

Re-Tubing of Heat-Exchangers at Texaco's Refinery

Application:

- Tube-to-tubesheet

Material:

- 0.75" diameter, 12BWG tubes of ASTM A249
- 1225 mm diameters, 208 mm thick ASTM 182 tubesheet

Welding Equipment:

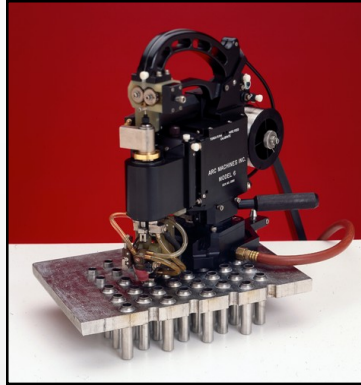
Weld Head::

- Model 6

Benefits:

- ✓ 8,016 tubesheet welds in just 10 days
- ✓ Exceeded strict quality requirements
- ✓ Completed project ahead of deadline

For further information, call AMI at 1-818-896-9556 or e-mail sales@arcmachines.com



Model 6



For a critical shutdown at Texaco's Pembroke refinery, Unit Superheater Engineering Ltd., of Swansea, UK, performed above expectations with the help of orbital tube-to-tubesheet welding equipment from Arc Machines, Inc., Pacoima, California.

Under time pressure to re-tube six exchangers, Unit Superheater Engineering used Arc Machines' orbital tube-to-tubesheet welding systems to make 8,016 tubesheet welds in just 10 days.

The 0.75" diameter, 12BWG tubes of ASTM A249 material were welded into the 1225 mm diameter, 208 mm thick ASTM 182 tubesheet using a 2-pass procedure, with filler wire. Two shifts of orbital machine operators welded for 12 hours a day to finish the work in the 10 days allotted. The welding was completed in advance of Texaco's deadline and met or exceeded their strict quality requirements.

This partnership of a reliable, technologically forward-thinking company like Unit Superheater Engineering and state of the art orbital welding equipment from Arc Machines, Inc. makes difficult jobs with strict performance requirements possible.

To read the full story, visit www.arcmachines.com



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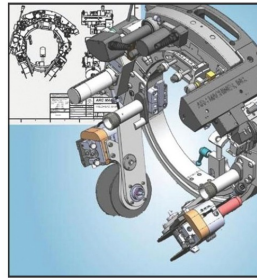
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Cutting Edge Narrow-Groove
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Turnkey Integrated Systems

Advanced Products, Systems & Solutions



With over 3000 customer relationships in over 50 countries, Arc Machines, Inc. has set the standard for Automated Orbital Welding Equipment for over 30 years, combining Quality and Durability with Innovative Engineering and Design. Around the world, leading manufacturers and contractors rely on AMI for their expertise in automated orbital welding and to develop customized solutions for new welding challenges.

www.arcmachines.com

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M6 Tubesheet Weld Head

QUICK SPECS

AVC Stroke

Automatic

Wire Feed Speed

5 - 100 IPM
(13 - 254 cm/min.)

Rotation Speed

0.1 - 10.0 RPM

Tungsten Size:

1/16" or 3/32"
(1,6 mm or 2,4 mm Ø)

Weld Current

200 A (maximum)

Torches

Water-cooled, 200 A
100% Duty Cycle

Wire Manipulator

Vertical, Horizontal and
Angular

Weight

16 lbs. (7,3 kg) less cables

- Gas chamber for welding titanium available
- Compatible with AMI Model 227 and 415 Power Supplies

