

Beam Shapes and Welder Specifications

Wide Variety of Beam Shapes

PHI understands that different beam configurations have different welding requirements. PHI's automatic steel beam welders can weld a wide variety of beam shapes. Welding Operation -- Automatic Steel Beam Welders

Working at a convenient push-button console, the operator presses the start button. The machine automatically holds the steel in position, while the work piece is fed under the two weld heads. Pressure and guide rollers maintain accurate alignment of web and flanges. All guides are easily adjustable to match the dimensions of the beam section. A pair of submerged twin-arc welders performs welding. The system automatically dispenses and removes flux, reducing labor requirements and cutting material costs through recycling of the flux. Outlining PHI's Welder Specifications

Here is a detailed look at PHI's welder specifications:

- Web Thickness: 1/8" to 1/2"
- Web Width: 5" min. To 72" max.
- Web Taper: 15-degree max.
- Flange Thickness: 3/16" min. To 1.5" max.
- Flange Width: 4" min. To 20" max.
- Beam Length: 8 ft. min.
- Beam Section: 200 lbs./ft. Max.
- Beam Weight: 12,000 lbs. overall, max.
- Weld Fillet Size: 1/8" min. to 5/16" max.
- Welding Speed: 20" to 120" per minute Typical Welding Speed
- 1/8" fillet on 10 ga. material 20" to 100"/min.
- 3/16" fillet on 1/4" material 60" to 70"/min.
- 5/16" fillet on 3/8" material 25" to 30"/min.