HNG Multi
Narrow Gap Welding Head
The HNG Multi welding head has been designed for both Single (AC or DC) and Tandem (DC/AC or AC/AC) wire welding in parallel or almost parallel joints, ranging in width from 18 mm and in depth down to 350 mm.

The HNG Multi meets the demands for a fully automatic welding process with accurate controlling of all parameters for reduced welding times and perfect weld metal when welding high-tensile material. HNG Multi is suitable for continuous operation under heavy conditions - with preheated welding objects still maintaining the same high precision and wear characteristics.

**Technical description**

The welding head HNG Multi has been designed around the flat, welding nozzle. The reciprocating movement of the nozzle is accomplished by means of a pneumatic three position cylinder and is transferred from cylinder to nozzle through a shaft transmission system. The amplitude of this movement is set by means of screws located on the upper part of the welding head. Individual lateral offset between wire tips and joint side wall as well as distance (longitudinal) between the two wires can be adjusted as required.

ESAB’s well-known worm gear motor A6-VEC is used for the wire feed. The double wire straightening devices for each wire are also located on respective motor, 2-dimensionally mounted with displacement of 90°. Each device contains five hardened rollers, which are readily positioned as required.

The flux hopper is made of silumin and holds approx. 10 litres. Flux is led from the hopper to the pneumatically controlled flux valve. The hopper has been designed to match first rank flux feeding system, type FFS with a pressurized container, which can be mounted elsewhere on the carrier (see separate leaflet).

The flux suction unit on top of the container represents a further development of ESAB’s well-known ejector suction unit, type OPC. It has been made from a special heat resistant material to enable its use in combination with pre-heated flux.

The welding head is equipped with separate joint tracking system for vertical and horizontal joint tracking, respectively.

In the vertical there is a spring-loaded roller, while horizontal tracking is accomplished by means of a spring loaded trailing device.

For changeover between longitudinal and circumferential welding a pivoting link has been mounted in the immediate vicinity of the weld centre.

- Continuous double-sided joint tracking gives a high reliability at shift overlap
- Continuous measuring of joint width.
- Short-circuit protected, welding head-workpiece
- Automatic positioning
- Possible to weld up to 50 mm joint width
- Air-cooled torch
- Reliable and uniform high weld quality
- High productivity
- Minimum of supplementary work

**Typical applications**

- Pressure vessels
- Rotor shafts
- Nuclear reactors
- Turbine shafts
Technical information.

Technical Data

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weld joint type</td>
<td>Butt</td>
</tr>
<tr>
<td>Wire dimension, mm</td>
<td>3-4</td>
</tr>
<tr>
<td>Wire feed motor A6-VEC 156:1, 4000 rpm</td>
<td></td>
</tr>
<tr>
<td>Wire feed speed, max m/min</td>
<td>4</td>
</tr>
<tr>
<td>Max welding current DC, A</td>
<td>800</td>
</tr>
<tr>
<td>Max welding current AC, A</td>
<td>800</td>
</tr>
<tr>
<td>Beads in each layer</td>
<td>2-4</td>
</tr>
<tr>
<td>Deposition rate, kg/h</td>
<td>approx. 7/16 (Single/Tandem)</td>
</tr>
<tr>
<td>Titrating angle of weld nozzle</td>
<td>± 3.5°</td>
</tr>
<tr>
<td>Joint depth, max mm</td>
<td>350</td>
</tr>
<tr>
<td>Joint width, mm</td>
<td>18-50</td>
</tr>
<tr>
<td>Wire angle between wires</td>
<td>15°</td>
</tr>
<tr>
<td>Distance between wires, mm</td>
<td>15 (valid for 30 mm stick-out)</td>
</tr>
<tr>
<td>Accuracy of joint tracking, mm</td>
<td>± 0.15</td>
</tr>
<tr>
<td>Max heat resistance, workpiece, °C</td>
<td>300</td>
</tr>
<tr>
<td>Min weld diameter, mm</td>
<td>500/1200 (Single/Tandem)</td>
</tr>
<tr>
<td>Flux hopper capacity, litres</td>
<td>approx. 10</td>
</tr>
<tr>
<td>Flux hopper unit</td>
<td>OPC Super</td>
</tr>
<tr>
<td>Min clearance internal weld</td>
<td></td>
</tr>
<tr>
<td>- Longitudinal, Ø mm</td>
<td>1500</td>
</tr>
<tr>
<td>- Circumferential, Ø mm</td>
<td>1500</td>
</tr>
<tr>
<td>Weight, kg</td>
<td>140/165 (Single/Tandem)</td>
</tr>
</tbody>
</table>

Joint tracking.

- Follows the side that is being welded
- Separate systems for the horizontal and the vertical joint tracking
- Pre-programmed number of beads at different joint width.
- Automatic positioning to the middle of the joint (for root bead/partial bead)
- The joint tracking is integrated in the control system.
- Actual value and reference value of the sensor position are shown, as well as the position of the welding head
- An alarm is activated if the actual values are not correct (are not the same as the reference values)

Options

- Laser lamp with dot pointer
- Laser lamp with cross pointer, mounted on a flexible arm
- Tracking kit for welding diameter 1200-2000 mm
- Tracking kit for welding diameter 500-1200 mm
WeldLog
Computer program for welding supervision and documentation.

### Purpose

- To log measured weld data with a visual online presentation of the data.
- To measure and calculate heat input and metal deposition rate.
- To be able to analyze the measured data after completed weld.
- To create a summarized report of the welded joint including alarms.

### Features

- Online presentation of up to 24 channels measured data on up to 8 axis simultaneously, both graphically displayed and with numerical values.
- Logged reference values for:
  - Voltage
  - Current
  - Travel speed
  - Wire feed speed
- Logged actual values for:
  - Voltage
  - Current
  - Travel speed
  - Wire feed speed
- Heat-input logged and displayed [kJ/mm].
- Metal deposition rate logged and displayed [kg/h]
- Possibility to register external alarms with a 2D axis position (X, Y)