



MAW-27
Argon Welding Machine

Operation Guide

SUZHOU INDUSTRIAL PARK MATE AUTOMATION

TECHNOLOGY CO.,LTD

www.suzhoumate.com

Thanks for using our products. Before use, please read this menu carefully and keep it for future reference. Thanks for your understanding if there's any discrepancies between the manual and practical operation process due to technical update ceaselessly.



Company brief

Suzhou Industrial Park Mate Automation Technology Co., Ltd. is a metallic gasket and equipment manufacturing and selling company. We are located in Suzhou - a city well known for its Chinese classic garden, south of Jiangsu Province, China. With our technology, we offer our customer very wide variety of metallic gasket equipment, such as

Spiral wound gasket machine;

Kammprofile machine;

Guide rings grooving machine;

Inner ring Chamfering machine;

Bend & weld machine;

Laser marking machine;

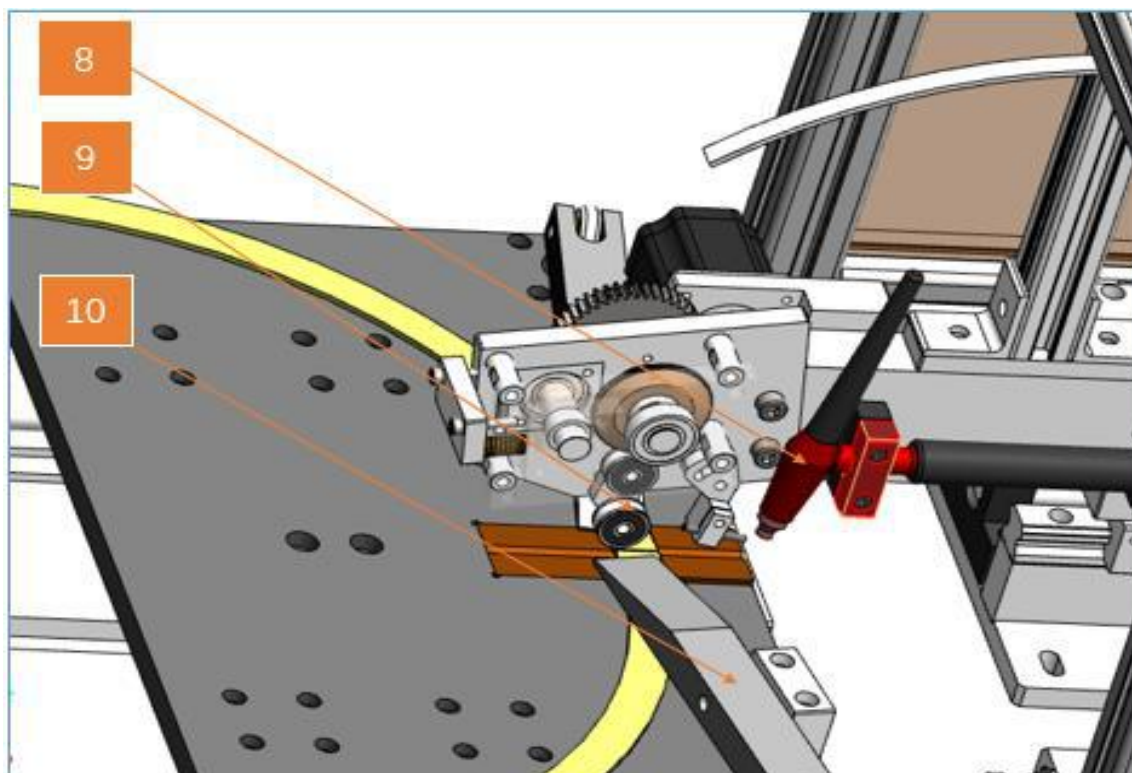
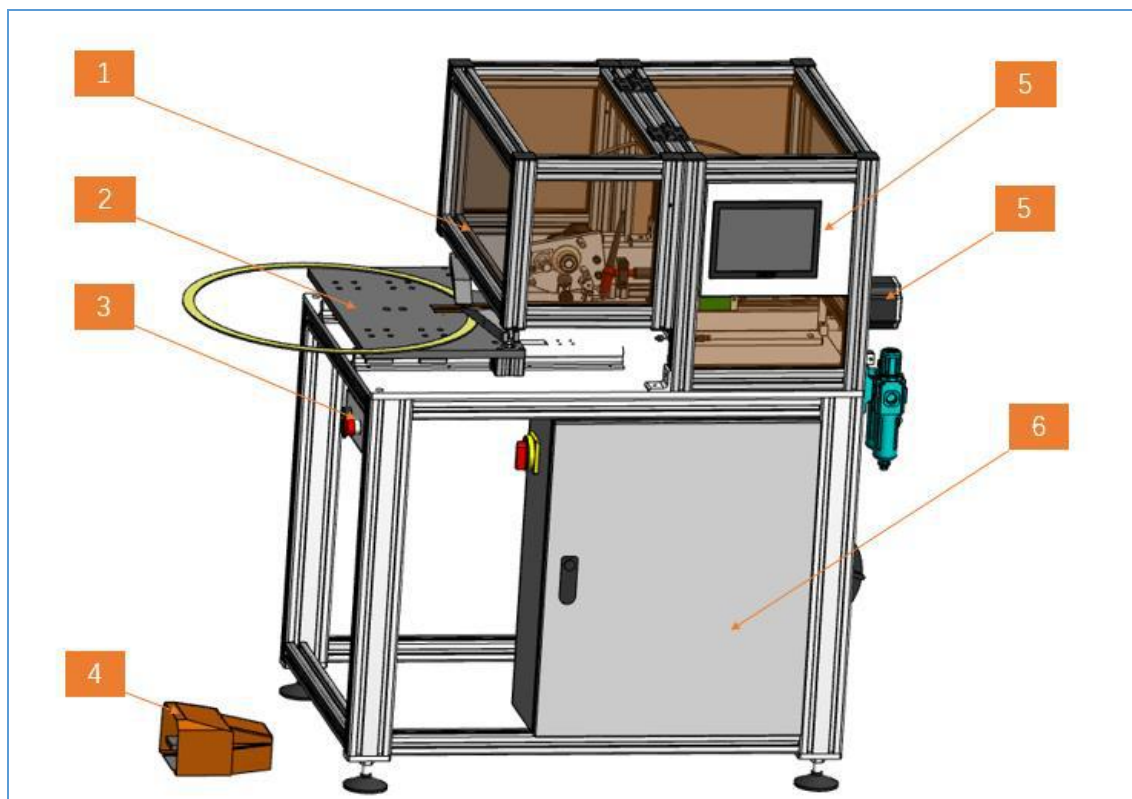
as well as computer controlled compression tester.

Our concept is to provide our customers with one-stop service for all metallic gasket related products, parts, and equipment. We have successfully sold our products and equipment to customers in the Asia India USA Europe and South America.

We welcome all customers from abroad and home.



MAW-27 Argon Welding Machine (Pic1)





(Machine details)

1. Hard light cover --- This cover is protect the eye during welding process, also it can be open when maintenance is under taking.
2. Sliding plate --- It can move into welding position, and move back to position where operator can load the ring easily.
3. Start button & Emergency button --- Press start button to trigger the automatic welding process, Emergency switch is safe button for stop the machine in case emergency occur.
4. Foot switch --- It controls the clamp and release the ring.
5. HIM --- Interface shows all parameter setting.
6. Step Motor --- controls welding head move forward and back.
7. Electronic cabinet
8. Welding head
9. Clamp --- Controlled by foot switch, clamp and release the ring.
10. Wire feeding head --- Controls wire feed length and feeding speed during process.

Machine Specification

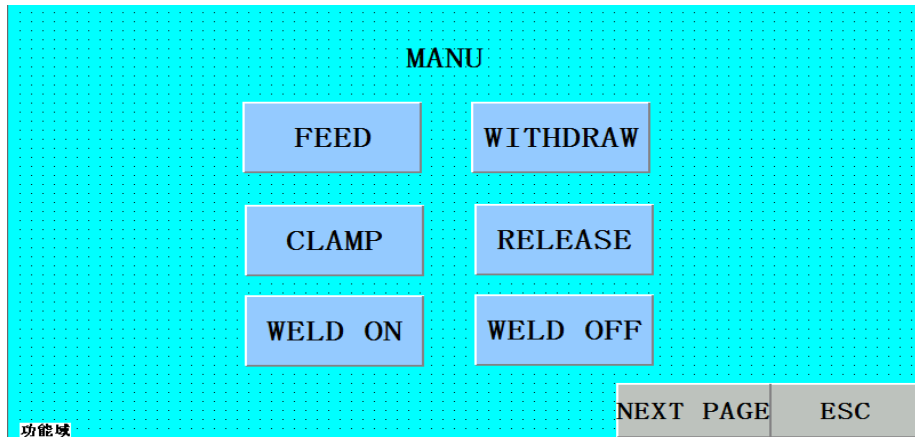
Type	MAW-27
Profile	1130*620*1460mm
Net weight	260KG
Power	2 KW
Voltage	220V
Max Welding thickness	3 mm
Max flange width	50 mm
Suitable material	SS
Argon Pressure mini	0.5 Mpa
Welding current	100-120 Amp

Machine main features

1. MAW-27 Argon arc welding machine is a semi-automatic welding machine, no need for specific welding skill, all need to do is load the ring and unload when job finish, make ring welding an easy job.
2. It needs weld only one side, one single process.
3. It can weld both stainless steel and carbon steel by adjusting the parameter settings.

Machine set up

1. Connect cable to power. 380V 3 phase.
2. Connect air pipe to compressed air source.
3. Turn on power, the interface will show the manual page as following pic,



FEED--- Feed the wire forward

WITHDRAW--- Withdraw wire back

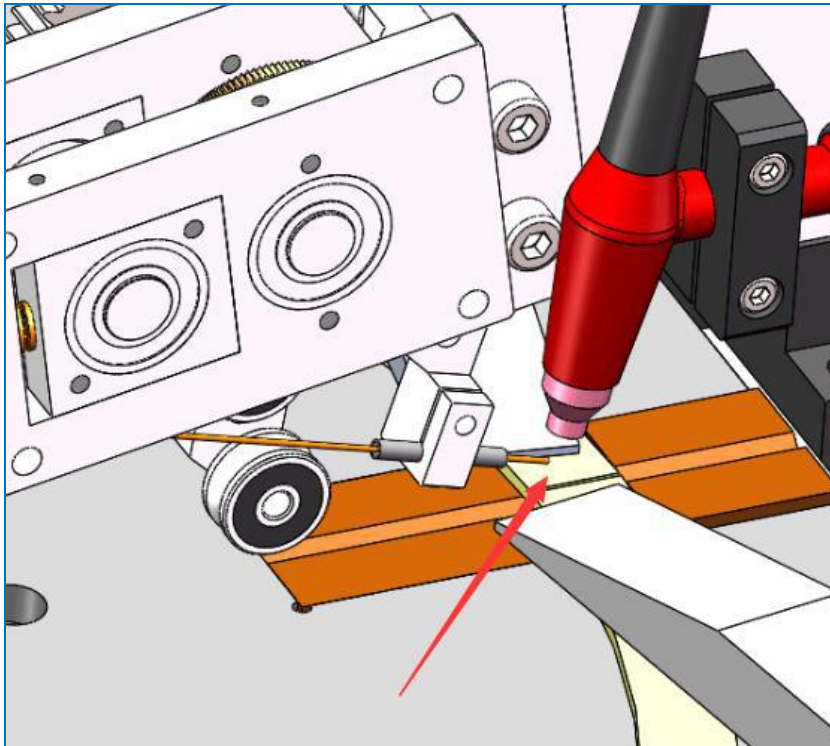
CLAMP--- Clamp the ring controlled by foot switch

RELEASE--- Release the ring also controlled by the foot switch

WELD ON--- Weld head power on

WELD OFF--- Weld head power off

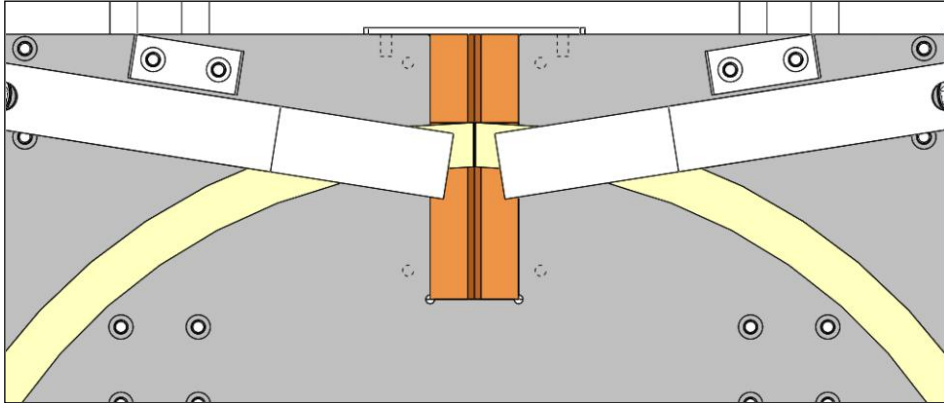
4. Use the manual control to feed the wire close to welding head as follow pic,



5. Press “auto” the machine switch to automatic work mode.

Machine operation

1. Load the bended ring into welding base plate; make the two joints line up see the pic below, then press the foot switch to clamp it. Leave a small gap for the two ends, around 1mm as per our experience.



2. Press the start button, the sliding plate will be push into the weld position, and then the welding head move forward and start welding automatically.
3. After welding finished, the sliding plate will move back, press the foot switch, clamp release, and take the ring out.
4. Load a new bended ring, and repeat the process above.

Tips, 1.The heat parameter setting for stainless steel is 110, while for carbon steel, parameter setting is 130. Adjust it by the tuner.



2. Use the same material wire, thickness 0.8mm-1.2mm, no greater than 1.2mm.

Safe Instruction



SUZHOU INDUSTRIAL PARK MATE AUTOMATION TECHNOLOGY CO.,LTD
ADD: BUILDING 15-1 PUTIAN PRIVATE INDUSTRIAL ZONE WEITING SIP JIANGSU 215122
TEL: 0086-512-6285 0086 FAX: 0086-512-6285 0087

1. Do not see straightly to the welding hard light during the entire welding process.

2. Do not touch the welding wire during welding process.

3. Do not open electronic box when electrician is absence.

END