

### **Technical Specification for Hand Held SAW Machine -- 2Nos**

Scope to include Power Source, Wire feeder and Hand Held SAW torch for hand Held SAW welding with 2.4mm wire

SINo	Description	Specification	Firm's confirmation Yes/No	Remarks
<b>1.0</b>	<b>Welding Power Source</b>			
1.1	Welding Power Source	Inverter based Digital Power Source		
1.2	Input Voltage	400V 3 Ph 50 hz		
1.3	Current Range	10 - 815 Amps		
1.4	60% Duty Cycle	Min 750 A		
1.5	100% Duty Cycle	Min 650 A		
1.6	Operating Temp	-10° to 55° C		
1.7	OCV	60 VDC		
1.8	Degree of Protection	IP23		
1.9	Insulation Class	H		
1.10	Type of Cooling	Force Air Cooled		
1.11	Display Type	Digital		
1.12	Multi process Capability	Capable of SMAW. Lift GTAW, FCAW. SAW and CAG		
1.13	Protection	Over Load and Thermal Protection		
<b>2.0</b>	<b>Wire Feeder with Trolley</b>			
2.1	Input Voltage	24-42 V DC		
2.2	60% Duty Cycle	Min 600 A		
2.3	Display Type	Digital		
2.4	Wire Size	2.4 mm solid		
2.5	Wire Feed Speed	35-500 IPM (Standard)		
		50-750 IPM (30 Tooth Gear)		
2.6	Drive Rolls	2.4mm solid Drive Rolls		
2.6	Feeder construction	4 Roll Driven with toolless changeover		
2.7	Display	Digital preset for voltage and wire feed speed		
<b>3.0</b>	<b>Hand Held Torch</b>			
3.1	Gun Type	Hand Held SAW Welding Head		
3.2	Rating	600 Amps @ 100% Duty cycle		
3.3	Wire Size	2.4mm Solid		
3.4	Flux Hopper	Optional pressured or gravity feed		
3.5	Contact Tips	Threaded type to suit 2.4mm		
<b>4</b>	<b>Following items shall be supplied additionally along with each welding equipment</b>			
4.1	Input Power Cable & Ground cable (90sq mm) of 5 m length each with clamps			
4.2	1 numbers of SAW Welding Torch			
4.3	Consumables like Contact Tips, Cone, Nozzles, Wire feed rollers etc suitable for 2.4 mm SAW Gun.			
4.4	Standard tool kit and accessories along with each machine.			
4.5	Detailed drawings of electrical circuits, list of spare parts & maintenance manual			
4.6	Inter connecting cables should have protective shielding & Electronic components should have safety features against any fluctuations in electric supply			
<b>5</b>	<b>Qualifying Criteria</b>			

5.1	Only OEMs or Authorised Dealers of OEMs to submit the offers with valid Authorisation Letter		
5.2	Make: Lincoln/Miller/Kemppi/Esab/ only		
5.3	Warranty: Min 3 years from the date of commissioning		
<b>6</b>	<b><u>General Terms &amp; Conditions</u></b>		
6.1	Firm should provide full technical details with catalogues.		
6.2	All the welding equipments shall be installed & commissioned at BEML, KGF.		
6.3	Firm to indicate the prices for consumable to enable BEML to purchase along with the machine.		
6.4	Firms to indicate compliance (Yes/No) to all the above points.		