

CR14E Heavy Idler Welder Specifications

MACHINE DIMENSIONS

	Weight	Width	Height	Length
Main Frame (w/ Hopper)	7750 lbs (3525 kg)	124 in (1,8 m)	184 in (4,7 m)*	120 in (3,0 m)
Power Supplies (X 2)	720 lbs (330 kg) each	24 in (0,7 m)	28 in (0,7 m)	38 in (1,0 m)
Flux Recovery Pump	200 lbs (90 kg)	19 in (0,5 m)	30 in (0,8 m)	37 in (1,0 m)
Water Cooling System (Optional)	150 lbs (70 kg)	15 in (0,4 m)	27 in (0,7 m)	30 in (0,8 m)

* Machine Height with Optional Pressurized Flux Recovery – 144 in (3,6 m)

Operating Temperature Range 40° to 110° F (4° to 43° C)

IDLER DIMENSIONS

Maximum Weight.....	14,000 lbs (6360 kg)
Maximum Diameter.....	84 inches (2,13 m)
Minimum Diameter	28 inches (0,71 m)
Maximum Width	22 inches (0,56 m)

IDLER DRIVE SYSTEM

Motor Type	3/4 Hp DC with 2400 : 1 Reduction
Torque	2000 lb-ft (2710 N-m)
Speed Range	0.08 to 0.75 rpm

IDLER CLAMPING SYSTEM

Hydraulic Clamping Force 0 to 12000 Pounds (5450 kg force)

IDLER TILT

Tilt Range 45° CCW to 45°CW

WELDING POWER SUPPLIES

Two Lincoln DC-655 Welding power supplies -		Power Requirements - (26.0 kVA each)	
Output		Voltage	Current
Maximum Current	650 Amperes	230 Volts	122 Amperes each
Maximum Voltage	50 Volts	380 Volts	75 Amperes each
Duty Cycle.....	100%	460 Volts	61 Amperes each

Other Welding Power Supplies available upon Request

STANDARD (Gravity-Feed) FLUX RECOVERY SYSTEM

Flux Pump Type.....	2-Lobe "Roots" Type	Power Requirements - (1½ Hp 1.1 kW)	
		Voltage	Current
Flux Hopper Capacity.....	4900 in ³ (81 liters)	230 Volts	5.4 Amperes
		380 Volts	3.0 Amperes
		460 Volts	2.7 Amperes

Other voltages Available

WIRE PAY-OUT PAK

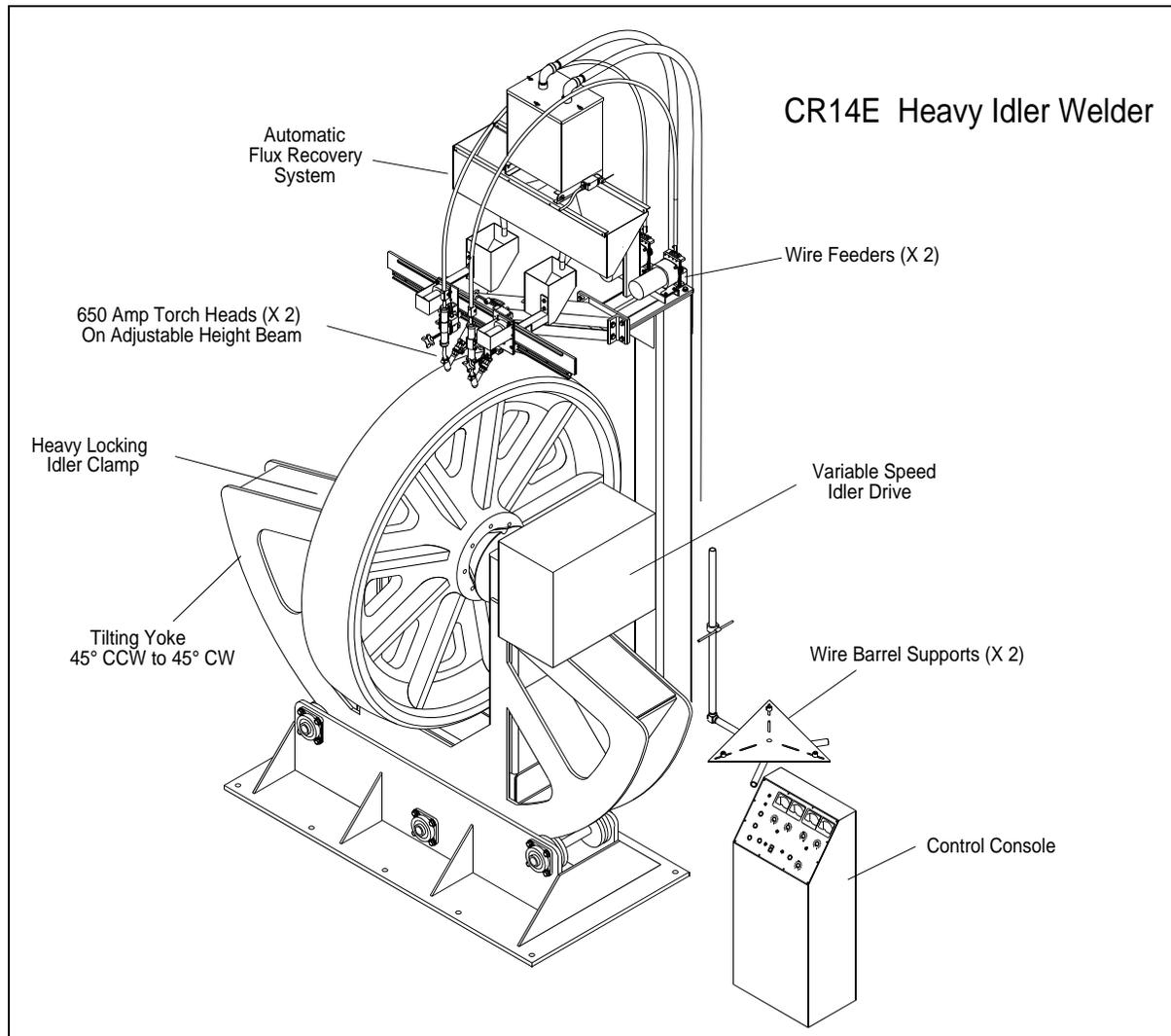
Two Pay-out Paks -

Capacity sized for all popular welding wire barrel containers

Maximum Wire Barrel Diameter	24 in (628 mm)
Minimum Wire Barrel Diameter	6 in (152 mm)
Maximum Wire Barrel Weight	1200 lb (540 kg)

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

Machine Overview



Power Yoke Tilt – rotates the idler 45° CW and CCW for flange welding.

Variable Idler Drive – rotates the idler with accurate, adjustable speed control.

Automatic Flux Recovery System and Flux Catch Hopper - recycle unused shielding flux.

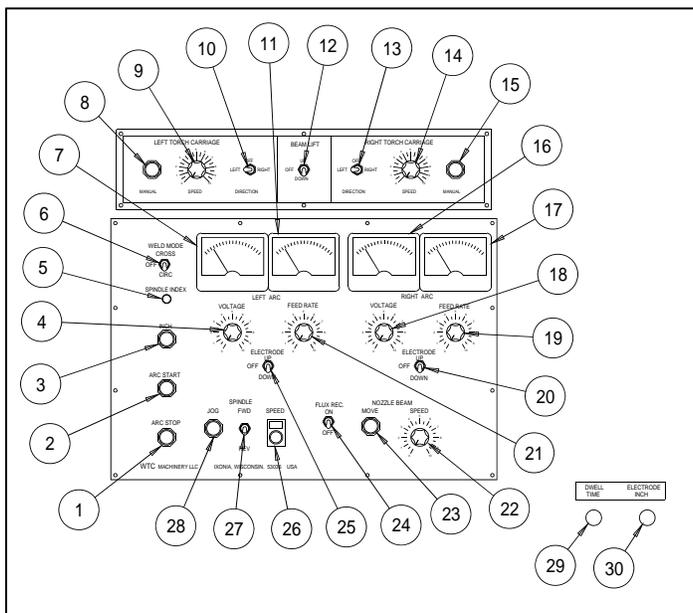
Heavy Locking Idler Clamp – holds the idler with secure clamping force.
Adjustable centering cones clamp idlers up to 22" (0,56 m) wide.

Wire Barrel Supports – hold two wire barrels up to 24" (628 mm) diameter, and 1,200 lbs (540 kg) weight.

Torch Heads – the torches are fully adjustable, and include automatic step-over.

Control Identification (Continued)

- 1) ARC STOP - Stops the welding cycle
- 2) ARC START - Starts the welding cycle
- 3) INCH - Manually moves the Left and Right welding wire, at the speed set by the Electrode Inch Control (30)
- 4) LEFT VOLTAGE - Controls the voltage of the Left Torch Head – shown on the Left Voltmeter (7)
- 5) SPINDLE INDEX - Lights at the Step-over point
- 6) WELD MODE - selects the welding mode : CIRC (Circumferential or Stringer) Mode constantly turns the idler or roller beneath the torch heads. Once every revolution the torches step to the left or right to overlap the previous weld bead.



CROSS Mode moves the torch heads left and right over the roller or idler. At each end of the torch travel, the idler or roller turns briefly, overlapping the previous weld bead.

- 7) LEFT VOLTMETER - Displays the voltage of the Left Torch Head, as set by the Left Voltage Control (4)
- 8) LEFT TORCH CARRIAGE MANUAL – Moves the Left Torch Carriage in the direction set by the Left Torch Carriage Direction Switch (10)
- 9) LEFT TORCH CARRIAGE SPEED – Sets the speed for the Left Torch Carriage both for manual moves and for automatic step-over. The Nozzle Beam Speed Control (22) also affects to the Left Torch Carriage speed.
- 10) LEFT TORCH CARRIAGE DIRECTION – Sets the direction of the Left Torch Carriage, for both manual moves and for automatic step-over
- 11) LEFT WIRE FEED METER - Shows the speed of the Left welding wire, as set by Electrode Inch (30) and Left Feed Rate Control (21) This is directly related to the amperage and size of the left weld bead.
- 12) BEAM LIFT - Raises and lowers the Upper Beam, along with the Left and Right Torch Heads
- 13) RIGHT TORCH CARRIAGE DIRECTION – Sets the direction the Right Torch Carriage moves both for manual moves and automatic step-over
- 14) RIGHT TORCH CARRIAGE SPEED – Sets the speed for the Right Torch Carriage, both for manual moves and for automatic step-over. The Nozzle Beam Speed Control (22) also affects to the Right Torch Carriage speed.
- 15) RIGHT TORCH CARRIAGE MANUAL – Moves the Right Torch Carriage in the direction selected by the Right Torch Carriage Direction Switch (13)

Control Identification (Continued)

- 16) RIGHT VOLTMETER - Shows the Right Torch Head voltage, as set with the Right Voltage Control (18)
- 17) RIGHT WIRE FEED METER - Shows the speed of the Right welding wire, set by Electrode Inch (30) and Right Feed Rate Control (19). This is directly related to the amperage and size of the right weld bead
- 18) RIGHT VOLTAGE - Controls the voltage of the Right Torch Head – shown on the Right Voltmeter (16)
- 19) RIGHT FEED RATE - Sets the speed of the Right welding wire, once welding begins. The speed is shown on the Right Feed Rate Meter (17), and controls the amperage and size of the right weld bead.
- 20) RIGHT ELECTRODE UP/OFF/DOWN - selects the direction of the right welding wire. Welding happens in the DOWN position
- 21) LEFT FEED RATE - Sets the speed of the left welding wire, once welding begins. The speed is shown on the Left Feed Rate Meter (10), and controls the amperage and size of the left weld bead.
- 22) NOZZLE BEAM SPEED – Master control for the speed of the left and right torch carriages. move from side-to-side
- 23) NOZZLE BEAM MOVE - Manually moves both the left and right torch carriages in the directions set by the Left and Right Torch Direction Switches. Use this to set and check the step-over distance.
- 24) FLUX RECOVERY ON/OFF - Starts and stops the flux recovery system
- 25) LEFT ELECTRODE UP/OFF/DOWN - Sets the direction of the left welding wire. Welding happens in the DOWN position
- 26) SPINDLE SPEED - Sets how fast the idler turns
- 27) SPINDLE FWD / REV - Sets whether the idler rotates forward (top away from the front) or reverse (top towards the front)
- 28) SPINDLE JOG - Manually rotates the idler or roller
- 29) DWELL TIME (Right Side of Control Console) - Sets how long Left and Right Torch Carriage travel (or “Step-over”) after each turn of the idler or roller (the “Step-over Point”)
- 30) ELECTRODE INCH - sets how fast the left and right welding wire moves before an arc is struck. This is usually set to 30, but increased when loading and unloading welding wire.



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MANUFACTURERS/BENEFICIARY'S WARRANTY CERTIFICATE WTC MACHINERY, LLC WARRANTY

WTC MACHINERY, LLC warrants its products to be free from defects in material and workmanship under normal use and service for a period of twelve (12) months after date of shipment. WTC MACHINERY, LLC undertakes to be responsible for any defect that may arise due to faulty raw materials, design, workmanship and defective parts and to replace them without extra cost. Freight charges are the customer's responsibility. Our warranty is not transferable.

WTC MACHINERY, LLC shall have the option of requiring the return of all parts claimed defective. Parts proved to be defective, due to defect in workmanship and/or material, shall be either repaired or replaced free of charge, F.O.B. our designated factory. All parts warranty claims are subject to inspection by WTC MACHINERY, LLC and acceptance at the factory

Our warranty does not obligate us to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts and the removal and/or remounting of the parts repaired or replaced under this warranty, unless specifically authorized in writing by WTC MACHINERY, LLC. All parts returned to the factory must be shipped freight prepaid; no collect freight will be accepted by the factory. Forms authorizing such returns for inspection must accompany all returns.

This warranty shall not apply to products not manufactured by WTC MACHINERY, LLC.

Outside purchased equipment and accessories (not of WTC manufacture) are warranted only to the extent of the original equipment manufacturer's warranty and subject to their allowance to WTC MACHINERY, LLC. In this respect, our warranty obligations must conform and be limited to the warranty extended to WTC MACHINERY, LLC by its suppliers as extended to the customer.

We shall, in no event, be liable for consequential damages or contingent liability arising out of the failure of any unit or part to operate properly, or that is subject to:

- Ordinary operating wear, abuse, misuse, or overloading;
- Repairs or alterations by parties other than WTC MACHINERY, LLC;
- The use of improper fluids, contaminated fluids or improper filtering;
- The use of improper voltage hookup in the electrical connections of any equipment;
- Negligence, accident or damages due to deterioration during periods of storage by the purchaser prior to installation and operation;
- Damages occurred in shipment after leaving factory en route to customers' delivery point, as title to equipment passes to customer when loaded onboard for shipment, f.o.b. factory, and customer must place his own claim against damaged goods directly to the shipping company and not against WTC MACHINERY, LLC, its factory, or any of its personnel.
- Damages due to circumstances beyond the control of WTC MACHINERY, LLC and in connection with fulfilling any obligation under this warranty.

To the maximum extent permitted by applicable law, in no event shall WTC Machinery, LLC be liable for indirect, special, incidental or consequential damages resulting from personal injury, loss of business profits or business interruption from the use of its products, or from the inability to use its products.

This warranty is exclusive and is in lieu of all other expressed and implied warranties, including but not limited to implied warranties or merchantability and fitness for a particular purpose. WTC MACHINERY, LLC shall not be subject to any other obligations or liabilities whatsoever with respect to equipment manufactured or supplied by WTC MACHINERY, LLC, or services rendered to it.