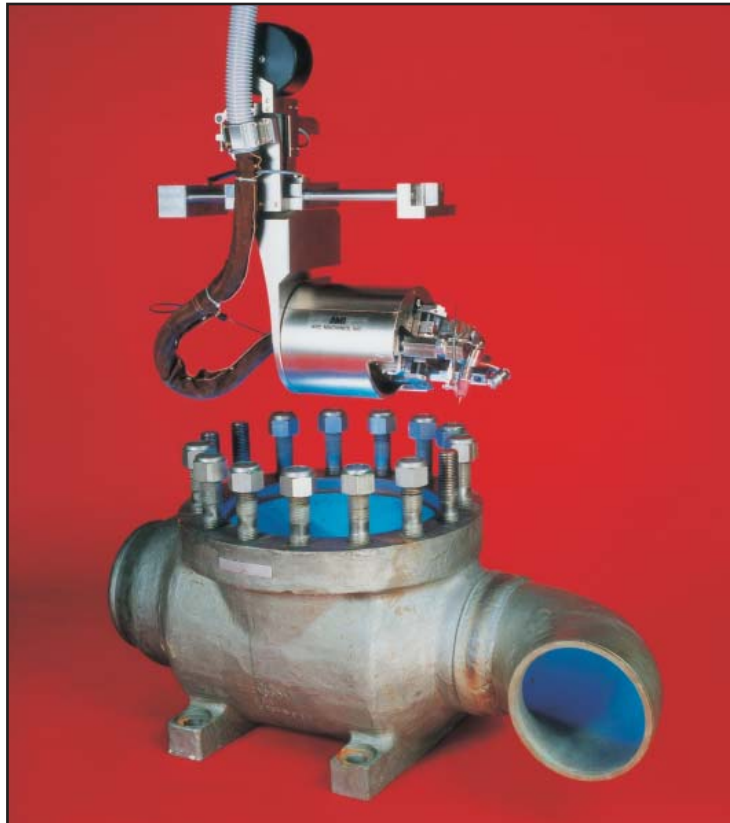


MODEL 72 VALVE REPAIR WELD HEAD



- Configurable for internal repair of valves from 8" through 24"
- Minimum radial and axial clearance
- Cross-seam steering
- Synchronized torch oscillation, AVC, rotation and wire feed
- On-board wire feed mechanics
- Compatible with the AMI Model 215 and 415 power supplies

MODEL 72 VALVE REPAIR WELD HEAD

The Model 72 is designed for welding, rewelding, or cladding eroded valve-to-pipe welds or for internal repair of many valve types from 8" through 24". Its modular features allow access through the bonnet without cutting or removal of valve welds. The head design allows installation where radial and axial access clearance to the valve is restricted.

The Model 72 features include multi-pass rotation, 100 IPM wire feed, AVC, cross-seam oscillation and axial position adjustment over a wide area. 300 ampere torch features leading and trailing edge direct-video weld vision using patented AMI arc-light filtration. Recommended for use on I.D. weld repairs, inlay applications along the bore or seat hard-facing and cladding.

The Model 72 requires the 215-DV MK II video controls. It operates with the Arc Machines' Model 215 and 415 power supplies and other accessories. Video system available in PAL or NTSC format.

For general dimensional and outline information, request drawing No.: 40720000. Due to variations in valve sizes, contours, flanges and bolt arrangements each Model 72 application may require some modification or custom design work. Contact AMI with your application details.



Technical Data

Process:	GTAW (TIG)	Torch Oscillation	
Torch AVC Stroke:	1.25"	Amplitude, max.:	1.00"
Rotation Speed:	0.05 - 0.50 RPM	Wire Manipulator:	± 0.125" cross-seam ± 0.125" up/down (Manual Adj.)
Wire Feed Speed:	5 to 100 IPM	Wire Entry Angle:	min. 20°, max. 30°
Torch:	Water-cooled, 300 ADC 100% duty cycle	Filler Wire:	0.030" - 0.035"
Torch Adjustments:	Adjustable lead/lag ± 5° Tilt in/out ± 5°	Wire Spool Size:	2 lb., 4" standard spool
Tungsten Size:	1/8"	Minimum I.D.:	7.5"
Torch Cross-seam		Maximum I.D.:	22.0"
Steering Range:	3.00" maximum	Minimum Bonnet I.D.	Approximately 11.0"
Max. Wall Thickness:	0.75"	for insertion:	(Depending on Bonnet Style)
		Weight:	25 lbs. (less cables & filler wire)
		Outline Drawing:	40720000

ARC MACHINES, INC.