



# WELD HEADS

## FOH 8-40 / 10-76 / 20-114 / 40-168

/ TIG Orbital welding with or without filler wire



/ Open weld heads for mechanized TIG Orbital welding of tube connections (outer diameter 8 - 168 mm / 0.31 - 6.61 in) made of steel, stainless steel, titanium, austenite nickel-chromium-based superalloys, aluminum and other materials in application areas: energy, biochemical industry, food industry, shipbuilding, aerospace and aeronautics etc...

### FEATURES

- / FOH weld head including up to 2 sets reducer jaws (depending on weld head type)
- / Integrated servomotor
- / Automatic drive to opening position
- / Free definable starting position
- / Automatic drive stop when overloaded
- / Stepless adjustable clamping-/centering system for quick adaptation to different tube diameters
- / Mechanical tube tracking for constant electrode distance
- / Torch bracket 0 - 45° stepless swivelling
- / Manual side adjustment of the electrode
- / Swivelling torch holder with fixation
- / Plugable control line 6 m (236.22 in)
- / Orbital welding torch with insulated torch body and high duty cycle

- / Ideal gas protection to avoid coloration
- / Torch with comfortable wear part changing system
- / Transport case with trolley-system

### ACCESSORIES

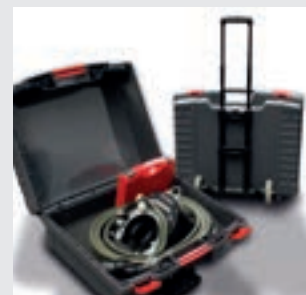
- / Orbital welding torch TTGO F++/ 5 m (196.85 in)
- / Orbital welding torch TTWO 2000 F++/ 5 m (196.85 in) (not useable with FOH 8-40)
- / Wear part box for torches
- / Extension hose pack FCH / FOH 10 m (393.70 in)
- / Wire feeder KD 4000 D-11
- / 2-axis wire adjustment
- / Wire feeding (wire-Ø 0,8 - 1,2 mm / 0.03 - 0.05 in)
- / Balancer spring return
- / Orbital system controller FPA 3020/3030



/ Wire feeding, torch bracket from 0 - 45° stepless swivelling



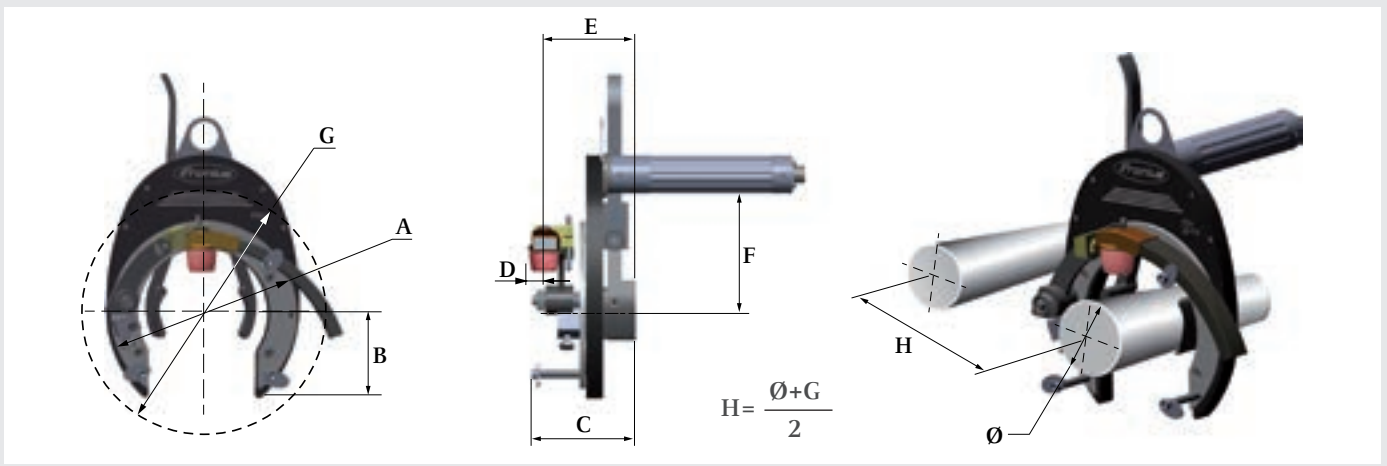
/ Reducer jaws depending on tube outer diameter



/ Transport case with trolley



/ Wire feeder KD 4000 D-11



ORBITAL WELD HEAD	FOH 8-40	FOH 10-76	FOH 20-114	FOH 40-168
Tube outer-Ø	8 - 40 mm (0.31 - 1.57 in)	10 - 76 mm (0.39 - 2.99 in)	20 - 114 mm (0.79 - 4.49 in)	40 - 168 mm (1.57 - 6.14 in)
A	90 mm	142 mm	200 mm	300 mm
B	40 mm (1.57 in)	64 mm (2.52 in)	90 mm (3.54 in)	134 mm (5.28 in)
C	95 mm (3.74 in)	108 mm (4.25 in)	111 mm (4.37 in)	111 mm (4.37 in)
D	7 mm (0.28 in)	7 mm (0.28 in)	7 mm (0.28 in)	10 mm (0.39 in)
E	77 mm (3.03 in)	91 mm (3.58 in)	91 mm (3.58 in)	91 mm (3.58 in)
F	66 mm (2.56 in)	90 mm (3.54 in)	130 mm (5.12 in)	185 mm (7.28 in)
G max.	120 mm (4.72 in)	230 mm (9.06 in)	260 mm (10.24 in)	400 mm (15.75 in)
Net weight (without hose pack)	1,87 kg (4.12 lb)	2,39 kg (5.27 lb)	3,97 kg (8.75 lb)	6,96 kg (15.34 lb)

ORBITAL WELDING TORCH	TTGO	TTWO
Duty cycle	DC 100% 60 A DC 60% 80 A DC 35% 100 A	DC 100% 200 A AC 100% 140 A
Electrode-Ø	2,4 / 3,2 mm (0.09 / 0.13 inch)	2,4 / 3,2 mm (0.09 / 0.13 inch)
Cooling	Gas	Water
Net weight hose pack	1,9 kg (4.19 lbs)	1,9 kg (4.19 lbs)

WIRE FEED	KD 4000 D-11
Wire speed	0,1 - 11 m (3.94 - 433.07 in) /min
Wire drive	4-rolls drive
Standard: Feed rollers Optional: Range of wire-Ø	1,0 H Profi 0,8 - 1,2 mm (0.03 - 0.05 in)
Wire coils-Ø	max. 300 mm (11.81 in)
Wire coil weight	max. 16 kg (35.27 lb)
Type of wire coils	all standardized coils
Dimensions l/w/h	650 x 290 x 410 mm (25.59 x 11.42 x 16.14 in)
Weight	15,7 kg (34.61 lb)



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