

JETLINE SEAMERS

LWS SERIES

Jetline LWS Series Longitudinal Seam Welder



Jetline seam welders, also known as stake bed welders, horn welders, and flat sheet welder are designed for all straight line, linear welding applications. They can be used to weld tubes, cylinders, cones, flat sheets, sinks, tank shells, and open ended boxes. The following materials can be welded in a Jetline seam welder: aluminum, stainless steel, hastelloy, titanium, inconel, galvanized, aluminized, and other materials. Let the Weld Plus technicians outfit your new weld seamer with Tig, Mig or plasma arc welding equipment. Other options such as arc length controls, hot or cold wire feeders, 9500 control, manual or powered cross slides and seam trackers. We can install anything you will need to seam weld your longitudinal or circumferential parts.

Jetline seam welders include the following features:

- Shallow clamping structure design (enhances visibility).
- Reversible, copper finger tips.
- Adjustable mandrel for optimum material thickness adjustment.
- Toe touch clamping strips (operable from any point along the weld seamer length).
- Stress relieved track with case hardened travel carriage ways.
- Travel Carriage and Control.
- Retractable Edge Aligning Device.
- Back-Up Mandrel.
- Back-Up-Bar Inserts.
- Pressure Hold-down.
- Safety Switch.
- Continuous Hold-down Strips.



Precision is the hallmark of every Jetline seam welder. Special gages ensure the alignment of the weld joint. Custom designed chill bars control penetration and minimize distortion. As the welding head/carriage moves accurately along the seam, quenching or cooling is uniform along the joint. Consistent travel speed provides further assurance of an accurate, high quality butt weld with 100% (percent) penetration.

Optional Accessories:

- Retractable Tooling
- Arc Length Control
- Cold and Hot Wire Feeders
- 9500 System Controller
- Auto-Loading Seamwelder
- Jetline seamwelders can be supplied with TIG (gas tungsten arc welding), MIG (gas metal arc welding), PAW (plasma arc welding), or SAW (submerged arc welding)



WELD PLUS
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LONGITUDINAL SEAMERS

Unique side beam track uses case hardened roundways for smooth, precise carriage travel. Linear accuracy is within +0.015" (0.3mm) on the standard model

Cable support bracket. A flexible cable support system is optionally available to support all the hoses and cables to the carriage.

The travel carriage rides on the track using hardened bearings. The microprocessor controller provides precision speed control.

9627 Microprocessor-based travel speed controller is supplied as the standard control with all Jetline seam welders. The control interfaces with suitable power supplies for weld sequence control. Jetline offers a range of weld system controllers.

Various types of alignment gages are available for the accurate placement of the sheet.

Air-operated, clamping hose generates a clamping force of up to 5000 lb/ft (75 kg/cm).

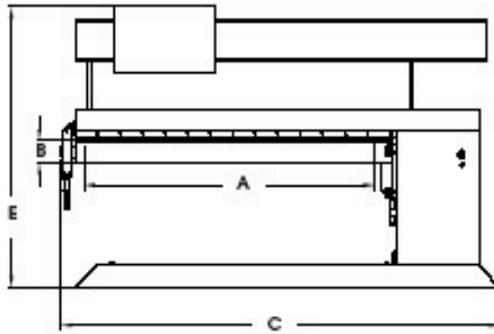
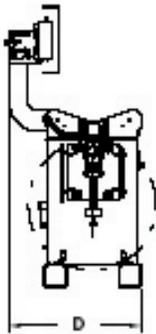
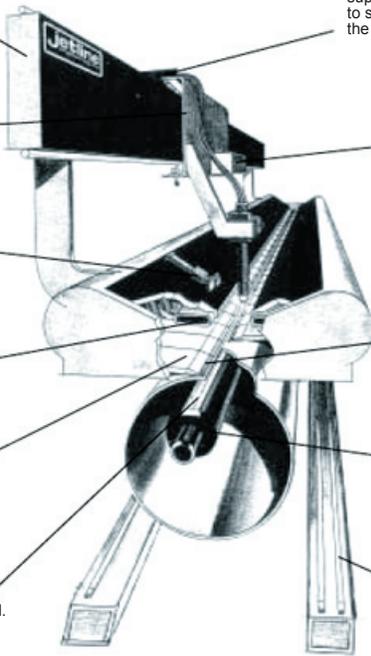
Dual-edged, replaceable copper finger tip. Precision machined for distortion-free welding.

Hold down fingers are aluminum to assist in the chilling of the weld joint. They are a precise width to assure consistent chill and to avoid aspiration of air in the critical applications.

Back-up mandrel, water cooling is optional, special mandrels are available on request.

Back-up bar insert. Grooved to specification. Made from copper, steel or stainless steel. Special configurations are available as required.

"Toe-Touch" tapeswitch control. Activates the finger clamping. A pendant control is optionally available.



LWS - Standard External Seamwelder

For all weldable metals
 For 0.020" to 3/8" (0.5 to 10mm) thickness
 Rack and pinion carriage drive
 Travel accuracy is ±0.015" (0.4mm) per 10 ft (3cm).

Model Number	Welding Length "A" Inches (mm)	Min. Dia. Piecepart "B" Inches (mm)	Overall Length "C" Inches (mm)	Overall Width "D" Inches (mm)	Welding Length "E" Inches (mm)	Shipping Wt. (Approx) Lbs. (kg)
LWS - 24	24 (610)	2 5/8 (67)	70 (1,780)	40 (1,000)	69 (1,750)	2,300 (1,040)
LWS - 36	36 (915)	3 1/2 (90)	82 (2,080)	40 (1,000)	69 (1,750)	2,600 (1,180)
LWS - 48	48 (1,220)	4 1/4 (180)	94 (2,390)	40 (1,000)	69 (1,750)	4,000 (1,815)
LWS - 60	60 (1,525)	5 1/4 (133)	106 (2,690)	40 (1,000)	69 (1,750)	4,700 (2,130)
LWS - 72	72 (1,830)	6 (152)	118 (3,000)	40 (1,000)	69 (1,750)	5,300 (2,400)
LWS - 84	84 (2,135)	6 7/8 (184)	130 (3,300)	40 (1,000)	69 (1,750)	5,900 (2,675)
LWS - 96	96 (2,440)	7 1/4 (184)	142 (3,605)	40 (1,000)	69 (1,750)	6,400 (2,900)
LWS - 120	120 (3,050)	9 1/2 (241)	176 (4,470)	42 (1,070)	76 (1,930)	12,000 (5,450)
LWS - 144	144 (3,660)	12 1/4 (311)	200 (5,080)	42 (1,070)	76 (1,930)	13,000 (5,900)
LWS - 168	168 (4,270)	15 1/4 (387)	224 (5,690)	42 (1,070)	76 (1,930)	14,000 (6,350)
LWS - 192	192 (4,875)	18 1/2 (470)	248 (6,300)	42 (1,070)	76 (1,930)	15,000 (6,800)
LWS - 216	216 (5,485)	21 1/4 (540)	272 (6,900)	42 (1,070)	76 (1,930)	16,000 (7,250)
LWS - 240	240 (6,100)	24 1/4 (616)	296 (7,500)	42 (1,070)	76 (1,930)	17,000 (7,700)