



# A6S SAW Strip Cladding Head

Highly alloyed materials, such as stainless steel or nickel-base alloys, are needed in many applications to provide protection against corrosion. However, the comparatively high cost of these materials in many cases makes deposition of a protective layer on a less expensive loadbearing mild or low alloy steel economically the most realistic alternative.

Furthermore, weld surfacing with A6S SAW Strip Cladding head gives the designer and the fabricator a great degree of freedom providing the possibility to choose a wide variety of parent materials and consumables. Cladding by weld surfacing also allows for flexibility in production of objects having various shapes and sizes. Stainless steel cladding is widely used in production of components where corrosion resistance is required together with a strength above that of standard stainless grades.

## Strip cladding kit

The well known A6S Arc Master welding head can be fitted with a standard accessory strip cladding kit. The strip cladding head gives the possibility to use a strip electrode with the width from 30 mm up to 100 mm and with the thickness of 0,5 mm.

## Power sources

Strip cladding welding requires a power source of high capacity and good welding characteristics. Esab LAF 1250 and LAF 1600 are perfect for to be used together with the A6S Arc Master welding head equipped with the strip cladding kit.

These power sources together with the process controller PEH demonstrate good arc stability at both high and low arc voltages and the continuously variable voltage control permits the very precise adjustment of welding parameters.



## Welding fluxes

The Esab produced fluxes for strip cladding plays an important part in producing the final weld metal composition. Agglomerated fluxes are best suited to compensate for the possible burnoff of different elements in the arc, in addition to adding alloying elements. The flux should also produce a selfreleasing slag which produces an optimum bead shape to avoid uneven overlaps between adjacent beads.

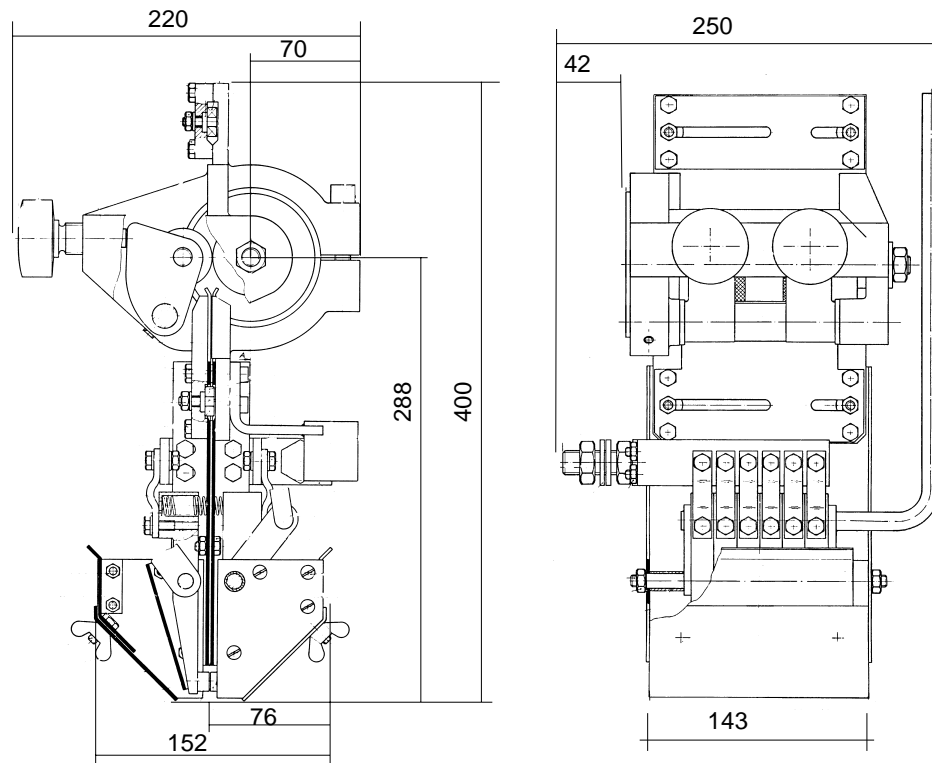
XA00101020

# Technical data A6S SAW Strip Cladding Head

## Technical data

Current capacity	1500 A max
Feed roll diameter	50 mm
Strip width	30-100 mm
Strip thickness	0.5 mm

Strip feed speed: see respective leaflet A6 Mastertrac XA000851\*\* or A6S Arc Master XA000889\*\*.  
(\* to change to resp. language code, 10 Swe, 20 Eng, 30 Ger, 40 Fr).



## Ordering information

Strip cladding kit to be used together with A6T SAW Tractor or A6S Arc Master HD	0155 972 880
Reel holder (not to be used with motor-operated cross slide)	0417 636 880
Wire reel, steel	0416 492 880
Suction nozzle, flux	0156 025 001



Printed in Sweden, SG lida & tryck ab, Göteborg 03.2001/15606

Esab reserves the right to change specifications without notice.

Approved according to the ISO 9001 system



**ESAB AB**  
Box 8004  
S-402 77 GÖTEBORG  
Sweden  
Phone: +46 31 50 90 00  
Fax: +46 31 50 93 60  
[www.esab.com](http://www.esab.com)