

Características técnicas:

Nº de referencia 44195

Tube Welding Line

Marca: DEMAG
 Modelo:
 Año de fabricación: 1988 used
 Reconstruida: 2022
 Control: PLC SIEMENS



Feedstock Steel Strip

Ancho de banda máx.:	450 mm
sheet width min.:	90 mm
Espesor máx.:	13 mm
Espesor mín. de fleje:	2 mm
exterior coil diameter max.:	1900 mm
exterior coil diameter min.:	1100 mm
internal coil diameter max.:	760 mm
internal coil diameter min.:	610 mm

Product (profile, tube)

external diameter min.:	30 mm
external diameter max.:	140 mm
wall thickness min.:	2 mm
wall thickness max.:	12 mm
Largo min.:	4000 mm
length max.:	10000 mm

Line Characteristics

Forming Process: rollforming
 welding process: HF inductive
 sawing process: travelling
 Velocidad máx.: 65 m/min
 Dirección de alimentación:
 Izquierda a derecha

Información adicional:

Line consists of:
 - Strip preparation MANNESMANN (YoM 1988, Retrofit 2022, Siemens S7-1500)
 - Blasting system GF HB-4/45-100 (YoM 1987, Retrofit 2021, Siemens S7-1200)
 - Core unit DEMAG RN140/170-L (YoM 1987, Retrofit 2012 Siemens S7-300/1200)
 - Roller press WINTER RATINGEN (YoM 1989)
 - Hot saw BENTELER (YoM 1988, Retrofit 2010, Siemens S7-300)
 - FollowUp processing MANNESMANN (YoM 1989, Siemens S5)
 - Baling press BOECKER VOLKENBORN SR800 (YoM 1988)

Line Specifications:

- Strip types: slit strip, cold strip
- max. yield strength: 650N/mm²
- max. tensile strength: 720N/mm²
- Belt sabre: 0.6% permissible deviation in relation to belt length
- alignment: center-line

Strip Preparation MANNESMANN:

- Twin decoiler incl. guide, shear, submerged arc welding system, strip loop
- 2022 Retrofit control system to Siemens S7-1500

Blasting System GF HB-4/45-100:

- 2022 Retrofit control system to Siemens S7-1200

Core Unit DEMAG RN140/170-L (forming unit, welding machine and calibrating unit):

- 2013-2022 various modernizations of the electrical engineering
- 2013 Renewal of HF generator Elotherm Eloweld 700
- 2012 pre-forming frames renewed
- 2011 roll forming unit renewed
- 2009 New emulsion system with Cymatec CN-5-50 magnetic separator
- Wall thickness range:
 - s = 2.0 - 12.7 mm, s/d = 1 : 7 to 1 : 70, yield strength max. 300 N/mm²
 - s = 2.0 - 10.0 mm, s/d = 1 : 8 to 1 : 60, yield strength max. 450 N/mm²
 - s = 2.0 - 9.0 mm, s/d = 1 : 9 to 1 : 50, yield strength max. 550 N/mm²
 - s = 2.0 - 8.5 mm, s/d = 1 : 10 to 1 : 40, yield strength max. 600 N/mm²
 - s = 2.0 - 8.0 mm, s/d = 1 : 10 to 1 : 35, yield strength max. 650 N/mm²
- max. HF power: 600 kW

Roller Press WINTER RATINGE:

- Force: 400 kN
- Stroke: 1000 mm

Hot Saw BENTELER:

- 2010 New protective cabin incl. air filter
- 2008 Retrofit control system to Siemens S7-300

- incl. Standby Saw Slide (BackUp, see ph

Further processing MANNESMANN:
 - incl. Milt chamfering system and Allweile system

- 2016 Retrofit chip shredder
- Speed of end machining heads: 135-130
- Diameter of small prism clamping basin:
- Diameter of large prism clamping basin:

Vendedor:

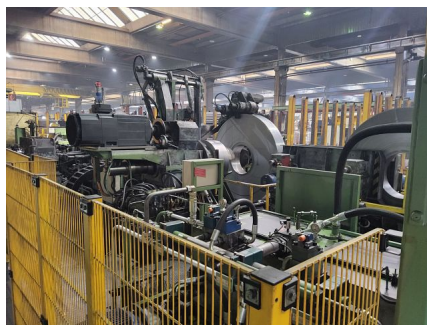
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Fotos y documentos

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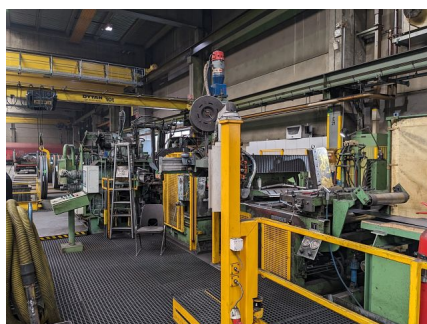
Bandanlage Übersicht



Bandanlage Hinten



Haspel



Bandanlage Ende



Bandanlage Übersicht 2



Band Stoss schweißen