

MAGNATECH

ORBITAL WELDING SYSTEMS

PIPEMASTER Model 515

Programmable Power Source
For Orbital Weld Heads



Use with

- *Orbital Tube Weld Heads*
- *Orbital Pipe Weld Heads*
- *Tube-Tubesheet Heads*
- *Weld Lathes*

PIPEMASTER Model 515

Programmable Power Source For Orbital Weld Heads

Revolutionary, Not Evolutionary

The latest generation of Pipemaster power sources is the result of a new direction in power source design. The Model 515 brings the benefits of digital technology to the orbital welding customer: unparalleled accuracy, repeatability, and reliability. The new model is half the size and weight of previous models. Digital technology forever eliminates the need for periodic weld Head calibration – motor speeds and response characteristics remain accurate and stable regardless of wear, and weld Heads can be interchanged without time-consuming calibration.

Software upgrades can be sent as e-mail attachments and loaded using a standard USB portable flash drive “memory key” (provided). The Model 515 is “internet ready” for future enhancements such as a web-based diagnostic service.

Two autoranging versions are available: a lighter weight 115/230 VAC input model, or with a wider 115/480 VAC input range, to operate on any input voltage worldwide. Both operate on 1 or 3 phase, 50/60 Hz.

Features

- Multi-pass welding of pipes/tubes/tubesheets
- Full function capability (torch rotation, filler wire feed, electronic arc gap control, electronic oscillation)
- Operates all models of Magnatech weld Heads (GTAW process)
- 200 Amp Output
- Autoranging input eliminates all internal modifications
- Up to 100 levels per program (time-based programs)
- Stores 100 weld programs internally
- AutoProgram automatically generates procedures
- Programming and operation guided by simple prompts
- Teach mode allows rapid program development
- Programmable “override limits” provide supervisory control
- Weld parameter monitoring/out-of-limits reporting for QA/QC purpose
- Transfer programs and QC data to PC using USB flash drive “Memory Key”
- AutoTack automatically generates tack weld programs
- Large color LCD display
- Stainless steel case
- Help Files provide immediate information/assistance
- Password protection of key functions
- Waterproof Remote Pendant (25’/8m cable)
- Auto rewind feature unwraps cable at weld completion
- All weld Head functions capable of synchronization with pulsed current output
- Selectable Position or Time-based programming
- Integral switch prevents welding without torch gas flow
- Integral printer
- Detachable coolant recirculator with integral flow switch protection
- Meets applicable NEMA, CE, CSA standards



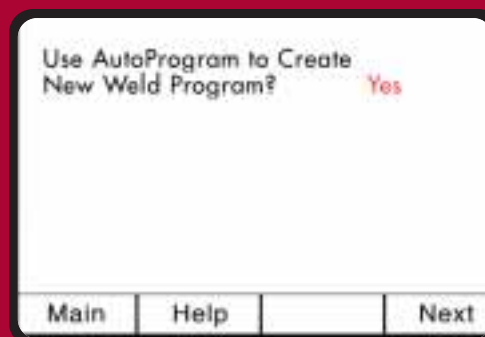
AutoProgram

Programming is simple and intuitive by manual entry or new AutoProgram which self-generates programs

Startup display



...automatically create a new weld program



...simply fill in the



Options

- Cart with bottle rack
- Extension cables
- Rugged storage/ shipping case
- Lighter weight 115/230 VAC version



Remote Pendant

This handheld control is used to both program and remotely operate the power source. Designed to withstand hard use, the pendant incorporates a completely sealed, waterproof silicone rubber panel keypad, impervious to grinding debris and weld spatter. The color LCD display is protected by a tempered glass shield

The intuitive switch layout allows the welder to make program override corrections without lifting his hood.



Coolant Recirculator

Detachable coolant recirculator mounts beneath power source with integral flow switch protection.



Teach Mode

Teach Mode speeds program development. Approximate parameter values are entered or copied from an existing program.

A test weld is then made in Teach Mode. Changes made during welding are temporarily stored and can be "saved" as a new weld program.

Programmable Overrides Provide Supervisory Control

The welder may override programmed parameters but only within preset limits. Password protected override limits are set for each parameter (0-100% of programmed value).

Simplified Programming

Specifying the weld Head to be used from a "dropdown" menu automatically selects the preferred programming mode – position or time. Time-based programming is generally preferred for weld Heads making simple fusion welds. Multipass pipe weld Heads are operated using position-based programming, eliminating calculations to determine when parameter changes must be made. A sensor in the weld Head provides position information. All welding parameters may be changed at each level.

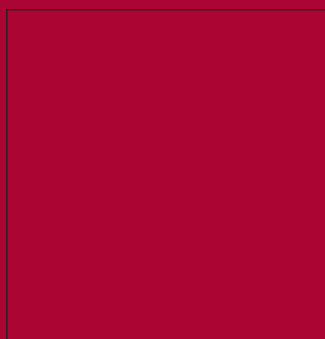
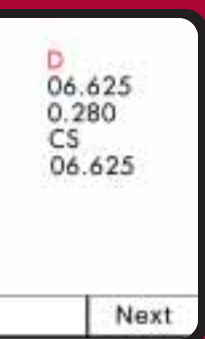
Weld Monitoring/QC

Additional documentation and notes can be added to weld programs and QC records, providing traceability to individual drawings, projects, and customers

cedures.

the blanks

...for a perfect weld, every time



Weld No	009	Date	9-11-2003
CD	00.500	Wall Thickness	00.049
Head	C10	Position	5G
Project	P326 03		
Drawing	H220		
Elect Diam	0.062"	Length	00.292"
Shield Gas	AR/H	Flow Rate	020 CFH
Backing Gas	AR	Flow Rate	005 CFH
Tacking	No	Overrides	No
Back	Help		Next

Specifications

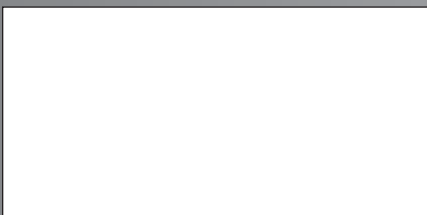
Application	For use with many Magnatech weld Head models (GTAW process), Welding Lathes, and dedicated Weld Systems
Functions Controlled	Weld Current Output/Current Pulsing, Weld Head Rotation, Weld Head Wire Feed Speed, Electronic Arc Voltage Control, Electronic Torch Oscillation, Electronic Torch Cross-Seam Adjustment
Output Power	0 – 200 Amps
Input Power Requirements (Rated Load)	115/480 VAC, 1 or 3Ø, 4.0 KVA, 50/60 Hz Autoranging (No modifications necessary)
Internal Memory Capacity	100 Weld Programs
Units of Measurement	Metric and Inch (selectable)
Program Transfer	Solid State Digital Media (USB Flash Drive/Memory Key)
Language (Selection)	English, Spanish, German, French, others
Settable Override Limits	Individually scalable overrides on each function 0 – 100%
Maximum Open Circuit Voltage	80V
Water and Gas Flow Switches	Standard. Prevent damage to equipment and workpiece
Data Recording/Printout	Operator ID, Weld ID Number, Program Number, Material, OD, Wall Thickness, Date, Time, Weld Head Model, Project, Drawing, Programmed Parameters, User Notes
QC-Parameter Monitoring/Recording/Printout	Records actual parameters and deviations from preprogrammed limits
Arc Start Type	High Voltage Impulse
Operating/Storage Temperature	Operating: -18 to 50°C (0 to 120°F) Storage: -25 to 60°C (-20 to 140°F)
Humidity	To 98% RH (Non-Condensing)

Dimensions

	Model 515 Power Source	Model 905 Circulator
Length	48cm (19")	48cm (19")
Width	35cm (14")	35cm (14")
Height	43cm (17")	27cm (11")
Weight	41 Kgs (91 Lbs)	15 Kgs (34 Lbs)
Weight - Model 515	35 Kgs (77 Lbs)*	15 Kgs (34 Lbs)*

*115/230 VAC Input Model

The Pipemaster Power Supply can be used with many Weld Head models



D/T Model Pipe Weld Heads



Quickclamp



424, 425, 426 Series Tube-to-Tubesheet Weld Heads

Represented By:

MAGNATECH

Headquarters: **MAGNATECH LIMITED PARTNERSHIP**
 6 Kripes Road, P.O. Box 260, East Granby, CT 06026-0260
 Telephone: (+1) 860 653-2573 • Fax: (+1) 860 653-0486
 E-Mail: info@magnatech-lp.com
 Web Site: www.magnatech-lp.com

European Office: **MAGNATECH EUROPE B.V.**
 Ambachtshof 15, 8251 KV Dronten, The Netherlands
 Telephone: (+31) 321 38 6677 • Fax: (+31) 321 31 4165
 E-Mail: info@magnatech-europe.com
 Web Site: www.magnatech-europe.com