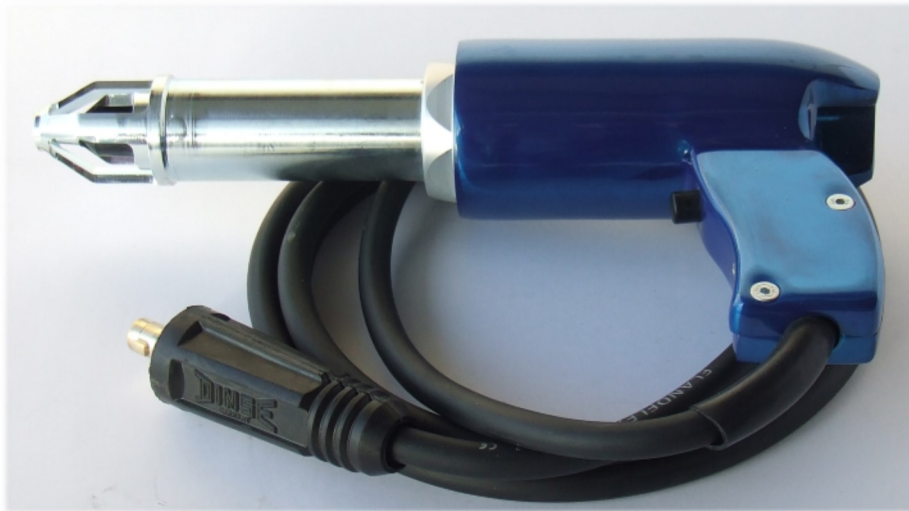




CORROSION CONTROL

EASYBOND



PIN BRAZING GENERATOR GUNS

Generator Guns

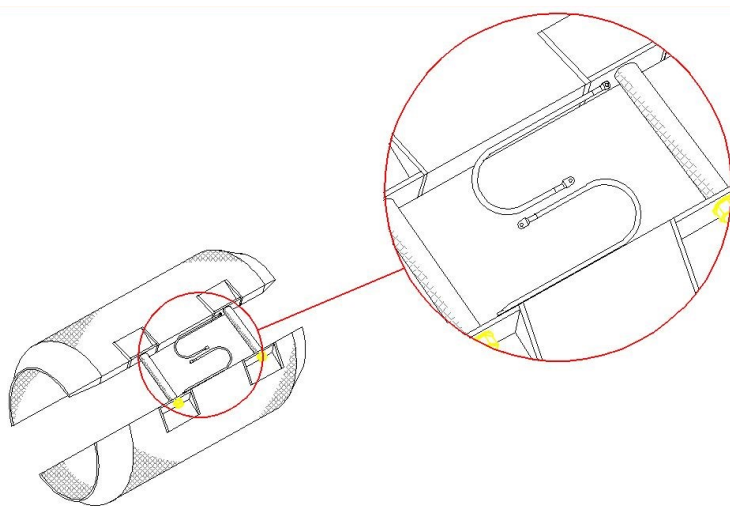
The generator guns are specifically designed for use at pipe coating terminals, lay barges and factories where pin brazing would be carried out at a static location and where power is available. The gun uses fused wire pins and can work directly off a welding generator set similar to the one detailed below.

The generator guns operate at around 240 Amp and 42 Volt DC. The weight of the gun is approximately 3.3kg for the standard and 3.5kg for the extended.

The extended gun is particularly suited for brazing bracelet anode cables where the pin braze needs to be between the anode segments.

The extended is suitable for gaps of a minimum 45mm width and maximum 140mm depth.

As the guns are mechanical so they can be easily maintained at site and virtually rebuilt provided that you have the required spare parts.



Offshore Bracelet Anode Connection



Pin Brazing Connections

Inverter Technical Specifications

| Input | | | | |
|--|-----------------------------|---|----------------------------|----------------------|
| Input Voltage 400V ± 15% Three Phase | Input Power at Rated Output | | EMC Group/ Class II / A | Frequency 50/60Hz |
| | 400SX | 10.9kW @ 100% Duty Cycle 16.4kW @ 35% Duty Cycle | | |
| Rated Output at 40°C | | | | |
| Duty Cycle (Based on a 10 minute Period) | | Output Current | Output Voltage | |
| 400SX | 100% | 300A | 32.0Vdc | |
| | 35% | 400A | 36.0Vdc | |
| Output Range | | | | |
| Welding Current Range | | Open Circuit Voltage | | |
| 400SX | 5 – 400A | | 45Vdc (CE model) | |
| | | | 12Vdc (AUSTRALIA model) | |
| Recommended Input Cable and Fuse Sizes | | | | |
| Fuse (delayed) or Circuit Breaker ("D" characteristic) Size | | Input Power Cable | | |
| 400SX | 30A | | 4x4mm ² | |
| Physical Dimensions | | | | |
| 400SX | Height | Width | Length | Weight |
| | 455mm | 301mm | 632mm | 37kg |
| Operating Temperature -10°C to +40°C | | Storage Temperature -25°C to +55°C | | |



Generator Pin Brazing Guns

| Part # | Description |
|--------------|---|
| 273 199 0240 | Gun VF 2300 ESAB c/w 8mm Pin and Ferrule Holder |
| 273 199 5230 | Gun VF 2300 Extended c/w 8mm Pin and Ferrule Holder |



Brazing Pins with Fuse Wire

| Part # | Description | Minimum pack size: |
|--------------|---------------------------------------|--------------------|
| 278 190 3250 | 8mm Direct Brazing Pin | 100 |
| 270 083 3520 | 8mm Direct Brazing Pin Extra Solder B | 100 |
| 278 190 0430 | M8 Threaded Brazing Pin | 50 |
| 278 190 3450 | M10 Threaded Brazing Pin | 40 |
| 278 190 2560 | M12 Threaded Brazing Pin | 40 |



Inverter

| Part # | Description |
|--------------|---------------------------|
| 273 900 2030 | Digital PBDI 300 Inverter |



Ferrules

| Part # | Description | Minimum pack size: |
|--------------|--|--------------------|
| 270 065 7230 | Ceramic Ferrule 8mm for direct pins | 100 |
| 270 077 3680 | Ceramic Ferrule 12mm for threaded pins | 50 |



Pin Brazing Cable Lugs

For use with 278 190 3250 & 270 083 3520

| Part # | Description |
|--------------|--|
| 278 100 7360 | Cable lug 10mm ² cable.....(Min Pack size 100) |
| 278 100 9000 | Cable lug 16mm ² cable.....(Min Pack size 100) |
| 270 088 7800 | Cable lug 25mm ² cable.....(Min Pack size 50) |
| 278 100 7810 | Cable lug 35mm ² cable.....(Min Pack size 50) |
| 270 088 7790 | Cable lug 50mm ² cable.....(Min Pack size 50) |
| 278 100 9890 | Cable lug # 6 - #8 AWG cable.....(Min Pack size 50) |
| 278 100 8590 | Sleeve 2.5mm ² t/s 278 100 7360.....(Min Pack size 100) |
| 278 100 8750 | Sleeve 4mm ² t/s 278 100 7360(Min Pack size 100) |
| 278 100 9270 | Sleeve 6mm ² t/s 278 100 7360(Min Pack size 100) |



Standard Generator Gun

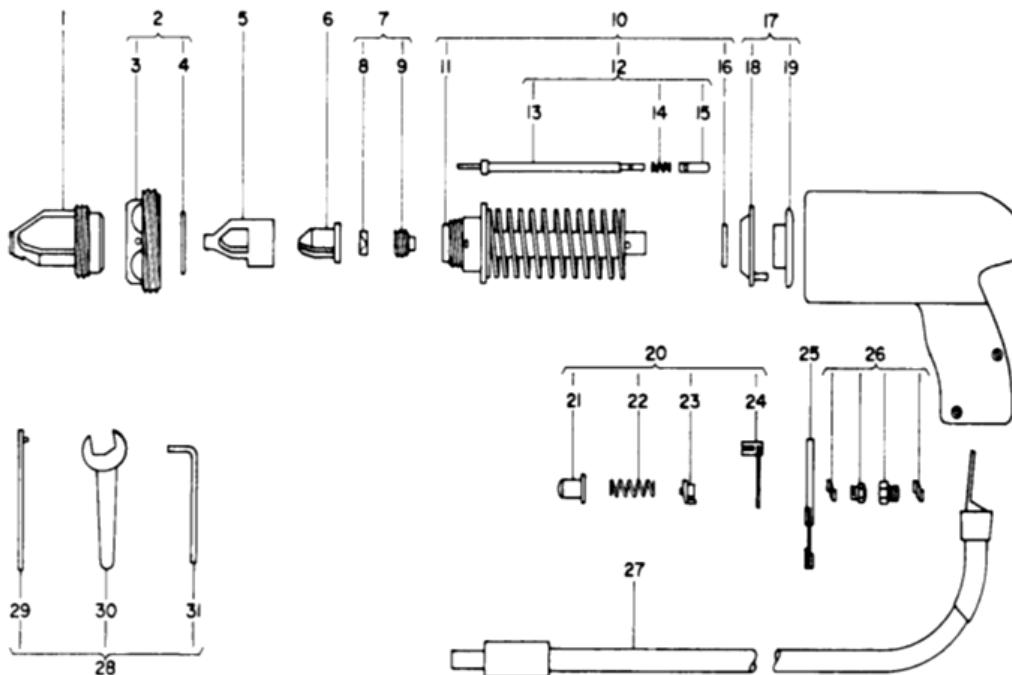


Extended Generator Gun

Spare Parts

| Item No. | Part # | Description | Item No. | Part # | Description |
|----------|--------------|---|----------|--------------|--------------------------------------|
| 1 | 270 074 8150 | Ferrule holder for 8mm direct brazing pins | 10 | 273 074 8220 | Centre piece complete (Standard Gun) |
| | 273 100 0560 | Ferrule holder for M8 threaded brazing pins | 10 | 270 088 7590 | Centre piece complete (Extended Gun) |
| | 273 100 1240 | Ferrule holder for M10/M12 | 12 | 273 190 0580 | Ejector rod complete (Standard Gun) |
| 2 | 273 190 0560 | Front piece complete with locking ring | 12 | 273 190 4580 | Ejector rod complete (Extended Gun) |
| 4 | 270 074 8160 | Locking ring | 16 | 270 071 5340 | Remanence washer |
| 5 | 270 071 5600 | Pin holder for 8mm direct brazing pins | 17 | 273 190 0590 | Conductor ring and insulating ring |
| | 273 100 0550 | Pin holder for M8 threaded brazing pins | 20 | 273 190 0600 | Trigger assembly |
| | 273 100 3870 | Pin holder for M10 threaded brazing pins | 25 | 270 071 5700 | Contact arm |
| | 273 100 1230 | Pin holder for M12 threaded brazing pins | 26 | 273 190 0110 | Contact set complete |
| 6 | 270 071 5610 | Spark shield | 27 | 273 190 1310 | Cable 35mm sq. 2.7m long |
| 7 | 273 190 0570 | Contact nipple and washer | 28 | 273 190 0610 | Tool kit |
| | | | | 120 001 0832 | Attache Case |

'Ensures a safe, strong and consistent electrical connection to many types of metallic structures'



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