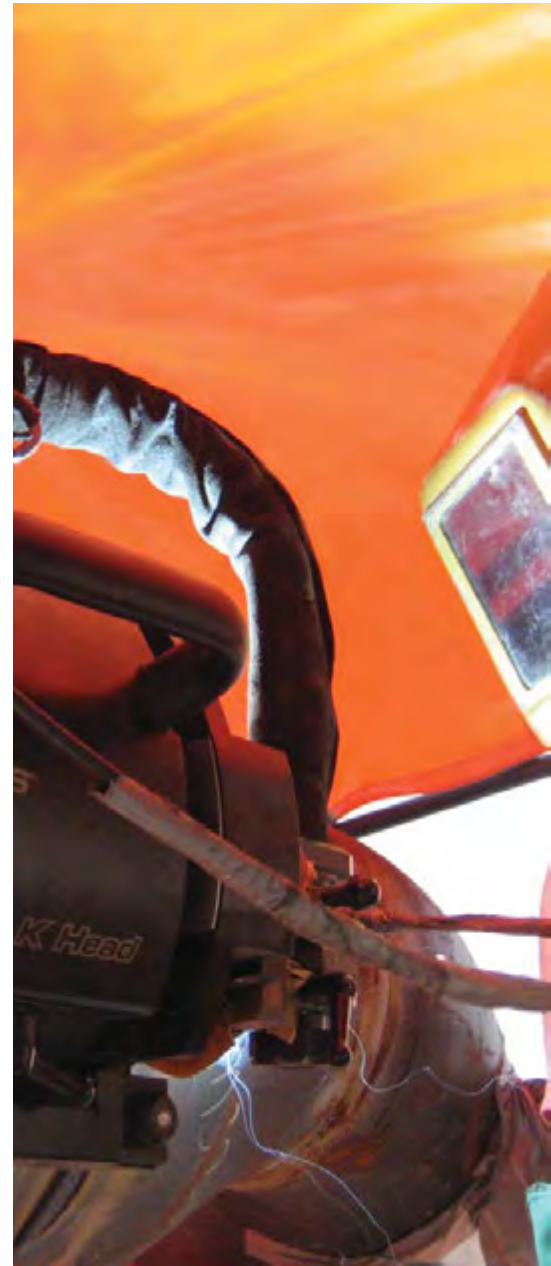


OrbiMIG II™ | **Orbital MIG Welding System**



Weld Quality Starts in the Arc

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'K' Weld Head



- Quick release clutch mechanism for rapid 360° setup, cable wrap and weld head positioning
- Compact radial & axial size
- On-board spool holder (flux core or solid core wire)
- Pipe ranging from 4" and up
- Flat plate, ID & Large diameter vessels
(*requires optional adapters and tracks)

Orbital Flux Core Welding Example

5" thick 25" O.D. heavy wall weld compound 37/10 degree bevel

Orbital flux core – 34 hrs arc time
47 hrs total weld time using 70% welder eff factor
Total four (4) shifts
add one extra shift for cushion
= 5 shifts

4" thick 20" O.D. heavy wall weld compound 37/10 degree bevel

31.5 hrs arc time
42 hrs weld time using 70% welder eff factor
Total 3.5 shifts
add one extra shift for cushion
= 4.5 shifts

Using the orbital flux core process we suggest
10 hour shifts
One operator per weld joint

Due to repeatability of orbital welding with all operators using same weld programs informational RT shots may be eliminated after successful initial info shot.



Orbital Pendant (*Optional Welding Lens)



OrbiMIG Power Source

Featuring

- LCX universal controller
- Touch start
- Portability
- Reliability
- Rugged design options
- 350 or 450 amps (power source dependant)
- Override capabilities for all welding parameters.
- Rugged square tube construction with gasket seals.
- Quick disconnect features for gas, water and electrical connection.
- Included LRD (Liburdi Real Time Data Logging) and critical function monitoring.
- Closed loop cooling system

Choice of Cabinet, Protective Shock Proof Case or All-in-One Orbital Field



Protective Shock Proof Case



Orbital Field Kit

OrbiMIG II™ | Orbital MIG Welding System

GTAW Model	OD Range		Amps	Duty Cycle (%)	Pulsed	Wire Feed	Cooling	Clamp or Track Mount	Multipass Capability for Groove Welds
	Inches	Millimeters							
K (Orbital, GMAW)	4.0 – Inf.	101 – Inf.	***	***	***	●	water/*gas	track	●

*** Amps, Duty Cycle(%) and Pulsed are power source dependant

K Weld Head Specifications

- Maximum programmable travel speed: 45 IPM (114 cm/min)
- Wire speed programmable to 600 ipm (1.50 m/min)
- Oscillation stroke is programmable up to 2" (50 mm)
- Minimum axial clearance 17.6" (447 mm)
- Minimum radial clearance 6.50" (165 mm)
- Torch theta adjustment range +55° - 50°
- Torch lead-lag adjustment ± 45°
- Cable harness length 35ft (10.7 m). Extensions are available



Heavy wall welding Orbital Flux core welding

SMAW

- **One operator per weld joint** ----- Typically two welders per joint
- **Deposition rates** ----- 1/8" rod = 1.5-2.5 lbs per hr
5G – 4-6 lbs per hr
2G – 6-8 lbs per hr
- **Operator eff factor** 70% ----- 50%
(out of 10 hr shift 7 hrs welding) (out of 10 hr shift 5 hrs welding)
- **Deposit eff factor** 85% ----- 55%
(refers to wasted filler material form smoke, spatter and stubs)
- **Fume issues** – operator is located further from weld arc resulting operator situated further away form fume than SMAW welding.
- **Fatigue** – operator work eff percentage is higher than SMAW welding due to less fatigue.
- **Tie Ins** – using orbital flux core process we start at bottom and stop at top of joint welding uphill, end results in far less tie ins than SMAW welding resulting in less chance for defects in weld since there is a fraction of tie ins of weld beads.

CE, CSA, UL, Compliant Versions Available.
© Liburdi Dimetrics Corp. November 18, 2011. Specs subject to change.



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