MOVE YOUR SUBMERGED ARC WELDING SOLUTION TO THE NEXT LEVEL

EFFICIENCY 300%+

MECHANICAL PROPERTIES IMPROVED
**APPLICATION**
Labor cost*: 60 €/h
Weld length: 10 000 m
Consumables: Lincolnweld® 860 / L-61 wire combination

<table>
<thead>
<tr>
<th>PROCESS</th>
<th>Electrical parameters</th>
<th>DC+</th>
<th>AC*</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Amperage [A]</td>
<td>550</td>
<td>550</td>
</tr>
<tr>
<td></td>
<td>Voltage [V]</td>
<td>29</td>
<td>31</td>
</tr>
<tr>
<td></td>
<td>Deposition rate [kg/h]</td>
<td>6.5</td>
<td>15.0</td>
</tr>
<tr>
<td></td>
<td>Welding speed [cm/min]</td>
<td>42</td>
<td>65</td>
</tr>
<tr>
<td></td>
<td>Heat input [kJ/cm]</td>
<td>23.0</td>
<td>16.0</td>
</tr>
</tbody>
</table>

**COST STUDY FOR 10 000 METERS OF WELD**

<table>
<thead>
<tr>
<th>CONSUMABLE COST</th>
<th>Weld metal cost [€]</th>
<th>187 000</th>
</tr>
</thead>
<tbody>
<tr>
<td>PRODUCTION COST</td>
<td>Welding time [h]</td>
<td>6 692</td>
</tr>
<tr>
<td></td>
<td>Time saving [h]</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Labour cost* [€]</td>
<td>401 538</td>
</tr>
<tr>
<td></td>
<td>Labour saving [€]</td>
<td>-</td>
</tr>
<tr>
<td>TOTAL COST</td>
<td>Total cost [€]</td>
<td>588 588</td>
</tr>
<tr>
<td></td>
<td>Total cost saving</td>
<td>-39%</td>
</tr>
</tbody>
</table>

* AC = 50 Hz, 25% balance, -25% offset
**LINCOLNWELD® 860 / L-61 WIRE COMBINATION**

**CVN IMPACT**

<table>
<thead>
<tr>
<th>Deposition rate [kg/h]</th>
<th>E Kj/cm</th>
<th>Elongation (%)</th>
<th>Yield [N/mm²]</th>
<th>Tensile [N/mm²]</th>
<th>Impact ISO-V(J) -20°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>DC+ *</td>
<td>6.5</td>
<td>23</td>
<td>28</td>
<td>430</td>
<td>510</td>
</tr>
<tr>
<td>LSO AC</td>
<td>15</td>
<td>16</td>
<td>30</td>
<td>462</td>
<td>526</td>
</tr>
</tbody>
</table>

**DEP. RATE**

+130%

**CVN IMPACT -20°C**

SIGNIFICANTLY IMPROVED

* typical
QUALITY AND SAFETY

- High quality welding results
- Excellent bead appearance
- Highest deposition rates
- Deep penetration
- Increased productivity
- WPS development

POWER WAVE® SOFTWARE SOLUTIONS
ACCESS TO MONITORING THE WELDING PROCESSES. ANYTIME. ANYWHERE.

WELDSCORE™
Enhance Your Product Quality
- An integrated weld quality system that can assist quality assurance initiatives

POWER WAVE® MANAGER
Control Your Process
- All the information and settings necessary for welding and procedure control.

CHECKPOINT™
Weld Data Anywhere
- Store your data in the cloud and access it on almost any device.

INCREASE YOUR SAFETY LEVEL & REDUCE YOUR COST
BY SWITCHING TO BULK PACKAGING SOLUTION

WE PROVIDE THE COMPLETE INSTALLATION

- Turntable
- Pneumatic feed assist
- Drum lifter
- Mexican hat
- Hood
- Wire guides
- Wire straightener

350kg drum: 14 x less change over time vs 25kg coil

VISIT WEB PAGE
DOWNLOAD/UPDATE SOFTWARES

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Upgrade your Power Wave® Power Source Software for FREE
- Get access to the best welding solutions in the industry

COMMAND CENTER
Keep tracks of your developments and production welds

MOVE YOUR SUBMERGED ARC WELDING SOLUTION TO THE NEXT LEVEL
ONE COMPANY, ONE TEAM
MORE SOLUTIONS

- HIGHEST PRODUCTIVITY AND EFFICIENCY IN SAW
- MULTIPLE ARC UPGRADE WITH STANDARD EQUIPMENT STEP BY STEP
- CONTROLLED HEAT INPUT AND IMPROVED MECHANICAL PROPERTIES
- SAFEST WIRE DELIVERY SYSTEM FOR LARGE BULK PACKAGE

TOTAL SOLUTION FOR SUBMERGED ARCWELDING

CUSTOMIZED AUTOMATION

OUTSTANDING PROCESS EXPERTISE

MAXIMIZE YOUR WELDING TIME

THE BEST FLUX/WIRE PORTFOLIO

LOCAL PROCEDURE DEVELOPMENT

HIGH END EQUIPMENT AND ACCESSORIES

HIGHEST PRODUCTIVITY AND EFFICIENCY IN SAW
MULTIPLE ARC UPGRADE WITH STANDARD EQUIPMENT STEP BY STEP
CONTROLLED HEAT INPUT AND IMPROVED MECHANICAL PROPERTIES
SAFEST WIRE DELIVERY SYSTEM FOR LARGE BULK PACKAGE
BEING PRESENT LOCALLY
MAKES US MORE AWARE GLOBALLY

CUSTOMER ASSISTANCE POLICY
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