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Complete Range Welding & CNC Cutting Equipment

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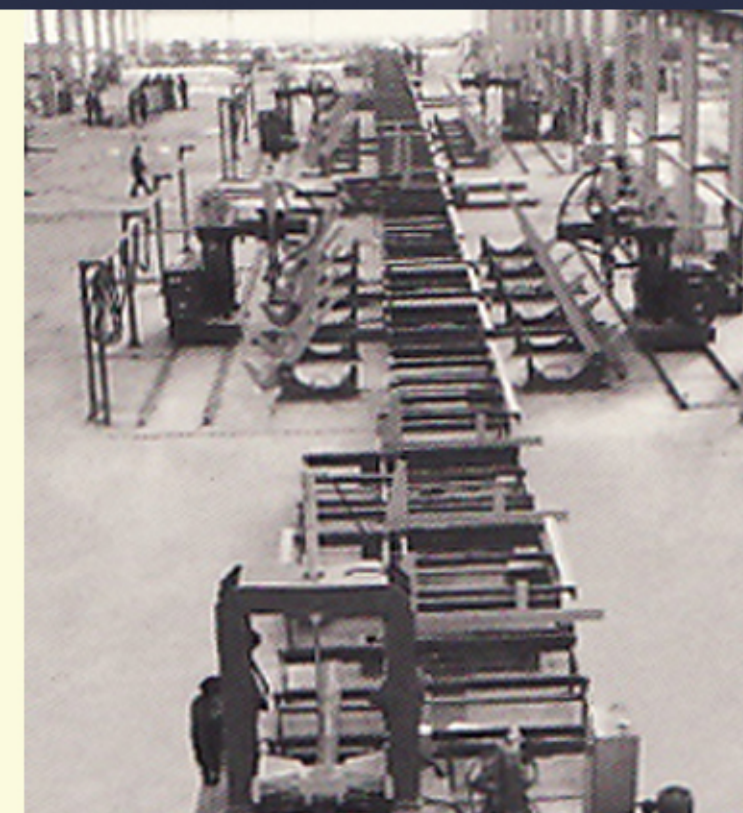
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complete set of welding
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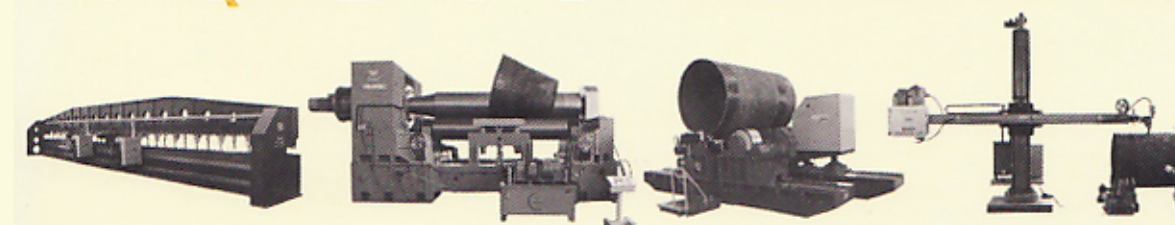


Galaksi Metal Mesindo^{PT}
Complete Range Welding & CNC Cutting Equipment

H-Beam production line



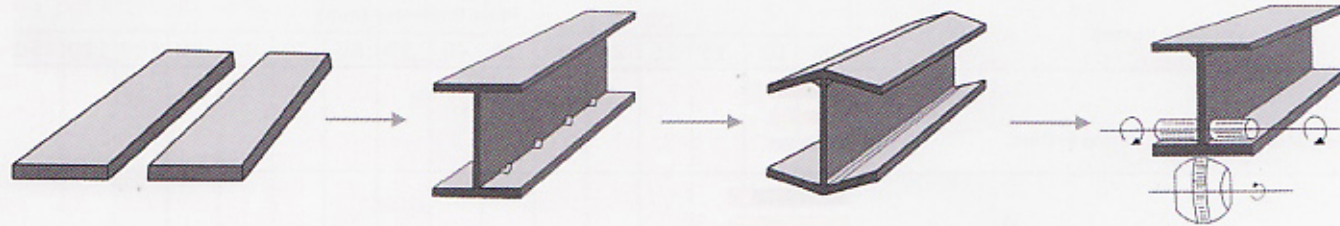
WELDING EQUIPMENT



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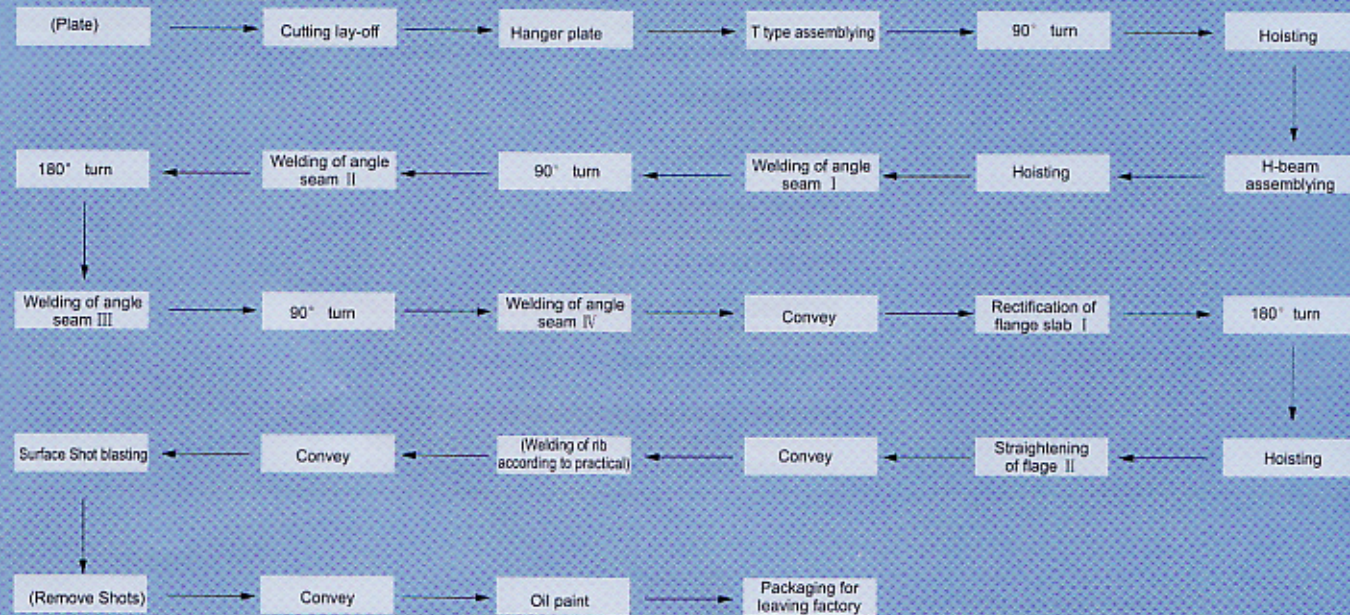
H-BEAM (LIGHT DUTY) PRODUCTION LINE



Multiple tip gas cutting machine H beam assembling machine The gantry submerged arc welding machine H-beam straightening machine

The production line of common H type steel is made up of some mainly equipment such as multiple tip gas cutting machine, H-beam assembling machine, the gantry submerged arc welding machine, straightening machine and shot blasting machine etc. It is much flexible and can be operated independently by single machine on the manufacturing technology. In order to improve whole operating efficiency, it also can be added some devices discretionarily at different parts of technology.

Steel structure Production Line



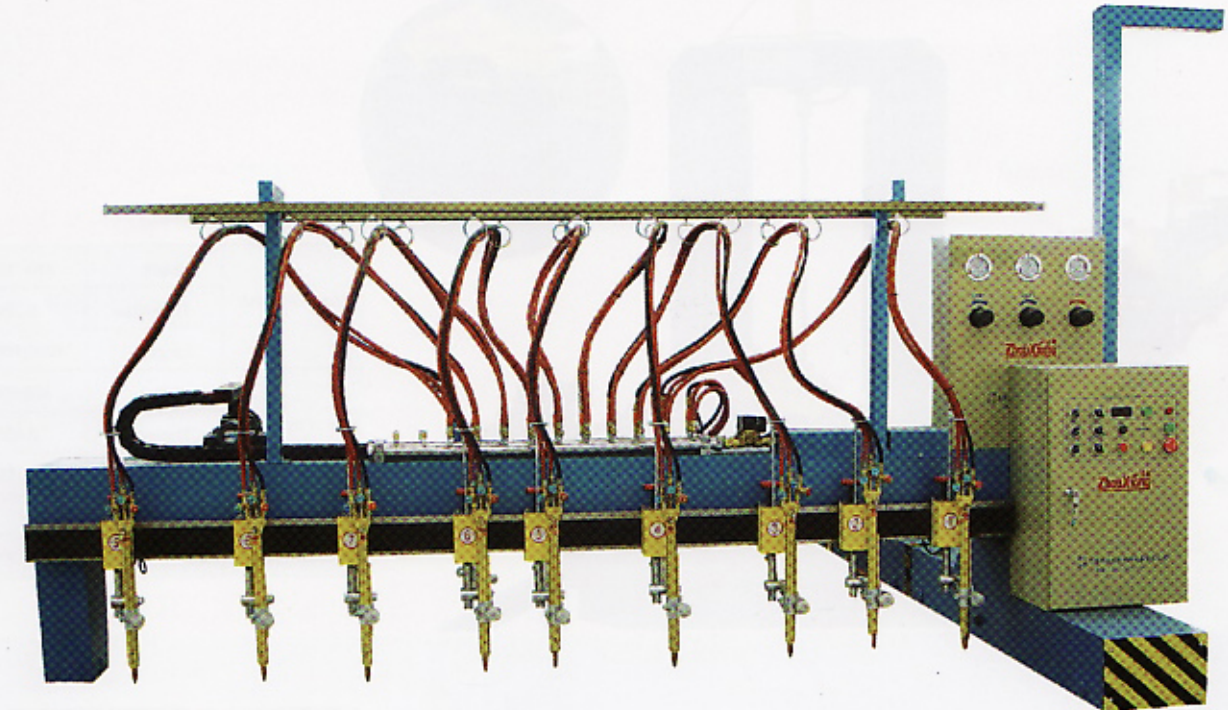
Steel structure Production Line



MULTI-HEAD STRIP CUTTING MACHINE

TECHNICAL PERFORMANCE

This machine is a kind of plate-cutting machine in high efficiency for straight plate, which the longitudinal cutting guns can be deployed according to the requirement. Many pieces of plates can be cut at same time accompanied by oxygen acetylene gathering arrays to avoid changing the gas bottles frequently. The AC frequency converter technology is accepted for speed-controlling with safe operating and reliability.



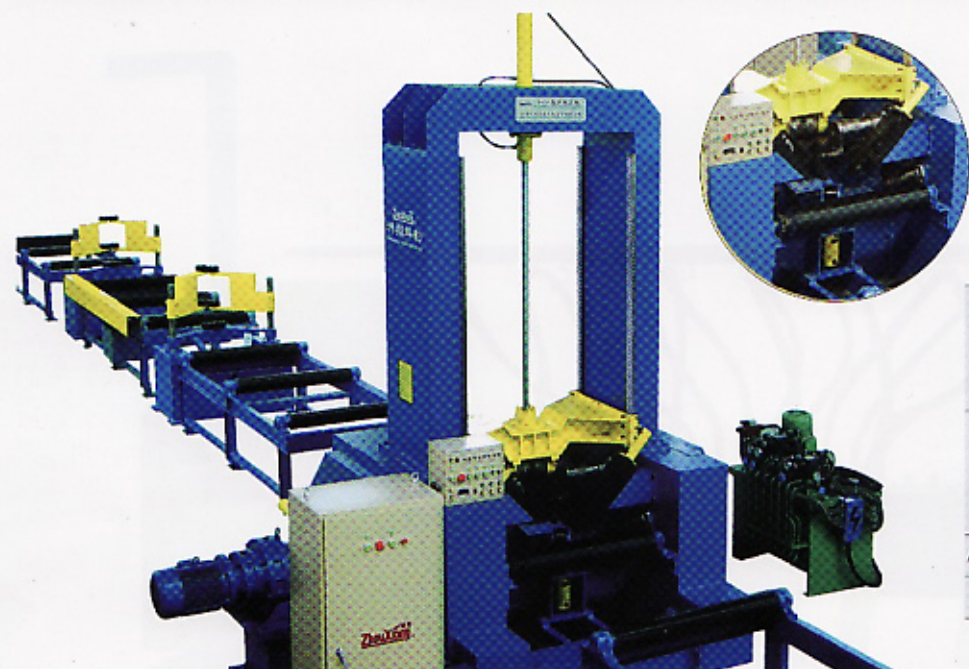


Steel structure Production Line

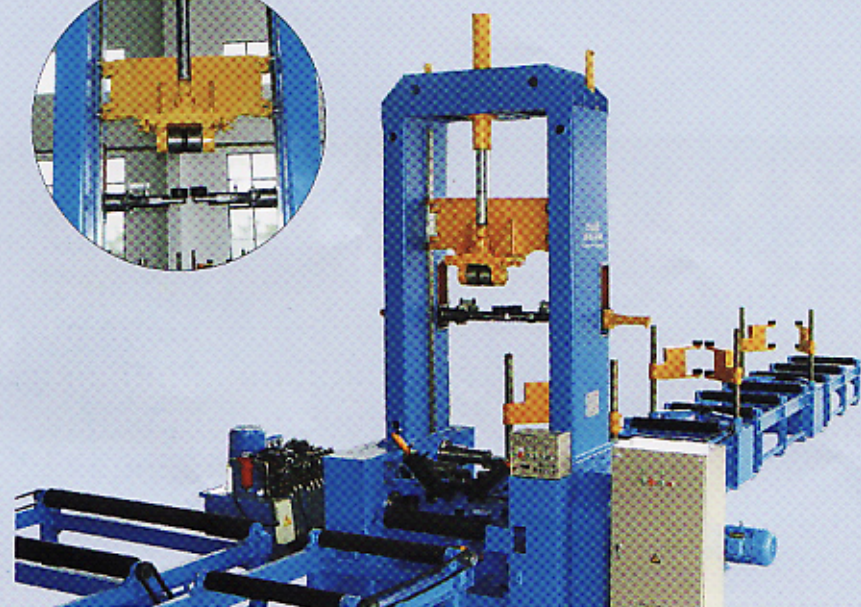
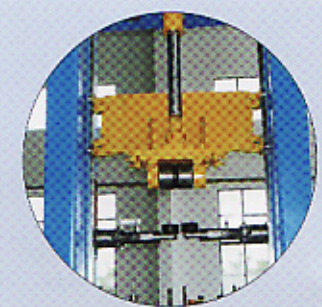
VERTICAL ASSEMBLY MACHINE FOR H-BEAM

TECHNICAL PERFORMANCE

The vertical assembly machine which the flange, web fastening and calibrating, positioning, and auto spot welding equipped, all of which accept the Japanese Mitsubishi programmable controller and the AC frequency converter so as to increase the productivity one times above comparing with common products, with the features of stable and reliable working state and the welding gun is equipped by the arc-tracing device to ensure the quality of spot welding.



Size of the web	Height	200-1500mm
	Thickness	6-32mm
	Length	4000-15000mm
Size of the flange	Width	200-800mm
	Thickness	6-40mm
	Length	4000-15000mm
Assembling speed	0.5-6m/min	
Power Overall	(Two welding machines are excluded)	



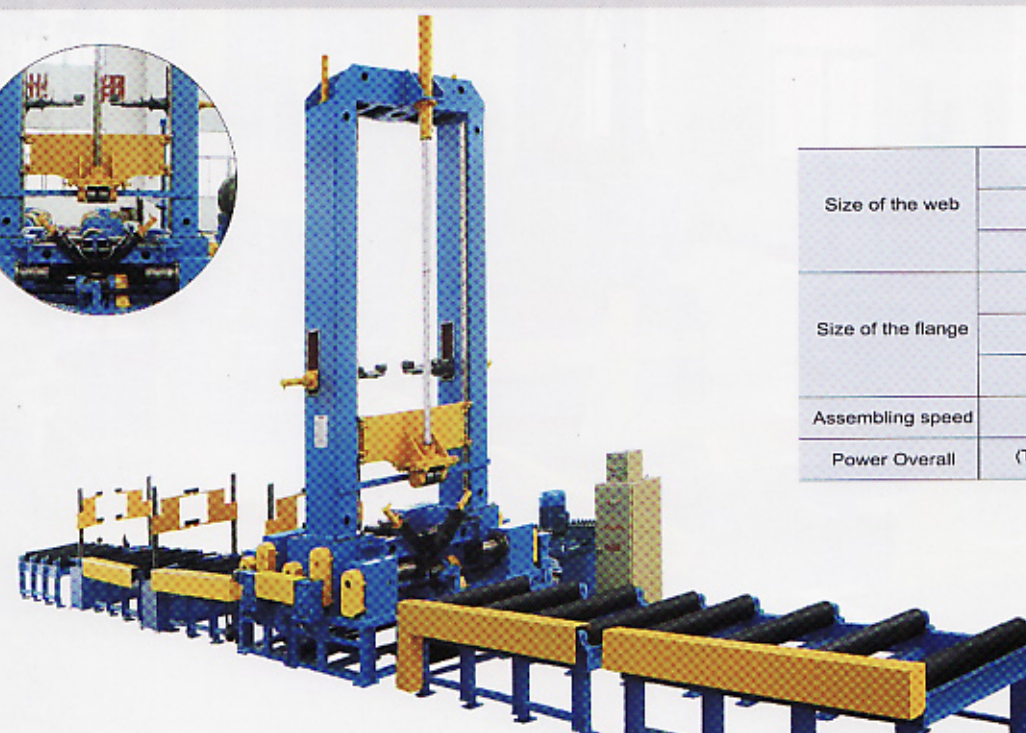
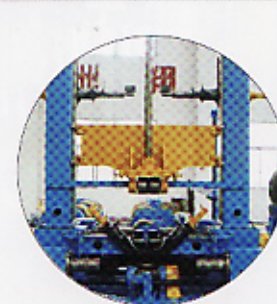
Steel structure Production Line



HEAVY-DUTY VERTICAL ASSEMBLY MACHINE H-BEAM

TECHNICAL PERFORMANCE

Single machine is composed of main machine, drag bar box, input roller conveyor, output roller conveyor, electrical control box, operation box, hydraulic pump. The assembling machine match with heavy duty H beam production line, that should add one group of 90° turning machine except assembling machine.



Size of the web	Height	200-3000mm
	Thickness	6-70mm
	Length	4000-15000mm
Size of the flange	Width	200-1000mm
	Thickness	6-80mm
	Length	4000-15000mm
Assembling speed	0.5-6m/min	
Power Overall	(Two welding machines are excluded)	





Steel structure Production Line

➤ H-BEAM ASSEMBLING, WELDING AND STRAIGHTENING INTEGRAL MACHINE



➤ INTRODUCTION

This is a special machine for H beam assembling, welding and straightening, it combines the three processes into one machine, thus improve productivity, reduce cost, and save the installation space. It can produce H beam and T beam with high efficiency

Steel structure Production Line

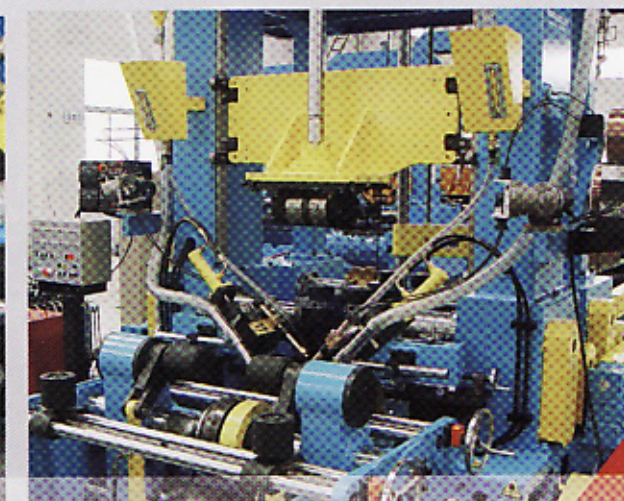
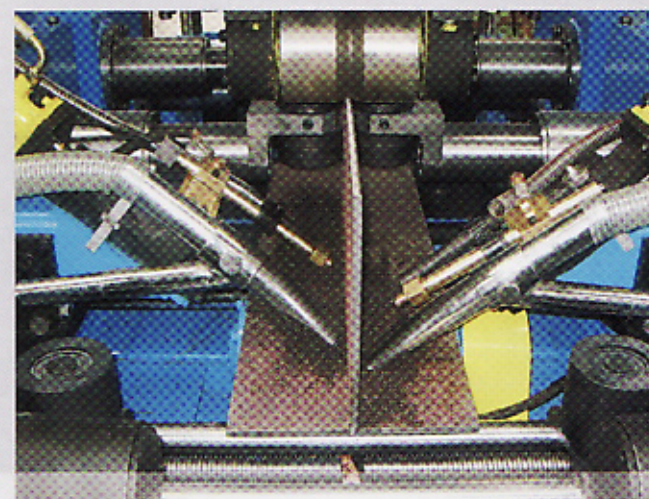


➤ HEAVY-DUTY VERTICAL ASSEMBLY MACHINE H-BEAM

➤ PERFORMANCE AND CHARACTERISTIC

1. the main assembling machine adopt heavy duty assembling structure which have applied invention patent, web plate and flange plate centering and positioning automatically, to make the assembling precision and efficiency greatly improved.
2. Firm welding torch fix mechanism is set up separately, it not only can adjust eight and horizontal moving position, also can adjust the angle of welding torch on two directions, it guarantee the nice seam form.
3. assistant straightening machine has special designed structure, the two straightening roller can straightening workpiece automatically under the pushing of oil cylinder, straightening mechanism will not block the line of sight on seam, it is convenient to see the adjustment of welding torch and seam quality.
4. Assembling machine and assistant straightening machine can be discharged and working separately.
5. Assistant straightening machine can work as small straightening machine after refit.

Web plate height	200-2000mm	flange plate width	200-800mm
Web plate thickness	6-14mm	flange plate thickness	6-20mm
Straightening speed	0.35-3m/min	main machine power	13.4KW





Steel structure Production Line



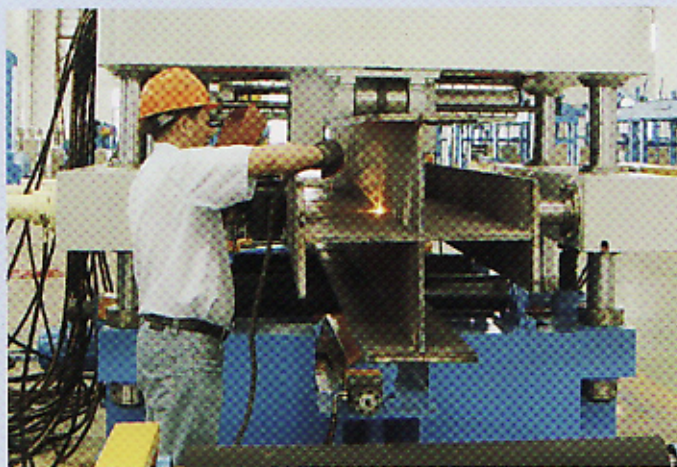
STAR BEAM ASSEMBLING MACHINE

TECHNICAL PERFORMANCE

Star beam assembling machine is a special machine which assembles welded H beam and T beam to be star beam. It adopts frequency speed adjust mode to control assembling speed, through hydraulic system (hydraulic station, hydraulic motor, hydraulic oil cylinder) to positioning and clamping workpiece. It adopts encoder and digital display meter to inspect and set up positioning size, and do spot welding with manual welding mode.



Web plate height	Web plate thickness	Flange plate width	Flange plate thickness	Assembling speed	Machine power
200-1000mm	12-60mm	200-800mm	12-70mm	0.5-6m/min	20.7KW



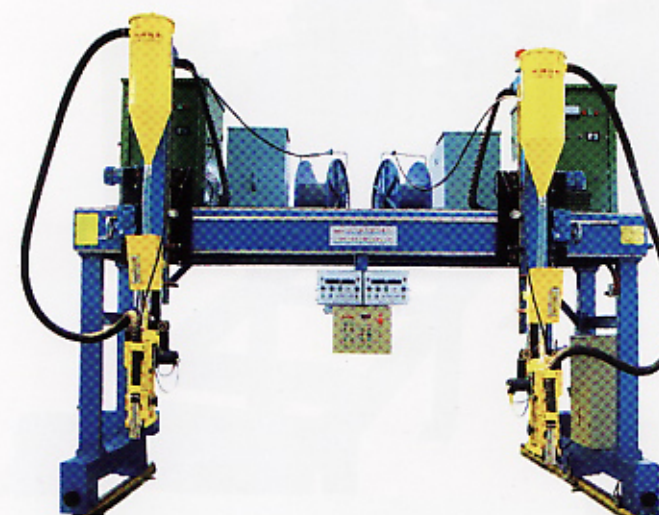
Steel structure Production Line



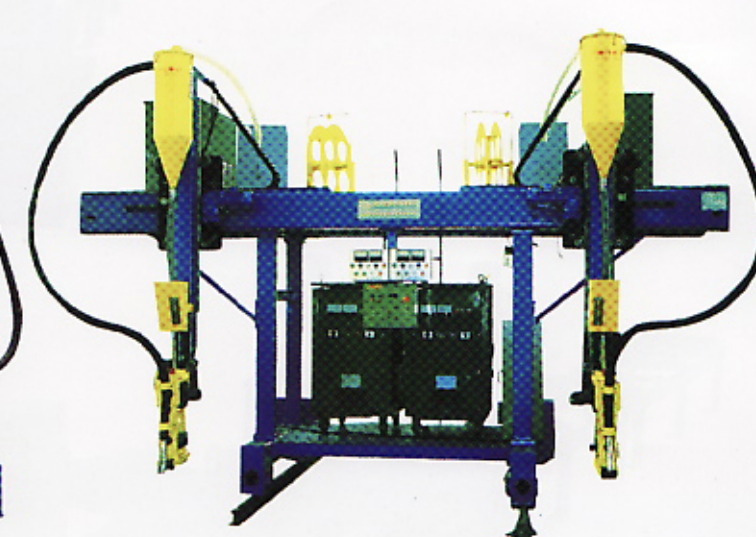
H-BEAM AUTO-WELDING MACHINE

TECHNICAL PERFORMANCE

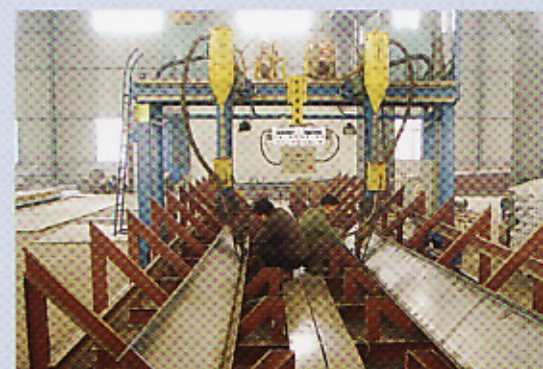
The auto-welding machine for H beam accepts the AC frequency converter to control speed with the merits of stable and reliable running and quick returning. It uses the auto-arc tracing & centering device to ensure the welding gun being auto and correct centering to the target workpiece. Meanwhile, it is equipped by the auto welding flux feed and recovery system, easy operating and high efficiency. And the column-beam welding machine can increase the height of web according to the need of users.



LMH-4000



SXBH20



Model	Height of web	Width of flange	Model of welder	Mode welding	Welding speed	Returning speed	Rails span	Overall Power
LMH-4000	200-1500mm	200-800mm	Two sets of model MZ-1-1000 auto submerged-arc welders	boat-type welding	0.15-1.0m/min	3m/min	4000mm	9.6kw (excluding the welder)
SXBH20	200-2000mm	200-800mm	Two sets of model MZ-1-1000 auto submerged-arc welders	boat-type welding	0.15-1.0m/min	3m/min	2000mm	10kw (excluding the welder)

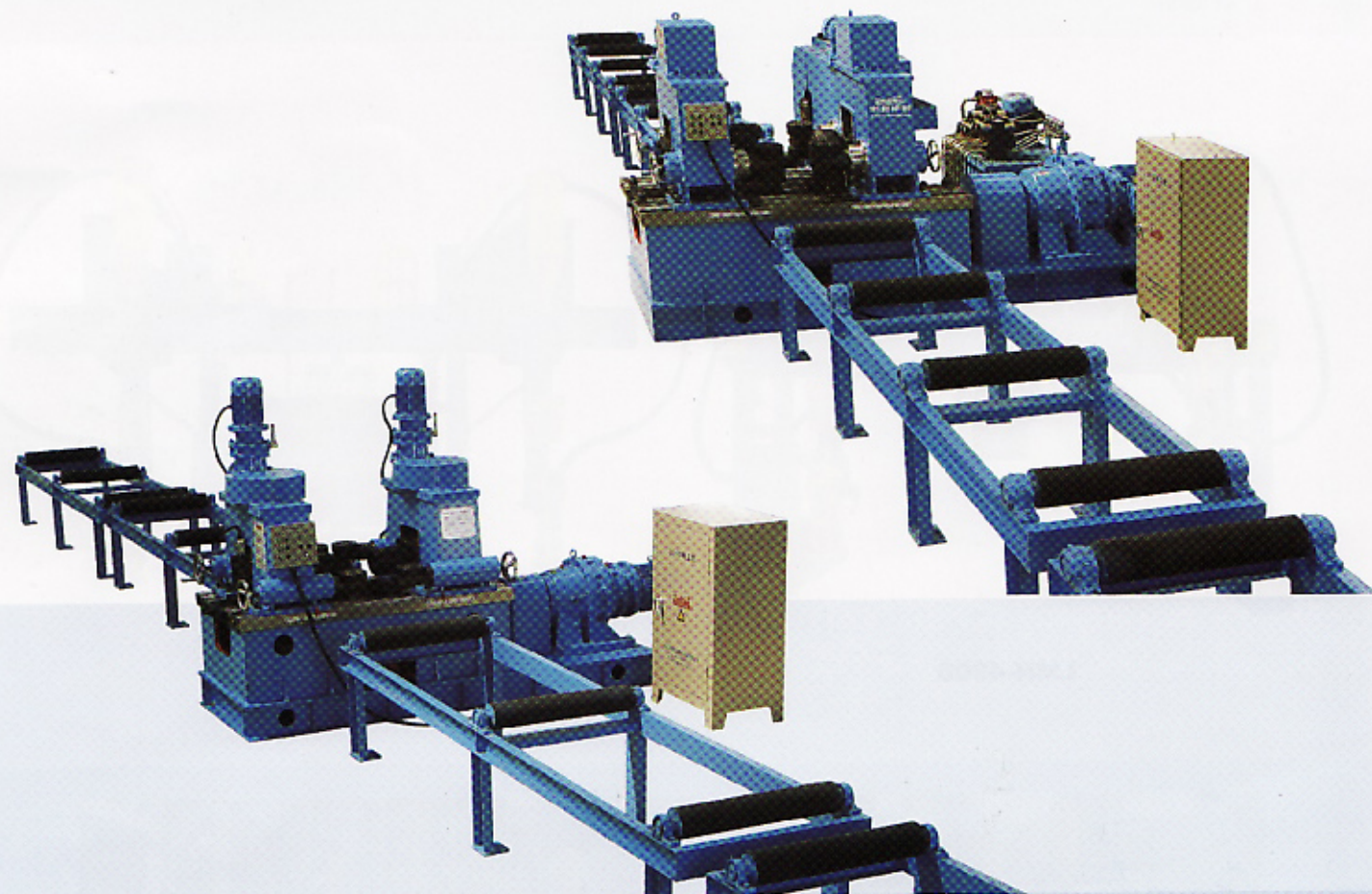


Steel structure Production Line

➤ H-BEAM FLANGE STRAIGHTENING MACHINE

➤ TECHNICAL PERFORMANCE

This machine is a special equipment for leveling the h beam flange which its figure was deformed when it being welding. It has the feature of easy operating, high efficiency, reliable working etc.



Model	JZJ-600	JZJ-800
Width of flange	150-600	200-800
Thickness of flange	≤20mm	≤40mm
Min height of web	160mm	350mm
Material	Q235-A	Q235-A
Straightening speed	8.5m/min	18m/min
Power of over all machine	6.6kw	24.2kw

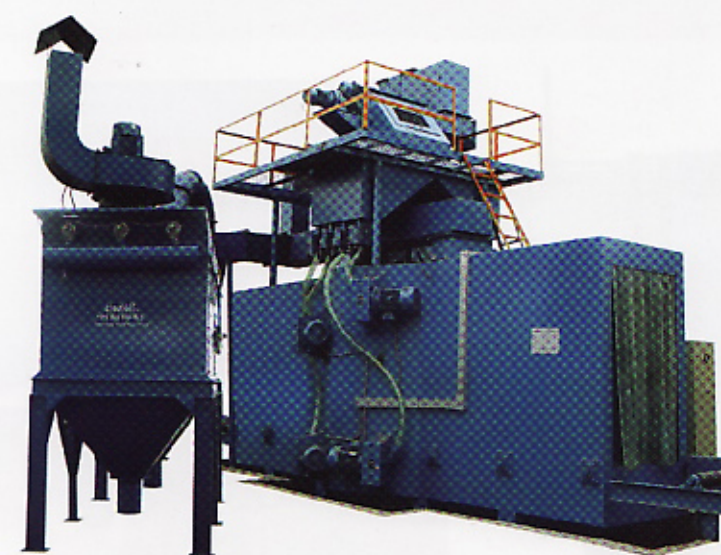
Steel structure Production Line



➤ H-BEAM SHOT-BLASTING AND CLEANING MACHINE

➤ TECHNICAL PERFORMANCE

H-beam shot-blasting and cleaning machine with HGP continuous rolling series is researched and developed in accordance with the features of the steel structure. The machine is adopted with computer 3-dimension dynamic simulating design to locate the position of the shot-blasting machine. The machine is equipped with a highly efficient filter-barrel pulse back-blowing dust.



FILTER CYLINDER DUST REMOVAL



Operating



Feed



Doing



Discharge



Partial Effect

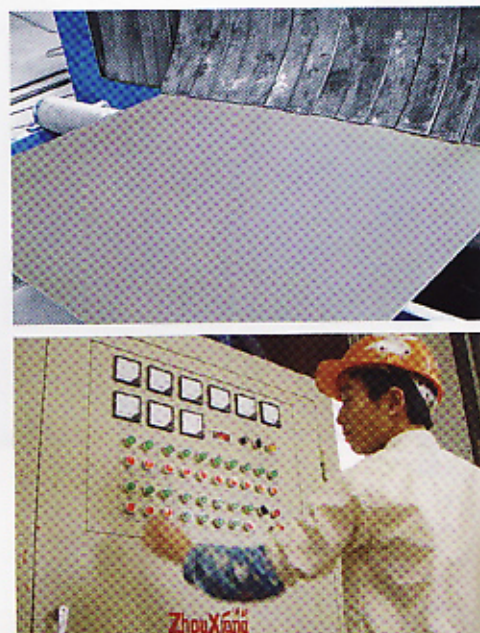
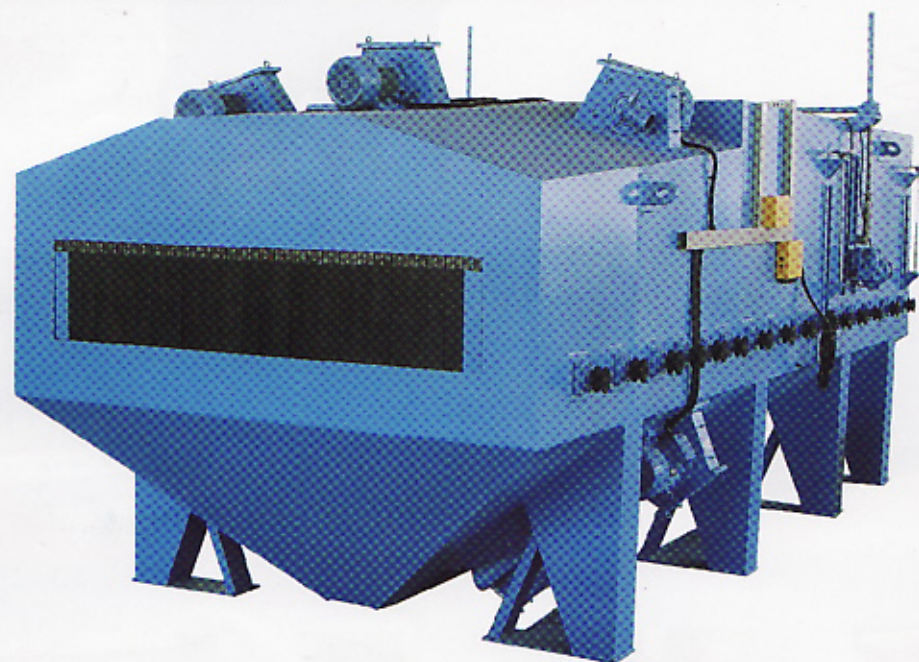
Type		HGP0816	HGP1018	HGP1220
Size of the work-piece	Section(width × height)	800×1600mm	1000×1800mm	1200×2000mm
	Length of the work-piece	3000×12000mm	3000×15000mm	3000×15000mm
Quality Standard	Cleanness of the surface	A-B Sa2-Sa2 ¹ / ₂	A-B Sa2-A-B Sa2 ¹ / ₂	A-B Sa2-A-B Sa2 ¹ / ₂
	Roughness of the surface	15-50 μ m	15-50 μ m	15-50 μ m
Shot-blaster	Qty	8	8	8
	Quan of shot-blasting	8×200kg/min	8×200kg/min	8×220kg/min
	Power	8×11KW	8×11KW	8×11KW
Inlet and outlet conveyor	Allowable load	1000kg/m	1000kg/m	1000kg/m
	Conveying speed	0.5-5m/min	0.5-5m/min	0.5-5m/min
Ventilation capacity		12000m³/h	12000m³/h	12000m³/h
Circulating quan of the shots		120T/h	120T/h	120T/h
Nominal Size(L × W × H)		6770×2900×3150mm	7895×2985×3460mm	7895×3200×3760mm
Depth of the pit		1900mm	1900mm	1900mm
Total power		135KW	140KW	140KW

Steel structure Production Line

SHEET SHOT BLASTING MACHINE

TECHNICAL PERFORMANCE

BP/HGP steel sheet shot blasting machine is mainly used to clean the surface of steel sheet and small profile beams. After clean by steel shots, the rust, dust, oxidated skin can be removed, the materials anti-wear strength is improved, the surface and inside quality is promoted. This equipment is widely used for chemical, ship yard, metal structures, steel products, rail vehicles, engineering machinery and bridge industry.

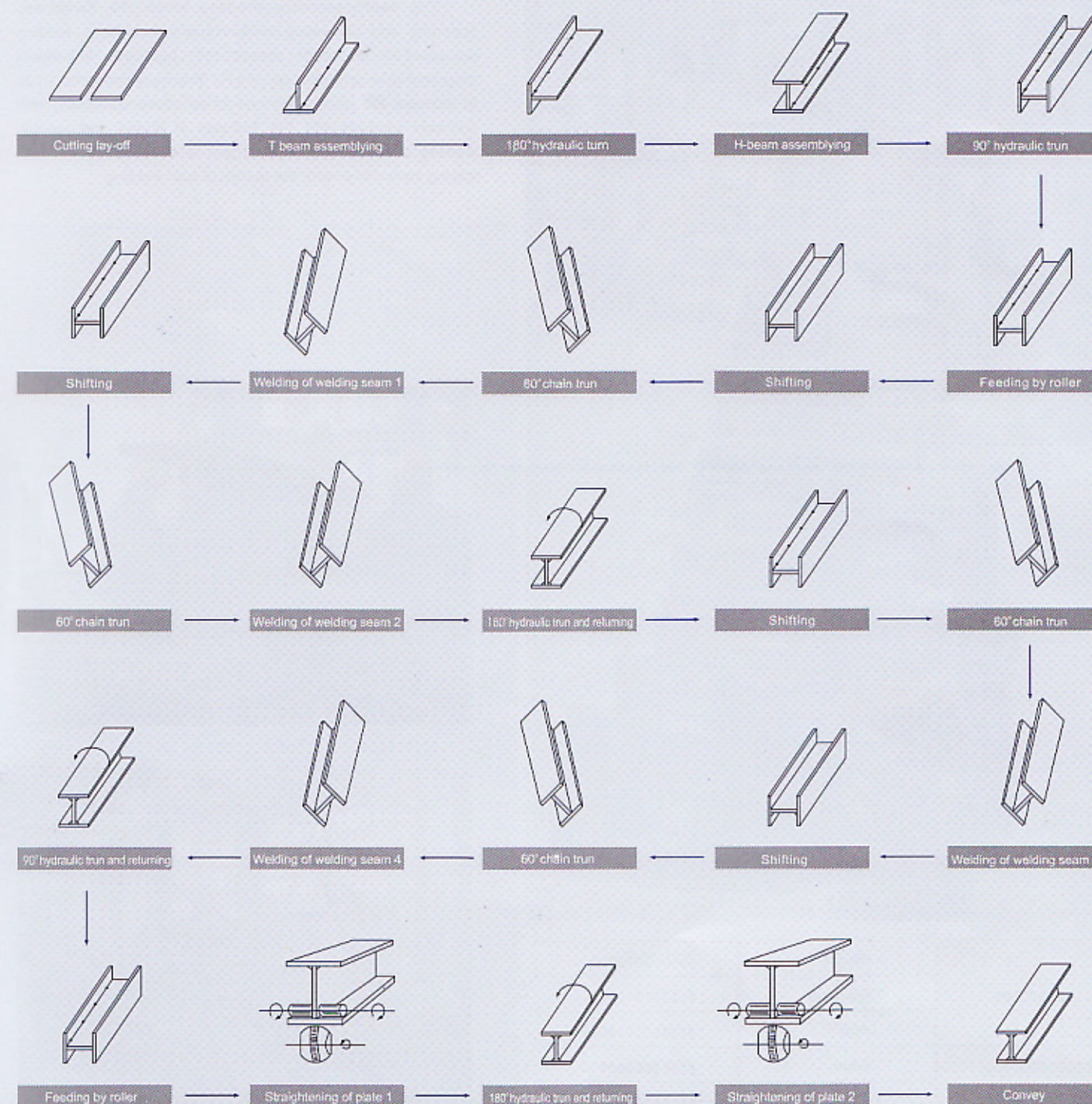


MAIN TECHNICAL PARAMETER:

Model		BP2500-6	HGP2224-12
Size of work piece	Section(W×H×L)	2500×400×15000mm	2200×2400×15000mm
	Speed	0.5~5m/min	0.5~5m/min
conveyor	Power	3×3kw	3×5.5kw
	Model	Q034 II	Q034 II
Shot blaster	Shot blasting speed	65~70m/s	65~70m/s
	No xunit power	6×15kw	12×11kw
Lifter	Power	7.5kw	11kw
Longitudinal conveyor	Conveying capacity	120T/h	180T/h
	Power	5.5kw	7.5kw
Feeding conveyor	Conveying capacity	120T/h	180T/h
	Power	2×4kw	4kw+5.5kw
Dust collection system	Model	LMC-18	LMF- II
	Ventilation capacity	12000m³/h	24000m³/h
Centrifugal ventilator	Model	4-72-5A	4-72-8C
	Power	15kw	22kw
Cleaning system	Ventilation capacity	6762m³/h	5000m³/h
	Power	18.5kw	15kw
Overall power		154kw	214kw
Overall dimension		7900×3100×3300mm	9750×3600×4580mm
Height overground+underground of main machine		6600mm+2400mm	8250mm+2350mm

Steel structure Production Line

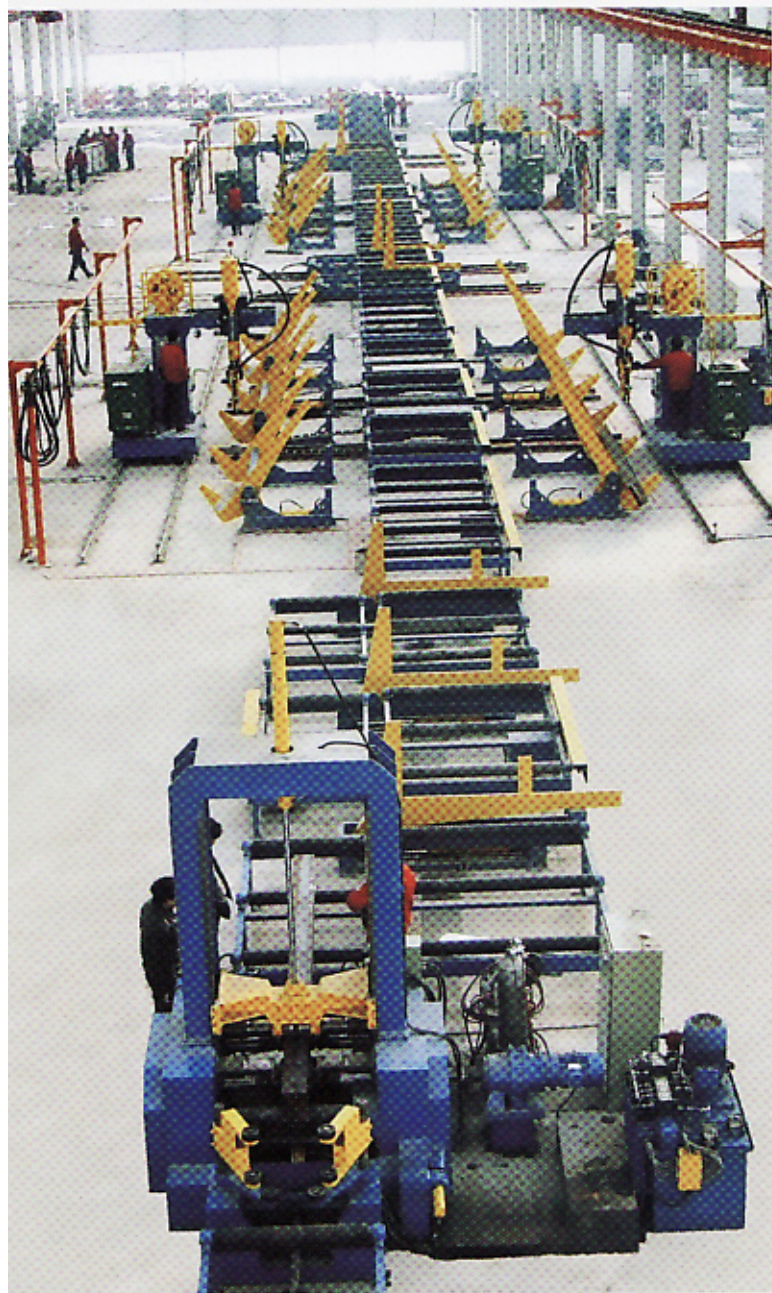
TECHNICAL PROCESS OF H-BEAM(HEAVY STEEL) AUTOMATIC WELDING PRODUCTION LINE



Steel structure Production Line



VERTICAL ASSEMBLY FOR HEAVY DUTY



TECHNICAL PERFORMANCE

The vertical assembly machine which the flange, web fastening and calibrating, positioning, and auto spot welding equipped, all of which accept the Japanese Mitsubishi programmable controller and the AC frequency converter so as to increase the productivity one times above comparing with common products, with the features of stable and reliable working state and the welding gun is equipped by the arc-tracing device to ensure the quality of spot welding.



Web of Size	Height	200-2000mm
	Thickness	6-32mm
	Length	4000-15000mm
Size of Flange	Width	200-800mm
	Thickness	60-40mm
	Length	4000-15000mm
Assembling speed	0.5-6m/min	
Machine power	16.5KW (Two welding machine are excluded)	

Steel structure Production Line



TURNING AND CONVEYING MACHINE

TECHNICAL PERFORMANCE

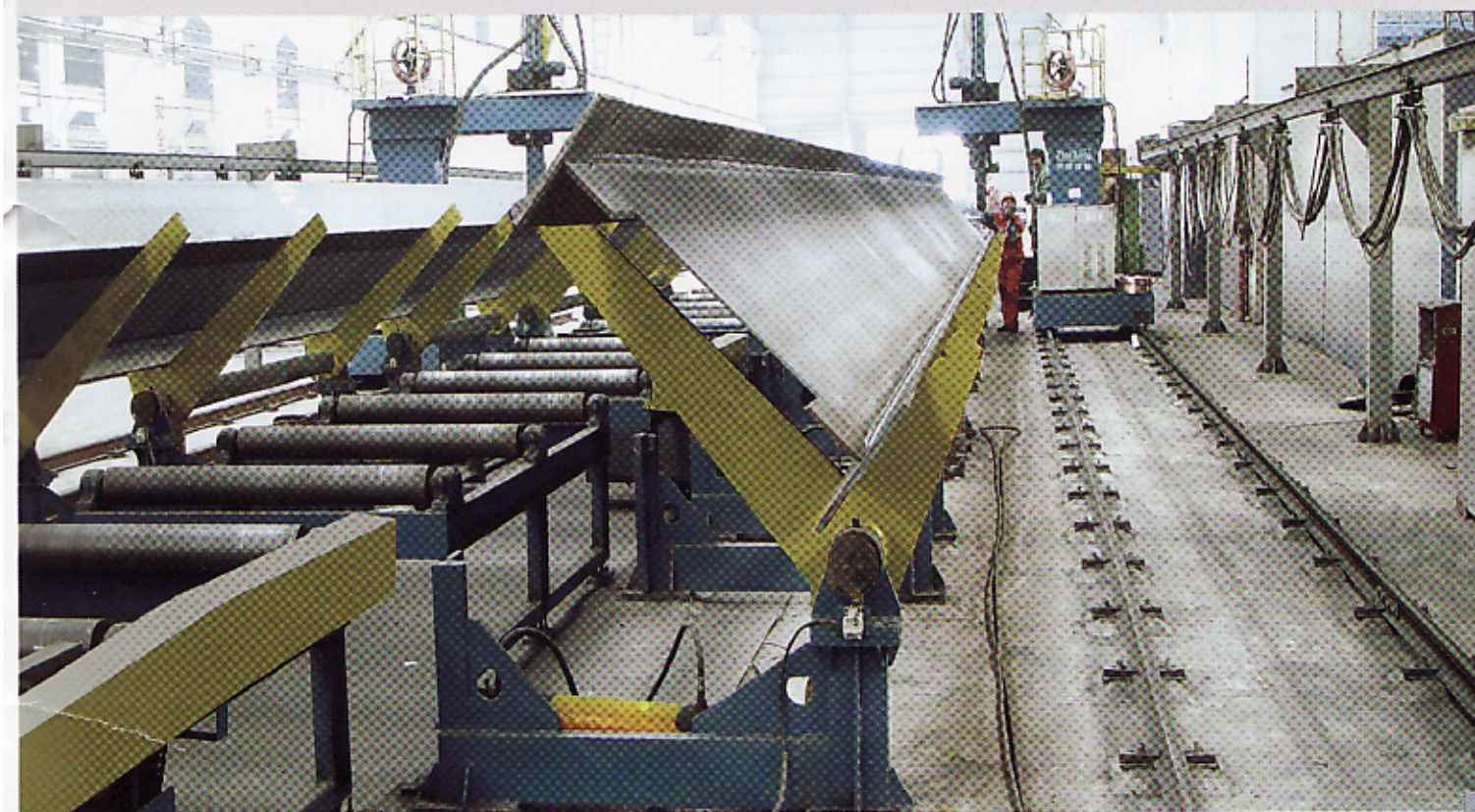
In order to improve manipulating and conveying efficiency and to reduce the usage frequency of moving the machine, we provide the chain manipulator, the conveyor for steel, overturning support to realize automatic conveying and manipulating for the whole welding and straightening course.



60° overturning machine

Conveying machine

90° overturning machine



Steel structure Production Line

CANTILEVER WELDING MACHINE

TECHNICAL PERFORMANCE

XBH type column-beam welding machine adopted The imported AC transducer. The equipment is stable and reliable in operation, and has the quick move-back function. The tracking arc-guide mechanism is three-spindle tracking system to guarantee the alignment and not bias are on the weld. The main frame and the welding machine are performed integrated interlocking and the equipment is provided with flux auto-recovering system and it is easy controlled, and highly efficient.



Type	XBH
Height of web(mm)	200-2000mm
Width of flange(mm)	200-800mm
Length of H-beam	4000-15000mm
Welding machines	MZ-1-1000Auto-submerged two sets of model MZ-1-1000 auto union melt welder
Welding mode	Ship-welding
Welding velocity	0.3-1.5m/min
Reverse velocity	3m/min
Track distance	1150mm
Power of the assembling machine	4.75kw (Welding machine is excluded)

180° HYDRAULIC OVERTURNING MACHINE



TECHNICAL PERFORMANCE

Moving type 180° overturning machine is composed of main machine, hydraulic system and electrical control system. Main machine is composed of 90° overturning arm, base frame, moving wheel group, moving motor gearbox box and rail.

When working away from roller conveyor, gear motor driving two groups overturning frame moving synchronize, to make workpiece moving to the side of roller conveyor, and finally oil cylinder push arm to turning workpiece 180°, and then moving to roller conveyor and conveying, cable oil pipe adopt drag link packing, safety and beauty, reliable, the total machine structure is compact and operation is simple.

180° hydraulic overturning machine

Suitable for weight of work-piece	≤ 15T
Max section dimension of overturning work-piece	800 × 1500mm
Moving motor power	2 × 1.5KW
Moving speed	6m/min
Overturning cylinder diameter	φ 140mm
Max pressure of hydraulic system	20Mpa
Power of the machine	18.5KW



Steel structure Production Line

HYDRAULIC STRAIGHTENING MACHINE

YJZ60C TYPE HYDRAULIC STRAIGHTENING MACHINE

YJZ60B/YJZ80B TYPE HYDRAULIC STRAIGHTENING MACHINE



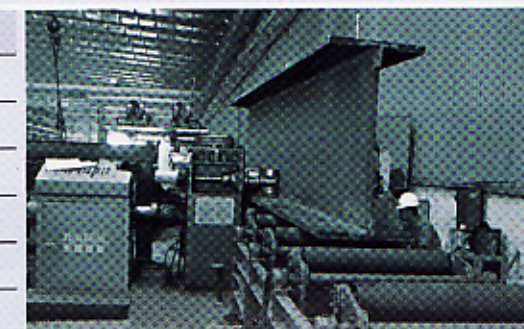
TECHNICAL PERFORMANCE

YJZ60C hydraulic straightening machine is oil cylinder down press type straightening machine, it's straightening capacity is the same as YJZ-60B, but straightening range is wider than YJZ-60B (flange plate can be 1000mm), and two upper press cylinder can do straightening work separately to straightening asymmetry deformation. The producing cost of down press type straightening is lower than up-lift type, no need elevating roller conveyor and universal joint.

TECHNICAL PERFORMANCE

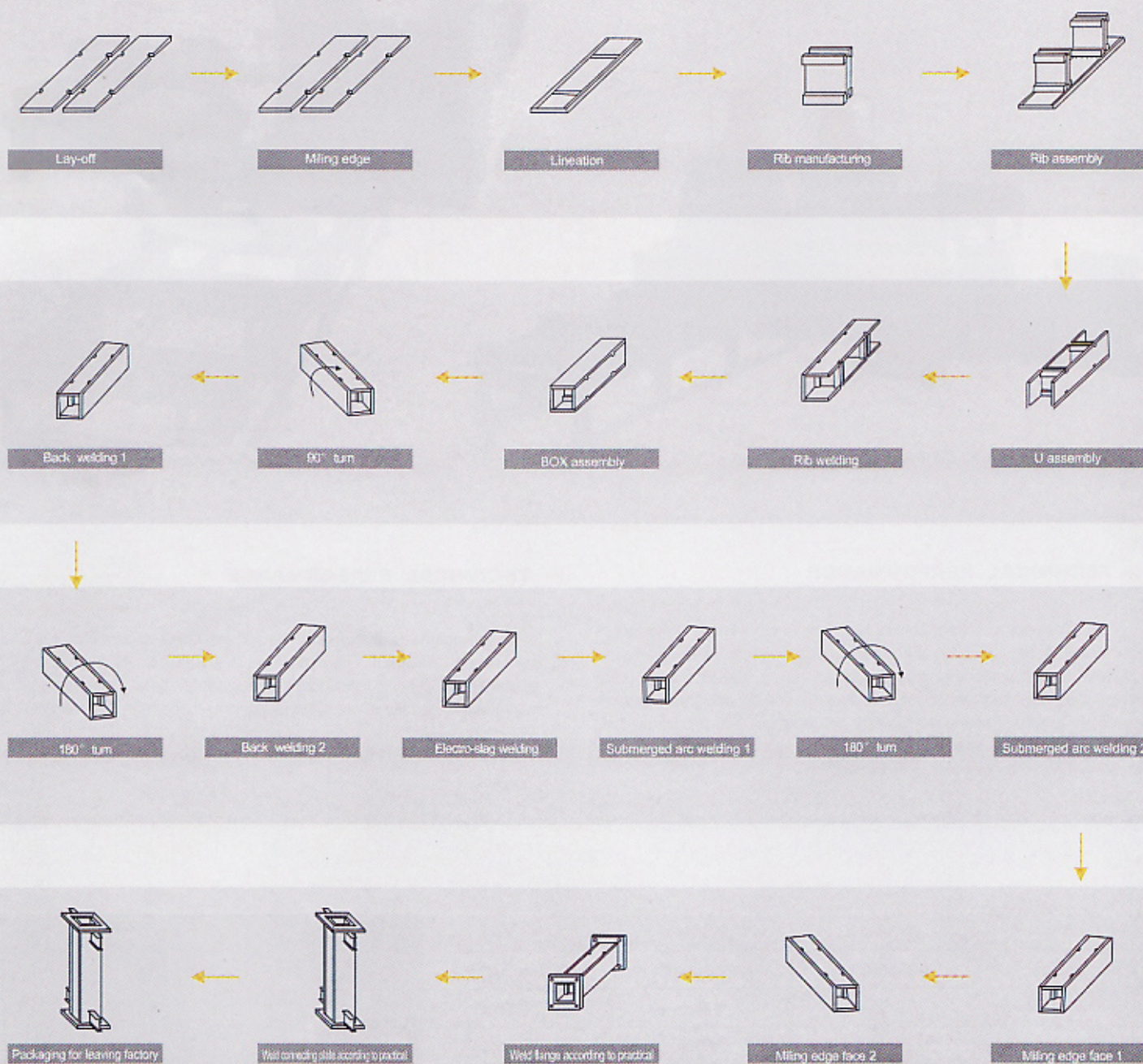
This machine is the special equipment used to straighten the deformed H-beam flange. The hydraulic straightening machine(YJZ60B, YJZ80B) oil cylinder up-lift type straightening machine has capacity of correction, wide range, and high automation.

Descriptions	YJZ60B	YJZ80B	YJZ60C
Width of flange	180-800mm	200-1000mm	200-1000mm
Thickness of flange	≤ 60mm	≤ 80mm	≤ 60mm
Min height of web	350mm	350mm	350mm
Material	Q345(16Mn)	Q345(16Mn)	Q345(16Mn)
Straightening speed	6.15m/min	6.56m/min	6.15m/min
Total Power	37kw	22kw	27.5kw



Box Beam Production Line Series Equipment

TECHNICAL PROCESS OF WELDING BOX BEAM



Box Beam Production Line Series Equipment

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT

TECHNICAL PERFORMANCE

This production line is mainly made up by CNC/Multi-head Strip Cutting Machine, U type /Box type integral assembling machine, cantilever back machine, Cantilever Electric slag-welder, Cantilever submerged arc-welding Machine, Terminal Surface Mill, Edge Miller, Baffle Assembling Machine, Roll Table and other complements.

Length	4000~15000mm
Sectional size	300×300mm ² ~1200×1200mm ²
Thickness	20~80mm



TECHNICAL PERFORMANCE

This is the special machine for assembling the U type and box type beam, it is composed of main machine, roller conveyor, centering device, positioning device, hydraulic system and electrical control system. This machine adopt workpiece fixed, but machine moving type, hold down workpiece with some pieces and manual welding the workpiece after holding.

The characteristic of this machine: finish U type assembling and box type assembling on the same machine, it reduces the cost and saves layout space.



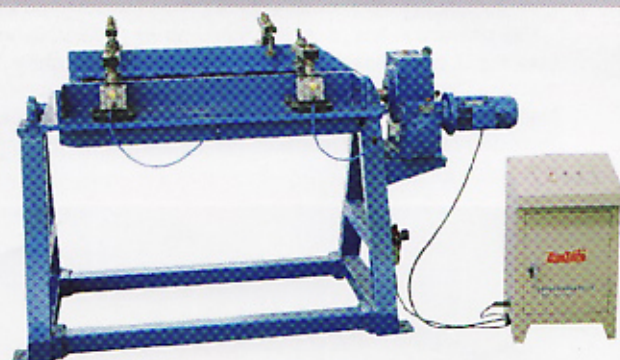
Box Beam Production Line Series Equipment

UZZ12 ASSEMBLING MACHINE

VERTICAL DIAPHRAGM ASSEMBLY MACHINE MODEL NO.GZ15

TECHNICAL PERFORMANCE

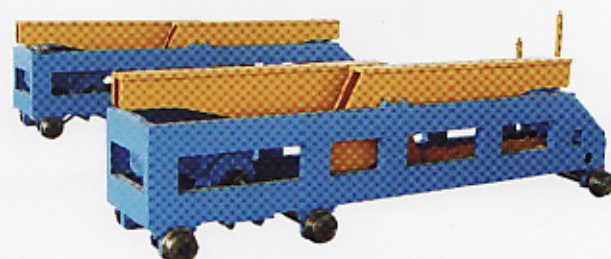
This machine is the special equipment to assemble and weld the middle claspboards in BOX type beam. When assembling, adopt the cylinder compacting to determine the position, then weld them by spot. After finish to weld one face, then turn over the rotation work table for 180 degree through motor. After weld the another face, Turn the work table to the level, loose the Cylinder and unload forworing.



BOX BEAM OVERTURNING MACHINE

Moving type 90 degree hydraulic overturning machine

Moving type 180 degree hydraulic overturning machine



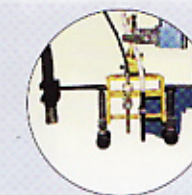
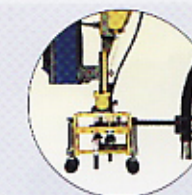
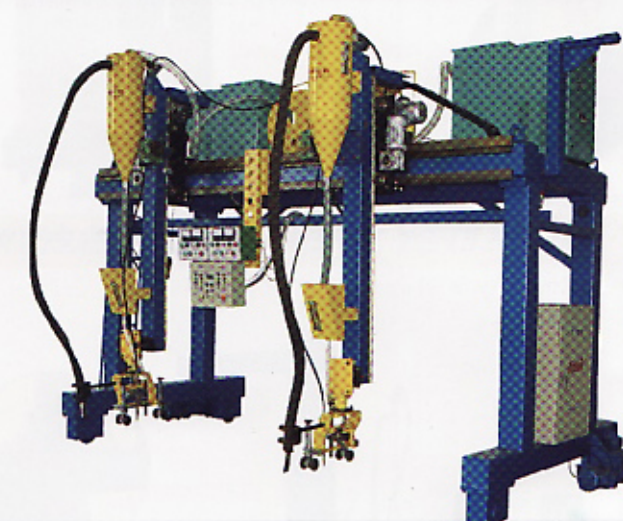
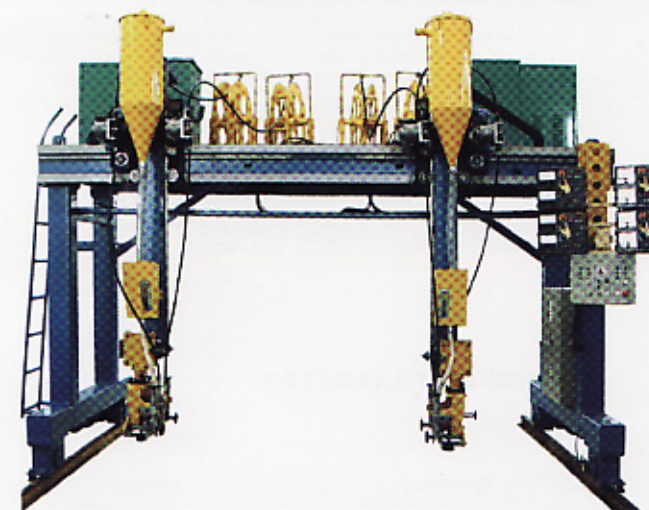
VERTICAL ASSEMBLY MACHINE MODEL NO.UZJ12



GANTRY TYPE BOX BEAM WELDING MACHINE MODEL NO.LMHA-4000

TECHNICAL PERFORMANCE

It is the welding supplementary machine for special use that design for box-beam welding (flat angle welding seam). The machine use gantry style main struture, driving in double-sides, controlled the speed steplessly by converter. Tracing of welding seam uses the type of mechanic guiding roller. The up-down and right-left operation is controlled by pneumatic technology. In order to improve the efficiency of big fillet welding, it is equipped with big electric current and double machine head (single welding seam) to process double arcs and double wires weldings, installation of the machine head is separated from arc-guiding mechanism. The device which is used to protect solder, avoiding too much solder drop down; lay-up of workpiece can use fixed frame and it can also be transmitted by roller, so it can from an assembly line with other sets of machines.



Box-beam arc guiding rack

Box-beam control system

H beam steel arc guiding rack

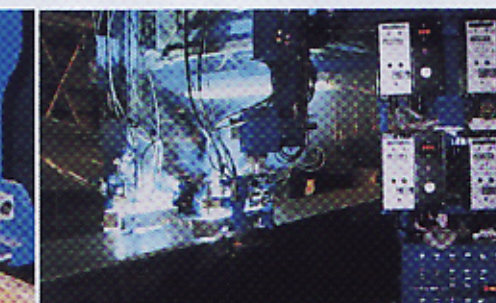
Width of applicable box-beam	Height of applicable box-beam	Welding speed	Returning speed	Welding position	Total power
300~1200mm	300~1200mm	0.17~3.4m/min	6.8m/min	Horizontal welding	9KW



Triple wires with triple arc (2DC+AC)



Twin wires with twin arc (DC+AC)

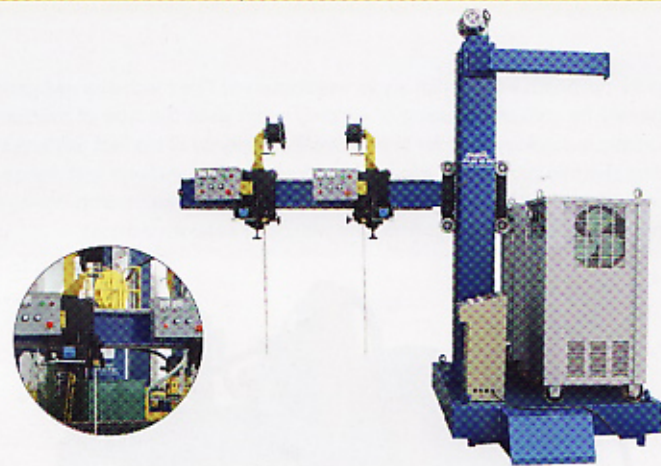


Gate double thread gas shield welding padding machine



Box Beam Production Line Series Equipment

➤ CANTILEVER TYPE(NOZZLE MELT) ELECTRO-SLAG WELDING MACHINE MODEL XDZ-12



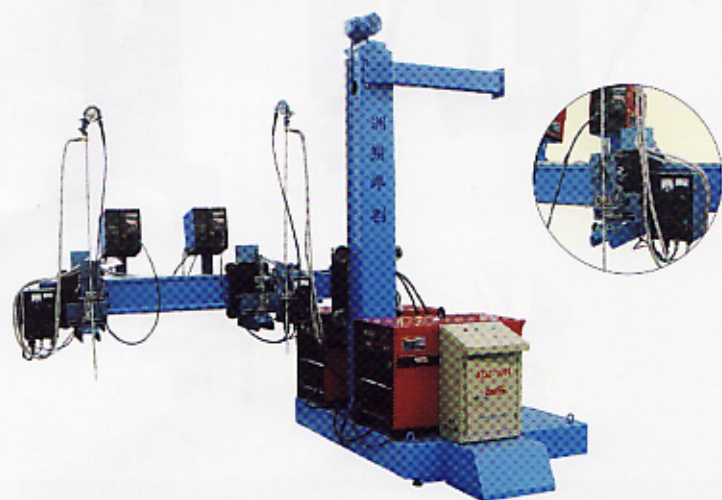
➤ TECHNICAL PERFORMANCE

XDZ-12/12S series box beam slag welder is a special equipment for box beam baffle welding, which adopts baffle and surround steel plate welding hard in vertical slag welding way.

According to customers' different requirement, these are two ways of box beam slag welding: wire melt and nozzle melt. Welding speed of wire melt slag welding is faster and lower welding cost, but higher equipment cost and more complicate control system; nozzle melt slag welding is lower equipment cost and simple operation, but the welding efficiency is lower than wire melt slag welding.

Wire melt slag welding is suitable for big quantity box beam production, while nozzle melt slag welding is suitable for small quantity.

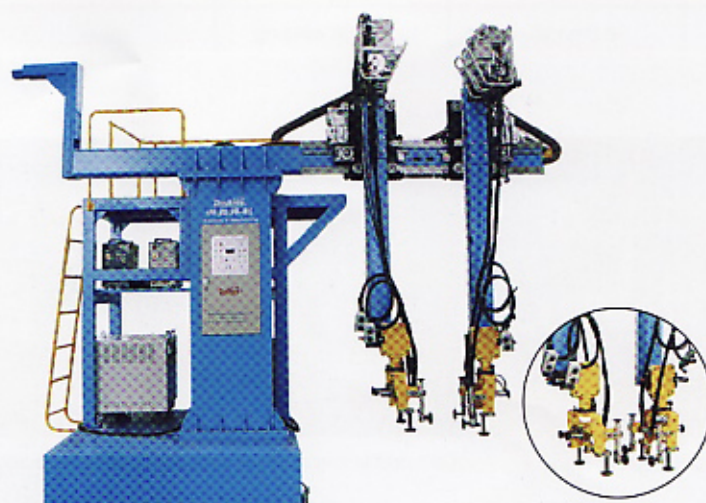
➤ CANTILEVER TYPE(WIRE MELT) ELECTRO-SLAG WELDING MACHINE MODEL XDZ-12



➤ TECHNICAL PARAMETER

Trolley gauge	1000 mm
Trolley travelling speed	6 m/min
travelling motor power	0.55 KW
suitable workpiece size	300~1200 mm

➤ XXBH-12 MODLE CANTIEVER TYPE BACK WELDING MACHINE



➤ STRUCTURE AND PERFORMANCE

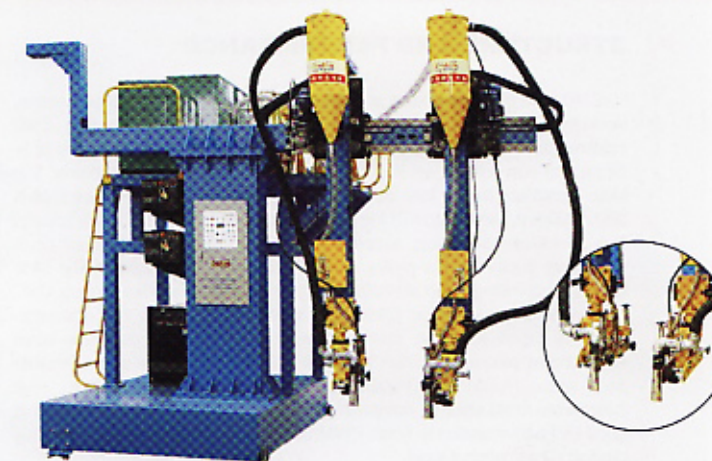
Cantilever type back welding machine is usually used before SAW welding in box-beam manufacturing process, this machine can prevent the workpieces welding seam to be burned through, and it is composed of travelling cart, welding arm, welding gun tracking device, pneumatic system, electrical control system, flux recovery system, CO₂ welding power and so on.

For box-beam back welding, it usually adopts single arc single wire, also can use double arc double wire. The welding power is Panasonic YD-600KH.

Width of applicable box-beam	300~1200mm
Length of applicable box-beam	4000~15000mm
Welding speed	0.3~1.5m/min
Returning speed	3m/min
Welding position	Horizontal welding

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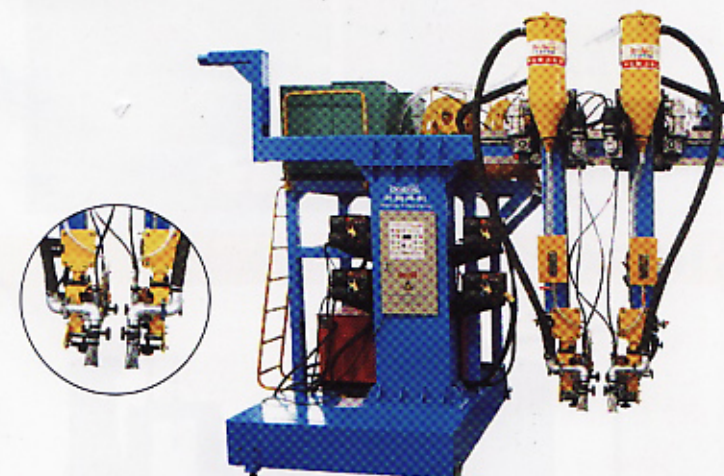
➤ XXBH-10 MODEL CANTILEVER TYPE SUBMERGED ARC WELDER(SINGLE ARC SINGLE WIRE)



➤ STRUCTURE AND PERFORMANCE

This machine is composed of travelling cart, welding arm, welding gun mechanical tracking device, pneumatic system, electrical control system, flux feeding and recovery machine and submerged arc welding power. It is mainly used for welding the box beam. This machine is composed of travelling cart, welding arm, welding torch mechanical tracking device, pneumatic system, electrical control system, flux feeding and recovery system and SAW power. It is always used for box-beam SAW welding.

There are two kinds of welding method for box-beam SAW welding, single arc single wire and double arc double wire. For single arc single wire welding, the welding power can be domestic-made or foreign-imported; while for double arc double wire welding, usually equipped with welding power American Lincoln DC-100, AC-1200 to improve work efficiency.



➤ TECHNICAL PARAMETER

Suitable workpiece size	300~1200mm
Welding speed	0.3~1.5 m/min
Return speed	3 m/min
Cart gauge	1400 mm
Gas power pressure	0.4~0.8 Mpa

➤ SUBMERGED ARC WELDING



Lincoln AC-1200 submerged arc welder



Lincoln DC-1000 SAW welder



ZD5-1600 Series of Mz Automatic Submerged Arc Welder



ZX5-1000 Arc Welding(AW) Rectifier



ZXG-1000R Submerged Arc Welder



MZ-1250 Model IGBT Inverter Submerged Arc Welder