



# PIPEMASTER 515

## PROGRAMMABLE POWER SOURCE FOR ORBITAL WELD HEADS

The latest generation of Pipemaster power sources is the result of a new direction in power source design. The Pipemaster 515 brings the benefits of digital technology to the orbital welding customer: unparalleled accuracy, repeatability, and reliability. The new model is half the size and weight of previous models. Digital technology forever eliminates the need for periodic weld head calibration – motor speeds and response characteristics remain accurate and stable regardless of wear, and weld heads can be interchanged without time-consuming calibration.

- Unique auto-programming for multi-pass welding
- Easy to program
- Rugged design

# PIPEMASTER 515

## FEATURES

- Multi-pass welding of pipes/tubes/tubesheets
- Full function capability (torch rotation, filler wire feed, electronic arc gap control, electronic oscillation)
- Operates all models of Magnatech weld heads (GTAW process)
- 200 amp output
- Autoranging input eliminates all internal modifications
- Up to 100 levels per program (time-based programs)
- Stores 100 weld programs internally
- AutoProgram automatically generates procedures
- Programming and operation guided by simple prompts
- Teach mode allows rapid program development
- Programmable "override limits" provide supervisory control
- Weld parameter monitoring/out-of-limits reporting for QA/QC purpose
- Transfer programs and QC data to PC using standard USB flash drive
- AutoTack automatically generates tack weld programs
- Large color LCD display
- Stainless steel case
- Help files provide immediate information/assistance
- Password protection of key functions
- Waterproof pendant with 7.6 m (25') cable
- Auto rewind feature unwraps cable at weld completion
- All weld head functions capable of synchronization with pulsed current output
- Selectable position or time-based programming
- Integral switch prevents welding without torch gas flow
- Integral printer
- Detachable coolant recirculator with integral flow switch protection
- Meets applicable NEMA, CE, CSA standards



## SPECIFICATIONS

Application	For use with all Magnatech weld head models (GTAW process), welding lathes, and dedicated weld systems
Functions controlled	Weld current output/current pulsing, weld head rotation, weld head wire feed speed, electronic arc voltage control, electronic torch oscillation, electronic torch cross-seam adjustment
Output power	0 – 200 amps
Input power requirements (rated load)	115/230 VAC, 1 Ø, 5.0 KVA, 50/60 Hz autoranging (no modifications necessary)
Internal memory capacity	100 weld programs
Units of measurement	Metric and Inch (selectable)
Program transfer	Solid state digital media (USB flash drive,
Language selection	English, Spanish, German, French, others
Settable override limits	Individually scalable overrides on each function 0 – 100%
Maximum open circuit voltage	80 V
Water and gas flow switches	Standard. Prevent damage to equipment and workpiece
Data recording/printout	Operator ID, weld ID number, program number, material, OD, wall thickness, date, time, weld head model, project, drawing, programmed parameters, user notes
QC-parameter monitoring/ recording/printout	Records actual parameters and deviations from preprogrammed limits
Arc start type	High voltage impulse
Operating/storage temperature	Operating: -18 to 50° C (0 to 120° F) Storage: -25 to 60° C (-20 to 140° F)
Humidity	To 98% RH (non-condensing)

**MAGNATECH**

AUTOMATIC PIPE WELDING SOLUTIONS

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