



# ORBITAL WELDING

Orbital welding systems and accessories for high-purity process installations





## ORBIWELD 17 | Micro weld head

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
- For use with electrode diameter 1.0/1.6 mm (0.039"/0.063")

...More from Page 25



## ORBIMAT 300 SW | Orbital welding power supply

Now also in the 300 Ampere class - more power, quality, safety 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 ensures the best welding results, high efficiency and sustainable quality management.

- Future-oriented connectivity through IoT/Industry 4.0 technology
- More sustainable quality management through web-based productivity control
- 100% data storage - fully available at any time and each location
- Cost-saving through digital and precise "PERMANENT-GAS" welding gas control
- Shorter welding cycles through unique gas "FLOW-FORCE" function
- More safety and higher product life through rotor stop function
- 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

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



# Orbital welding power supplies & accessories



## Compatibility matrix power supplies and weld heads

This quick reference shows the different combination possibilities of our power sources and weld heads and make it easier to combine the correct orbital welding systems. Interested in a personal consultation? Then contact us under

+49 (0) 77 31 792-0 or send an email to [tools@orbitalum.com](mailto:tools@orbitalum.com). Our team is happy to find a suitable product for your individual requirement.

	<b>ORBIMAT 180 SW</b> 850 000 001	<b>ORBIMAT 300 SW</b> 852 000 001	<b>ORBIMAT 300 CA AVC/OSC</b> 872 000 020	<b>ORBITWIN SW</b> 853 000 001
<b>ORBIWELD 12</b> 821 000 010	●	●	●	●
<b>ORBIWELD 17</b> 817 000 010	●	●	●	●
<b>ORBIWELD 19</b> 822 000 010	●	●	●	●
<b>ORBIWELD 38S</b> 826 000 001	●	●	●	●
<b>ORBIWELD 76S</b> 827 000 001	●	●	●	●
<b>ORBIWELD 115S</b> 828 000 001	●	●	●	●
<b>ORBIWELD 170</b> 825 000 001	●	●	●	●
<b>HX 12P</b> 847 000 010	●	●	●	○
<b>HX 16P</b> 848 000 010	●	●	●	○
<b>HX 25P</b> 845 000 010	●	●	●	○
<b>TP 250 (KD)</b> 811 000 001 811 000 005	●	●	●	●
<b>TP 400 (KD)</b> 812 000 011	●	●	●	●
<b>TP 600 (KD)</b> 813 000 001 813 000 005	●	●	●	●
<b>TP 1000 (KD)</b> 814 000 001 814 000 005	●	●	●	●
<b>TP 400 AVC/OSC</b> 812 000 012	○	○	●	○
<b>TP 600 AVC/OSC</b> 813 000 002	○	○	●	○
<b>TP 1000 AVC/OSC</b> 814 000 002	○	○	●	○
<b>TX 38P</b> 830 000 005	●	●	●	●
<b>P16 (KD)</b> 831 000 001 831 000 003	●	●	●	●
<b>P16 AVC</b> 831 000 002	○	○	●	○
<b>DVR turntables</b>	●	●	●	●
<b>Manual torch</b> 890 013 010	●	●	●	●

● = Compatible

○ = Not compatible

◐ = Conditionally compatible

\* = Only DC welding

KD = Cold wire supplies

# ORBIMAT SW

## Orbital welding power supplies

World premiere:

Intelligent

welding power source

More quality, safety 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 ORBIMAT 180 SW (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** - fully available at any time and each location



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



**Shorter welding cycles** through unique gas "FLOW-FORCE" function



**More safety** and higher product life through rotor stop function



**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 new generation of 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 ORBIMAT 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 ORBIMAT SW power sources are operated using the 12.4" color touch display screen, or alternatively with the multifunctional rotary knob,

as is familiar from premium automobiles and the ORBIMAT CA series. 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 and safety

The ORBIMAT 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.

The automatic rotor stop function provides improved safety. To this purpose the ORBIMAT SW power sources dispose of a motor torque

control: If the welding head rotor is prevented from rotating by stiffness or an obstruction during automatic rotation, the power supply stops the rotor movement of the welding head immediately. Man and machine are thus provided with better protection, and costly production downtimes, caused by rejected goods and repairs, are prevented. At the same time, the service life of the welding head is extended.

### 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 welding heads: The digital gas control supplies protective gas at a very high volumetric flow rate directly from the pressure reducer to the welding head - the unwanted residual oxygen is flushed out abruptly in the process. The resultant reduced pre-flow and post-flow times make





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



The integrated liquid cooling system keeps connected welding tongs and heads constantly at the right temperature



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

CHARACTERISTICS	ORBIMAT 180 SW	ORBIMAT 300 SW
Easy and convenient operation using a multi-functional rotary knob	●	●
Touch screen operation	●	●
DC current welding source	●	●
WIDE RANGE input voltages for safe operation of power sets or voltage networks with extreme fluctuations in voltage	●	
"Flow Force" function to reduce the gas pre-flow and post-flow time	●	●
"Permanent gas" function	●	●
Digital regulation of the weld gas quantity	●	●
Monitoring of cooling water and weld gas	●	●
Control option for cold wire feed	●	●
Possibility of connecting an external remote control	●	●
Constant or pulsed wire feed motion and rotation	●	●
Optimal visibility and operating conditions thanks to clearly laid-out 12.4" swivel monitor	●	●
Graphically-supported operating interface and multilingual menu navigation via color display	●	●
Metric and imperial measuring units	●	●
Process-oriented, stable and real-time operating system without power-down sequence	●	●
Automatic weld head recognition and resulting parameter modification	●	●
Motor current monitoring of the drive motors	●	●
Capacity to store over 5,000 welding-procedures, providing systematic and clear procedure management thanks to the creation of folder structures	●	●
Welding data logging and printout of actual values	●	●
Integrated system printer	●	●
Possibility of connecting a monitor or printer (through HDMI/USB/LAN)	●	●
Integrated carrier handles	●	●
Option to program up to 99 sectors	●	●
Power and motor slope adjustment between the individual sectors	●	●
Integrated liquid cooling system for cooling the connected weld heads	●	○
Can only be used in combination with a separately available liquid cooling system	●	●

● = Function included    ● = Function only conditionally included    ○ = Not compatible

TECHNICAL SPECIFICATIONS	ORBIMAT 180 SW
ORBIMAT 180 SW	Code 850 000 001
Connectivity IOT/4.0 Package 1	Code 850 080 001
Supply voltage	110 - 230 V, 50/60 Hz, 1-phase
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"
SCOPE OF DELIVERY	ORBIMAT 180 SW
Orbital welding power supply ORBIMAT 180 SW	1 PIECE
Hose connection set ORBIMAT (Code 875 030 018)	1 PIECE
USB stick (Code 850 030 001)	1 PIECE
External keyboard (Code 875 012 057)	1 PIECE
Dummy plug for remote control-socket (Code 850 050 004)	1 PIECE
3.5 liter OCL-30 cooling liquid (Code 850 030 010)	1 canister
Operating instructions with calibration certificate	1 set
QuickStart guide	1 PIECE
TECHNICAL SPECIFICATIONS	ORBIMAT 300 SW
ORBIMAT 300 SW	Code 852 000 001
Connectivity IOT/4.0 Package 1	Code 850 080 001
Supply voltage	400 - 480 V, 50/60 Hz, 3-phase
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"
SCOPE OF DELIVERY	ORBIMAT 300 SW
Orbital welding power supply ORBIMAT300 SW	1 PIECE
Hose connection set ORBIMAT (Code 875 030 018)	1 PIECE
USB stick (Code 850 030 001)	1 PIECE
External keyboard (Code 875 012 057)	1 PIECE
Dummy plug for remote control-socket (Code 850 050 004)	1 PIECE
Operating instructions with calibration certificate	1 set

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

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 welding 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 welding head, even during secondary processing times. As a result, the ORBIMAT system achieves almost completely oxidation-free seams with simultaneously short processing times.

#### Elegant housing for good handling

The ORBIMAT 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 ORBIMAT 180 SW 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 ORBIMAT power supply automatically detects and includes the connected system components. The integrated liquid cooling system keeps connected welding tongs and heads constantly at the right temperature.

#### Expendable with "Connectivity Package"

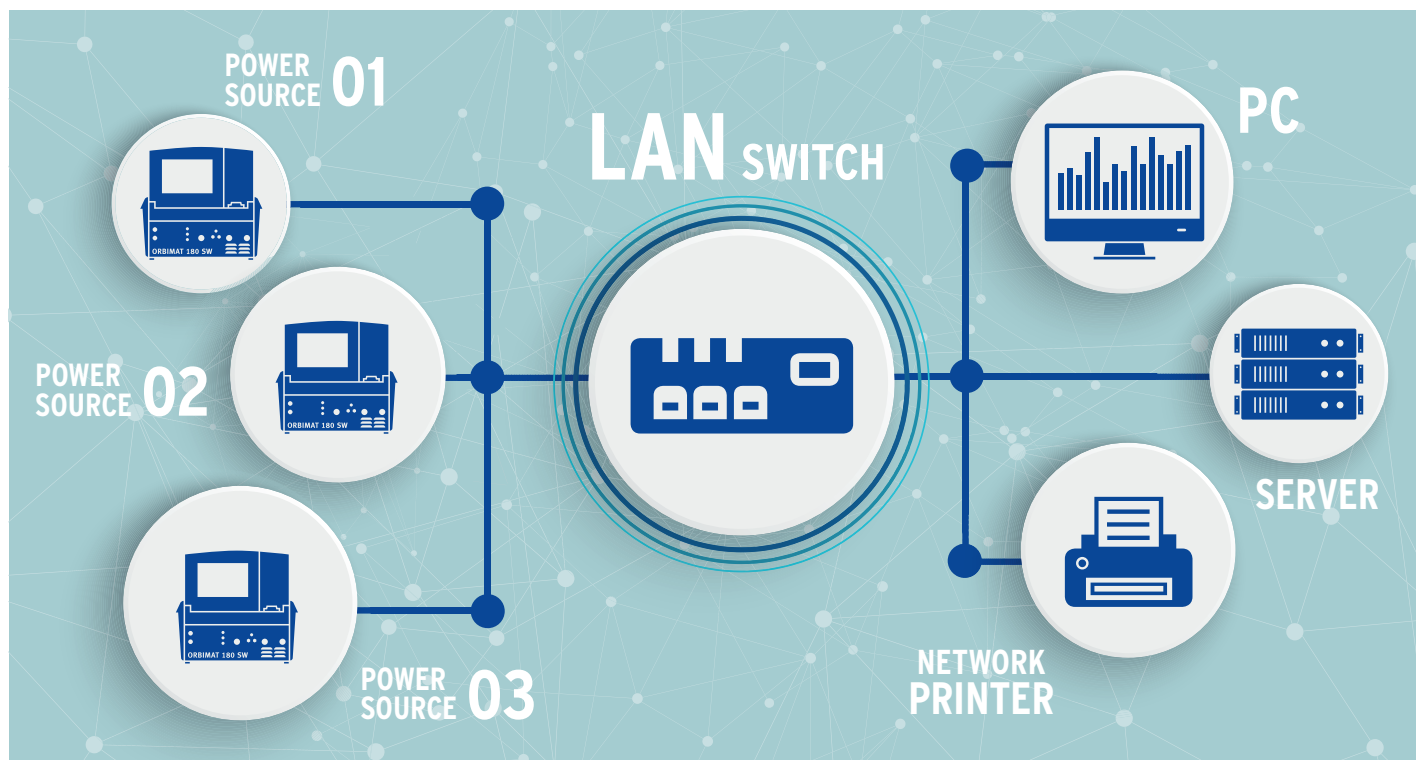
The optionally available "Connectivity Package 1" allows saving and calling up of welding programs via a central network storage location. To increase the process security of the documentation the log files can be stored centrally. Detailed information on "Connectivity package 1" starting on Page 9.

# Connectivity Package

Welding parameters  
in local network environments  
Backing up and further processing

## for ORBIMAT SW power supplies

The optionally available "Connectivity Package 1" enables integration of the ORBIMAT SW 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 ORBIMAT SW 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, electrode 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 ORBIMAT SW 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 package is activated using a license key which can be entered directly into the power supply software. In this way, all relevant functions and interfaces can be immediately activated. A separate connectivity package is required for each welding power source for enabling.



ORBIMAT 180 SW



ORBIMAT 300 SW

## Orbital welding power supply

### ORBIMAT 180 SW (SmartWelder)

Properties, application area, technical specifications and delivery scope, see from Page 7.

ITEM	VERSION	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ORBIMAT 180 SW	110 - 230 V, 50/60 Hz, 1-phase	850 000 001	15.960.00	24.600	27.000
Connectivity IoT/4.0 package 1		850 080 001	1.625.00	0.002	

#### Suitable accessories (optionally available):

- ORBICAR W trolley with integrated liquidcooling, see Page 14
- ORBICOOL Active compressor cooling unit, see Page 14
- ORBICAR S carriage, see Page 15
- Rugged transport case, see Page 15
- ORBITWIN SW switching unit, see Page 15
- Remote control with cable, see Page 16
- Bar code/QR code scanner SW, see Page 16
- ORBmax residual oxygen meter, see Page 83
- TIG manual welding, see Page 88
- Double pressure reducer, see Page 87

### ORBIMAT 300 SW (SmartWelder)

Properties, application area, technical specifications and delivery scope, see from Page 7.

ITEM	VERSION	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ORBIMAT 300 SW	400 - 480 V, 50/60 Hz, 3-phase	852 000 001	18.305.00	35.400	
Connectivity IoT/4.0 package 1		850 080 001	1.625.00	0.002	

#### Suitable accessories (optionally available):

- ORBICAR W trolley with integrated liquidcooling, see Page 14
- ORBICOOL Active compressor cooling unit, see Page 14
- ORBITWIN SW switching unit, see Page 15
- Remote control with cable, see Page 16
- Bar code/QR code scanner SW, see Page 16
- ORBmax residual oxygen meter, see Page 83
- TIG manual welding, see Page 88
- Double pressure reducer, see Page 87



# ORBIMAT CA AVC/OSC

## Orbital welding power supply

Compact power source for mechanized TIG orbital welding with unique operating concept (human machine interface HMI) and a series of further technical features such as electronic arc gap control (AVC) and oscillation (OSC). In connection with an orbital weld head from ORBITALUM TOOLS the user receives an especially innovative as well economical welding system.



Simple and convenient operation by multifunctional rotary knob



10.5" swivel monitor and system printer integrated

model: OM165CA	
Prozessfortschritt	100%
Korrekturfaktor	0
Rohrdurchmesser	62 mm
Anfangswinkel	135°
Endwinkel	240°
Zeit	33.63 sec
Neigung	0.0°
HP Strom	63.5 A
TP Strom	24.1 A
HP Zeit	0.15 sec
TP Zeit	0.15 sec
HP Geschwindigkeit	35 mm/min
TP Geschwindigkeit	35 mm/min
Draht HP-Geschr.	1.98 mm
Draht TP-Geschr.	0 mm

Auto programming and multilingual menu navigation via color display

In addition to tried-and-tested Orbitalum auto-programming via entry of the pipe diameter, wall thickness, material and welding gas using a programming aid, it disposes of a "Flow Force" function for reducing the gas pre-purge time with closed weld heads.

The operating concept of the power sources differs significantly from common operation variants: The operator guidance with display and single-knob operation (rotary knob) stems from car manufacturing and has proven itself worldwide in infotainment systems of modern luxury vehicles. The main advantage is that the operator's view remains focused on the screen.

Further technical refinements of the ORBIMAT CA AVC/OSC are soft keys for significant, quick-to-activate superordinate commands, for example "Start/Stop". The operating system RTOS (Real Time Operating System) used has the advantage in contrast to Windows-based

systems that a direct, abrupt switch-off of the systems does not lead to any problems. This is particularly important for the operation at vulnerable power supplies, such as on construction sites. In contrast to Windows, RTOS always focuses on the control and regulation of the welding process, which is ultimately decisive for the quality of the welding result.

Also unique on the market is the Flow Force function which significantly reduces the processing procedure when using closed weld heads. Through a second channel for protective gas, the protective gas flows directly from the pressure reducer to the chamber of the welding head before the start of the weld process - the unwanted residual oxygen is flushed out abruptly in the process. The ORBIMAT power source automatically detects and includes the system components connected for the course of the process, from closed or opened weld head with automatic control of the arc gap\* (AVC = Arc

Voltage Control) and/or integrated oscillation of the torch\* (OSC = Oscillation) up to the oxygen analysis device. In contrast to conventional orbital welding control systems the setting and controlling of the torch distances to the weld seam takes place directly via the arc gap.

\* Only for ORBIMAT 300 AVC/OSC


PROPERTIES ORBIMAT ORBITAL WELDING POWER SUPPLIES		300 CA AVC/OSC
Easy and convenient operation using a multi-functional rotary knob		●
DC current welding source		●
AC power source for aluminum materials		○
"Flow Force" function to reduce the gas pre-flow and post-flow time		●
"Permanent gas" function		●
Monitoring of cooling water and weld gas		●
Control option for cold wire feed		●
Possibility of connecting an external remote control		●
Constant or pulsed wire feed motion and rotation		●
Optimal visual and operating conditions thanks to clearly laid-out 10.5" swivel monitor		●
Graphically-supported operating interface and multilingual menu navigation via color display		●
Metric and imperial measuring units		●
Process-oriented, stable and real-time operating system without power-down sequence		●
Automatic weld head recognition and resulting parameter modification		●
Capacity to store over 5,000 welding procedures, providing systematic and clear procedure management thanks to the creation of folder structures		●
Welding data logging and printout of actual values		●
Integrated system printer		●
Possibility of connecting a monitor or printer (via VGA/LPT)		●
Integrated multi card reader for transfer of log files and welding programs via CompactFlash Card (CF), SD, MMC, SM, Sony Memory Stick		●
Optional PC software (OrbiProg CA) for welding procedure management and logging		●
Integrated, folding carrying grips		●
PSS (Pro Service System) for external functional checking of the system as well as easy maintenance and fast replacement of parts thanks to system component design		●
Option to program up to 99 sectors		●
Power and motor slope adjustment between the individual sectors		●
Can only be used in combination with a separately available liquid cooling system		●
AC setting option of positive and negative half-cycle with a 20 - 80% ratio		○
AC frequency setting 50 - 200 Hz		○
AVC electronic arc gap control: Arc gap programmable in "mm" or via the arc voltage in "V", OSC oscillation with sampling function for automated determination of the tube joint between the sides of the pipe		●
SCOPE OF DELIVERY		300 CA AVC/OSC
Orbital welding power source of the ORBIMAT CA series	PCS.	1
Hose connection set ORBIMAT (Code 875 030 018)	PCS.	1
Dummy plug for remote control socket (Code 875 050 006)	PCS.	1
Welding current connection adapter	PCS.	1
External operating keyboard (Code 875 012 057)	PCS.	1
External remote control (Code 875 050 001)	PCS.	1
Key for key switch (for re-ordering of 1 key: Code 875 012 058)	PCS.	2
Operating instructions with calibration certificate	Set	1
QuickStart guide	PCS.	1

● = Function included

○ = Function not included

◐ = Function only conditionally included

\* = Only DC welding

SUITABLE ACCESSORIES (optionally available):	TECHNICAL SPECIFICATIONS	300 CA AVC/OSC
<ul style="list-style-type: none"> <li>• ORBICAR W trolley with integrated liquidcooling</li> <li>• ORBICOOL Active compressor cooling unit</li> <li>• ORBICAR S carriage</li> <li>• Rugged transport case</li> <li>• ORBITWIN SW Switching Unit</li> <li>• Remote control with cable</li> <li>• Software/Hardware Package "CA"</li> <li>• ORBmax residual oxygen meter</li> <li>• Double pressure reducer</li> <li>• TIG manual welding torch for ORBIMAT</li> </ul>	Code	872 000 020
	Supply voltage	400 - 480 V +/- 10%, 50/60 Hz, 3-phase
	Control range (Supply voltage > 160 V)	5 - 300 A
	Duty cycle	40% at 300 A 60% at 260 A 100% at 220 A
	Dimensions (LxDxH)	540 x 420 x 440 mm 21.3" x 16.5" x 17.3"
		

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

## Orbital welding power supplies

### ORBIMAT CA AVC/OSC

Properties, application area, technical specifications and delivery scope, see from Page 11.

ITEM	VERSION	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ORBIMAT 300 CA AVC/OSC	400 - 480 V +/- 10%, 50/60Hz, 3-phase	872 000 020	28.890.00	37.300	53.000



ORBIMAT 300 CA AVC/OSC

### Suitable accessories (optionally available):

- ORBICAR W trolley with integrated liquidcooling, see Page 14
- ORBICOOL Active compressor cooling unit, see Page 14
- Rugged transport case, see Page 15
- Remote control with cable, see Page 16
- Software/Hardware Package "CA", see Page 16
- ORBmax residual oxygen meter, see Page 83
- TIG manual welding, see Page 88
- Double pressure reducer, see Page 87
- Welding current connection adapter set, see Page 87





ORBICAR W trolley with integrated liquidcooling

## Cooling systems for ORBIMAT

### ORBICAR W trolley with integrated liquidcooling

Thanks to its integrated liquid cooling function, the ORBICAR W trolley is the perfect complement to Orbitalum power sources\*. Beside the liquid cooling, the trolley 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 17).

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"
Dimensions storage area (LxDxH)	65 x 38 x 65 cm/26.6 x 15 x 26.6"

ITEM	SUITABLE FOR ORBIMAT	CODE	EUR	KG
ORBICAR W 300 trolley	300 SW, 300 CA	884 000 002	1.780.00	58.200
ORBICAR W 165 trolley	165 CA*	884 000 004	1.900.00	58.200
ORBICAR W 180 trolley	180 SW	884 000 005	1.900.00	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 current sources

2 canisters each 3.5 liters (0.92 gal) are included in the scope of delivery of the OCL-30 cooling liquid (see Page 17). Suitable for all\* ORBIMAT 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"

ITEM	VERSION	CODE	EUR	KG
ORBICOOL Active for ORBIMAT 165 CA*	230 V, 50 Hz	889 000 011	3.030.00	42.000
ORBICOOL Active for ORBIMAT 300 CA/SW	230 V, 50 Hz	889 000 012	3.030.00	42.000
ORBICOOL Active for ORBIMAT 180 SW	230 V, 50 Hz	889 000 015	3.030.00	42.000

\* ORBIMAT 165 power sources must be modified in the factory.

#### ORBITAL WELDING POWER SUPPLIES & ACCESSORIES

## Other accessories for ORBIMAT

### Weld current connection adapter set

See Page 87.



Weld 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. 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 ORBIMAT	CODE	EUR	KG
ORBITWIN SW Switching Unit	180 SW, 165 CA*, 300 CA*, 300 SW, 300 CA AC/DC*	<b>853 000 001</b>	3.990.00	15.00
Connection set ORBITWIN SW at ORBIMAT CA	165 CA, 300 CA, 300 CA AC/DC	<b>853 050 010</b>	368.00	0.100
Connection extension set 1.1 m (3.6 ft)	180 SW	<b>853 050 011</b>	630.00	2.585

\* Usage of ORBITWIN SW with ORBIMAT 165 CA, 300 CA and 300 CA AC/DC only possible in combination with the "connection set ORBITWIN SW at ORBIMAT CA" (available separately, see table above).

### ORBICAR S carriage

The ORBICAR S is a practical carriage with shelf and fastening possibility for a gas bottle and the ideal supplement for the Orbitalum 165 A and 180 SW orbital welding power supplies.

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	EUR	KG
ORBICAR S carriage	<b>884 000 001</b>	660.00	19.100

### Rugged transport case

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

ITEM	SUITABLE FOR ORBIMAT	CODE	EUR	KG
165 transport case	165 CA	<b>875 050 002</b>	865.00	17.500
300 transport case	300 CA, 300 CA AC/DC	<b>874 050 001</b>	985.00	20.800
180 SW transport case	180 SW	<b>850 030 020</b>	1.365.00	18.700



Transport case 165/300



180 SW transport case



Software/Hardware Package "CA"



CompactFlash Card ORBIMAT CA



Remote control with cable



Bar code/QR code scanner SW

## Software/Hardware Package "CA"

Suitable for all ORBIMAT CA orbital welding power supplies.

For external programming and data documentation, consisting of:

- 1 CompactFlash card for data transfer between machine and PC.  
For saving welding data logs or expanding the program memory. Storage capacity of up to 5,000 welding programs.
- 1 USB card reading device for reading out the CompactFlash Card at the PC.
- Software ORBIPROG CA. Allows saving and printing of programs and log files at the PC. Conversion of all data into PDF and Excel format Programs from the Orbitalum machine the C series (e.g. ORBIMAT 160 C) can also be converted into the CA format by means of the software. The parameters of the CA programs can be edited with the software and can be transferred to the machine again after editing and used there.

ITEM	CODE	EUR	KG
Software/Hardware Package "CA"	875 050 003	515.00	0.488

## Storage media

For saving welding data logs or expanding the program memory. Storage capacity of up to 5,000 welding programs.

When the Software/Hardware Package "CA" is purchased, 1 **CompactFlash Card ORBIMAT CA** is already included in the scope of delivery.

ITEM	CODE	EUR	KG
CompactFlash Card ORBIMAT CA	875 012 056	42.00	0.010
ORBIMAT SW USB stick	850 030 001	26.50	0.002

## Remote control with cable

Suitable for all ORBIMAT orbital welding power supplies (the remote control is already included in the scope of delivery with the ORBIMAT 300 CA AVC/OSC). It is not required when working with enclosed orbital weld heads.

Remote including "Remote control adapter OM CA to ORBIMAT SW" (Code 850 040 030). This adapter can be retrofitted at any time and allows the connection of older remote control units to the new SW generation.

ITEM	CABLE LENGTH [M]	CABLE LENGTH [INCH]	CODE	EUR	KG
Remote control with cable	7.5	24.6	875 050 001	955.00	1.350
OM CA remote control adapter for OM 180 SW (upgrade)	-	-	850 040 030	134.00	0.118

## Bar code/QR code scanner SW

Compatible with the ORBIMAT SW 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	EUR	KG
Bar code/QR code scanner SW	850 030 005	347.00	0.250

### ORBITAL WELDING POWER SUPPLIES & ACCESSORIES



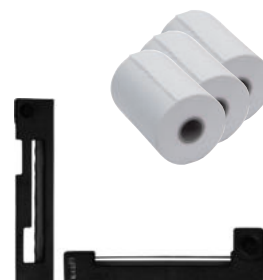
## Consumables for ORBIMAT

### Replacement paper rolls and ribbon cartridges

For internal system printer.  
Suitable for all ORBIMAT orbital welding power supplies.

1 paper roll and 1 ribbon cartridge are already included in the scope of delivery of the ORBIMAT power sources.

ITEM	CODE	EUR	KG
Panel printer paper rolls, 3-pack	875 050 017	16.50	0.150
Panel printer ink ribbon cartridge CA/SW	875 030 004	22.50	0.010



Replacement paper rolls and ribbon cartridges

### OCL-30 cooling liquid

Anti-freeze pre-mix for ORBIMAT power sources and cooling units to avoid freezing of the cooling water. 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, ORBICOOL Active, 165 CA and 180 SW.

1 canister already included in the scope of delivery of the ORBIMAT 165 CA and 180 SW power sources.

ITEM	VERSION	CODE	EUR	KG
OCL-30 cooling liquid	Canister each 3.5 l (0.92 gal)	850 030 010	42.00	3.715



OCL-30 cooling liquid

### Hose connection set ORBIMAT

1 connection set is already included in the scope of delivery of the ORBIMAT power sources.

Consisting of:

- Teflon gas hose
- Ear clamps with insert ring
- Hose connectors 3/8"
- Water hose for tank deaeration
- Gas connector inlet
- Union nuts 3/8"
- Hose connectors 1/4"
- Union nuts 1/4"
- Funnel

ITEM	CODE	EUR	KG
Hose connection set ORBIMAT	875 030 018	66.00	0.445

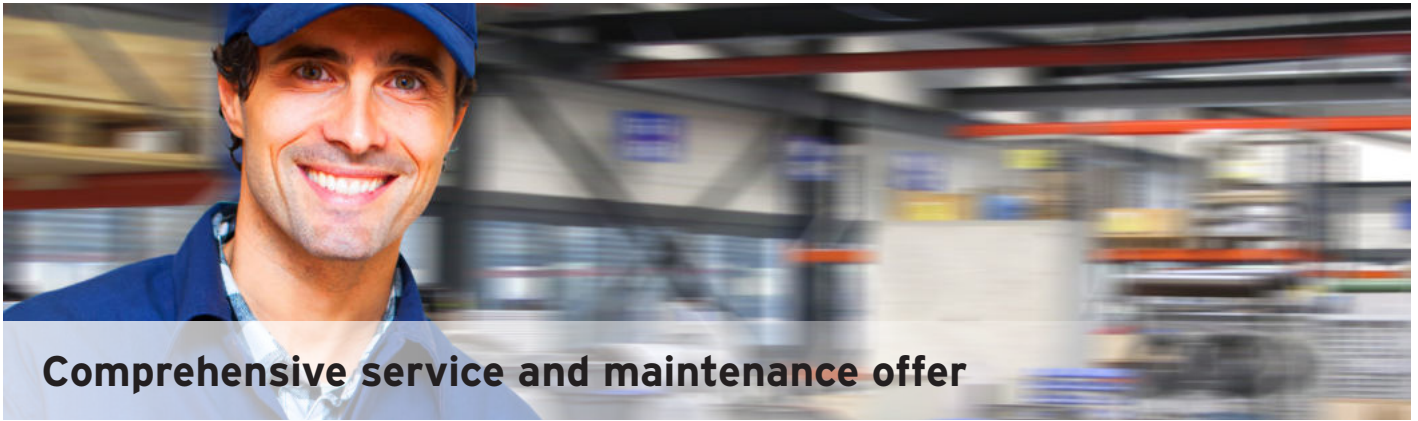


Hose connection set ORBIMAT

### Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Double pressure reducer, see Page 87
- WS2 tungsten electrodes, see Page 87
- TIG manual welding torch for ORBIMAT, see Page 88
- Welding current connection adapter set, see Page 87

#### ORBITAL WELDING POWER SUPPLIES & ACCESSORIES



## 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:



**+49 (0) 77 31 792-786**



**customerservice@itw-ocw.com**

### **Do not forget: Fill out the service form!**

The service form can be downloaded under: [www.orbitalum.de/service.html](http://www.orbitalum.de/service.html)

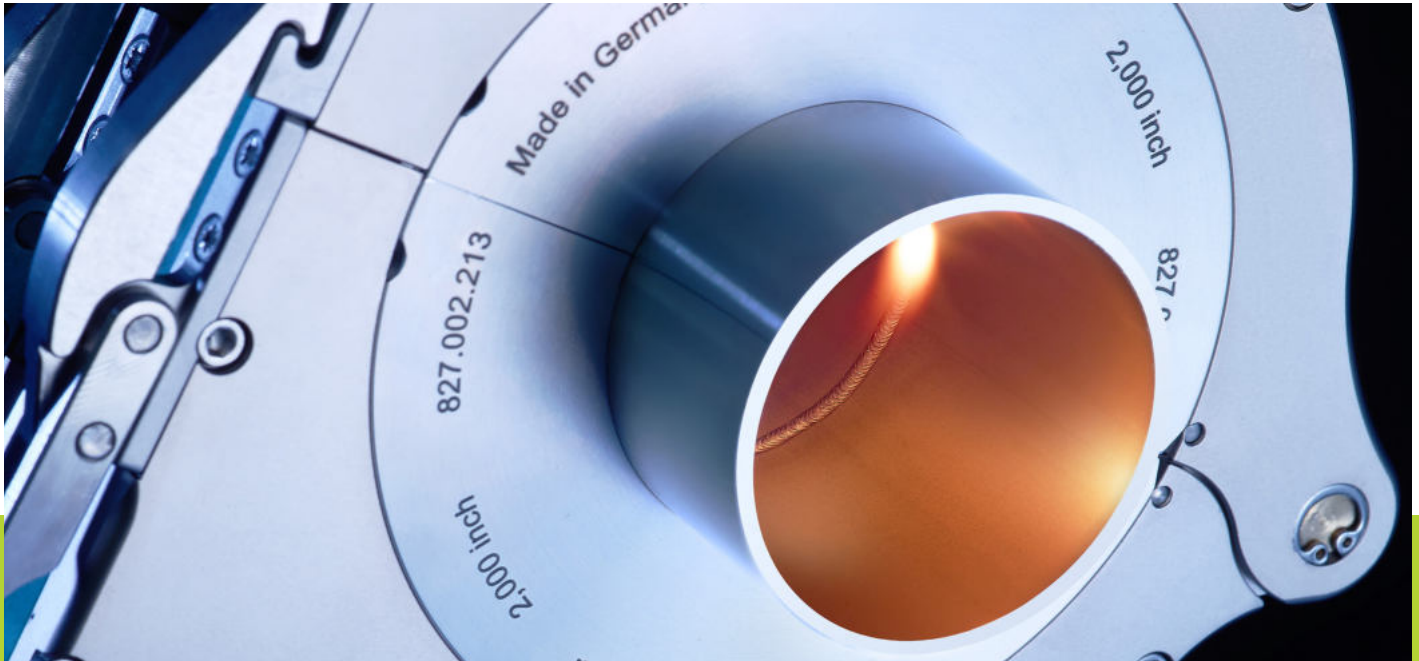
## Our services:

- Repairing, replacing
- Cost quotation
- Proactive maintenance
- Service training for customers
- Rental machines for bridging repair periods with special conditions
- Collection service for machines
- 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

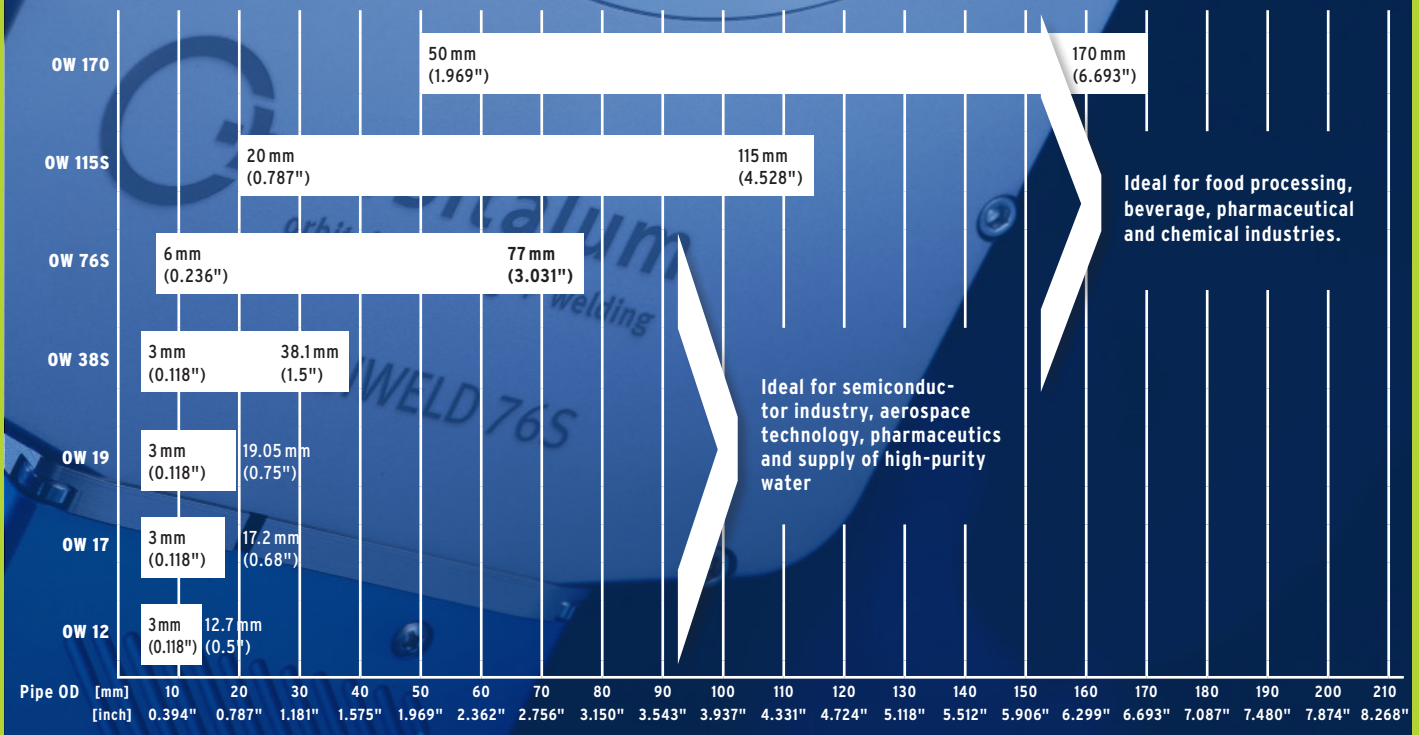
## Your advantages:

- 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

# 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		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"	
HOSE 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



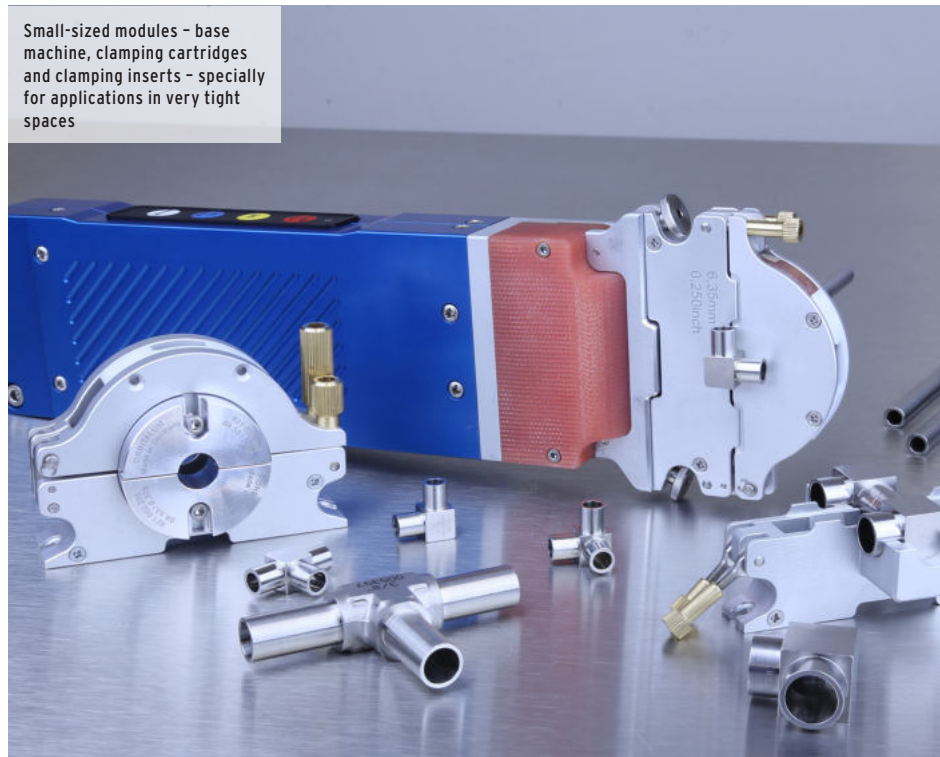
# ORBIWELD 12

**Compact TIG weld head**  
**- ideal for tight spaces**

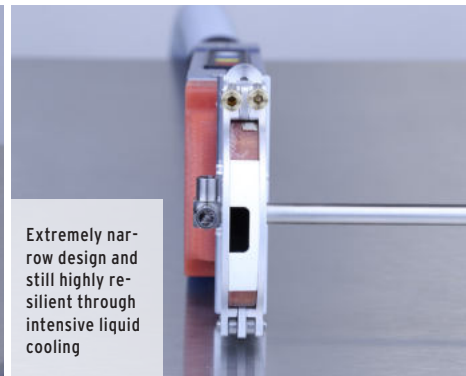
## Micro weld head

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



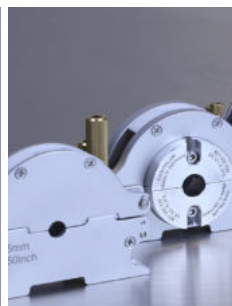
Robust and stable aluminum handle with integrated control panel



Quick change system for clamping cartridges



Ideal for welding all common micro fittings



Diameter-specific clamping cartridges - available separately



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

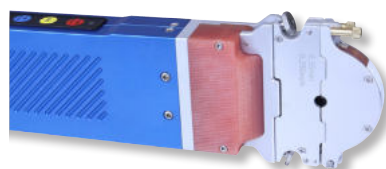


Wide accessories program, e.g. ORBmax residual oxygen meter

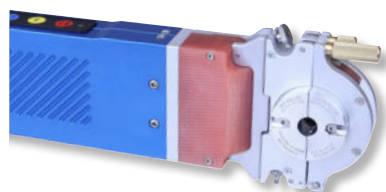
SCOPE OF APPLICATION OW 12	MICRO FITTING AT MICRO FITTING	MICRO FITTING AT HOSE	HOSE AT HOSE	ADVANTAGES:
Clamping cassettes, Type "A" (narrow)	x	x	x	High flexibility through narrow design
Clamping cassettes, Type "B" (wide)			x	Low costs through exchangeable cartridges

APPLICATION AREA	ORBIWELD 12
Code	821 000 010
Pipe 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"> <li>• 1 micro weld head ORBIWELD 12</li> <li>• 1 transport case</li> <li>• 1 tool set</li> <li>• 1 feeler gauge</li> <li>• 1 set of operating instructions and spare parts list</li> </ul>
Suitable accessories (optionally available):	<ul style="list-style-type: none"> <li>• Clamping cassettes for OW 12, Type "A" (small)</li> <li>• Clamping cassette for OW 12, Type "B" (wide)</li> <li>• Clamping inserts for OW 12, Type "B" (wide)</li> <li>• ESG electrode grinders</li> <li>• ORBmax residual oxygen meter</li> <li>• ORBIPURGE forming set</li> <li>• Hose package extensions</li> <li>• WS2 tungsten electrodes</li> </ul>

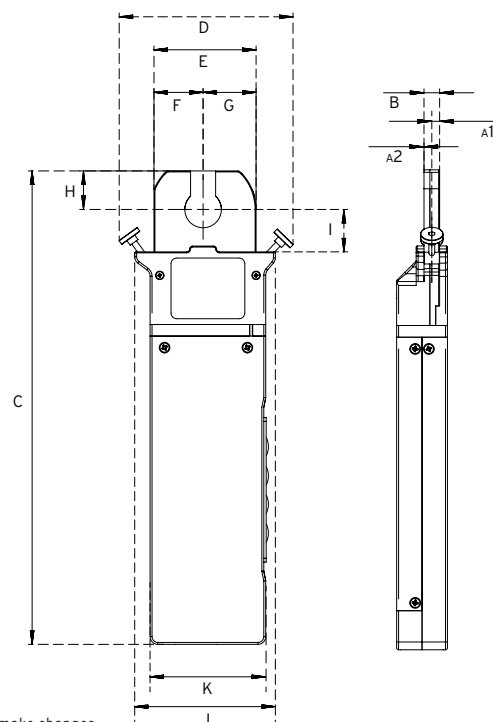
DIMENSIONS ORBIWELD 12	DIMENSION		ELECTRODE GAP			
			CASSETTE TYPE "A"		CASSETTE TYPE "B"	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	4.25	0.167	6.35	0.250	15.60	0.614
Dimension "A2"	3.75	0.148	5.85	0.230	15.10	0.594
Dimension "B"	8.00	0.315	12.20	0.480	30.70	1.209
Dimension "C"	245.70	9.673				
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				



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



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



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

## Micro weld head OW

### ORBIWELD 12

Properties, application area, technical specifications and delivery scope, see Page 21.

Clamping cassettes and clamping inserts are not included in the scope of delivery (see from Page 23).

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 12	821 000 010	7.195.00	4.800	11.000

\* Machine weight including hose package

### Suitable accessories (optionally available):

- Clamping cassettes for OW 12, Type "A" (narrow), see Page 23
- Clamping cassette for OW 12, Type "B" (wide), see Page 23
- Clamping inserts for OW 12, Type "B" (wide), see Page 24
- Welding current connection adapter set, see Page 87

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

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	PIPE OD [MM]	PIPE OD [INCH]	CODE	EUR	KG
Clamping cassette VA for OW 12, Type "A" (narrow), V3	2.00	0.079	821 050 200	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	3.00	0.118	821 050 201	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	3.18	0.125	821 050 202	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	6.00	0.236	821 050 203	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	6.35	0.250	821 050 204	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	8.00	0.315	821 050 205	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	9.53	0.375	821 050 206	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	10.00	0.394	821 050 207	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	12.00	0.472	821 050 208	830.00	0.100
Clamping cassette VA for OW 12, Type "A" (narrow), V3	12.70	0.500	821 050 209	830.00	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	EUR	KG
Clamping cassette for OW 12, Type "B" (wide)	821 050 002	1.140.00	0.095



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)

#### CLOSED ORBITAL WELD HEADS



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

## 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).

ITEM	PIPE OD [MM]	PIPE OD [INCH]	CODE	EUR	KG
Clamping insert for OW 12, Type "B" (wide), 4-part	3.00	0.118	<b>821 002 220</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	3.18	0.125	<b>821 002 222</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	4.00	0.157	<b>821 002 224</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	6.00	0.236	<b>821 002 228</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	6.35	0.250	<b>821 002 229</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	7.00	0.276	<b>821 002 230</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	7.94	0.313	<b>821 002 232</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	8.00	0.315	<b>821 002 233</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	9.00	0.354	<b>821 002 234</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	9.53	0.375	<b>821 002 235</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	10.00	0.394	<b>821 002 237</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	12.00	0.472	<b>821 002 243</b>	176.00	0.050
Clamping insert for OW 12, Type "B" (wide), 4-part	12.70	0.500	<b>821 002 245</b>	176.00	0.050

## Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Hose package extensions, see Page 86
- WS2 tungsten electrodes, see Page 87
- Welding current connection adapter set, see Page 87

## CLOSED ORBITAL WELD HEADS



# ORBIWELD 17

Extremely short production cycles

thanks to integrated control elements

and active cooling

## Micro weld head

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 cartridges 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.

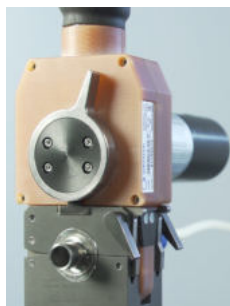
When the cartridge is in place, the weld head is inserted and secured in the cartridge and welding can begin. The operating elements required for starting, stopping, gas flow and electrode changes are integrated in the handle of the head. An LED informs the welder of the operating conditions, like readiness 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.

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.



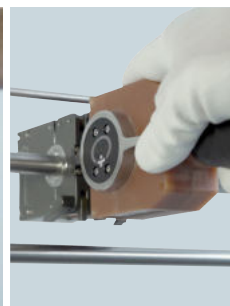
An insertion gage which is permanently attached to the clamping cartridge and thus cannot be lost ensures precise positioning to the tube joint to be welded.



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 in the workshop.



An extremely narrow design for use in confined spaces, such as in the semi-conductor industry.

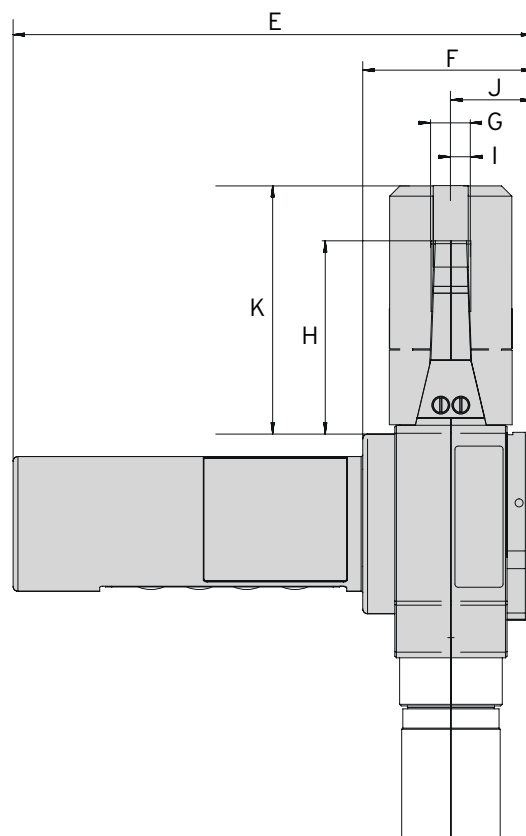
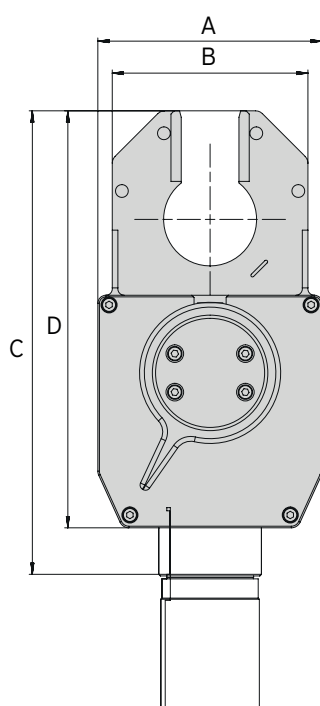
APPLICATION AREA	ORBIWELD 17
Code	817 000 001
Pipe OD, min. - max.	3.0 - 17.2 mm 0,118" - 0,677"
Electrode diameter	1.0/1.6 mm 0.039"/0.063"
Machine weight including hose package	5.5 kg 12.1 lbs
Hose package length	7.5 m 24.6 ft

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



DIMENSIONS	ORBIWELD 17	
	DIMENSION	
	[MM]	[INCH]
Dimension "A"	70.00	2.756
Dimension "B"	61.00	2.402
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"	12.40	0.488
Dimension "H"	60.25	2.372
Dimension "I"	5.00	0.120
Dimension "J"	26.80	1.055
Dimension "K"	75.20	2.961

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



## Micro weld head OW

### ORBIWELD 17

Properties, application area, technical specifications and delivery scope, see Page 25.

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

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 17	817 000 001	9.400.00	5.500	13.900

\* Machine weight including hose package



ORBIWELD 17

### 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:

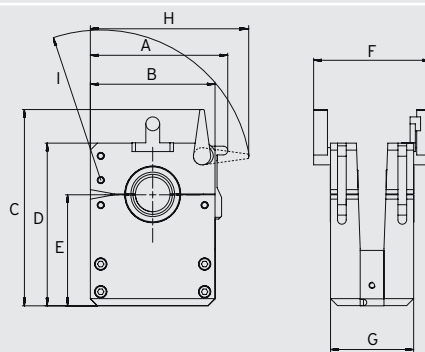
- 1 x insertion gage for standard applications
- 1 x insertion gage for COAX applications
- 1 x 3/32" hexagon wrench
- 1 x 1/16" hexagon wrench
- 1 x plastic box

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



Clamping cassette for OW17  
(clamping inserts are not included in the scope of delivery)

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
Dimension "J"	19.05	0.750



ITEM	CODE	EUR	KG
Clamping cassette for OW 17	817 050 010	1.735.00	0.442

CLOSED ORBITAL WELD HEADS



Clamping insert 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.

In the case of COAX connections, 2 tubes with different tube diameters are usually welded together, e.g. a tube with a 12.7 mm (1/2") diameter and a tube with a 15.88 mm (5/8") diameter. For such applications 2 clamping inserts with correspondingly different hose diameters have to be inserted.

Further dimensions on request.

PIPE OD [MM]	PIPE OD [INCH]	CODE	EUR
3.00	0.118	<b>817 002 209</b>	231.00
3.18	0.125	<b>817 002 201</b>	231.00
4.00	0.157	<b>817 002 210</b>	231.00
4.76	0.188	<b>817 002 202</b>	231.00
5.00	0.196	<b>817 002 211</b>	231.00
6.00	0.236	<b>817 002 212</b>	231.00
6.35	0.250	<b>817 002 203</b>	231.00
7.94	0.313	<b>817 002 204</b>	231.00
8.00	0.314	<b>817 002 213</b>	231.00
9.00	0.354	<b>817 002 214</b>	231.00
9.53	0.375	<b>817 002 205</b>	231.00
10.00	0.393	<b>817 002 215</b>	231.00
11.00	0.433	<b>817 002 216</b>	231.00
12.00	0.472	<b>817 002 217</b>	231.00
12.70	0.500	<b>817 002 206</b>	231.00
14.00	0.551	<b>817 002 218</b>	231.00
14.29	0.563	<b>817 002 207</b>	231.00
15.00	0.590	<b>817 002 219</b>	231.00
15.88	0.625	<b>817 002 208</b>	231.00
16.00	0.629	<b>817 002 220</b>	231.00
17.20	0.677	<b>817 002 221</b>	231.00

## Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Hose package extensions, see Page 86
- WS2 tungsten electrodes, see Page 87
- Welding current connection adapter set, see Page 87

### CLOSED ORBITAL WELD HEADS



# 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!

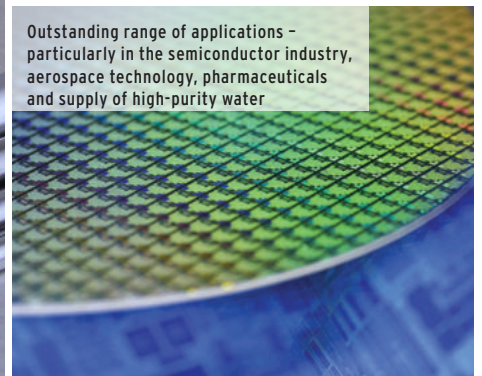
Can be used in all positions, irrespective of whether the tubes to be connected are positioned horizontally, vertically or inclined



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:

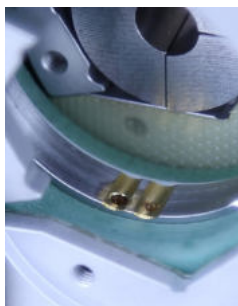
- ✓ Optimized scissors clamping system
- ✓ Flip-up weld head cover "Flip-Cover"
- ✓ Optimized weld gas control
- ✓ One-hand operation
- ✓ Completely liquid-cooled
- ✓ Integrated control panel
- ✓ 7.5 m (24.6 ft) hose package



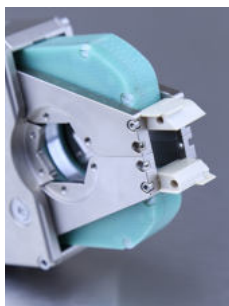
Robust and stable aluminum handle with integrated control panel



Practical clamping locks allowing single-hand operation



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



Folding weld head cover "FlipCover"



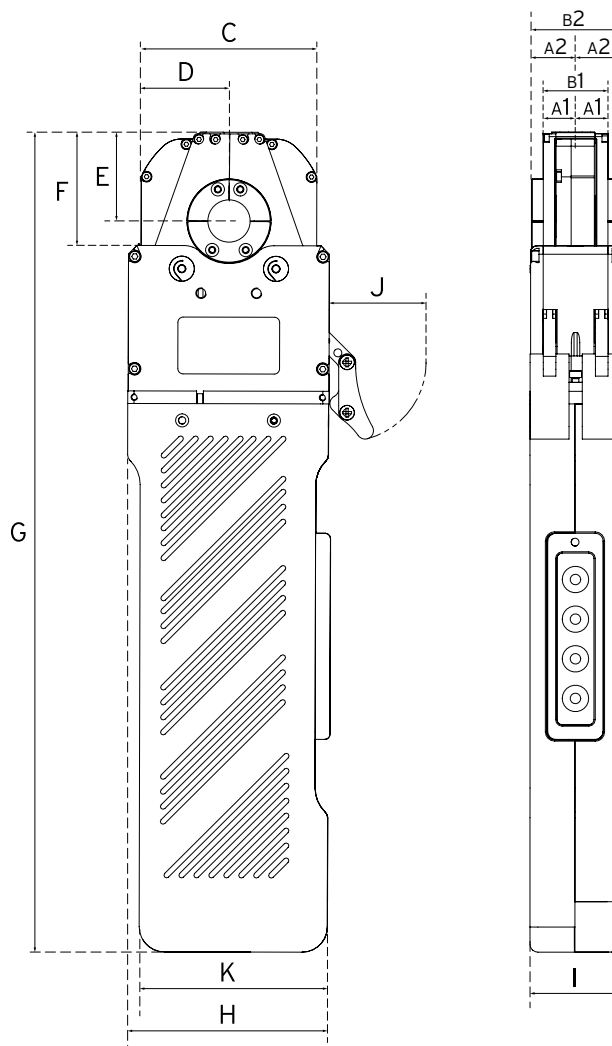
Diameter-specific clamping inserts (each 6-part, wide and narrow) available separately



Wide accessories program, e.g. ORBIPURGE forming set

APPLICATION AREA	ORBIWELD 19
Code	822 000 010
Pipe OD, min. - max.	3.0 - 19.05 mm 0.118" - 0.750"
Electrode diameter	1.0/1.6 mm 0.039"/0.063"
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"> <li>• 1 micro weld head ORBIWELD 19</li> <li>• 1 transport case</li> <li>• 1 tool set</li> <li>• 1 Feeler gauge</li> <li>• 1 set of operating instructions and spare parts list</li> </ul>
Suitable accessories (optionally available):	<ul style="list-style-type: none"> <li>• Clamping inserts for OW 19</li> <li>• ESG electrode grinders</li> <li>• ORBmax residual oxygen meter</li> <li>• ORBIPURGE forming set</li> <li>• Hose package extensions</li> <li>• WS2 tungsten electrodes</li> </ul>

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.



## Micro weld head OW

### ORBIWELD 19

Properties, application area, technical specifications and delivery scope, see Page 29.

Clamping inserts are not included in the scope of delivery (see from Page 32).



ORBIWELD 19

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Micro weld head OW 19	822 000 010	9.090.00	6.500	14.800

\* Machine weight including hose package

### Suitable accessories (optionally available):

- Clamping inserts for OW 19, see Page 32
- Welding current connection adapter set, see Page 87

CLOSED ORBITAL WELD HEADS



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



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

## 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.

ITEM	PIPE OD [MM]	PIPE OD [INCH]	TYPE "W" (WIDE)			TYPE "S" (SMALL/NARROW)		
			CODE	EUR	KG	CODE	EUR	KG
Clamping insert for OW 19, 6-part	3.00	0.118	<b>822 002 120</b>	369.00	0.100	<b>822 002 320</b>	412.00	0.044
Clamping insert for OW 19, 6-part	3.18	0.125	<b>822 002 122</b>	369.00	0.100	<b>822 002 322</b>	412.00	0.044
Clamping insert for OW 19, 6-part	3.95	0.156	<b>822 002 123</b>	369.00	0.099	<b>822 002 323</b>	412.00	0.044
Clamping insert for OW 19, 6-part	4.00	0.157	<b>822 002 124</b>	369.00	0.099	<b>822 002 324</b>	412.00	0.044
Clamping insert for OW 19, 6-part	4.78	0.188	<b>822 002 126</b>	369.00	0.099	<b>822 002 326</b>	412.00	0.043
Clamping insert for OW 19, 6-part	5.95	0.234	<b>822 002 127</b>	369.00	0.097	-	-	-
Clamping insert for OW 19, 6-part	6.00	0.236	<b>822 002 128</b>	369.00	0.097	<b>822 002 328</b>	412.00	0.043
Clamping insert for OW 19, 6-part	6.35	0.250	<b>822 002 129</b>	369.00	0.097	<b>822 002 329</b>	412.00	0.043
Clamping insert for OW 19, 6-part	7.00	0.276	<b>822 002 130</b>	369.00	0.096	-	-	-
Clamping insert for OW 19, 6-part	7.94	0.313	<b>822 002 132</b>	369.00	0.094	-	-	-
Clamping insert for OW 19, 6-part	8.00	0.315	<b>822 002 133</b>	369.00	0.094	<b>822 002 333</b>	412.00	0.042
Clamping insert for OW 19, 6-part	9.00	0.354	<b>822 002 134</b>	369.00	0.092	<b>822 002 334</b>	412.00	0.041
Clamping insert for OW 19, 6-part	9.53	0.375	<b>822 002 135</b>	369.00	0.091	<b>822 002 335</b>	412.00	0.040
Clamping insert for OW 19, 6-part	9.95	0.392	<b>822 002 136</b>	369.00	0.090	<b>822 002 336</b>	412.00	0.040
Clamping insert for OW 19, 6-part	10.00	0.394	<b>822 002 137</b>	369.00	0.090	<b>822 002 337</b>	412.00	0.040
Clamping insert for OW 19, 6-part	12.00	0.472	<b>822 002 143</b>	369.00	0.083	<b>822 002 343</b>	412.00	0.038
Clamping insert for OW 19, 6-part	12.10	0.476	-	-	-	<b>822 002 344</b>	412.00	0.038
Clamping insert for OW 19, 6-part	12.70	0.500	<b>822 002 145</b>	369.00	0.081	<b>822 002 345</b>	412.00	0.037
Clamping insert for OW 19, 6-part	13.00	0.512	<b>822 002 146</b>	369.00	0.080	-	-	-
Clamping insert for OW 19, 6-part	13.50	0.531	<b>822 002 148</b>	369.00	0.078	<b>822 002 348</b>	412.00	0.036
Clamping insert for OW 19, 6-part	14.00	0.551	<b>822 002 150</b>	369.00	0.076	<b>822 002 350</b>	412.00	0.035
Clamping insert for OW 19, 6-part	15.00	0.591	<b>822 002 153</b>	369.00	0.071	<b>822 002 353</b>	412.00	0.034
Clamping insert for OW 19, 6-part	15.30	0.602	-	-	-	<b>822 002 354</b>	412.00	0.033
Clamping insert for OW 19, 6-part	15.88	0.625	<b>822 002 157</b>	369.00	0.066	<b>822 002 357</b>	412.00	0.032
Clamping insert for OW 19, 6-part	16.00	0.630	<b>822 002 158</b>	369.00	0.066	<b>822 002 358</b>	412.00	0.032
Clamping insert for OW 19, 6-part	17.20	0.677	<b>822 002 162</b>	369.00	0.058	-	-	-
Clamping insert for OW 19, 6-part	17.30	0.681	<b>822 002 163</b>	369.00	0.058	<b>822 002 363</b>	412.00	0.030
Clamping insert for OW 19, 6-part	18.00	0.709	<b>822 002 164</b>	369.00	0.053	<b>822 002 364</b>	412.00	0.029
Clamping insert for OW 19, 6-part	19.00	0.748	<b>822 002 165</b>	369.00	0.044	<b>822 002 365</b>	412.00	0.027
Clamping insert for OW 19, 6-part	19.05	0.750	<b>822 002 166</b>	369.00	0.044	<b>822 002 366</b>	412.00	0.027

## Other accessories for orbital welding

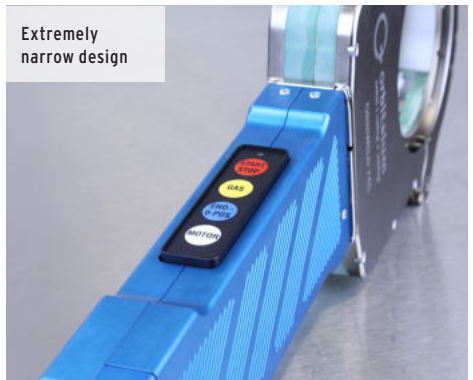
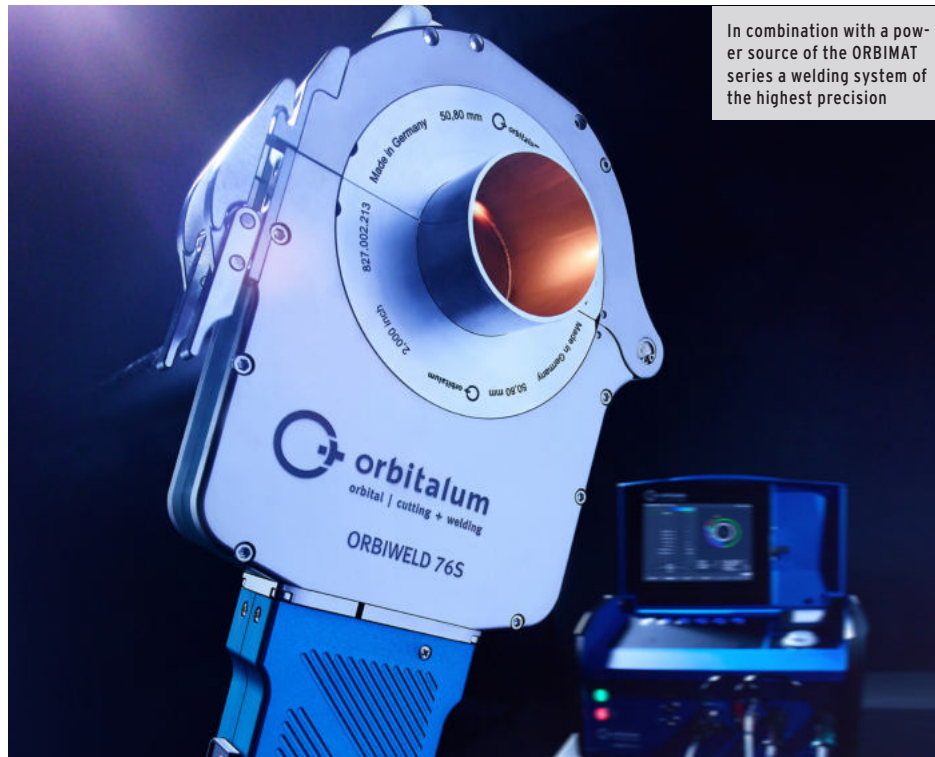
- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Hose package extensions, see Page 86
- WS2 tungsten electrodes, see Page 87
- Welding current connection adapter set, see Page 87



# ORBIWELD 38S, 76S, 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.



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

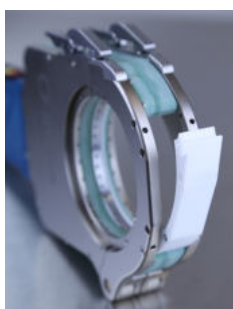
- Quick change system for clamping inserts allows simple locking and releasing without tools
- Cost-effective clamping inserts
- Stable clamping locks in connection with the clamping inserts available for all pipe dimensions ensure a secure and offset-free clamping and centering of the parts to be welded.
- 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



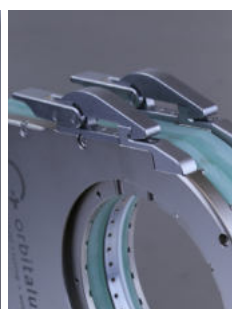
Robust and stable aluminum handle with integrated control panel



Simpler inserting of the electrodes with 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

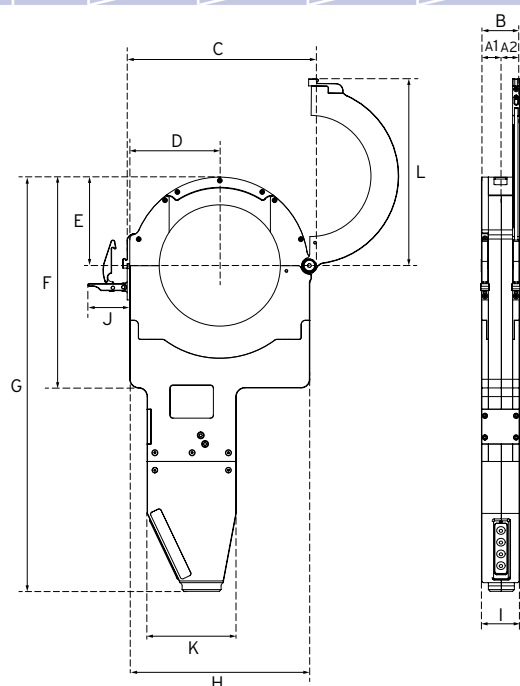
	ORBIWELD 38S				ORBIWELD 76S				ORBIWELD 115S					
DIMENSIONS	DIMENSION		ELECTRODE GAP CLAMPING INSERT*		DIMENSION		ELECTRODE GAP CLAMPING INSERT*		DIMENSION		ELECTRODE GAP			
											CLAMPING INSERT* TYPE "S"		CLAMPING INSERT+ TYPE "W"	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Dimension "A1"	17.00	0.669	17.50	0.689	19.00	0.748	19.00	0.748	22.75	0.896	25.00	0.984	45.75	1.801
Dimension "A2"	17.00	0.669	17.50	0.689	19.00	0.748	19.00	0.748	21.25	0.837	25.00	0.984	44.25	1.742
Dimension "B"	34.00	1.339	35.00	1.378	38.00	1.496	38.00	1.496	44.00	1.732	50.00	1.969	90.00	3.543
Dimension "C"	112.00	4.409			159.00	6.260			220.00	8.661				
Dimension "D"	47.50	1.870			67.50	2.657			104.00	4.094				
Dimension "E"	47.00	1.850			66.00	2.598			102.00	4.016				
Dimension "F"	144.00	5.669			187.00	7.362			244.00	9.606				
Dimension "G"	357.00	14.055			400.00	15.748			480.00	18.898				
Dimension "H"	95.00	3.740			135.00	5.315			208.00	8.189				
Dimension "I"	34.00	1.339			34.00	1.339			44.00	1.732				
Dimension "J"	55.00	2.165			55.00	2.165			55.00	2.165				
Dimension "K"	71.00	2.795			71.00	2.795			102.00	4.016				
Dimension "L"	110.00	4.331			153.00	6.024			216.00	8.504				

\* 2 pairs

APPLICATION AREA	ORBIWELD 38S	ORBIWELD 76S	ORBIWELD 115S
Code	826 000 001	827 000 001	828 000 001
Pipe OD, min. - max.	3 - 38.1 mm 1/8" - 1.5"	6 - 77 mm 1/4" - 3.0"	20 - 115 mm 3/4" - 4.5"
Electrode diameter	1.6/2.4 mm .063"/.094"	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	7.5 kg 16.5 lbs	9.7 kg 21.4 lbs
Hose package length	7.5 m/24.6 ft	7.5 m/24.6 ft	7.5 m/24.6 ft

#### SCOPE OF DELIVERY

Including:	<ul style="list-style-type: none"> <li>• 1 orbital weld head OW 38S, OW 76S or OW 115S</li> <li>• 1 transport case</li> <li>• 1 tool set</li> <li>• 1 Feeler gauge</li> <li>• 1 set of operating instructions and spare parts list</li> </ul>
Suitable accessories (optionally available):	<ul style="list-style-type: none"> <li>• Clamping inserts, narrow and wide</li> <li>• Chamber insert for fittings</li> <li>• Inserts for arc welding</li> <li>• T-piece clamping inserts</li> <li>• Electrode adapters</li> <li>• Table mounts</li> <li>• ESG electrode grinders</li> <li>• ORBmax residual oxygen meter</li> <li>• ORBIPURGE forming set</li> <li>• Hose package extensions</li> <li>• WS2 tungsten electrodes</li> </ul>



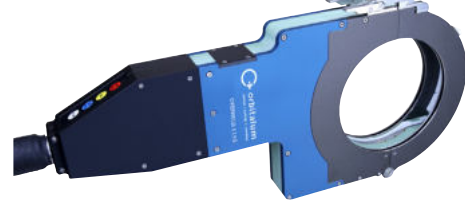
Technical specifications are non-binding. They do not constitute any assurance of properties. We reserve the right to make changes.



ORBIWELD 38S



ORBIWELD 76S



ORBIWELD 115S

## Closed orbital weld heads OW S

### ORBIWELD 38S, ORBIWELD 76S, ORBIWELD 115S

Properties, application area, technical specifications and delivery scope, see Page 33.

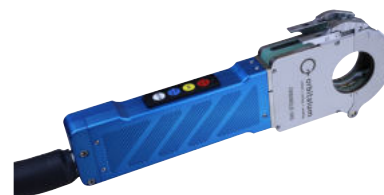
Clamping inserts are not included in the scope of delivery (see from Page 40).

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head OW 38S	826 000 001	9.045.00	6.900	16.500
Orbital weld head OW 76S	827 000 001	10.425.00	7.500	16.900
Orbital weld head OW 115S	828 000 001	11.040.00	9.700	18.600

\* Machine weight including hose package

### Suitable accessories (optionally available):

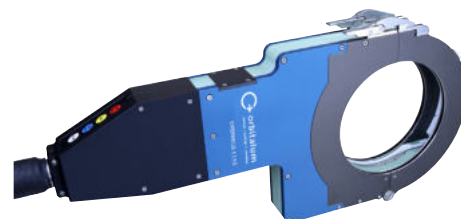
- Clamping inserts for ORBIWELD S and ORBIWELD, see Page 40
- Chamber inserts for fittings, see Page 43
- Inserts for arc welding, see Page 44
- T-piece clamping inserts, see Page 44
- Electrode adapters, see Page 45
- Table mounts, see Page 46
- Welding current connection adapter set, see Page 87



ORBIWELD 38S



ORBIWELD 76S



ORBIWELD 115S

#### 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
- Hire purchase
- 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 pharmaceuticals, chemical, semiconductor and food processing industry or aerospace technology, where, due to ever increasing diameters and wall thicknesses of the pipes 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 pipe 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

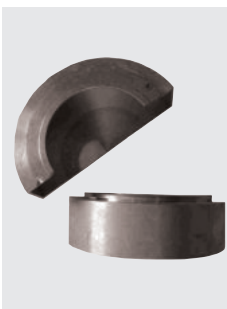
## Comprehensive and customer-specific accessories program (optionally available):



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



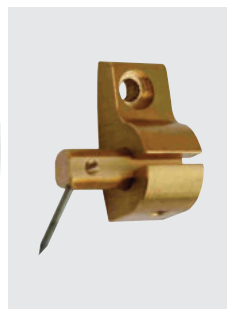
Cost-effective clamping inserts



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

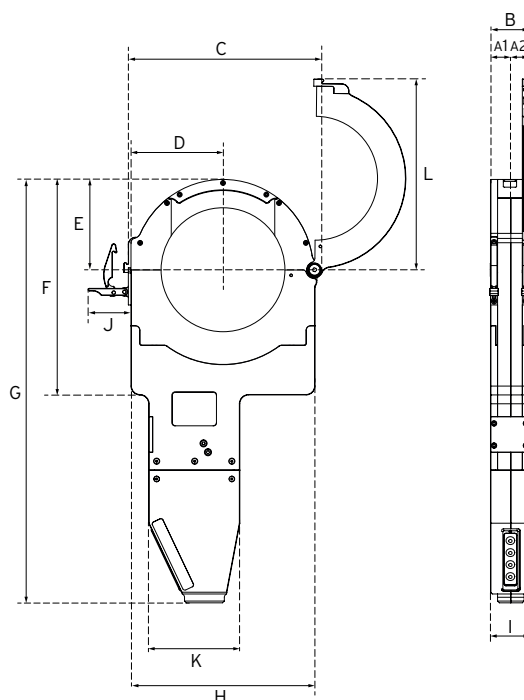


Electrode adapter for lateral offset of the tungsten electrode



Practical and sturdy aluminum table mount

APPLICATION AREA	ORBIWELD 170
Code	825 000 001
Pipe OD, min. - max.	50 - 170 mm 2" - 6"
Electrode diameter	1.6/2.4 mm 0.063"/0.094"
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"> <li>• 1 orbital weld head OW 170</li> <li>• 1 transport case (code 821 030 001)</li> <li>• 1 tool set</li> <li>• 1 feeler gauge</li> <li>• 1 set of operating instructions and spare parts list</li> </ul>
Suitable accessories (optionally available):	<ul style="list-style-type: none"> <li>• Clamping inserts, narrow and wide</li> <li>• Chamber insert for fittings</li> <li>• Inserts for arc welding</li> <li>• T-piece clamping inserts</li> <li>• Electrode adapters</li> <li>• Table mounts</li> <li>• ESG electrode grinders</li> <li>• ORBmax residual oxygen meter</li> <li>• ORBIPURGE forming set</li> <li>• Hose package extensions</li> <li>• Double pressure reducer</li> <li>• WS2 tungsten electrodes</li> </ul>



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

## Closed orbital weld head OW

### ORBIWELD 170

Properties, application area, technical specifications and delivery scope, see Page 37.

Clamping inserts are not included in the scope of delivery (see from Page 40).



ORBIWELD 170

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head OW 170	825 000 001	15.375.00	18.900	36.200

\* Machine weight including hose package

### Suitable accessories (optionally available):

- Clamping inserts for ORBIWELD S and ORBIWELD, see Page 40
- Chamber inserts for fittings, see Page 43
- Inserts for arc welding, see Page 44
- T-piece clamping inserts, see Page 44
- Electrode adapters, see Page 45
- Table mounts, see Page 46
- Welding current connection adapter set, see Page 87

#### CLOSED ORBITAL WELD HEADS

# Accessories for ORBIWELD S and ORBIWELD

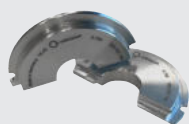
## Clamping inserts

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 pipe diameter.

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

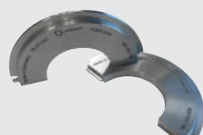
Clamping insert blanks for unscrewing, see Page 43.



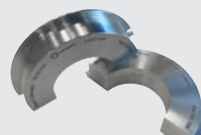
Clamping insert  
for OW 38S, 2-part  
for a clamping insert



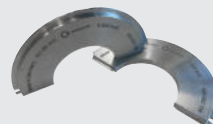
Clamping insert  
for OW 76S, 2tlg 2-part  
for a clamping side



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



Clamping insert "W" (wide)  
for OW 115/115S, 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

PIPE OD		OW 38S		OW 76S		OW 65		OW 115/115S "S" (SMALL/NARROW)		OW 115/115S "W" (WIDE)		OW 170 "S" (SMALL/NARROW)		OW 170 "W" (WIDE)	
[MM]	[INCH]	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR
3.00	0.118	826 002 120	98.00	-	-	-	-	-	-	-	-	-	-	-	-
3.18	0.125	826 002 122	98.00	-	-	-	-	-	-	-	-	-	-	-	-
4.00	0.157	826 002 124	98.00	-	-	-	-	-	-	-	-	-	-	-	-
4.76	0.187	826 002 125	98.00	-	-	-	-	-	-	-	-	-	-	-	-
4.78	0.188	826 002 126	98.00	-	-	-	-	-	-	-	-	-	-	-	-
5.95	0.234	826 002 127	98.00	-	-	-	-	-	-	-	-	-	-	-	-
6.00	0.236	826 002 128	98.00	827 002 120	118.00	823 002 120	140.00	-	-	-	-	-	-	-	-
6.35	0.250	826 002 129	98.00	827 002 121	118.00	823 002 121	140.00	-	-	-	-	-	-	-	-
7.00	0.276	826 002 130	98.00	-	-	823 002 122	140.00	-	-	-	-	-	-	-	-
7.50	0.295	826 002 131	98.00	-	-	-	-	-	-	-	-	-	-	-	-
7.94	0.313	826 002 132	98.00	827 002 124	118.00	-	-	-	-	-	-	-	-	-	-
8.00	0.315	826 002 133	98.00	827 002 125	118.00	823 002 125	140.00	-	-	-	-	-	-	-	-
9.00	0.354	-	-	827 002 126	118.00	823 002 126	140.00	-	-	-	-	-	-	-	-
9.53	0.375	826 002 135	98.00	827 002 127	118.00	823 002 127	140.00	-	-	-	-	-	-	-	-
9.95	0.392	826 002 136	98.00	-	-	-	-	-	-	-	-	-	-	-	-
10.00	0.394	826 002 137	98.00	827 002 129	118.00	823 002 129	140.00	-	-	-	-	-	-	-	-
10.10	0.398	826 002 138	98.00	827 002 130	118.00	823 002 130	140.00	-	-	-	-	-	-	-	-
10.20	0.402	826 002 139	98.00	827 002 131	118.00	-	-	-	-	-	-	-	-	-	-
11.00	0.433	826 002 140	98.00	827 002 132	118.00	823 002 132	140.00	-	-	-	-	-	-	-	-
11.95	0.470	826 002 142	98.00	827 002 134	118.00	-	-	-	-	-	-	-	-	-	-
12.00	0.472	826 002 143	98.00	827 002 135	118.00	823 002 135	140.00	-	-	-	-	-	-	-	-
12.10	0.476	826 002 144	98.00	827 002 136	118.00	-	-	-	-	-	-	-	-	-	-
12.70	0.500	826 002 145	98.00	827 002 137	118.00	823 002 137	140.00	-	-	-	-	-	-	-	-
13.00	0.512	826 002 146	98.00	827 002 138	118.00	823 002 138	140.00	-	-	-	-	-	-	-	-
13.20	0.520	-	-	827 002 139	118.00	-	-	-	-	-	-	-	-	-	-
13.50	0.531	826 002 148	98.00	827 002 140	118.00	-	-	-	-	-	-	-	-	-	-
13.70	0.539	826 002 149	98.00	827 002 141	118.00	823 002 141	140.00	-	-	-	-	-	-	-	-
14.00	0.551	826 002 150	98.00	827 002 142	118.00	823 002 142	140.00	-	-	-	-	-	-	-	-
14.30	0.563	826 002 151	98.00	-	-	-	-	-	-	-	-	-	-	-	-
14.70	0.579	826 002 152	98.00	-	-	-	-	-	-	-	-	-	-	-	-
15.00	0.591	826 002 153	98.00	827 002 145	118.00	823 002 145	140.00	-	-	-	-	-	-	-	-
15.30	0.602	826 002 154	98.00	827 002 146	118.00	-	-	-	-	-	-	-	-	-	-
15.60	0.614	826 002 155	98.00	827 002 147	118.00	-	-	-	-	-	-	-	-	-	-
15.70	0.618	826 002 156	98.00	827 002 148	118.00	-	-	-	-	-	-	-	-	-	-
15.88	0.625	826 002 157	98.00	827 002 149	118.00	-	-	-	-	-	-	-	-	-	-
16.00	0.630	826 002 158	98.00	827 002 150	118.00	823 002 150	140.00	-	-	-	-	-	-	-	-
16.70	0.657	826 002 159	98.00	-	-	-	-	-	-	-	-	-	-	-	-
17.00	0.669	-	-	827 002 152	118.00	-	-	-	-	-	-	-	-	-	-
17.20	0.677	826 002 162	98.00	827 002 154	118.00	823 002 154	140.00	-	-	-	-	-	-	-	-
17.30	0.681	826 002 163	98.00	827 002 155	118.00	823 002 155	140.00	-	-	-	-	-	-	-	-
18.00	0.709	826 002 164	98.00	827 002 156	118.00	823 002 156	140.00	-	-	-	-	-	-	-	-

## CLOSED ORBITAL WELD HEADS



PIPE OD		OW 38S		OW 76S		OW 65		OW 115/115S "S" (SMALL/NARROW)		OW 115/115S "W" (WIDE)		OW 170 "S" (SMALL/NARROW)		OW 170 "W" (WIDE)	
[MM]	[INCH]	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR
19.00	0.748	826 002 165	98.00	827 002 157	118.00	823 002 157	140.00	-	-	-	-	-	-	-	-
19.05	0.750	826 002 166	98.00	827 002 158	118.00	823 002 158	140.00	-	-	-	-	-	-	-	-
19.50	0.768	826 002 167	98.00	827 002 159	118.00	-	-	-	-	-	-	-	-	-	-
20.00	0.787	826 002 168	98.00	827 002 160	118.00	823 002 160	140.00	824 002 120	176.00	-	-	-	-	-	-
21.00	0.827	-	-	827 002 161	118.00	-	-	-	-	-	-	-	-	-	-
21.30	0.839	826 002 170	98.00	827 002 162	118.00	823 002 162	140.00	824 002 122	176.00	824 002 322	285.00	-	-	-	-
21.70	0.854	826 002 171	98.00	827 002 163	118.00	823 002 163	140.00	824 002 123	176.00	-	-	-	-	-	-
22.00	0.866	826 002 172	98.00	827 002 164	118.00	823 002 164	140.00	824 002 124	176.00	-	-	-	-	-	-
22.22	0.875	826 002 173	98.00	827 002 165	118.00	-	-	-	-	-	-	-	-	-	-
22.23	0.875	826 002 174	98.00	827 002 166	118.00	-	-	-	-	-	-	-	-	-	-
22.55	0.888	826 002 175	98.00	-	-	-	-	-	-	-	-	-	-	-	-
23.00	0.906	826 002 176	98.00	827 002 168	118.00	823 002 168	140.00	824 002 128	176.00	824 002 328	285.00	-	-	-	-
24.00	0.945	826 002 177	98.00	827 002 169	118.00	-	-	-	-	-	-	-	-	-	-
25.00	0.984	826 002 179	98.00	827 002 171	118.00	823 002 171	140.00	824 002 131	176.00	824 002 331	285.00	-	-	-	-
25.25	0.994	-	-	827 002 172	118.00	-	-	-	-	-	-	-	-	-	-
25.40	1.000	826 002 181	98.00	827 002 173	118.00	823 002 173	140.00	824 002 133	176.00	824 002 333	285.00	-	-	-	-
26.00	1.024	826 002 182	98.00	827 002 174	118.00	-	-	-	-	-	-	-	-	-	-
26.70	1.051	826 002 183	98.00	827 002 175	118.00	823 002 175	140.00	824 002 135	176.00	-	-	-	-	-	-
26.90	1.059	826 002 184	98.00	827 002 176	118.00	823 002 176	140.00	824 002 136	176.00	824 002 336	285.00	-	-	-	-
27.00	1.063	826 002 185	98.00	827 002 177	118.00	-	-	-	-	-	-	-	-	-	-
27.20	1.071	826 002 186	98.00	827 002 178	118.00	823 002 178	140.00	824 002 138	176.00	-	-	-	-	-	-
28.00	1.102	826 002 187	98.00	827 002 179	118.00	823 002 179	140.00	824 002 139	176.00	-	-	-	-	-	-
29.00	1.142	826 002 188	98.00	827 002 180	118.00	823 002 180	140.00	824 002 140	176.00	824 002 340	285.00	-	-	-	-
30.00	1.181	826 002 189	98.00	827 002 181	118.00	823 002 181	140.00	824 002 141	176.00	-	-	-	-	-	-
30.53	1.202	826 002 190	98.00	-	-	-	-	-	-	-	-	-	-	-	-
31.75	1.250	826 002 191	98.00	827 002 183	118.00	823 002 183	140.00	824 002 143	176.00	824 002 343	285.00	-	-	-	-
31.80	1.252	826 002 192	98.00	827 002 184	118.00	-	-	824 002 144	176.00	-	-	-	-	-	-
32.00	1.260	826 002 193	98.00	827 002 185	118.00	823 002 185	140.00	824 002 145	176.00	824 002 345	285.00	-	-	-	-
33.00	1.299	-	-	827 002 186	118.00	-	-	-	-	-	-	-	-	-	-
33.40	1.315	826 002 195	98.00	827 002 187	118.00	823 002 187	140.00	824 002 147	176.00	-	-	-	-	-	-
33.70	1.327	826 002 196	98.00	827 002 188	118.00	823 002 188	140.00	824 002 148	176.00	824 002 348	285.00	-	-	-	-
34.00	1.339	826 002 197	98.00	827 002 189	118.00	823 002 189	140.00	824 002 149	176.00	-	-	-	-	-	-
35.00	1.378	826 002 198	98.00	827 002 190	118.00	823 002 190	140.00	824 002 150	176.00	824 002 350	285.00	-	-	-	-
36.00	1.417	826 002 199	98.00	-	-	823 002 191	140.00	-	-	-	-	-	-	-	-
38.00	1.496	826 002 200	98.00	827 002 192	118.00	823 002 192	140.00	824 002 152	176.00	824 002 352	285.00	-	-	-	-
38.10	1.500	826 002 201	98.00	827 002 193	118.00	823 002 193	140.00	824 002 153	176.00	824 002 353	285.00	-	-	-	-
40.00	1.575	-	-	827 002 194	118.00	823 002 194	140.00	824 002 154	176.00	-	-	-	-	-	-
41.00	1.614	-	-	827 002 195	118.00	823 002 195	140.00	824 002 155	176.00	824 002 355	285.00	-	-	-	-
42.00	1.654	-	-	827 002 196	118.00	823 002 196	140.00	824 002 156	176.00	-	-	-	-	-	-
42.16	1.660	-	-	827 002 197	118.00	-	-	824 002 157	176.00	-	-	-	-	-	-
42.30	1.665	-	-	827 002 198	118.00	-	-	-	-	-	-	-	-	-	-
42.40	1.669	-	-	827 002 199	118.00	823 002 199	140.00	824 002 159	176.00	824 002 359	285.00	-	-	-	-
42.70	1.681	-	-	827 002 200	118.00	-	-	824 002 160	176.00	-	-	-	-	-	-
43.00	1.693	-	-	827 002 201	118.00	-	-	824 002 161	176.00	824 002 361	285.00	-	-	-	-
44.00	1.732	-	-	827 002 203	118.00	-	-	-	-	-	-	-	-	-	-
44.45	1.750	-	-	827 002 204	118.00	-	-	824 002 164	176.00	824 002 364	285.00	-	-	-	-
44.50	1.752	-	-	827 002 205	118.00	823 002 205	140.00	824 002 165	176.00	-	-	-	-	-	-
45.00	1.772	-	-	827 002 206	118.00	823 002 206	140.00	-	-	-	-	-	-	-	-
48.00	1.890	-	-	827 002 208	118.00	823 002 208	140.00	-	-	-	-	-	-	-	-
48.26	1.900	-	-	827 002 209	118.00	-	-	824 002 169	176.00	-	-	-	-	-	-
48.30	1.902	-	-	827 002 210	118.00	823 002 210	140.00	824 002 170	176.00	824 002 370	285.00	-	-	-	-
48.60	1.913	-	-	827 002 211	118.00	823 002 211	140.00	824 002 171	176.00	-	-	-	-	-	-
50.00	1.969	-	-	827 002 212	118.00	823 002 212	140.00	824 002 172	176.00	824 002 372	285.00	825 002 120	263.00	-	-
50.80	2.000	-	-	827 002 213	118.00	823 002 213	140.00	824 002 173	176.00	824 002 373	285.00	825 002 121	263.00	825 002 321	360.00
51.00	2.008	-	-	827 002 214	118.00	-	-	824 002 174	176.00	824 002 374	285.00	-	-	-	-
52.00	2.047	-	-	827 002 215	118.00	823 002 215	140.00	824 002 175	176.00	824 002 375	285.00	-	-	-	-
53.00	2.087	-	-	827 002 216	118.00	823 002 216	140.00	824 002 176	176.00	824 002 376	285.00	825 002 124	263.00	-	-
54.00	2.126	-	-	827 002 217	118.00	-	-	824 002 177	176.00	824 002 377	285.00	-	-	-	-
57.00	2.244	-	-	827 002 218	118.00	823 002 218	140.00	824 002 178	176.00	-	-	-	-	-	-
60.00	2.363	-	-	827 002 219	118.00	823 002 219	140.00	824 002 179	176.00	-	-	-	-	-	-
60.10	2.366	-	-	827 002 220	118.00	-	-	-	-	-	-	-	-	-	-
60.30	2.374	-	-	827 002 221	118.00	823 002 221	140.00	824 002 181	176.00	824 002 381	285.00	825 002 129	263.00	825 002 329	360.00
60.45	2.380	-	-	827 002 222	118.00	-	-	824 002 182	176.00	-	-	-	-	-	-
60.50	2.382	-	-	827 002 223	118.00	823 002 223	140.00	824 002 183	176.00	-	-	-	-	-	-
63.00	2.480	-	-	827 002 224	118.00	823 002 224	140.00	824 002 184	176.00	824 002 384	285.00	-	-	-	-
63.20	2.488	-	-	827 002 225	118.00	-	-	-	-	-	-	-	-	-	-
63.50	2.500	-	-	827 002 226	118.00	823 002 226	140.00	824 002 186	176.00	824 002 386	285.00	825 002 134	263.00	825 002 334	360.00

## CLOSED ORBITAL WELD HEADS

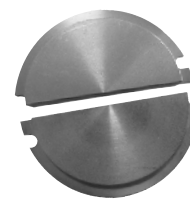
PIPE OD		OW 38S		OW 76S		OW 65		OW 115/115S "S" (SMALL/NARROW)		OW 115/115S "W" (WIDE)		OW 170 "S" (SMALL/NARROW)		OW 170 "W" (WIDE)	
[MM]	[INCH]	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR	CODE	EUR
65.00	2.559	-	-	827 002 227	118.00	823 002 227	140.00	-	-	-	-	-	-	-	-
70.00	2.756	-	-	827 002 228	118.00	823 002 228	140.00	824 002 188	176.00	824 002 388	285.00	825 002 136	263.00	825 002 336	360.00
70.20	2.764	-	-	-	-	-	-	824 002 189	176.00	824 002 389	285.00	-	-	-	-
73.00	2.874	-	-	827 002 230	118.00	-	-	824 002 190	176.00	-	-	-	-	-	-
73.03	2.875	-	-	827 002 231	118.00	-	-	824 002 191	176.00	-	-	-	-	-	-
75.00	2.953	-	-	827 002 233	118.00	-	-	824 002 193	176.00	-	-	-	-	-	-
76.00	2.992	-	-	827 002 234	118.00	-	-	824 002 194	176.00	-	-	-	-	-	-
76.10	2.996	-	-	827 002 235	118.00	-	-	824 002 195	176.00	824 002 395	285.00	825 002 143	263.00	825 002 343	360.00
76.20	3.000	-	-	827 002 236	118.00	-	-	824 002 196	176.00	824 002 396	285.00	825 002 144	263.00	825 002 344	360.00
76.30	3.004	-	-	827 002 237	118.00	-	-	824 002 197	176.00	824 002 397	285.00	-	-	-	-
80.00	3.150	-	-	-	-	-	-	824 002 198	176.00	824 002 398	285.00	-	-	825 002 346	360.00
82.00	3.228	-	-	-	-	-	-	824 002 199	176.00	-	-	-	-	-	-
82.30	3.240	-	-	-	-	-	-	824 002 200	176.00	-	-	-	-	-	-
85.00	3.346	-	-	-	-	-	-	824 002 201	176.00	824 002 401	285.00	-	-	825 002 349	360.00
88.90	3.500	-	-	-	-	-	-	824 002 203	176.00	824 002 403	285.00	825 002 151	263.00	825 002 351	360.00
89.00	3.504	-	-	-	-	-	-	824 002 204	176.00	-	-	-	-	-	-
89.10	3.508	-	-	-	-	-	-	824 002 205	176.00	824 002 405	285.00	-	-	-	-
90.00	3.543	-	-	-	-	-	-	824 002 206	176.00	-	-	-	-	-	-
100.00	3.937	-	-	-	-	-	-	824 002 209	176.00	-	-	-	-	-	-
101.60	4.000	-	-	-	-	-	-	824 002 210	176.00	824 002 410	285.00	825 002 158	263.00	825 002 358	360.00
104.00	4.094	-	-	-	-	-	-	824 002 211	176.00	824 002 411	285.00	825 002 159	263.00	825 002 359	360.00
108.00	4.252	-	-	-	-	-	-	824 002 212	176.00	-	-	825 002 160	263.00	-	-
110.00	4.331	-	-	-	-	-	-	824 002 213	176.00	-	-	-	-	-	-
114.00	4.488	-	-	-	-	-	-	824 002 215	176.00	-	-	-	-	-	-
114.30	4.500	-	-	-	-	-	-	824 002 216	176.00	824 002 416	285.00	825 002 164	263.00	825 002 364	360.00
115.00	4.528	-	-	-	-	-	-	824 002 217	176.00	824 002 417	285.00	825 002 165	263.00	-	-
127.00	5.000	-	-	-	-	-	-	-	-	-	-	825 002 167	263.00	825 002 367	360.00
127.05	5.002	-	-	-	-	-	-	-	-	-	-	-	-	-	-
129.00	5.079	-	-	-	-	-	-	-	-	-	-	825 002 169	263.00	825 002 369	360.00
133.00	5.236	-	-	-	-	-	-	-	-	-	-	825 002 170	263.00	-	-
139.70	5.500	-	-	-	-	-	-	-	-	-	-	825 002 171	263.00	825 002 371	360.00
152.40	6.000	-	-	-	-	-	-	-	-	-	-	825 002 173	263.00	825 002 373	360.00
154.00	5.063	-	-	-	-	-	-	-	-	-	-	825 002 174	263.00	825 002 374	360.00
159.00	6.260	-	-	-	-	-	-	-	-	-	-	825 002 175	263.00	-	-
165.20	6.504	-	-	-	-	-	-	-	-	-	-	825 002 177	263.00	-	-
168.30	6.626	-	-	-	-	-	-	-	-	-	-	825 002 178	263.00	825 002 378	360.00
170.00	6.693	-	-	-	-	-	-	-	-	-	-	825 002 179	263.00	825 002 379	360.00

## CLOSED ORBITAL WELD HEADS

## Clamping insert blanks

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

ITEM	CODE	EUR	KG
Clamping insert blank for OW 38S, 2-part	826 002 210	98.00	0.066
Clamping insert blank for OW 76S, 2-part	827 002 241	118.00	0.280
Clamping insert blank for OW 115/115S "S" (small/narrow), 2-part	824 002 220	176.00	0.590
Clamping insert blank for OW 115/115S "W" (wide), 2-part	824 002 420	285.00	1.445
Clamping insert blank for OW 65, 2-part	823 002 230	140.00	0.256
Clamping insert blank for OW 170 "S" (small/narrow), 2-part	825 002 185	263.00	1.010
Clamping insert blank for OW 170 "W" (wide), 2-part	825 002 385	360.00	1.000



Clamping insert blanks

## 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	EUR	KG
Packaging clamping insert OW 38S	826 002 010	4.50	0.019
Packaging clamping insert OW 76S/OW 65	827 002 010	5.00	0.065
Packaging clamping insert OW 115 "S" (small/narrow)	824 002 010	5.50	0.101
Packaging clamping insert OW 115 "W" (wide)	824 002 011	6.00	0.129



Packagings for clamping inserts

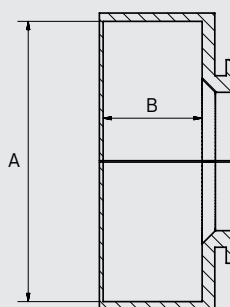
## Chamber inserts for fittings

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
65	[mm]	125.0	30.0
	[inch]	4.921	1.181
76S	[mm]	130.0	35.0
	[inch]	5.118	1.378
115/115S	[mm]	179.0	39.0
	[inch]	7.047	1.535
170	[mm]	214.0	44.0
	[inch]	8.425	1.732



Chamber insert for fittings

ITEM	CODE	EUR	KG
Chamber inserts for fittings for OW 38S	826 050 010	415.00	0.146
Chamber inserts for fittings for OW 76S	827 050 007	385.00	0.266
Chamber inserts for fittings for OW 65	823 050 010	390.00	0.612
Chamber inserts for fittings for OW 115 and OW 115S	824 050 003	417.00	0.660
Chamber inserts for fittings for OW 170	825 050 002	1.245.00	0.852

### CLOSED ORBITAL WELD HEADS



T-piece clamping inserts

## 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 set (Page 45) as well as 1 standard clamping insert (from Page 40) (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	PIPE OD MAX. [MM]	PIPE OD MAX. [INCH]	CODE	EUR	KG
T-piece clamping insert for OW 38S	25.0	0.984	<b>826 050 038</b>	985.00	
T-piece clamping insert for OW 76S	48.0	1.890	<b>827 050 005</b>	1.000.00	0.720
T-piece clamping insert for OW115S	85.0	3.346	<b>824 050 004</b>	1.345.00	1.825
T-piece clamping insert for OW 170	144.0	5.669	<b>825 050 003</b>	1.565.00	3.700



Insert for arc welding  
(Basic retainers/covers)

## 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 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.

ITEM	CODE	EUR	KG
Arc covers OW 38S complete*	<b>826 050 031</b>	185.00	0.017
Basic retainer for arc insert for OW 76S	<b>827 002 018</b>	168.00	0.150
Cover for arc insert for OW 76S	<b>827 050 021</b>	98.00	0.030
Basic retainer for arc insert for OW 65	<b>823 050 029</b>	168.00	0.089
Cover for arc insert for OW 65*	<b>823 050 030</b>	98.00	0.028
Basic retainer for arc insert for OW 115 and OW 115S	<b>824 050 006</b>	234.00	0.150
Cover for arc insert for OW 115S*	<b>828 050 016</b>	115.00	0.054
Cover for arc insert for OW 115*	<b>824 050 020</b>	115.00	0.050
Basic retainer for arc insert for OW 170	<b>825 050 005</b>	473.00	0.250
Cover for arc insert for OW 170*	<b>825 050 020</b>	125.00	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.  
 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°

ELECTRODE ADAPTERS USABLE UP TO MAX. TUBE DIAMETER	[MM]	[INCH]
OW 38S	25.0	0.984
OW 76S	48.0	1.890
OW 65	43.5	1.713
OW 115 / OW 115S	85.0	3.346
OW 170	144.0	5.669

ELECTRODE ADAPTER SETS	CODE	EUR	KG
Electrode adapter set OW 38S, standard	826 050 034	439.00	0.033
Electrode adapter set OW 76S, standard	827 050 027	439.00	0.089
Electrode adapter set OW 65, standard	823 050 028	439.00	0.045
Electrode adapter set OW 115 standard	824 050 025	439.00	0.064
Electrode adapter set OW 115S, standard	828 050 022	439.00	0.064
Electrode adapter set OW 170, standard	825 050 022	439.00	0.094

INDIVIDUAL PARTS FOR OW 38S				
Basic part electrode adapter OW 38S	826 004 003	185.00	0.013	
Extension 10 mm/0.394", 15° for electrode adapter OW 38S	823 004 008	95.00	0.003	
Extension 10 mm/0.394", 30° for electrode adapter OW 38S	823 004 009	95.00	0.003	
Extension 10 mm/0.394", 45° for electrode adapter OW 38S	823 004 010	95.00	0.003	

INDIVIDUAL PARTS FOR OW 76S				
Basic part electrode adapter OW 76S	827 004 003	185.00	0.024	
Extension 15 mm/0.591", 15°/90° for electrode adapter OW 76S	823 004 002	95.00	0.005	
Extension 15 mm/0.591", 30°/90° for electrode adapter OW 76S	823 004 003	95.00	0.005	
Extension 15 mm/0.591", 45°/90° for electrode adapter OW 76S	823 004 004	95.00	0.005	

INDIVIDUAL PARTS FOR OW 65				
Basic part electrode adapter OW 65	823 004 011	185.00	0.018	
Extension 15 mm/0.591", 15°/90° for electrode adapter OW 65	823 004 002	95.00	0.005	
Extension 15 mm/0.591", 30°/90° for electrode adapter OW 65	823 004 003	95.00	0.005	
Extension 15 mm/0.591", 45°/90° for electrode adapter OW 65	823 004 004	95.00	0.005	

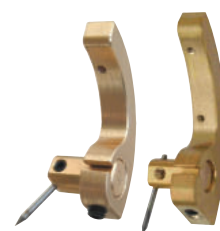
INDIVIDUAL PARTS FOR OW 115 AND OW 115S				
Basic part electrode adapter OW 115	824 004 002	185.00	0.037	
Basic part electrode adapter OW 115S	828 004 004	185.00	0.037	
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 115/115S	823 004 006	95.00	0.009	
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 115/115S	823 004 005	95.00	0.009	
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 115/115S	823 004 007	95.00	0.009	

INDIVIDUAL PARTS FOR OW 170				
Basic part electrode adapter OW 170	825 004 001	185.00	0.067	
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 170	823 004 006	95.00	0.009	
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 170	823 004 005	95.00	0.009	
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 170	823 004 007	95.00	0.009	

ELECTRODE ADAPTER FOR FRONT SEAM WELDING*				
Electrode adapter set OW 38S front seam	826 050 036	439.00	0.045	
Electrode adapter set OW 76S front seam	827 050 038	439.00	0.045	
Electrode adapter set OW 65 front seam	823 050 034	439.00	0.045	
Electrode adapter set OW 115 front seam	824 050 026	439.00	0.070	
Electrode adapter set OW 115 S front seam	828 050 023	439.00	0.070	

ELECTRODE ADAPTER FOR INTERNAL WELDING*				
Electrode adapter set OW 38S internal welding	826 050 037	439.00	0.071	
Electrode adapter set OW 76S internal welding	827 050 039	439.00	0.071	
Electrode adapter set OW 115 internal welding	824 050 027	439.00	0.193	
Electrode adapter set OW 115 internal welding	828 050 024	439.00	0.193	
Electrode adapter set OW 170 internal welding	825 050 026	439.00		

\* Further electrode adapter for other weld heads on request.



Electrode adapters for OW 38S, OW 76S



Electrode adapter for OW 170



Front seam adapter (without rotor)



Internal welding adapter (without rotor)

## CLOSED ORBITAL WELD HEADS



Table mounts

## 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	EUR	KG
Table mount for OW 38S, OW 76S	<b>826 030 006</b>	206.00	1.250
Table mount for OW 65, OW 115, OW 115S, OW 170	<b>823 030 006</b>	206.00	1.070

## Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Hose package extensions, see Page 86
- WS2 tungsten electrodes, see Page 87
- Welding current connection adapter set, see Page 87

### CLOSED ORBITAL WELD HEADS


NEW

# HX 12P, HX 25P

## 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.



<b>Dramatically shorter welding times</b> Welding times 30 s per pipe	✓
<b>Up to 250 welds</b> per head and shift	✓
<b>50% less preparation time</b> in contrast to manual work	✓
<b>Pipe spacings:</b> HX 12P: Below 40 mm (1:57") HX 25P: Below 60 mm (2:36")	✓
<b>For pipe outer diameters:</b> HX 12P: 9.5 ... 13.3 mm (0.37" ... 0.52") HX 25P: 18.0 ... 25.4 (0.71" ... 1:00")	✓
<b>Highly resilient</b> through liquid-cooled rotor housing	✓
<b>Horizontal, lateral and inclined weld-</b> ing position possible	✓
<b>Very robust</b> and ergonomic design	✓
<b>Best welding results</b> 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 or tongs require a lot of space between the tubes for positioning, the narrow HX heads allow very compact heat exchangers with high tube density and thus a high 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

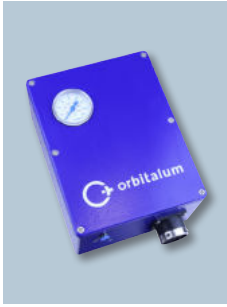
operate multiple weld heads at the same time – which significantly increases the manufacturing efficiency. The closed weld chamber and continuous process also result in no annealing colors arising, so that expensive rework such as pickling or passivating is generally not required.

### Compact design results in simple handling.

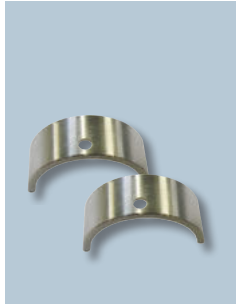
In contrast to open welding tongs, all connections for current, gas and cooling water are integrated in the HX head. For good handling the Orbitalum heads are connected with a 7.5m long, flexible hose with the welding power supply. The HX 12P and HX 25P furthermore impresses with a very straight design, 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



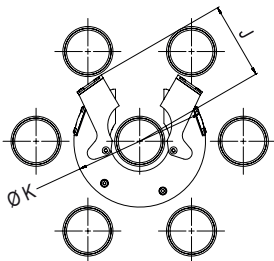
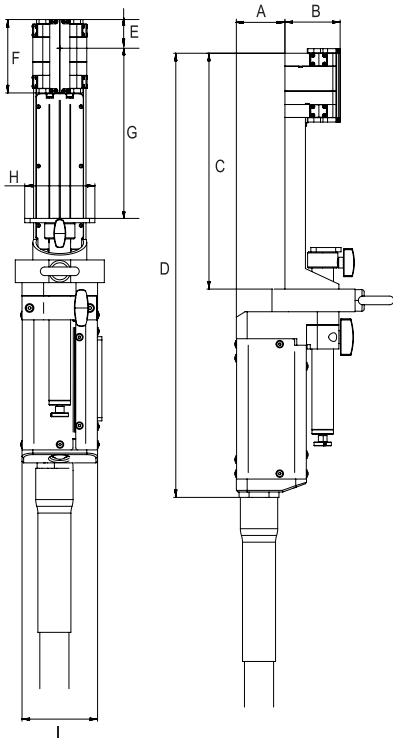
Optionally available:  
Ground cable



Optionally available:  
Adjustable bar pressure  
reducer for argon



The perfect supplement: Or-  
bital welding power sources  
ORBITAT



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/14.1 lbs	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"><li>• Clamping inserts</li><li>• Bar pressure reducer "Argon"</li><li>• Ground cable</li><li>• WS2 tungsten electrodes</li><li>• ESG electrode grinders</li></ul>			

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 pipe bundles of fin heat exchangers. There is no other solution as effective as this one in the world!



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

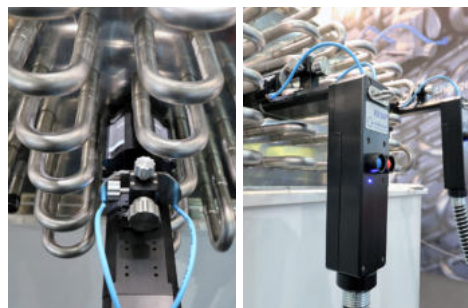
The HX series impresses in the fields of economy and efficiency when compared to conventional machine weld heads. The pipe ends of the heat exchanger can be fully fitted with elbows before welding and then welded in any order. For conventional orbital tongs, the principle of fit elbow, weld, fit elbow, weld etc. applies, always starting from the center of the pipe 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 tongs with a cumbersome hose assembly, all connections for power, gas and cooling water are permanently integrated in the HX.

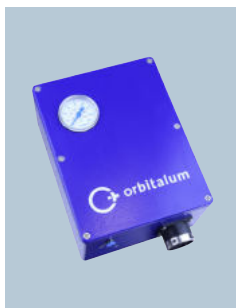
All orbital welding power sources from Orbitalum automatically detect the head and its properties so that, before beginning to weld, the operator only has to call up their specified welding program and start the welding process.

Traditionally, complex heat exchangers for cooling systems were made of copper, and soldered with the pipe 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



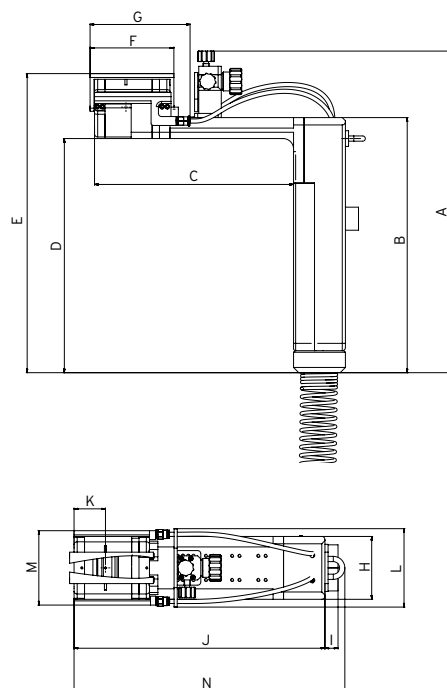
Adjustable bar pressure reducer for argon for pneumatic clamping of the HX 16P – available separately



The perfect supplement: Orbital welding power sources ORBITAT



HX 16P



APPLICATION AREA		HX 16P	
Code		848 000 010	
Pipe 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"><li>• Clamping inserts</li><li>• Bar pressure reducer "Argon"</li><li>• Ground cable</li><li>• WS2 tungsten electrodes</li><li>• ESG electrode grinders</li></ul>	

\* Other dimensions on request

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

## Closed orbital weld heads

### HX 12P, HX 16P, HX 25P

Properties, application area, technical specifications and delivery scope, see Page 47 and Page 49.

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

- Clamping inserts, see Page 52
- Ground cable, see Page 86
- Bar pressure reducer "Argon", see Page 52



HX 12P / HX 25P

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Orbital weld head HX 12P	847 000 010	17.200.00	6.400	14.100
Orbital weld head HX 16P	848 000 010	16.550.00	5.900	16.600
Orbital weld head HX 25P	845 000 010	17.200.00	18.500	40.800

\* Machine weight including hose package



HX 16P

### Suitable accessories (optionally available):

- Clamping inserts, see Page 52
- Bar pressure reducer "Argon", see Page 52
- Ground cable, see Page 86
- WS2 tungsten electrodes, see Page 87
- ESG electrode grinders, see Page 79
- Welding current connection adapter set, see Page 87



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

#### CLOSED ORBITAL WELD HEADS



Clamping inserts

## Accessories for HX

### Clamping inserts

Made of stainless steel.

Two clamping inserts are required for each pipe diameter.

Further dimensions on request.

ITEM	PIPE OD		FOR HX 12P			FOR HX 16P			FOR HX 25P		
	[MM]	[INCH]	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG
Clamping insert	9.50	0.374	847 002 020	123.00	0.018	-	-	-	-	-	-
Clamping insert	11.00	0.433	847 002 027	123.00	0.003	-	-	-	-	-	-
Clamping insert	12.00	0.472	847 002 021	123.00	0.018	-	-	-	-	-	-
Clamping insert	12.40	0.488	847 002 026	123.00	0.002	-	-	-	-	-	-
Clamping insert	12.43	0.489	847 002 024	123.00	-	-	-	-	-	-	-
Clamping insert	12.70	0.500	847 002 023	123.00	0.018	848 002 301	120.00	0.006	-	-	-
Clamping insert	13.30	0.524	847 002 025	123.00	0.002	848 002 302	120.00	0.006	-	-	-
Clamping insert	15.00	0.591	-	-	-	848 002 303	120.00	0.005	-	-	-
Clamping insert	15.75	0.620	-	-	-	848 002 305	120.00	0.004	-	-	-
Clamping insert	15.88	0.625	-	-	-	848 002 306	120.00	0.002	-	-	-
Clamping insert	16.00	0.630	-	-	-	848 002 307	120.00	0.002	-	-	-
Clamping insert	16.20	0.638	-	-	-	848 002 308	120.00	0.002	-	-	-
Clamping insert	16.30	0.642	-	-	-	848 002 309	120.00	0.002	-	-	-
Clamping insert	16.50	0.650	-	-	-	848 002 310	120.00	0.002	-	-	-
Clamping insert	16.60	0.654	-	-	-	848 002 311	120.00	0.002	-	-	-
Clamping insert	18.00	0.709	-	-	-	-	-	-	-	-	-
Clamping insert	19.05	0.750	-	-	-	-	-	-	-	-	-
Clamping insert	20.00	0.787	-	-	-	-	-	-	845 002 210	120.00	-
Clamping insert	22.00	0.866	-	-	-	-	-	-	845 002 208	120.00	-
Clamping insert	22.22	0.875	-	-	-	-	-	-	-	-	-
Clamping insert	23.00	0.906	-	-	-	-	-	-	845 002 211	120.00	-
Clamping insert	25.00	0.984	-	-	-	-	-	-	845 002 209	120.00	-
Clamping insert	25.40	1.000	-	-	-	-	-	-	845 002 212	120.00	-



Bar pressure reducer "Argon"

### 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"

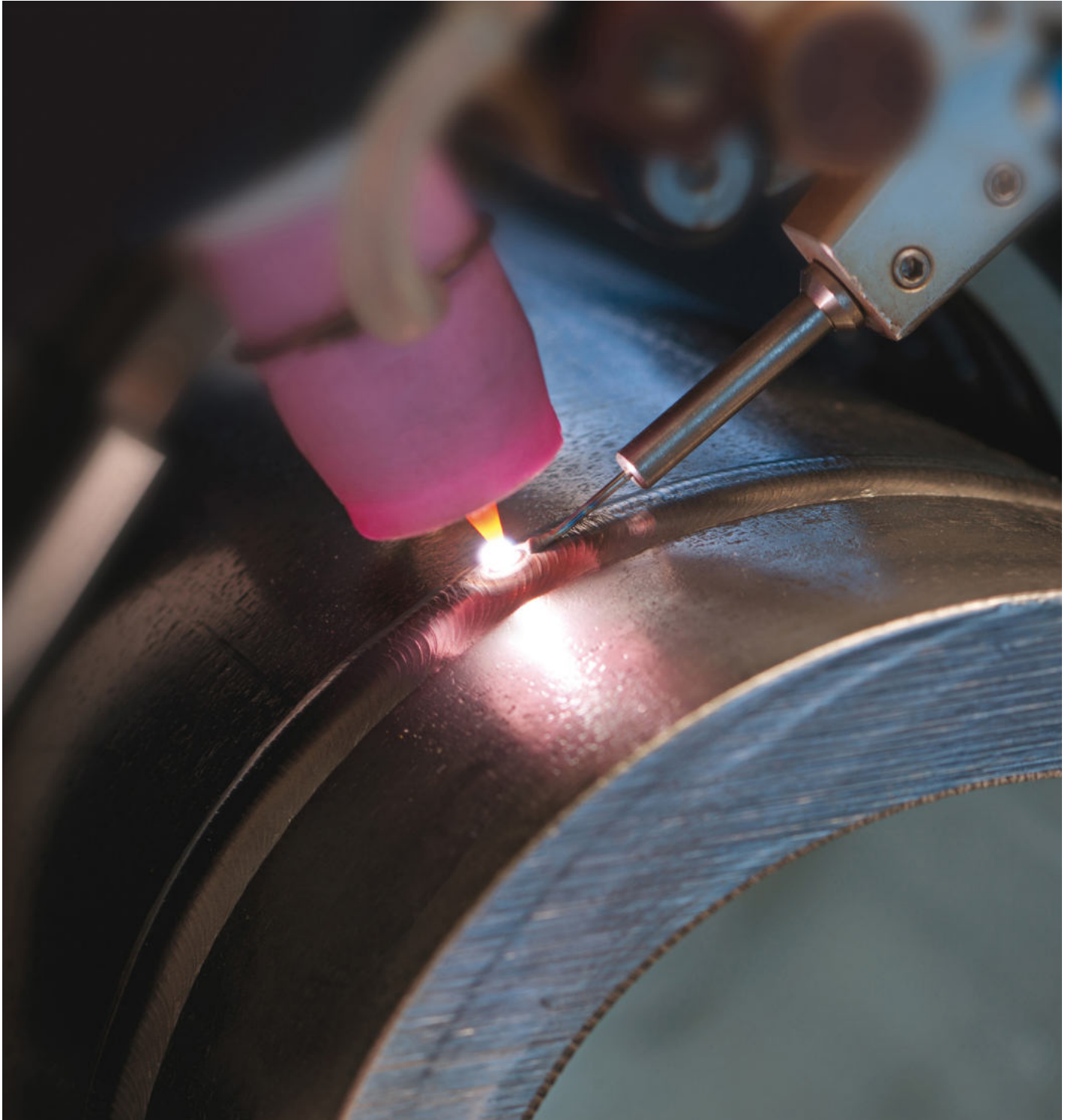
ITEM	CODE	EUR	KG
Bar pressure reducer "Argon"	888 000 006	217.00	1.428

### Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- WS2 tungsten electrodes, see Page 87
- Welding current connection adapter set, see Page 87

#### CLOSED ORBITAL WELD HEADS

# Open orbital welding tongs

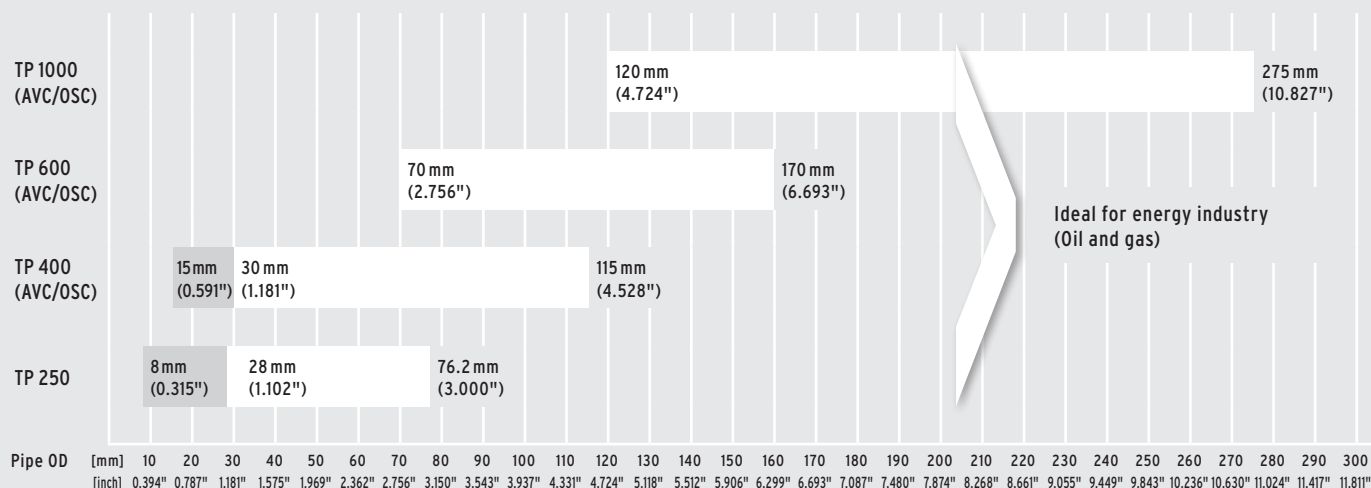




# Overview of open orbital welding tongs

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			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		(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*		

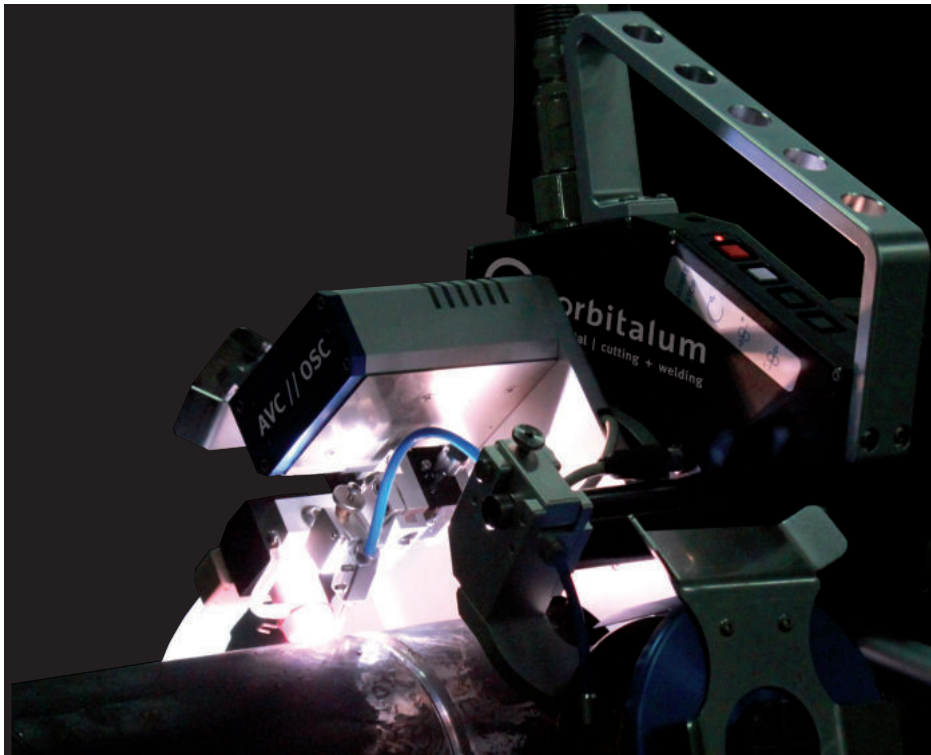
\* Wire diameter 1.0 mm (0.039") is available separately.



# ORBIWELD TP

## Open orbital welding tongs

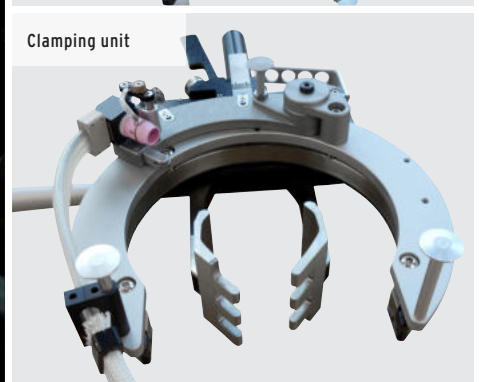
The ORBIWELD TP series is unique in design and functionality: Through the drive motor completely integrated into the tong housing an extremely compact design is realized. The drive concept furthermore makes the large and laborious gearing of conventional welding tongs superfluous. This compact design 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 tongs
- Wire coil for mounting of the filler wire at TIG cold wire welding is mounted on the tong 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 after welding

- Simple, toolless adjustment of the clamping unit onto the tube diameter
- By default TP 1000 tongs are equipped with clamping plates made of tool steel which secure an optimum support on the pipe surface. The pipe 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 tongs 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 tongs can be easily centered at the tube and are clamped via clamping levers
- Through the operating buttons integrated directly in the tong housing no additional remote control is required

### ADDITIONAL CHARACTERISTICS TP AVC/OSC:

- With oscillation (OSC) and electronic arc gap control (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 pipe 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
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	(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	(0.591)*/ 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
	[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
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**
	[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**
Machine weight including hose package	[kg]	7.0	8.9	11.0	12.5	15.2	13.7	15.2	18.9	22.5	28.7
	[lbs]	15.4	19.6	24.3	27.6	33.5	30.2	33.5	41.7	49.6	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
	[ft]	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	245.00
	[inch]	3.386	3.386	4.252	4.252	5.906	5.787	5.787	7.283	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
	[inch]	-	-	-	7.087	6.890	-	7.717	8.465	-	9.331
Dimension "D":	[mm]	85.00	85.00	120.00	182.00	182.00	140.00	140.00	186.00	170.00	206.00
	[inch]	3.346	3.346	4.724	7.165	7.165	5.512	5.512	7.323	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	191.00
	[inch]	2.913	2.913	3.543	6.496	6.496	3.819	3.819	6.772	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
	[inch]	4.921	4.921	7.874	7.874	7.874	7.953	7.953	7.953	10.630	10.630
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

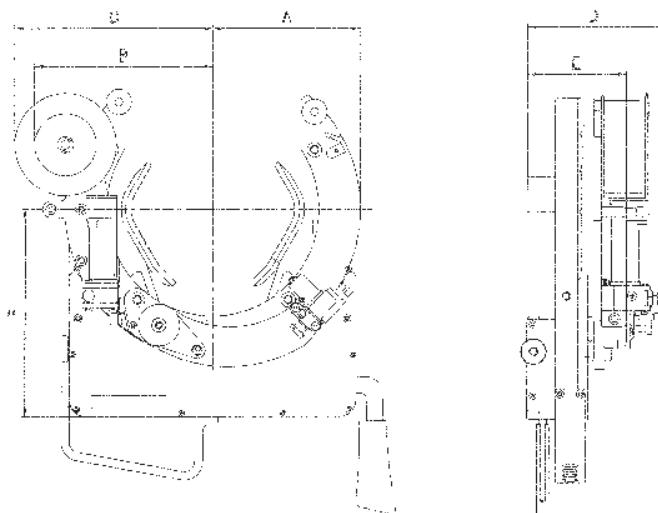
◐ = Function only conditionally included (can be retrofitted)

\* With accessories

\*\* KD conversion sets optionally available (Page 58)

\*\*\* 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:	<ul style="list-style-type: none"> <li>1 welding tong ORBIWELD TP</li> <li>1 transport case</li> <li>1 handle (TP 1000: 2 pieces)</li> <li>1 expansion jaw set of size 8 - 28 mm/0.315" - 1.102" (TP 250 only)</li> <li>1 tool set</li> <li>1 set of operating instructions and spare parts list</li> </ul>
Suitable accessories (optionally available):	<ul style="list-style-type: none"> <li>Clamping unit "V2" (retrofitting kits)</li> <li>Cold-wire feeds KD (retrofitting kits)</li> <li>Expansion jaw sets for TP 400</li> <li>Control cable</li> <li>Remote control</li> <li>ESG electrode grinders</li> <li>ORBmax residual oxygen meter</li> <li>ORBIPURGE forming set</li> <li>Ground cable</li> <li>Hose package extensions</li> <li>WS2 tungsten electrodes</li> </ul>

## Open orbital welding tongs 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 55.

**The following accessories are mandatory for the use of the TP orbital welding tongs and must be ordered separately:**

- Control cable, see Page 59
- Ground cable, see Page 86

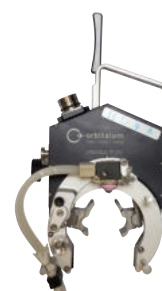
ITEM	WITH COLD WIRE UNIT (KD)	CODE	EUR	MACHINE WEIGHT KG**	SHIPPING WEIGHT KG
Weld tong TP 250	-	<b>811 000 001</b>	8.645.00	7.000	15.600
Weld tong TP 250	KD 4	<b>811 000 005</b>	10.775.00	8.900	20.000
Weld tong TP 400	-	<b>812 000 010</b>	10.890.00	11.000	20.000
Weld tong TP 400	KD3-100	<b>812 000 011</b>	13.040.00	12.500	20.000
Weld tong TP 400 AVC/OSC*	KD3-100	<b>812 000 012</b>	19.050.00	15.200	24.800
Weld tong TP 600	-	<b>813 000 001</b>	14.055.00	13.700	23.600
Weld tong TP 600	KD3-100	<b>813 000 005</b>	15.620.00	15.200	30.000
Weld tong TP 600 AVC/OSC*	KD3-100	<b>813 000 002</b>	23.090.00	18.900	33.300
Weld tong TP 1000	-	<b>814 000 001</b>	19.700.00	22.500	38.000
Weld tong TP 1000	KD3-100	<b>814 000 005</b>	21.240.00	24.000	40.900
Weld tong TP 1000 AVC/OSC*	KD3-100	<b>814 000 002</b>	28.415.00	28.700	45.300

\* Only usable in connection with an ORBIMAT CA AVC/OSC power source (see from Page 11).

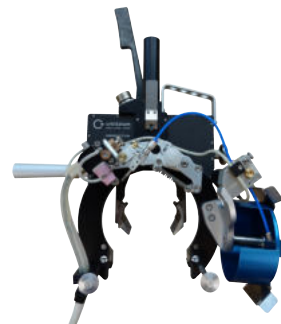
\*\* Machine weight including hose package

### Suitable accessories (optionally available):

- Clamping unit "V2" (retrofitting kits), see Page 58
- Cold-wire feeds KD (retrofitting kits), see Page 58
- Extension clamping jaw kits for TP 400, see Page 59
- Ground cable, see Page 86
- Control cable, see Page 59
- Remote control, see Page 16



ORBIWELD TP 250



ORBIWELD TP 400 KD3-100



ORBIWELD TP 400 AVC/OSC



ORBIWELD TP 600

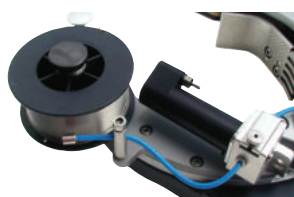


ORBIWELD TP 1000

### OPEN ORBITAL WELDING TONGS



KD 4 with opened cover



KD3-100 with Ø 100 standard coil



KD retrofitting kit



TP 400 clamping unit, complete

## 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/1kg (3.937"/2.2 lbs) standard coils.
- 1 external cold-wire box (only for KD 4)

ITEM	CAN BE USED WITH	CODE	EUR	KG
Cold-wire feed KD 4	TP 250	811 050 001	1.990.00	2.110
Cold-wire feed KD3-100*	TP 400*	812 050 061	2.445.00	0.680
Cold-wire feed KD3-100	TP 600	813 050 001	1.890.00	0.680
Cold-wire feed KD3-100	TP 1000	814 050 008	1.945.00	0.720

\* Weld tong must be sent in for the retrofitting.

### KD retrofitting kit

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

ITEM	CAN BE USED WITH	CODE	EUR	KG
KD retrofitting kit to wire Ø 1.0 mm (0.039")	TP 250	811 050 046	296.00	0.115
KD retrofitting kit to wire Ø 1.0 mm (0.039") V2*	TP 400/600/1000 incl. AVC/OSC	812 050 076	264.00	0.115

\* Please note series no., see above.

### Clamping unit "V2" (retrofitting kits)

The orbital weld tongs ORBIWELD TP 400 and TP 600 (AVC/OSC) have been delivered with a new clamping unit since 11/2013 and the TP 250 since 09/2017. For older models we offer the possibility to retrofit this new clamping unit rapidly and easily.

Please inform us about the respective machine number during the order (see type plate). The new clamping unit is delivered including the new type plate.

#### Advantages of the new clamping system:

- Improved handling, easier and more precise alignment of the weld tongs
- Increased clamping power
- Including clamping jaws made of stainless steel (1.4305); clamping jaws for other applications optionally available (see from Page 59)

#### The scope of delivery includes:

- 1 clamping unit with clamping jaws
- 4 fastening screws M4x20

ITEM	CODE	EUR	KG
Clamping unit "V2" for TP 250 complete	811 050 050	2.340.00	
Clamping unit "V2" for TP 400 complete	812 050 044	3.235.00	3.785
Clamping unit "V2" for TP 600 complete	813 050 024	4.350.00	4.750

### OPEN ORBITAL WELDING TONGS



## Expansion clamping jaw kits

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

ITEM	VERSION	PIPE OD [MM]	PIPE OD [INCH]	CODE	EUR	KG
Expansion clamping jaw kit for TP 400	Stainless steel	15.00 - 30.00	0,591 - 1,181	<b>812 002 005</b>	600.00	0.520



Expansion clamping jaw kit for TP 400

## Control cable

Matching for all ORBIWELD TP orbital weld tongs

ITEM	LENGTH [M]	LENGTH [INCH]	CODE	EUR	KG
Control cable for ORBIWELD TP	7.5	24.6	<b>811 050 003</b>	234.00	1.202



Control cable

## Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- Hose package extensions, see Page 86
- WS2 tungsten electrodes, see Page 87
- Torch and cold wire accessories, see Page 89
- Ground cable, see Page 86

OPEN ORBITAL WELDING TONGS



Standard-compliant, precise  
and reproducible weld seam  
preparation.

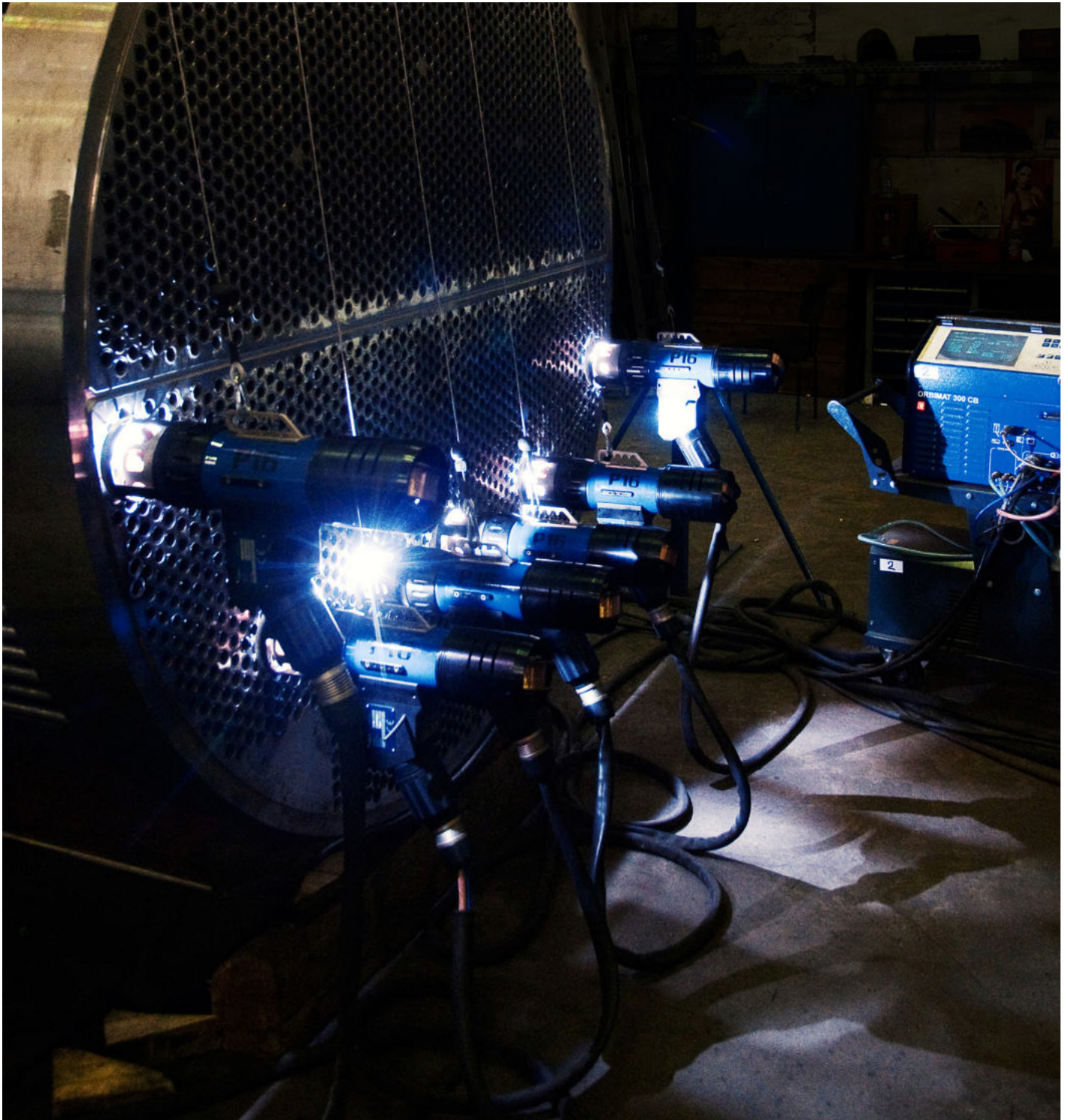
For more than 40 years installation manufacturers have been relying on the standard formed by Orbitalum in the industrial pipe end preparation: With the pipe saws for the precise cutting in seconds.

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

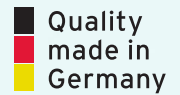
**>> Catalog "Orbital pipe cutting and beveling machines for high-purity process installations"**



# Tube-to-tube-sheet orbital weld heads



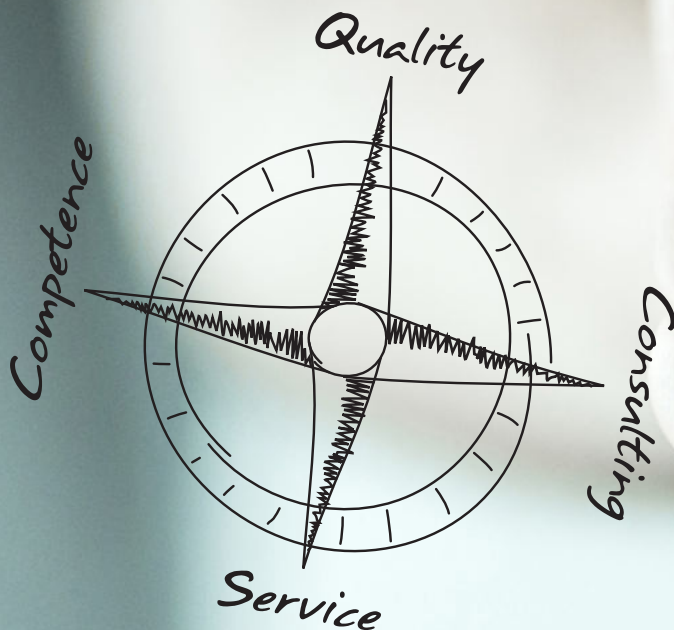
## Quality products from Orbitalum Tools - always a good decision!



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 tube-to-tube-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 through dimensionally stable clamping segments, available for tube inner diameters of 13.8 - 37 mm (0.543" - 1.457")

**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:**

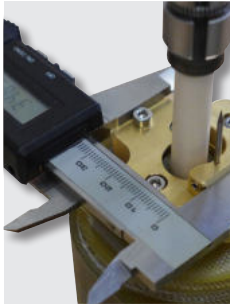
- Handy TIG orbital weld head for welding of tubes in tube sheets
- Precise work in every position, thus high-quality results at horizontal or vertical tube sheets
- Can be used at flush, slightly offset and protruding tubes
- Compatible with AMI arbors, model 96
- Service-friendly design of the clamping 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 welding head housing
- ✓ One-hand operation
- ✓ Quick change system for arbors
- ✓ Integrated control panel
- ✓ Chambered protective gas cover

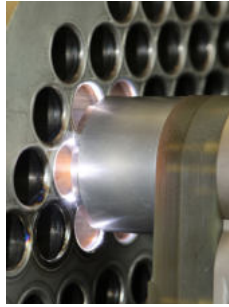




Simple and precise setting of the electrode position



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

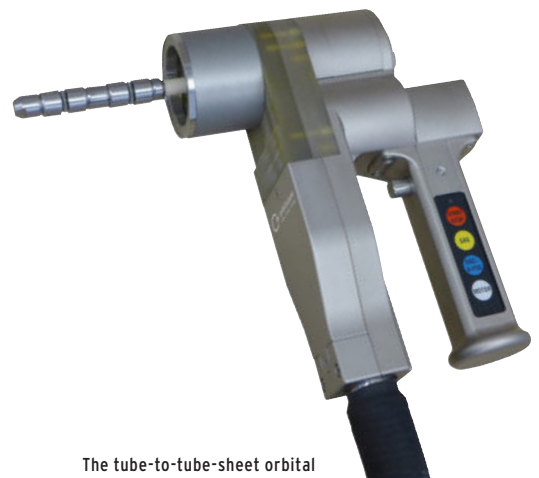
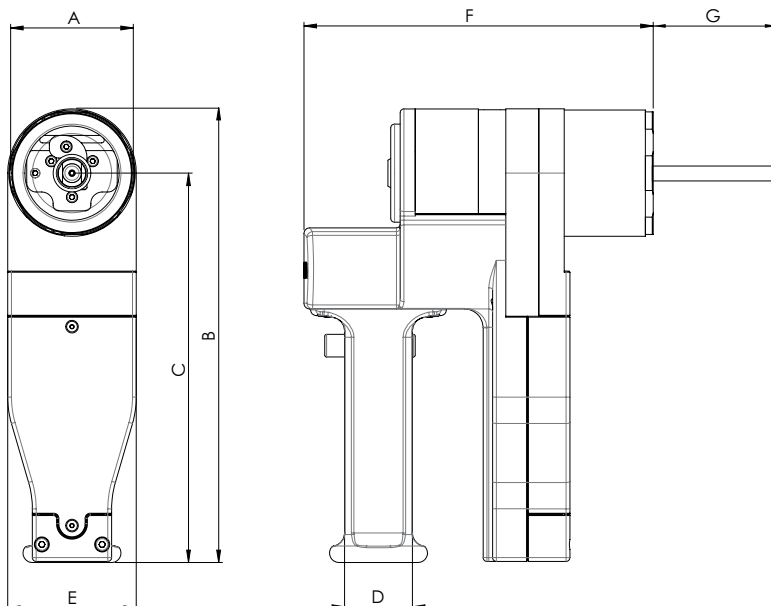


The perfect supplement: Orbital welding power sources of the ORBITAL series

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



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

## Tube-to-tube-sheet orbital weld head

### TX 38P

Properties, application area, technical specifications and delivery scope, see from Page 67.

**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 66
- Spring sleeves, see Page 66
- Clamping segments, see Page 66
- Ground cable, see Page 86



TX 38P

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Tube-to-tube-sheet orbital weld head TX 38P	830 000 005	17.760.00	7.500	15.600

\* Machine weight including hose package

### Suitable accessories (optionally available):

- Arbors, see Page 66
- Spring sleeves, see Page 66
- Clamping segments, see Page 66
- Electrode adapters, see Page 66
- Ground cable, see Page 86
- Balancer spring, see Page 71
- Hose package extensions, see Page 86
- Welding current connection adapter set, see Page 87

#### TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS



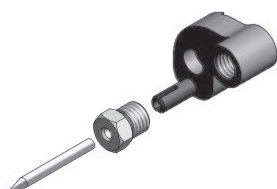
Arbor TX 38P



Spring sleeve



Clamping segments



Electrode support

## Accessories for TX 38P

### Arbors

Base arbor including insulation sleeve and clamping cone.

ITEM	SUITABLE FOR	CODE	EUR	KG
Arbor TX 38P, Type A	Spring sleeves, Type A	<b>830 020 020</b>	1.080.00	0.130
Spring sleeves TX 38P, Type B	Clamping segments, Type B	<b>830 020 021</b>	815.00	0.130

### Spring sleeves

Suitable for arbor, Type A.

ITEM	PIPE ID [MM]	PIPE ID [INCH]	CODE	EUR	KG
Spring sleeve TX 38P, Type A1	10.0 - 11.3	0,394 - 0,445	<b>830 020 022</b>	498.00	0.030
Spring sleeve TX 38P, Type A2	11.0 - 12.7	0,433 - 0,500	<b>830 020 019</b>	498.00	0.030
Spring sleeve TX 38P, Type A3	12.5 - 14.0	0,492 - 0,551	<b>830 020 023</b>	498.00	0.030

### 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	EUR	KG
Clamping segments TX 38P, Type B1	13.8 - 16.8	0,543 - 0,661	<b>830 020 024</b>	395.00	0.025
Clamping segments TX 38P, Type B2	16.6 - 19.6	0,654 - 0,772	<b>830 020 025</b>	395.00	0.045
Clamping segments TX 38P, Type B3	19.4 - 22.4	0,764 - 0,882	<b>830 020 026</b>	395.00	0.065
Clamping segments TX 38P, Type B4	22.2 - 25.2	0,874 - 0,992	<b>830 020 027</b>	395.00	0.085
Clamping segments TX 38P, Type B5	25.0 - 28.0	0,984 - 1,102	<b>830 020 028</b>	730.00	0.105
Clamping segments TX 38P, Type B6	28.0 - 31.0	1,102 - 1,220	<b>830 020 029</b>	498.00	0.130
Clamping segments TX 38P, Type B7	31.0 - 34.0	1,220 - 1,339	<b>830 020 030</b>	498.00	0.160
Clamping segments TX 38P, Type B8	34.0 - 37.0	1,339 - 1,457	<b>830 020 031</b>	550.00	0.200
Clamping segments TX 38P, Type B9	37.0 - 40.0	1,457 - 1,575	<b>830 020 032</b>	498.00	0.200

### Electrode support

ITEM	CODE	EUR	KG
Electrode support TX 38P cpl., 2.4 mm (0.094")	<b>830 013 010</b>	483.00	

### Other accessories for orbital welding

- Ground cable, see Page 86
- Double pressure reducer, see Page 87
- ESG electrode grinders, see Page 79
- WS2 tungsten electrodes, see Page 87
- Torch and cold wire accessories, see Page 89
- Welding current connection adapter set, see Page 87

#### TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

# P16, P16 AVC

## Tube-to-tube-sheet orbital weld heads

Easy handling for high efficiency and functionality is a feature of the Orbitalum P-series: These TIG tube-to-tube-sheet orbital weld heads produce several thousand weld seams of consistent seam quality with maximum precision.



**With these TIG tube-to-tube-sheet weld heads a welding of tubes in tube sheets with highest precision and continuous quality is no problem.**

The liquid cooling of the P-series runs up to the TIG head torch which provides for a precise process and continuous quality of the welding process and extends the duty cycle. The torch head can be swiveled steplessly up to 30° - this function is, for example, valuable for tubes entering diagonally into the tube sheets and in tight spaces.

### FURTHER PROPERTIES:

- Completely liquid-cooled welding head housing
- Torch head can be swiveled steplessly up to 30° (reduced diameter area)
- Weld seam geometries: Recessed, flush and protruding tubes
- Current transfer: Multi-plate clutch
- Gas water transfer: Rotating coupling
- 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 addition-

ally 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 three-point support
- Including 7.5 m (24.6 ft) hose package and tool set

### ADDITIONAL CHARACTERISTICS P16 AVC:

- With electronic arc gap control (AVC) - only usable in combination with welding power supply ORBIMAT 300 CA AVC/OSC



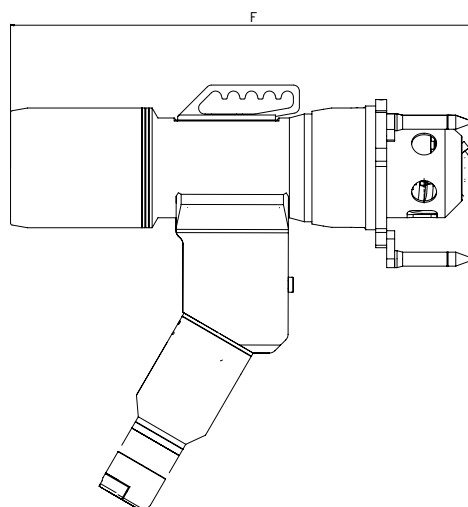
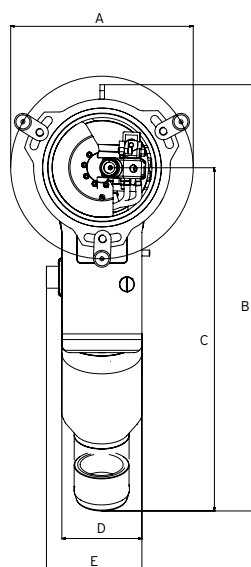
P16



P16 AVC

APPLICATION AREA		P16	P16 AVC
Code	with cold wire	831 000 001	831 000 002
	Without cold wire	831 000 003	-
From pipe ID to pipe OD		10 - 78 mm*	12 - 100 mm*
		0.394" - 3.071"*	0.470" - 3.937"*
TECHNICAL SPECIFICATIONS		P16	P16 AVC
Weight machine including hose package	With cold wire	17.5 kg	18.3 kg
	Without cold wire	16.2 kg	-
Weight additional wire unit		2.2 lbs	2.2 lbs
		1.0 kg	1.0 kg
Additional wire unit Ø		0.8 mm	0.8 mm
		0.03"	0.03"
Hose package length		7.5 m	7.5 m
		24.6 ft	24.6 ft
SCOPE OF DELIVERY			
Including:		<ul style="list-style-type: none"> <li>• 1 tube-to-tube-sheet orbital weld head P16, or P16 AVC</li> <li>• 1 three-point support</li> <li>• 1 transport case</li> <li>• 1 tool set</li> <li>• 1 set of operating instructions and spare parts list</li> </ul>	
Suitable accessories (optionally available):		<ul style="list-style-type: none"> <li>• Centering cartridges and arbors</li> <li>• Special torch (box header torch, rear sheet torch)</li> <li>• Quick-change adapter torch equipment</li> <li>• Cold-wire feeds KD</li> <li>• Balancer spring</li> <li>• Closed gas cover</li> <li>• Front cage</li> <li>• ESG electrode grinders</li> <li>• Ground cable</li> <li>• Hose package extensions</li> <li>• Double pressure reducer</li> <li>• WS2 tungsten electrodes</li> </ul>	
DIMENSIONS		P16	P16 AVC
Dimension "A"		182.97 mm	187.05 mm
		7.204"	7.364"
Dimension "B"		427.25 mm	427.25 mm
		16.821"	16.821"
Dimension "C"		344.00 mm	344.00 mm
		13.543"	13.543"
Dimension "D"		80.00 mm	80.00 mm
		3.150"	3.150"
Dimension "E"		95.50 mm	95.50 mm
		3.760"	3.760"
Dimension "F"		466.00 mm	582.00 mm
		18.346"	22.913"

\* Smaller and larger diameters on request.



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



## Tube-to-tube-sheet orbital weld heads

### P16, P16 AVC

Properties, application area, technical specifications and delivery scope, see Page 67.

**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 72)
- Ground cable (see Page 86)

ITEM	CODE	EUR	MACHINE WEIGHT KG*	SHIPPING WEIGHT KG
Tube-to-tube-sheet orbital weld head P16 with cold wire	<b>831 000 001</b>	19.320.00	17.500	26.500
Tube-to-tube-sheet orbital weld head P16 without cold wire	<b>831 000 003</b>	14.270.00	16.200	25.100
Tube-to-tube-sheet orbital weld head P16 AVC with cold wire	<b>831 000 002</b>	21.590.00	18.300	27.300

\* Machine weight including hose package

### Suitable accessories (optionally available):

- Centering cartridges and arbors, see Page 72
- Ground cable, see Page 86
- Special torch (box header/rear sheet), see Page 70
- Quick-change adapter torch equipment, see Page 70
- Balancer spring, see Page 71
- Closed gas cover, see Page 71
- Front cage, see Page 71
- Remote control, see Page 16



#### TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

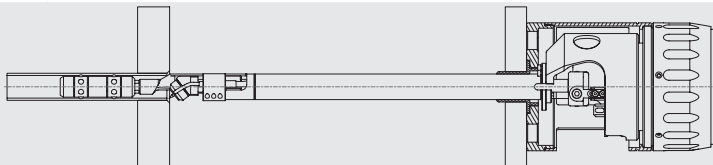


## Accessories for P16, P16 AVC

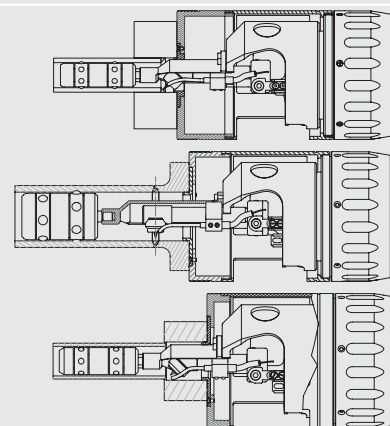
### Special torches

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

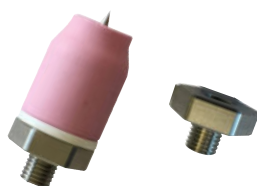
Box header torch



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



ITEM	CODE	EUR	KG
Box header torch	on request		
Inner torch	on request		



Quick-change adapter torch equipment

### 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	EUR	KG
Quick-change adapter torch equipment	831 050 019	93.00	0.012

### 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	EUR	KG
Cold-wire feed P16/P16 AVC	831 001 116	4.705.00	1.500

#### TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

## Balancer spring

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

ITEM	TENSILE LOAD MAX. [KG]	CODE	EUR	KG
Balancer spring for P16	10 - 14	832 030 002	287.00	3.800



Balancer spring

## Closed gas cover

For welding of titanium tubes under full gas cover.

ITEM	CODE	EUR	KG
Closed gas cover for P16	831 001 101	1.200.00	1.300



Closed gas cover

## Front cage

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

ITEM	CODE	EUR	KG
Front cage for P16	831 050 001	560.00	0.360



Front cage

TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS



Centering cartridges



Arbor

## Centering cartridges and arbors

The inner diameter of the pipe 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.	PIPE ID* [MM]	PIPE ID* [INCH]	CODE	EUR	KG
Arbor for centering cartridge for group A					<b>832 020 003</b>	327.00	0.060
Centering cartridge	A	1	10.0 - 10.5	0,394 - 0,413	<b>832 020 004</b>	326.00	0.040
Centering cartridge	A	2	10.5 - 11.0	0,413 - 0,433	<b>832 020 005</b>	431.00	0.050
Centering cartridge	A	3	11.0 - 11.5	0,433 - 0,452	<b>832 020 006</b>	326.00	0.070
Centering cartridge	A	4	11.5 - 12.0	0,452 - 0,472	<b>832 020 007</b>	326.00	0.070
Centering cartridge	A	5	12.0 - 12.5	0,472 - 0,492	<b>832 020 008</b>	326.00	0.080
Centering cartridge	A	6	12.5 - 13.0	0,492 - 0,512	<b>832 020 009</b>	326.00	0.100
Centering cartridge	A	7	12.8 - 14.0	0,504 - 0,551	<b>832 020 011</b>	338.00	0.110
Arbor centering cartridge for group B					<b>832 020 010</b>	327.00	0.070
Centering cartridge	B	8	13.8 - 15.0	0,543 - 0,591	<b>832 020 012</b>	338.00	0.120
Centering cartridge	B	9	14.8 - 16.0	0,583 - 0,630	<b>832 020 013</b>	338.00	0.140
Centering cartridge	B	10	15.8 - 17.0	0,622 - 0,669	<b>832 020 014</b>	338.00	0.150
Centering cartridge	B	11	16.8 - 18.0	0,661 - 0,709	<b>832 020 015</b>	338.00	0.180
Centering cartridge	B	12	17.8 - 19.0	0,701 - 0,748	<b>832 020 016</b>	338.00	0.190
Centering cartridge	B	13	18.8 - 20.5	0,740 - 0,807	<b>832 020 017</b>	338.00	0.200
Centering cartridge	B	14	19.8 - 22.5	0,780 - 0,886	<b>832 020 018</b>	338.00	0.250
Grub screw for arbor for group B					<b>832 001 025</b>		
Arbor centering cartridge for group C					<b>832 020 019</b>	327.00	0.115
Centering cartridge	C	15	22.3 - 24.6	0,878 - 0,969	<b>832 020 020</b>	378.00	0.340
Centering cartridge	C	16	24.5 - 27.0	0,965 - 1,063	<b>832 020 021</b>	378.00	0.350
Centering cartridge	C	17	26.5 - 29.0	1,043 - 1,142	<b>832 020 022</b>	384.00	0.360
Centering cartridge	C	18	28.5 - 31.0	1,122 - 1,220	<b>832 020 023</b>	384.00	0.400
Centering cartridge	C	19	30.5 - 33.0	1,201 - 1,299	<b>832 020 024</b>	404.00	0.500
Centering cartridge	C	20	32.5 - 36.0	1,280 - 1,417	<b>832 020 025</b>	425.00	0.510
Centering cartridge	C	21	35.5 - 39.0	1,397 - 1,535	<b>832 020 026</b>	445.00	0.530
Centering cartridge	C	22	38.5 - 42.0	1,516 - 1,654	<b>832 020 027</b>	464.00	0.550
Centering cartridge	C	23	41.5 - 45.0	1,634 - 1,772	<b>832 020 028</b>	485.00	0.560
Centering cartridge	C	24	44.5 - 48.0	1,752 - 1,890	<b>832 020 029</b>	485.00	1.000
Centering cartridge	C	25	47.5 - 51.0	1,870 - 2,008	<b>832 020 030</b>	485.00	1.200
Threaded screw DIN913-M5x5-A2 for group C					<b>445 005 222</b>		
Arbor for centering cartridge for group D					<b>832 020 031</b>	327.00	0.215
Centering cartridge	D	26	50.5 - 54.0	1,988 - 2,126	<b>832 020 032</b>	665.00	1.500
Centering cartridge	D	27	53.5 - 58.0	2,106 - 2,283	<b>832 020 033</b>	665.00	1.800
Centering cartridge	D	28	57.5 - 62.0	2,264 - 2,441	<b>832 020 034</b>	665.00	1.900
Centering cartridge	D	29	61.5 - 66.0	2,421 - 2,598	<b>832 020 035</b>	665.00	2.100
Centering cartridge	D	30	65.5 - 70.0	2,579 - 2,756	<b>832 020 036</b>	720.00	2.400
Centering cartridge	D	31	69.5 - 74.0	2,736 - 2,913	<b>832 020 037</b>	720.00	2.600
Centering cartridge	D	33	77.5 - 82.0	3,051 - 3,228	<b>832 020 039</b>	890.00	3.100
Centering cartridge	D	34	82.0 - 87.0	3,228 - 3,425	<b>832 020 045</b>	1.045.00	3.100
Centering cartridge	D	36	91.0 - 95.0	3,582 - 3,740	<b>832 020 047</b>	1.260.00	3.300
Centering cartridge	D	37	95.0 - 99.0	3,740 - 3,897	<b>832 020 048</b>	1.575.00	3.960

\* Smaller tube diameters on request.

## Other accessories for orbital welding

- Ground cable, see Page 86
- ESG electrode grinders, see Page 79
- WS2 tungsten electrodes, see Page 87
- Torch and cold wire accessories, see Page 89

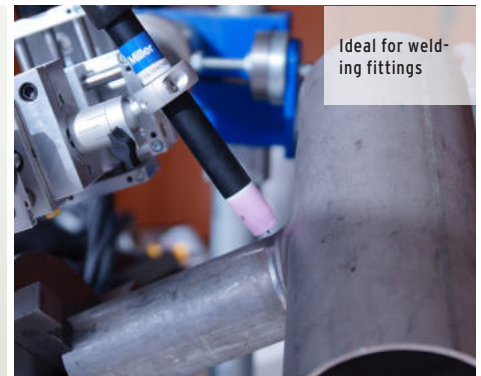
### TUBE-TO-TUBE-SHEET ORBITAL WELD HEADS

# DVR

Turning devices for  
TIG orbital welding

## Welding turntables

The turning gears of Orbitalum for the mechanical TIG orbital welding are a reliable and efficient solution for the welding of rotating workpieces, short fittings and fittings.



**Compact turntables for industrial manufacturing or for flexible workshop use - in combination with a power source of the ORBITAT series a welding system of the highest precision and nevertheless extremely simple handling.**

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

The welding turntables are available in different versions and can be equipped with various options as required. Thanks to the stable construction even massive workpieces can be positioned without any problems. In the process the powerful clamping is carried out without any deformation of the workpiece. While the quality of the weld seam remains at a constantly high level, the physical burden for the operator is reduced significantly.

The result: maximum reliability and productivity.

### The advantages at a glance:

- Turntable can be tilted steplessly from 0 to 90°
- Centered clamping three-jaw chuck made of hardened and polished steel
- Three-jaw lathe chuck available for different clamping ranges
- Robust steel structure, excellently suited for use even under extreme process conditions
- Stable, swivel torch stand
- Three-coordinate torch support
- Ball-joint holder for TIG machine welding torch
- Liquid-cooled 250 A TIG machine welding torch
- Remote controls for higher operator comfort (available optionally)
- Cold-wire feed for wire Ø 0.8 mm (0.031") and 1.0 mm (0.039") for welding with cold wire (available optionally)
- Modern functional design
- Arc gap control unit for automatic controlling and holding of the arc gap (AVC = Arc Voltage

Control)

- Shorter welding times at constant high quality
- Compatible with all power sources of the ORBITAT series

### The most important advantages of the

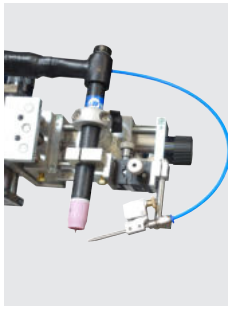
#### DVR turning devices:

- ✓ Stepless tilting up to 90°
- ✓ High-quality three-jaw chuck
- ✓ 3-axis torch support
- ✓ Modular extendable structure
- ✓ Direction of rotation selection
- ✓ Cold wire retrofitted optionally
- ✓ Wire equipping quick change system
- ✓ Liquid-cooled torch





Robust steel structure, excellently suited for use even under extreme process conditions



Liquid-cooled torch



Three-jaw lathe chuck (available separately)



Control cable and ground cable (available separately)



Remote controls for higher operator comfort (available separately)



Cold-wire feeds DVR (retrofitting kits) for welding with cold wire including feed motor and wire adjusting unit

PROPERTIES & TECHNICAL SPECIFICATIONS		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Code		855 000 011	855 000 012	855 000 001	855 000 002
TURNTABLE		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Max. load in horizontal position (workpiece + lathe chuck), max.:		50 kg (110 lbs)	50 kg (110 lbs)	100 kg (220 lbs)	100 kg (220 lbs)
Dimensions:		300 x 300 x 395 mm (11.8" x 11.8" x 15.6")	300 x 300 x 395 mm (11.8" x 11.8" x 15.6")	600 x 570 x 695 mm (23.6" x 22.4" x 27.4")	600 x 570 x 695 mm (23.6" x 22.4" x 27.4")
Distance floor to rotating axis:		279 mm (11")	279 mm (11")	590 mm (23.2")	590 mm (23.2")
Turntable can be tilted steplessly from 0 to 90°		●	●	●	●
Locking via two clamping levers		●	●	●	●
Turning plate-Ø OD:		300 mm (11.81")	300 mm (11.81")	400 mm (15.75")	400 mm (15.75")
Hollow shaft Ø ID:		30 mm (1.18")	30 mm (1.18")	125 mm (4.9")	125 mm (4.9")
Built-in weld power coupling for mass transfer to turning plate		●	●	●	●
Weld current built-in plug for ground cable connection		●	●	●	●
Limit switch for zero setting and speed calibration		●	●	●	●
Stand console for mounting the stand directly on the turntable		○	○	●	●
Mounting holes for floor fastening		●	●	●	●
Signal distribution box with connecting option for control cable ORBIMAT-DVR, turntable motor, limit switch, cold wire feed and remote control OWH BASIC		●	●	●	●
Tilt lever for selecting the direction of rotation		●	●	●	●
STAND		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Weld torch stand mounted on console		○	○	●	●
Weld torch stand to be fastened separately		●	●	○	○
Base clamp with mounting holes for fastening at point of use		●	●	○	○
Dimensions stand tube OD x L:		50 x 1200 mm (2" x 47.2")	50 x 1200 mm (2" x 47.2")	50 x 1200 mm (2" x 47.2")	50 x 1200 mm (2" x 47.2")
Dimensions extension arm OD x L:		50 x 800 mm (2" x 31.5")	50 x 800 mm (2" x 31.5")	50 x 800 mm (2" x 31.5")	50 x 800 mm (2" x 31.5")
Extension swivel unit with magnetic stop for locking the welding position		●	●	●	●
Rough adjustment possible without tools via clamping lever, incl. cross-clamping unit		●	●	●	●
Three-coordinate support for torch fine adjustment. Linear adjustment path: each 50 mm (2")		●	●	●	●
Torch holder with ball head		●	○	●	○
MACHINE TORCH		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Liquid-cooled machine torch with hose package length 4 m (13.12 ft)		●	●	●	●
Current carrying capacity DC: 250 A, AC: 180 A at 100% ED		●	●	●	●
Incl. standard torch equipment for electrode diameter 2.4 mm (0.09")		●	●	●	●
AVC LINEAR UNIT*		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Arc gap control unit for automatic controlling and holding of the arc gap		○	●	○	●
Linear stroke: 55 mm		○	●	○	●
SCOPE OF DELIVERY		DVR 50	DVR 50 AVC	DVR 100	DVR 100 AVC
Welding turntable of the DVR series (without lathe chuck)	PCS.	1	1	1	1
Stand	PCS.	1	1	1	1
Signal distribution box	PCS.	1	1	-	-
Machine torch with equipment	PCS.	1	1	1	1
AVC linear unit	PCS.	-	1	-	1
Welding current connection adapter	PCS.	1	1	1	1
Operating instructions and spare part list	Set	1	1	1	1

● = Function included

○ = Function not included

◐ = Function only conditionally included

\* Can only be used in combination with the orbital welding power sources ORBIMAT 300 CA AVC/OSC as well as ground cable for 300 CA AVC/OSC power sources

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

## Welding turntables

### DVR

Properties, application area, technical specifications and delivery scope, see from Page 73.

**The following accessories are mandatory for the use of the welding turntables and must be ordered separately:**

- Control cable (see Page 76)
- Ground cable (see Page 76)
- Three-jaw lathe chuck (see Page 76)

ITEM	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
Welding turntable DVR 50	855 000 011	8.895.00	45.000	
Welding turntable DVR 50 AVC*	855 000 012	13.915.00	50.000	
Welding turntable DVR 100	855 000 001	10.790.00	100.000	
Welding turntable DVR 100 AVC*	855 000 002	16.325.00	105.000	

\* Can only be used in connection with an ORBIMAT CA AVC/OSC power source (see from Page 11).

### Suitable accessories (optionally available):

- Three-jaw lathe chuck, see Page 76
- Control cable, see Page 76
- Ground cable, see Page 76
- Remote control OWH BASIC, see Page 77
- Remote control ORBIMAT, see Page 16
- Cold-wire feeds DVR, see Page 77
- Welding current connection adapter set, see Page 87



Welding turntable DVR 50

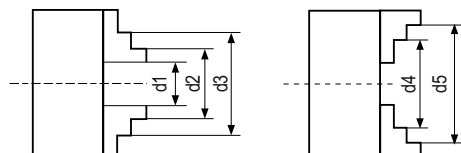


Welding turntable DVR 100

#### WELDING TURNABLES



Three-jaw lathe chuck



Clamping range three-jaw lathe chuck

## Accessories for DVR

### Three-jaw lathe chuck

Centered clamping three-jaw chuck made of hardened and polished steel. With cylindrical retainer for clamping the pipe.

#### The scope of delivery includes:

- 1 three-jaw lathe chuck
- 1 adapter plate for the clamping turning plate
- 1 chuck key
- 1 set each of turning and drilling jaws, graded to the inside and outside
- 1 set of fastening screws

CLAMPING RANGE	D1		D2		D3 MAX.		D4 MAX.		D5 MAX.	
	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	[INCH]
Three-jaw lathe chuck DVR 50	4 - 90	0.16 - 3.54	52 - 135	2.05-5.31	120 - 202	4.72 - 7.95	60 - 145	2.36-5.71	130 - 200	5.12-7.87
Three-jaw lathe chuck DVR 100	5 - 118	0.20 - 4.65	62 - 174	2.44-6.85	145 - 256	5.71 - 10.18	77 - 188	3.03-7.40	160 - 250	6.30-9.84
Three-jaw lathe chuck DVR 100	10 - 131	0.39 - 5.16	78 - 200	3.07-7.87	172 - 299	6.77 - 11.77	90 - 215	3.54-8.46	190 - 315	7.48-12.40

ITEM	OUTER Ø CHUCK		INNER Ø HOLE		CODE	EUR	KG
	[MM]	[INCH]	[MM]	[INCH]			
Three-jaw lathe chuck DVR 50	200.0	7.874	55.0	2.175	<b>890 030 050</b>	1.015.00	14.500
Three-jaw lathe chuck DVR 100	250.0	9.842	76.0	2.992	<b>890 030 054</b>	1.410.00	25.700
Three-jaw lathe chuck DVR 100	315.0	12.402	103.0	4.055	<b>890 030 051</b>	2.020.00	44.200

### Control cable

Required for use with DVR welding turntables.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	EUR	KG
Control cable for welding turntable DVR	5.0	16.4	<b>890 030 022</b>	223.00	1.170



Control cable for turning gear DVR

### Ground cable

Required for use with DVR welding turntables.

ITEM	SUITABLE FOR ORBITAT	LENGTH [M]	LENGTH [FT]	CODE	EUR	KG
Ground cable for welding turntable DVR	165/180/300	5.0	16.4	<b>890 030 015</b>	99.00	2.500
Ground cable for welding turntable DVR	300 AVC	5.0	16.4	<b>890 030 017</b>	152.00	2.885



Ground cable for turning gear DVR

## WELDING TURNABLES

## Remote control OWH BASIC

Can be used with all DVR turntables without AVC/OSC function.  
 For advanced functions such as the **AVC/OSC control** etc. please order our remote control **ORBIMAT**, see Page 16.

For even more operator comfort the DVR welding turntables can be controlled with this "OWH BASIC" remote control. The remote control is connected directly to the turntable and disposes of the following standard functions:

- Start/Stop button
- Direction of rotation
- Wire feed
- Wire withdrawal

ITEM	CABLE LENGTH [M]	CABLE LENGTH [INCH]	CODE	EUR	KG
Remote control OWH BASIC	7.5	24.6	<b>871 050 035</b>	329.00	0.368



Remote control OWH BASIC

## Cold-wire feeds DVR

**For welding with cold wire. Can be retrofitted to all DVR turntables.**  
 The cold wire unit can be adjusted individually in four axes.  
 Retooling of the wire diameter is carried out completely without tools.

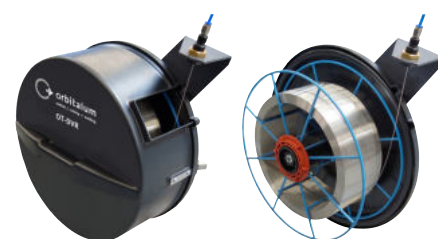
**The scope of delivery includes:**

- 1 feed motor
- 1 wire adjusting unit
- 2 wire nozzles with wire core
- 1 wire coil mounting
- Fastening material

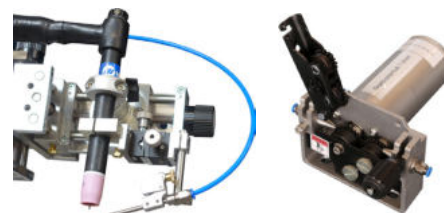
TECHNICAL SPECIFICATIONS	WIRE FEED QUANTITY MAX.	WIRE Ø		WIRE COIL Ø		WEIGHT WIRE COIL	
	[MM/MIN.]	[MM]	[INCH]	[MM]	[INCH]	[KG]	[LBS]
Cold-wire feed DVR 50/100	1300	0.8/1.0	0.031/0.039	100.0	3.937	1.0	2.2
Cold-wire feed DVR 100	1300	0.8/1.0	0.031/0.039	300.0	11.811	15.0	33.0

ITEM	CAN BE USED WITH	CODE	EUR
Cold-wire feed DVR 50	DVR 50 (AVC)*	<b>855 050 008</b>	5.140.00
Cold-wire feed DVR 100	DVR 100 (AVC)	<b>855 050 005</b>	5.140.00

\* Can also be used with DVR 100



Cold wire feed DVR 100 (with or without cover)



Adjusting unit and feed motor

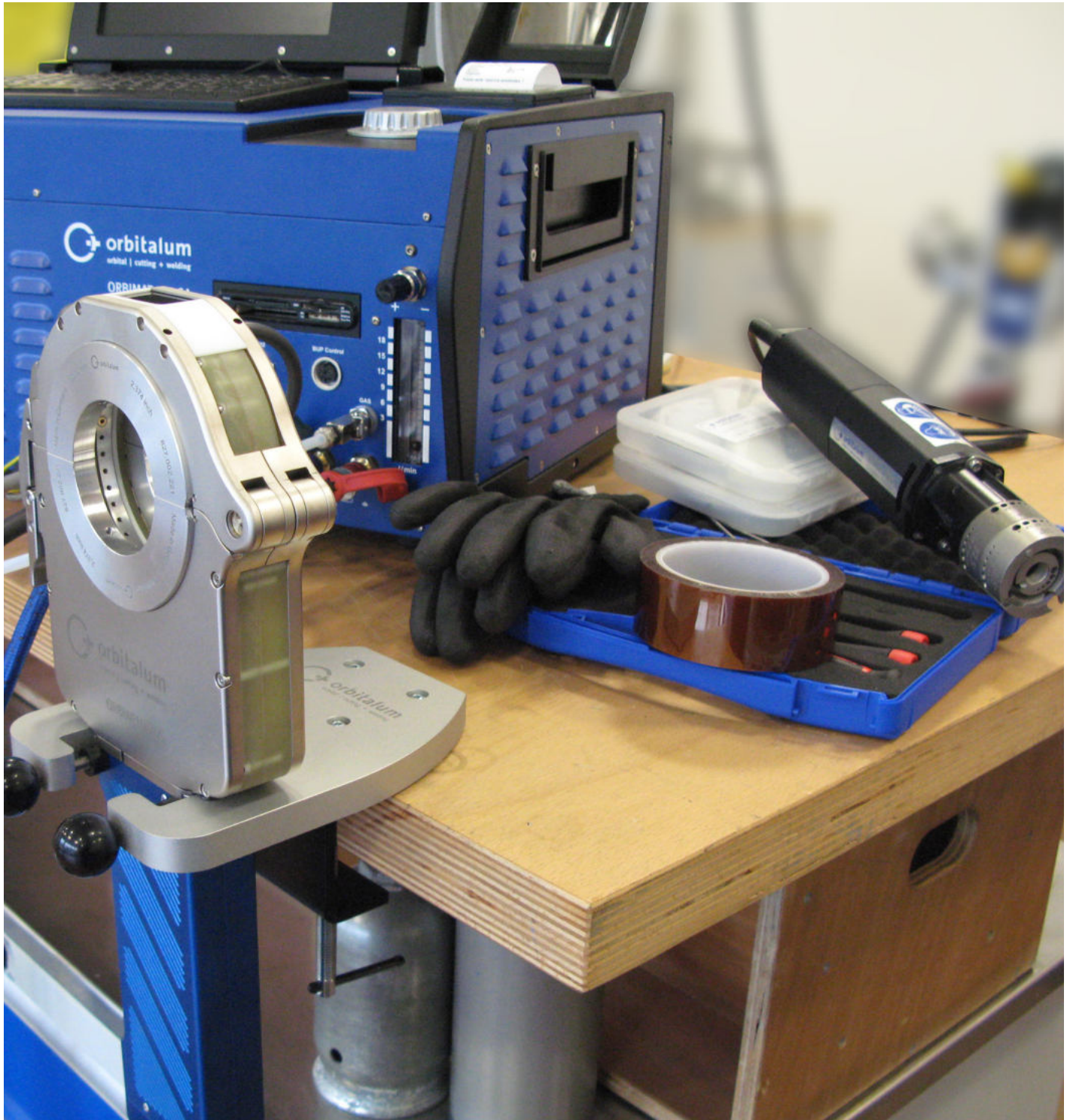
## Other accessories for orbital welding

- ESG electrode grinders, see Page 79
- ORBmax residual oxygen meter, see Page 83
- ORBIPURGE forming set, see Page 86
- WS2 tungsten electrodes, see Page 87
- Torch and cold wire accessories, see Page 89
- Welding current connection adapter set, see Page 87

### WELDING TURNABLES



# Accessories and wear parts for orbital welding





# ESG Plus, ESG Plus<sup>2</sup>

## 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 machining	✓
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 design, 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 PLUS<sup>2</sup>:

- 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 <sup>2</sup>
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°)
	PCS.	1	1
	PCS.	1	1
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 <sup>2</sup>
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
Wattage	[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 <sup>2</sup> ]	< 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 electrode grinders

### ESG Plus, ESG Plus<sup>2</sup>

Properties, application area, technical specifications and delivery scope, see from Page 79.

ITEM	VERSION	GRINDING ANGLE [°]	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ESG Plus	230 V, 50/60 Hz EU	15/18/22.5/30	<b>790 052 485</b>	645.00	1.430	3.560
ESG Plus	110 V, 50/60 Hz EU/US	15/18/22.5/30	<b>790 052 486</b>	645.00	1.430	3.560
ESG Plus	230 V, 50/60 Hz EU	15/30/45/60	<b>790 052 545</b>	645.00	1.430	3.560
ESG Plus	110 V, 50/60 Hz EU/US	15/30/45/60	<b>790 052 645</b>	645.00	1.430	3.560
ESG Plus <sup>2</sup>	230 V, 50/60 Hz EU	15/18/22.5/30	<b>790 052 585</b>	960.00	1.520	3.825
ESG Plus <sup>2</sup>	110 V, 50/60 Hz EU/US	15/18/22.5/30	<b>790 052 586</b>	960.00	1.520	3.825
ESG Plus <sup>2</sup>	230 V, 50/60 Hz EU	15/30/45/60	<b>790 052 546</b>	960.00	1.520	3.825
ESG Plus <sup>2</sup>	110 V, 50/60 Hz EU/US	15/30/45/60	<b>790 052 646</b>	960.00	1.520	3.825



ESG Plus

ESG Plus<sup>2</sup>

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



Diamond grinding wheels

ITEM	CAN BE USED WITH	GRAIN	WHEEL Ø		S		CODE	EUR	KG
			[MM]	[INCH]	[MM]	[INCH]			
Diamond grinding wheel	ESG 4	Standard	32.00	1.290	1.2	0.047	<b>790 052 460</b>	67.00	0.005
Diamond grinding wheel	ESG Plus, ESG Plus <sup>2</sup>	Fine	33.50	1.319	2.2	0.087	<b>790 052 487</b>	69.00	0.010
Diamond grinding wheel	ESG Plus, ESG Plus <sup>2</sup>	Medium	33.50	1.319	2.2	0.087	<b>790 052 488</b>	69.00	0.011
Diamond grinding wheel	ESG Plus, ESG Plus <sup>2</sup>	Rough	33.50	1.319	2.2	0.087	<b>790 052 550</b>	69.00	0.011

### Cutting 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	EUR	KG
		[MM]	[INCH]			
Cutting device	fix	12.0	0.472	<b>790 052 513</b>	199.00	0.030
		13.0	0.512			
		15.0	0.591			
		17.0	0.669			



Cutting device

#### ELECTRODE PROCESSING TECHNOLOGY



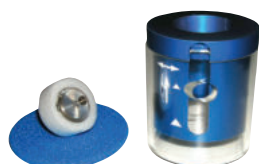
Electrode holder with collet



Spare collet



Wall, table vice mount



Dust protection



Double-decker kit

## Electrode holder

### For machining smaller electrodes.

The electrode holder is delivered including 1 flexible collet.

ITEM	SETTING	ELECTRODE Ø		CODE	EUR	KG
		[MM]	[INCH]			
Electrode holder with collet	continuous	1.0 - 3.2	0.039 - 0.126	<b>790 052 457</b>	42.00	0.023
Spare collet	continuous	1.0 - 3.2	0.039 - 0.126	<b>790 052 481</b>	16.00	0.002

## Wall, table vice mount

For stationary use of the ESG Plus and ESG Plus<sup>2</sup>.

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

ITEM	CODE	EUR	KG
Wall, table vice mount	<b>790 052 483</b>	34.00	0.102

## 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	EUR	KG
Dust protection ESG Plus	<b>790 052 496</b>	143.00	0.170
Dust protection ESG Plus <sup>2</sup>	<b>790 052 596</b>	143.00	0.220

## 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	EUR	KG
Double-decker kit	ESG Plus	15/18/22.5/30	<b>790 052 490</b>	326.00	0.160
Double-decker kit	ESG Plus	15/30/45/60	<b>790 052 390</b>	304.00	0.100

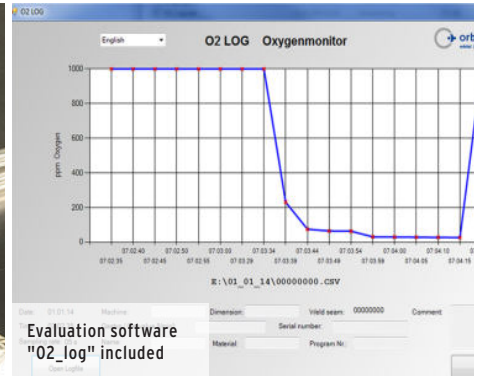
# ORBmax

## 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.





Evaluation software "O2\_log" included



Wide range of accessories, including robust transport case

**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





ORBmax



Including practical protective cover

## Residual Oxygen Meter

### ORBmax

Characteristics, see Page 83.

TECHNICAL SPECIFICATIONS	ORBMAX
Dimensions (LxDxH)	203 x 204 x 82 mm 7.99" x 8.03" x 3.23"
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"> <li>• 1 ORBmax residual oxygen meter</li> <li>• 1 transport case</li> <li>• 1 power unit supply set 100 - 240 VAC/12 VDC</li> <li>• 1 measuring hose (with test tip and filter)</li> <li>• 1 SD card incl. PC evaluation software "O2_log"</li> <li>• 1 interface cable ORBmax/ORBIMAT CA</li> <li>• 1 interface cable ORBmax/ORBIMAT SW</li> <li>• 2 reserve filter inserts</li> <li>• 1 operating instructions</li> </ul>

ITEM	VERSION	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
ORBmax	100 - 240 V, 50/60 Hz	882 000 010	2.705.00	1.65	4.665

### 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	EUR	KG
Interface cable ORBmax - ORBIMAT SW	850 040 031	88.00	0.065



Measuring hose (individual parts)

### Consumables for ORBmax

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

ITEM	CODE	EUR	KG
Measuring hose set, including:	882 050 006	59.00	0.081
• 1 hose*			
• 1 filter housing including filter insert (1 unit)			
• 1 test tip			
• 1 hose connector			
Hose*	882 012 010	3.50	0.050
Filter housing including filter insert (1 unit)	882 020 003	26.00	0.021
Filter inserts (5 piece per packing unit)	882 030 002	34.00	0.003
Test tip	882 012 011	24.50	0.004
Plastic connector test tip - hose	882 012 012	10.00	0.001

\* Please specify the hose length in meters when ordering.

#### 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](mailto:training@itw-ocw.com)



ORBIPURGE forming set



Replacement protective gas vents



Ground cable



Hose package extensions

## 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 pipe 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 pipe 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 83)
- 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.

ITEM	CODE	EUR	KG
ORBIPURGE forming set	<b>881 000 001</b>	760.00	3.150
Replacement protective gas vents for ORBIPURGE 3/8"	<b>881 020 014</b>	11.50	0.030
Replacement protective gas vents for ORBIPURGE M5	<b>881 020 015</b>	7.50	0.005
Forming plugs pair ID 114 - 130 mm (4.488" - 5.118"), 3/8"	<b>881 050 030</b>	105.00	0.220
Forming plugs pair ID 121 - 142 mm (4.764" - 5.591"), 3/8"	<b>881 050 031</b>	105.00	0.230
Forming plugs pair ID 148 - 162 mm (5.827" - 6.378"), 3/8"	<b>881 050 032</b>	117.00	0.250

### Ground cable

For utilization in combination with an Orbital welding power source of the OR-BIMAT series.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	EUR	KG
Ground cables for ORBIMAT 165/180/300-power sources	5.0	16.4	<b>811 050 005</b>	132.00	2.400
Ground cables for ORBIMAT 300 CA AVC/OSC power sources	5.0	16.4	<b>812 050 046</b>	184.00	2.850

### 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 86). Newer machine models are already equipped with DINSE compatible connections.

Further lengths on request.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	EUR	KG
Hose package extension 5 m (16 ft)	5	16	<b>871 050 011</b>	945.00	7.600
Hose package extension 10 m (32 ft)	10	32	<b>871 050 012</b>	1.125.00	14.600
Hose package extension 15 m (49 ft)	15	49	<b>871 050 013</b>	1.300.00	22.000
Hose package extension 20 m (64 ft)	20	64	<b>871 050 016</b>	1.480.00	28.700

#### OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

## 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	W21.8x1/14" LH	W21.8x1/14"
Hose connection	G 3/8 LH	G 1/4

ITEM	VERSION	CODE	EUR	KG
Double pressure reducer	Argon	888 000 001	261.00	1.850
Double pressure reducer	Argon/hydrogen	888 000 002	261.00	1.870
Replacement seals for double pressure reducer		888 000 005	10.00	0.002



Double pressure reducer "Argon"

## Bar pressure reducer "Argon"

For HX 16P, see Page 52.



Bar pressure reducer "Argon"

## 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 pieces Length: 175 mm (6,890").

Composition: WS2 = Rare earths (mixed oxides)

Identification color: Turquoise



WS2 tungsten electrodes

ITEM	ELECTRODE Ø [MM]	ELECTRODE Ø [INCH]	CODE	EUR	KG
WS2 tungsten electrodes	1.0	0.039	826 004 018	78.00	0.006
WS2 tungsten electrodes	1.6	0.063	826 004 019	41.50	0.010
WS2 tungsten electrodes	2.4	0.094	826 004 020	78.00	0.018

## Weld current connection adapter set

Simple, safe, robust and durable.

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

ITEM	CODE	EUR	KG
Welding current connection adapter set for socket & plug	850 030 004	95.00	0.326
Welding current connection adapter for plug	850 030 002	49.00	0.130
Welding current connection adapter for socket	850 030 003	49.00	0.195



Weld current connection adapter set

### OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY





TIG manual welding torch for ORBIMAT

## TIG manual welding torch for ORBIMAT

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

Including lockable metal transport case as well as a wear parts set.

Characteristics:

- Liquid-cooled 250 A DC, 200 A AC
- Superflex hose package
- Flexible torch body
- Ergonomic handle

**The scope of delivery includes:**

- 1 TIG manual welding torch
- 1 transport case
- Torch wear parts set

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


- Ground cable, see Page 86

ITEM	HOSE PACKAGE [M]	HOSE PACKAGE [FT]	CODE	EUR	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
TIG manual welding torch for ORBIMAT	4.0	13.0	<b>890 013 010</b>	645.00	2.425	6.405

### OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY



## Torch and cold wire accessories

ACCESSORIES	CLAMPING SLEEVE ELECTRODES			CLAMPING SLEEVE PRESSURE PIECE			TORCH ISOLATOR								
Image															
SUITABLE FOR:	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG						
TP 250	811 020 018	5.50	0.001	812 005 002	12.50	0.003	811 013 001	6.50	0.001						
TP 400 KD4-100	812 020 024	6.50	0.002				812 005 001	12.50	0.002						
TP 400 KD3-62 (AVC/OSC)	812 020 024	6.50	0.002												
TP 600 (AVC/OSC)															
TP 1000 (AVC/OSC)															
P16	831 001 058	4.50	0.010	-	-	-	831 001 007	12.00	0.005						
P16 AVC															
TIG manual welding torch	812 020 024	6.50	0.002	812 020 059	8.50	0.005	812 020 060	6.50	0.002						
DRV turntables (standard)	890 020 039	18.00	0.005	890 020 046	12.50	0.009	890 020 041	14.00	0.002						
DRV turntables (Jumbo)	-	-	-	-	-	-	812 020 065	17.00	0.012						

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	EUR	KG	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG						
TP 250	811 020 030	31.50	0.074	811 002 006	38.50		-	-	-	-	-	-						
TP 400 KD4-100	812 020 041	10.00	0.009	811 002 005	12.50	0.009												
TP 400 KD3-62 (AVC/OSC)																		
TP 600 (AVC/OSC)																		
TP 1000 (AVC/OSC)							831 001 022	12.50	0.005	831 001 015	6.00	0.005						
P16	-	-	-	-	-	-												
P16 AVC																		
TIG manual welding																		
DVR turntables	890 020 055	20.00	0.020	890 020 056	24.50	0.020	-	-	-	-	-	-						

ACCESSORIES	HF SPIRAL			TORCH SEAL			GAS NOZZLE			GAS LENS		
Image												
SUITABLE FOR:	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG
TP 250 Clamping sleeve	831 001 027	28.00	0.003	811 005 020	7.50	0.003	811 020 017	4.50	0.004	811 020 016	8.50	0.004
TP 400 KD4-100	811 050 011	43.50	0.002	-	-	-	812 020 023	5.00	0.010	812 020 022	10.00	0.010
TP 400 KD3-62 (AVC/OSC)	831 001 027	28.00	0.003									
TP 600 (AVC/OSC)												
TP 1000 (AVC/OSC)												
P16	811 050 011	43.50	0.002				831 001 060	4.00	0.020	831 001 161	11.50	0.009
P16 AVC												
TIG manual welding	-	-	-				812 020 023	5.00	0.010	812 020 022	10.00	0.010
DRV turntables (standard)	-	-	-	-	-	-	812 020 023	5.00	0.010	812 020 022	10.00	0.010
DRV turntables (Jumbo)	-	-	-	-	-	-	812 020 064	7.50	0.039	812 020 063	29.50	0.048
Clamping sleeve JUMBO 2.4 mm MB 250 A	812 020 068	18.00	0.010									

### 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	EUR	KG	CODE	EUR	KG	CODE	EUR	KG	CODE	EUR	KG
TP 250		811 018 010	49.00	0.004	811 018 011	49.00	-	-	-	-	-	-	-
TP 400 KD4-100		812 018 045	49.00	0.002	812 018 046	66.00	0.002	812 018 050	22.50	-	812 018 051	22.50	-
TP 400 KD3-62 (AVC/OSC)													
TP 600 (AVC/OSC)													
TP 1000 (AVC/OSC)													
P16		831 001 031	39.50	0.020	831 001 039	39.50	0.005	-	-	-	-	-	-
P16 AVC		831 018 051	54.00	0.003	-	-	-						
TIG manual welding torch		-	-	-	-	-	-						
DVR turntables		855 018 003	49.00	-	855 018 004	49.00	-	812 018 050	22.50	-	812 018 051	21.00	-

Notes:



## About us

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

Since 50 years installation manufacturers have been relying on the standard formed by the market leader Orbitalum Tools in the industrial pipe end preparation.

Orbitalum Tools GmbH (Singen, Germany) and E.H. Wachs (Lincolnshire, Illinois, USA) together form the "ITW Orbital Cutting & Welding" group (short: ITW OCW), a business division of the US-American industrial group ITW.

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. 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

(to Directive 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.



The ITW ORBITAL CUTTING & WELDING Group offers global customers the best in the field of pipe cutting and beveling as well as orbital welding technology from a single source.



Certified  
Management System ac-  
cording to ISO 9001:2015



Approved  
Economic Operator  
with AEO certification

## worldwide | sales + service

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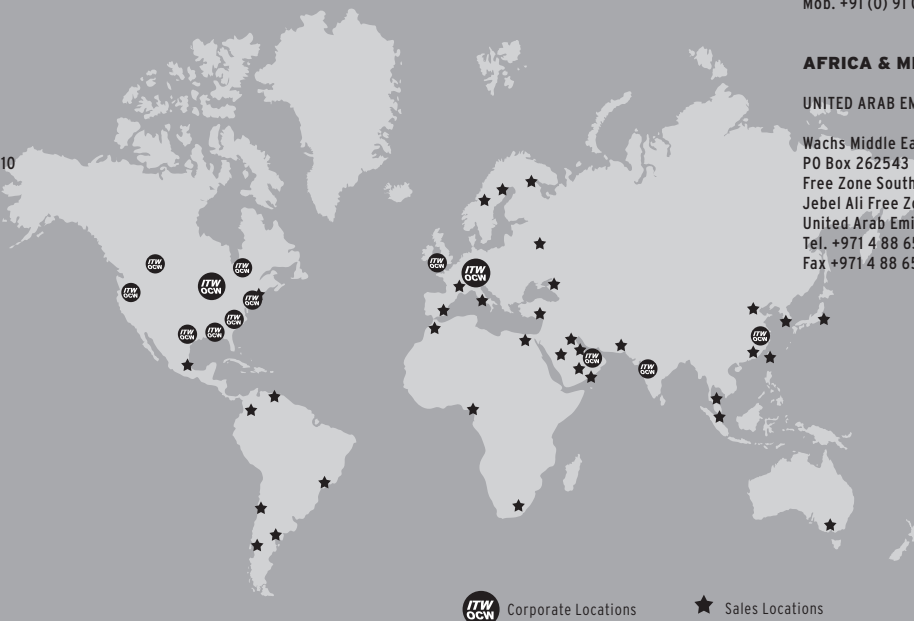
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ITW OCN Corporate Locations

★ Sales Locations



A brand of  
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