spaces



Extremely narrow design and still highly resilient through intensive liquid cooling



Removable clamping cartridges for exact aligning of the parts to be welded

The OW 12 with its small-sized modules – basic machine, clamping cartridges and clamping inserts – is the ideal tool for work under tight spaces such as in the semi-conductor industry, aerospace technology, pharmaceuticals and supply of high-purity water.

With a control panel integrated in the robust and stable aluminum handle of the weld head, all commands which are important for the welding process can be transferred to the power source so that no additional remote control is required.

Removable clamping cartridges allow exact aligning of the parts to be welded, even under tight spaces.

FURTHER PROPERTIES:

- Toolless quick change system for clamping cartridges and clamping inserts
- Wide clamping cartridges (Type "B") with changeable clamping inserts for standard applications
- Extremely narrow clamping cartridge (Type "A") for welding of micro fittings and for other applications with very limited clamping lengths
- The head is 5.7 kg (12.6 lbs) light. All connections for electricity, gas and cooling water are firmly integrated in the OW 12
- To increase productivity, the optional ORBITWIN switching unit allows working with up to two heads in an alternating fashion, thus reducing conversion times and downtimes considerably
- Including highly flexible hose package (length: 7.5 m/24.6 ft) with strain relief to the power source – optionally extendable to up to 20.0 m (64 ft)

The OW 12 success model has been optimized!

The result: A well-engineered weld head with unequalled robustness, high ease of use and even higher performance, for example through:

- ✓ Higher temperature stability
- ✓ Improved ignition characteristics
- ✓ Optimized rotor guidance
- ✓ Optimized weld gas control
- ✓ Liquid-cooled
- ✓ Integrated control panel
- ✓ 7.5 m (24.6 ft) hose package



Robust and stable aluminum handle with integrated control panel



Ideal for welding all common micro fittings



Diameter-specific clamping cartridges - available separately



Aluminum clamping inserts for OW 12, type "B" (wide) - available separately



Wide accessories program, e.g. ORBmax residual oxygen meter

SCOPE OF APPLICATION OW 12:	MICRO FITTING AT MICRO FITTING	MICRO FITTING AT HOSE	HOSE AT HOSE	ADVANTAGES:
Clamping cassettes, Type "A" (narrow)	x	x	x	High flexibility through narrow design
Clamping cassettes, Type "B" (wide)			x	Low costs through exchangeable cartridges

APPLICATION AREA	ORBIWELD 12
Code	821 000 010
Tube OD, min. - max.	3.0 - 12.7 mm 0.118 "- 0.500"
Electrode diameter	1.0 mm 0.039"
Machine weight including hose package	4.8 kg 10.6 lbs
Hose package length	7.5 m 24.6 ft
SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 micro weld head ORBIWELD 12 • 1 transport case • 1 tool set • 1 feeler gauge • 1 General safety instructions • Operating instructions and spare parts list (PDF)
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping cassettes for OW 12, Type "A" (small) • Clamping cassette for OW 12, Type "B" (wide) • Clamping inserts for OW 12, Type "B" (wide) • Table mount • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • WS2 tungsten electrodes

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

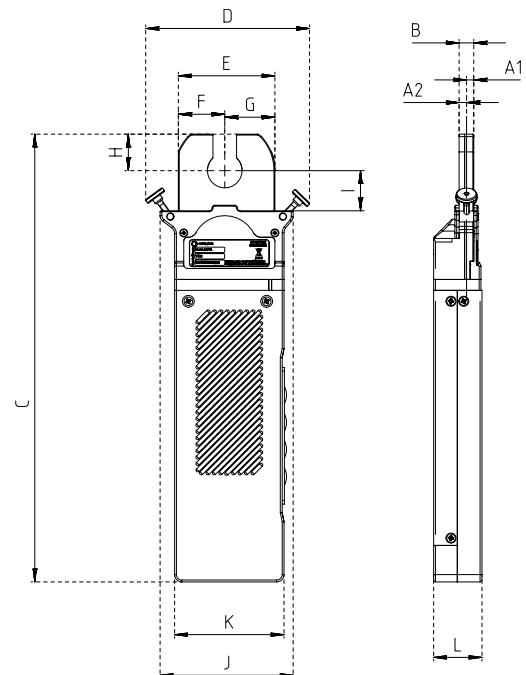


ORBIWELD 12
with narrow clamping cassette
(Type "A")



ORBIWELD 12
with wide clamping cassette
(Type "B")

DIMENSIONS			ELECTRODE GAP			
ORBIWELD 12	DIMENSION		CASSETTE TYPE "A"		CASSETTE TYPE "B"	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	4.25	0.167	6.35	0.250	15.60	0.614
Dimension "A2"	3.75	0.148	5.85	0.230	15.10	0.594
Dimension "B"	8.00	0.315	12.20	0.480	30.70	1.209
Dimension "C"	245.70	9.673				
Dimension "D"	90.00	3.543				
Dimension "E"	53.00	2.087				
Dimension "F"	25.50	1.004				
Dimension "G"	27.50	1.083				
Dimension "H"	20.00	0.787				
Dimension "I"	22.00	0.866				
Dimension "J"	73.00	2.874				
Dimension "K"	60.00	2.362				
Dimension "L"	26.50	1.043				





OW 12 with narrow clamping cassette (Type "A")


OW 12 with wide clamping cassette (Type "B")
And changeable clamping inserts


Clamping cassettes for OW 12, Type "A" (small)



Clamping cassette for OW 12, Type "B" (wide)

Micro weld head OW

ORBIWELD 12

Properties, application area, technical specifications and delivery scope, see page 30.

Clamping cassettes and clamping inserts are not included in the scope of delivery (see from page 32).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 12	821 000 010	4.800	11.000

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping cassettes for OW 12, Type "A" (narrow), see page 32
- Clamping cassette for OW 12, Type "B" (wide), see page 32
- Welding current connection adapter set, see page 109

Clamping cassettes for OW 12, Type "A" (narrow)

Made of stainless steel with folding cover "FlipCover" - allows control and, if necessary, readjustment of the electrode position before welding. For welding of micro fittings and other applications with very limited clamping lengths, clamping cartridges with an overall width of only 12.2 mm (0.48") can be supplied (Type "A"). A separate clamping cassette is required for each hose diameter for Type "A".

ITEM	TUBE OD [MM]	TUBE OD [INCH]	CODE	KG
Clamping cassette VA for OW 12, Type "A" (narrow), V3	3.00	0.118	821 050 201	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	3.18	0.125	821 050 202	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	6.00	0.236	821 050 203	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	6.35	0.250	821 050 204	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	8.00	0.315	821 050 205	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	9.53	0.375	821 050 206	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	10.00	0.394	821 050 207	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	12.00	0.472	821 050 208	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	12.70	0.500	821 050 209	0.100

Clamping cassette for OW 12, Type "B" (wide)

When using clamping cassette Type "B", an additional clamping insert, Type "B" (wide) is required for each hose diameter.

ITEM	CODE	KG
Clamping cassette for OW 12, Type "B" (wide)	821 050 002	0.095

CLOSED ORBITAL WELD HEADS

Clamping inserts for OW 12, Type "B" (wide)

Made of aluminum. Can only be used if the Type "B" clamping cartridge is used.
A clamping insert consists of 4 individual parts (2 inserts per side).



Clamping inserts for OW 12, Type "B" (wide), 4-part

ITEM	TUBE OD [MM]	TUBE OD [INCH]	CODE	KG
Clamping insert for OW 12, Type "B" (wide), 4-part	3.00	0.118	821 002 220	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	3.18	0.125	821 002 222	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	4.00	0.157	821 002 224	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	6.00	0.236	821 002 228	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	6.35	0.250	821 002 229	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	7.00	0.276	821 002 230	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	7.94	0.313	821 002 232	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	8.00	0.315	821 002 233	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	9.00	0.354	821 002 234	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	9.53	0.375	821 002 235	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	10.00	0.394	821 002 237	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	12.00	0.472	821 002 243	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	12.70	0.500	821 002 245	0.050

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

ORBIWELD 17

Micro weld head

Extremely short production cycles
thanks to integrated control elements
and active cooling

Active-cooled orbital weld head for tubes in semi-conductor production:

With its removable clamping cartridge, integrated control elements and active cooling, the ORBIWELD 17 - or OW 17, for short - clearly stands out in comparison to conventional systems from the competition. This makes it possible to weld thin tubes like those used in semi-conductor production easily, quickly, reliably and - above all - with high quality.



Compatibility with market standards enables trouble-free transitioning to the latest Orbitalum technology	✓
An extremely narrow design for use in confined spaces, such as in the semi-conductor industry	✓
Removable clamping cartridge specifically for inline assembly or prefab production of modules	✓
For small tube diameters 3.0 mm to 17.2 mm (0.118" - 0.677")	✓
COAX tube systems can be welded with wall thicknesses up to 1.62 mm (0.064")	✓
Highly resilient thanks to their integrated active liquid cooling	✓
Integrated control panel for operation of the power source	✓

Following intensive research, this orbital weld head was improved in comparison to commonly available weld heads in crucial areas so as to optimize handling, welding results and production times.

As the OW 17 is compatible with the current market standard, users can easily switch over to the new technology.

The orbital weld head is specially designed for small tube diameters from 3.0 mm to 17.2 mm (0.118" - 0.677") and wall thicknesses up to 1.62 mm (0.064") like those used in production systems from the semi-conductor industry.

The OW 17 features a removable clamping cartridge which can be very easily positioned around the tubes to be welded in inline assembly at the construction site or prefab production of modules in the workshop.

Thanks to its compact, handy design, it can be neatly positioned and perfectly aligned to the weld point, thus enabling use in confined spaces.

When the cartridge is in place, the weld head is inserted and secured in the cartridge and welding can begin. The operating elements required for starting, stopping, gas flow and electrode changes are integrated in the handle of the head. An LED informs the welder of the operating conditions, like readiness to weld and the active process. During installation work, a second operator is not required at the welding power supply, which may not be located nearby.

Integrated active liquid cooling protects the OW 17 head from overheating and enables a long operating duration and therefore shorter work cycles. With the OW 17 GC, a gas-cooled variant is also available.

The head of the OW 17 is designed for 1.0 mm (0.039") and 1.6 mm (0.063") electrodes and thus ensures a consistently high electrode service life when welding thicker walls. This orbital weld head can also be used with COAX tube systems, for example. This saves the user a second orbital weld head.

The included adjustable electrode distance gage makes it easier for the operator to set up the electrode; an insertion gage which is permanently attached to the cartridge and thus cannot be lost ensures precise positioning to the tube joint to be welded.



Rugged, compact and handy design.



Integrated control panel – this way all commands which are important for welding can be transferred, so that no additional remote control is required.



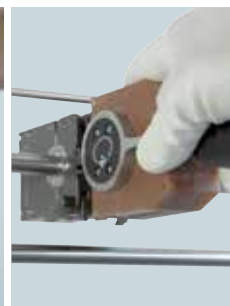
An insertion gage which is permanently attached to the clamping cartridge and thus cannot be lost ensures precise positioning to the tube joint to be welded.



Compatibility with market standards enables trouble-free transitioning to the latest Orbitalum technology.



Removable clamping cartridge, which is ideal for inline assembly at the construction site or prefabrication of modules in the workshop.



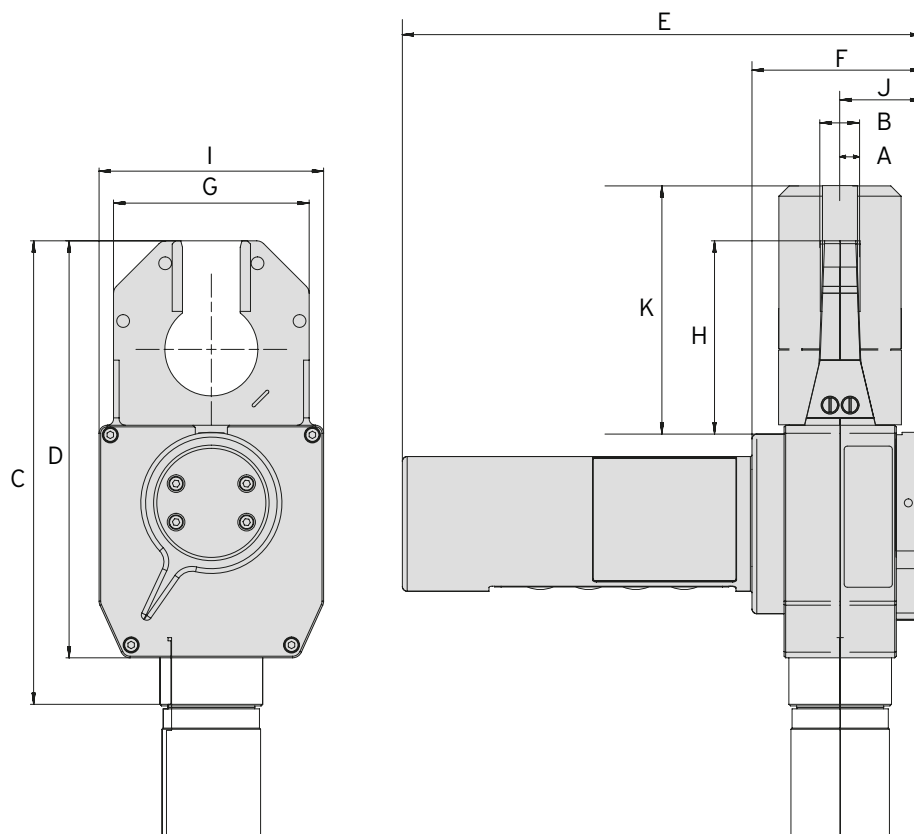
An extremely narrow design for use in confined spaces, such as in the semiconductor industry.

APPLICATION AREA	ORBIWELD 17
Code	817 000 001
Pipe OD, min. - max.	3.0 - 17.2 mm 0.118 - 0.677 in
Electrode diameter	1.0/1.6 mm 0.039 / 0.063 in
Machine weight including hose package	5.5 kg 12.1 lbs
Hose package length	7.5 m 24.6 ft
SCOPE OF DELIVERY	ORBIWELD 17
Including:	<ul style="list-style-type: none"> • 1 micro weld head ORBIWELD 17 • 1 transport case • 1 tool set • 1 safety clamp hose assembly • 1 electrode distance gage • 1 General safety instructions • Operating instructions and spare parts list (PDF)
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping cassette for OW 17 • Clamping inserts for OW 17 • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • WS2 tungsten electrodes • Application set OW17 COAX sleeve

APPLICATION AREA	ORBIWELD 17 GC
Code	817 000 002
Pipe OD, min. - max.	3.0 - 17.2 mm 0.118 - 0.677 in
Electrode diameter	1.0/1.6 mm 0.039 / 0.063 in
Machine weight including hose package	5.36 kg 11.8 lbs
Hose package length	7.5 m 24.6 ft

SCOPE OF DELIVERY	ORBIWELD 17 GC
Including:	<ul style="list-style-type: none"> • 1 micro weld head ORBIWELD 17 • 1 transport box • 1 tool set • 1 safety clamp hose assembly • 1 electrode distance gage • 1 General safety instructions • Operating instructions and spare parts list (PDF)
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping cassette for OW 17 • Clamping inserts for OW 17 • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • WS2 tungsten electrodes

DIMENSIONS	ORBIWELD 17 /ORBIWELD 17 GC	
	DIMENSION	
	[MM]	[INCH]
Dimension "A"	6,20	0.244
Dimension "B"	12,40	0.488
Dimension "C"	144,50	5.689
Dimension "D"	130,00	5.118
Dimension "E"	162,00	6.378
Dimension "F"	53,00	2.087
Dimension "G"	61,00	2.402
Dimension "H"	60,25	2.372
Dimension "I"	70,00	2.756
Dimension "J"	26,80	1.055
Dimension "K"	75,20	2.961



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We reserve the right to make changes.



ORBIWELD 17


Clamping cassette for OW 17
(clamping inserts are not included in the scope of delivery)

Micro weld head OW

ORBIWELD 17

Properties, application area, technical specifications and delivery scope, see page 34.

Clamping cassette and clamping inserts are not included in the scope of delivery.

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 17	817 000 001	5,500	13,900
Micro weld head OW 17 GC	817 000 002	5,360	9,800

* Machine weight including hose package

Clamping cassette for OW 17

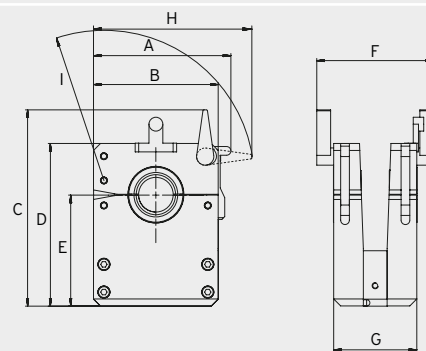
Made of stainless steel. Removable clamping cartridge specifically for inline assembly or prefab production of modules. For the mounting of clamping inserts. An insertion gage which is permanently attached to the cartridge and thus cannot be lost ensures precise positioning to the tube joint to be welded. The clamping cartridges are supplied in a rugged, lockable plastic box.

Scope of delivery:

- 1 x insertion gage for standard applications
- 1 x 3/32" hexagon wrench
- 1 x 1/16" hexagon wrench
- 1 x plastic box

Suitable clamping inserts for different tube diameters must be ordered separately.

DIMENSIONS	[MM]	[INCH]
Dimension "A"	63.00	2.480
Dimension "B"	57.20	2.252
Dimension "C"	90.00	3.543
Dimension "D"	74.60	2.937
Dimension "E"	50.90	2.004
Dimension "F"	53.60	2.110
Dimension "G"	38.10	1.500
Dimension "H"	72.60	2.858
Dimension "I"	70.00	2.756



ITEM	CODE	KG
Clamping cassette for OW 17	817 050 010	0.442

CLOSED ORBITAL WELD HEADS

Table base for clamping cartridge OW 17

The table base is designed for use with the OW 17 clamping cassette. It ensures secure fixing of large and heavy workpieces.
The spacer plate can be clamped in a vice, and the base can be mounted on a workbench.

DIMENSIONS	[MM]	[INCH]
Dimension "A"	57,20	2.250
Dimension "B"	76,20	3,000
Dimension "C"	76,20	3,000
Dimension "D"	88,90	3,500
Dimension "E"	11,20	0,440
Dimension "F"	102,00	4,000

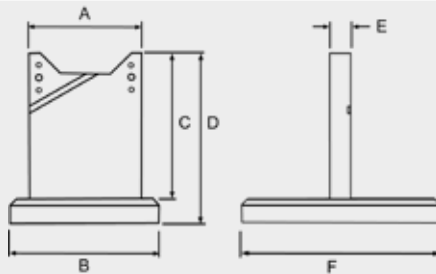


Table base for clamping cartridge OW 17

ITEM	CODE	KG
Table base, clamping cartridge OW17	817 050 020	0,268

Application set OW17 COAX sleeve for OW 17

Supplementary set for COAX double wall tube sleeve applications - fillet welds sleeve to safety tube.
For sleeve Ø 15.88mm (5/8").

- Scope of delivery:
1 x Tube center gauge for COAX sleeve applications.
1 x Clamping insert for OW17, 15.88mm/0.625"

ARTIKEL	CODE	KG
Application set OW17 COAX sleeve 15.88mm	817 060 025	

Clamping insert for safety tube must be ordered separately.



Clamping inserts for OW 17

Clamping inserts for OW 17

Made of stainless steel. Can only be used when clamping cassette OW17 as well as other common or compatible clamping cassettes are used.

1 clamping insert consists of 2 half shells.

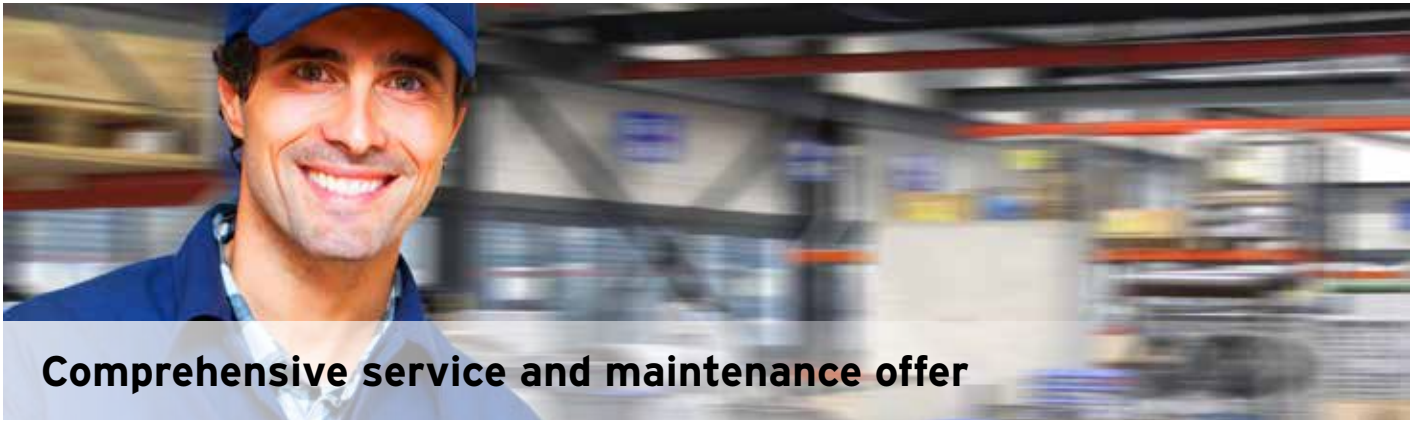
Per clamping side of the clamping cassette you require 1 clamping insert (= 2 half shells). Thus you have to use 2 clamping inserts (=4 half shells) per clamping cassette.

Further dimensions on request.

PIPE OD [MM]	PIPE OD [INCH]	CODE
3.00	0.118	817 002 209
3.18	0.125	817 002 201
4.00	0.157	817 002 210
4.76	0.188	817 002 202
5.00	0.196	817 002 211
6.00	0.236	817 002 212
6.35	0.250	817 002 203
7.94	0.313	817 002 204
8.00	0.314	817 002 213
9.00	0.354	817 002 214
9.53	0.375	817 002 205
10.00	0.393	817 002 215
11.00	0.433	817 002 216
12.00	0.472	817 002 217
12.70	0.500	817 002 206
14.00	0.551	817 002 218
14.29	0.563	817 002 207
15.00	0.590	817 002 219
15.88	0.625	817 002 208
16.00	0.629	817 002 220
17.20	0.677	817 002 221

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- ORBIPURGE forming set, see page 107
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109



Comprehensive service and maintenance offer

We not only care about your concerns before the purchase. You can rely completely on us after your purchase as well.

Our products are extremely robust and reliable.

To ensure the performance in the long run, the recommended service and maintenance intervals should be performed regularly. All service and maintenance work is performed with great care by qualified and motivated employees. They analyze your situation to find the best long-term solution.

We offer competent service via branches as well as our worldwide network of authorized partners. These are carefully selected and are regularly trained by our experts to always be up-to-date with regard to products and technologies.

Why maintenance?

"Prevention is better than cure"

Better not wait until your machine sooner or later breaks down completely because of a lack of service or maintenance! Small causes can often have large effects, and failures or malfunctions could have been avoided with timely control or maintenance.

When did you have your machine serviced the last time?
Better to arrange a meeting now:



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- Visual and functional test
- Determination and measurement technical parameters
- Discussion with customer about maintenance result
- Functional test of the system components
- Cleaning and maintenance work
- Exchange defined wear parts as well as defective components
- Implementation of modifications, in as far as this serves the technical improvements of the device
- Required adjustment and set-up tasks including calibration and new inspection

Your advantages:

- Service directly by the manufacturer or authorized partner
- Reduced downtimes
- Long-term functioning of your machines and plants
- Ensuring high availability
- Wear discovered at an early stage avoids unnecessary and expensive repairs
- Reducing the failure susceptibility
- Value preservation of your machines and plants
- Regular services ensure reliable machine operation - even after years
- Relief of in-house service employees

ORBIWELD 19

Micro weld head
with additional advantages

Micro weld head

Small, robust and efficient: The OW 19 is the perfect tool when the task involves connections of ultra-high-purity tubes and high-performance tubes, such as are used for example in the semiconductor industry or applications in branches in which high purity and maximum performance are imperative. Even under extremely difficult conditions and in tight spaces the OW 19 produces excellent and reliable quality!

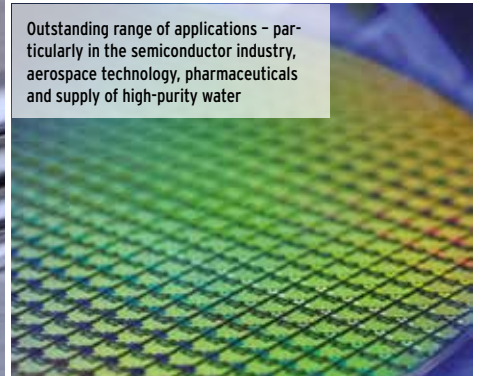
Can be used in all positions, irrespective of whether the tubes to be connected are positioned horizontally, vertically or inclined



Three-part clamping mechanism - no parts project beyond the head outline even in the opened position



Outstanding range of applications - particularly in the semiconductor industry, aerospace technology, pharmaceuticals and supply of high-purity water



Its extremely high endurance thanks to the intensive liquid cooling as well as its high-quality robust construction are characteristics which distinguish this micro weld head.

Thanks to the three-part clamping mechanism the head can be spread in very tight spaces since no parts project beyond the head outline even in the opened position. In addition an exact and offset-free alignment of the parts to be welded is ensured.

With a control panel integrated in the robust and stable aluminum handle of the weld head, all commands which are important for the welding process can be transferred to the power source so that no additional remote control is required.

All orbital welding power sources from Orbitalum automatically detect the head and its properties so that, before beginning to weld, the operator only has to call up their specified welding program and start the welding process.

The matching clamping inserts are available in narrow and broad versions and can be inserted into the weld head with just a few simple steps.

The head is 7.5 kg (16.5 lbs) light. All connections for electricity, gas and cooling water are firmly integrated in the OW 19.

To increase productivity, the optional ORBITWIN switching unit allows working with up to two heads in an alternating fashion, thus reducing conversion times and downtimes considerably.

Including highly flexible hose package (length: 7.5 m/24.6 ft) with strain relief to the power source - optionally extendable to up to 20.0 m (64 ft).

The OW 19 - with many additional advantages:

- ✓ Optimized scissors clamping system
- ✓ Flip-up weld head cover "Flip Cover"
- ✓ Optimized weld gas control
- ✓ One-hand operation
- ✓ Completely liquid-cooled
- ✓ Integrated control panel
- ✓ 7.5 m (24.6 ft) hose package



Robust and stable aluminum handle with integrated control panel



Practical clamping locks allowing single-hand operation



Simpler inserting of the electrodes by markings for \varnothing 1.0/1.6 mm (0.039"/0.063")



Folding weld head cover "FlipCover"



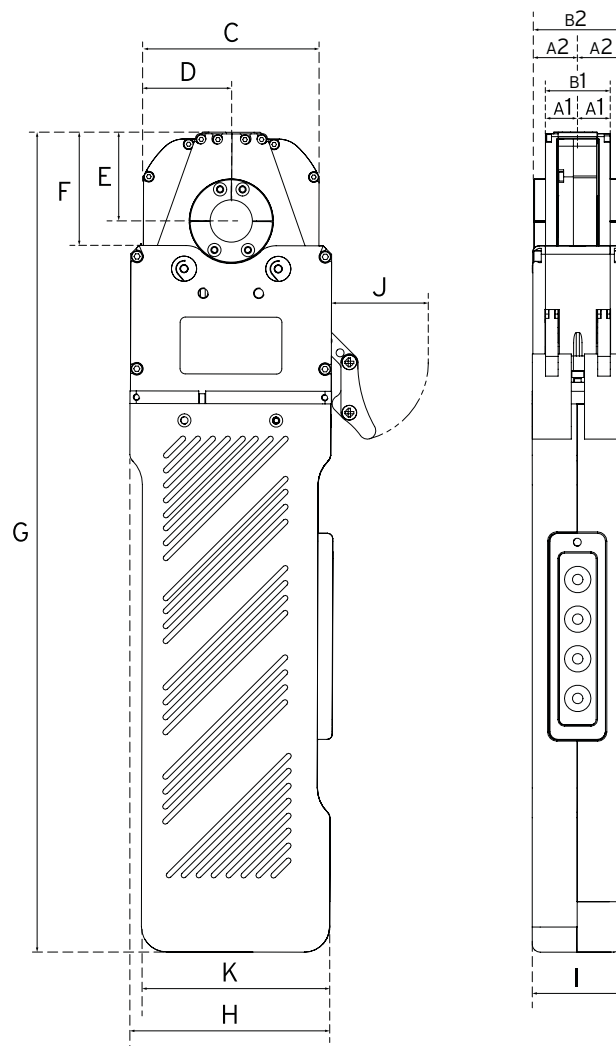
Diameter-specific clamping inserts (each 6-part, wide and narrow) available separately



Wide accessories program, e.g. ORBmax residual oxygen meter

APPLICATION AREA		ORBIWELD 19
Code		822 000 010
Pipe OD, min. - max.		3.0 - 19.05 mm 0.118 - 0.750 in
Electrode diameter		1.0/1.6 mm 0.039 / 0.063 in
Machine weight including hose package		6.5 kg 14.3 lbs
Hose package length		7.5 m 24.6 ft
SCOPE OF DELIVERY		
Including:	<ul style="list-style-type: none"> • 1 micro weld head ORBIWELD 19 • 1 transport case • 1 tool set • 1 feeler gauge • 1 General safety instructions • Operating instructions and spare parts list (PDF) 	
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping inserts for OW 19 • Conversion kit OW 19 HD • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • WS2 tungsten electrodes 	

DIMENSIONS			ELECTRODE GAP			
ORBIWELD 19	DIMENSION		CLAMPING INSERT TYPE "S"		CLAMPING INSERT TYPE "W"	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	12.00	0.472	12.00	0.472		
Dimension "A2"	17.00	0.669			17.00	0.669
Dimension "B1"	24.00	0.945	24.00	0.945		
Dimension "B2"	34.00	1.339			34.00	1.339
Dimension "C"	66.50	2.618				
Dimension "D"	33.25	1.309				
Dimension "E"	35.20	1.386				
Dimension "F"	44.50	1.752				
Dimension "G"	313.50	12.343				
Dimension "H"	76.00	2.992				
Dimension "I"	34.00	1.339				
Dimension "J"	35.00	1.378				
Dimension "K"	71.00	2.795				



Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.





ORBIWELD 19

Micro weld head OW

ORBIWELD 19

Properties, application area, technical specifications and delivery scope, see page 40.

Clamping inserts are not included in the scope of delivery (see from page 43).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 19	822 000 010	6.500	14.800

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping inserts for OW 19, see page 43
- Welding current connection adapter set, see page 109



Clamping cassette for OW 19 HD
(Clamping inserts are not included in the scope of delivery)

Conversion kit OW 19 HD

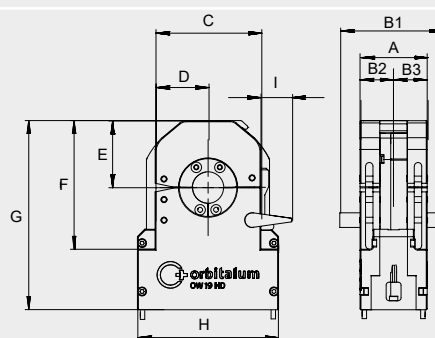
With the conversion kit, consisting of a clamping cassette and two fastening screws, the OW 19 can be quickly and easily converted to an OW 19 HD (see page 46). The clamping cassette has been specially developed for inline assembly or prefab production of modules. For holding clamping inserts. The clamping cassette is supplied in a robust, lockable plastic box.

Scope of delivery:

- 1 x hexagon wrench 2x60
- 1 x cheese head screw ISO4762-M2.5x10-A2
- 1 x installation instructions for conversion kit OW 19 HD
- 1 x type plate engraved according to specifications
- 1 x plastic box

Suitable clamping inserts for different pipe diameters must be ordered separately.

DIMENSIONS	[MM]	[INCH]
A	36,00	1.417
B1	55,20	2.173
B2	18,00	0.709
B3	18,00	0.709
C	57,20	2.252
D	28,60	1.126
E	36,00	1.417
F	69,50	2.736
G	10,20	4.016
H	76,20	3.000



ARTIKEL	CODE
Conversion kit,OW 19 HD	822 030 011

CLOSED ORBITAL WELD HEADS

Clamping inserts for OW 19

A clamping insert consists of 6 individual parts (3 inserts per side).

Type "W" (wide) for standard applications.

Type "S" (small) for applications in extremely confined spaces.



Clamping insert for OW 19 "W" (wide) 6-part



Clamping insert for OW 19 "S" (small/narrow) 6-part

ITEM	PIPE OD		TYPE "W" (WIDE)		TYPE "S" (SMALL/ NARROW)	
	[MM]	[INCH]	CODE	KG	CODE	KG
Clamping insert for OW 19, 6-part	3.00	0.118	822 002 120	0.100	822 002 320	0.044
Clamping insert for OW 19, 6-part	3.18	0.125	822 002 122	0.100	822 002 322	0.044
Clamping insert for OW 19, 6-part	3.95	0.156	822 002 123	0.099	822 002 323	0.044
Clamping insert for OW 19, 6-part	4.00	0.157	822 002 124	0.099	822 002 324	0.044
Clamping insert for OW 19, 6-part	4.78	0.188	822 002 126	0.099	822 002 326	0.043
Clamping insert for OW 19, 6-part	5.95	0.234	822 002 127	0.097	-	-
Clamping insert for OW 19, 6-part	6.00	0.236	822 002 128	0.097	822 002 328	0.043
Clamping insert for OW 19, 6-part	6.35	0.250	822 002 129	0.097	822 002 329	0.043
Clamping insert for OW 19, 6-part	7.00	0.276	822 002 130	0.096	-	-
Clamping insert for OW 19, 6-part	7.94	0.313	822 002 132	0.094	-	-
Clamping insert for OW 19, 6-part	8.00	0.315	822 002 133	0.094	822 002 333	0.042
Clamping insert for OW 19, 6-part	9.00	0.354	822 002 134	0.092	822 002 334	0.041
Clamping insert for OW 19, 6-part	9.53	0.375	822 002 135	0.091	822 002 335	0.040
Clamping insert for OW 19, 6-part	9.95	0.392	822 002 136	0.090	822 002 336	0.040
Clamping insert for OW 19, 6-part	10.00	0.394	822 002 137	0.090	822 002 337	0.040
Clamping insert for OW 19, 6-part	12.00	0.472	822 002 143	0.083	822 002 343	0.038
Clamping insert for OW 19, 6-part	12.10	0.476	-	-	822 002 344	0.038
Clamping insert for OW 19, 6-part	12.70	0.500	822 002 145	0.081	822 002 345	0.037
Clamping insert for OW 19, 6-part	13.00	0.512	822 002 146	0.080	-	-
Clamping insert for OW 19, 6-part	13.50	0.531	822 002 148	0.078	822 002 348	0.036
Clamping insert for OW 19, 6-part	14.00	0.551	822 002 150	0.076	822 002 350	0.035
Clamping insert for OW 19, 6-part	15.00	0.591	822 002 153	0.071	822 002 353	0.034
Clamping insert for OW 19, 6-part	15.30	0.602	-	-	822 002 354	0.033
Clamping insert for OW 19, 6-part	15.88	0.625	822 002 157	0.066	822 002 357	0.032
Clamping insert for OW 19, 6-part	16.00	0.630	822 002 158	0.066	822 002 358	0.032
Clamping insert for OW 19, 6-part	17.20	0.677	822 002 162	0.058	-	-
Clamping insert for OW 19, 6-part	17.30	0.681	822 002 163	0.058	822 002 363	0.030
Clamping insert for OW 19, 6-part	18.00	0.709	822 002 164	0.053	822 002 364	0.029
Clamping insert for OW 19, 6-part	19.00	0.748	822 002 165	0.044	822 002 365	0.027
Clamping insert for OW 19, 6-part	19.05	0.750	822 002 166	0.044	822 002 366	0.027

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

ORBIWELD 19 HD

Micro weld head
with robust
clamping mechanism

Micro weld head with robust clamping mechanism

Precise, robust and powerful - that's the OW 19 HD micro weld head. As a continuation of the proven OW 19 orbital weld head, the HD version has a high load capacity. The use of a robust clamping mechanism guarantees a long service life with consistently precise weld seam quality. The OW 19 HD is particularly suitable for the installation and hook-up of pipes in the semiconductor industry. Conversion between OW 19 and OW 19 HD is possible at any time.



The OW 19 HD is a continuation of the proven OW 19 micro weld head. The name suffix "Heavy Duty" suffix highlights the optimized service life and clamping force compared to the narrower basic version of the OW 19.

Robust and stable

The OW 19 HD was developed to withstand extreme loads. This includes a long service life and the completion of many welds within a very short time. Its design guarantees robust and reliable performance, even in demanding work environments.

Liquid-cooled

To ensure the optimum temperature even during intensive welding work, the OW 19 HD is equipped with efficient liquid cooling. This not only ensures constant performance, but also a longer service life for the welding head.

Optimized clamping mechanism

The use of a robust clamping mechanism not only ensures a high clamping force, but also precise and stable pipe alignment. The practical clamping fasteners enable convenient operation. The flip cover makes it easy to check the position of the electrodes and ensures that the pipes to be welded are aligned precisely.

Easy to operate

Like the OW 19, the OW 19 HD has a control panel integrated into the aluminum handle. All relevant functions can be controlled via the control panel. In addition, all orbital welding power sources from Orbitalum automatically recognize the head and its properties, so that the operator only has to call up his specified welding program and start the process before welding begins.

The head weighs 6.5 kg (14.3 lbs). The hose package attached to the welding head has a length of 7.5 meters (24.6 feet). This allows the user to move and work freely around the power source.

OW 19 HD conversion kit - for more flexibility!

Existing OW 19 welding heads can be easily converted to the OW 19 HD welding head variant using a conversion kit. (see "ORBIWELD 19" on page 40 and "Conversion kit OW 19 HD" on page 42)



Robust and stable aluminum handle with integrated control panel



Practical tension locks for convenient one-handed operation



Easier insertion of the electrodes due to markings for Ø 1.0/1.6 mm (0.039"/0.063")



Flip up weld head cover "Flip Cover"



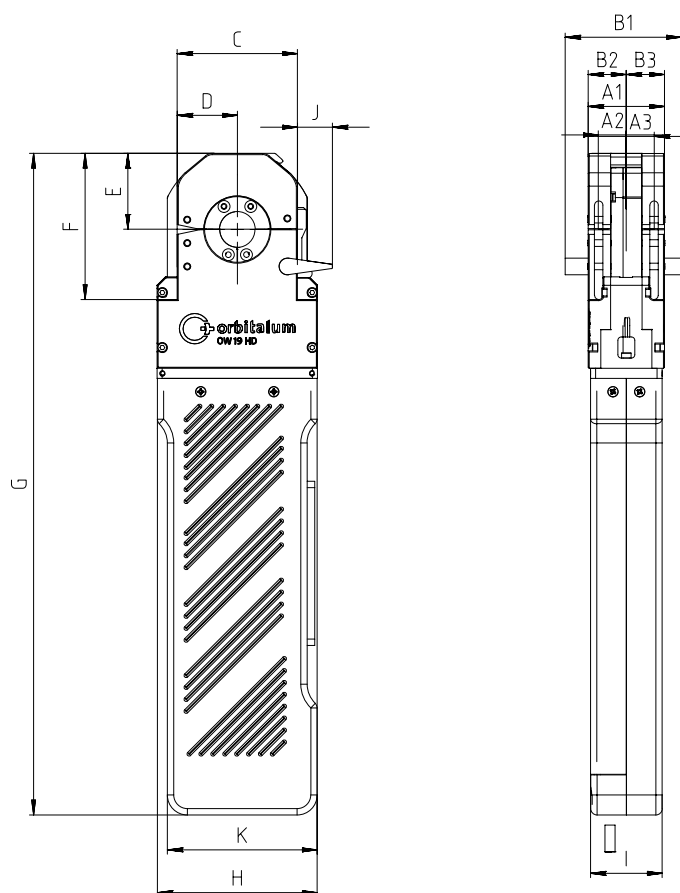
Diameter-specific clamping inserts (each 4-part, wide and narrow) available separately



Wide accessories program, e.g. ORBmax residual oxygen meter

APPLICATION AREA	ORBIWELD 19 HD
Code	822 000 011
Pipe OD, min. - max.	3,0 - 19,05 mm 0.118 - 0.750 in
Electrode diameter	1,0 / 1,6 mm 0.039 / 0.063 in
Machine weight including hose package	6,5 kg 14.3 lbs
Hose package length	7,5 m 24.6 ft
SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 x micro weld head ORBIWELD 19 HD • 1 x transport case • 1 x tool set • 1 x feeler gauge • 1 x general safety instructions • Operating instructions and spare parts list (PDF)
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping inserts for OW 19 HD • ESG electrode grinders • ORBmax residual oxygen meter • Hose package extensions • WS2 tungsten electrodes

DIMENSIONS			ELECTRODE GAP	
ORBIWELD 19 HD	DIMENSION		CLAMPING INSERT TYPE "W"	
	[MM]	[INCH]	[MM]	[INCH]
A1	36,00	1.417		
A2				
A3				
B1	55,20	2.173		
B2			18,00	0.709
B3			18,00	0.709
C	57,20	2.252		
D	28,60	1.126		
E	36,00	1.417		
F	69,50	2.736		
G	31,50	1.240		
H	76,20	3.000		
I	34,00	1.339		
J	16,60	0.654		
K	71,20	2.803		



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ORBIWELD 19 HD

Micro weld head OW

ORBIWELD 19 HD

Properties, application area, technical specifications and delivery scope, see page 44.

Clamping inserts are not included in the scope of delivery (see from page 47).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 19 HD	822 000 011	6,500	14,800

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping inserts for OW 19 HD, see page 47
- Conversion kit OW 19 HD, see
- Welding current connection adapter set, see page 107

CLOSED ORBITAL WELD HEADS

Clamping inserts for OW 19 HD

A clamping insert consists of 4 individual parts (2 inserts per side).



Clamping insert for OW 19 HD 4-part

ITEM	PIPE OD		CODE
	[MM]	[INCH]	
Clamping insert for OW 19 HD, 4-part	3,00	0.118	822 002 201
Clamping insert for OW 19 HD, 4-part	3,18	0.125	822 002 202
Clamping insert for OW 19 HD, 4-part	6,00	0.236	822 002 203
Clamping insert for OW 19 HD, 4-part	6,35	0.250	822 002 204
Clamping insert for OW 19 HD, 4-part	8,00	0.315	822 002 205
Clamping insert for OW 19 HD, 4-part	9,53	0.375	822 002 206
Clamping insert for OW 19 HD, 4-part	10,00	0.394	822 002 207
Clamping insert for OW 19 HD, 4-part	12,00	0.472	822 002 208
Clamping insert for OW 19 HD, 4-part	12,70	0.500	822 002 209
Clamping insert for OW 19 HD, 4-part	13,00	0.512	822 002 210
Clamping insert for OW 19 HD, 4-part	13,50	0.531	822 002 211
Clamping insert for OW 19 HD, 4-part	13,70	0.539	822 002 212
Clamping insert for OW 19 HD, 4-part	14,00	0.551	822 002 213
Clamping insert for OW 19 HD, 4-part	15,00	0.591	822 002 214
Clamping insert for OW 19 HD, 4-part	15,88	0.625	822 002 215
Clamping insert for OW 19 HD, 4-part	16,00	0.630	822 002 216
Clamping insert for OW 19 HD, 4-part	17,20	0.677	822 002 217
Clamping insert for OW 19 HD, 4-part	18,00	0.709	822 002 218
Clamping insert for OW 19 HD, 4-part	19,00	0.748	822 002 219
Clamping insert for OW 19 HD, 4-part	19,05	0.750	822 002 220

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

ORBIWELD 25 GC

Micro weld head

with robust

clamping mechanism

Micro weld head

With its slim design, seamless parts supply thanks to fast customer service and proven compatibility with existing systems, the ORBIWELD 25 GC sets standards in high-precision tube welding. Specially developed for the semiconductor industry, it enables the simple, fast and reliable welding of thin-walled tubes - even in confined spaces.

Compatibility with market standards makes it easy to switch to the latest Orbitalum technology



Extremely narrow design for use in confined spaces, e.g. in the semiconductor industry



Removable clamping cassettes especially for inline assembly or prefab production of modules



For small tube diameters 6.0 mm - 34.0 mm (0.236" - 1.339")



Integrated control panel for controlling the power source



Compact, powerful and versatile - the ORBIWELD 25 GC, or OW 25 GC for short, impresses with its slim design and state-of-the-art technology for demanding welding tasks in the semiconductor industry. The "GC" stands for the integrated gas cooling system, which ensures optimum cooling for intensive applications.

The OW 25 GC was specially developed for applications that require maximum precision in the tightest of spaces. With its slim design and modular construction, it is the ideal solution for semiconductor production and similar industries. Thanks to the integrated gas cooling, the system remains reliable and powerful even during intensive use - for consistently high welding quality with short cycle times.

Thanks to its high compatibility with standard clamping cassettes, the OW 25 GC can be seamlessly integrated into existing systems.

Its clamping cassette has been specially optimized for inline assembly and for the prefab production of modules so that pipes can be positioned easily and precisely.

It is controlled directly via the integrated control panel in the handle, allowing all important welding functions to be adjusted quickly and conveniently - no additional operator is required at the welding power source. An LED display provides information on the current operating status and thus ensures maximum process control.

Thanks to the electrode setting gauge supplied, precise welding joints are possible with minimal effort. In addition, the pipe center gauge attached to the cassette ensures that the pipe joint is perfectly aligned - for consistent and repeatable weld seams.

The OW 25 GC is suitable for pipe diameters from 6.0 mm - 34.0 mm (0.236" - 1.339") and, thanks to its high load capacity, enables a long duty cycle with minimal electrode wear.



Robust, compact and handy design.



Integrated control panel - this means that all commands important for welding can be transmitted to the power source, so that no additional remote control is required.



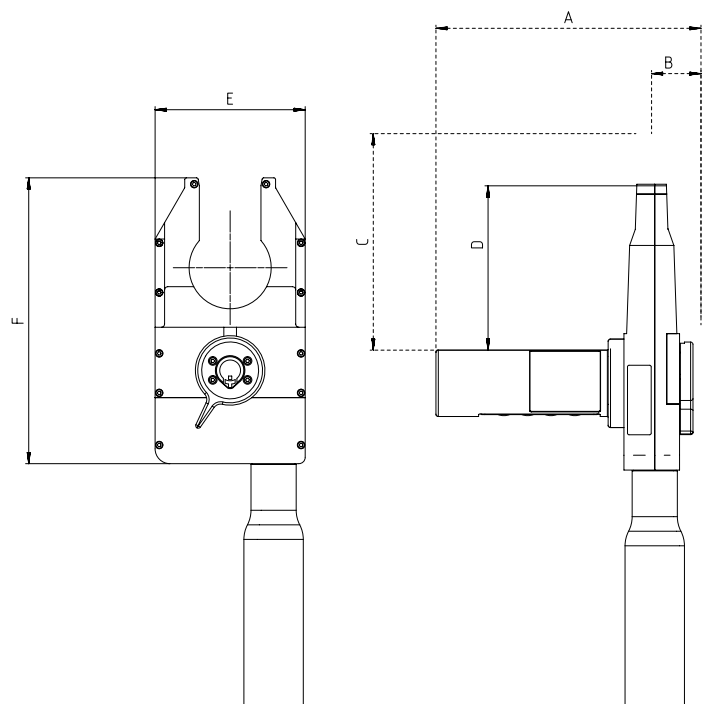
A captive pipe center gauge attached to the clamping cassette ensures the exact positioning of the pipe joint to be welded.

APPLICATION AREA	ORBIWELD 25 GC
Code	819 000 001
Pipe OD, min. - max.	6,0 - 34,00 mm 0.236 - 1.339 in
Electrode diameter	1,6 / 2,4 mm 0.063 / 0.094 in
Machine weight including hose package	6,0 kg 13.23 lbs
Hose package length	7,5 m 24.6 ft
SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 x micro weld head ORBIWELD 25 GC • 1 x transport case • 1 x tool set • 1 x electrode setting gauge • 1 x safety clamp hose assembly • 1 x general safety instructions • Operating instructions and spare parts list (PDF)
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping cassette for OW 25 GC • Clamping inserts zu OW 25 GC • ESG electrode grinders • ORBmax residual oxygen meter • Hose package extensions • WS2 tungsten electrodes



DIMENSIONS		
ORBIWELD 25 GC	DIMENSION	
	[MM]	[INCH]
A	167,77	6.605
B	31,27	1.231
C	137,04	5.395
D	104,01	4.095

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.





OW 25 GC

Micro weld head OW 25 GC

ORBIWELD 25 GC

Properties, application area, technical specifications and delivery scope, see page 48.

Clamping inserts are not included in the scope of delivery (see from page 51).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 25 GC	819 000 001	6,000	13,200

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping cassette OW 25 GC, see page 50
- Clamping inserts OW 25 GC, see page 51

Clamping cassette for OW 25 GC

Made of hard-anodized aluminium. Removable clamping cartridge specifically for inline assembly or prefab production of modules. For the mounting of clamping inserts. An insertion gauge which is permanently attached to the cassette and thus cannot be lost ensures precise positioning to the tube joint to be welded. The clamping cartridges are supplied in a rugged, lockable plastic box.

Scope of delivery:

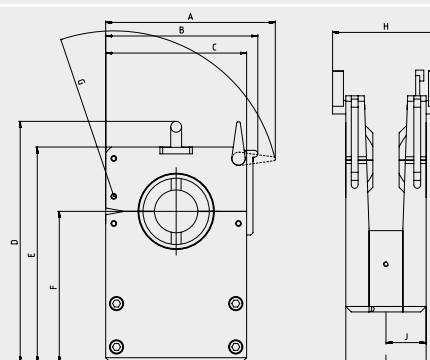
- 1 x insertion gauge
- 1 x cassette alignment gauge
- 1 x hexagon wrench 3/32"
- 1 x hexagon wrench 5/32"
- 1 x plastic box

Suitable clamping inserts for different pipe diameters must be ordered separately.



Clamping cassette for OW 25 GC
(Clamping inserts are not included in the scope of delivery)

DIMENSIONS	[MM]	[INCH]
Dimension "A"	99,34	3.911
Dimension "B"	89,1	3.508
Dimension "C"	82,55	3.25
Dimension "D"	141,63	5.576
Dimension "E"	126,6	4.984
Dimension "F"	88,91	3.500
Dimension "G"	120 °	120 °
Dimension "H"	62,54	2.462
Dimension "I"	47,04	1.852
Dimension "J"	23,52	0,926



* Does not apply to angle G

ITEM	CODE	KG
Clamping cassette OW 25 GC	819 050 010	1,00

CLOSED ORBITAL WELD HEADS

Clamping inserts for OW 25 GC

Made of stainless steel. Can be used with the OW 25 GC clamping cassette and other commercially available or compatible clamping cassettes.

A clamping insert consists of 2 half shells.

Per clamping side of the clamping cassette you require 1 clamping insert (= 2 half shells). Thus you have to use 2 clamping inserts (=4 half shells) per clamping cassette.

Further dimensions on request.



Clamping insert for OW 25 GC 4-part

IMPERIAL			IMPERIAL METRIC		
PIPE-OD		CODE	PIPE-OD		CODE
[MM]	[INCH]		[MM]	[INCH]	
6,35	1/4	819 002 201	6,00	0.236	819 002 209
7,94	5/16	819 002 202	10,00	0.393	819 002 210
9,53	3/8	819 002 203	14,00	0.551	819 002 211
12,70	1/2	819 002 204	18,00	0.709	819 002 212
15,88	5/8	819 002 205	22,00	0.866	819 002 213
19,05	3/4	819 002 206	27,20	1.071	819 002 214
22,20	7/8	819 002 207	30,00	1.181	819 002 215
25,40	1	819 002 208	34,00	1.339	819 002 216

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

ORBIWELD 38S, 115S

Closed orbital weld heads

Handier, more efficient, effective - closed TIG orbital weld head with outstanding specifications: The ORBIWELD "S" series from Orbitalum convinces by its extremely narrow design and highly resilient through efficient liquidcooling.



Extremely narrow design



Secure and offset-free clamping and centering of the parts to be welded

Thanks to its compact dimensions, the ORBIWELD "S" series is ideal for applications, under tight spaces as they often occur in the pharmaceuticals, chemical, semiconductor and food processing industry as well as in aerospace technology.

All closed weld heads of the ORBIWELD series are manufactured from outstanding materials and characterized by a unique cooling system. The fitting clamping inserts are designed to be of high-quality, functional and durable and do not wear as rapidly as those of many of the competitors. The clamping inserts are available in small (narrow) and wide versions and can be inserted into the weld head rapidly and easily.

FURTHER PROPERTIES:

- Thanks to the extremely narrow design, parts with short welding lengths can also be processed
- High quality, robust housing and handles
- Highly resilient through completely liquid-cooled weld head housing
- Highly flexible hose package (length: 7.5 m/24.6 ft) with strain relief to the power source
- With a control panel integrated in the robust and stable aluminum handle of the weld head, all commands which are important for the welding can be transferred to the power source so that no additional remote control is required
- Quick change system for clamping inserts allows simple locking and releasing without tools

- Cost-effective clamping inserts
- Stable clamping locks in connection with the clamping inserts available for all tube dimensions ensure a secure and offset-free clamping and centering of the parts to be welded
- Comprehensive and customer-specific accessories program
- A folding cover at the weld head - allows checking and, if necessary, readjustment of the electrode position before welding



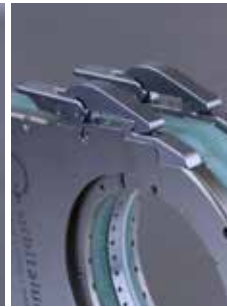
Robust and stable aluminum handle with integrated control panel



Simpler inserting of the electrodes by markings for Ø 1.6/2.4 mm (0.063"/0.094")



Flip-up weld head cover "FlipCover"



Stable clamping locks



Diameter-specific aluminum clamping inserts (each of 2 half-shells) available separately



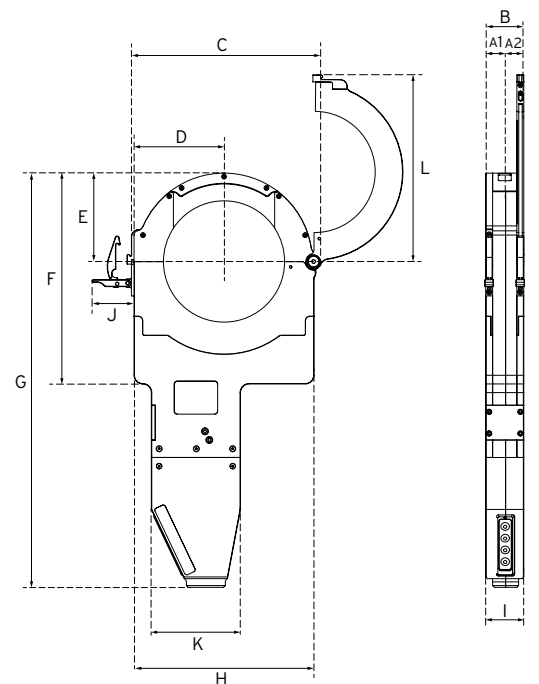
Wide accessories program, e.g. table mounts

DIMENSIONS	ORBIWELD 38S				ORBIWELD 115S					
	DIMENSION		ELECTRODE GAP CLAMPING INSERT*		DIMENSION		ELECTRODE GAP			
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	CLAMPING INSERT* TYPE "S"		CLAMPING INSERT* TYPE "W"	
							[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	17.00	0.669	17.50	0.689	22.75	0.896	25.00	0.984	45.75	1.801
Dimension "A2"	17.00	0.669	17.50	0.689	21.25	0.837	25.00	0.984	44.25	1.742
Dimension "B"	34.00	1.339	35.00	1.378	44.00	1.732	50.00	1.969	90.00	3.543
Dimension "C"	112.00	4.409			220.00	8.661				
Dimension "D"	47.50	1.870			104.00	4.094				
Dimension "E"	47.00	1.850			102.00	4.016				
Dimension "F"	144.00	5.669			244.00	9.606				
Dimension "G"	357.00	14.055			480.00	18.898				
Dimension "H"	95.00	3.740			208.00	8.189				
Dimension "I"	34.00	1.339			44.00	1.732				
Dimension "J"	55.00	2.165			55.00	2.165				
Dimension "K"	71.00	2.795			102.00	4.016				
Dimension "L"	110.00	4.331			216.00	8.504				

* 2 pairs

APPLICATION AREA	ORBIWELD 38S	ORBIWELD 115S
Code	826 000 001	828 000 001
Tube OD, min. - max.	3 - 38.1 mm 1/8" - 1.5"	20 - 115 mm 3/4" - 4.5"
Electrode diameter	1.6/2.4 mm .063"/.094"	1.6/2.4 mm .063"/.094"
Machine weight including hose package	6.9 kg 15.2 lbs	9.7 kg 21.4 lbs
Hose package length	7.5 m/24.6 ft	7.5 m/24.6 ft
SCOPE OF DELIVERY		
Including:	<ul style="list-style-type: none"> • 1 orbital weld head OW 38S or OW 115S • 1 transport case • 1 tool set • 1 feeler gauge • 1 operating instructions and spare parts list • General safety instructions 	
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping inserts, narrow and wide • Chamber insert for fittings • Inserts for arc welding • T-piece clamping inserts • Electrode adapters • Table mounts • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • WS2 tungsten electrodes 	

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.



ORBIWELD 38S



ORBIWELD 115S



ORBIWELD 38S



ORBIWELD 115S

Closed orbital weld heads OW S

ORBIWELD 38S, ORBIWELD 115S

Properties, application area, technical specifications and delivery scope, see page 52.

Clamping inserts are not included in the scope of delivery (see from page 63).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head OW 38S	826 000 001	6.900	16.500
Orbital weld head OW 115S	828 000 001	9.700	18.600

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping inserts for ORBIWELD S and ORBIWELD, see page 63
- Chamber inserts for fittings, see page 66
- Inserts for arc welding, see page 67
- T-piece clamping inserts, see page 67
- Electrode adapters, see page 67
- Table mounts, see page 69
- Welding current connection adapter set, see page 109

CLOSED ORBITAL WELD HEADS

Just rent and stay flexible.

We offer rental machines for short-term and long-term rental - as a cost-effective alternative to purchasing.

Our rental machines are serviced regularly and are thus always in top condition. We are happy to help to find suitable machines for your individual application. By the way renting is an excellent opportunity to test a machine before you buy it.

Advantages of renting:

- Lower storage costs
- No repair costs
- Small investment
- Always the newest technology in use
- Minimum downtimes

Our rental and used machine service includes:

- Rental tariffs on a weekly basis
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- Long-term rental

Ask us for our low rental and hire purchase conditions:

Phone: +49 (0) 77 31 792-0

Or via email under
tools@orbitalum.com

ORBIWELD 170

Closed orbital weld head

The ORBIWELD 170 is characterized by a very high thermal load. This means it is particularly suitable for applications in the pharmaceutical, chemical, semiconductor and food processing industry or aerospace technology, where, due to ever increasing diameters and wall thicknesses of the tubes to be welded, higher and higher requirements are placed on the closed weld heads.



With cooling channels running through the entire weld head body, excellent heat dissipation has been ensured which allows for continuous work with the ORBIWELD weld head even with high quality weld seams and intensive operation.

The closed design of the ORBIWELD 170 as well as the gas flow system ensure permanent flushing of the weld seam during welding with protective gas resulting in seams that are almost without tempering color.

CHARACTERISTICS:

- Quick change system for clamping inserts allows simple locking and releasing without tools
- Highly resilient through completely liquid-cooled weld head housing
- Stable clamping locks in connection with the clamping inserts available for all tube dimensions ensure a secure and offset-free clamping and centering of the parts to be welded
- With a control panel integrated in the robust and stable aluminum handle of the weld head, all

commands which are important for the welding can be transferred to the power source so that no additional remote control is required

- High quality, robust housing and handles
- Highly flexible hose package (length: 7.5 m/24.6 ft) with strain relief to the power source
- Cost-effective clamping inserts
- Comprehensive and customer-specific accessories program

Comprehensive and customer-specific accessories program (optionally available):



Hose package length extensions up to max. of 20 m (64ft)



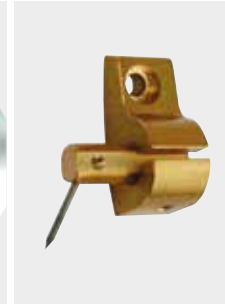
Cost-effective clamping inserts



Chamber inserts for fittings for welding of fittings



T-piece clamping inserts with absorption possibility of the collared hose and the hose to be welded

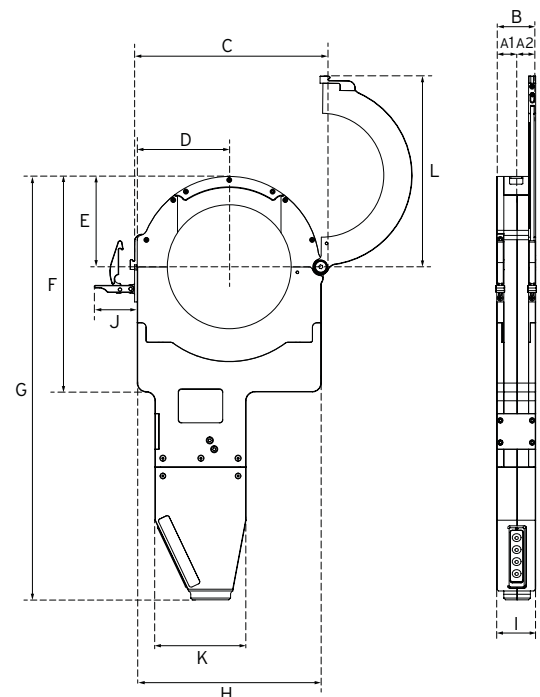


Electrode adapter for lateral offset of the tungsten electrode



Practical and sturdy aluminum table mount

APPLICATION AREA	ORBIWELD 170
Code	825 000 001
Tube OD, min. - max.	50 - 170 mm 2 - 6 in
Electrode diameter	1.6/2.4 mm 0.063/0.094 in
Machine weight including hose package	18.9 kg 41.7 lbs
Hose package length	7.5 m 24.6 ft
SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 orbital weld head OW 170 • 1 transport case (code 821 030 001) • 1 tool set • 1 feeler gauge • 1 Operating instructions and spare parts list • General safety instructions
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping inserts, narrow and wide • Chamber insert for fittings • Inserts for arc welding • T-piece clamping inserts • Electrode adapters • Table mounts • ESG electrode grinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hose package extensions • Double pressure reducer • WS2 tungsten electrodes



ORBIWELD 170	DIMENSION		ELECTRODE GAP			
			CLAMPING INSERT TYPE "S" [2 PAIRS]		CLAMPING INSERT TYPE "W" [2 PAIRS]	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	30.00	1.181	32.00	1.260	50.00	1.969
Dimension "A2"	41.00	1.614	43.00	1.693	61.00	2.402
Dimension "B"	70.00	2.756	72.00	2.835	110.00	4.331
Dimension "C"	345.00	13.583				
Dimension "D"	160.00	6.299				
Dimension "E"	140.00	5.512				
Dimension "F"	365.00	14.370				
Dimension "G"	585.00	23.031				
Dimension "H"	285.00	11.220				
Dimension "I"	50.00	1.969				
Dimension "J"	67.00	2.638				
Dimension "K"	88.00	3.465				
Dimension "L"	332.00	13.071				

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.



ORBIWELD 170



ORBIWELD 170

Closed orbital weld head OW

ORBIWELD 170

Properties, application area, technical specifications and delivery scope, see page 56.

Clamping inserts are not included in the scope of delivery (see from page 63).

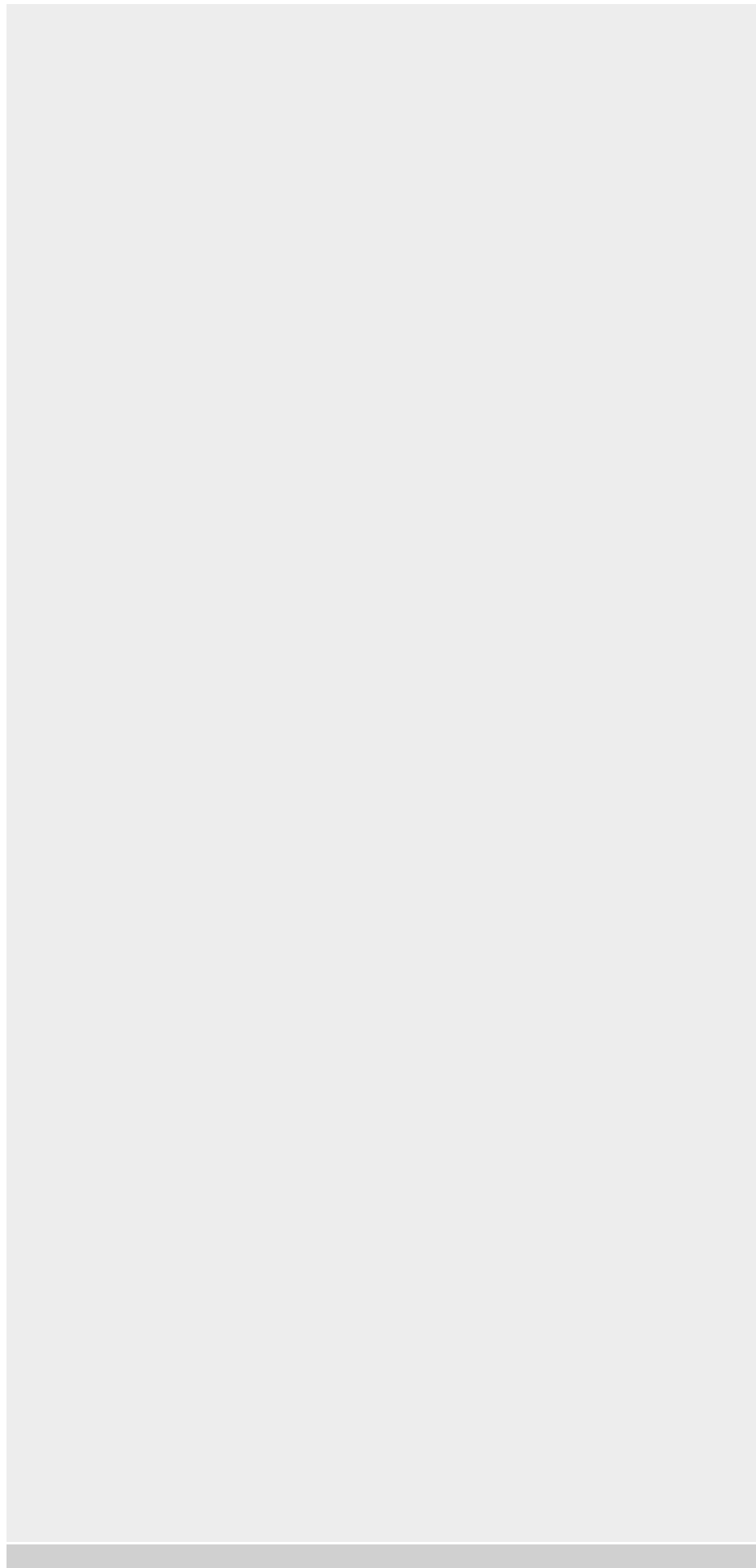
ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head OW 170	825 000 001	18.900	36.200

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping inserts for ORBIWELD S and ORBIWELD, see page 63
- Chamber inserts for fittings, see page 66
- Inserts for arc welding, see page 67
- T-piece clamping inserts, see page 67
- Electrode adapters, see page 67
- Table mounts, see page 69
- Welding current connection adapter set, see page 109

CLOSED ORBITAL WELD HEADS



ORBIWELD X

Closed orbital weld head

Intelligent, closed
orbital weld head

The new generation of intelligent orbital weld heads - the OWX weld heads mark a significant advance in orbital welding technology. As the successor to the well-known OWS series, the OWX heads offer a wide range of innovative functions that make orbital welding more efficient and user-friendly. They impress with their simple handling, reliable performance and maintenance-friendly design. The weld heads are compatible with Orbitalum power sources Smart Welder and Mobile Welder and OWS clamping shells.

The OWX welding head sets new standards for orbital welding comfort.

Illuminating the Future of Orbital Welding



As the follow-up to the OWS series, the OWX weld heads offer a wide range of innovative developments. The slim and futuristic design, combined with the latest smart features, make the OWX heads a must-have in modern pipeline construction.

Simple operation

The OWX weld head is equipped with an ergonomic handle and an optimized clamping mechanism. The flip cover with viewing window and the integrated LED lighting inside the weld head make it easier to visually align and check the position of the pipes. The weld head has a mechanical mounting interface to enable easy integration into fixture construction. In addition, simple and intuitive operation of the weld head is made possible by an operating unit integrated into the aluminum handle shell.

Modern smart features

The operating unit of the OWX is equipped with a display that has smart functions. For example, welding programs marked as favourites can be selected directly from the head. The progress is visualized during the welding process. A gyro sensor is also installed in the weld head, which precisely determines the position of the weld head and enables automatic positioning of the electrode to the programmed start position. A temperature sensor also monitors the weld head during the entire welding process.

Easy to service and maintain

The OWX welding head was designed for quick and easy maintenance. Thanks to its service-friendly design, gearbox maintenance can be carried out in just 15 minutes - without long waiting times for external repairs or dispatch. The gearbox components are easily accessible for maintenance with minimal use of tools, reducing downtime and maximizing operational reliability.

Compatible with Orbitalum products

For maximum flexibility, the OWX weld heads are compatible with the Orbitalum power sources from the Smart Welder and Mobile Welder series as well as the OWS clamping shells and electrode adapters.

OPTIONAL: Table mount for greater safety

The OWX table mount offers a stable and secure attachment of the weld head at the workplace. As it is flexible, it can be used for temporary storage or permanent mounting. The bracket allows the weld head to be positioned both parallel and perpendicular to the mounting surface (page 62).

Technical highlights and range of accessories (optionally available):



Control unit with display integrated in the aluminum handle.



Sturdy aluminum table mount for fastening to the edge or surface of the table.



Universal central mechanical fixing interface for drop protection

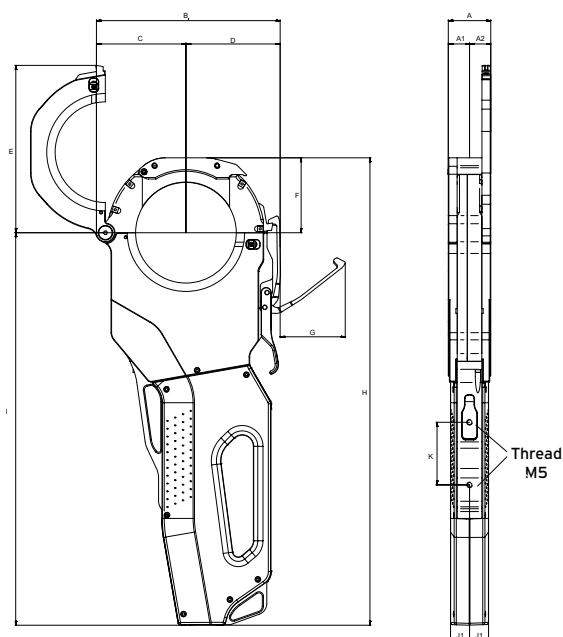
APPLICATION AREA	ORBIWELD X 3.0
Code	837 000 001
Pipe OD, min. - max.	6,00 - 77,00 mm 0.250" - 3.000"
Electrode diameter	1,6/2,4 mm 0.063"/0.094"
Machine weight including hose package	8,50 kg 18.739 lbs
Hose package length	7,5 m 24.6 ft
SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 ORBIWELD X 3.0 orbital weld head • 1 OWX 3.0 transport case (code 837 030 010) • 1 OWX tool set (code 836 030 001) • Operating instruction and spare parts list • General safety instructions
Suitable accessories (optionally available):	<ul style="list-style-type: none"> • Clamping inserts for Orbiweld, Orbiweld S and ORBIWELD X • Chamber inserts for molded parts • Inserts for arc welding • T-piece clamping inserts • Electrode adapters • Table mount • ESG electrodegrinders • ORBmax residual oxygen meter • ORBIPURGE forming set • Hosepack extensions • Double pressure reducer • WS2 Tungsten electrodes



ORBIWELD X 3.0

ORBIWELD X 3.0				
DIMENSIONS	DIMENSION		ELECTRODE GAP CLAMPING INSERT*	
	[MM]	[INCH]	[MM]	[INCH]
A	38,00	1.496	38,00	1.496
A1	19,00	0.748	19,00	0.748
A2	19,00	0.748	19,00	0.748
B	164,27	6.467		
C	80,03	3.151		
D	84,24	3.317		
E	149,64	5.891		
F	67,00	2.638		
G	58,20	2.291		
H	417,99	16.456		
I	351,00	13.819		
J1	17,00	0.669		
J2	17,00	0.669		
K	56,00	2.205		

* 2 pairs



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We reserve the right to make changes.



ORBIWELD X 3.0



Table mount OWX, V2

Closed orbital weld head OWX

ORBIWELD X 3.0

Properties, application area, technical specifications and delivery scope, see page 60.

Clamping inserts are not included in the scope of delivery (see from page 63).

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head OWX 3.0	837 000 001	8,50	16,50

* Machine weight including hose package

Table mount OWX, V2

The aluminium table mount (anodized) with its quick-release clamp enables convenient and secure positioning and fixing of ORBIWELD X-series weld heads. It can be clamped to the edges of worktops, screwed onto worktops or integrated into alternative fastening systems. The base can also be offset by 90° on the mounting bracket, which provides additional flexibility.

TECHNICAL DATA

Dimensions (lxbxh*)	330,0 x 137,0 x 120 mm 12.992 x 5.394 x 4.724 in
Clamping range (from bottom surface of table to maximum extended screw clamp)	max. 132,00 mm / 5.197 in
Weight	1,17 Kg

ITEM	CODE	KG
Table mount OWX, V2	836 030 201	1,17

Suitable accessories (optionally available):

- Clamping inserts for ORBIWELD, ORBIWELD S and ORBIWELD X, see page 63
- Inserts for arc welding, see page 67
- T-piece clamping inserts, see page 67
- Electrode adapters, see page 91
- Welding current connection adapter set, see page 109

Accessories for ORBIWELD, ORBIWELD S and ORBIWELD X

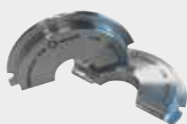
Clamping inserts

Made of aluminum. One clamping insert is comprised of two half shells for one clamping side.

Two clamping inserts (i.e. 4 half shells) are required for each tube diameter.

For ORBIWELD 115S and 170 you can select between the wide "W" and small (narrow) "S" clamping inserts which can be combined randomly with each other.

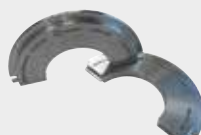
Clamping insert blanks for unscrewing, see page 66.



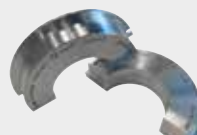
Clamping insert
for OW 38S, 2-part
for a clamping insert



Clamping insert
for OW 76S and OWX 3.0, 2-part
for a clamping side



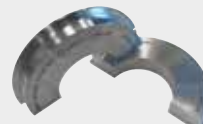
Clamping insert "S" (small/
narrow)
for OW 115S, 2-part
for a clamping side



Clamping insert "W" (wide)
for OW 115S, 2-part
for a clamping side



Clamping insert "S" (small/
narrow)
for OW 170, 2-part
for a clamping side



Clamping insert "W" (wide)
for OW 170, 2-part
for a clamping side

TUBE OD		OW 38S	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
3.00	0.118	826 002 120	-		-	-	-	-
3.18	0.125	826 002 122	-		-	-	-	-
4.00	0.157	826 002 124	-		-	-	-	-
4.76	0.187	826 002 125	-		-	-	-	-
4.78	0.188	826 002 126	-		-	-	-	-
5.95	0.234	826 002 127	-		-	-	-	-
6.00	0.236	826 002 128	827 002 120		-	-	-	-
6.35	0.250	826 002 129	827 002 121		-	-	-	-
7.00	0.276	826 002 130	-		-	-	-	-
7.50	0.295	826 002 131	-		-	-	-	-
7.94	0.313	826 002 132	827 002 124		-	-	-	-
8.00	0.315	826 002 133	827 002 125		-	-	-	-
9.00	0.354	826 002 134	827 002 126		-	-	-	-
9.53	0.375	826 002 135	827 002 127		-	-	-	-
9.95	0.392	826 002 136	-		-	-	-	-
10.00	0.394	826 002 137	827 002 129		-	-	-	-
10.10	0.398	826 002 138	827 002 130		-	-	-	-
10.20	0.402	826 002 139	827 002 131		-	-	-	-
11.00	0.433	826 002 140	827 002 132		-	-	-	-
11.95	0.470	826 002 142	827 002 134		-	-	-	-
12.00	0.472	826 002 143	827 002 135		-	-	-	-
12.10	0.476	826 002 144	827 002 136		-	-	-	-
12.70	0.500	826 002 145	827 002 137		-	-	-	-
13.00	0.512	826 002 146	827 002 138		-	-	-	-
13.20	0.520	-	827 002 139		-	-	-	-
13.50	0.531	826 002 148	827 002 140		-	-	-	-
13.70	0.539	826 002 149	827 002 141		-	-	-	-
14.00	0.551	826 002 150	827 002 142		-	-	-	-
14.30	0.563	826 002 151	827 002 143		-	-	-	-
14.70	0.579	826 002 152	-		-	-	-	-
15.00	0.591	826 002 153	827 002 145		-	-	-	-
15.30	0.602	826 002 154	827 002 146		-	-	-	-
15.60	0.614	826 002 155	827 002 147		-	-	-	-
15.70	0.618	826 002 156	827 002 148		-	-	-	-
15.88	0.625	826 002 157	827 002 149		-	-	-	-
16.00	0.630	826 002 158	827 002 150		-	-	-	-
16.70	0.657	826 002 159	-		-	-	-	-
17.00	0.669	826 002 160	827 002 152		-	-	-	-
17.20	0.677	826 002 162	827 002 154		-	-	-	-
17.30	0.681	826 002 163	827 002 155		-	-	-	-
18.00	0.709	826 002 164	827 002 156		-	-	-	-
19.00	0.748	826 002 165	827 002 157		-	-	-	-

CLOSED ORBITAL WELD HEADS

TUBE OD		OW 38S	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
19.05	0.750	826 002 166	827 002 158		-	-	-	-
19.50	0.768	826 002 167	827 002 159		-	-	-	-
20.00	0.787	826 002 168	827 002 160		824 002 120	-	-	-
21.00	0.827	826 002 169	827 002 161		-	-	-	-
21.30	0.839	826 002 170	827 002 162		824 002 122	824 002 322	-	-
21.70	0.854	826 002 171	827 002 163		824 002 123	-	-	-
22.00	0.866	826 002 172	827 002 164		824 002 124	-	-	-
22.22	0.875	826 002 173	827 002 165		-	-	-	-
22.23	0.875	826 002 174	827 002 166		824 002 126	-	-	-
22.55	0.888	826 002 175	-		-	-	-	-
23.00	0.906	826 002 176	827 002 168		824 002 128	824 002 328	-	-
24.00	0.945	826 002 177	827 002 169		824 002 129	-	-	-
25.00	0.984	826 002 179	827 002 171		824 002 131	824 002 331	-	-
25.25	0.994	826 002 180	827 002 172		-	-	-	-
25.40	1.000	826 002 181	827 002 173		824 002 133	824 002 333	-	-
26.00	1.024	826 002 182	827 002 174		-	-	-	-
26.70	1.051	826 002 183	827 002 175		824 002 135	-	-	-
26.90	1.059	826 002 184	827 002 176		824 002 136	824 002 336	-	-
27.00	1.063	826 002 185	827 002 177		-	-	-	-
27.20	1.071	826 002 186	827 002 178		824 002 138	-	-	-
28.00	1.102	826 002 187	827 002 179		824 002 139	-	-	-
29.00	1.142	826 002 188	827 002 180		824 002 140	824 002 340	-	-
30.00	1.181	826 002 189	827 002 181		824 002 141	-	-	-
30.53	1.202	826 002 190	827 002 182		824 002 142	-	-	-
31.75	1.250	826 002 191	827 002 183		824 002 143	824 002 343	-	-
31.80	1.252	826 002 192	827 002 184		824 002 144	-	-	-
32.00	1.260	826 002 193	827 002 185		824 002 145	824 002 345	-	-
33.00	1.299	826 002 194	827 002 186		824 002 146	-	-	-
33.40	1.315	826 002 195	827 002 187		824 002 147	-	-	-
33.70	1.327	826 002 196	827 002 188		824 002 148	824 002 348	-	-
34.00	1.339	826 002 197	827 002 189		824 002 149	-	-	-
35.00	1.378	826 002 198	827 002 190		824 002 150	824 002 350	-	-
36.00	1.417	826 002 199	827 002 191		824 002 151	-	-	-
38.00	1.496	826 002 200	827 002 192		824 002 152	824 002 352	-	-
38.10	1.500	826 002 201	827 002 193		824 002 153	824 002 353	-	-
40.00	1.575	-	827 002 194		824 002 154	-	-	-
41.00	1.614	-	827 002 195		824 002 155	824 002 355	-	-
42.00	1.654	-	827 002 196		824 002 156	-	-	-
42.16	1.660	-	827 002 197		824 002 157	-	-	-
42.30	1.665	-	827 002 198		-	-	-	-
42.40	1.669	-	827 002 199		824 002 159	824 002 359	-	-
42.70	1.681	-	827 002 200		824 002 160	-	-	-
43.00	1.693	-	827 002 201		824 002 161	824 002 361	-	-
44.00	1.732	-	827 002 203		-	-	-	-
44.45	1.750	-	827 002 204		824 002 164	824 002 364	-	-
44.50	1.752	-	827 002 205		824 002 165	-	-	-
45.00	1.772	-	827 002 206		824 002 166	-	-	-
48.00	1.890	-	827 002 208		824 002 168	-	-	-
48.26	1.900	-	827 002 209		824 002 169	-	-	-
48.30	1.902	-	827 002 210		824 002 170	824 002 370	-	-
48.60	1.913	-	827 002 211		824 002 171	-	-	-
50.00	1.969	-	827 002 212		824 002 172	824 002 372	825 002 120	-
50.80	2.000	-	827 002 213		824 002 173	824 002 373	825 002 121	825 002 321
51.00	2.008	-	827 002 214		824 002 174	824 002 374	-	-
52.00	2.047	-	827 002 215		824 002 175	824 002 375	-	-
53.00	2.087	-	827 002 216		824 002 176	824 002 376	825 002 124	-
54.00	2.126	-	827 002 217		824 002 177	824 002 377	-	-
57.00	2.244	-	827 002 218		824 002 178	-	-	-
60.00	2.363	-	827 002 219		824 002 179	-	-	-
60.10	2.366	-	827 002 220		-	-	-	-
60.30	2.374	-	827 002 221		824 002 181	824 002 381	825 002 129	825 002 329
60.45	2.380	-	827 002 222		824 002 182	-	-	-
60.50	2.382	-	827 002 223		824 002 183	-	-	-
63.00	2.480	-	827 002 224		824 002 184	824 002 384	-	-
63.20	2.488	-	827 002 225		-	-	-	-
63.50	2.500	-	827 002 226		824 002 186	824 002 386	825 002 134	825 002 334
65.00	2.559	-	827 002 227		824 002 187	-	-	-

CLOSED ORBITAL WELD HEADS

TUBE OD		OW 38S	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
70.00	2.756	-	827 002 228		824 002 188	824 002 388	825 002 136	825 002 336
70.20	2.764	-	-		824 002 189	824 002 389	-	-
73.00	2.874	-	827 002 230		824 002 190	-	-	-
73.03	2.875	-	827 002 231		824 002 191	-	-	-
75.00	2.953	-	827 002 233		824 002 193	-	-	-
76.00	2.992	-	827 002 234		824 002 194	-	-	-
76.10	2.996	-	827 002 235		824 002 195	824 002 395	825 002 143	825 002 343
76.20	3.000	-	827 002 236		824 002 196	824 002 396	825 002 144	825 002 344
76.30	3.004	-	827 002 237		824 002 197	824 002 397	-	-
80.00	3.150	-	-		824 002 198	824 002 398	-	825 002 346
82.00	3.228	-	-		824 002 199	-	-	-
82.30	3.240	-	-		824 002 200	-	-	-
85.00	3.346	-	-		824 002 201	824 002 401	-	825 002 349
88.90	3.500	-	-		824 002 203	824 002 403	825 002 151	825 002 351
89.00	3.504	-	-		824 002 204	-	-	-
89.10	3.508	-	-		824 002 205	824 002 405	-	-
90.00	3.543	-	-		824 002 206	-	-	-
100.00	3.937	-	-		824 002 209	-	-	-
101.60	4.000	-	-		824 002 210	824 002 410	825 002 158	825 002 358
104.00	4.094	-	-		824 002 211	824 002 411	825 002 159	825 002 359
108.00	4.252	-	-		824 002 212	-	825 002 160	-
110.00	4.331	-	-		824 002 213	-	-	-
114.00	4.488	-	-		824 002 215	-	-	-
114.30	4.500	-	-		824 002 216	824 002 416	825 002 164	825 002 364
115.00	4.528	-	-		824 002 217	824 002 417	825 002 165	-
127.00	5.000	-	-		-	-	825 002 167	825 002 367
127.05	5.002	-	-		-	-	-	-
129.00	5.079	-	-		-	-	825 002 169	825 002 369
133.00	5.236	-	-		-	-	825 002 170	-
139.70	5.500	-	-		-	-	825 002 171	825 002 371
152.40	6.000	-	-		-	-	825 002 173	825 002 373
154.00	5.063	-	-		-	-	825 002 174	825 002 374
159.00	6.260	-	-		-	-	825 002 175	-
165.20	6.504	-	-		-	-	825 002 177	-
168.30	6.626	-	-		-	-	825 002 178	825 002 378
170.00	6.693	-	-		-	-	825 002 179	825 002 379

CLOSED ORBITAL WELD HEADS



Clamping insert blanks

Clamping insert blanks

Ideal for special applications.

Completely closed clamping inserts for turning out yourself to customer-specific diameter areas.

ITEM	CODE	KG
Clamping insert blank for OW 38S, 2-part	826 002 210	0.066
Clamping insert blank for OW 76S/OWX 3.0, 2-part	827 002 241	0.280
Clamping insert blank for OW 115S "S" (small/narrow), 2-part	824 002 220	0.590
Clamping insert blank for OW 115S "W" (wide), 2-part	824 002 420	1.445
Clamping insert blank for OW 170 "S" (small/narrow), 2-part	825 002 185	1.010
Clamping insert blank for OW 170 "W" (wide), 2-part	825 002 385	1.000



Packagings for clamping inserts

Packagings for clamping inserts

All clamping inserts are delivered as pairs in a plastic cover.

In case of a loss of the original packaging it can be reordered as a replacement.

ITEM	CODE	KG
Packaging clamping insert OW 38S	826 002 010	0.019
Packaging clamping insert OW 76S/OWX 3.0	827 002 010	0.065
Packaging clamping insert OW 115S "S" (small/narrow)	824 002 010	0.101
Packaging clamping insert OW 115S "W" (wide)	824 002 011	0.129



Chamber insert for fittings

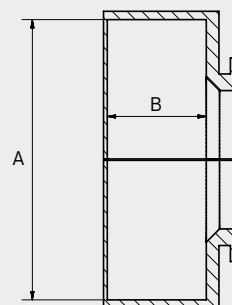
Chamber inserts for fittings

Clamping inserts for welding of fittings (e.g. flanges, flanged wheels and screw joints in the food processing industry).

1 chamber insert consists of 2 half shells.

Dimensions of the different chamber inserts:

ORBIWELD		DIMENSION "A"(Ø)	DIMENSION "B"
38S	[mm]	85.0	30.0
	[inch]	3.346	1.181
76S	[mm]	130.0	35.0
	[inch]	5.118	1.378
115S	[mm]	179.0	39.0
	[inch]	7.047	1.535
170	[mm]	214.0	44.0
	[inch]	8.425	1.732



ITEM	CODE	KG
Chamber inserts for fittings for OW 38S	826 050 010	0.146
Chamber inserts for fittings for OW 76S/OWX 3.0	837 050 017	0.266
Chamber inserts for fittings for OW 115S	824 050 003	0.660
Chamber inserts for fittings for OW 170	825 050 002	0.852

CLOSED ORBITAL WELD HEADS

T-piece clamping inserts

Clamping inserts with holding possibility of the collared hose and the hose to be welded. One complete T-piece clamping insert, 1 electrode adapter (page 67) as well as 1 standard clamping insert (from page 63) (to be ordered separately) are required per task and dimension.

Please request respective questionnaire for order and submit together with a drawing.

Special clamping inserts for other orbital weld heads on request.
Internal centering with simultaneous shaping device on request.

ITEM	TUBE OD MAX. [MM]	TUBE OD MAX. [INCH]	CODE	KG
T-piece clamping insert for OW 38S	25.0	0.984	826 050 038	
T-piece clamping insert for OW 76S/OWX 3.0	48.0	1.890	827 050 005	0.720
T-piece clamping insert for OW 115S	85.0	3.346	824 050 004	1.825
T-piece clamping insert for OW 170	144.0	5.669	825 050 003	3.700



T-piece clamping inserts

Inserts for arc welding

For welding with standard arcs without straight leg root at tubes.

When using these inserts on a weld head side (right or left) only the gas protection around the arc is ensured; clamping does not take place so that the arc has to be crimped.

Insert consisting of:

- 2 basic retainer halves, independent of tube diameter
- 2 cover retainer halves, dependent of tube diameter*

Basic retainers/covers

The covers are inserted into the basic retainers and can be turned so that the side of the elbow can exit at any angle from the weld head. The tube to be welded on the other side of the weld head is held via a standard clamping insert (standard clamping inserts are not included in the scope of delivery).

Arc covers for OW 38S

With the weld head OW 38S the customer-specifically manufactured covers (2 halves) are inserted directly in the head without basic retainer. A basic retainer is therefore not required.

Please specify or submit at order:

- The desired tube outer diameter and arc inner radius.
- **Drawing of the arc or sample part – a corresponding drawing template for this can be requested in advance.** We subsequently check whether an electrode adapter can additionally be used, if necessary.



Insert for arc welding
(Basic retainers/covers)

ITEM	CODE	KG
Arc covers OW 38S complete*	826 050 031	0.017
Basic retainer for arc insert for OW 76S/OWX 3.0	827 002 018	0.150
Cover for arc insert for OW 76S/OWX 3.0	827 050 021	0.030
Basic retainer for arc insert for OW 115S	824 050 006	0.150
Cover for arc insert for OW 115S*	828 050 016	0.054
Basic retainer for arc insert for OW 170	825 050 005	0.250
Cover for arc insert for OW 170*	825 050 020	0.045

* Please submit drawing of the arc or sample part at order.

CLOSED ORBITAL WELD HEADS

Electrode adapters

Robust brass adapter for lateral offset of the tungsten electrode.

Standard electrode adapter

For fillet weld applications and applications where lateral electrode offset is required. Can be ordered as a set or individually. Please note that the maximum weldable tube diameter is reduced during the use of an electrode adapter.

Complete sets consisting of:

- Basic part for extension
- 1 extension each for 15°, 30°, 45° and 90°
- Mounting screw(s)

FOR ELECTRODES WITH 1.6 MM DIAMETER.

ELECTRODE ADAPTERS USABLE UP TO MAX. TUBE OUTER DIAMETER

	[MM]	[INCH]
OW 38S	25,4	1.000
OW 76S	48,0	1.890
OW 115S	85,0	3.346
OW 170	144,0	5.669



Electrode adapters for OW 38S, OW 76S



Electrode adapter for OW 170

ELECTRODE ADAPTER SETS	CODE	KG
Electrode adapter set OW 38S, standard	826 050 034	0.033
Electrode adapter set OW 76S/OWX 3.0, standard	827 050 027	0.089
Electrode adapter set OW 115S, standard	828 050 022	0.064
Electrode adapter set OW 170, standard	825 050 022	0.094
INDIVIDUAL PARTS FOR OW 38S		
Basic part electrode adapter OW 38S	826 004 003	0.013
Extension 10 mm/0.394", 15° for electrode adapter OW 38S	823 004 008	0.003
Extension 10 mm/0.394", 30° for electrode adapter OW 38S	823 004 009	0.003
Extension 10 mm/0.394", 45° for electrode adapter OW 38S	823 004 010	0.003
INDIVIDUAL PARTS FOR OW 76S		
Basic part electrode adapter OW 76S/OWX 3.0	827 004 003	0.024
Extension 15 mm/0.591", 15°/90° for electrode adapter OW 76S/OWX 3.0	823 004 002	0.005
Extension 15 mm/0.591", 30°/90° for electrode adapter OW 76S/OWX 3.0	823 004 003	0.005
Extension 15 mm/0.591", 45°/90° for electrode adapter OW 76S/OWX 3.0	823 004 004	0.005
INDIVIDUAL PARTS FOR OW 115S		
Basic part electrode adapter OW 115S	828 004 004	0.037
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 115S	823 004 006	0.009
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 115S	823 004 005	0.009
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 115S	823 004 007	0.009
INDIVIDUAL PARTS FOR OW 170		
Basic part electrode adapter OW 170	825 004 001	0.067
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 170	823 004 006	0.009
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 170	823 004 005	0.009
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 170	823 004 007	0.009

Electrode adapter for front seam welding

FOR ELECTRODES WITH 1.6 MM DIAMETER.

ELECTRODE ADAPTER APPLICABLE UP TO MAX. TUBE OUTER DIAMETER

	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW 38S	6,0	0.236	25,0	0.984
OW 76S/OWX 3.0	6,0	0.236	48,0	1.890
OW 115S	20,0	0.787	85,0	3.346

A chamber insert is mandatory for the non-workpiece-receiving weld head side and must be ordered separately.

See "Chamber inserts for fittings" on page 48

ELECTRODE ADAPTER SETS FOR FRONT SEAM WELDING	CODE	KG
Electrode adapter set OW 38S front seam	826 050 036	0.045
Electrode adapter set OW 76S/OWX 3.0 front seam	827 050 038	0.045
Electrode adapter set OW 115S front seam	828 050 023	0.070



Front seam adapter (without rotor)

CLOSED ORBITAL WELD HEADS

Electrode adapter for internal welding

FOR ELECTRODES WITH 1.6 AND 2.4 MM DIAMETER.

ELECTRODE ADAPTER APPLICABLE UP TO MAX. TUBE INNER DIAMETER

	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW38S	18,0	0.709	36,6	1.441
OW76S/OWX 3.0	18,0	0.709	75,5	2.972
OW115S	20,0	0.787	113,5	4.469
OW170	20,0	0.787	168,5	6.600

MAX. ADJUSTABLE WELDING DEPTH (ROTOR CENTER TO ELECTRODE)

	ELEKTRODE 1,6 MM		ELEKTRODE 2,4 MM	
	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW38S	52,0	2.047	47,0	1.850
OW76S/OWX 3.0	52,0	2.047	47,0	1.850
OW115S	110,0	4.331	105,0	4.134
OW170	110,0	4.331	105,0	4.134

A clamping insert blank is mandatory for the non-workpiece-receiving weld head side and must be ordered separately.

See "Clamping insert blanks" on page 48

ELECTRODE ADAPTER SETS FOR INTERNAL WELDING	CODE	KG
Electrode adapter set OW 38S internal welding	826 050 037	0.071
Electrode adapter set OW 76S/OWX 3.0 internal welding	827 050 039	0.071
Electrode adapter set OW 115 S internal welding	828 050 024	0.193
Electrode adapter set OW 170 internal welding	825 050 026	

Table mounts

Practical and sturdy aluminum table mount (anodized).

The mount allows a convenient and secure placing and fixating of the ORBIWELD orbital weld heads.

The mount can be mounted rapidly and easily at the worktop by means of the integrated table clamp. Thus the weld head can be firmly fixed in the mount – also ideal for temporary placement of the weld head between individual weldings.

TECHNICAL SPECIFICATIONS	TABLE MOUNTS
Dimensions (LxDxH)	180 x 140 x 185 mm 7.1" x 5.5" x 7.3"
Clamping range (from bottom surface of table to maximum extended screw clamp)	max. 65 mm / 2.56"

ITEM	CODE	KG
Table mount for OW 38S, OW 76S	826 030 006	1.250
Table mount for OW 65, OW 115S, OW 170	823 030 006	1.070

*via adapter included in scope of delivery

See also "Table mount OWX" on page 62



Table mounts

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- ORBIPURGE forming set, see page 107
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

CLOSED ORBITAL WELD HEADS


HX 12P, HX 25P

NEW

Closed orbital weld heads

Weld stainless steel pipes economically and with high quality with the TIG procedure:

The worldwide unique HX orbital weld heads with their automated welding technology are THE solution for an efficient as well as high-quality production. Pre-mounted tube elbows such as in heat exchanger production, even in narrow pipe bundles, can be connected reliably, quickly and securely with stainless steel pipes.



Dramatically shorter welding times Welding times 30 s per pipe	✓
Up to 250 welds per head and shift	✓
50% less preparation time in contrast to manual work	✓
Pipe spacings: HX 12P: Below 40 mm (1:57") HX 25P: Below 60 mm (2:36")	✓
For pipe outer diameters: HX 12P: 9.5 ... 13.3 mm (0.37" ... 0.52") HX 25P: 18.0 ... 25.4 (0.71" ... 1:00")	✓
Highly resilient through liquid-cooled rotor housing	✓
Horizontal, lateral and inclined weld- ing position possible	✓
Very robust and ergonomic design	✓
Best welding results even with semi-skilled personnel	✓

In addition to the HX 12P and HX 25P, this series also includes the HX 16P.

The welding of tube elbows in heat exchanger production is laborious for a manual welding procedure. In the long run it is also not ensured that the welder reaches a constantly high quality and thus achieves sealing of all tube elbows. This results in expensive rework and high reject rates.

While conventional heads require a lot of space between the tubes for positioning, the narrow HX heads allow for very compact heat exchangers with high tube density and thus a high degree of effectiveness to be achieved. Pipe spacings under 40 mm (1.57") are possible with the HX 12P and under 60 mm (2.36") with the HX 25P.

Handling is also easy: The HX head is swiveled open, laid around the pipe and fixated pneumatically self-retaining at the push of a button. A limit stop with rough and fine adjustment helps with secure

positioning at the tube. After the starting process the water-cooled head is flooded with argon gas and welding takes place automatically in consistent quality. The Orbitalum system ensures a clean weld penetration completely without recess, gaps or grates inside the tube. Clamping and starting is carried out via the button at the weld head.

Best welding results - even with semi-skilled personnel

The Orbitalum welding power sources automatically detect the connected HX head with its provided parameters, so that the operator only has to call up their specified welding program and start the process before beginning to weld. Working with the Orbitalum system is so easy and reliable that even semi-skilled operators achieve top welding results. Practice has shown that with the Orbitalum system the reject rate is reduced from 4% to below 0.7%. Another advantage: An operator can operate multiple weld heads at the same time – which significant-

ly increases the manufacturing efficiency. The closed weld chamber and continuous process also result in no annealing colors arising, so that expensive rework such as pickling or passivating is generally not required.

Compact design results in simple handling.

In contrast to open weld heads, all connections for current, gas and cooling water are integrated in the HX head. For good handling the Orbitalum heads are connected with a 7.5 m long, flexible hose with the welding power supply. The HX 12P and HX 25P furthermore impresses with a very straight design, which allows for easy rotation of the head at the heat exchanger. The entire unit can be hung on a balancer to relieve the operator.



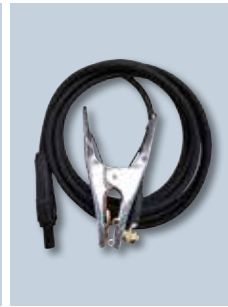
Extremely narrow design - ideal for welding pre-mounted arcs in narrow pipe bundles



Including pneumatic box



Optionally available:
Diameter-specific
Clamping inserts



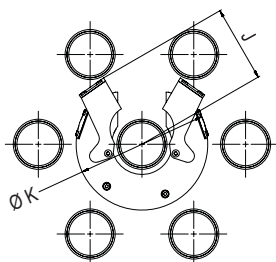
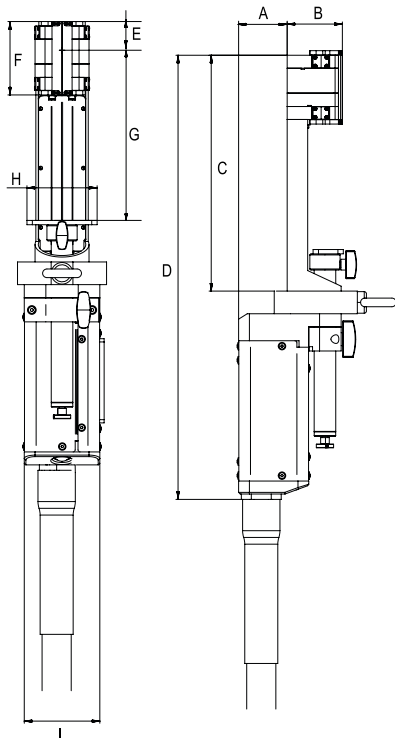
Optionally available:
Ground cable



Optionally available:
Adjustable bar pressure reducer
for argon



The perfect supplement: Orbital
welding power sources ORBIMAT



APPLICATION AREA	HX 12P	HX 25P		
Code	847 000 010	845 000 010		
Pipe OD, min. - max.*	9.5 - 13.3 mm/0.374" - 0.524"	18.0 - 25.4 mm/0.708" - 1.000"		
Wall thickness, min. - max.	0.5 - 0.8 mm/0.02" - 0.03"	0.5 - 1.0 mm/0.016" - 0.039"		
TECHNICAL SPECIFICATIONS	HX 12P	HX 25P		
Electrode diameter	1.6 mm/0.063"	1.6 mm/0.063"		
Machine weight including hose package	6.4 kg/14.1lbs	18.5 kg/40.8 lbs		
Hose package length	7.5 m/24.6 ft	7.5 m/24.6 ft		
TECHNICAL SPECIFICATIONS	PNEUMATICS BOX	PNEUMATICS BOX		
Input medium	Argon	Argon		
Recommended input pressure	6 bar / 87 PSI	6 bar / 87 PSI		
DIMENSIONS	HX 12P	HX 25P		
	[mm]	[inch]	[mm]	[inch]
Dimension "A"	45.0	1.772	62.0	2.441
Dimension "B"	52.0	2.047	68.0	2.677
Dimension "C"	219.0	8.622	278.0	10.945
Dimension "D"	412.0	16.220	496.0	19.528
Dimension "E" (electrode), min.	30.0	1.181	35.0	1.378
Dimension "F"	70.0	2.756	80.0	3.150
Dimension "G" to max.	155.0	7.283	210.0	8.268
Dimension "H"	65.0	2.559	80.0	3.150
Dimension "I"	70.0	2.756	100.0	3.937
Dimension "J" (Ø)	33.0	1.299	43.0	1.693
Dimension "K"	50.0	1.969	72.0	2.835
SCOPE OF DELIVERY	HX 12P	HX 25P		
Orbital weld head of the HX series	PCS. 1	1		
transport case	PCS. 1	1		
Pneumatics box	PCS. 1	1		
Supply hose (2 m/6.56 ft) for pneumatics box	PCS. 1	1		
Swivel bracket pair	Pair 1	1		
Elbow stop	PCS. 1	1		
Tool set	set 1	1		
Operating instructions and spare part list	set 1	1		
SUITABLE ACCESSORIES:				
Optionally available:	<ul style="list-style-type: none">• Clamping inserts• Bar pressure reducer "Argon"• Ground cable• WS2 tungsten electrodes• ESG electrode grinders			

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

* Other dimensions on request




HX 16P

Closed orbital weld head

The orbital weld heads HX for compact cooling systems set new standards!

HX stands for heat exchanger and for the welding of pre-mounted elbows in tight tube bundles of fin heat exchangers. There is no other solution as effective as this one in the world!



Best welding results even with semi-skilled personnel	✓
50% less preparation time in contrast to manual work	✓
Pneumatic tension for easy mounting on the tube elbows	✓
Highly resilient through liquid-cooled rotor housing	✓
Horizontal, lateral and inclined weld- ing position possible	✓
Very robust and ergonomic design	✓
Easy and quick mounting on the pipe	✓
Self-retaining weld head through patented piston fixation saves up to 80% Preparation time	✓
External fitting for adjustment of the electrode position	✓

All common closed or open orbital weld heads are not suitable for their positioning between individual tubes of fin heat exchangers because of their size.

The HX series impresses in terms of economy and efficiency when compared to conventional machines in several ways: The tube ends of the heat exchanger can be fully fitted with elbows before welding and then welded in any order. For conventional orbital weld heads, the principle of fit elbow, weld, fit elbow, weld etc. applies, always starting from the center of the tube sheet and working outward. If quality testing reveals a faulty weld later on, all elbows must be disconnected and new ones must be welded on in the worst case scenario (fault in the middle of the bundle) due to the accessibility factor. With the HX head, only the affected elbow would have to be replaced. This design-based advantage also makes the Orbitalum system the ideal tool for unbeatably cost-effective repairs.

In contrast to open weld heads with a cumbersome hose assembly, all connections for power, gas and cooling water are permanently integrated in the HX.

All orbital welding power sources from Orbitalum automatically detect the head and its properties so that, before beginning to weld, the operator only has to call up their specified welding program and start the welding process.

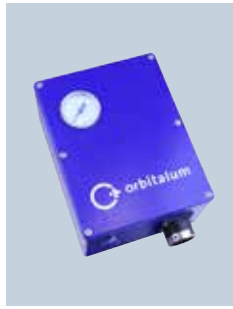
Traditionally, complex heat exchangers for cooling systems were made of copper, and soldered with the tube elbows. The high price of copper prompted manufacturers to switch over to stainless steel for production. Stainless steel can only be joined economically, reliably and in high quality with tungsten inert gas (TIG) welding in conjunction with mechanized orbital welding.



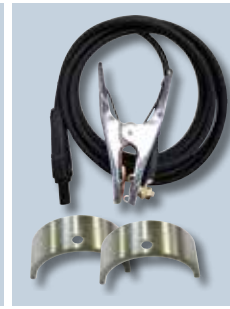
Extremely narrow design - ideal for welding pre-mounted arcs in narrow pipe bundles



All connections for electricity, gas and cooling water are firmly integrated



Including pneumatic box



Optionally available:
Diameter-specific clamping inserts and ground cable



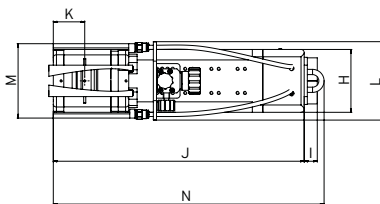
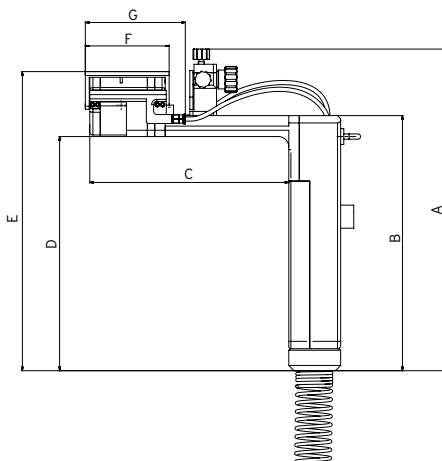
Adjustable bar pressure reducer for argon for pneumatic clamping of the HX 16P - available separately



The perfect supplement: Orbital welding power sources ORBIMAT



HX 16P



APPLICATION AREA		HX 16P	
Code		848 000 010	
Tube OD, min. - max.*	[mm]	15.0 - 16.8	
	[inch]	0.591 - 0.661	
TECHNICAL SPECIFICATIONS		HX 16P	
Electrode diameter	[mm]	1.6	
	[inch]	0.063	
Machine weight including hose package	[kg]	5.9	
	[lbs]	13.0	
Hose package length	[m]	7.5	
	[ft]	24.6	
TECHNICAL SPECIFICATIONS		PNEUMATICS BOX	
Input medium		Argon	
Recommended input pressure	[bar]	8	
	[PSI]	116	
DIMENSIONS		HX 16P	
		[mm]	[inch]
Dimension "A"		307.00	12.087
Dimension "B"		243.50	9.587
Dimension "C"		190.00	7.480
Dimension "D"		223.50	8.799
Dimension "E"		285.50	11.240
Dimension "F"		80.00	3.150
Dimension "G"		95.45	3.758
Dimension "H"		60.00	2.362
Dimension "I"		12.50	0.492
Dimension "J"		239.50	9.429
Dimension "K" (electrode)		30.00	1.181
Dimension "L"		74.85	2.947
Dimension "M"		71.00	2.795
Dimension "N"		258.50	10.177
SCOPE OF DELIVERY		HX 16P	
Orbital weld head of the HX series	PCS.	1	
transport case	PCS.	1	
Pneumatics box	PCS.	1	
Supply hose (2 m/6.56 ft) for pneumatics box	PCS.	1	
Swivel bracket pair	Pair	1	
Elbow stop	PCS.	1	
Sheet stop alignment kit	PCS.	1	
Tool set	set	1	
Operating instructions and spare part list	set	1	
SUITABLE ACCESSORIES:			
Optionally available:		<ul style="list-style-type: none">• Clamping inserts• Bar pressure reducer "Argon"• Ground cable• WS2 tungsten electrodes• ESG electrode arinders	

* Other dimensions on request

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.



HX 12P / HX 25P



HX 16P



Pneumatics box
(included in the scope of delivery of the HX heads)

Closed orbital weld heads

HX 12P, HX 16P, HX 25P

Properties, application area, technical specifications and delivery scope, see page 70 and page 72.

The following accessories are mandatory for the use of the HX orbital weld heads and must be ordered separately:

- Clamping inserts, see page 75
- Ground cable, see page 107
- Bar pressure reducer "Argon", see page 75

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head HX 12P	847 000 010	6.400	14.100
Orbital weld head HX 16P	848 000 010	5.900	16.600
Orbital weld head HX 25P	845 000 010	18.500	40.800

* Machine weight including hose package

Suitable accessories (optionally available):

- Clamping inserts, see page 75
- Bar pressure reducer "Argon", see page 75
- Ground cable, see page 107
- WS2 tungsten electrodes, see page 108
- ESG electrode grinders, see page 100
- Welding current connection adapter set, see page 109
- Balancer spring, see page 96

CLOSED ORBITAL WELD HEADS

Accessories for HX

Clamping inserts

Made of stainless steel.

Two clamping inserts are required for each tube diameter.

Further dimensions on request.



Clamping inserts

ITEM	TUBE OD		FOR HX 12P		FOR HX 16P		FOR HX 25P	
	[MM]	[INCH]	CODE	KG	CODE	KG	CODE	KG
Clamping insert	9.50	0.374	847 002 020	0.018	-	-	-	-
Clamping insert	11.00	0.433	847 002 027	0.003	-	-	-	-
Clamping insert	12.00	0.472	847 002 021	0.018	-	-	-	-
Clamping insert	12.40	0.488	847 002 026	0.002	-	-	-	-
Clamping insert	12.43	0.489	847 002 024	-	-	-	-	-
Clamping insert	12.70	0.500	847 002 023	0.018	-	-	-	-
Clamping insert	13.30	0.524	847 002 025	0.002	-	-	-	-
Clamping insert	15.00	0.591	-	-	848 002 303	0.005	-	-
Clamping insert	15.75	0.620	-	-	848 002 305	0.004	-	-
Clamping insert	15.88	0.625	-	-	848 002 306	0.002	-	-
Clamping insert	16.00	0.630	-	-	848 002 307	0.002	-	-
Clamping insert	16.20	0.638	-	-	848 002 308	0.002	-	-
Clamping insert	16.30	0.642	-	-	848 002 309	0.002	-	-
Clamping insert	16.50	0.650	-	-	848 002 310	0.002	-	-
Clamping insert	16.60	0.654	-	-	848 002 311	0.002	-	-
Clamping insert	18.00	0.709	-	-	-	-	-	-
Clamping insert	19.05	0.750	-	-	-	-	-	-
Clamping insert	20.00	0.787	-	-	-	-	845 002 210	-
Clamping insert	22.00	0.866	-	-	-	-	845 002 208	-
Clamping insert	22.22	0.875	-	-	-	-	845 002 214	-
Clamping insert	23.00	0.906	-	-	-	-	845 002 211	-
Clamping insert	25.00	0.984	-	-	-	-	845 002 209	-
Clamping insert	25.40	1.000	-	-	-	-	845 002 212	-

Bar pressure reducer "Argon"

Adjustable bar pressure reducer for argon for pneumatic clamping of the HX.

TECHNICAL SPECIFICATIONS	BAR PRESSURE REDUCER "ARGON"
Max. input pressure	230 bar
Output pressure	0 - 10 bar
Bottle connection	W21.8x1/14"
Hose connection	G 1/4"



Bar pressure reducer "Argon"

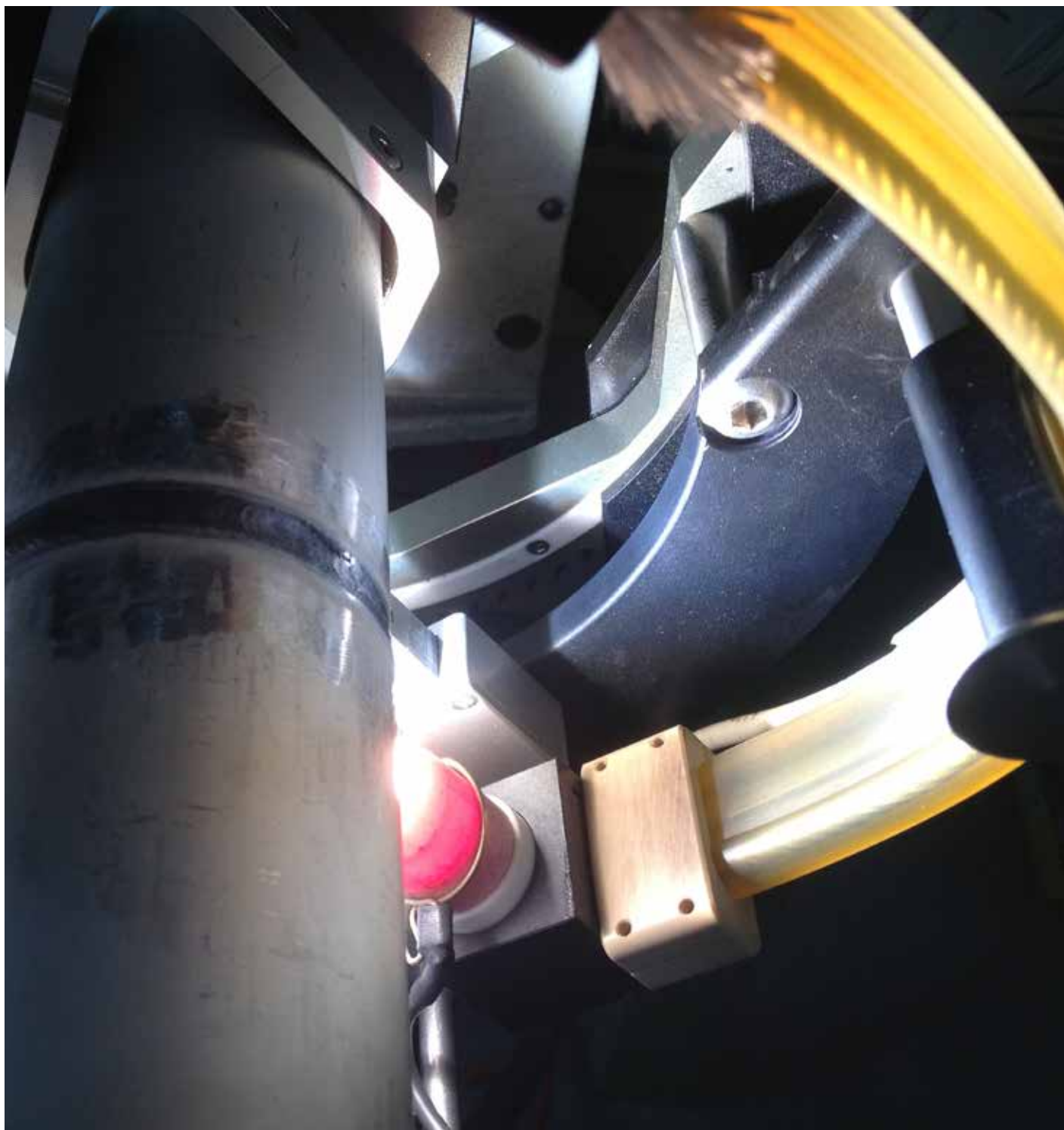
ITEM	CODE	KG
Bar pressure reducer "Argon"	888 000 006	1.428

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- WS2 tungsten electrodes, see page 108
- Welding current connection adapter set, see page 109

CLOSED ORBITAL WELD HEADS

Open orbital weld heads

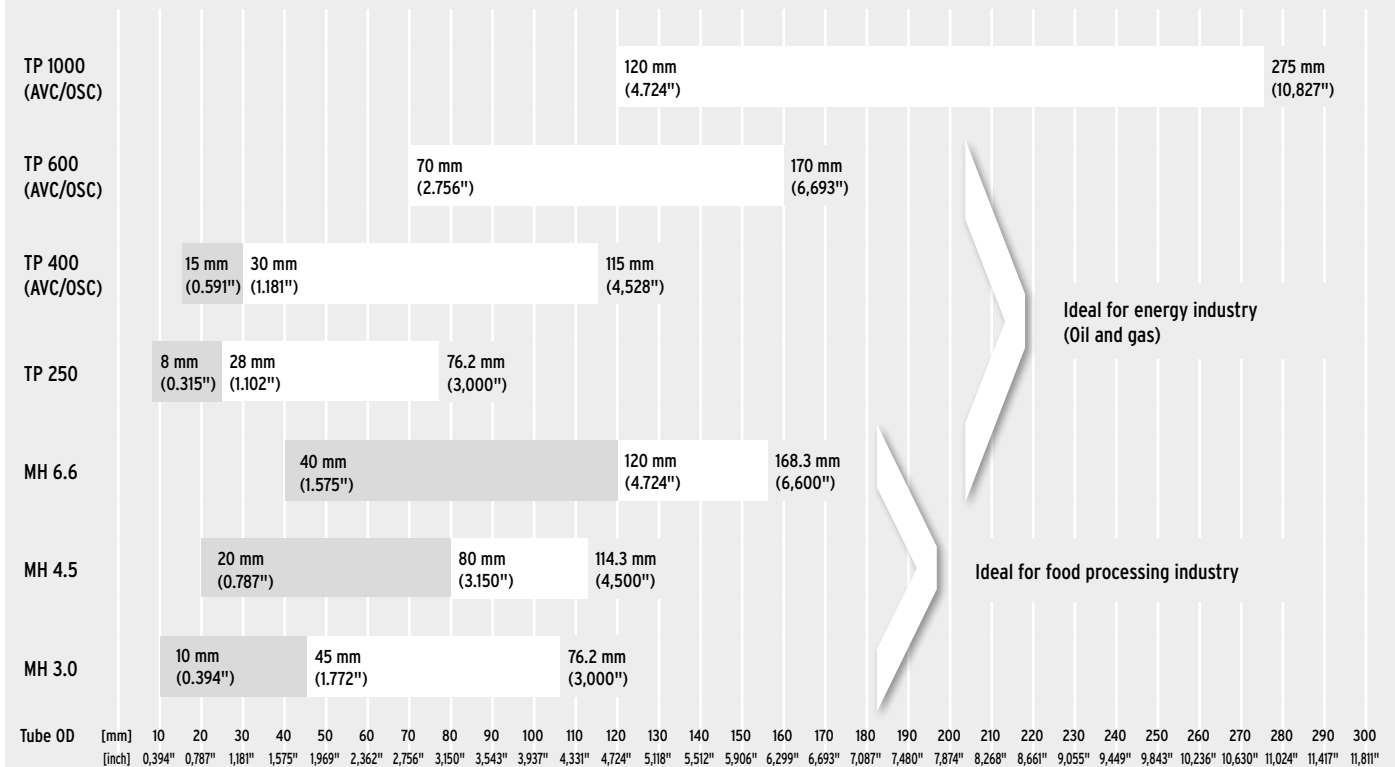


Overview of open orbital weld heads

MODEL		TP 250	TP 250	TP 400	TP 400	TP 400	TP 600	TP 600	TP 600	TP 1000	TP 1000	TP 1000
WITH COLD WIRE UNIT (KD):			KD 4		KD3-100	KD3-100		KD3-100	KD3-100		KD3-100	KD3-100
WITH ARC GAP CONTROL (AVC) AND OSCILLATION (OSC):					AVC/OSC			AVC/OSC				AVC/OSC
CODE		811 000 001	811 000 005	812 000 010	812 000 011	812 000 012	813 000 001	813 000 011	813 000 002	814 000 001	814 000 005	814 000 002
APPLICATION AREA	[mm]	8 - 28 28 - 76.2		(15)** 30 - 115			70 - 170			120 - 275		
	[inch]	0.315 - 1.102 1.102 - 3.000		(0.591)** 1.181 - 4.528			2.756 - 6.693			4.724 - 10.827		
ELECTRODE LENGTHS	[mm]	18 - 32		30 - 55			30 - 55			30 - 55		
	[inch]	0.709 - 1.260		1.181 - 2.165			1.181 - 2.165			1.181 - 2.165		
WIRE DIAMETER*	[mm]	0.8*		0.8*			0.8*			0.8*		
	[inch]	0.031*		0.031*			0.031*			0.031*		
WEIGHT	[kg]	7.0	8.9	11.0	12.5	15.2	13.7	15.2	18.9	22.5	24.0	28.7
	[lbs]	15.4	19.6	24.3	27.6	33.5	30.2	33.5	41.7	49.6	52.9	63.3
MAX. WELD CURRENT	[A]	200		250								

* Wire diameter 1.0 mm (0.039") is available separately.

MODEL		MH 3.0	MH 4.5	MH 6.6
CODE		803 000 001	804 000 001	805 000 001
APPLICATION AREA	[mm]	10 - 30 30 - 45 45 - 76.2	20 - 40 40 - 80 80 - 114.30	40 - 80 80 - 120 120 - 168.30
	[inch]	0.394 - 1.181 1.181 - 1.772 1.772 - 3.000	0.787 - 1.575 1.575 - 3.150 3.150 - 4.500	1.575 - 3.150 3.150 - 4.724 4.724 - 6.600
ELECTRODE LENGTHS	[mm]	30 - 55	30 - 55	30 - 55
	[inch]	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165
WEIGHT	[kg]	4.24	5.42	6.11
	[lbs]	9.35	11.95	13.47
MAX. WELD CURRENT	[A]	140		



Mobile Head MH

Open orbital weld heads

Tube to tube, tube to fitting - The open orbital weld heads of the MH series are impressive with a diverse range of applications. What is more, they have a narrow and very lightweight design. As a result, the Mobile Head series is perfectly suitable for use at construction sites.

MH 4.5 front view



MH 4.5 control panel



The open orbital weld heads of the MH series are used wherever thin-walled stainless steel tubes are welded in tube installation. They have a compact design and are equipped with a narrow weld head housing with the result that it is possible to weld even under narrow conditions. The Mobile Head is compatible with the orbital welding power supplies of the SW series and the Mobile Welder.

Flexible in application

The gas-cooled, infinitely variable swiveling torch body can be adjusted in position and angle and in addition to the classic tube I-seam applications, among others, makes it possible to weld fillet welds as well. The weld heads can be used flexibly, without additional accessories, in the widest range of applications, e.g. Tube to tube, tube to fitting and tube to extrusion. The mechanically adjustable electrode scanning guarantees in addition a consistent electrode gap during the entire welding process.

Mobile in use

The Mobile Head series is impressive, with a light (4-6 kg) and as a result is ideally suited for mobile use in the assembly environment. Every relevant operating function can be accessed right on the weld heads via the control panel integrated in the handheld. What is more, the open orbital weld heads are easy to operate. All of the main mechanical adjustments can be made without any tools.

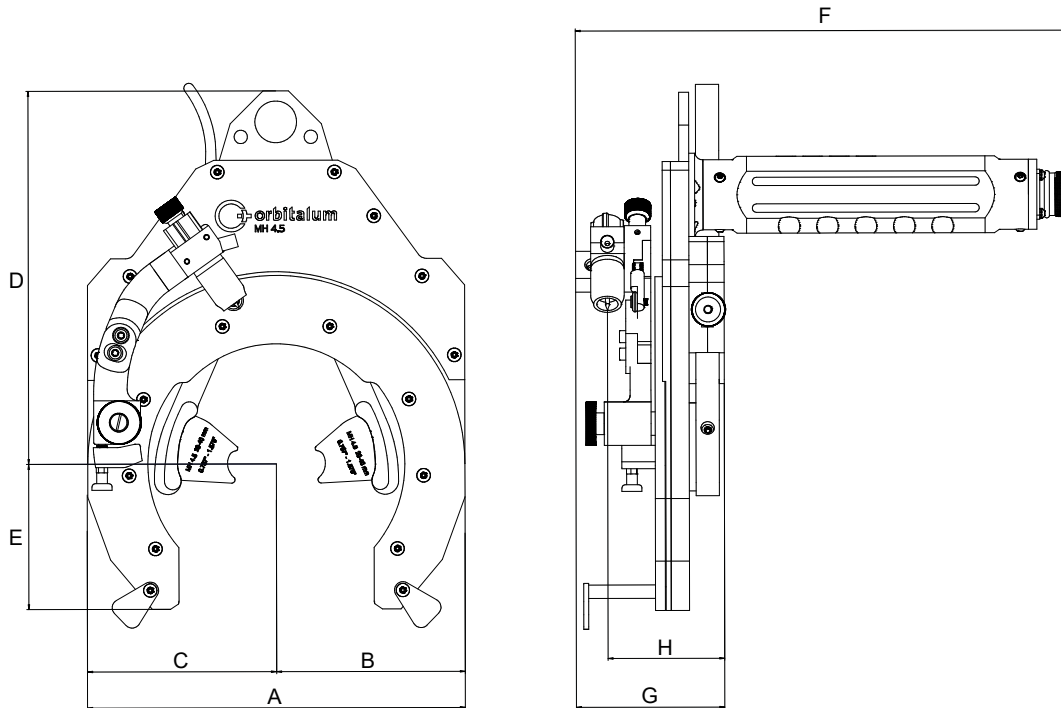
The rotating scanning wheel protects the tube surface and thus prevents damage caused by scanning.

Different tube diameters

The open orbital weld heads of the MH series can be adjusted to the desired tube diameter via an infinitely variable clamping mechanism in order to fix the weld heads in place on the tube securely and free of play.

The clamping range can be easily expanded by using the reduction jaws included in the scope of delivery.

The MH series consists of three different sizes and as a result covers a broad range of tube dimensions: MH3.0, MH4.5, MH6.6.

DIMENSIONS (MH4.5 SHOWN AS AN EXAMPLE, VALUES, SEE TABLE):

ORBITAL WELD HEADS		MH 3.0	MH 4.5	MH 6.6
Code		803 000 001	804 000 001	805 000 001
TECHNICAL SPECIFICATIONS				
Application area	[mm]	10 - 76,20	20 - 114,30	40 - 168,30
	[inch]	0.394 - 3.000	0.787 - 4.500	1.575 - 6.626
Electrode lengths	[mm]	30 - 55	30 - 55	30 - 55
	[inch]	1.181-2.165	1.181-2.165	1.181-2.165
Machine weight including power/gas cable	[kg]	4,24	5,42	6,11
	[lbs]	9,35	11,95	13,47
Power/gas hose length	[m]	7,00	7,00	7,00
	[ft]	23,00	23,00	23,00
Dimension "A":	[mm]	150,00	226,00	290,00
	[inch]	5,91	8,90	11,42
Dimension "B":	[mm]	75,00	113,00	145
	[inch]	2,95	4,45	5,71
Dimension "C":	[mm]	75,00	113,00	145
	[inch]	2,95	4,45	5,71
Dimension "D":	[mm]	171,50	223,5	251,00
	[inch]	6,75	8,799	9,92
Dimension "E":	[mm]	60,99	87,00	110
	[inch]	2,40	3,43	4,33
Dimension "F":	[mm]	296,70	296,70	296,70
	[inch]	11,68	11,68	11,68
Dimension "G":	[mm]	88,90	88,90	88,90
	[inch]	3,50	3,50	3,50
Dimension "H":	[mm]	69,90 - 73,90	69,90 - 73,90	69,90 - 73,90
	[inch]	2,75 - 2,909	2,75 - 2,909	2,75 - 2,909

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

ORBITAL WELD HEADS		MH 3.0	MH 4.5	MH 6.6
Code		803 000 001	804 000 001	805 000 001
SCOPE OF DELIVERY				
Transport box		●	●	●
Consumables/set of tools		●	●	●
MH 3.0 reduction jaws 10 - 30 mm (0.394 - 1.181 in)		●	○	○
MH 3.0 reduction jaws 30 - 45 mm (1.181 - 1.772 in)		●	○	○
MH 4.5 reduction jaws 20 - 40 mm (0.787 - 1.575 in)		○	●	○
MH 4.5 reduction jaws 40 - 80 mm (1.575 - 3.150 in)		○	●	○
MH 6.6 reduction jaws 40 - 80 mm (1.575 - 3.150 in)		○	○	●
MH 6.6 reduction jaws 80 - 120 mm (3.150 - 4.724 in)		○	○	●
Operating instructions with spare parts list		●	●	●
OTHER FEATURES				
Electrode angle adjustment		●	●	●
Electrode gap spacer		●	●	●
Infinitely variable adjustable clamping system		●	●	●
Swiveling torch body		●	●	●
Integrated control panel		●	●	●
Safety eyelet		●	●	●
Torch arm bracket adjustable		●	●	●
Torch fine-tuning		●	●	●
Torch arm latch		●	●	●

● = Function included

○ = Function not included



Mobile Head MH 4.5

Open orbital weld heads MH

Mobile Head MH 3.0

Mobile Head MH 4.5

Mobile Head MH 6.6

Properties, application area, technical specifications and delivery scope, see from page 81.

The following accessories are mandatory for the use of the MH orbital weld heads and must be ordered separately:

- Control cable, see page 107
- Ground cable, see page 107

ITEM	CODE	MACHINE WEIGHT KG*
Mobile Head MH 3.0	803 000 001	4.240
Mobile Head MH 4.5	804 000 001	5.420
Mobile Head MH 6.6	805 000 001	6.110

* Machine weight including power/gas cable.

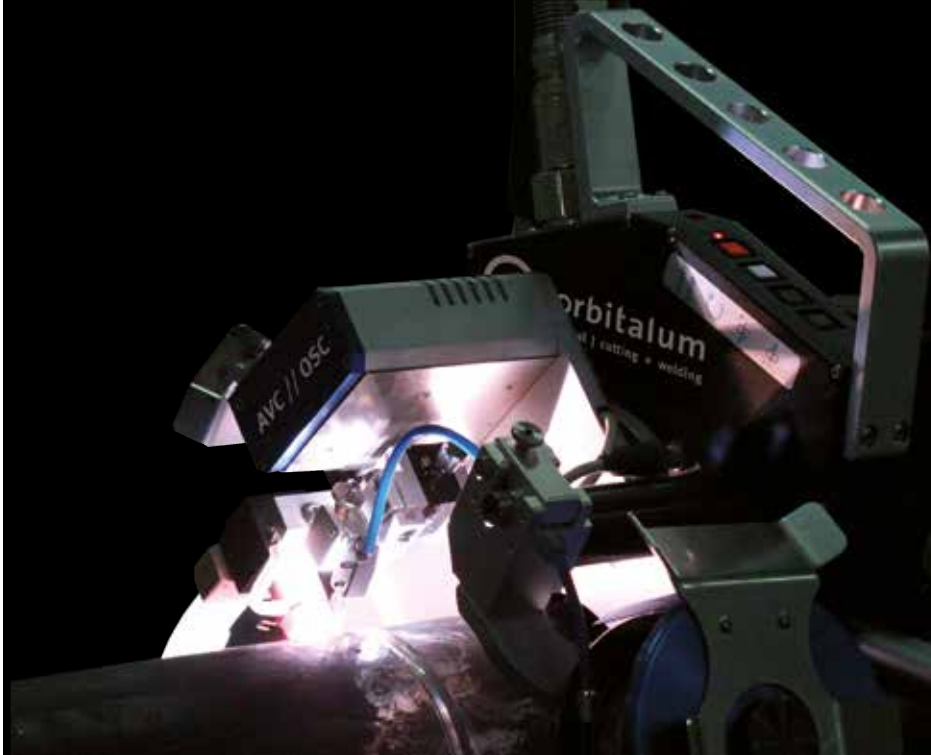
Suitable accessories (optionally available):

- Ground cable, see page 107
- Control cable, see page 107
- Hose assembly extensions, see page 108
- ORBmax residual oxygen meter, see page 104
- ORBIPURGE Forming set, see page 107
- WS2 tungsten electrodes, see page 108
- Electrode grinders ESG, see page 100

ORBIWELD TP

Open orbital weld heads

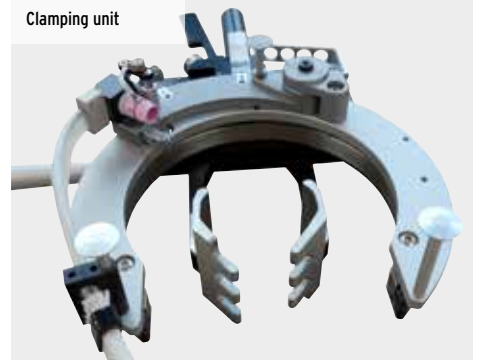
The ORBIWELD TP series is unique in design and functionality: Through the drive motor completely integrated into the housing an extremely compact design is realized. The drive concept furthermore makes the large and laborious gearing of conventional weld heads superfluous. This compact design offers huge advantages at mobile construction site operations.



TP 400 AVC/OSC



Clamping unit



PROPERTIES OF THE TP SERIES:

- Compact design without interfering protrusions
- Can be used with and without cold wire feeding
- Cold wire unit can be retrofitted at all TP heads
- Wire coil for mounting of the filler wire at TIG cold wire welding is mounted on the weld head housing for KD3 variants. This prevents disruptive twisting of the wire during welding
- Wire feed nozzle exactly adjustable vertically and horizontally
- Open arc system
- Infinitely variable adjustable clamping mechanism
- Liquid-cooled steplessly swiveling TIG torch head allows the welding of fillet welds or short tube collards
- TIG torch head is attached on an adjustable slide which allows precise fine-tuning of the electrode position even during the welding process
- Simple, toolless adjustment of the clamping unit onto the tube diameter

- By default TP 1000 heads are equipped with clamping plates made of tool steel which secure an optimum support on the tube surface. The tube clamping for ORBIWELD TP 250, TP 400 and TP 600 is effected by means of clamping jaws made of stainless steel (1.4305). In addition to more clamping power this new clamping system offers an even easier and more precise alignment of the weld heads on the tube. Clamping jaws for clamping range extension (TP 400) are available optionally. The new clamping unit can be retrofitted for older TP 250, TP 400- and TP 600 models
- TP heads can be easily centered at the tube and are clamped via clamping levers
- Through the operating buttons integrated directly in the housing no additional remote control is required

ADDITIONAL CHARACTERISTICS TP AVC/OSC:

- With oscillation (OSC) and electronic arc gap con-

- trol (AVC) – only in combination with the welding power supply ORBIMAT 300 CA AVC/OSC
- The arc length is kept mechanically at a constant distance; for AVC/OSC versions the constant distance spacing is effected automatically
- Can be used for thick-walled tubes (multi-layer weldings)
- Motor drive possibility ranging across the entire nominal diameter range of the TIG torch so that no additional mechanical basic default value is necessary a changed tube diameter
- Max. oscillation path of the torch: 20 mm (0,787")
- Complete with cold wire feed unit mounted directly on the weld head with mount for a D 100 mm/1 kg (3.937"/2.2 lbs) standard coil

MODEL		TP 250	TP 250	TP 400	TP 400	TP 400	TP 600	TP 600	TP 600	TP 1000	TP 1000	TP 1000
With cold wire unit (KD):			KD4		KD3-100	KD3-100		KD3-100	KD3-100		KD3-100	KD3-100
With arc gap control (AVC) and oscillation (OSC):					AVC/OSC	AVC/OSC			AVC/OSC			AVC/OSC
Code		811 000 001	811 000 005	812 000 010	812 000 011	812 000 012	813 000 001	813 000 005	813 000 002	814 000 001	814 000 005	814 000 002
Application area	[mm]	8 - 28 28 - 76.2	8 - 28 28 - 76.2	(15)*/30 - 115	(15)*/30 - 115	(15)*/30 - 115	70 - 170	70 - 170	70 - 170	120 - 275	120 - 275	120 - 275
	[inch]	0.315 - 1.102 1.102 - 3.000	0.315 - 1.102 1.102 - 3.000	(0.591)*/ 1.181 - 4.528	(0.591)*/ 1.181 - 4.528	(0.591)*/ 1.181 - 4.528	2.756 - 6.693	2.756 - 6.693	2.756 - 6.693	4.724 - 10.827	4.724 - 10.827	4.724 - 10.827
Electrode lengths	[mm]	18 - 32	18 - 32	30 - 55	30 - 55	30 - 55	30 - 55	30 - 55	30 - 55	30 - 55	30 - 55	30 - 55
	[inch]	0.709 - 1.260	0.709 - 1.260	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165	1.181 - 2.165
Wire diameter*	[mm]	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**	0.8/ 1.0**
	[inch]	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**	0.031/ 0.039**
Machine weight including hose package	[kg]	7.0	8.9	11.0	12.5	15.2	13.7	15.2	18.9	22.5	24.0	28.7
	[lbs]	15.4	19.6	24.3	27.6	33.5	30.2	33.5	41.7	49.6	52.9	63.3
Hose package length	[m]	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5	7.5
	[ft]	24.6	24.6	24.6	24.6	24.6	24.6	24.6	24.6	24.6	24.6	24.6
Dimension "A":	[mm]	86.00	86.00	108.00	108.00	150.00	147.00	147.00	185.00	215.00	215.00	245.00
	[inch]	3.386	3.386	4.252	4.252	5.906	5.787	5.787	7.283	8.465	8.465	9.646
Dimension "B" without cold wire KD:	[mm]	86.00	86.00	108.00	-	-	147.00	-	-	215.00	-	-
	[inch]	3.386	3.386	4.252	-	-	5.787	-	-	8.465	-	-
Dimension "C": with cold wire KD:	[mm]	-	-	-	180.00	175.00	-	196.00	215.00	-	237.00	274.00
	[inch]	-	-	-	7.087	6.890	-	7.717	8.465	-	9.331	10.787
Dimension "D":	[mm]	85.00	85.00	120.00	182.00	182.00	140.00	140.00	186.00	170.00	170.00	206.00
	[inch]	3.346	3.346	4.724	7.165	7.165	5.512	5.512	7.323	6.693	6.693	8.110
Dimension "E":	[mm]	74.00	74.00	90.00	165.00	165.00	97.00	97.00	172.00	146.00	146.00	191.00
	[inch]	2.913	2.913	3.543	6.496	6.496	3.819	3.819	6.772	5.748	5.748	7.520
Dimension "F":	[mm]	125.00	125.00	200.00	200.00	200.00	202.00	202.00	202.00	270.00	270.00	270.00
	[inch]	4.921	4.921	7.874	7.874	7.874	7.953	7.953	7.953	10.630	10.630	10.630
Dimension "G":	[mm]	275.78	275.78	387.54	387.54	387.54	417.78	417.78	417.78	478.67	478.67	478.67
	[inch]	10.858	10.858	15.258	15.258	15.258	16.448	16.448	16.448	18.845	18.845	18.845
Integrated remote control		●	●	●	●	●	●	●	●	●	●	●
Liquid-cooled torch body		●	●	●	●	●	●	●	●	●	●	●
Swiveling torch body		●	●	●	●	●	●	●	●	●	●	●
Fine-tuning of the electrode position		●	●	●	●	●	●	●	●	●	●	●
Coupling of manual rotation of the rotor		●	●	●	●	●	●	●	●	●	●	●
Infinitely variable adjustable clamping system		●	●	●	●	●	●	●	●	●	●	●
Optional clamping range extension		●	●	●	●	●	○	○	○	○	○	○
Integrated cold-wire feed		○	○	●	●	●	●	●	●	●	●	●
External cold-wire feed		●	●	○	○	○	○	○	○	○	○	○
Fine-tuning of the wire position		●	●	●	●	●	●	●	●	●	●	●
AVC electronic arc gap control***		○	○	○	○	●	○	○	●	○	○	●
OSC oscillation unit***		○	○	○	○	●	○	○	●	○	○	●

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

● = Function included

○ = Function not included

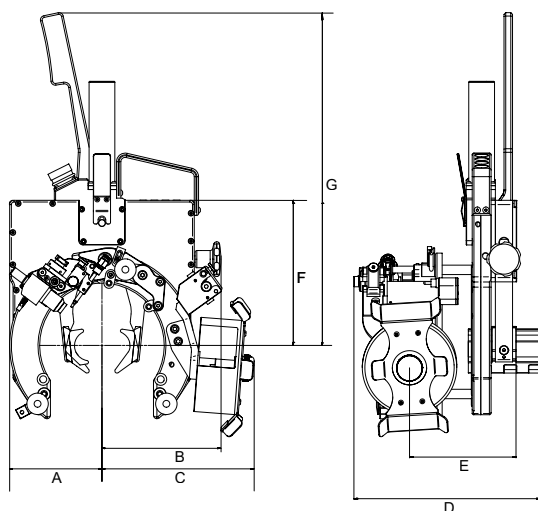
◐ = Function only conditionally included (can be retrofitted)

* with accessories

** KD conversion sets optionally available (page 84)

*** Can only be used in combination with the orbital welding power supply ORBITAT 300 CA AVC/OSC

DIMENSIONS (VALUES, SEE TABLE):



SCOPE OF DELIVERY

Including:

- 1 weld head ORBIWELD TP
- 1 transport case
- 1 handle (TP 1000: 2 pieces)
- 1 expansion jaw set of size 8 - 28 mm/0.315" - 1.102" (TP 250 only)
- 1 tool set
- 1 set of operating instructions and spare parts list

Suitable accessories (optionally available):

- Clamping unit "V2" (retrofitting kits)
- Cold-wire feeds KD (retrofitting kits)
- Expansion jaw sets for TP 400
- Control cable
- Remote control
- ESG electrode grinders
- ORBmax residual oxygen meter
- ORBIPURGE forming set
- Ground cable
- Hose package extensions
- WS2 tungsten electrodes

Open orbital weld heads OW TP

ORBIWELD TP 250 ORBIWELD TP 400 (AVC/OSC) ORBIWELD TP 600 (AVC/OSC) ORBIWELD TP 1000 (AVC/OSC)

Properties, application area, technical specifications and delivery scope, see page 81.

The following accessories are mandatory for the use of the TP orbital weld heads and must be ordered separately:

- Control cable, see page 107
- Ground cable, see page 107

ITEM	WITH COLD WIRE UNIT (KD)	CODE	MACHINE WEIGHT KG**	SHIPPING WEIGHT KG
Open orbital weld head TP 250	-	811 000 001	7.000	15.600
Open orbital weld head TP 250	KD 4	811 000 005	8.900	20.000
Open orbital weld head TP 400	-	812 000 010	11.000	20.000
Open orbital weld head TP 400	KD3-100	812 000 011	12.500	20.000
Open orbital weld head TP 400 AVC/OSC*	KD3-100	812 000 012	15.200	24.800
Open orbital weld head TP 600	-	813 000 010	13.700	23.600
Open orbital weld head TP 600	KD3-100	813 000 011	15.200	30.000
Open orbital weld head TP 600 AVC/OSC*	KD3-100	813 000 012	18.900	33.300
Open orbital weld head TP 1000	-	814 000 001	22.500	38.000
Open orbital weld head TP 1000	KD3-100	814 000 005	24.000	40.900
Open orbital weld head TP 1000 AVC/OSC*	KD3-100	814 000 002	28.700	45.300

* Only usable in connection with an ORBIMAT CA AVC/OSC power source.

** Machine weight including hose package

Suitable accessories (optionally available):

- Cold-wire feeds KD (retrofitting kits), see page 84
- Extension clamping jaw kits for TP 400, see page 84
- Ground cable, see page 107
- Control cable, see page 107
- Remote control, see page 26



ORBIWELD TP 250



ORBIWELD TP 400 KD3-100



ORBIWELD TP 400 AVC/OSC



ORBIWELD TP 600



ORBIWELD TP 1000

OPEN ORBITAL WELD HEADS



KD 4 with opened cover



KD3-100 with Ø 100 standard coil



KD retrofitting kit



Expansion clamping jaw kit for TP 400

Accessories for ORBIWELD TP

Cold-wire feeds KD (retrofitting kits)

The scope of delivery includes:

- 1 feed motor for wire Ø 0.8 mm (0.031")
- 1 wire adjusting unit
- 1 wire nozzle with core (for wire Ø 0.8 mm (0.031"))
- 1 wire coil mounting for Ø 100 mm/1 kg (3.937"/2.2 lbs) standard coils.
- 1 external cold-wire box (only for KD 4)

ITEM	CAN BE USED WITH	CODE	KG
Cold-wire feed KD 4	TP 250	811 050 001	2.110
Cold-wire feed KD3-100*	TP 400*	812 050 061	0.680
Cold-wire feed KD3-100	TP 600	813 050 001	0.680
Cold-wire feed KD3-100	TP 1000	814 050 008	0.720

* Weld heads must be sent in for the retrofitting.

KD retrofitting kits

For retrofitting the cold-wire feed to wire Ø 1.0 mm (0.039").

ITEM	CAN BE USED WITH	CODE	KG
KD retrofitting kit to wire Ø 1.0 mm (0.039")	TP 250	811 050 046	0.115
KD retrofitting kit to wire Ø 1.0 mm (0.039") V2*	TP 400/600/1000 incl. AVC/OSC	812 050 076	0.115

* Please note series no., see above.

Expansion clamping jaw kits

The **expansion jaw kits made of stainless steel** are only available for TP 400 for the extension of the clamping range to a min. of 15.00 mm (0.591").

ITEM	VERSION	TUBE OD [MM]	TUBE OD [INCH]	CODE	KG
Expansion clamping jaw kit for TP 400	Stainless steel	15.00 - 30.00	0.591 - 1.181	812 002 005	0.520

Other accessories for orbital welding

- ESG electrode grinders, see page 100
- ORBmax residual oxygen meter, see page 104
- ORBIPURGE forming set, see page 107
- Hose package extensions, see page 108
- WS2 tungsten electrodes, see page 108
- Torch and cold wire accessories, see page 111
- Ground cable, see page 107

OPEN ORBITAL WELD HEADS

Standard-compliant, precise and reproducible weld seam preparation.

For more than 50 years installation manufacturers have been relying on the standard set by Orbitalum in industrial pipe end preparation: With the pipe saws for the precise cutting in seconds.

Request the following catalog from us to receive more information about this and other products for orbital weld seam preparation:

>>Catalog "Orbital pipe cutting and beveling machines for high-purity process installations"



Tube-to-tube-sheet orbital weld heads





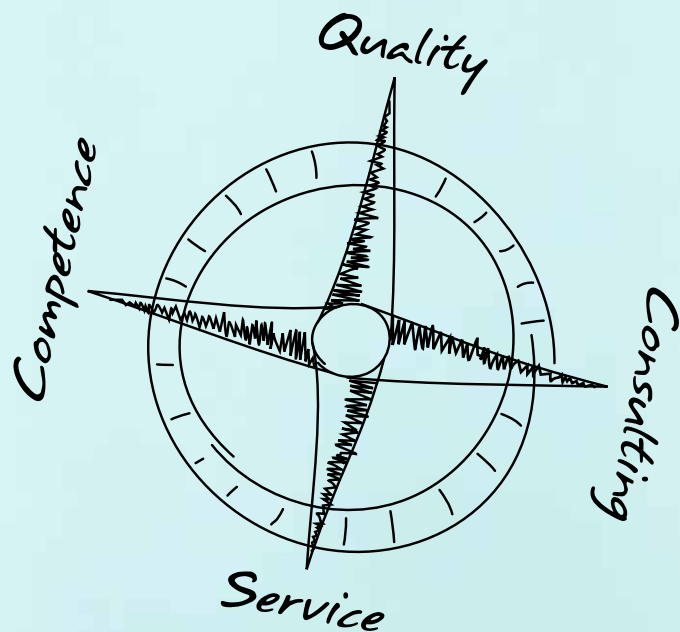
Quality
made in
Germany

Quality products from Orbitalum Tools - always a good decision!

For our products we select the best materials and suitable production processes and already during development place particular on a high degree of quality and durability.

Our machines and tools are assembled, set, controlled and packed by hand by qualified and motivated employees with great care in Singen/Htwl. (Germany).

Our employees guarantee this with their knowledge and their experience.



TX 38P

Orbital TIG orbital weld head for
tube-to-tube sheet connections

Tube-to-tube-sheet orbital weld head

The orbital TIG weld head from Orbitalum for manufacturing pipe-to-pipe-sheet connections guarantees extremely short production times of industrial heat exchangers at constantly high reproducible quality. Also excellently suitable for repair, maintenance and servicing work.



Usable at flush, slightly offset and protruding tube ends



Ideal for the repair and maintenance of generously dimensioned heat exchanging systems



Precise centering of the weld head in the tube thanks to dimensionally stable clamping segments, available for tube inner diameters of 13.8 - 37 mm (0.543 - 1.457 in)

Process heat exchanger tubes particularly effectively and simply: With the TX 38P for automated TIG orbital welding you can in the future weld the base plate and heat exchanger tubes precisely and highly accurately, for example, for thousands of connection at cooling tubes.

In combination with an orbital weld head from ORBITALUM TOOLS the user holds an especially innovative as well economical welding system in their hands: The power sources detect the head automatically, so that before beginning welding only the specified welding program has to be called up and the welding process can be started.

To increase productivity, the optional ORBITWIN switching unit allows working with up to two heads in an alternating fashion, thus reducing conversion times and downtimes considerably.

THE ADVANTAGES AT A GLANCE:

- Handy TIG orbital weld head for welding of tubes

in tube sheets

- Precise work in every position, thus high-quality results at horizontal or vertical tube sheets
- Can be used at flush, slightly offset and protruding tubes
- Compatible with AMI arbors, model 96
- Service-friendly design of the clamping and drive system in the housing
- Self-supporting at tube sheet through stable arbor designs (balancer anchorage point available)
- Limit switch for electrode position; thus start position can be selected freely
- Integrated express setting of the electrode position to the tube diameter
- Constant or pulsed rotor rotation possible (CONT-STEP mode)
- Robust, tachometer-regulated 24 volt drive motor with reduction gears
- Liquid-cooled sliding contact for weld current transfer. As a result no rotary transmission and no leaks
- Including highly flexible hose package

(length: 7.5 m/24.6 ft) with strain relief to the power source - optionally extendable to up to 20.0 m (64 ft)

The highlights of the TX 38P:

- ✓ Pneumatic clamping and centering
- ✓ Liquid-cooled weld head housing
- ✓ One-hand operation
- ✓ Quick change system for arbors
- ✓ Integrated control panel
- ✓ Chambered protective gas cover



Simple and precise setting of the electrode position



One-hand operation through remote control and pneumatics operation integrated in handle



High-quality results at horizontal or vertical pipe sheets



Rapid changing of clamping elements



Optionally available: Ground cable, spring sleeves and diverse clamping segment sizes

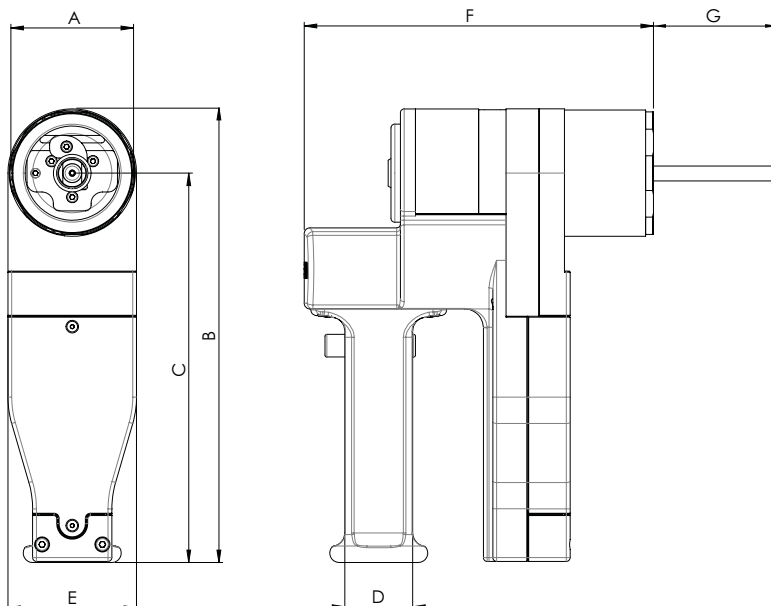


The perfect supplement: Orbital welding power sources of the ORBITAT series

APPLICATION AREA		TX 38P	
Code		830 000 005	
Pipe ID, min. - max.	[mm]	10 - 40	
	[inch]	0.394 - 1.575	
TECHNICAL SPECIFICATIONS			
Weld current, max.	[Amp DC]	150	
Rotation speed, max.	[rpm]	10	
Drive motor with tachometer regulation	[VDC]	24	
Electrode diameter	[mm]	1.6 (optional 2.4)	
	[inch]	0.063 (optional 0.094)	
Gas flow	[l/min]	5 - 20	
Gas type		Argon/argon-helium/argon-hydrogen	
Water pressure max.	[bar]	2.5	
Pneumatics pressure	[bar]	5 - 7	
Hose package length	[m]	7.5	
	[ft]	25	
Machine weight including Hose package	[kg]	7.5	
	[lbs]	16.5	
Connection type		Fully compatible to all Orbitalum power sources	
DIMENSIONS			
Dimension "A"	[mm]	65.0	[inch] 2.559
Dimension "B"	[mm]	241.0	[inch] 9.488
Dimension "C"	[mm]	207.0	[inch] 8.150
Dimension "D"	[mm]	36.0	[inch] 1.417
Dimension "E"	[mm]	68.0	[inch] 2.677
Dimension "F"	[mm]	185.0	[inch] 7.283
Dimension "G"	[mm]	110.0	[inch] 4.331

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

SCOPE OF DELIVERY	
Including:	<ul style="list-style-type: none"> • 1 tube-to-tube-sheet orbital weld head TX 38P (Code 830 000 005) • 1 hose package, length 7.5 m (25 ft) • 1 integrated remote control • 1 transport case • 1 tool set • 1 set of operating instructions and spare parts list
MANDATORY FOR THE USE OF THE TUBE-TO-TUBE-SHEET ORBITAL WELD HEAD:	
Please order separately:	<ul style="list-style-type: none"> • Arbors • Spring sleeves • Clamping segments • Electrode support
FURTHER ACCESSORIES	
Optionally available:	<ul style="list-style-type: none"> • Balancer springs • ESG electrode grinders • Ground cable • Hose package extensions 5 m/10 m/15 m • Double pressure reducer • WS2 tungsten electrodes
EQUIPMENT	
Integrated remote control, function keys:	<ul style="list-style-type: none"> • START/STOP welding process • ON/OFF gas • Motor (rotor rotation) • Approaching of the end position (home position) • Actuation of arbor pneumatics



The tube-to-tube-sheet orbital weld head TX 38P:
Ideal for the repair, maintenance and servicing of industrial heat exchanging systems



TX 38P

Tube-to-tube-sheet orbital weld head

TX 38P

Properties, application area, technical specifications and delivery scope, see from page 92.

The following accessories are mandatory for the use of the tube-to-tube-sheet orbital weld head and must be ordered separately:

- Arbors, see page 91
- Spring sleeves, see page 91
- Clamping segments, see page 91
- Ground cable, see page 107

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Tube-to-tube-sheet orbital weld head TX 38P	830 000 005	7.500	15.600

* Machine weight including hose package

Suitable accessories (optionally available):

- Arbors, see page 91
- Spring sleeves, see page 91
- Clamping segments, see page 91
- Electrode adapters, see page 91
- Ground cable, see page 107
- Balancer spring, see page 96
- Hose package extensions, see page 108
- Welding current connection adapter set, see page 109

TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

Accessories for TX 38P

Arbors

Base arbor including insulation sleeve and clamping cone.

ITEM	SUITABLE FOR	CODE	KG
Arbor TX 38P, Type A	Spring sleeves, Type A	830 020 020	0.130
Arbor TX 38P, Type B	Clamping segments, Type B	830 020 021	0.130



Arbor TX 38P

Spring sleeves

Suitable for arbor, Type A.

ITEM	PIPE ID [MM]	PIPE ID [INCH]	CODE	KG
Spring sleeve TX 38P, Type A1	10.0 - 11.3	0.394 - 0.445	830 020 022	0.030
Spring sleeve TX 38P, Type A2	11.0 - 12.7	0.433 - 0.500	830 020 019	0.030
Spring sleeve TX 38P, Type A3	12.5 - 14.0	0.492 - 0.551	830 020 023	0.030



Spring sleeve

Clamping segments

Suitable for arbor, Type B.

Consisting of 1 set each with 2 clamping segments.

Differing dimensions on request.

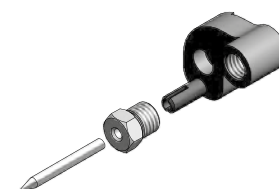
ITEM	PIPE ID [MM]	PIPE ID [INCH]	CODE	KG
Clamping segments TX 38P, Type B1	13.8 - 16.8	0.543 - 0.661	830 020 024	0.025
Clamping segments TX 38P, Type B2	16.6 - 19.6	0.654 - 0.772	830 020 025	0.045
Clamping segments TX 38P, Type B3	19.4 - 22.4	0.764 - 0.882	830 020 026	0.065
Clamping segments TX 38P, Type B4	22.2 - 25.2	0.874 - 0.992	830 020 027	0.085
Clamping segments TX 38P, Type B5	25.0 - 28.0	0.984 - 1.102	830 020 028	0.105
Clamping segments TX 38P, Type B6	28.0 - 31.0	1.102 - 1.220	830 020 029	0.130
Clamping segments TX 38P, Type B7	31.0 - 34.0	1.220 - 1.339	830 020 030	0.160
Clamping segments TX 38P, Type B8	34.0 - 37.0	1.339 - 1.457	830 020 031	0.200
Clamping segments TX 38P, Type B9	37.0 - 40.0	1.457 - 1.575	830 020 032	0.200



Clamping segments

Electrode adapters

ITEM	CODE	KG
Electrode adapter TX 38P cpl., 2.4 mm (0.094")	830 013 014	0.020



Electrode support

Other accessories for orbital welding

- Ground cable, see page 107
- Double pressure reducer, see page 108
- ESG electrode grinders, see page 100
- WS2 tungsten electrodes, see page 108
- Torch and cold wire accessories, see page 111
- Welding current connection adapter set, see page 109

TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

P16 EVO (KD), P16 EVO AVC

Tube-to-tube-sheet orbital weld heads

The further developed P16 EVO series combines the economy and reliability of its predecessor with simplified handling and extended functionality: highest weld seam quality - reproducible thousands of times.

Reliable - power transmission with rotary coupling	✓
Adjustable without tools - Balance suspension with increased adjustment range	✓
Flexible operation - control panel integrated into the handle	✓
Easy operation - Optimized quick-change system for torches	✓
Precise - adjustment of the Wire feed tension	✓
Solid - stainless steel screws for fine adjustment of torch and wire nozzle	✓
Adjustable without tools - 3-point support welding head on tube sheet	✓



The P16 EVO TIG tube-to-tube-sheet weld head is the result of continuous further development of the proven P series. Tool-free balancing and integrated control keypad increase operating convenience. The use of high-quality components and materials raises the precise reproducibility of welds to a new level.

Liquid cooling up to the torch head ensures the consistent quality of the welding process and increases the duty cycle. The reliability of the current transmission is increased by the use of the new graphite coupling. The torch head, which can be continuously tilted by up to 30 degrees, enables complex applications in confined spaces.

Features:

- Current transfer: Rotating clutch
- Gas water transfer: Rotating coupling
- Flexible operation via control panel in the handle
- Precise and comfortable balancing due to tool-free adjustable balance suspension with enlarged

adjustment range

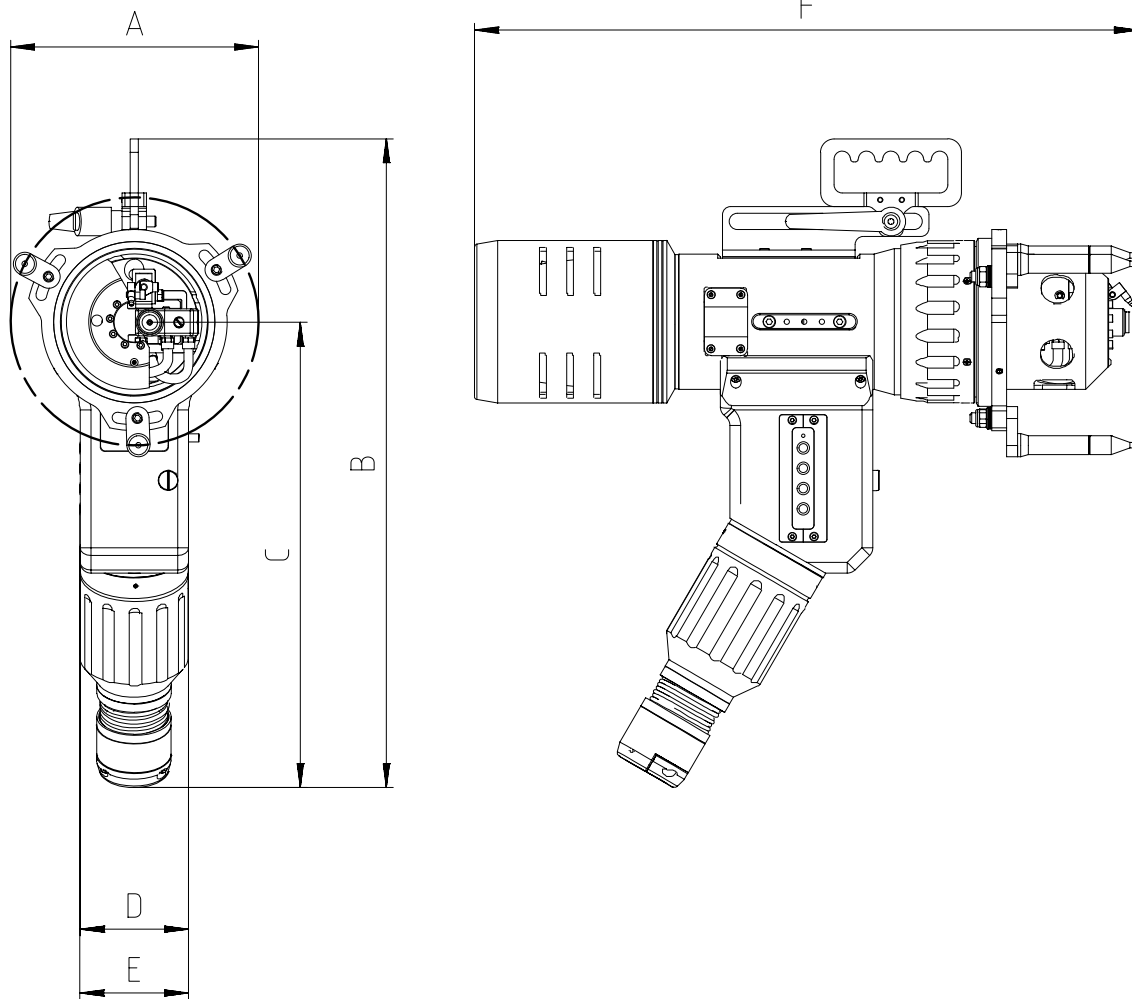
- Completely liquid-cooled weld head housing
- Torch head can be swiveled steplessly up to 30° (reduced diameter area)
- Weld seam geometries: Recessed, flush and protruding tubes
- Three-point support made of stainless steel
- Manual electrode position setting: Stroke +/- 5 mm
- Adaptable to special torches, e.g. box header, inner torch (with/without cold wire)
- Positioning in tube to be welded per centering cartridge, which is placed on an arbor (optionally available)
- Weld heads with cold wire unit are additionally equipped with a cold-wire feed mounted directly on the weld head, including a mounting gear for a D 100 mm/1 kg (3.937"/2.2 lbs) standard wire coil
- Wire feeder following on the rotating axis of the TIG torch to prevent spin of the filler wire while running out of the wire nozzle
- Including stainless steel 3-point support adjustable without tools
- Including 7.5 m (24.6 ft) hose package and tool set

Additional characteristics P16 EVO AVC:

- With electric arc distance control (AVC) - can only be used in combination with the ORBIMAT 300 CA AVC/OSC welding power source.



Integrated control panel

DIMENSIONS (EXEMPLARY P16 EVO KD SHOWN, VALUES, SEE TABLE):

DIMENSIONS	P16 EVO	P16 EVO KD	P16 EVO AVC
Dimension "A"	183,00 mm 7.204 in	183,00 mm 7.204 in	184,00 mm 7.244 in
Dimension "B"	478,84mm 19.202 in	478,84mm 19.202 in	478,84mm 19.202 in
Dimension "C"	343,40 mm 13.504 in	343,40 mm 13.504 in	344,74 mm 13.572 in
Dimension "D"	80,00 mm 3.150 in	80,00 mm 3.150 in	80,00 mm 3.150 in
Dimension "E"	80,20 mm 3.157 in	80,20 mm 3.157 in	80,20 mm 3.157 in
Dimension "F"	357,31 mm 14.067 in	489,81 mm 19.284 in	591,50 mm 23.287 in
APPLICATION AREA	P16 EVO	P16 EVO AVC	
Code	with cold wire 833 000 001 Without cold wire 833 000 003	833 000 002 -	
From tube ID to tube OD	10 - 78 mm* 0.394 - 3.071 in*	20 - 100 mm** 0.787 - 3.937 in**	
TECHNICAL SPECIFICATIONS	P16 EVO	P16 EVO AVC	
Weight machine including hose package	with cold wire 17.5 kg 38.6 lbs Without cold wire 16.2 kg 35.7 lbs	18.3 kg 40.3 lbs -	
Weight additional wire unit	1.0 kg 2.2 lbs	1.0 kg 2.2 lbs	
Additional wire unit Ø	0.8 mm 0.03 in	0.8 mm 0.03 in	
Hose package length	7.5 m 24.6 ft	7.5 m 24.6 ft	

*Expandable OD 20 mm to OD 126,00 mm (0.787 in - 4.016 in)

** Expandable from OD 10- OD 140 mm (0.394 in - 5.512 in)

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.

SCOPE OF DELIVERY

Including:

- 1 tube-to-tube-sheet orbital weld head P16 EVO, or P16 EVO AVC
- 1 three-point support
- 1 transport case
- 1 tool set
- 1 set of operating instructions and spare parts list
- General safety instructions Tube rewelding heads

Suitable accessories (optionally available):

- Centering cartridges and arbors
- Special torch (box header torch, rear sheet torch)
- Quick-change adapter torch equipment
- Cold-wire feeds KD
- Balancer spring
- Closed gas cover
- Front cage
- ESG electrode grinders
- Ground cable
- Hose package extensions
- Double pressure reducer
- WS2 tungsten electrodes



P16 EVO KD



P16 EVO AVC KD

Tube-to-tube-sheet orbital weld heads

P16 EVO, P16 EVO KD, P16 EVO AVC

Properties, application area, technical specifications and delivery scope, see page 92.

The following accessories are mandatory for the use of the tube-to-tube-sheet orbital weld heads and must be ordered separately:

- Arbors and centering cartridges (see page 97)
- Ground cable (see page 107)

ITEM	CODE	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Tube-to-tube-sheet orbital weld head P16 with cold wire	833 000 001	17.500	26.500
Tube-to-tube-sheet orbital weld head P16 without cold wire	833 000 003	16.200	25.100
Tube-to-tube-sheet orbital weld head P16 AVC with cold wire	833 000 002	18.300	27.300

* Machine weight including hose package

Suitable accessories (optionally available):

- Centering cartridges and arbors, see page 97
- Ground cable, see page 107
- Special torch (box header/rear sheet), see page 95
- Quick-change adapter torch equipment, see page 95
- Balancer spring, see page 96
- Closed gas cover, see page 96
- Front cage, see page 96
- Remote control, see page 26

TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

Accessories for P16 EVO, P16 EVO AVC

Special torches

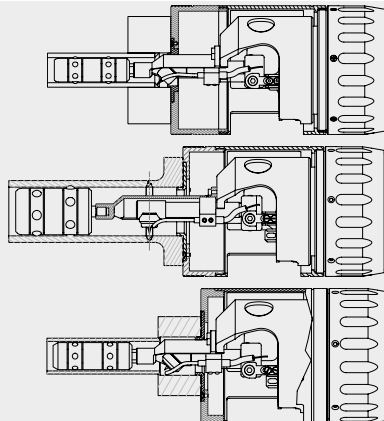
Individual special torches for following welding positions are available on request:

Box header torch



Box header torch

Inner torch:
For welding of recessed tubes and
rear sheet applications

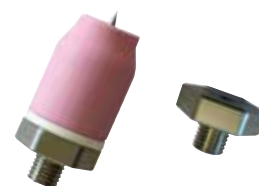


ITEM	CODE
Box header torch	on request
Inner torch	on request

Quick-change adapter torch equipment

Through this quick-change adapter the torch equipment of the tube-to-tube-sheet orbital weld heads P16 and P16 AVC, can be set up comfortably and exchanged faster, irrespective of the torch.

ITEM	CODE	KG
Quick-change adapter torch equipment	831 050 019	0.012



Quick-change adapter torch equipment

Cold-wire feeds KD (retrofitting kits)

For refitting of tube-to-tube-sheet orbital weld heads without wire unit.
Wire coil mounting for Ø 100 mm/1 kg (3.937"/2.2 lbs) standard coils.

ITEM	CODE	KG
Cold-wire feed P16/P16 AVC	831 001 116	1.500

TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS



Balancer spring



Closed gas cover



Front cage

Balancer spring

For load-free hanging of tube-to-tube-sheet orbital weld heads.

ITEM	TENSILE LOAD MAX. [KG]	CODE	KG
Balancer spring for P16	10 - 14	832 030 002	3,800
Balancer spring for TX38P//HX-Series	6 - 8	832 020 001	2,370

Closed gas cover

For welding of titanium tubes under full gas cover.

ITEM	CODE	KG
Closed gas cover for P16	831 001 101	1,300
Forming gas cover P16 AVC	831 030 004	

Front cage

With bearing ring.
Ideal for welding of tube-to-tube-sheet applications with flush or recessed tubes.

ITEM	CODE	KG
Front cage with support ring for P16 (EVO)	831 050 001	0,360
Front cage with support ring for P16 (EVO) AVC	831 050 003	0,965

Centering cartridges and arbors

The inner diameter of the tube is definitive for the selection of the correct centering cartridge. Smaller and larger dimensions on request.

Please ensure matching centering cartridge/arbor combination.

ITEM	GROUP	CARTRIDGE SIZE/ NO.	TUBE ID* [MM]	TUBE ID* [INCH]	CODE	KG
Arbor for centering cartridge for group A					832 020 003	0.060
Centering cartridge	A	1	10.0 - 10.5	0.394 - 0.413	832 020 004	0.040
Centering cartridge	A	2	10.5 - 11.0	0.413 - 0.433	832 020 005	0.050
Centering cartridge	A	3	11.0 - 11.5	0.433 - 0.452	832 020 006	0.070
Centering cartridge	A	4	11.5 - 12.0	0.452 - 0.472	832 020 007	0.070
Centering cartridge	A	5	12.0 - 12.5	0.472 - 0.492	832 020 008	0.080
Centering cartridge	A	6	12.5 - 13.0	0.492 - 0.512	832 020 009	0.100
Centering cartridge	A	7	12.8 - 14.0	0.504 - 0.551	832 020 011	0.110
Arbor centering cartridge for group B					832 020 010	0.070
Centering cartridge	B	8	13.8 - 15.0	0.543 - 0.591	832 020 012	0.120
Centering cartridge	B	9	14.8 - 16.0	0.583 - 0.630	832 020 013	0.140
Centering cartridge	B	10	15.8 - 17.0	0.622 - 0.669	832 020 014	0.150
Centering cartridge	B	11	16.8 - 18.0	0.661 - 0.709	832 020 015	0.180
Centering cartridge	B	12	17.8 - 19.0	0.701 - 0.748	832 020 016	0.190
Centering cartridge	B	13	18.8 - 20.5	0.740 - 0.807	832 020 017	0.200
Centering cartridge	B	14	19.8 - 22.5	0.780 - 0.886	832 020 018	0.250
Grub screw for arbor for group B					832 001 025	
Arbor centering cartridge for group C					832 020 019	0.115
Centering cartridge	C	15	22.3 - 24.6	0.878 - 0.969	832 020 020	0.340
Centering cartridge	C	16	24.5 - 27.0	0.965 - 1.063	832 020 021	0.350
Centering cartridge	C	17	26.5 - 29.0	1.043 - 1.142	832 020 022	0.360
Centering cartridge	C	18	28.5 - 31.0	1.122 - 1.220	832 020 023	0.400
Centering cartridge	C	19	30.5 - 33.0	1.201 - 1.299	832 020 024	0.500
Centering cartridge	C	20	32.5 - 36.0	1.280 - 1.417	832 020 025	0.510
Centering cartridge	C	21	35.5 - 39.0	1.397 - 1.535	832 020 026	0.530
Centering cartridge	C	22	38.5 - 42.0	1.516 - 1.654	832 020 027	0.550
Centering cartridge	C	23	41.5 - 45.0	1.634 - 1.772	832 020 028	0.560
Centering cartridge	C	24	44.5 - 48.0	1.752 - 1.890	832 020 029	1.000
Centering cartridge	C	25	47.5 - 51.0	1.870 - 2.008	832 020 030	1.200
Threaded screw DIN913-M5x5-A2 for group C					445 005 222	
Arbor for centering cartridge for group D					832 020 031	0.215
Centering cartridge	D	26	50.5 - 54.0	1.988 - 2.126	832 020 032	1.500
Centering cartridge	D	27	53.5 - 58.0	2.106 - 2.283	832 020 033	1.800
Centering cartridge	D	28	57.5 - 62.0	2.264 - 2.441	832 020 034	1.900
Centering cartridge	D	29	61.5 - 66.0	2.421 - 2.598	832 020 035	2.100
Centering cartridge	D	30	65.5 - 70.0	2.579 - 2.756	832 020 036	2.400
Centering cartridge	D	31	69.5 - 74.0	2.736 - 2.913	832 020 037	2.600
Centering cartridge	D	33	77.5 - 82.0	3.051 - 3.228	832 020 039	3.100
Centering cartridge	D	34	82.0 - 87.0	3.228 - 3.425	832 020 045	3.100
Centering cartridge	D	36	91.0 - 95.0	3.582 - 3.740	832 020 047	3.300
Centering cartridge	D	37	95.0 - 99.0	3.740 - 3.897	832 020 048	3.960
Centering cartridge	D	38	97.5 - 102.0	3.839 - 4.016	832 020 049	

* Other dimensions on request.



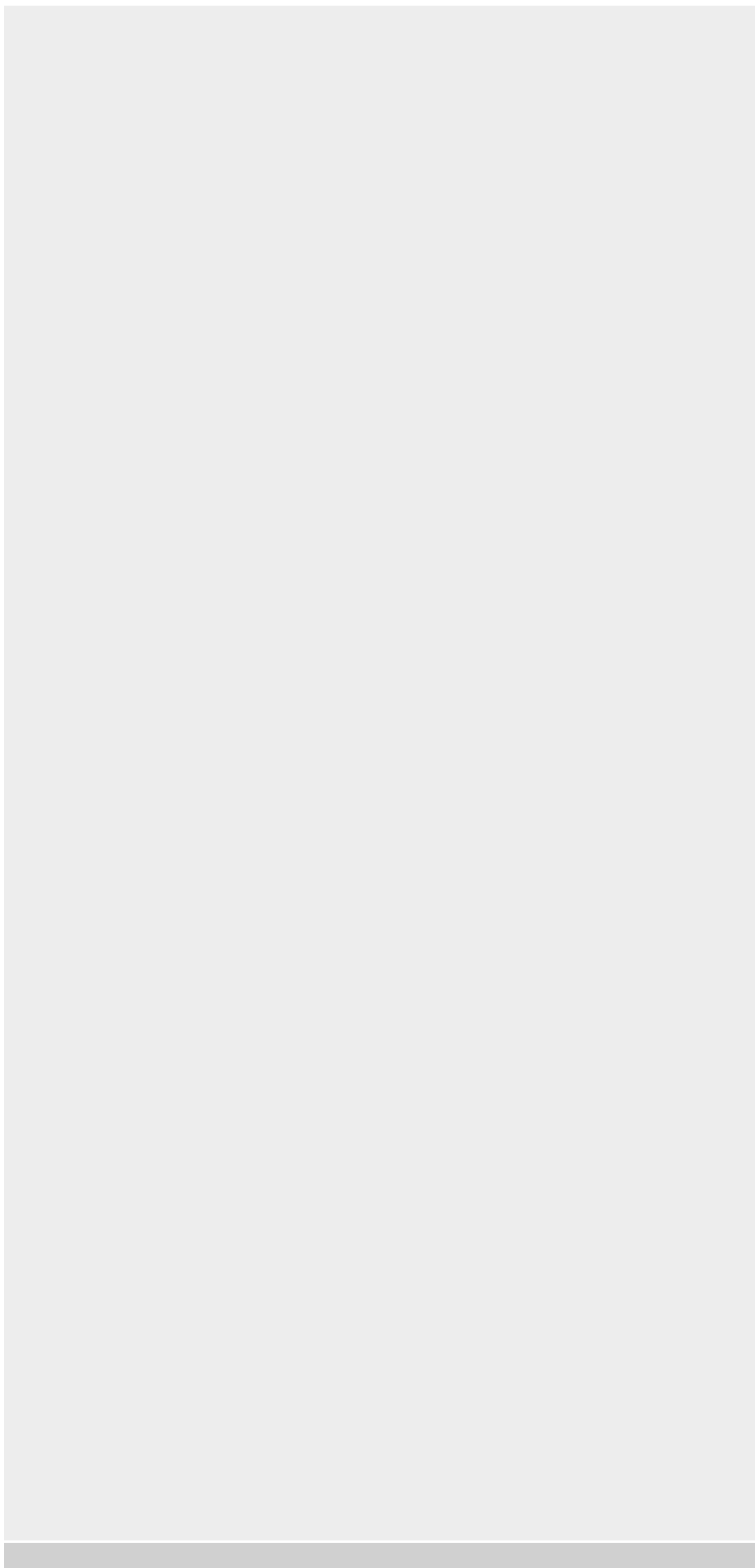
Centering cartridges



Arbor

Other accessories for orbital welding

- Ground cable, see page 107
- ESG electrode grinders, see page 100
- WS2 tungsten electrodes, see page 108
- Torch and cold wire accessories, see page 111



Accessories and wear parts for orbital welding



ESG Plus, ESG Plus²

Electrode grinders

The optimum solution for precise and quick working of weld electrodes.

For working, grinding and cutting weld electrodes which are used in the TIG welding machines.



High angular precision through preset grinding angle for all electrodes	✓
Light and rapid processing	✓
Optimum preparation for orbital or manual welding	✓
Grinding in the longitudinal direction for optimal arc ignition and high arc stability	✓
Guarantees a higher service life and ignition ease of the tungsten electrode	✓
Specially for small batch production directly on the building site	✓
Compact version, optimal resistance and perfect repeatability	✓
Functional design	✓
Precise cylindrical grinding	✓

The powerful hand-held electrode grinding units for grinding, squaring and cutting.

One unit - complete electrode machining:

- Grinding electrodes:
 - 4 different angles
 - 6 different electrode diameters
- Squaring an electrode tip
- Cutting electrodes

The devices are equipped with a high-quality, powerful drive in 230 or 110 Volt design. Machine and accessories are supplied in a robust transport case.

ADDITIONAL ADVANTAGES:

- Device for easy cutting of the electrodes (optional)
- External vacuum cleaners can be adapted easily
- Short machining times through the high grinding capacity
- Reduced work required without setup time

ADDITIONAL CHARACTERISTICS ESG PLUS²:

- Portable electrode grinders with 2 different grinding wheels. This way the electrode can be pre-sanded with the rough diamond grinding wheel without any effort and sharpened with the fine diamond grinding wheel.



Grinding electrodes: - 4 different angles, 6 different electrode diameters

Squaring an electrode tip

Cutting electrodes

Interchangeable, diamond grinding wheels coated on both sides for an optimum operational performance



SCOPE OF DELIVERY/AREA OF APPLICATION		ESG PLUS	ESG PLUS ²
Code	[230 V]	790 052 485 (15°/18°/22.5°/30°) 790 052 545 (15°/30°/45°/60°)	790 052 585 (15°/18°/22.5°/30°) 790 052 546 (15°/30°/45°/60°)
	[110 V]	790 052 486 (15°/18°/22.5°/30°) 790 052 645 (15°/30°/45°/60°)	790 052 586 (15°/18°/22.5°/30°) 790 052 646 (15°/30°/45°/60°)
Electrode grinder	PCS.	1	1
transport case	PCS.	1	1
Weld head for electrode Ø 1.0 - 1.6 - 2.0 - 2.4 - 3.2 - 4.0 mm (0.04" - 1/16" - 0.08" - 3/32" - 1/8" - 5/32")	PCS.	1	1
Weld head for grinding angle 15° - 18° - 22.5° - 30° or 15° - 30° - 45° - 60°	PCS.	1	1
Diamond grinding wheel fine (790 052 487)	PCS.	-	1
Diamond grinding wheel medium (790 052 488)	PCS.	1	-
Diamond grinding wheel rough (790 052 550)	PCS.	-	1
Table mount	PCS.	-	-
Tool to change the grinding wheel	PCS.	1	1
Operating instructions and spare part list	set	1	1
TECHNICAL SPECIFICATIONS		ESG PLUS	ESG PLUS ²
Dimensions (with drive)	[mm]	Ø 65 x 350	Ø 65 x 350
	[inch]	Ø 2.56 x 13.78	Ø 2.56 x 13.78
Power	[W]	500	500
Duty cycle	[%]	100	100
Speed (idle speed)	[rpm]	30.000	30.000
Power cable (length)	[m]	3	3
	[inch]	118.1	118.1
Vibration level (EN 28662, part 1)	[m/s ²]	< 2.5	< 2.5
Noise pressure level at the workplace (during idling), approx.	[dB (A)]	83	83

Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.



ESG Plus



ESG Plus²



Diamond grinding wheels



Cutting device

ESG electrode grinders

ESG Plus, ESG Plus²

Properties, application area, technical specifications and delivery scope, see from page 100.

ITEM	VERSION	GRINDING ANGLE [°]	CODE	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ESG Plus	230 V, 50/60 Hz EU	15/18/22.5/30	790 052 485	1.430	3.560
ESG Plus	110 V, 50/60 Hz EU/US	15/18/22.5/30	790 052 486	1.430	3.560
ESG Plus	230 V, 50/60 Hz EU	15/30/45/60	790 052 545	1.430	3.560
ESG Plus	110 V, 50/60 Hz EU/US	15/30/45/60	790 052 645	1.430	3.560
ESG Plus²	230 V, 50/60 Hz EU	15/18/22.5/30	790 052 585	1.520	3.825
ESG Plus²	110 V, 50/60 Hz EU/US	15/18/22.5/30	790 052 586	1.520	3.825
ESG Plus²	230 V, 50/60 Hz EU	15/30/45/60	790 052 546	1.520	3.825
ESG Plus²	110 V, 50/60 Hz EU/US	15/30/45/60	790 052 646	1.520	3.825

Diamond grinding wheels

Interchangeable, diamond grinding wheels coated on both sides for an optimum operational performance.

For 1.0 and 1.6 mm electrodes we recommend the fine grinding wheel grains.

For 2.0 mm and 2.4 mm electrodes an average grinding wheel grain is recommended and for 3.2 mm and 4.0 mm a rough grinding wheel grain.

ITEM	CAN BE USED WITH	GRAIN	WHEEL Ø		S		CODE	KG
			[MM]	[INCH]	[MM]	[INCH]		
Diamond grinding wheel	ESG 4	Standard	32.00	1.290	1.2	0.047	790 052 460	0.005
Diamond grinding wheel	ESG Plus, ESG Plus²	Fine	33.50	1.319	2.2	0.087	790 052 487	0.010
Diamond grinding wheel	ESG Plus, ESG Plus²	Medium	33.50	1.319	2.2	0.087	790 052 488	0.011
Diamond grinding wheel	ESG Plus, ESG Plus²	Rough	33.50	1.319	2.2	0.087	790 052 550	0.011

Cut to length device

For simple separating of the electrodes.

Can be used up to an electrode diameter of 2.4 mm (0.094").

ITEM	SETTING	CUTTING LENGTHS		CODE	KG
		[MM]	[INCH]		
Cutting device	fix	12.0	0.472	790 052 513	0.030
		13.0	0.512		
		15.0	0.591		
		17.0	0.669		

Electrode holder

For processing smaller electrodes.

The electrode holder is delivered including 1 flexible collet.

ITEM	SETTING	ELECTRODE Ø		CODE	KG
		[MM]	[INCH]		
Electrode holder with collet	continuous	1.0 - 3.2	0.039 - 0.126	790 052 457	0.023
Spare collet	continuous	1.0 - 3.2	0.039 - 0.126	790 052 481	0.002



Electrode holder with collet



Spare collet

Wall, table, vise mount

For stationary use of the ESG Plus and ESG Plus².

Simple and rapid mounting to a wall, a table or a vice.

ITEM	CODE	KG
Wall, table, vise mount	790 052 483	0.102



Wall, table, vise mount

Dust protection

Easy to mount on the ESG grinding head.

With integrated mounting for extraction systems.

To be used for electrodes containing thorium.

Country-specific regulations, standards and guidelines have to be observed.

ITEM	CODE	KG
Dust protection ESG Plus	790 052 496	0.170
Dust protection ESG Plus ²	790 052 596	0.220



Dust protection

Double-decker kit

Easy to mount for the ESG Plus. This mount allows simultaneous working with 2 different grinding wheels.

Including:

- 1 grinding head
- 1 diamond grinding wheel (rough)
- 1 cylinder-head screw with collar (M4x34)
- 1 shaft extension

ITEM	CAN BE USED WITH	GRINDING ANGLE [°]	CODE	KG
Double-decker kit	ESG Plus	15/18/22.5/30	790 052 490	0.160
Double-decker kit	ESG Plus	15/30/45/60	790 052 390	0.100



Double-decker kit

ORBmax

residual oxygen meter

The ORBmax residual oxygen meter sets a milestone for fast, exact detection of residual oxygen, and with it for complete documentation of this parameter. At the same time, the new measuring method results in greater efficiency and higher quality.



The ORBmax does not require any heating-up time. It recognizes the oxygen percentage reliably, rapidly and precisely during the entire welding process.



The "Optical oxygen measurement via fluorescence extinction" method for welding technology is far superior to the conventional methods using zirconium sensors: It requires no warm-up time whatsoever; reliably, quickly and precisely detects the oxygen share in the gas; unchecked alleged increasing of the measured value due to the formation of ozone is eliminated; the measurement is possible in all gas mixtures without manual switch-over (even with forming gas with a variable percentage of hydrogen).

The exact, fast detection of the oxygen content reduces the otherwise long flooding time of the forming gas. The operator can start the safe welding process considerably earlier: As a result, precious working time is saved and the gas consumption reduced. In addition, ORBmax requires no maintenance of any kind: Calibration once a year in accordance with the standard ISO 9001 is totally sufficient. Comprehensive quality assurance is required for welding pipes in plant and apparatus engineering for

the food processing, beverage, cosmetics and pharmaceuticals industries, medical and bio-technology as well as fine chemicals, and a welding procedure qualification is often specified for the welded seams: As quality certification, not only the values from the power source, but also the residual oxygen values can be documented with the ORBmax.

When used as a stand-alone solution, ORBmax records a digital log with a time stamp. In conjunction with the ORBIMAT welding current source, the welding process can be monitored in real-time and automatically switched off when an increased oxygen content occurs.

- No heating period required
- Rapid reaction times
- High measuring precision
- Measuring of the residual oxygen value during the welding process
- No uncontrolled increase in measurement values during the welding process

- Measuring of forming gas with variable hydrogen content without switching over
- Measuring of the residual oxygen value in all gas mixtures
- SD-card storage of the measured value
- User-friendly touch screen
- Moisture-resistant sensor
- Alarm mode with signal (beeper) as well as change in display color (green/red)
- Degree of protection IP32
- Configurable alarm or limit value and storage interval
- Multi-range voltage supply
- Software for data evaluation
- Connection possibility to ORBIMAT orbital welding power sources
- Maintenance-free sensor
- Appealing and compact design

Residual oxygen meter

ORBmax

Characteristics, see page 104.

TECHNICAL SPECIFICATIONS	ORBMAX
Dimensions (LxDxH)	203 x 204 x 82 mm 7.99 x 8.03 x 3.23 in
Weight, approx.	1.65 kg 3.64 lbs
Protection class device	IP32
Protection class transport case	IP67
Power connection	100 - 240 V AC, 50 - 60 Hz
Measuring range	1 - 999 ppm
SCOPE OF DELIVERY	<ul style="list-style-type: none"> • 1 ORBmax residual oxygen meter • 1 transport case • 1 power unit supply set 100 - 240 VAC/12 VDC • 1 measuring hose (with test tip and filter) • 1 SD card incl. PC evaluation software "O2_log" • 1 interface cable ORBmax/ORBIMAT CA • 1 interface cable ORBmax/ORBIMAT SW • 2 reserve filter inserts • 1 operating instructions

ITEM	VERSION	CODE	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ORBmax	100 - 240 V, 50/60 Hz	882 000 010	1.65	4.665



ORBmax



including practical mounting eye

Interface cable ORBmax/ORBIMAT SW

For retrofitting older ORBmax devices.

Allows the connection to ORBIMAT SW power sources.

At newer ORBmax devices this interface cable is already included in the scope of delivery.

ITEM	CODE	KG
Interface cable ORBmax - ORBIMAT SW	850 040 031	0.065

Consumables for ORBmax

All individual parts are already included in the scope of delivery of the ORBmax.

ITEM	CODE	KG
Measuring hose set, including:	882 050 006	0.081
• 1 hose 2 m		
• 1 filter housing including filter insert (1 unit)		
• 1 test tip		
• 1 hose connector		
Hose*	882 012 010	0.050
Filter housing including filter insert (1 unit)	882 020 003	0.021
Filter inserts (5 piece per packing unit)	882 030 002	0.003
Test tip	882 012 011	0.004
Plastic connector test tip - hose	882 012 012	0.001

* Please specify the hose length in meters when ordering.



Measuring hose (individual parts)

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

Comprehensive training program.

We attach great importance to the safe operation of our machines - this has the highest priority for us. Therefore we recommend participation in a product training to learn correct and safe handling of our machines and avoid possible dangers and accidents already in advance.



If you would like to learn more about our comprehensive training program or would like information on upcoming dates for users, please contact our training team under the phone number:

+49 (0) 77 31 792-200

Or send us an e-mail to:

training@itw-ocw.com

Other accessories orbital welding technology

ORBIPURGE forming set

Complete with Teflon gas hose and quick-release couplers.

The ORBIPURGE forming set for inner diameter of the tube 12 - 110 mm (0.472" - 4.331") includes all accessories for a quick and efficient internal forming during orbital welding.

Forming plugs for larger diameters are available separately.

- Suitable for all common materials
- Different forming plugs adapt precisely to the inner diameter of the tube and thus ensure complete sealing
- The complete set is delivered in a rugged plastic case
- The standard scope of delivery includes 2 forming plugs each per size, a Teflon gas hose as well as protective gas vents made of sinter metal with quick-release couplers.
- Is especially suitable for very high cleanliness requirements for the forming atmosphere and is the ideal supplement to the ORBmax residual oxygen meter (see from page 104)
- The included, self-closing quick-release couplers allow a simple connecting and disconnecting of the gas hose

Replacement protective gas vents for ORBIPURGE forming plugs:

Fitting for all ORBIPURGE forming plugs.



ORBIPURGE forming set



Replacement protective gas vents

ITEM	CODE	KG
ORBIPURGE forming set	881 000 001	3.150
Replacement protective gas vents for ORBIPURGE 3/8"	881 020 014	0.030
Replacement protective gas vents for ORBIPURGE M5	881 020 015	0.005
Forming plugs pair ID 114 - 130 mm (4.488" - 5.118"), 3/8"	881 050 030	0.220
Forming plugs pair ID 121 - 142 mm (4.764" - 5.591"), 3/8"	881 050 031	0.230
Forming plugs pair ID 148 - 162 mm (5.827" - 6.378"), 3/8"	881 050 032	0.250

Ground cable

For utilization in combination with an Orbital welding power source of the ORBIMAT series.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	KG
Ground cable for Power Welder, Smart Welder and Mobile Welder power sources	5.0	16.4	811 050 005	2.400



Ground cable

Control cable

Matching for all ORBIWELD TP and MH orbital weld heads

ITEM	LENGTH [M]	LENGTH [INCH]	CODE	KG
Control cable TP/MH	7.5	24.6	811 050 003	1.202



Control cable

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY



Hose package extensions



Double pressure reducer "Argon"



Bar pressure reducer "Argon"



WS2 tungsten electrodes

Hose package extensions

Fitting for all weld heads of Orbitalum, with exception of the AVC/OSC versions of the ORBIWELD TP series. The weld current connection adapter set may be required for usage with older Orbital welding power sources and heads with green Superior connections (see page 97). Newer machine models are already equipped with DINSE-compatible connections.

Further lengths on request.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	KG
Hose package extension 5 m (16 ft)	5	16	871 050 011	7.600
Hose package extension 10 m (32 ft)	10	32	871 050 012	14.600
Hose package extension 15 m (49 ft)	15	49	871 050 013	22.000
Hose package extension 20 m (64 ft)	20	64	871 050 016	28.700

Double pressure reducer

With 2 adjustable flow displays and possibility of connection of weld and forming gas.

TECHNICAL SPECIFICATIONS	ARGON/HYDROGEN	ARGON
Max. input pressure	200 bar	230 bar
Flow display	Up to 50 l/min.	Up to 30 l/min.
Bottle connection	W21.8x1/4" LH	W21.8x1/4"
Hose connection	G 3/8 LH	G 1/4

ITEM	VERSION	CODE	KG
Double pressure reducer	Argon	888 000 001	1.850
Double pressure reducer	Argon/hydrogen	888 000 002	1.870
Replacement seals for double pressure reducer		888 000 005	0.002

Bar pressure reducer "Argon"

For HX 16P, see page 75.

WS2 tungsten electrodes

WS electrodes are used for direct current and alternating current welding and are an adequate replacement for WT electrodes.

Advantages:

- High spark reliability
- Low combustion
- Long service life
- High arc quality

Contents: 10 pcs. Length: 175 mm (6,890").
Composition: WS2 = Rare earths (mixed oxides)
Identification color: Turquoise

ITEM	ELECTRODE Ø [MM]	ELECTRODE Ø [INCH]	CODE	KG
WS2 tungsten electrodes	1.0	0.039	826 004 018	0.006
WS2 tungsten electrodes	1.6	0.063	826 004 019	0.010
WS2 tungsten electrodes	2.4	0.094	826 004 020	0.018

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

Welding current connection adapter sets

Simple, safe, robust and durable.

For use with older Orbitalum welding power sources and heads with green Superior connections. Newer machine models are already equipped with DINSE-compatible connections.

ITEM	CODE	KG
Welding current connection adapter set for socket & plug	850 030 004	0.326
Welding current connection adapter for plug	850 030 002	0.130
Welding current connection adapter for socket	850 030 003	0.195



Welding current connection adapter for plug



Welding current connection adapter for socket



Welding current connection adapter set

TIG manual torch for Mobile Welder

High-performance TIG manual torch for Mobile Welder orbital welding power supplies for manual welding and tacking. The liquid-cooled manual torch provides optimum heat dissipation and high service life. Thanks to the handy design and the switching function integrated in the handle, the manual torch provides optimum user-friendliness.

The fully rubberized hose package can be easily cleaned and as a result is well suited for use in clean environments.

Characteristics:

- Gas-cooled DC 140 A / 35% ED
- Fully rubberized hose package
- Flexible torch body
- Ergonomic handle

The scope of delivery includes:

- 1 TIG manual torch MW
- Torch pre-fitted

The following accessories are mandatory for the use of the TIG manual torch and must be ordered separately:

- Ground cable, see page 107

ITEM	HOSE PACKAGE [M]	HOSE PACKAGE [FT]	CODE	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
TIG manual torch MW	6.0	19.7	854 030 200	3.350	3.665



TIG manual torch MW



2-rocker control panel

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY



TIG manual torch CA/SW



2-button control panel

TIG manual torch for Smart Welder

High-performance TIG manual torch for ORBIMAT orbital welding power supplies for manual welding and tacking. The liquid-cooled manual torch offers optimum heat dissipation and high service life. Thanks to the handy design and the switching function integrated in the handle, the manual torch provides optimum user-friendliness.

The fully rubberized hose package can be easily cleaned and as a result is well suited for use in clean environments.

Characteristics:

- Liquid-cooled DC 250 A, AC 175 A / 10% ED
- Fully rubberized hose package
- Flexible torch body
- Ergonomic handle

The scope of delivery includes:

- 1 TIG manual torch
- Torch pre-fitted

The following accessories are mandatory for the use of the TIP manual torch and must be ordered separately:

- Ground cable, see page 107


ITEM	HOSE PACKAGE [M]	HOSE PACKAGE [FT]	CODE	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
TIG manual torch CA/SW	6.0	19.7	890 013 015	3.010	3.325

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

Torch and cold wire accessories



ACCESSORIES	CLAMPING SLEEVE ELECTRODES	BACK CAP PRESSURE PIECE	TORCH ISOLATOR		
Image					
SUITABLE FOR:	CODE	CODE	CODE		
TP 250	811 020 018	812 005 002	811 013 001		
TP 400 KD4-100	812 020 024		812 005 001		
TP 400 KD3-62 (AVC/OSC)	812 020 024				
TP 600 (AVC/OSC)					
TP 1000 (AVC/OSC)					
P16	831 001 058	-	831 001 007		
P16 AVC					
TIG manual torch CA/SW	812 020 072	812 020 075	812 020 076		
TIG manual torch MW	854 030 225	854 030 221*	854 030 220		
		854 030 222**			
		854 030 223***			

* Short
 ** Medium
 *** Long

ACCESSORIES	WIRE CORE			
Image				
Version	TP wire core 0.8 mm (0.031")	TP wire core 1.0 mm/1.2 mm (0.039"/0.047")	Front wire core (long) 0.8 mm (0.031")	Rear wire core (short) 0.8 mm (0.031")
SUITABLE FOR:	CODE	CODE	CODE	CODE
TP 250	811 020 030	811 002 006	-	-
TP 400 KD4-100	812 020 041	811 002 005		
TP 400 KD3-62 (AVC/OSC)				
TP 600 (AVC/OSC)				
TP 1000 (AVC/OSC)	-	-	831 001 022	831 001 015
P16				
P16 AVC				

ACCESSORIES	HF SPIRAL	TORCH SEAL	GAS NOZZLE	GAS LENS
Image				
SUITABLE FOR:	CODE	CODE	CODE	CODE
TP 250	831 001 027	811 005 020	811 020 017	811 020 016
TP 400 KD4-100	811 050 011	-	812 020 023	812 020 022
TP 400 KD3-62 (AVC/OSC)	831 001 027			
TP 600 (AVC/OSC)				
TP 1000 (AVC/OSC)				
P16	811 050 011		831 001 060	831 001 161
P16 AVC				
TIG manual torch CA/SW			812 020 071	812 020 070
TIG manual torch MW		854 030 226	854 030 224	854 030 227

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

ACCESSORIES	WIRE NOZZLES							
Image								
Version	Wire nozzle for wire Ø 0.8 mm (0.031")		Wire nozzle for wire Ø 1.0 mm (0.039")		Wire nozzle head for wire Ø 0.8 mm (0.031")		Wire nozzle head for wire Ø 1.0 mm (0.039")	
SUITABLE FOR:	CODE	KG	CODE	KG	CODE	KG	CODE	KG
TP 250	811 018 010	0.004	811 018 011	-	-	-	-	-
TP 400 KD4-100	812 018 045	0.002	812 018 046	0.002	812 018 050	-	812 018 051	-
TP 400 KD3-62 (AVC/OSC)								
TP 600 (AVC/OSC)								
TP 1000 (AVC/OSC)								
P16	831 001 031	0.020	831 001 039	0.005	-	-	-	-
P16 AVC	831 018 051	0.003	-					
TIG manual torch V1	-	-						
TIG manual torch V2	-	-						



About us

The best in the field of pipe cutting and beveling as well as orbital welding technology from a single source

For more than 50 years installation manufacturers have been relying on the standard set by the market leader Orbitalum Tools in industrial pipe end preparation.

Orbitalum Tools is a worldwide provider of complete solutions in industrial preproduction, installation and servicing of pipeline systems for everything from cutting pipes and preparing weld seams to orbital welding in process and plant engineering. E.H. Wachs with its high-quality, nearly indestructible, portable and user-friendly pipe processing machines for cutting and beveling, has established itself in many industries: in the oil and gas industry, the chemical industry and in pipeline and ship construction – in the preproduction, maintenance, repair and dismantling of installations.

ITW (Illinois Tool Works), with headquarters in Glenview, Illinois/US is a US-listed "Fortune 200" company and a manufacturer operating worldwide for special production, special plants as well as provider for related services. Organizationally ITW Orbital Cutting & Welding belongs to the ITW Welding Group which is among the world leading providers for welding units (e.g. MILLER ELECTRIC, HOBART BROTHERS).

With us as a partner you not only work with the industry leader for portable pipe processing machines and orbital welding systems, you also cooperate with ITW the global leader for demanding and future-oriented welding technologies.

The ITW Orbital Cutting & Welding Group stands for the best, most efficient technology in all aspects of orbital cutting and welding around the globe.

As ITW OCW we offer a nearly unique product availability, technical support worldwide as well as a sales network down to the local level.

A partnership with ITW OCW includes:

- Recognized top technology, competent contact partner
- Quick, comprehensive delivery service
- Reliable product service
- Large inventories on a local level
- Comprehensive OEM spare parts and special production
- Strategically optimized positioned sales locations, service and rental centers
- Excellent technicians trained and certified in the factory
- Practical training courses - at our location or yours
- Certified company

ITW Orbital Cutting & Welding banks on excellent product solutions from Orbitalum and E.H. WACHS company. In combination with excellent service and advisory service, ITW OCW is the primary supplier for machines and tools for cutting, beveling and welding - all from a single source.

Environment and disposal instructions



Disposal of electric devices

(as per RL 2012/19/EU)

Electrical and electronic devices marked with the symbol above may not be disposed of with household garbage as per EU directive. By actively using the offered return and collection systems, you are doing your part to reuse and recycle used electrical and electronic devices. Used electric and electronic devices contain parts which must be handled specially as per EU directives. Separate collection and selective treatment are the basis for environmentally responsible disposal and protection of human health. We will properly dispose of devices and machines from us purchased from August 13th, 2005 if they are sent to us postage-paid. In the case of used devices which may represent a risk to human health or safety due to contamination during use, we have the option of refusing return. The user is responsible for disposing of used devices purchased before August 13th, 2005. For this purpose, please contact a professional disposal company in your area.

Important note for Germany: Our devices and machines may not be disposed of at communal dumps, as they are only used in the commercial sector.



Return of accumulators

Some of our devices are operated with accumulators. Accumulators and batteries that are marked with the above symbol may not be disposed of with household garbage as per EU Directive 2006/66/EC. In the case of accumulators containing hazardous materials the chemical sign for the heavy metal contained is specified below the refuse bin:

Cd = Cadmium
Hg = Quicksilver
Pb = Lead

Applies for Germany: The end consumer is obliged to return defective or used batteries to the distributor or to the returning facilities set up to this purpose.

Orbitalum Tools GmbH offers global customers the best in the field of pipe cutting and beveling as well as orbital welding technology from a single source.



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Certified
Management System ac-
cording to ISO 9001:2015



Approved
Economic Operator
with AEO certification

worldwide | sales + service

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ITW OCN Corporate Locations

★ Sales Locations

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An ITW Company