

Model 72

VALVE REPAIR WELD HEAD



THE WIDEST RANGE OF ORBITAL WELDING EQUIPMENT IN THE WORLD

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 hardfacing and cladding.

INDUSTRY

- Nuclear
- Power Generation
- Shipyards
- Oil and Gas



MODEL 72 VALVE REPAIR WELD HEAD

FEATURES

- Configurable for internal repair of valves from 8" through 24"
- Minimal 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

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.

Visit arcmachines.com for more information.

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



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