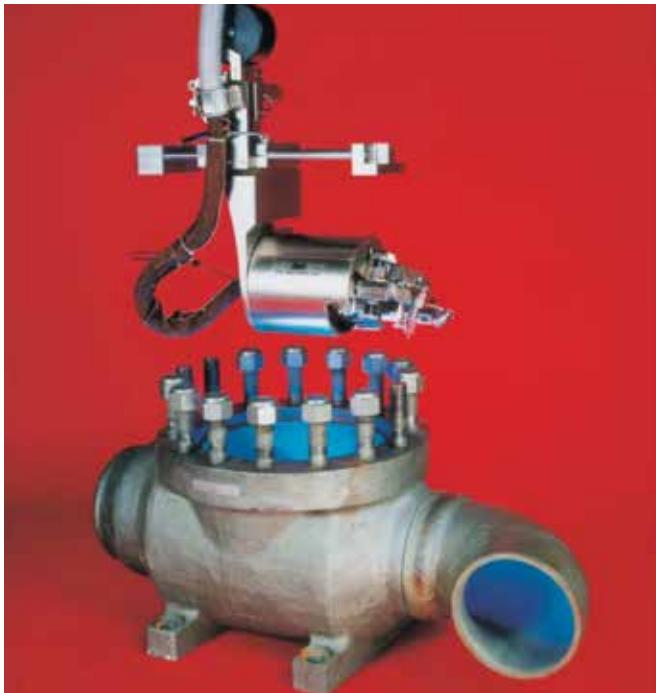


Model 72

VALVE REPAIR WELD HEAD

AMI[®]
AN ESAB[®] BRAND



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



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.

Model 72

VALVE REPAIR WELD HEAD

| 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° Tilt in/out \pm 5° |
| 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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XAA00219521 / US / EN / 08-21-20