

REDHEAD

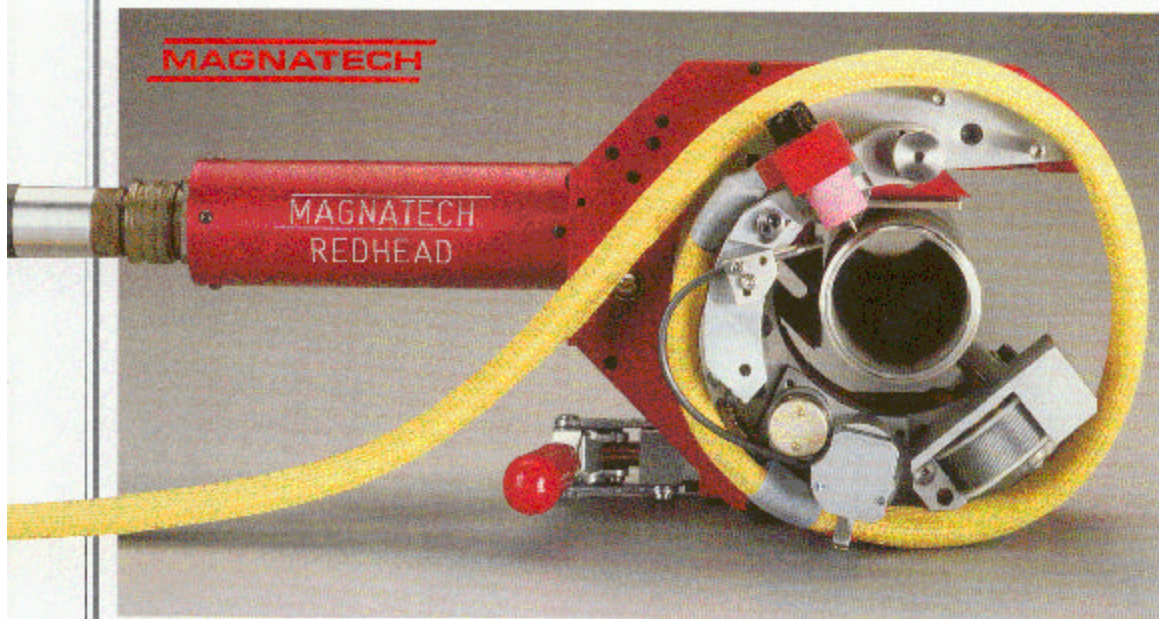
PIPE AND TUBE WELD HEADS

The Redhead series of weld Heads are easy-to-operate tools for welding pipe. Three standard models cover pipe sizes 12.7mm to 168mm O.D. (0.5" to 6.625"). Redhead weld Heads incorporate filler wire feeders and a mechanical arc length control device to compensate for out-of-round pipe.

This Second Generation design provides continuously adjustable clamping – no need to interchange components when changing pipe sizes.

Redheads clamp only on one side of the weld joint, allowing use for pipe-to-fitting welds.

The Redhead series can be operated by any Magnatech control/power source package, ranging from simple to operate analog controls to microprocessor-based systems with program storage capability.



FEATURES

- Water-cooled, top-loading torch for high duty cycle applications
- Full range adjustable clamping eliminates separate components
- Mechanical arc length control compensates for out-of-round pipe
- Push-button clutch for rapid cable unwind at weld completion
- Lever activated clamp with micrometer fine adjustment accommodates variation in pipe O.D.
- Heat tolerant steel bearings and chain drive
- Waterproof storage case for weld Head

OPTIONS

- Bottom-loading torch for applications with restricted radial clearance
- Socket (fillet) welding kit for angled torch application
- Extended/Extension cables

APPLICATIONS

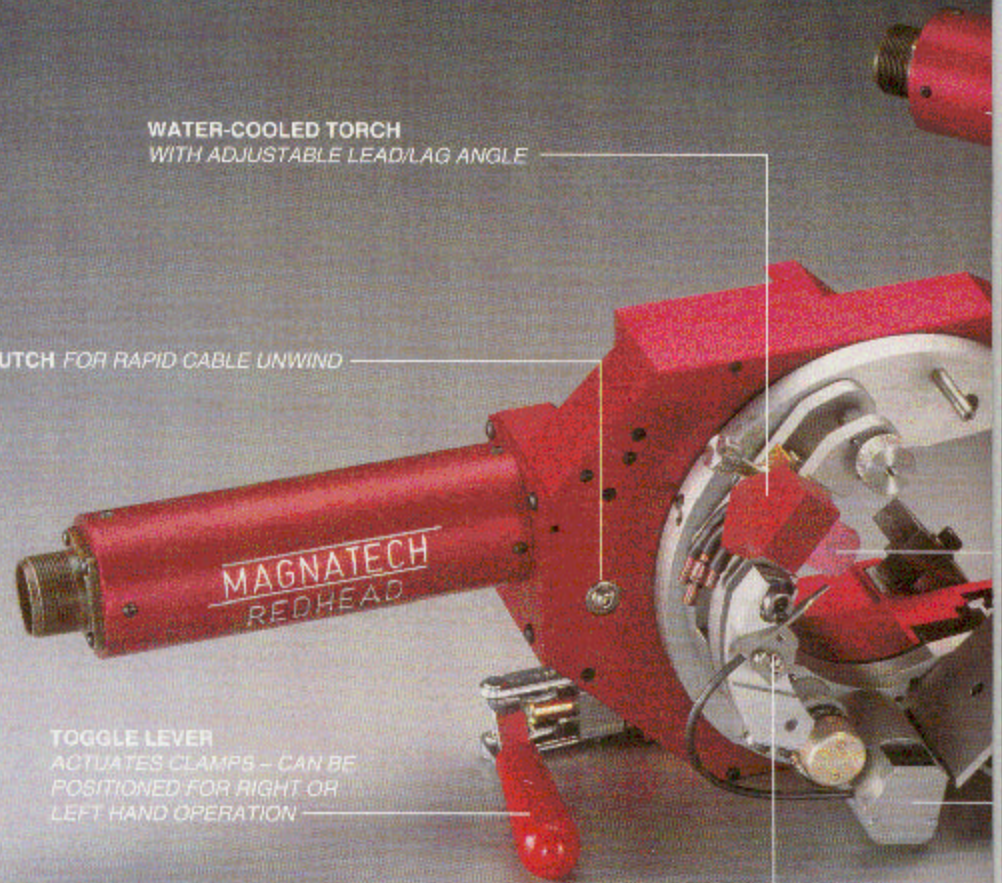
- Aerospace
- Pharmaceutical
- Semiconductor/High Purity
- Food Process/Dairy
- Process Pipe
- Heat Exchangers
- Chemical
- Power Generation

REDHEAD

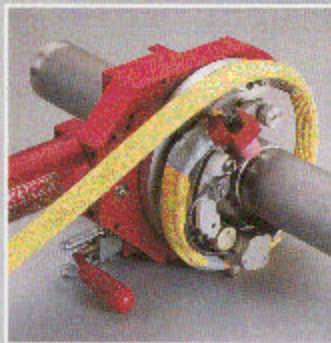
PIPE AND TUBE WELD HEADS

WATER-COOLED TORCH
WITH ADJUSTABLE LEAD/LAG ANGLE

PUSH BUTTON CLUTCH FOR RAPID CABLE UNWIND

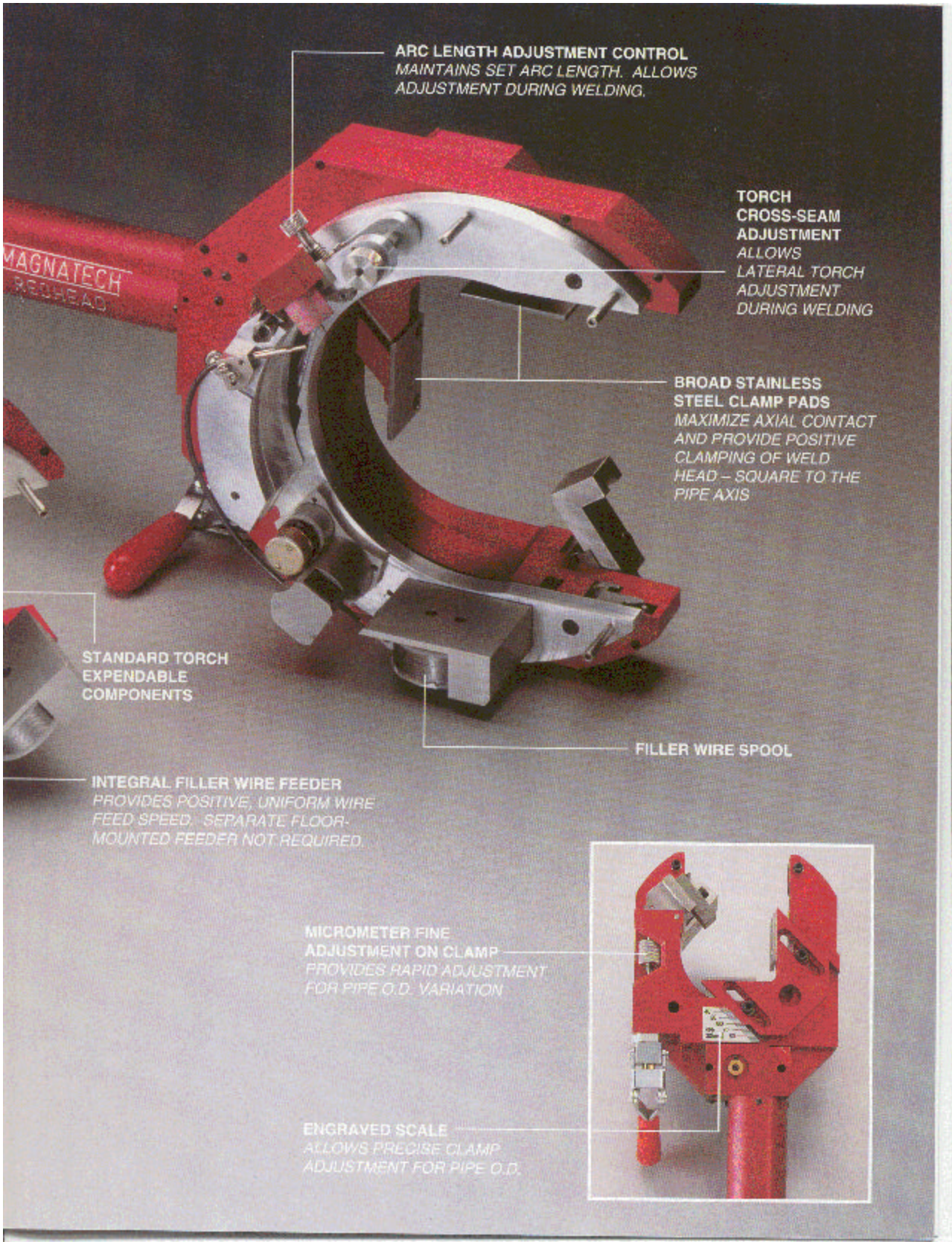


TOGGLE LEVER
ACTUATES CLAMPS - CAN BE
POSITIONED FOR RIGHT OR
LEFT HAND OPERATION



3 AXIS POSITION
ADJUSTMENT
FOR FILLER WIRE NOZZLE
(VERTICAL, HORIZONTAL,
ANGULAR)

THE WELD HEAD MOUNTS ENTIRELY ON ONE SIDE OF THE JOINT,
ALLOWING USE ON PIPE-TO-PIPE AND PIPE-TO-FITTING WELDS



ARC LENGTH ADJUSTMENT CONTROL
MAINTAINS SET ARC LENGTH. ALLOWS
ADJUSTMENT DURING WELDING.

**TORCH
CROSS-SEAM
ADJUSTMENT**
ALLOWS
LATERAL TORCH
ADJUSTMENT
DURING WELDING

**BROAD STAINLESS
STEEL CLAMP PADS**
MAXIMIZE AXIAL CONTACT
AND PROVIDE POSITIVE
CLAMPING OF WELD
HEAD - SQUARE TO THE
PIPE AXIS

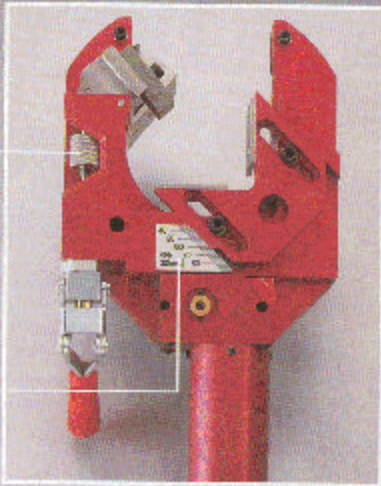
**STANDARD TORCH
EXPENDABLE
COMPONENTS**

FILLER WIRE SPOOL

INTEGRAL FILLER WIRE FEEDER
PROVIDES POSITIVE, UNIFORM WIRE
FEED SPEED. SEPARATE FLOOR-
MOUNTED FEEDER NOT REQUIRED.

**MICROMETER FINE
ADJUSTMENT ON CLAMP**
PROVIDES RAPID ADJUSTMENT
FOR PIPE O.D. VARIATION

ENGRAVED SCALE
ALLOWS PRECISE CLAMP
ADJUSTMENT FOR PIPE O.D.



SPECIFICATIONS

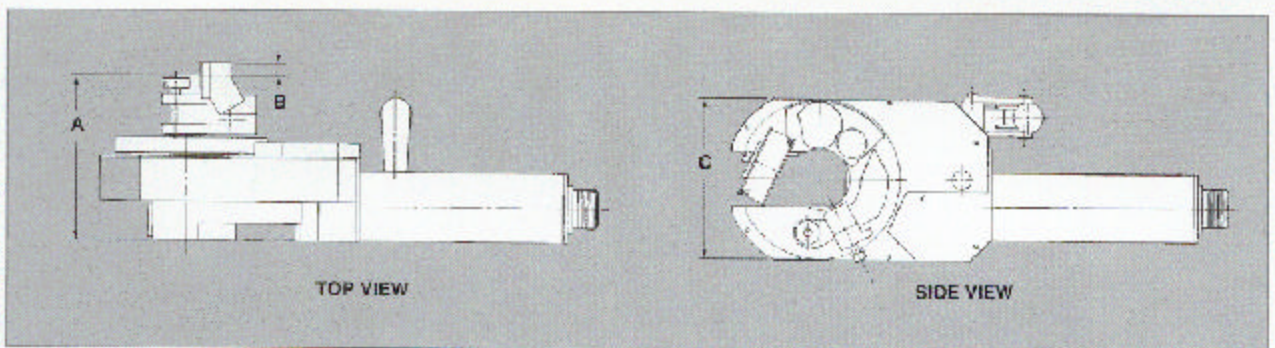
	R-1 Head	R-2 Head	R-3 Head
Pipe Size Range	13mm – 38mm (0.5" – 1.5")	33.4mm – 88.9mm (1.315" – 3.5")	90mm – 168mm (3.5" – 6.625")
Basic Head Max. Rotation Speed Arc Length Control Torch Rating	4.0 rpm Mechanical 200 Amps @ 100% Duty Cycle	1.5 rpm Mechanical 200 Amps @ 100% Duty Cycle	0.6 rpm Mechanical 200 Amps @ 100% Duty Cycle
Filler Wire Module Wire Size Max. Speed Capability Spool Size	0.8mm (0.03") 190cm/min (75 ipm) 0.16kg (0.35lbs.)	0.8mm (0.03") 190cm/min (75 ipm) 0.16kg (0.35lbs.)	0.8mm (0.03") 190cm/min (75 ipm) 0.16kg (0.35lbs.)
Cable Length	7.6M (25') Standard	7.6M (25') Standard	7.6M (25') Standard
Head Weights	3.9kg (8.5lbs.)	5.4kg (12lbs.)	9.0kg (20lbs.)
Control/Power Supply Compatibility	All Models of Magnatech Controller/Power Sources (TIG Process)		

HEAD DIMENSIONS

	R-1 Head	R-2 Head	R-3 Head
A. Torch C/L to Rear Extremity	12.7cm (5.0")	12.7cm (5.0")	12.7cm (5.0")
B. Torch C/L to Front Extremity	1cm (0.41")	1cm (0.41")	1cm (0.41")
C. Width	14.0cm (5.5")	19.1cm (7.5")	28.0cm (11.0")

RADIAL CLEARANCE REQUIREMENT

	R-1 Head	R-2 Head	R-3 Head
	$[14\text{cm (5.5")} - \text{Pipe O.D.}] \div 2$ = Radial Clearance Requirement	$[19.1\text{cm (7.5")} - \text{Pipe O.D.}] \div 2$ = Radial Clearance Requirement	$[28.0\text{cm (11.0")} - \text{Pipe O.D.}] \div 2$ = Radial Clearance Requirement



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