

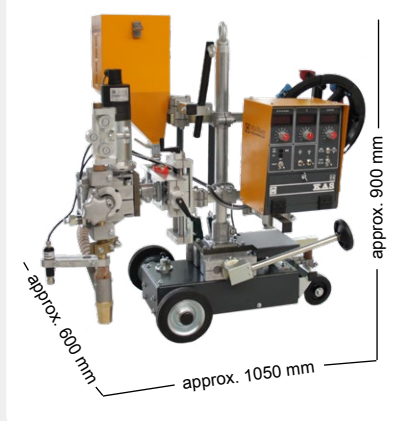


Kjellberg®

FINSTERWALDE

SUBMERGED ARC WELDING

WELDING AUTOMAT STEERABLE



KA 1-UP 5 mm steerable

Application: Submerged arc single-wire welding and cladding, especially of circumferential welds in pipes

Welding wire: 2.5 - 5.0 mm

Article no.: .11.303.105.N

Alternatives:

KA 1-UP 3 mm .11.303.103.N

KA 7-UPP .11.303.700.N (double wire)

Advantages

- ✓ Mobile, self-propelled welding automat, which easily can be moved to any working place
- ✓ Especially suitable for welding inside of conical tubes from approx. 1500 mm Ø
- ✓ Easy control by pre-set controls for welding current, arc voltage and travel speed in connection with Kjellberg power sources
- ✓ Start and stop circuit for optimising the welding process
- ✓ Start and crater filler parameters to adjust separately
- ✓ Exact positioning of the welding head with cross slides in horizontal and vertical direction
- ✓ Reliable wire feed
- ✓ Encoder controlled tractor with all-wheel drive (rubber rims)
- ✓ Dust-protected manual drive coupling
- ✓ Control elements on two service levels
- ✓ Quick adaptation to other process variant thanks of modular system (e.g. single wire to double wire)

Standard equipment

Carriage
Wire feeder
Laser pointer
KA control
Flux hopper



Robust feeding gear for wire up to Ø 5,0 mm

Options

Flux recovery unit
Rails



KA 1-UP 5 mm as steerable version

Kjellberg is certified acc. to
DIN EN ISO 9001

Technical data	KA 1-UP 3 mm	KA 1-UP 5 mm	KA 7-UPP
Article no.	.11.303.103.N	.11.303.105.N	.11.303.700.N
Welding current max.	800 A	1200 A	1200 A
Wire diameter	1.6 - 3.0 mm	2.5 - 5.0 mm	2x 2.0 - 2x 3.0 mm
Wire feed speed	0.1 - 10 m/min	0.1 - 6.5 m/min	0.1 - 10 m/min
Travel speed		0.1 - 1.5 m/min	
Cross/height adjustment		100/100 mm	
Column swivel range		360 °	
Welding head inclination		45 ° (to both sides)	
Mass KA+wire reel	61 kg + max. 30 kg	70 kg + max. 30 kg	72 kg + max. 2x 25 kg
Travel gauge		265 mm Option: 330 or 395	
Dimensions (L x W x H)	1110 x 560 x 940 mm	1050 x 600 x 900 mm	1050 x 600 x 900 mm
Control voltage		42 V AC/50 Hz	
Power sources (recomm.)		GTH 802, GTH 1202	

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