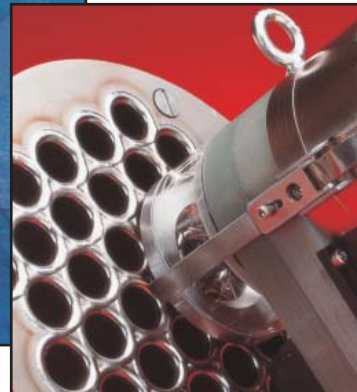


MODEL 96 TUBE-TO-TUBESHEET WELD HEAD



Shown welding titanium heat exchangers



Hastelloy® tubesheet

- Rugged, reliable tube-to-tubesheet weld head suited for high production applications
- Makes autogenous GTAW (TIG) welds on flush or slightly projected tubes. Consult factory for dimensional limitations
- Single or multi-pass welds
- Self-supporting on tubesheet, pneumatically operated
- One-button operation, quick mount and dismount
- Welds in any position, including overhead
- Compatible with Arc Machines Model 107, 207, 215, 415 or 227 power supplies

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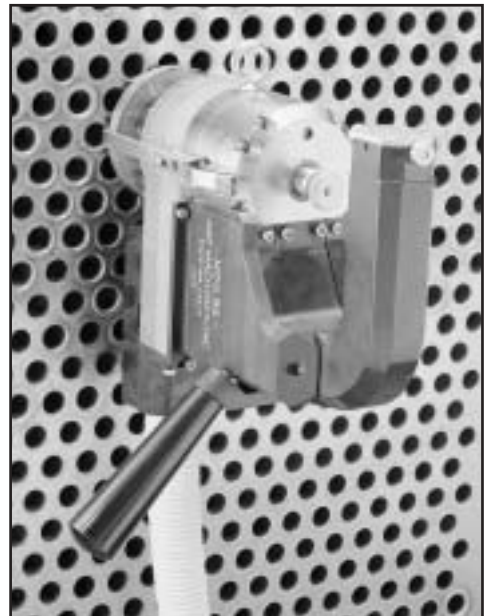
The Arc Machines' Model 96 is an automated weld head designed for high-speed, high-production autogenous welding of tubes to tubesheet. Welds made with this head, utilizing the GTAW (TIG) welding process, can pass the most rigid specifications.

The weld head is held in place (on the tube to be welded) by an expanding mandrel. This mandrel is actuated by a single button, conveniently located in the handle. Actuation of the mandrel holds the weld head firmly to the tubesheet and positions the torch concentric to the tube to be welded.

The Model 96 features a completely enclosed purge chamber. This gas chamber eliminates the use of gas cups and provides superior shielding for materials which oxidize easily, such as titanium.

The Arc Machines Model 96 Offers:

- Servo-controlled rotation
- Water-cooled weld head
- Pulsed-current welding, and synchronized torch rotation
- Pneumatic mandrel operation
- Transparent or opaque purge chamber
- Complete coverage of weld area with inert gas



Technical Data

Process:	GTAW (TIG)	Tube Size Range:	0.375" I.D. (minimum)
Weld Current:	150 ADC (maximum)		1.870" I.D., 2.000" O.D. (maximum)
Rotation Speed:	0.1 to 9.9 RPM	Weight:	7 lbs. (less cables)
Tungsten Size:	1/16" or 3/32"	Outline Drawing No:	40960001
Requires compressed air - 90 psi (6 bar)			

ARC MACHINES, INC.