

KOIKE

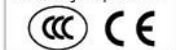
Submerged Arc Welding



ISO9001:2000 Quality Management System Certification
No. : 03409Q10661R11M



GSN CCC Compulsory Certification
PASS Through European CE Mark



E Series

Thyristor controlled DC
SAW power source

SAW
Welding

DC AIR
GOUGING

ESW

100% Duty Cycle

Suitable for long-time
high-current welding!



■ The convincing high reliability (E/B Series)

- 200°C insulation, main transformer and reactor coil are insulated by US DuPont Nomex(R) Paper and Japanese HITACHI-Chemical insulating varnish with high insulation, high temperature resistance and dust tightness.
- Main circuit with perfect performed SCHNEIDER AC contactor, featuring no-load current pull-in, fully enclosed structure, high stability and reliability.
- Main circuit with LEM brand current transformer, featuring high temperature resistance, anti-interference, monitoring the current output from the interphase of balancing reactor, which protects the main transformer effectively.
- The protection prevents damage to the PCB from internal short of control cable, short between control cable and the workpiece or the output cable.
- Anti-interference of high frequency, which prevents damage to the PCB caused by high frequency and voltage generated by the working TIG welder around the SAW machine.
- Protection Class-IP21S, featuring physical insulation between main circuit and control circuit, which prevents the control circuit from being interfered by the main circuit, the whole structure has excellent damp resistance, anti-dipping and dust tightness.

■ The effective protection (E/B Series)

- The protection against overheat, overcurrent, lose phase, undervoltage and overvoltage etc. prevents the broken from accidents.

■ Other features (E/B Series)

- Input voltage compensation
- Multifunctional welding machine(E/B Series)
- Multi-output design, suitable for SAW, gouging and ESW etc.



E Series Control Panel

■ Rated specifications(E Series)

Model	ZD5-630E	ZD5-1000E	ZD5-1250E	ZD5-1600E	
Control Mode	-	Thyristor			
Rated Input Voltage, Phase	-	AC380V*, 3 phases			
Input Power Frequency	Hz	50			
Rated Input Capacity	kVA	43	69	89	112
Rated Output Current	A	630	1000	1250	1600
Rated Output Voltage	V	44			
Rated Duty Cycle	%	100			
Rated No-load Voltage	V	72	74	75	75
Output Current Range	A	100-630	200-1000	250-1250	300-1600
Output Voltage Range	V	24-44	28-44	30-44	32-44
Protection Class	-	IP21S			
Insulation Class	-	200°C			
Cooling Mode	-	Forced convection			
Dimension (LxWxH)	mm	840x570x860	880x590x925		980x670x1060
Weight	kg	260	310	330	460

*Other voltages are optional but orderingly mentioned additionally.

F1 Series

Standard SAW tractor



Widely applicable
single wire SAW tractor



F10 SAW tractor

The excellent welding operation

- Digital display, easy for reading.
- Welding voltage, current and speed can be preset before welding with perfect weld consistency.
- Touch sense function, together with precision wire retracting function, can make 100% arc striking rate.



Rated specifications

Model		MZC-630F10	MZC-1250F19	MZC-1600F10
Applicable wire diameter	mm	2.0/2.4/3.2/4.0	2.4/3.2/4.0/4.8	3.2/4.0/4.8/6.4
Current range	A	150-630	200-1250	300-1600
Arc striking mode	-	Retracting / Scraping		
Wire feed speed	m/h	30-300	20-200	16-160
Welding speed	m/h	9-75		
Cross slide board adjustment	mm	100x120 (Vertical x Horizontal)		
Base board adjustment	mm	70		
Rotating angle	-	360°		
Adjustable angle of the welding head	-	45°		
Front-and-back adjustment of welding head	-	45°		
Flux capacity	L	8		
Wire reel capacity	kg	25		
Dimension (LxWxH)	mm	900x520x850		
Net weight	kg	68		

- Crater current, voltage and flashback time are adjustable to set crater parameters.
- Polarity can be set to positive and negative for different welding process request.
- The arc striking mode can be selected from touch or scratch through panel.
- Laser indicator can be used in dark area for pointing out the groove, and meanwhile avoid the visual bias.
- Specific nozzle design for more sufficient flux covering.
- Wire spool with rotatable resistance prevents wire reel from mess when welding.
- Openable wire support makes the wire installation more convenient and faster.

Welding Mode

Flat position welding

Fillet welding in the flat position with side guiding ※1

Inside and outside welding of longitudinal and girth weld

Flat fillet welding ※2

Fillet welding in the flat position with guide rails ※2

※1. Side guide components and extended support is needed additionally. Order number: MZC-□□□□02 or standard tractor with option of part CVN2202.

※2. Extended support is needed additionally.

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Single electrode submerged arc welding machine



Laser indicator



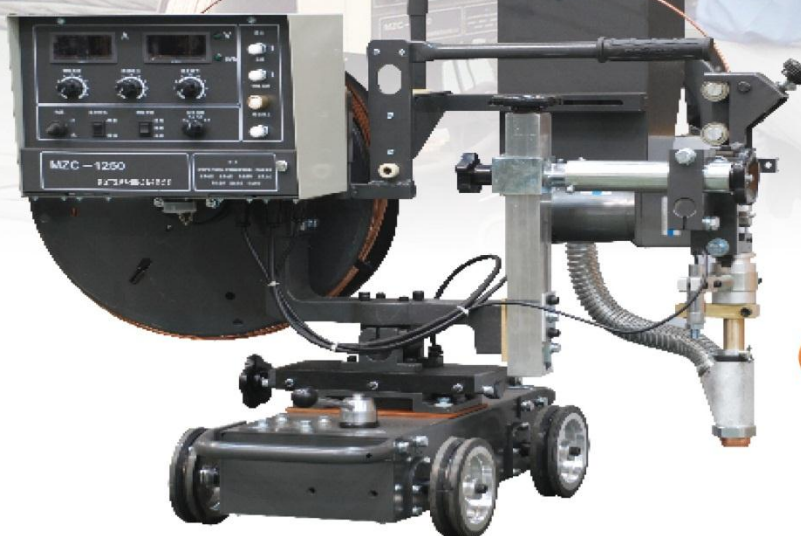
Digital display



Touch sense



Preset function



Widely applicable
single wire SAW tractor



ZD5-1000E

Wide applied in shipbuilding, pressure vessel, steel fabricator, oceanengineering and wind tower industries.

■ Rated specifications

Model		MZC-1250F19
Applicable wire diameter	mm	2.4/3.2/4.0/4.8
Current range	A	200-1250
Arc striking mode	-	Retracting / Scraping
Wire feed speed	m/h	20-200
Welding speed	m/h	9-75
Cross slide board adjustment	mm	100x120 (Vertical x Horizontal)
Base board adjustment	mm	70
Rotating angle	-	360°
Adjustable angle of the welding head	-	45°
Front-and-back adjustment of welding head	-	45°
Flux capacity	L	8
Wire reel capacity	kg	25
Dimension (LxWxH)	mm	900x520x850
Net weight	kg	68

Model		ZD5-1000E
Control Mode	-	Thyristor
Rated Input Voltage, Phase	-	AC380V*, 3 phases
Input Power Frequency	Hz	50
Rated Input Capacity	kVA	69
Rated Output Current	A	1000
Rated Output Voltage	V	44
Rated Duty Cycle	%	100
Rated No-load Voltage	V	74
Output Current Range	A	200-1000
Output Voltage Range	V	28-44
Protection Class	-	IP21S
Insulation Class	-	200°C
Cooling Mode	-	Forced convection
Dimension (LxWxH)	mm	880x590x925
Weight	kg	310

*Other voltages are optional but orderingly mentioned additionally.

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CAUTION

● Read the manual instruction carefully before using!

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