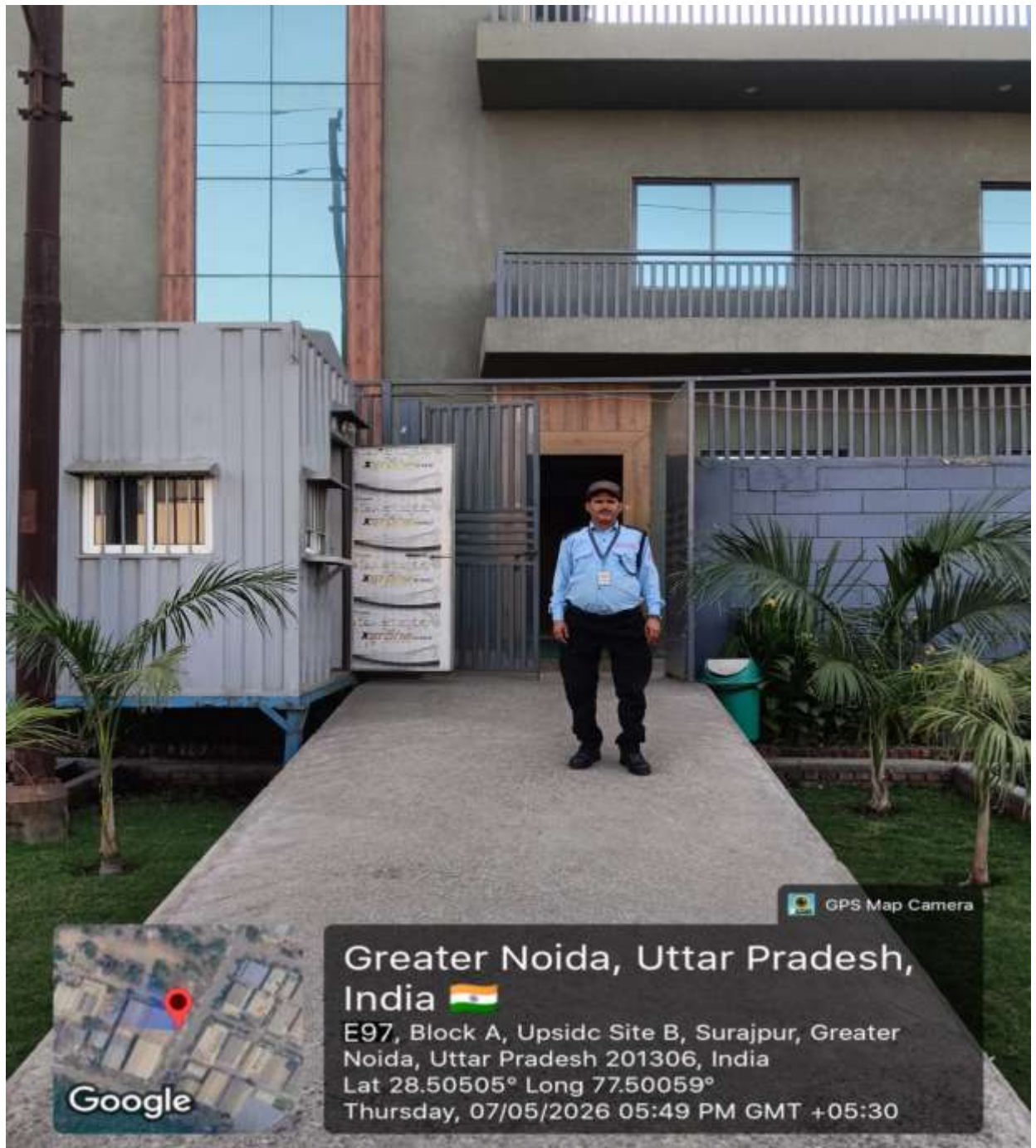


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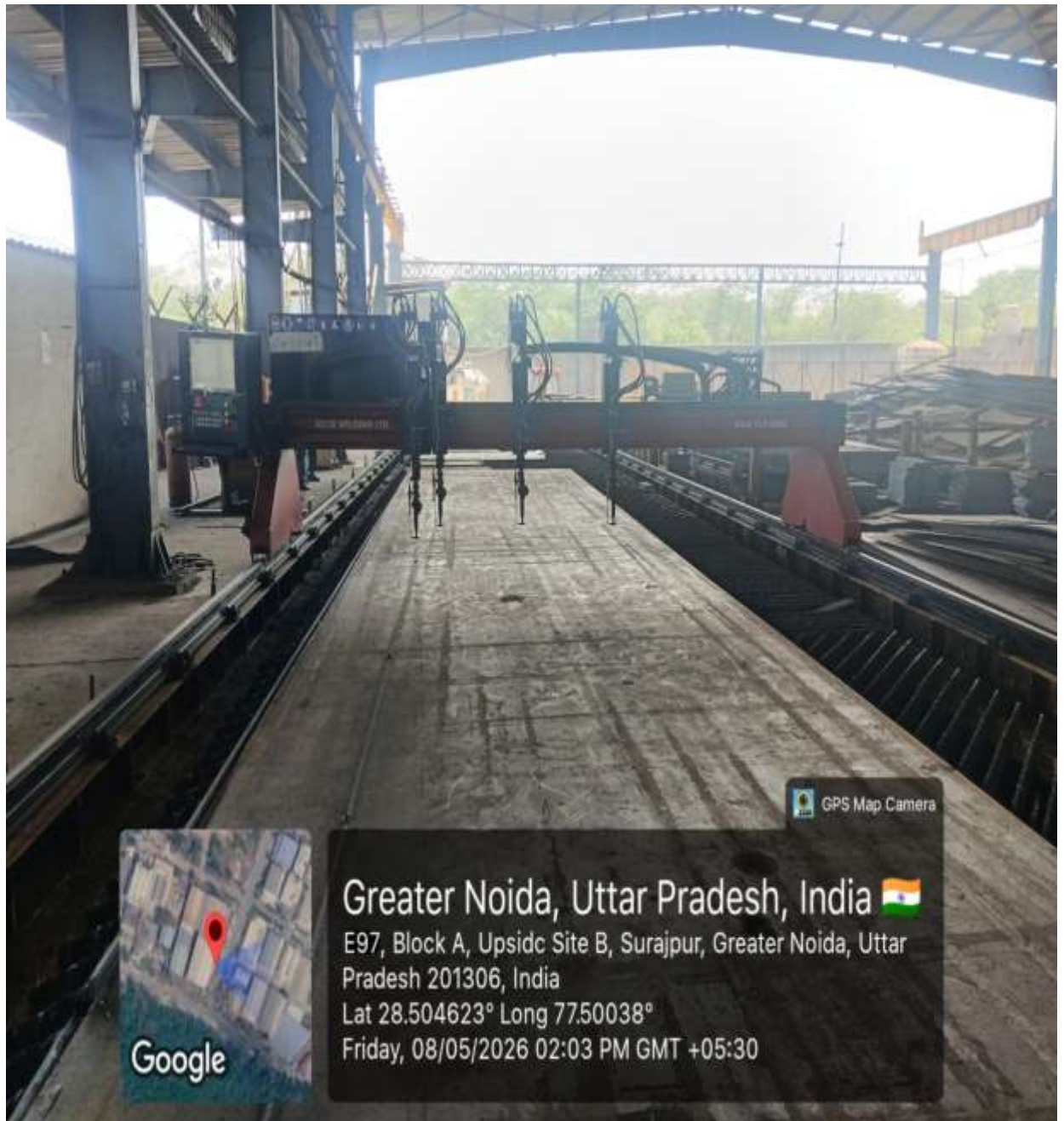


HEAD OFFICE



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CNC PROFILE CUTTING MACHINE



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CNC DRILLING MACHINE



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MILLING MACHINE



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RADIAL DRILLING MACHINE



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BROACH CUTTER MACHINE





AUTOMATIC SUBMERGED ARC BEAM WELDING MACHINE



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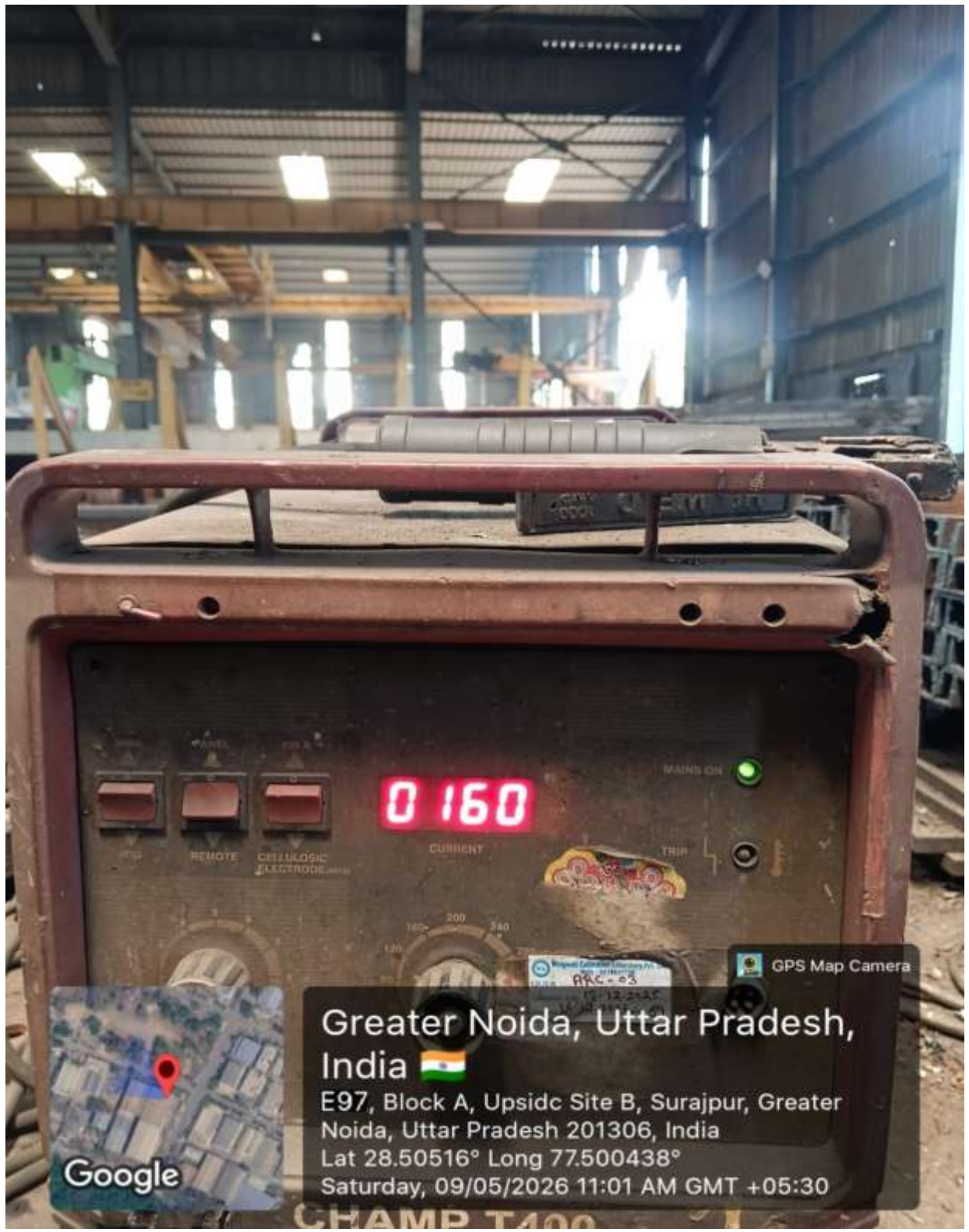


GMAW MACHINE



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MMAW MACHINE



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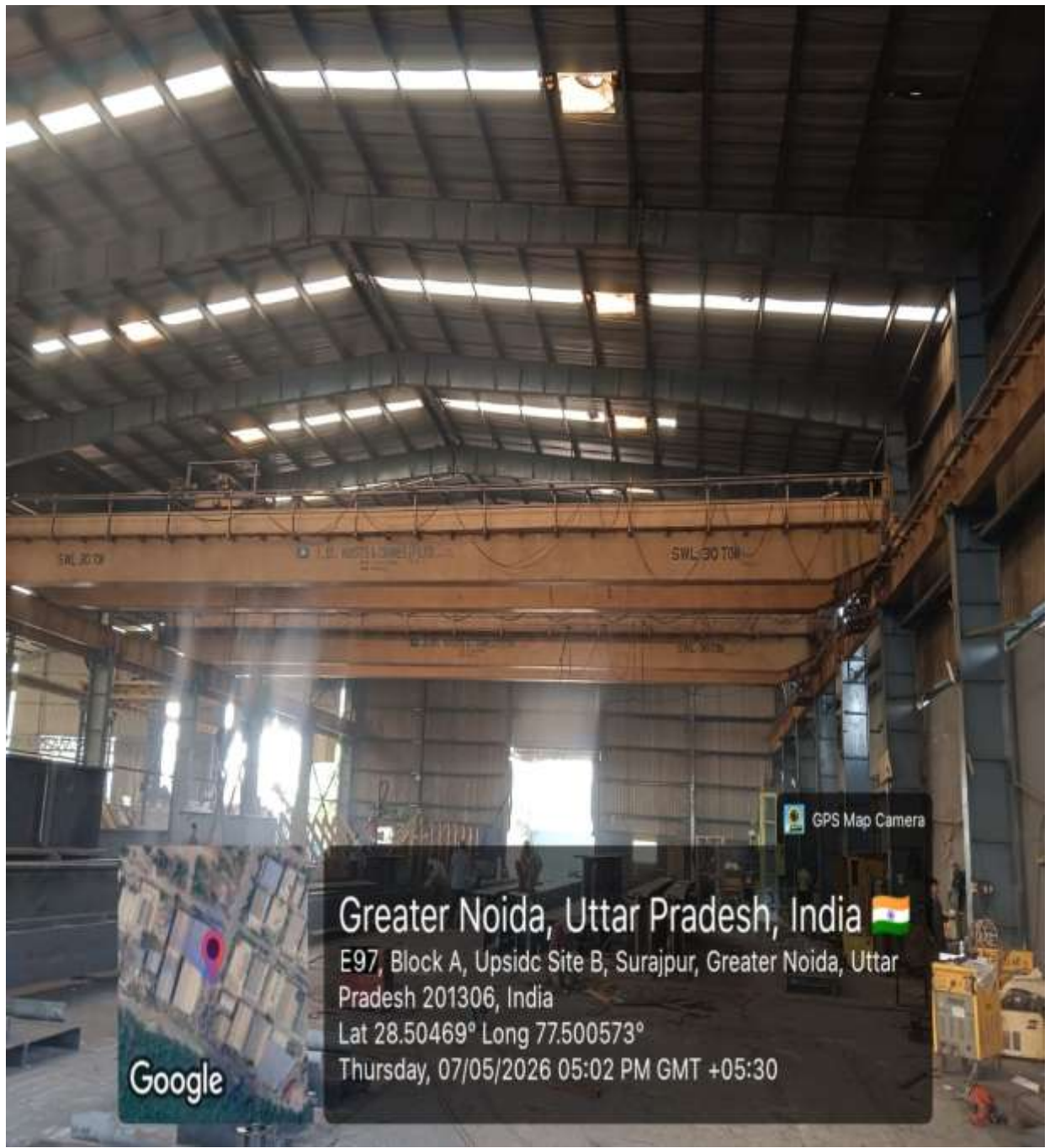


STUD WELDING MACHINE



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ELECTRIC OVERHEAD TRAVELLING CRANE



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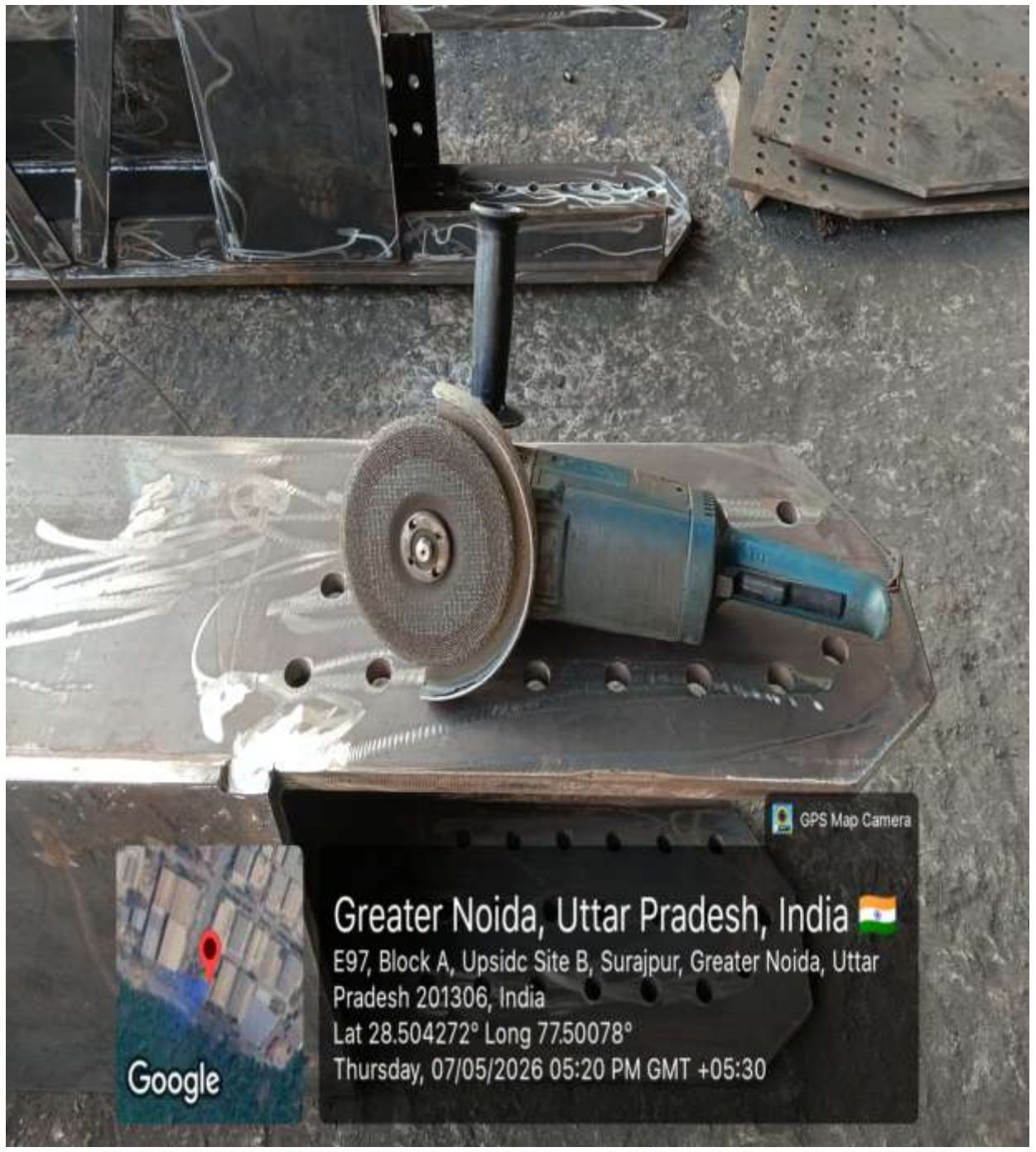


STRAIGHTNING MACHINE



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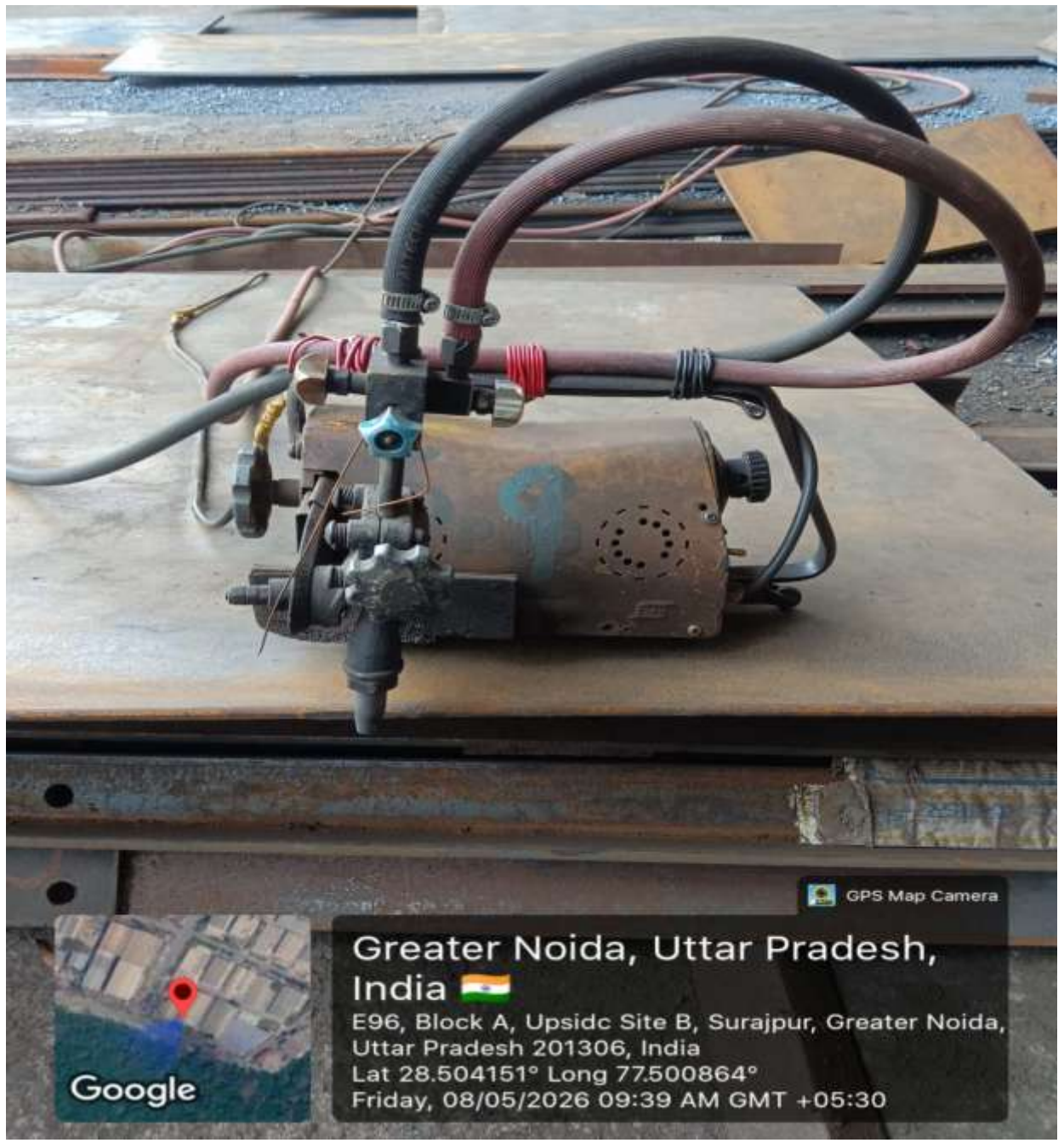


GRINDER



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PUG MACHINE



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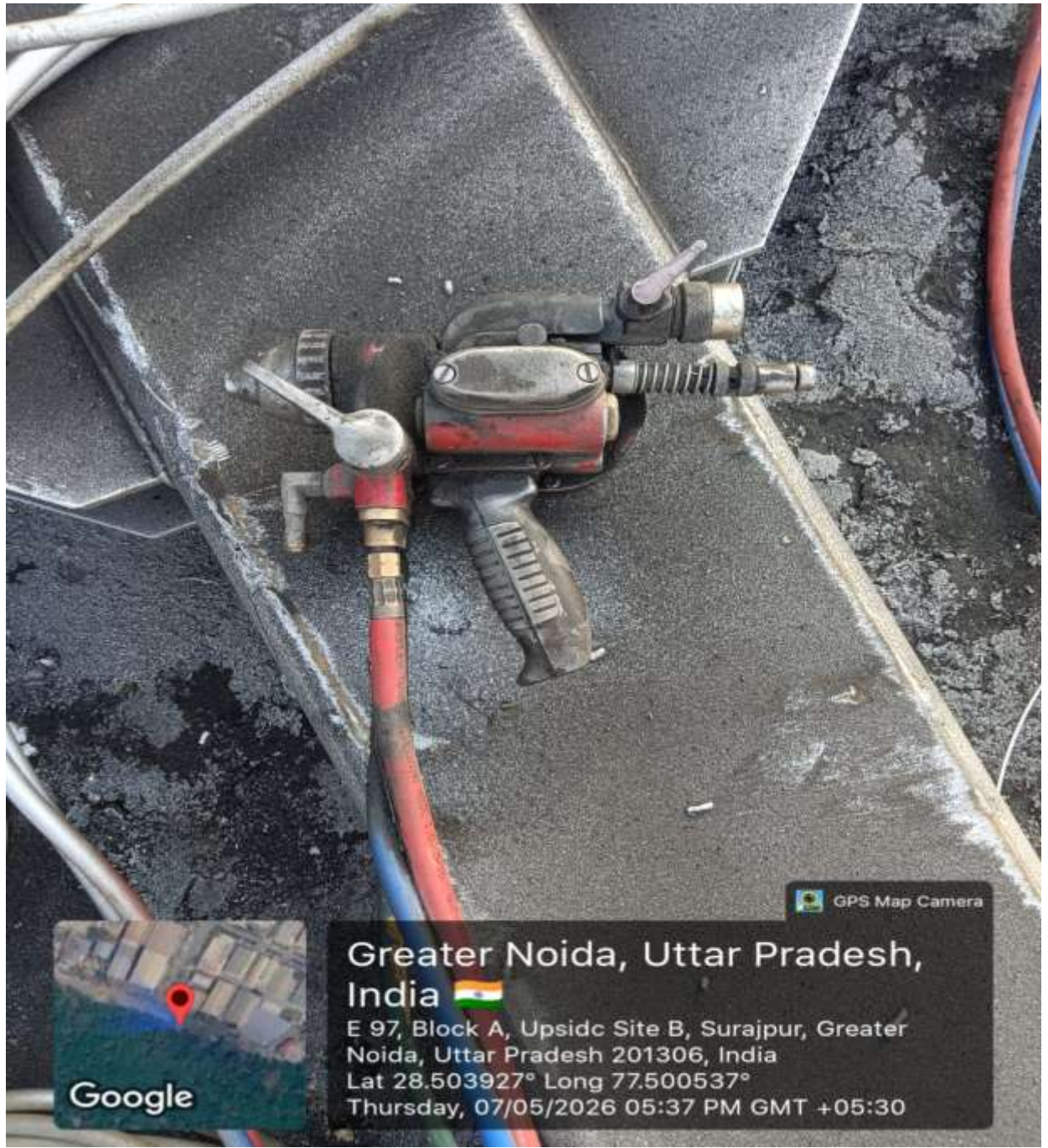


BALLASTING NOZZLE



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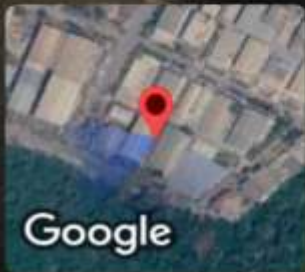
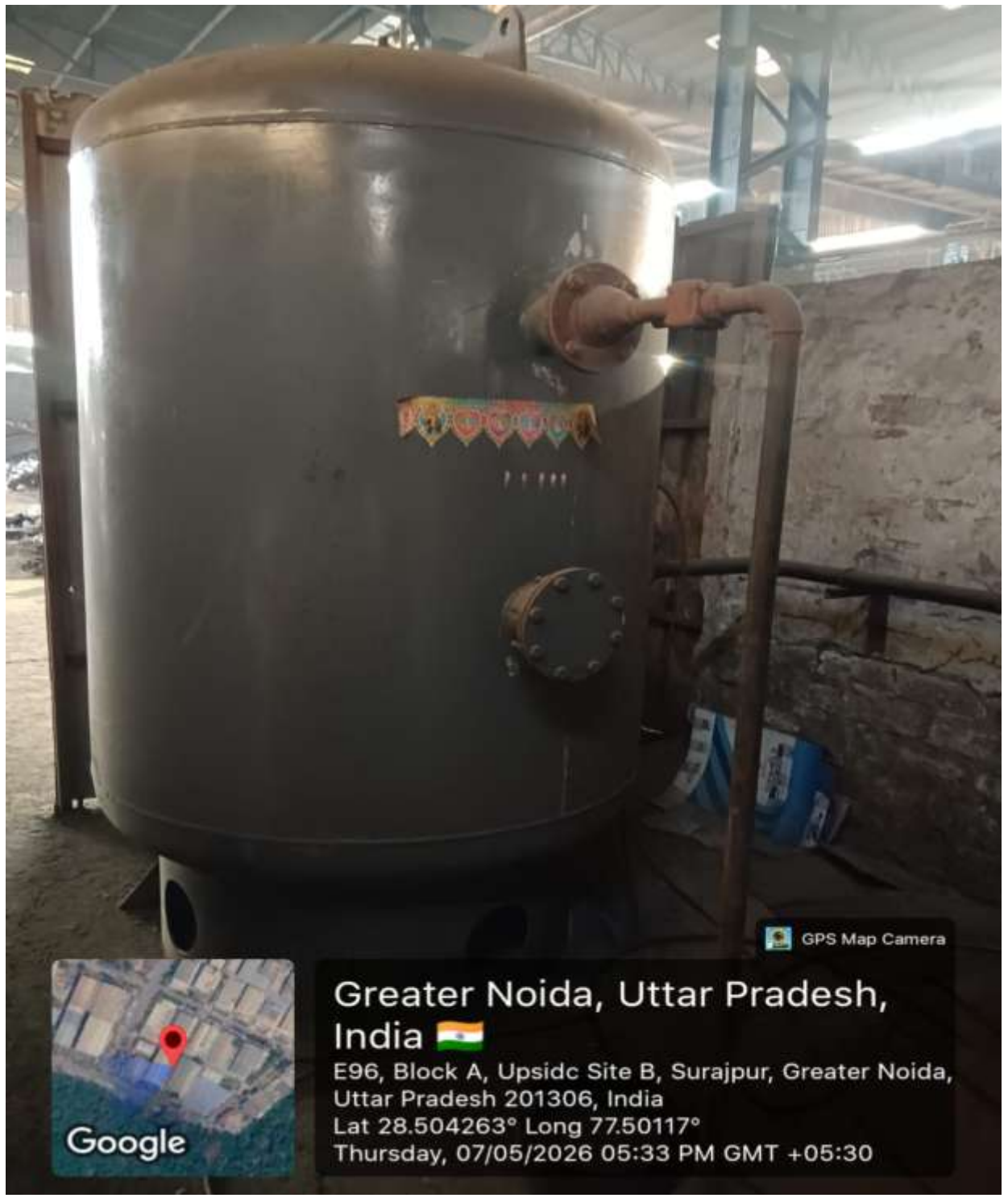


METALIZING GUN



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GPS Map Camera

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COMPRESSOR



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WRENCHES



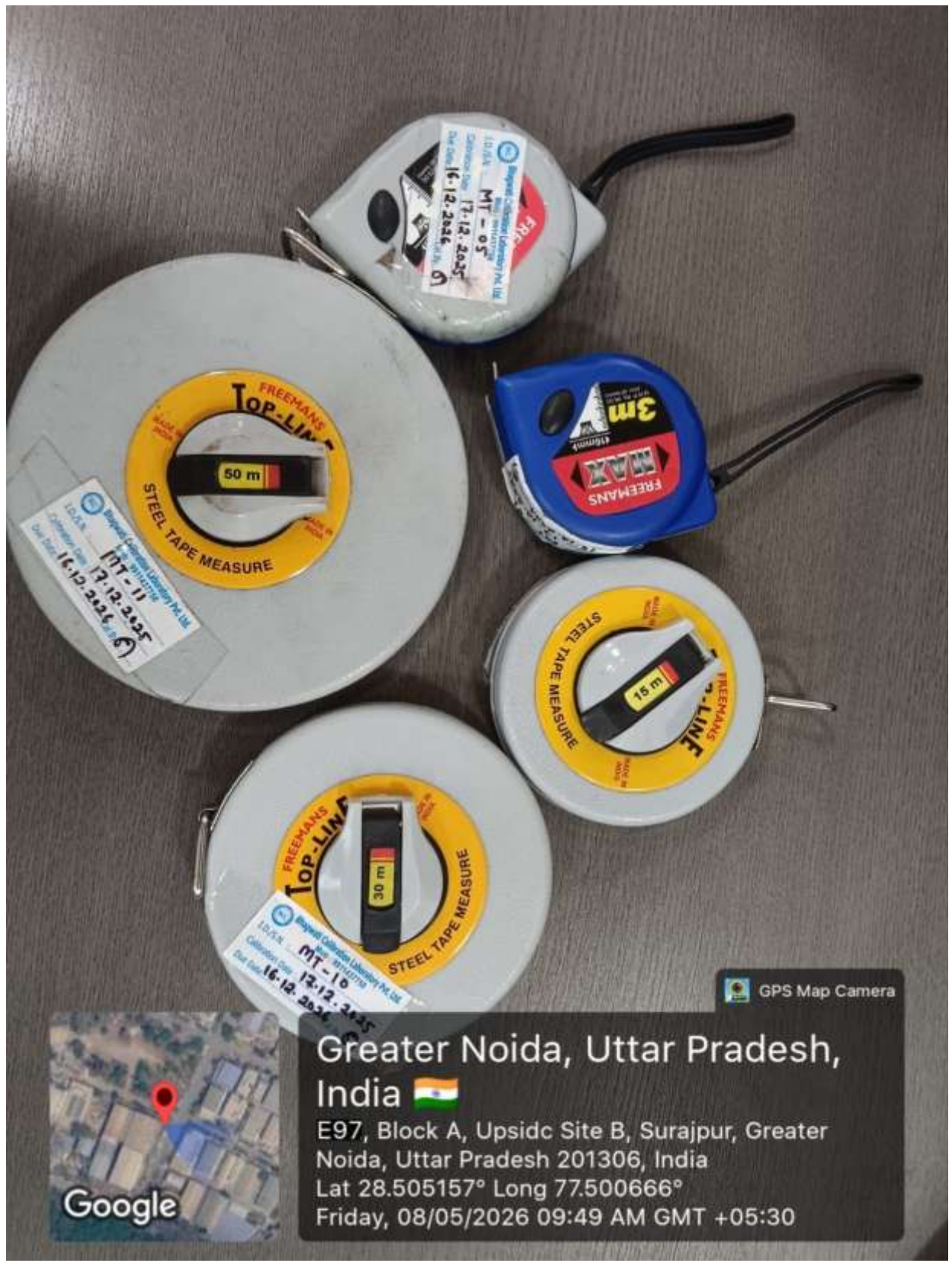
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ELCOMETER





STEEL TAPES

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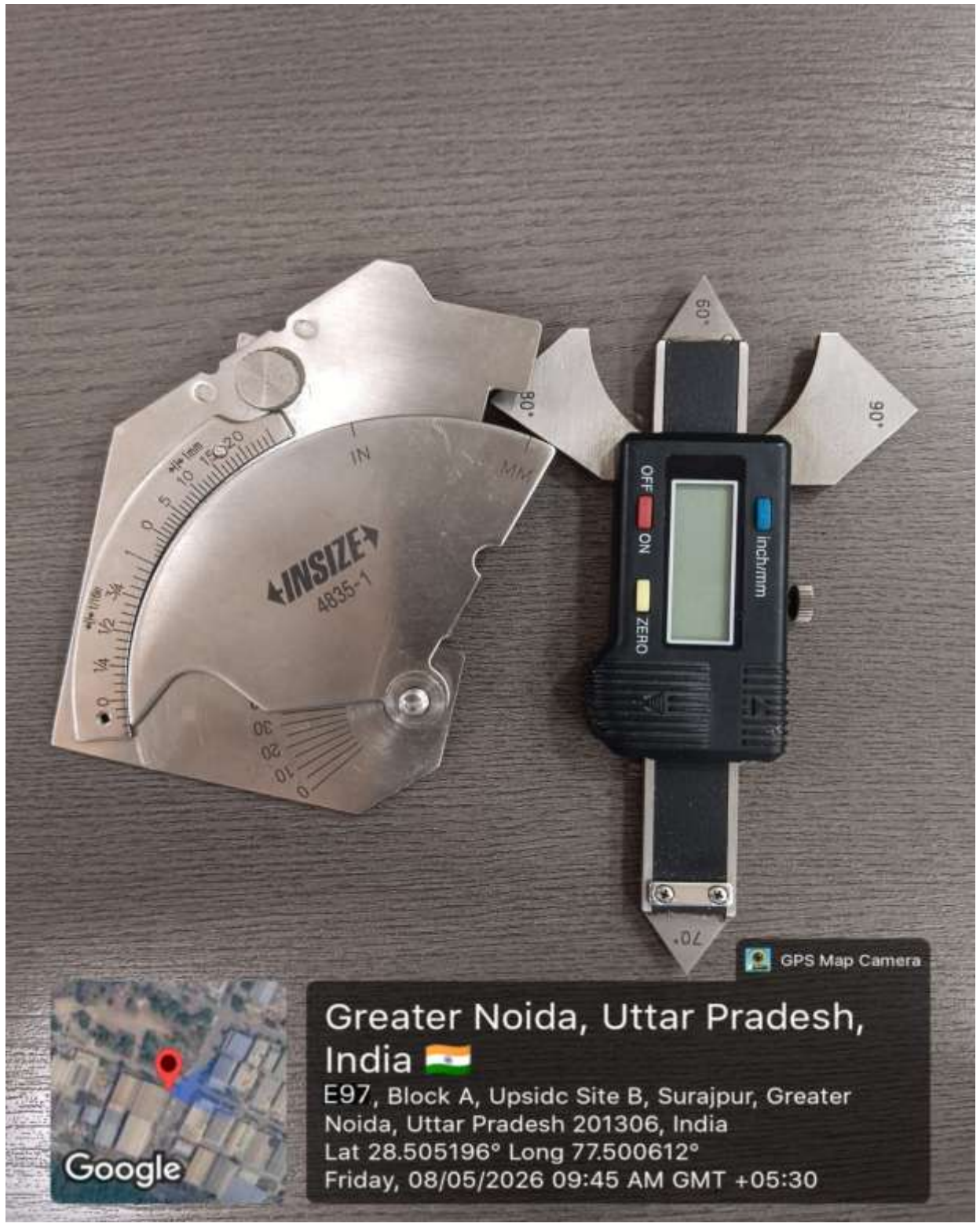
DUMPY LEVEL





DYE PENETRATION TESTING KIT

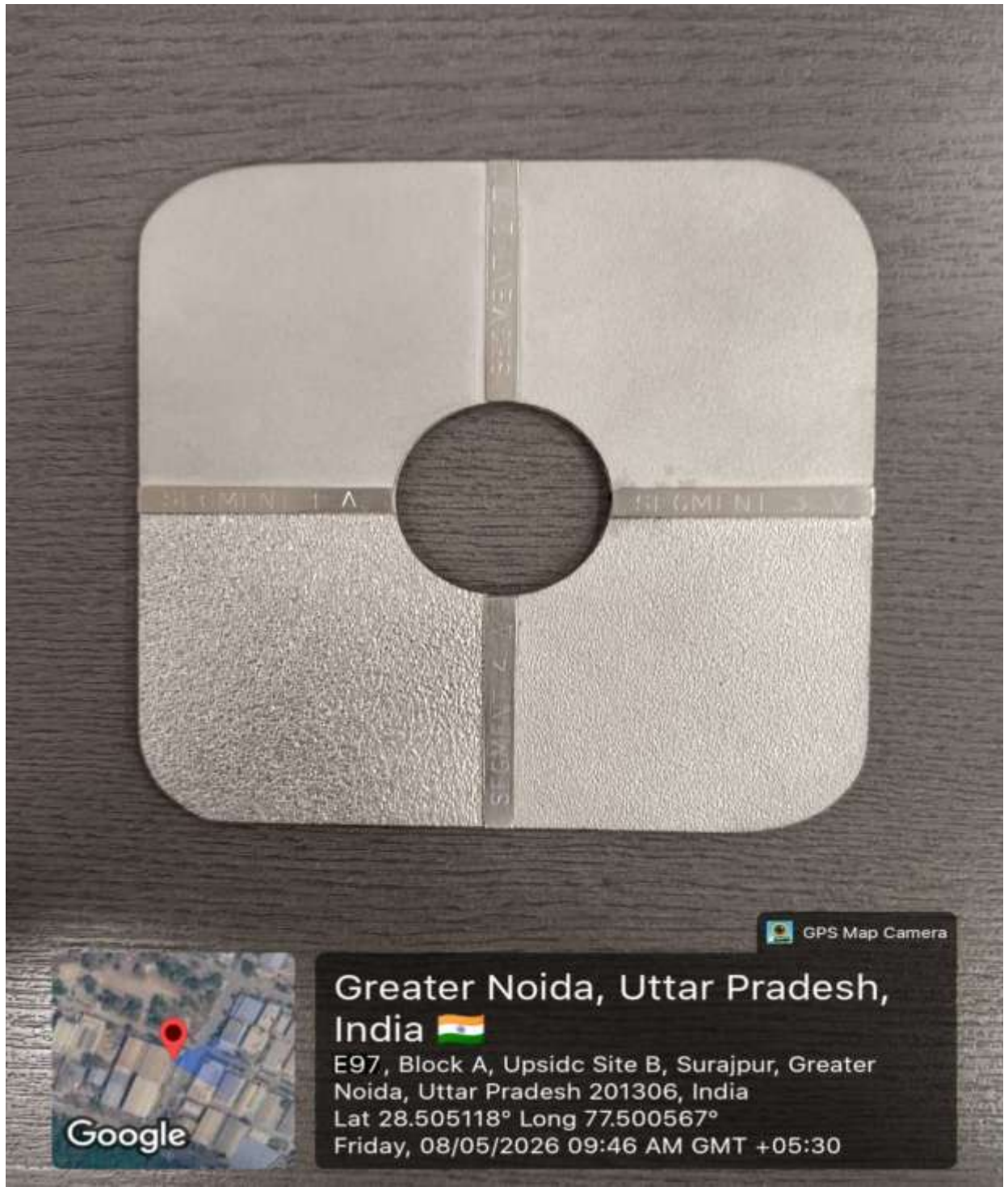




WELDING GAUGE

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COMPARATOR



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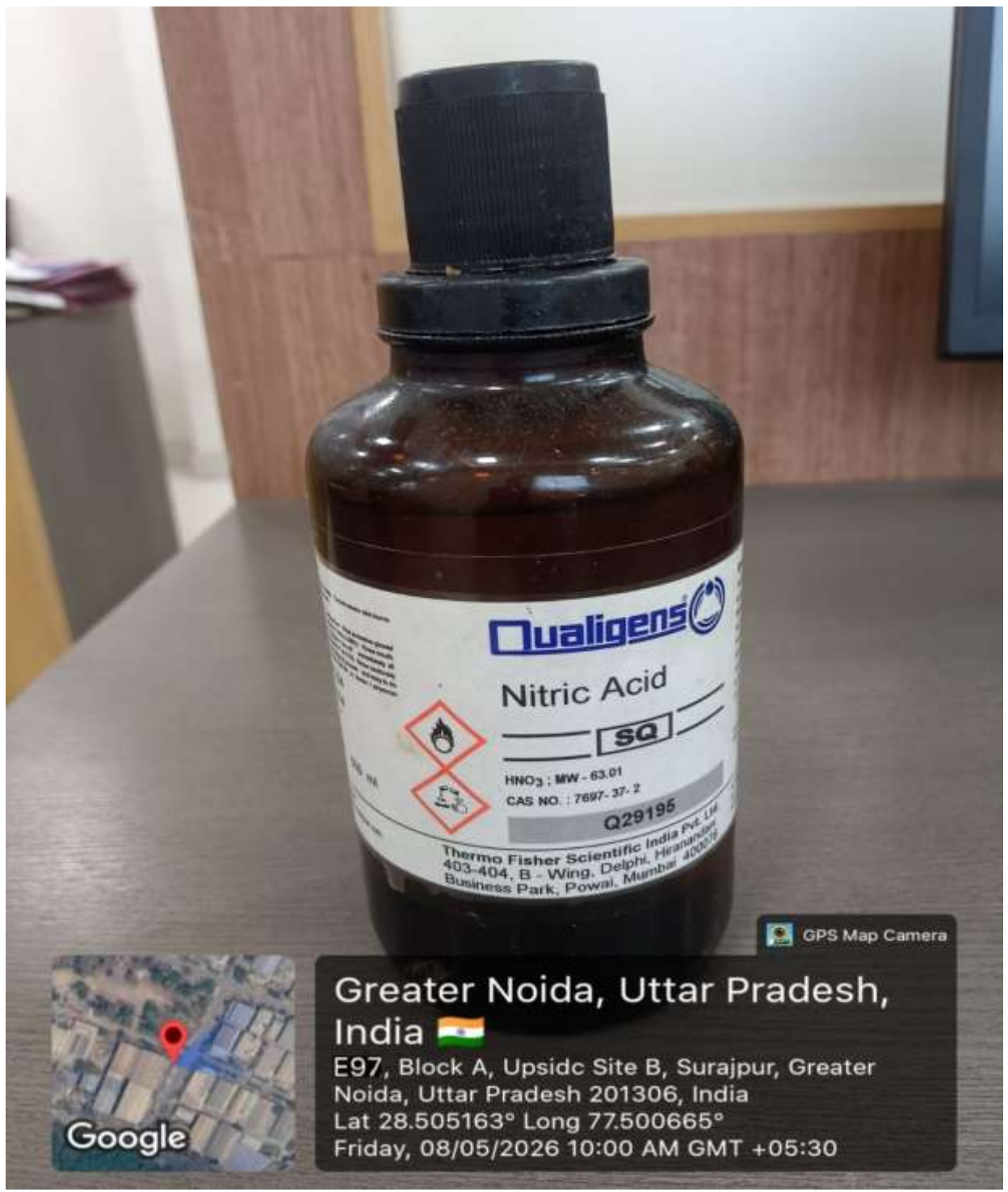


FEELER GAUGE



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MICRO-ETCHING SOLUTION



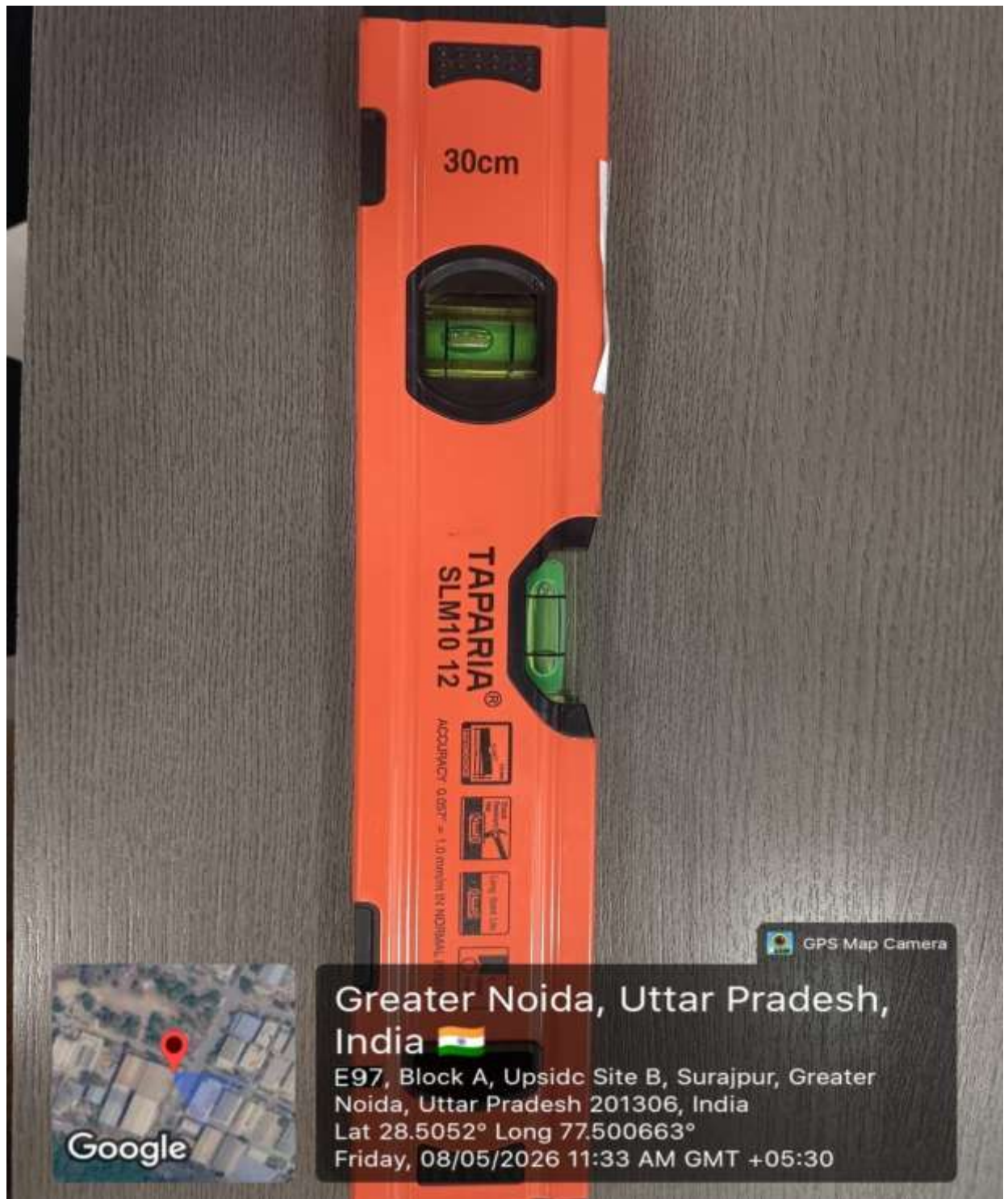


VERNIER CALIPER



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SPIRIT LEVEL

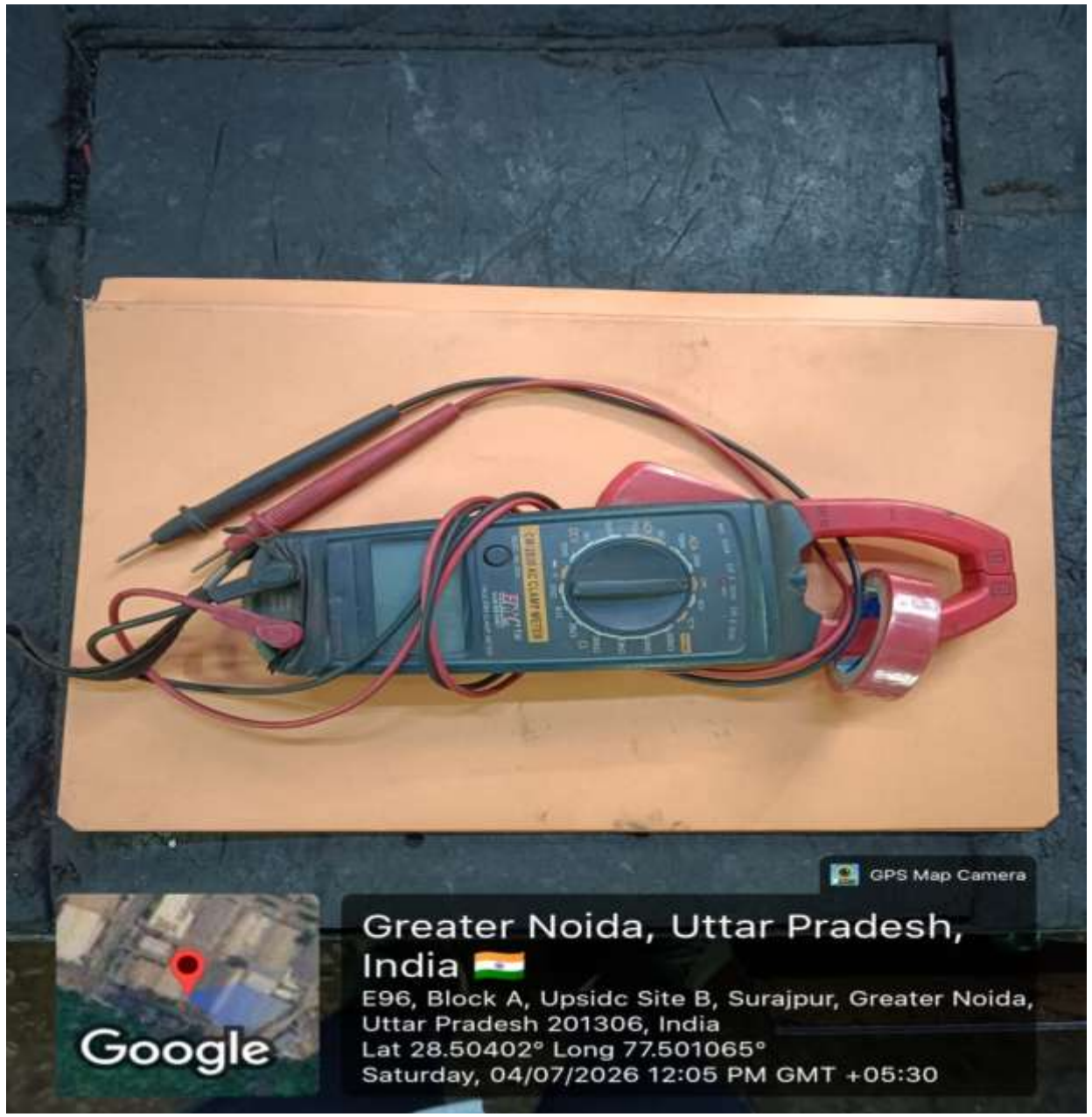




ROUGHNESS TESTER

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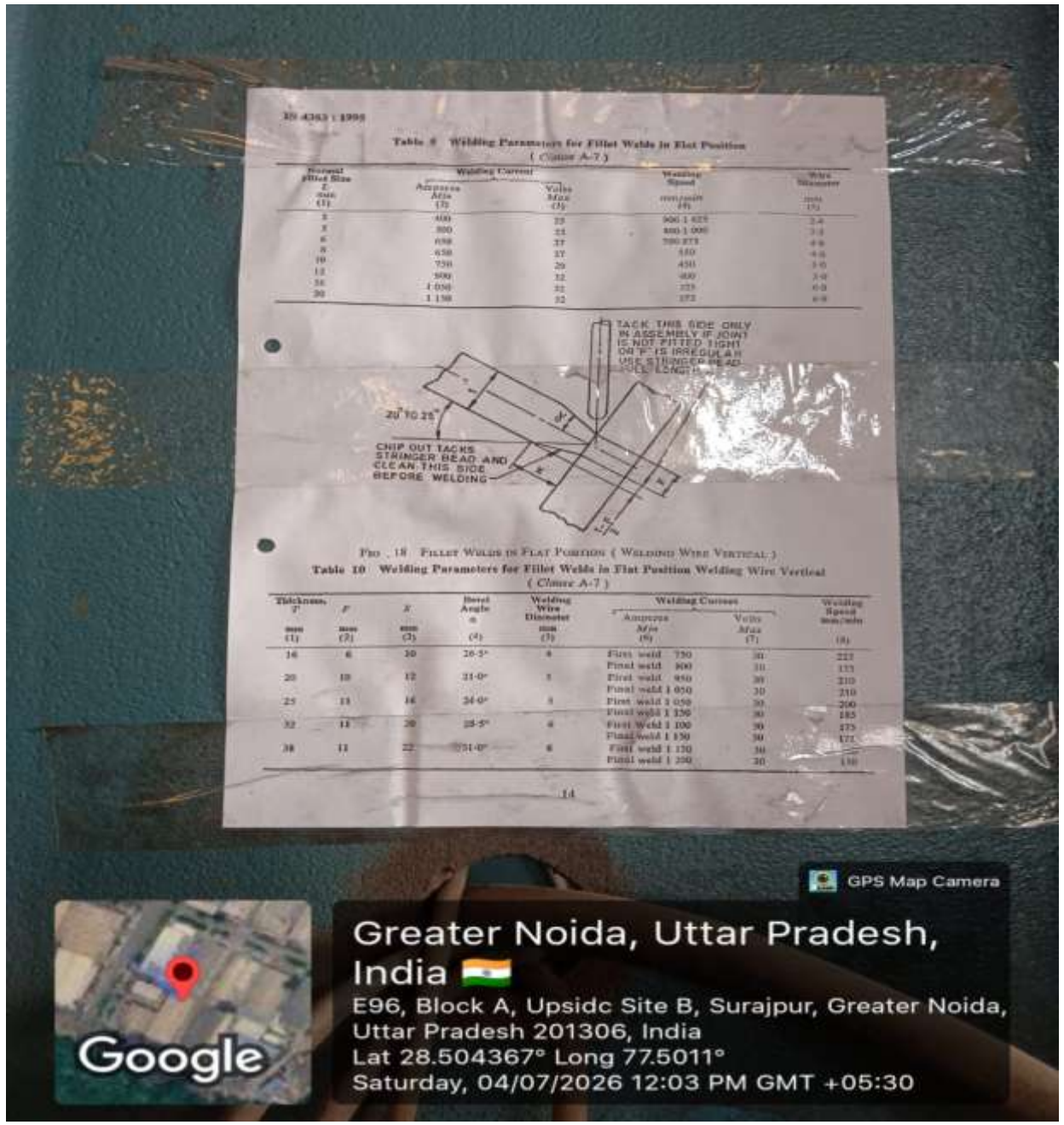


CLAMP METER



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WELDING PARAMETER IN WORKSHOP



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IS 10178 : 1995

Table 4 Typical Welding Conditions for Fillet Welds in Flat Position
(Clauses 9.4, 11 and 14.1)

Fillet Size Leg Length	Wire Diameter	Welding Current	Arc Voltage	Wire Feed Rate	Welding Speed	No. of Passes
mm (1)	mm (2)	A (3)	V (4)	mm/min (5)	mm/min (6)	(7)
2	0.8	60	18	3 000	420	1
3	0.8	155	21	10 000	640	1
	1.0	180	24	6 500	780	1
	1.2	150	21	4 000	480	1
6	0.8	115	20	6 500	130	2
	1.0	140	22	4 800	150	1
	1.2	180	24	5 000	200	1
10	0.8	155	21	10 000	90	2
	1.0	230	26	9 400	140	2
	1.2	270	31	8 600	160	1
	1.6	350	32	5 300	180	1
20	1.2	170	21	4 700	25	4
	1.2	300	35	10 000	50	3
	1.6	270	28	3 600	40	3
	1.6	350	32	5 300	50	2
25	1.2	170	21	4 700	20	9
	1.2	300	35	10 000	40	8
	1.6	270	26	3 600	20	8
	1.6	350	32	5 300	25	4

NOTE—Refer 6.5 for gas flow rates.

Typical melting rates are given in Table 5.

Table 5 Melting Rates
(Clause 13.1)

Electrode Diameter	Current	Melting Rate
mm (1)	A (2)	kg/h (3)
0.8	50 - 180	0.5 - 2.8
1.0	70 - 225	0.75 - 3.5
1.2	80 - 270	1.0 - 5.2
1.6	160 - 400	1.7 - 9.2
2.0	220 - 475	2.5 - 10.0

13.1.1 Depending on the critical current for a particular electrode diameter two types of techniques are identified:

- Short-arc technique, and
- High-current technique.

13.2 Short-Arc Technique

In this technique, the metal transfer taken place in a certain cyclic manner, which is reinforced through a corresponding modification of power sources.

13.2.1 By conventional arc welding process, it is difficult to weld sheets of thickness less than 3 mm. Because of longer arcing time between the individual short circuits (beating time), under usual arc welding conditions the metal at the end of the consumable electrode reaches boiling temperature. This results in



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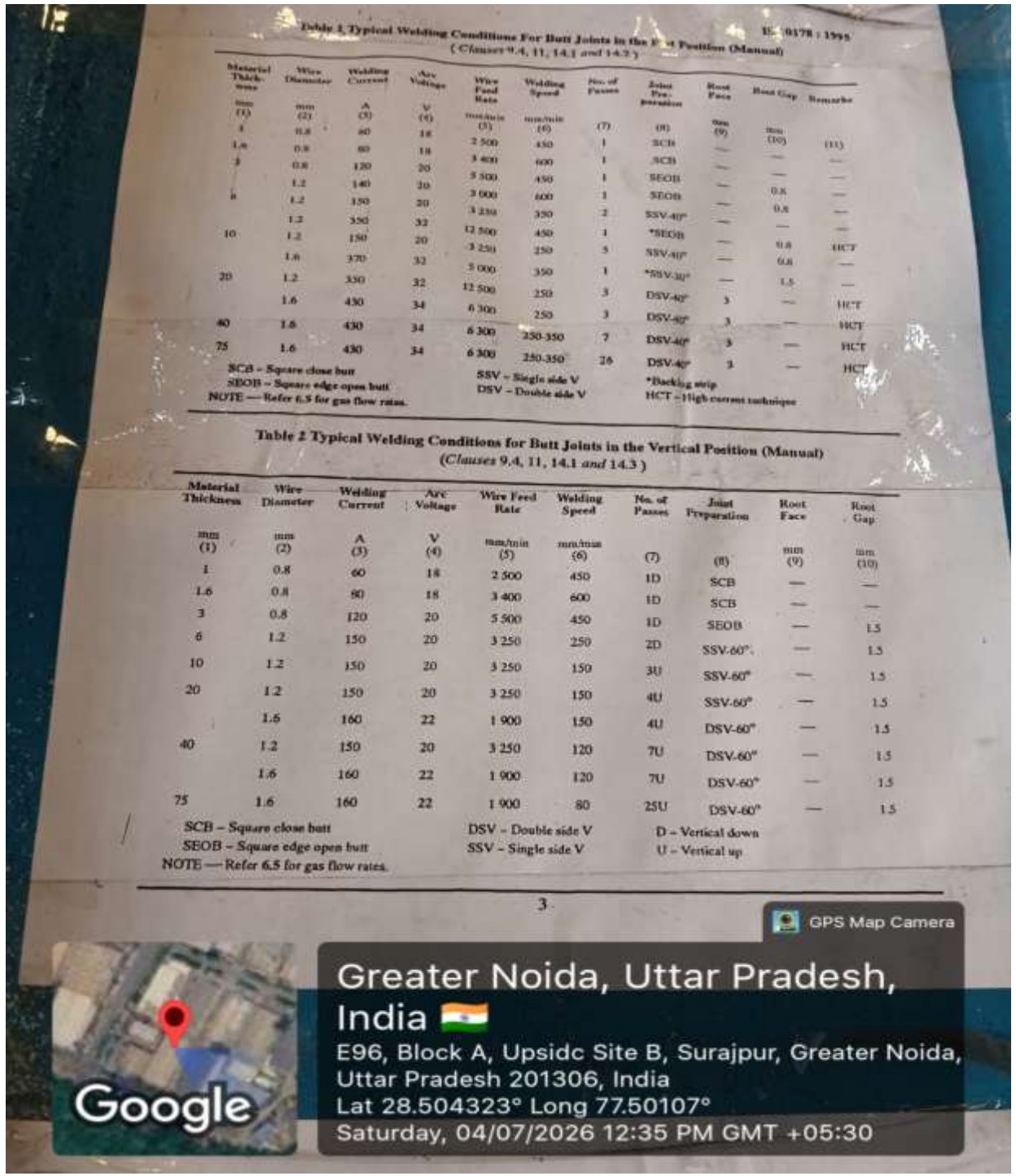
GPS Map Camera

WELDING PARAMETER IN WORKSHOP



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WELDING PARAMETER IN WORKSHOP

