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3-in 1 H Beam Welding Lines

JINFENG WELDCUT is a professional China manufacturer and supplier of 3-in 1 H beam welding lines with affordable price. The 3-in 1 H beam welding lines are integrated with assembling, welding and straightening on flange after welding in one machine for making welded H-beam or T-beam. It can realize the production on welded H-beam or T-beam with fast speed

and high accuracy, which having the features of simple operation, less occupied space and less labor.

ZHJ 3-in 1 H beam welding lines

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For all the **3-in 1 H beam welding lines** that manufactured by JINFENG WELDCUT will have 12 months warranty, which are the highest efficiency machine to increase the productivity for End-users from steel structure, bridge, construction.

Specifications

| Model | ZHJ15 | ZHJ18 |
|-----------------------|---|--------------|
| T-Beam web Height (H) | 200~1500mm | 200-1800 |
| Web thickness (d) | 6~12mm | 6~19mm |
| Flange width (B) | 200~800mm | 200~800mm |
| Flange thickness (t) | 6~25mm | 6~25mm |
| Beam length (L) | 4000~15000mm | 4000~15000mm |
| Beam material | Q235 | |
| Welding type | Submerged arc transverse fillet welding | |
| Welding power source | Single wire or twin wire type | Single wire |

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| | |
|--------------------------|------------------------------|
| Welding output speed | 200~1000 mm/min |
| Angle of torch: | 45° fine adjustment |
| Hydraulic pressure | ≤16 MPa |
| Flux recovery system | 2 sets |
| Volume of flux hopper | 2×50L |
| Input conveyor roller: | 12000 mm |
| Output conveyor roller: | 12000 mm |
| Main Machine power | 14.5kW |
| Hydraulic system: | 1set |
| Straightening unit | 1 set, integrated on machine |
| Power supply: | AC/380 V/50 Hz/3PH |
| Straightening capability | 6-40mm |

Feature And Application

3-in 1 H beam welding lines has as combined function of H beam, T-beam assembly, welding and flange deformation straightening after welding. Thus it can accurately and rapidly realize H beam and T beam production. It has the following advantages: simple operation, less labor cost and small covering area.

This line has two optional welding process for you to choose according to the structural steel plate thickness to be welded:

OPTION A: Single arc twin wire welding of which the deposition rate is 40% higher than the general single arc single wire submerged arc welding, So it is especially suitable for the structure steel thickness of which the thickness is less than 20mm.

OPTION B: Single arc single wire welding. It suitable for bigger range of the plate thickness welding.

Details

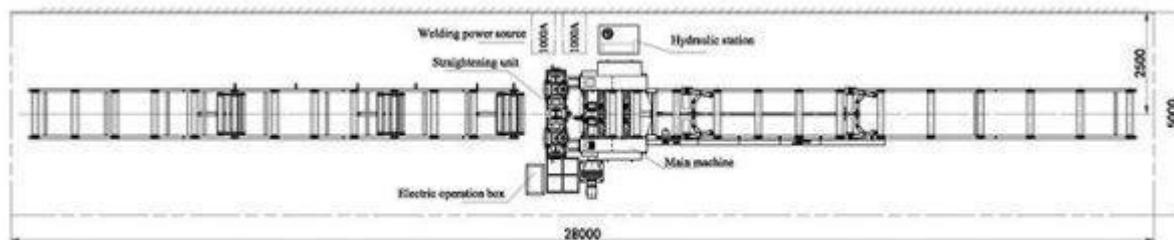
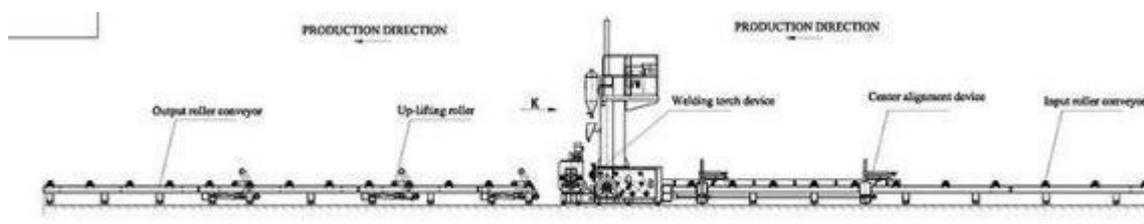
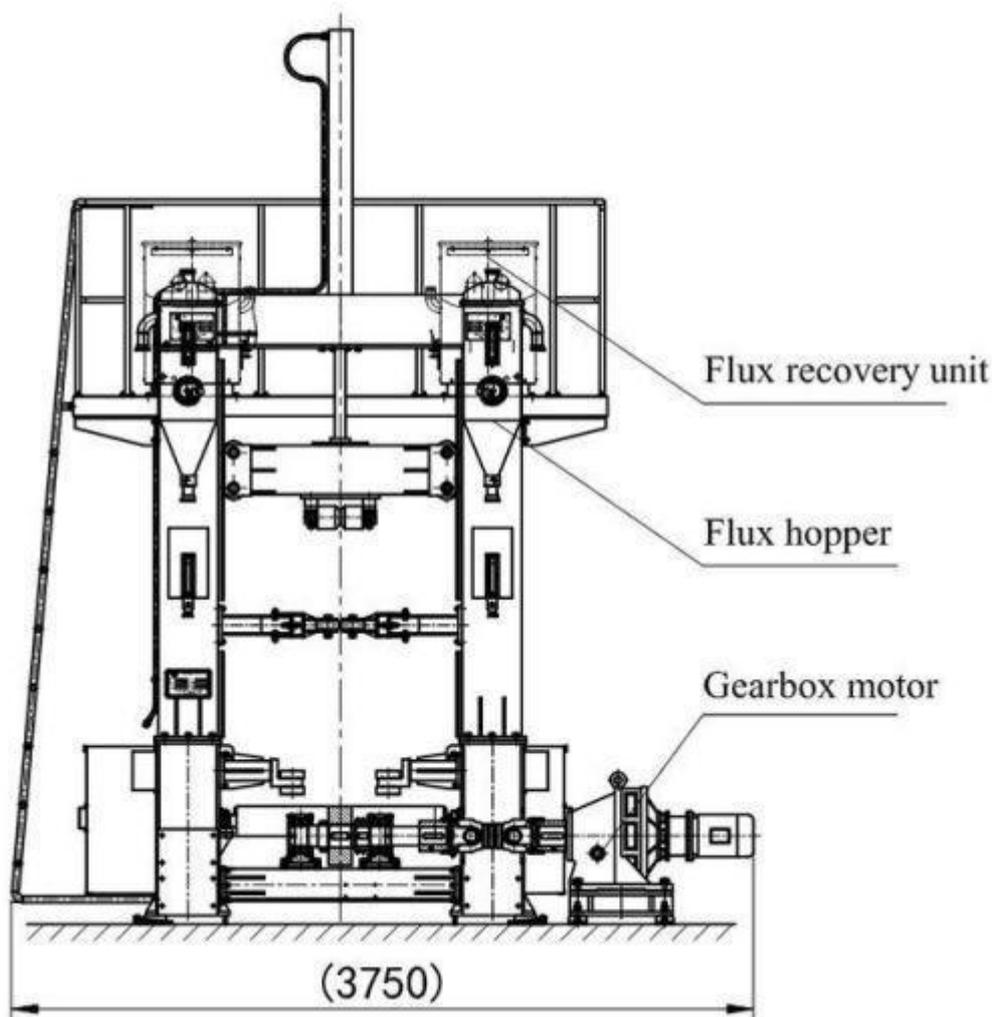
The standard ZHJ **3-in 1 H beam welding lines** Consists of one input roller table, main welding and straightening station, output roller table. On the main welding and straightening station there installed with flux recovery units, welding head with torch and clamping devices for flange and web. The standard line also including the welding power sources, hydraulic station and control operation box.

1. Standard ZHJ **3-in 1 H beam welding lines**



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K View



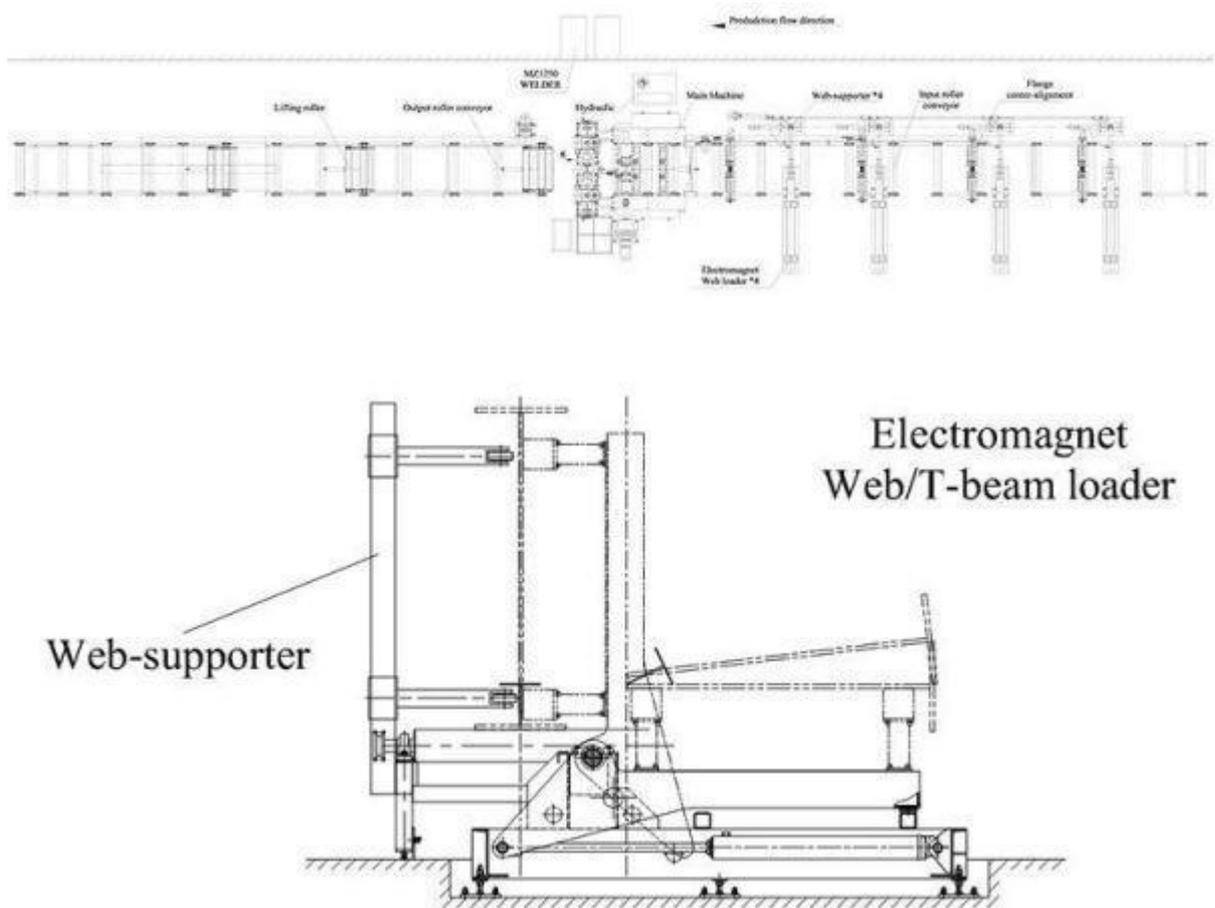
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2. OPTION 1:

As per different requests from customers, we also provide the configuration for the ZHJ 3-in 1 H beam welding lines as the following:

Based on the standard 3-in-1 H beam welding lines, there add one set of web-loader, which consists of 4 pcs of magnet loading arm and 4pcs of web supporter. On each web loading arm there are 2pcs of magnet for holding the steel web plate.

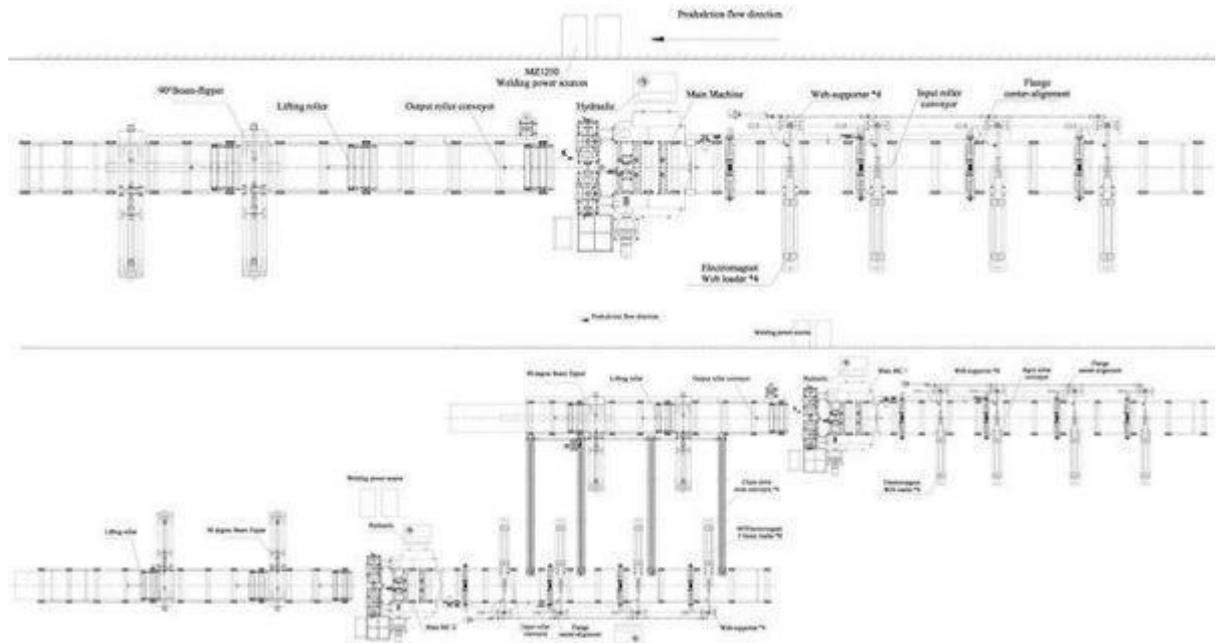


3. OPTION 2:

As per different requests from customers, we also provide the configuration for the ZHJ 3-in 1 H beam welding lines as the following:

Based on the standard 3-in-1 H beam welding lines, there add one set of web-loader, which consists of 4 pcs of magnet loading arm and 4pcs of web supporter. On each web loading arm there are 2pcs of magnet for holding the steel web plate.

Based on above, we can add one set of 90 degrees beam flipper on the output roller table for overturn the welded beam in horizontal position.



3. OPTION 3:

Some customers may need to increase the production output, they need one welding line to consists of 2 sets of welding station. The first welding station for welding 1st flange and web to form a T beam, the 2nd one for welding the welded T-beam and 2nd flange to form a H beam.

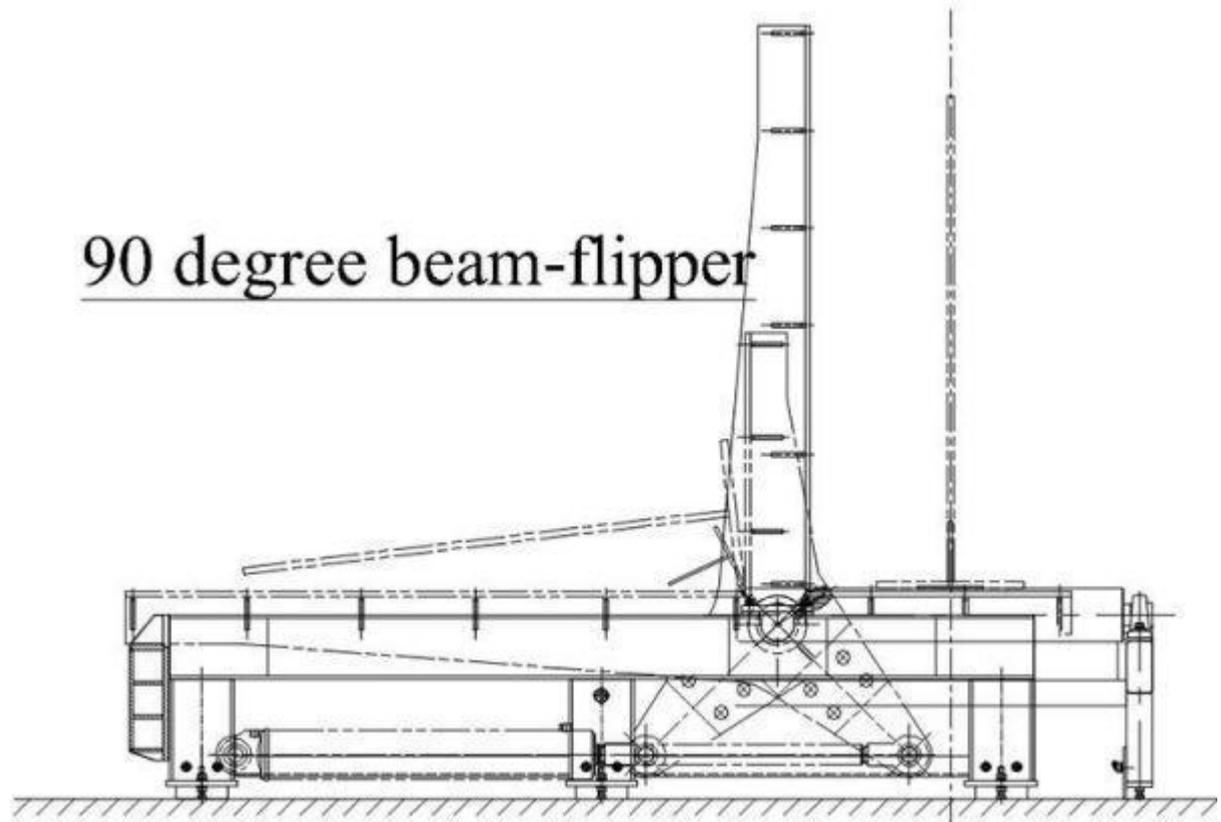
3.1 So Based on the standard 3-in-1 H beam welding lines, there add one set of web-loader, which consists of 4 pcs of magnet loading arm and 4pcs of web supporter. On each web loading arm there are 2pcs of magnet for holding the steel web plate.

3.2 To add one set of 90 degrees beam flipper on the output roller table of 1st welding station for overturn the welded beam in horizontal position.

3.3 To add a chain type cross conveyor to move the T-beam in horizontal to the 2nd welding station.



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3-in-1 Integrated H-beam welding lines installed in Users' factory

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