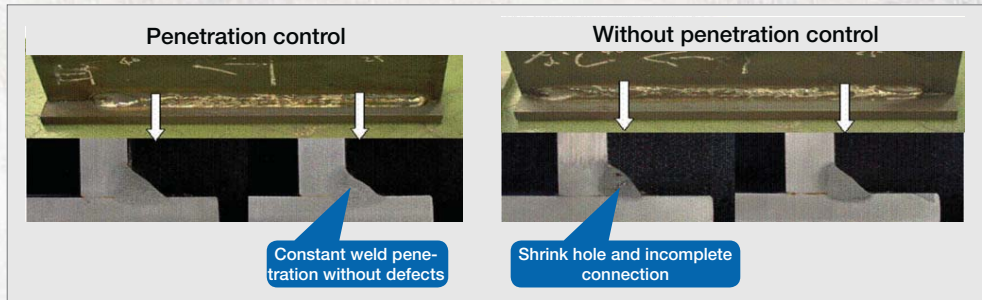




Ideal seam geometry with secure root formation

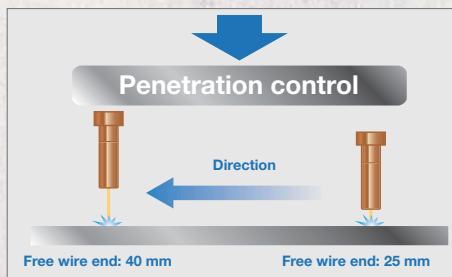
Penetration Control – ideal seam geometry with secure root formation



Advantages

- Approximation to the ideal seam geometry, concave seam
- The under-cutting are reduced, regardless of burner position
- Smooth surfaces and excellent seam quality
- Safe root formation, especially in tight and narrow joints

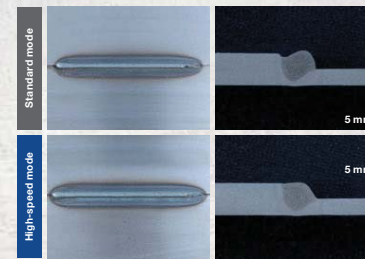
Penetration control produces high welding quality



The penetration control keeps the weld penetration constant, even if the free wire end varies.

High-speed pulse mode for robot welding

In conjunction with OTC DAIHEN robots, the performance spectrum of Welbee can be optimally used. For high-speed pulse welding, parameter settings can be synchronized with speed information via the hand-held programming device.



Welding current:	300 A
Welding voltage:	22 V
Sheet thickness:	3.2 mm
Welding wire diameter:	1.2 mm
Welding speed:	150 cm/min
Wire feed speed:	11 m/min
Overhang:	1.5 mm

Advantages

- Higher welding speed allows for less material warping
- Minimized microstructure changes
- Lower heat input, which also reduces the inter-layer temperature through the concentrated or constricted arc
- Smooth surface
- Reduced firing of alloying elements, particularly advantageous, e.g. for CrNi steels