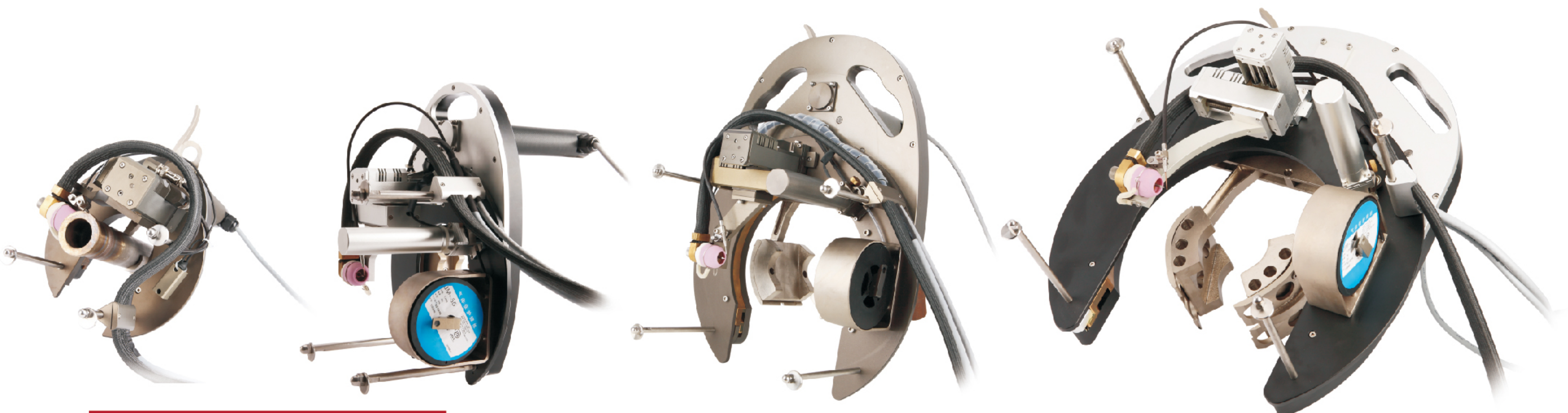
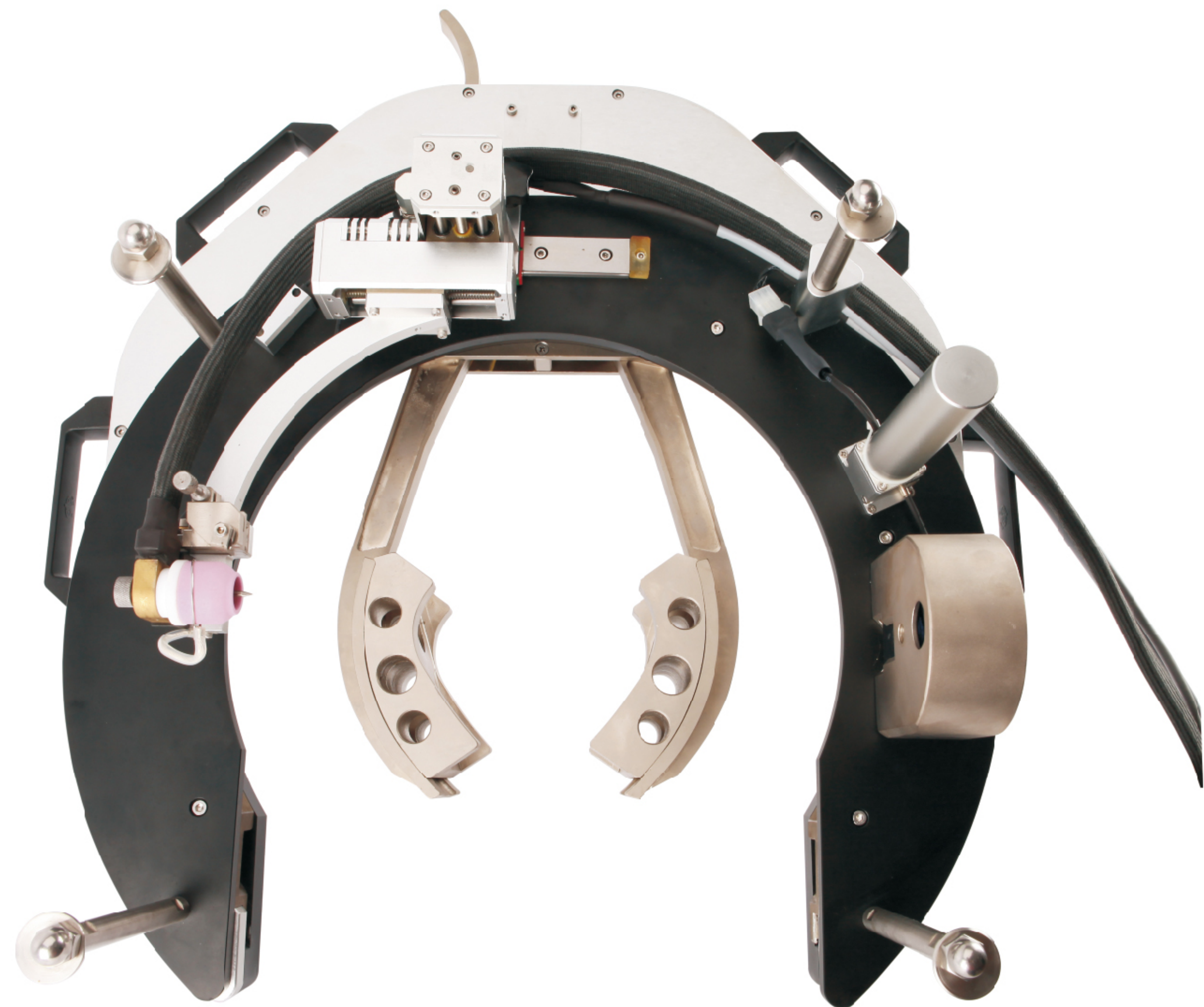
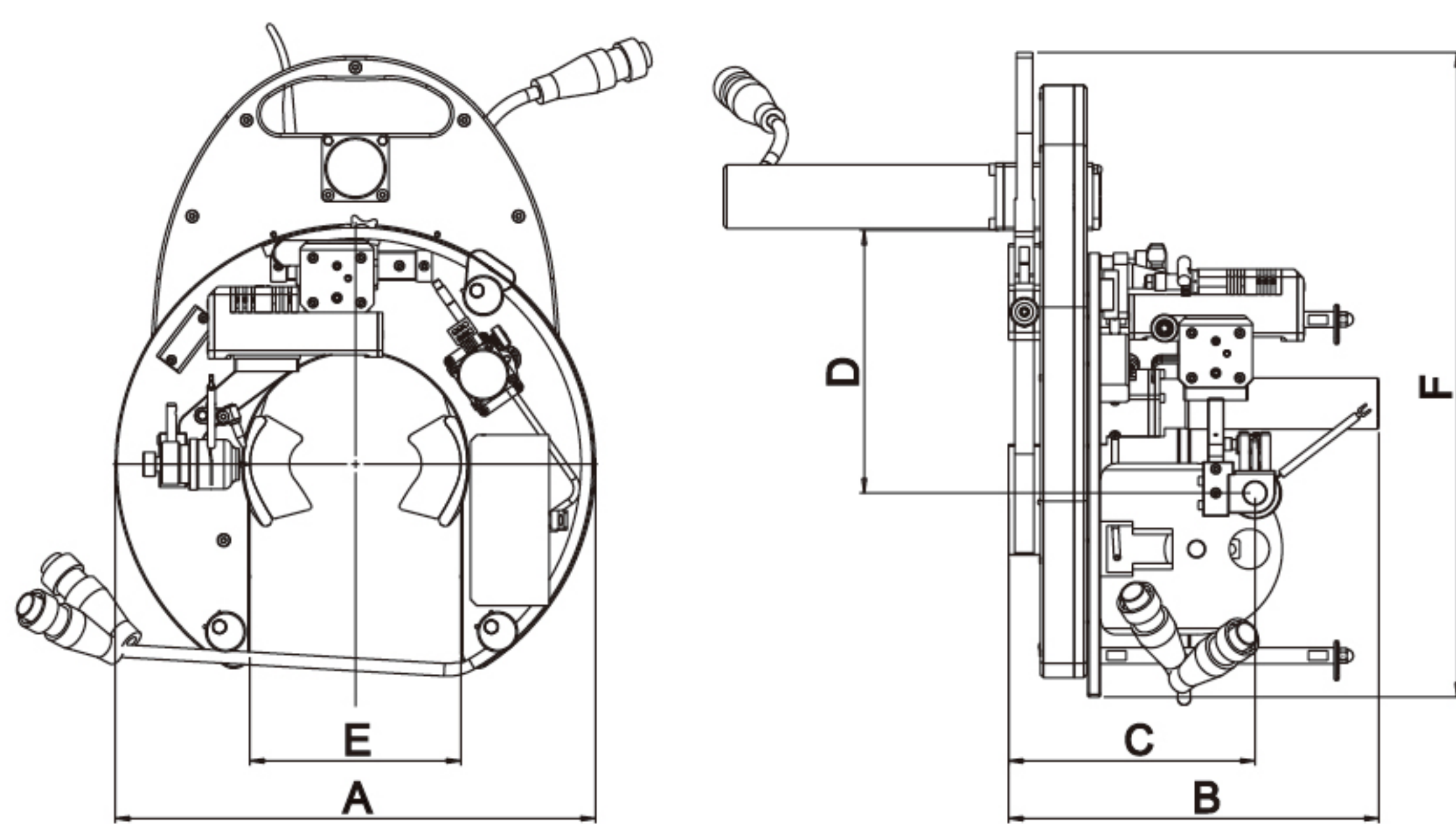


TOA series

Pipe/pipe Orbital Weld Head

Summary

This welding head is special designed for tube to tube TIG welding, suitable for carbon steel, stainless steel tube to tube butt joint. It's fit for fusion welding or wire feeding with external TB150 integrated wire feeder with AVC&OSC function. It is compatible with iOrbital 5000 programmable to achieve accurate orbital TIG welding for tube/tube welding with high repeatability. It mainly applied in chemical, food, medicine, engineering installation boiler, military nuclear and so on.



Technical specification

	TOA77	TOA130	TOA180	TOA230	TOA320
Material	Carbon steel, stainless steel	Carbon steel, stainless steel	Carbon steel, stainless steel	Carbon steel, stainless steel	Carbon steel, stainless steel
Tube OD(mm)	inner clamp: Φ19.05~Φ45(3/4"~1 3/4") Outer clamp: Φ45~Φ77(1 3/4"~3")	Inner clamp: Φ38.1~Φ76(1 1/2"~ 3") Outer clamp: Φ76~Φ130(3"~5")	Inner clamp: Φ50.8~Φ114.3(2"~4 1/2") Outer clamp: Φ114.3~Φ180(4 1/2"~7")	Inner clamp: Φ120~Φ178(4 1/2"~7") Outer clamp: Φ178~Φ230(7"~9")	Inner clamp: Φ150~Φ230(6"~9") Outer clamp: Φ230~Φ324(9"~12 3/4")
Tungsten diameter(mm)	Φ2.4、Φ3.2	Φ2.4、Φ3.2	Φ2.4、Φ3.2	Φ2.4、Φ3.2	Φ2.4、Φ3.2
Rotation speed(rpm)	0.19~3.8	0.11~2.2	0.09~1.8	0.05~1.0	0.026~0.52
Protective gas	Ar	Ar	Ar	Ar	Ar
Cooling	Water	Water	Water	Water	Water
Coolant flow(ml/min)	≥300	≥300	≥300	≥300	≥300
Rated current	200A 60%	200A 60%	200A 60%	200A 60%	200A 60%
OSC width(mm)	20	20	40	40	40
AVC height(mm)	40	40	40	40	40
Wire diameter(mm)	Φ1.0	Φ1.0	Φ1.0	Φ1.0	Φ1.0
Max wire feeding speed(mm/min)	1800	1800	1800	1800	1800
A	220	300	375	425	550
B	180	235	285	300	315
C	112 ~ 132	156 ~ 196	184 ~ 224	195 ~ 235	230 ~ 270
D	92	165	225	250	297
E	82	132	182	232	328
F	320	400	525	570	680
Weight(kg)	5.5(no cable)	10.8(no cable)	19.5(no cable)	21.5(no cable)	36(no cable)
Dimension(mm)	370 x220 x320	410 x300 x405	395x375 x525	410x425x560	420x610x680