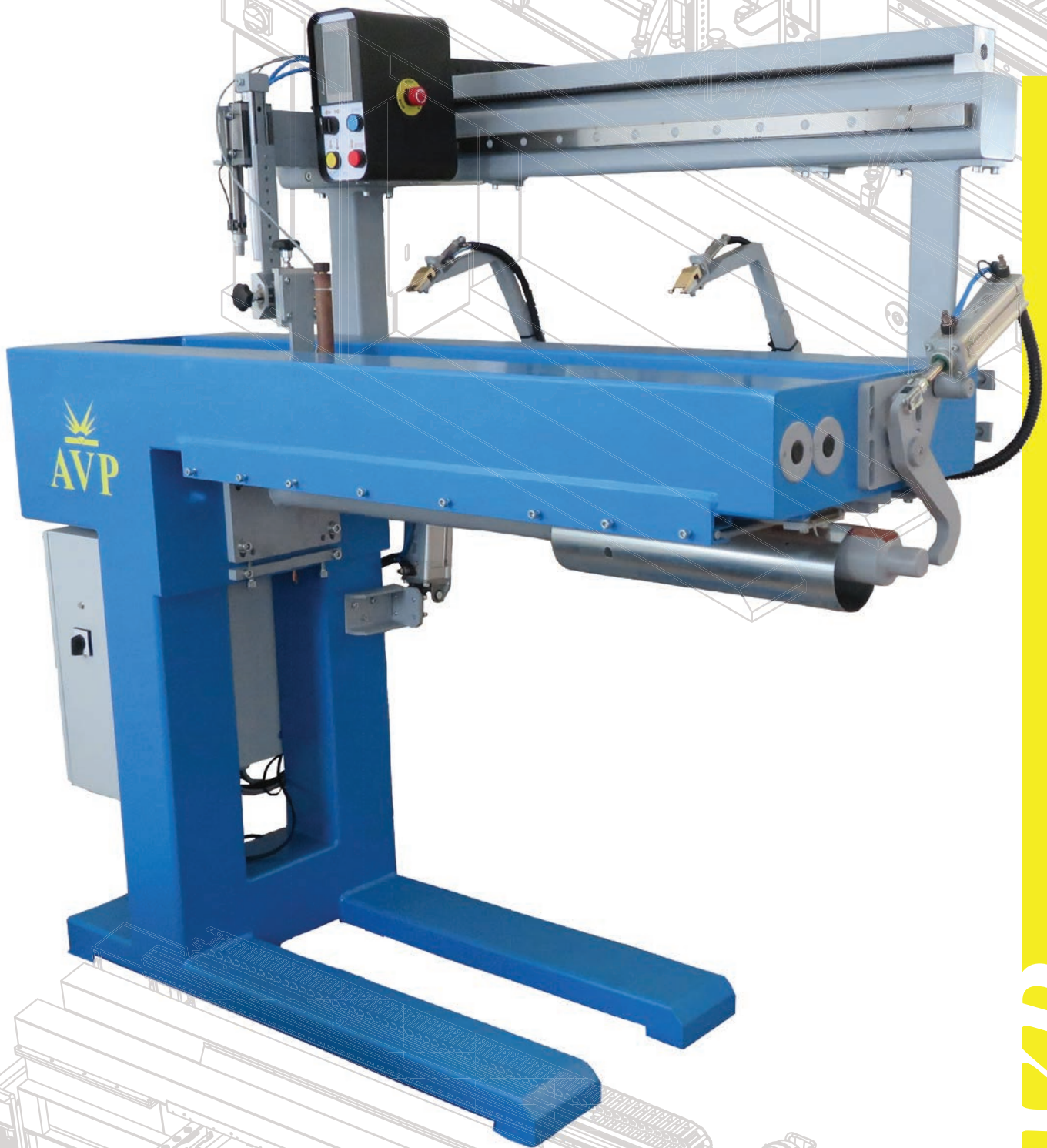




WELDING
AUTOMATION



VSV (101, 201, 301), VSV-HYD, VSV-S

LONGITUDINAL WELDING SEAMERS



LONGITUDINAL WELDING SEAMERS



VSV-S 401



VSV 191-1500 (laser welding)



VSV 301 (with walk-on structures)



DESCRIPTION:

Automatic longitudinal welding seamers enable high-quality welding of **steel tubes or sheets**, thicknesses of 0.5 to 3 mm **without the need for previous binding** (tack welds) and up to 8 mm with binding welds. They can be used for welding using TIG (GTAW), MIG (GMAW), plasma, laser, or SAW processes. **The workpiece is clamped with a unique clamping system** that enables fast and easy positioning. A water-cooled copper rail with protective gas underflow can be used. A touch display NC control is used to adjust welding parameters and save programs. Adjustable limiters on the rail restrict the welding length. The torch can be precisely positioned as required (3-axis adjustment) with the possibility of corrections during welding.

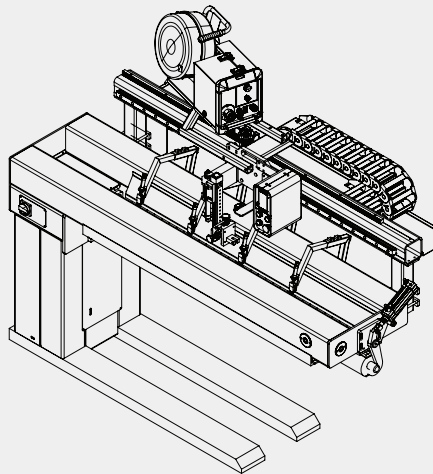
OPTIONS:

- Arc Voltage Control system integration,
- multi-stage clamping,
- 2 axis torch actuators,
- seam tracking,
- automatic start & stop detection,
- welding cameras,
- line laser,
- additional safety: bolt mechanism,
- stainless steel support bar,
- water-cooled copper backing bar,
- wire feeding unit,
- touch display upgrade to 10.1",
- standalone command panel.

LONGITUDINAL WELDING SEAMERS: TYPES

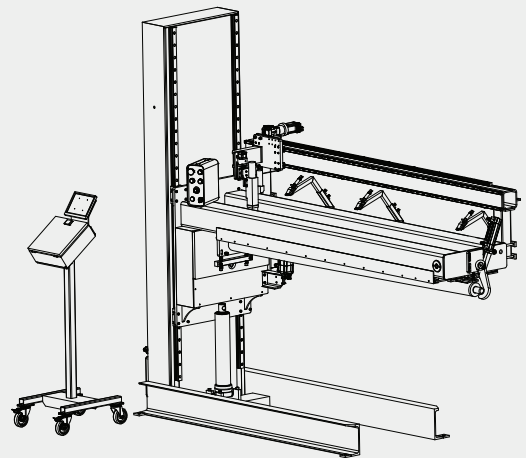
VSV (standard)

The standard VSV type is designed for outside longitudinal seam welding. It is suitable for high-demand production of all types of steel and includes a pneumatic bolt and a centering device.



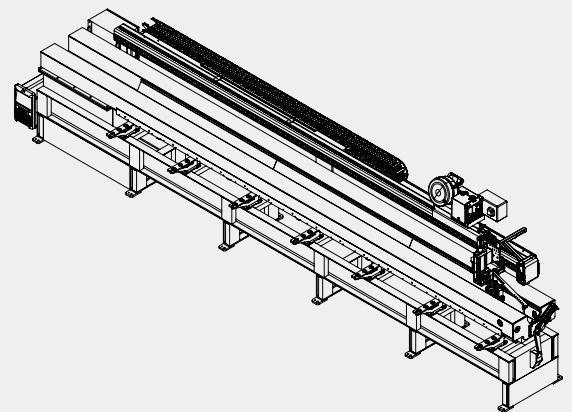
VSV-HYD (hydraulic)

This type is used for outside seam welding. The hydraulic lift allows for easy and more ergonomic operation with various workpiece sizes.



VSV-S

VSV-S is a low-profile seamer, designed for inside welding of pipes and welding of steel sheets. The welding length for this type is available up to 12 m.

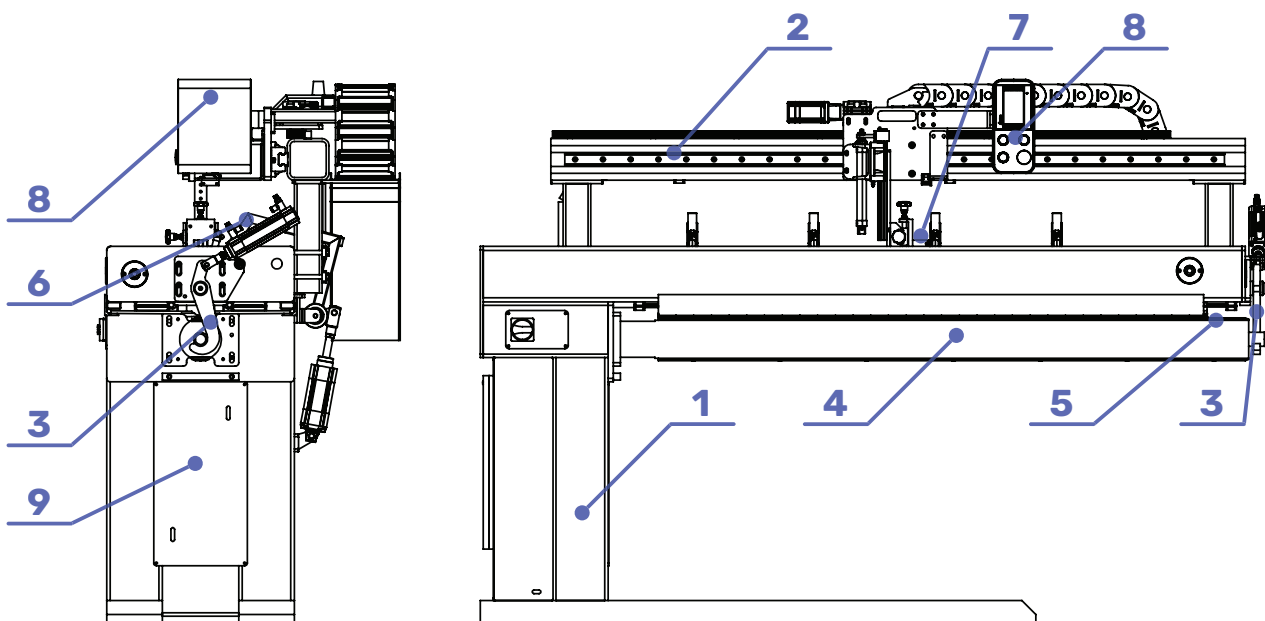


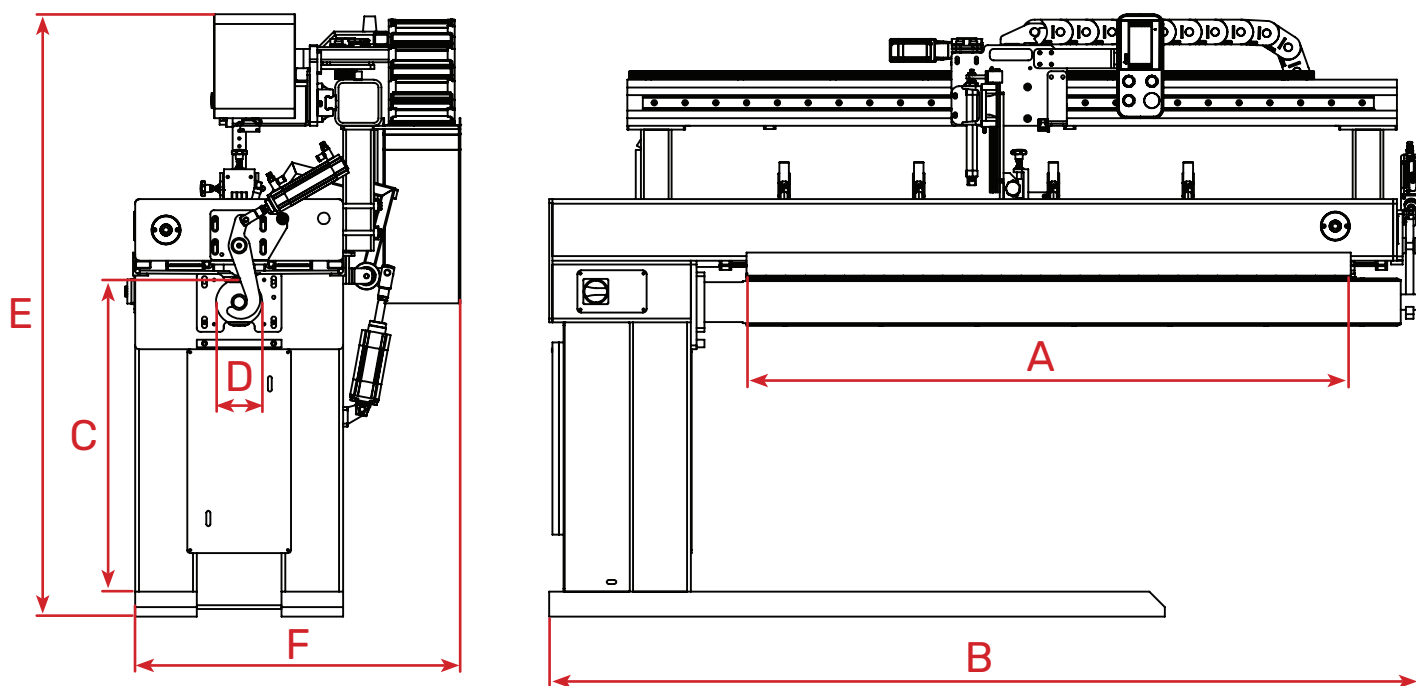
LONGITUDINAL WELDING SEAMERS - STANDARD

CODING SYSTEM:

VSV	1	0	1	*WELDING PROCESS
 ○	 ○	 ○	 ○	0. TIG (GTAW)
Machine type identifier	Welding length [m]	Welding process*	Quantity of welding torches	1. MIG / MAG (GMAW)
				2. SAW
				3. PLASMA
				9. LASER

- ① **Framework**
- Different sizes.
- ② **Bridge**
- Used for horizontal torch movement.
- ③ **Bolt (clamping)**
- Pneumatic bolt.
- ④ **Backing bar**
- Pneumatic clamping system, - different diameters.
- ⑤ **Welding copper rail**
- Water or air cooled.
- ⑥ **Centering device**
- Used for fast insertion of the welding piece.
- ⑦ **Welding torch**
- Any type can be mounted.
- ⑧ **Command cabinet (panel)**
- Cabinet for setting welding parameters.
- ⑨ **Control cabinet**
- Main electrical box.
- ⑩ **Foot switches**
- Clamping and unclamping "hands free".





		VSV 101/111/121/191	VSV 2XX	VSV 3XX
A*	mm	1050	1550	2050
B		2000	2500	3000
C		800	1000	1000-1300
D (min)		80	100	130
E		1800	1800	1800-2100
F		800	800	800

"XX" refers to welding process and torch quantity, both can be custom.
 *Other dimensions available.



VSV 101 - 1500

		VSV 101	VSV 201	VSV 301
Min./max. diameter*		80/800	130/1300	180/1500
Welding length	mm	1050	2050	3050
Welding speed	cm/min	10 - 200		
Voltage rating	V	230		

*The min./max. diameter varies with the welding length. Typically, a longer weld length corresponds to a larger minimum diameter. The diameter on VSV standard (outside welding) can be customized up to 2200 mm. Bigger diameters require a modular construction.

LONGITUDINAL WELDING SEAMERS: VSV-HYD



VSV-HYD 311 (hydraulic lift)

Welding length	mm	1050	2050	3050
Welding speed	cm/min	10 - 200		
Voltage rating	V	230 (50 Hz)		
Minimum diameter	mm	80	130	180
Maximum diameter*	mm	800	800 - 1300	1500
TIG				
Product code		VSV-HYD 101	VSV-HYD 201	VSV-HYD 301
Material thickness	mm	0,5 - 3	0,6 - 3	0,8 - 3
MIG / MAG				
Product code		VSV-HYD 111	VSV-HYD 211	VSV-HYD 311
Material thickness	mm	0,8 - 5	1 - 6	1 - 6
PLASMA				
Product code		VSV-HYD 131	VSV-HYD 231	VSV-HYD 331
Material thickness	mm	3-10	3-10	3-10
LASER				
Product code		VSV-HYD 191	VSV-HYD 291	VSV-HYD 391
Material thickness	mm	0,5 - 2		

*Can be customized.

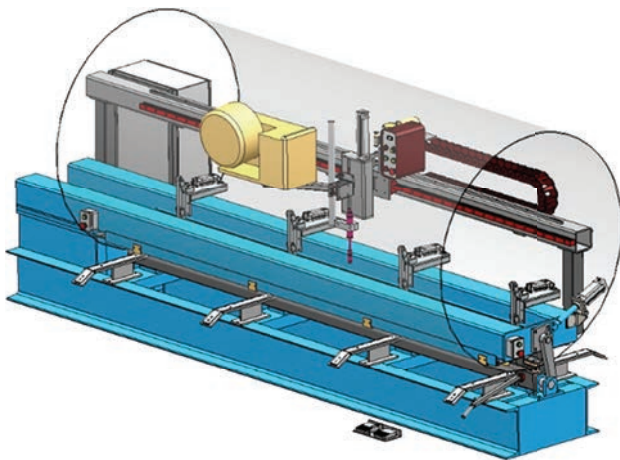
LONGITUDINAL WELDING SEAMERS: VSV-S



VSV-S 311



VSV-S 611



VSV-S 311



PRODUCT EXAMPLE

PROPERTIES:

The VSV-S type is used primarily for **inside longitudinal welding**. It features a specialized gantry for heavy-duty use. Supports with bearings help the operator to easily insert steel sheets or tubes and align to the center. A special heavy-duty centering device is installed that helps with alignment. For easier control of tube inside welding, we suggest using a welding camera and a standing command panel outside the machine.

- Backing bars can easily be replaced if needed. A bar with rail for welding aluminum or a bar with rail (made out of copper) for welding steel. It is also possible to have two rails on a single backing bar and only rotate it for 180° along its axis.
- All welding parameters can be set and saved using the touch display NC system.

Welding process		ALL WELDING PROCESSES
Thickness	mm	1 - 8
Minimum diameter	mm	1350
Weld length	mm	3050 - 12050
Weld speed	cm/min	10 - 200
Voltage rating	V	230