






DOUBLE PRESSURE WELDING MACHINE TYPE DDO

The **DDO double pressure butt welding machines** produce extremely high-strength, dimensionally accurate welds through the use of an additional hydraulic upsetting force.

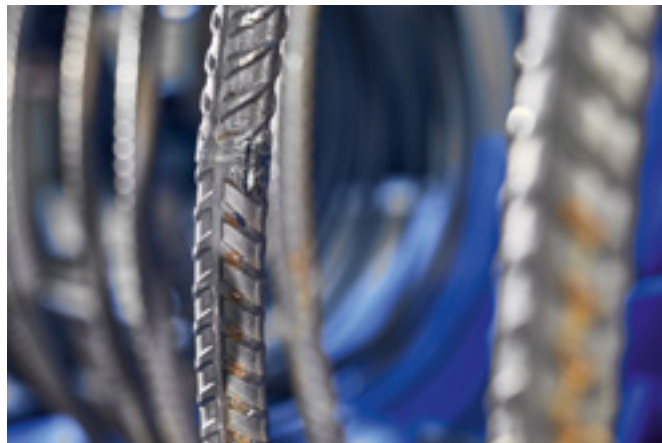
During the welding process, the heat-affected material is almost completely displaced from the weld zone, resulting in a refined grain structure and **maximum tensile and bending strength**.

DDO 020-025	DDO 104	DDO 200 S-K
		
<p>Welding of reinforcing steel coils</p>	<p>Heavy welding of reinforcing steel coils</p>	<p>Heavy welding of reinforcing steel coils</p>
<p>Application Welding of coil ends made of ribbed reinforcing steel (B500B), vertical/horizontal</p>	<p>Application Coil welding of reinforcing steel up to Ø 22 mm (0.866 in) for wire drawing</p>	<p>Application Multi-sided welding of steel rings, radially and axially aligned</p>
<p>Materials and specifications: Diameter: Ø 12 - 20 mm (0.472-0.787") Surface: hot-rolled, pickled, oil-free Rm: 550 N/mm² Re: 500 N/mm²</p>	<p>Materials and specifications: Material: B500B (hot-rolled, oil-free) Diameter incl. ribs: Diameter incl. ribs: Ø 14 → 14.8 - 15.4 mm (0.551 → 5.826 - 6.062") Ø 16 → 17.2 - 17.8 mm (0.629 → 6.771 - 7.007") Ø 18 → 19.3 - 19.9 mm (0.708 → 7.598 - 7.834") Ø 20 → 21.2 - 22.2 mm (0.787 → 8.346 - 8.740")</p>	<p>Materials and specifications: Cross-section: 400 - 1133 mm² Width: 24 - 51.5 mm (0.944 - 20.275") Height: 18 - 22 mm (0.708 - 0.866") Inner Ø: 345 - 450 mm (13.582 - 17.716")</p>

GENERAL ADVANTAGES OF THE DDO SERIES

- Extremely high tensile, bending, and fatigue strength due to material consolidation
- Improved grain structure through displacement of the heat-affected zone
- Reduced welding cycle times for high-volume production
- No welding gases or filler materials required
- Highly accurate, reliable joints for continuous 24/7 operation
- Suitable for semi-automated and fully automated production lines
- Designed for fully automatic welding of ribbed reinforcing steel coil ends in vertical applications

Double-pressure butt welding machine for the fully automatic welding of the ends of coiled ribbed reinforcing bars in a vertical position.



TECHNICAL DATA – DDO 104 V

Parameter	Value	Unit
Compression force max.	120	kN
Clamping force max.	250	kN
Connection voltage	400	V / 50 Hz
Control voltage	24	V DC
Rated power at 50% duty cycle	120	kVA
Connected load	150	kVA
Fuse protection per phase	200	A
Cable cross-section at 400 V	120	mm ² je Phase
Ambient temperature	10 - 32	°C
Cooling water consumption approx.	ca. 1200	l/h

DDS 120 - DDS 160 - DDS 220

Double pressure butt welding machine for fully automatic welding of wire coil ends made of ribbed reinforcing steel in a vertical position

WELDING RANGES

Machine type	Copper wire mm Ø	Aluminum wire mm Ø	Brass wire mm Ø
DDS 120	6 - 12	6 - 15	6 - 12
DDS 160	6 - 16	6 - 18	6 - 16
DDS 220	10 - 22	10 - 30	8 - 20