

A6 Mastertrac SAW (Single or Twin) and LAF 1001 power source

The universal welding automat for better welding economy!

The A6 Mastertrac Welding Package is designed to make your welding operation optimal and to increase the productivity and quality.

The tractor is four-wheel driven which ensures a constant and accurate travelling / welding speed even in inclined positions. The tractor carriage is equipped with a handle to disengage the clutch for quick movements of the A6 Mastertrac to a new position.

The most common welding method is Submerged Arc Welding (SAW) with single wire or twin wire. The LAF 1001 welding power source have excellent welding characteristics throughout the entire current and voltage range. Particularly good is the starting and re-ignition properties. All welding data are set and monitored from the process controller PEK.

Process controller PEK

The A2-A6 Process Controller can easily be pre-set by the user whereof the most will be able to use their native language. Manual control keys for wire feed and travel direction allow fast access to often used settings. Turn knobs allow easy adjustment of wire feed speed, voltage and travel speed during the process.

Up to 255 different parameter sets including secondary conditions can be stored and used during the welding process. These parameter sets can be given names and thus become easier to assign. PEK supports your system's maintenance and keeps track of its use.

Applications

- Butt welding of heavy flat plates
- Fillet welding of stiffeners
- Beam welding
- Heavy constructions of bridges



Productivity example

Manual MIG/MAG compared with Mechanized UP welding

- Horizontal welding: 70° V-joint, T=18 mm
- **Weight of weld metal:** 2 kg/m
- **Filler material**
 - MIG/MAG: OK 14.12, Ø 1.4 mm, mixed gas Ar+CO₂
 - Mechanized UP: OK Autrod 12.20 + OK Flux 10.71
- **Parameters**
 - manual welding: 250A, 28 V = 4 kg/hour
 - mechanized welding: 750A, 35V = 9 kg/hour
- **Welding length**
 - manual welding: 2 m/hour
 - mechanized welding: 4.5 m/hour
- **Arc time factor manual welding:** 20%
 - gives a welding length of 0.4 m/hour
- **Arc time factor mechanized welding:** 75%
 - gives a welding length of 3.35 m/hour

Increase in productivity: 737 %

Technical data

For technical data we refer to resp fact sheet:

A6 Mastertrac SAW	XA00143420
Process controller PEK	XA00143720
Power source LAF 1001	XA00143820



A2-A6 Process Controller PEK

Ordering information

Single

Qty.	A6 Mastertrac package
1	A6T Mastertrac SAW 156:1 with PEK (std)
1	Plastic wire reel
1	Power source LAF 1001
1	Wear Part Kit, Wire Diameter: 4.0 mm (A6 SAW)
Ordering number 0460 661 980	

Twin

Qty.	A6 Mastertrac package
1	A6T Mastertrac SAW 156:1 with PEK (std)
2	Plastic wire reel
1	Power source LAF 1001
1	Contact jaw 2x2.0 mm
1	Feed roller Twin 2x2.0 mm
Ordering number 0460 661 981	

15 m

Qty.	Cable package for LAF 1001
2	Welding Cable 15 m, Area: 95 mm ²
2	Return Cable 10 m, Area: 95 mm ²
1	Control cable 15 m PEK – LAF/TAF
1	Reference cable, 10 m
2	EG 600 Earth lead clamp
Ordering number 0460 663 980	

24 m

Qty.	Cable package for LAF 1001
2	Welding Cable 24 m, Area: 95 mm ²
2	Return Cable 10 m, Area: 95 mm ²
1	Control cable 25 m PEK – LAF/TAF
1	Reference cable, 10 m
2	EG 600 Earth lead clamp
Ordering number 0460 663 981	

35 m

Qty.	Cable package for LAF 1001
2	Welding Cable 38 m, Area: 95 mm ²
2	Return Cable 10 m, Area: 95 mm ²
1	Control cable 35 m PEK – LAF/TAF
1	Reference cable, 10 m
2	EG 600 Earth lead clamp
Ordering number 0460 663 982	

Accessories, Spare parts and Wear parts are handled in separate documentation

Address field

