

## Strip Cladding System

### Weld Overlay Application for Cap Seal, Shell and Pipe

Electro Slag Strip Cladding (ESSC) is a process of overlaying special material on base material (carbon steel) to enhance operating life and prevent corrosion wherein strips as a filler material is deposited using Electro Slag Strip Cladding (ESSC) or Electro Slag Welding (ESW) process. The set up required for this contains a heavy duty SAW power source compatible for ESW / Cladding, a suitable Cladding Head for the matching strip width (mounted on column and boom), weld controller, water cooling arrangement for the cladding head (option), flux heating system (option) and flux recovery system (option).

#### Salient Features

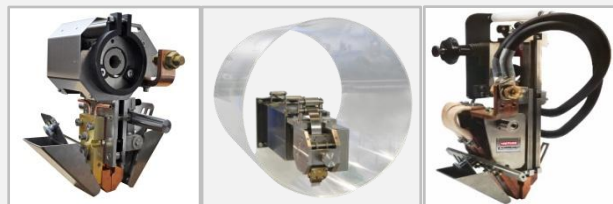
- Suitable for circumferential and longitudinal cladding applications.
- Patented Strip Cladding Head with state of the art technology ensures consistent bead finish / deposition layer after layer.
- Unique strip feed roller design ensures smooth and reliable feeding and eliminates slippage and feeding issues.
- Digital and user-friendly control panel for setting parameters.
- Options available to enhance quality and productivity e.g. flux heating / recovery system and magnetic steering

#### Application Segments

- Nuclear
- Pressure Vessels
- Oil and Gas
- Power Plant Equipment



**Cap Seal Strip Cladding System**



**Various Cladding Applications**

Strip Cladding Head	Cladding Application	Strip Width	Pipe Diameter
KSC-30L	Tiny long strip cladding	15, 20, 30 mm	OD≥220 mm, ID≥360 mm
KSC-30C	Tiny circumferential strip cladding	15, 20, 30 mm	OD≥220 mm, ID≥360 mm
KSC-60L	Medium long strip cladding	30, 60 mm	OD≥220 mm, ID≥400 mm
KSC-60C	Medium circumferential strip cladding	30, 60 mm	OD≥220 mm, ID≥600 mm
KSC-90	Strip Cladding	30 ~ 90 mm	OD≥220 mm, ID≥1000 mm

#### Note

- 1) Outer Diameter (OD) and Inner Diameter (ID) values mentioned above are relevant for outer and inner cladding respectively.
- 2) Magnet steering is recommended for strip width ≥60mm, additional parts are available for 120mm strip against requirement.

## POWER SOURCE FOR STRIP CLADDING – ZD5-1200EJ/1600EJ

These are heavy duty Thyristor (SCR) controlled CC/CV power sources suitable for Electro Slag Strip Cladding (ESSC) / Electro Slag Welding (ESW) apart from Submerged Arc Welding (SAW), Carbon Air Arc Gouging (CAAG). Backed by proven performance, rugged and reliable design along with a wide range of protective features make it an ideal choice for customers.

### Salient Features

- Heavy Duty – up to 1600A / 100%
- Operating Mode – CC/CV
- Suitability – ESSC, ESW, SAW, CAAG
- Digital Display – V/A
- In-built Protections
  - Over Current
  - Over Heat
  - Over / Under Voltage
  - Phase Fault
  - Control Cable Short Circuit
  - High Frequency (HF) interference
- Operation at high ambients

*40,000+ machines  
world wide*

*High Reliability  
Heavy Duty*



Technical Specifications	ZD5-1200EJ	ZD5-1600EJ
Control Mode	Thyristor	Thyristor
Mains supply	415V±20%, 3Ph, 50Hz	415V±20%, 3Ph, 50Hz
Rated input power	83KVA	112KVA
Rated no load voltage	74V	75V
Output current range	200 – 1200A	300 – 1600A
Full load rating	1200A / 70%	1600A / 100%
Continuous load	1000A / 100%	1600A / 100%
Protection class	IP21S	IP21S
Insulation class	200°C	200°C
Dimensions, l x w x h	880 x 590 x 925 mm	980 x 670 x 1060 mm
Weight	310 Kg	460 Kg

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