

# *A2 Multitrac A2TF (SAW)*

*The universal welding automat for Submerged-Arc Welding*

**A2 Multitrac is designed to put your Submerged-Arc Welding operation on the right track to increase both the productivity and the quality.**

**The compact and efficient design makes it easy to move and to set up the A2 Multitrac between different welding workpieces. The mechanical components are very reliable, even under hard working conditions. Feedback systems on the wire feed and travel unit secures a very good welding result. The A2 Multitrac is designed to be used with LAF or TAF welding power sources.**

The simple design makes it possible to adjust the nozzle into numerous positions, to best suit the application. The heavy dimensioned feed unit with an encoder feedback secures an even and stable wire feed, and pre-requisite for top quality and homogenous welding. Another feature which ensures constant welding speed is the four-wheel drive carriage which also has an encoder for feedback.

Pre-setting and control of the welding parameters is done on the operator panel on the A2-A6 Process Controller (PEK). The A2-A6 Process Controller is a digital control system, which is easy to handle by the menus on the display.

The A2 Multitrac for Submerged-Arc Welding can be delivered in two versions, for single or twin wire. When using twin wire the deposit rate is increased by 30-40%. Joint gaps can easily be bridged and there is less risk for burn through. When cladding, the A2 Multitrac with twin wires can easily be set up for a low penetration.



## Accessories

To be able to increase the profitability, there are a number of accessories; specially developed idling rollers, guide wheel boogies in V-joint keeps the automate on track along the joint. The guide wheel boogies can also be used for inside tube welding

V-guide wheels for guide rail when the welding workpiece lacks a guiding edge when an I-joint is to be welded. Pilot lamps with a light bulb or a laser diode, which projects a luminous spot in the joint.

## Welding with cored wire - a modern weld process

The A2 Multitrac can also be used with cored wire. Productivity, economy and welding speed can then be increased.

## Programmed precision with ESAB's A2-A6 Process Controller

The digital electronic control equipment with a digital display makes fast programming and control of all welding parameters possible. 255 different weld sets can be stored in the controller. No running-in period is necessary. Adjustments can be made during welding.

## Technical data

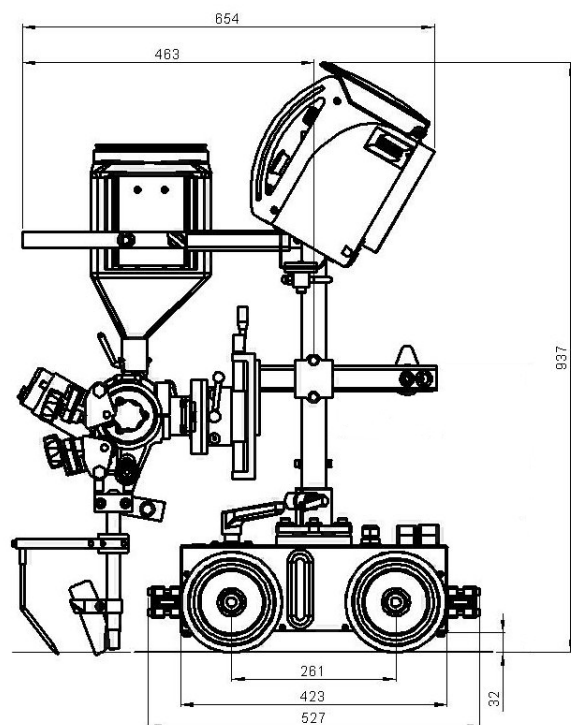
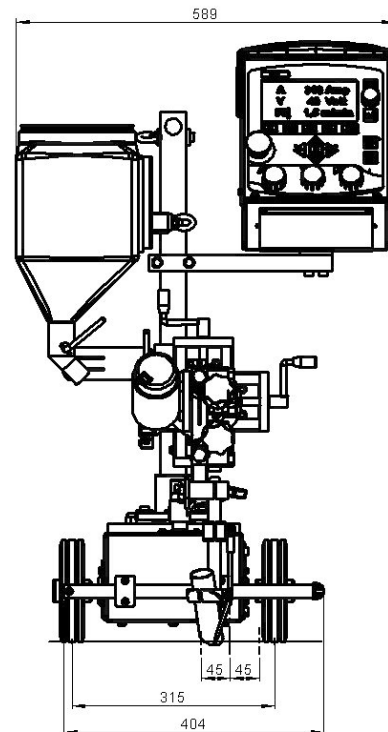
		Single SAW	Twin SAW
Wire dimensions (mm)	Steel	1.6-4.0	2 x 1.2-2.5
	Stainless	1.6-4.0	2 x 1.2-2.5
	Cored wire	1.6-4.0	-
Max wire feed speed (m/min)		9	9
Electrode weight (kg)		30	2 x 15
Flux volume (l)		6	6
Weight excl wire and flux (kg)		47	47
Permissible load 100% (A)		800	800
Control voltage (V)		42	42
Travel speed (m/min)		0.1-1.7	0.1-1.7
Linear slides setting length (mm)		90	90
Rotary slide setting angle (°)		360	360

## Accessories

		Single SAW	Twin SAW
<b>Contact tips Ø</b>			
<b>M12</b>			
1.6 mm	0154 623 008	X	
2.0 mm	0154 623 007	X	
2.5 mm	0154 623 006	X	
3.0 mm	0154 623 005	X	
3.2 mm	0154 623 004	X	
4.0 mm	0154 623 003	X	
<b>M6</b>			
1.2 mm	0153 501 005		X
1.6 mm	0153 501 007		X
2.0 mm	0153 501 009		X
2.4-2.5 mm	0153 501 010		X
<b>Feed rollers Ø</b>			
1.6 mm	0218 510 281	X	
2.0 mm	0218 510 282	X	
2.4-2.5 mm	0218 510 283	X	
3.0-3.2 mm	0218 510 298	X	
4.0 mm	0218 510 286	X	
<b>Knurled feed rollers for cored wire Ø</b>			
0.8-1.6 mm	0146 024 880	X	
2.0-4.0 mm	0146 024 881	X	
<b>Knurled pressure rollers Ø</b>			
0.8-1.6 mm	0146 025 880	X	
2.0-4.0 mm	0146 025 881	X	
<b>Shaft for knurled pressure roller</b>	0212 901 101	X	
<b>Feed rollers for Twin Ø</b>			
2 x 1.2 mm	0218 522 486		X
2 x 1.6 mm	0218 522 488		X
2 x 2.0 mm	0218 522 484		X
2 x 2.4-2.5 mm	0218 522 480		X
<b>Auxiliary guiding equipment</b>			
Guide wheel bogie	0413 542 880	X	X
Idling roller	0333 164 880	X	X
Guide bar 3 m	0154 203 880	X	X
V-guide wheel	0333 098 881	X	X
V-wheeltrack in steel (4 pcs)	0443 682 881	X	X
Loop for connection of two automat	0334 680 881	X	X
Pilot lamp, laser diode	0821 440 880	X	X
<b>Flux handling equipment</b>			
Flux recovery unit OPC	0148 140 880	X	X
Bracket suction	0332 947 880	X	X
Flux hopper of silumin alloy	0413 315 881	X	X
Concentric flux feeding funnel	0145 221 881	X	X
Contact tube, bent	0413 511 001	X	X
<b>Completion set Twin Arc</b>			
0413 541 882		X	
<b>Wire reel</b>			
Wire reel, plastic, 30 kg	0153 872 880	X	X
Wire reel, steel, fixed width	0416 492 880	X	X
Wire reel, steel, flexible width	0449 125 880	X	X
Wire reel, steel Ø 220 mm	0671 164 080	X	X

## Ordering information

A2 Multitrac A2TF J1 (SAW)	0461 233 880
A2 Multitrac A2TF J1 (SAW Twin)	0461 233 881



2009-12-10 / ESAB reserves the right to alter specifications without prior notice



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