

# Dual Force Butt Welding Machines



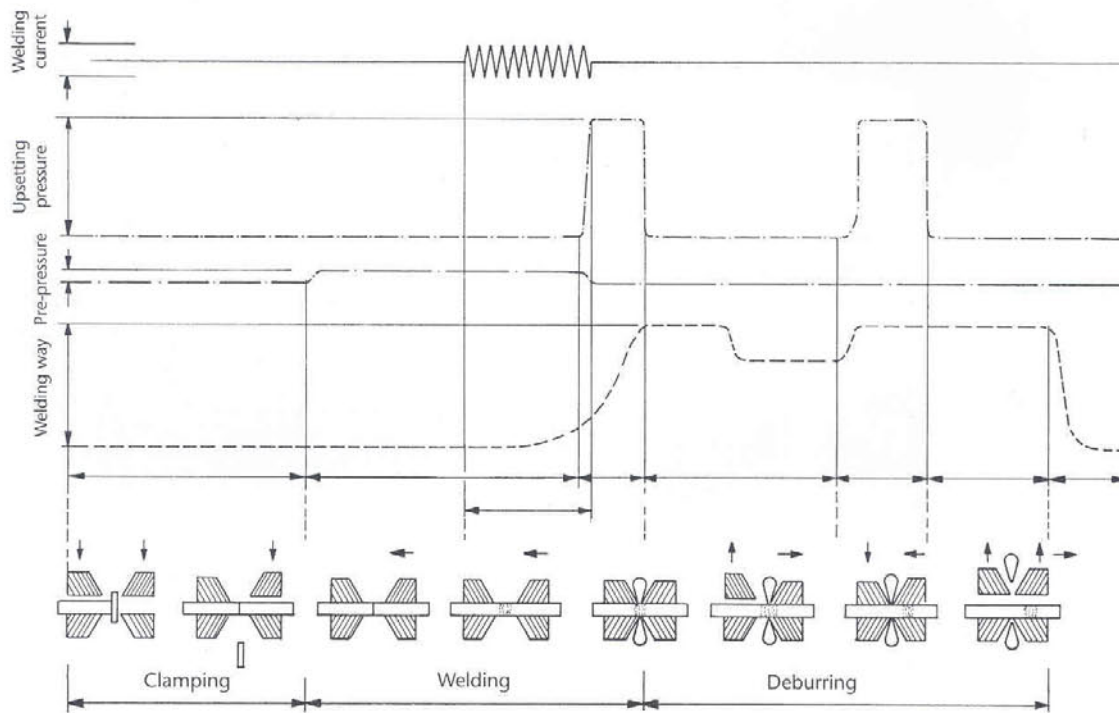
## Types DDS 120 - DDS 220

*Your advantage by upgraded technology:*

- Draw resistant butt welds in heavy non-ferrous rod by butt welding process in two phases according to IDEAL dual force welding system
- Automatic weld cycle and reliable consistency of the weld parameters to assure the production of metallurgically clean, high tensile welds
- Important time savings when producing the coil joining operation by automatic welding and subsequent deburring of weld joint by shearing the weld burr within the clamping dies

**IDEAL**

- *The fastest means of producing jumbo coils: Highly economic dual force welding of round and profiled non-ferrous rod in front of high speed drawing mills and for production of jumbo coils*
- *Dual force welding process made in two phases: Production of welding heat at the butting ends after actuating light pre-pressure and switch-on of weld current - upsetting produced by extremely high specific upsetting force after producing sufficient weld heat - welds showing clean grain structure and having highest tensile strength*
- *Automatic deburring of weld joint by shearing and breaking of the burr ring by special shearing dies made from tool steel*
- *Electrode dies and shearing dies to be machined according to the actual wire diameter, made for long lifetime and easily interchangeable*



Type	Welding range mm Ø			Rated capacity kVA	Dimensions L x W x H (m)	Weight net (kgs)
	Cu	Al	Ms			
DDS 120	6 - 12	6 - 15	6 - 12	40	1,8 x 1,0 x 1,5	1 200
DDS 160	6 - 16	6 - 18	6 - 16	120	2,2 x 1,3 x 1,5	1 700
DDS 220	10 - 22	10 - 30	8 - 20	250	Machine: 2,2 x 1,2 x 1,8 Hydr.+Elec.: 1,8 x 1,3 x 2,2	2 400 1 100