

# Pneumatic Butt Welding Machines

- Pneumatic high speed butt welders for big volume production - **high hourly output** of rings, frames, shaped wire parts formed out of round and profiled wire
- Machines made for continuous operation with water cooled electrode dies - clamping and upsetting by pneumatic cylinders, for **perfect ease of operation** - pedal operation for initiating the welding operation including clamping, welding, cooling time, unclamping - possibility of incorporating into feeding devices



Pneumatic butt welding machine type DSP 080

- **No or reduced finishing of weld joints having a minimum weld burr:** All weld parameters are precisely and continuously adjustable - optional current cut-off according to upset way or weld time - thus extreme small weld burr

Types DSP 080 - DSP 140,  
DST 100/DST 120



Pneumatic butt welding machine  
type DSP 100

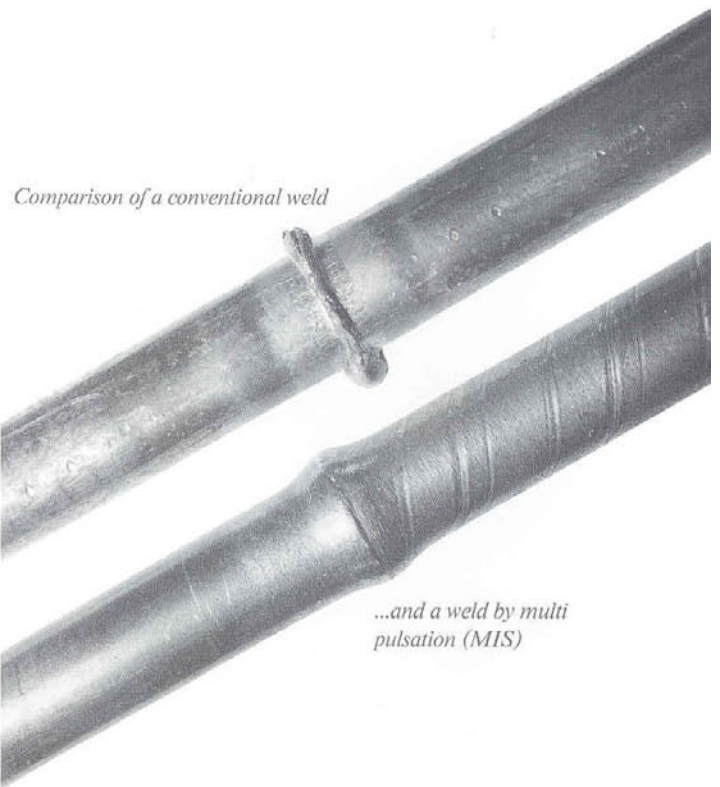


| Type    | Wire diameter steel |                    | Capacity kVA | Admissible max. output $\phi$ / piece / h | Weight net/gross | Packing sizes mm   |
|---------|---------------------|--------------------|--------------|---|------------------|--------------------|
|         | maximum             | continuous service |              |   |                  |                    |
| DSP 080 | 1,5 - 8,0           | 1,5 - 6,0          | 2,6          | 4,0/1200                                  | 123/193          | 980 x 860 x 1350   |
| DSP 100 | 2,0 - 10,0          | 2,0 - 8,0          | 16           | 6,0/1200                                  | 195/285          | 1000 x 850 x 1300  |
| DSP 120 | 3,0 - 12,0          | 2,0 - 10,0         | 25           | 6,0/1200                                  | 200/290          | 1000 x 850 x 1300  |
| DSP 140 | 4,0 - 14,0          | 4,0 - 12,0         | 45           | 8,0/2000                                  | 620/690          | 1200 x 1040 x 1550 |
| DST 100 | 2,0 - 10,0          | 2,0 - 8,0          | 16           | 6,0/1200                                  | 350/420          | 1200 x 1000 x 1350 |
| DST 120 | 3,0 - 12,0          | 2,0 - 10,0         | 25           | 6,0/1200                                  | 355/425          | 1200 x 1000 x 1350 |

- **Models DST 100 / DST 120 with universal clamping device** for producing butt welds in line and for T-welds - quick change-over of electrode dies - clamps easily accessible from above for fast loading - workplate with adjustable stops and T-electrodes for T-welding of center bars into frames etc.



Welding machine for butt and T-welds type DST 100



Comparison of a conventional weld

...and a weld by multi pulsation (MIS)

- **Burr-free butt welds by MIS multi pulsation current control** for mild steel wire having precisely cut ends (not possible for carbon steel or stainless steel) - weld joints having minimum overthickness, without sharp edges produced by multiple current pulses and reduced upsetting way

Subject to alteration (DSE: 12/97)