

PipeWorx™ System

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**Multiprocess Pipe
Welding Systems** 

Quick Specs



Pipe Welding Fabrication

Process Piping
Refinery
Petrochemical
Power
HVAC and Water Pipe

Processes

MIG/MAG
Pro Pulse MIG
RMD
Stick
DC TIG
Flux Cored

Rated Output : 400 VAC, 3 phase
Output Range: 400 A at 44 V, 100% DC
Voltage-Current: MIG: 40-400 A, 10-44 V
Stick: 40-350 A, 20,2-35 V
TIG: 10-350 A, 10-25 V
Weight: 102 kg (only power source)

The Power of Blue.®

Simple Process Setup

- Clearly labeled controls in easy-to-understand welder terminology.
- Requires just a few basic steps to set up a new weld process, resulting in less training time and minimizing errors from incorrect setups.
- The front panel was designed by welders for welders. Only backlit controls are adjustable to eliminate confusion.
- Memory feature stores four programs for each selection: Stick, DC TIG, and MIG (left and right side of feeder). Beneficial when using multiple procedures, multiple process parameters or multiple welders and eliminates the need to remember parameters.

Quick Process Changeover

- No need to manually switch polarity or cables and hoses between processes. Simply push a process selection button to choose a welding process. PipeWorx 'Quick-Select' technology automatically selects the welding process, the correct polarity, cable outputs and user programmed welding parameters.
- Quick process changeover eliminates set-up time for switching cables and gas hoses. Also, reduces the risk of weld reworks due to incorrect cable connection.



NEW! Accu-Power™ PipeWorx Memory Card (optional) displays instantaneous power during welding to meet the new ASME requirement for calculating heat input on complex waveform processes (RMD® and Pro-Pulse™).

Multiprocess Machine


- Weld processes are optimized to deliver superior arc performance and stability specifically for root pass, fill and cap pipe welding.
- Includes conventional Stick, DC TIG (Lift-Arc™ or HF Start), Flux-Cored and MIG welding processes.
- Also features the advanced RMD® and Pro-Pulse™ processes that deliver superior quality welds, increase productivity, and reduce rework and training.

Streamlined System

- Wind Tunnel Technology™ and Fan-On-Demand™ provide system protection in the dusty shop environment.
- Innovative cable and gun storage manages clutter for a cleaner, organized weld-cell area. Cables remain connected to the power source and do not need to be switched for the different welding processes.
- All system components have been selected to meet the needs of a pipe fabrication shop.



Power source is warranted for 3 years, parts and labour.

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Specifications

IP 21 **S** **CV** **DC** **3** Phase

Model	Welding Mode	Nominal output @ 100 % Duty Cycle	Amp/Volt Range	Amps input at 400V	KVA 400 V	KW 400 V	Max. Open-Circuit Voltage	Dimensions	Weight
PipeWorx Power Source	Stick	350 A at 34 VDC	40-350 A	24.3	16.9	14.3	90	H: 711 mm W: 495 mm D: 806 mm	102,0 kg
	TIG	350 A at 34 VDC	10-350 A	34.3	16.9	14.3			
	MIG/ Flux Cored	400 A at 44 VDC	10-44 V	33.4	23.1	20.7			

Model	Supply	Wire Feed Speed	Wire Diameter	Nominal input	Maximum Spool Size	Dimensions		Weight	
						Single	Dual	Single	Dual
PipeWorx Feeder	24 VAC, 11 A	1,3 - 19,8 MPM	0,9 - 1,6 mm	100 V, 750 A, 100% DC	27 kg	H: 365 mm W: 483 mm D: 737 mm	H: 365 mm W: 483 mm D: 737 mm	29,5 kg	41,0 kg

Drive Roll & Drive Roll Kits

Wire Size	V-groove	U-groove
0,9 mm	151 026	151 052
1,0 mm	161 190	-
1,1/1,2 mm	151 027	151 053
1,3/1,4 mm	151 028	151 054
1,6 mm	151 029	151 055
1,8 mm	-	151 056
2,0 mm	-	151 057
2,4 mm	-	151 058

Ordering Information

Power Source	Stock No.	Description
PipeWorx 400	907 534	400 V, 50 Hz., 3 phase, includes cable management
Single Bench-Style Feeder	300 949	Drive rolls not included
Dual Bench-Style Feeder	300 950	Drive rolls not included
Interconnection cable	058 019 189	2,5 m air-cooled
Interconnection cable	058 019 192	2,5 m water-cooled
Torches		
Bernard PipeWorx 250-15	195 399	4,6 m, 250 A, air-cooled MIG gun
Tregaskiss tough gun 450	E4515-MC	4,6 m, 450 A, water-cooled MIG gun
Weldcraft TIG torch	CS3 10A AL8 CKA-I	7,6 m, 310 A, water-cooled TIG torch
Accessories		
PipeWorx cart	300 368	
PipeWorx cooler	028 042 102	Cooling system for MIG guns and TIG torches
Coolant	043 810	Cooling Fluid
Feeder Cart	300 467	For Wire Feed unit

