



AUTOMATED MANUFACTURING SYSTEMS

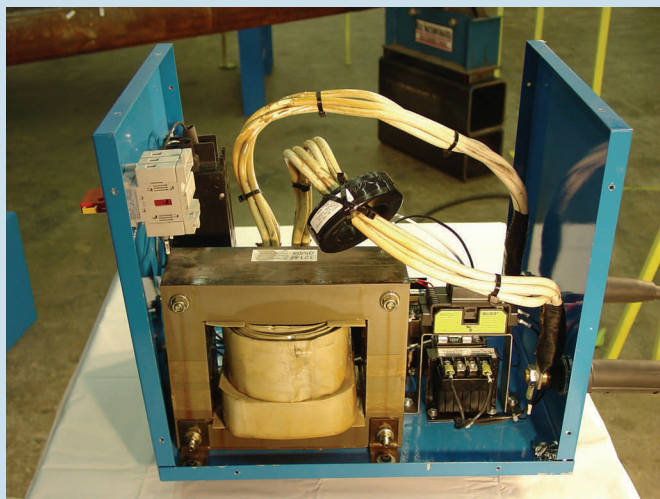


"Your Single Source for Engineering,

Process, Machine & Controls"

ARC-"Hot-One" GTAW Hot Wire Power Supply

- Hot wire Gas Tungsten Arc Welding (GTAW) is a variation on standard GTAW
- A second power supply is connected between a wire contact tube (similar to a GMA torch) and the work piece
- The wire is fed into the weld puddle immediately behind the arc
- Normally a AC constant voltage power supply is used. This minimizes magnetic interference (arc blow) of the main GTA arc
- The hot wire power supply electrically resistance heats the wire before it reaches the puddle
- This preheating allows higher deposition rates and/or lower dilution rates
- Deposition rates up to 16 pounds per hour have been achieved in the flat position. 3 pounds per hour are typical in the 2G (horizontal) position
- At ARC Specialties we have recently developed a solid state hot wire power supply
- HOT-ONE is a compact unit measuring 12 x 15 x 16" weighing 95 pounds
- Input power is 230/480 VAC single phase, 60 Hz
- Output is 0-15 VAC constant voltage
- Rated at 150 amps 100% duty cycle
- Output voltage is controlled using an external 0-10 VDC signal or an optional front panel knob



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ARC- "Hot One" Power Supply