

# Kemwelder IV

Welding system for rapid and reliable repairs in tool making and mould building. Product Code: 339100

- Pre-set welding parameters for variety of materials
- Ability to program bespoke welding operations
- Shielding gas process
- Can weld a variety of materials (e.g. Steel & Aluminium)
- Handheld tablet with lessons for using the welder
- Package includes microscope (10x magnification)
- Welding kit is small and portable

The welder works by gently touching the spot of the welding point with the electrode tip. After 2 seconds, the control unit triggers welding and at the same time an electromagnet draws the electrode back. You can precisely position the electrode for subsequent points which can then be triggered every second. For safety, the shutter of the microscope closes with each weld.

**Contents Include:** Control unit, handpiece with 125 cm connecting hose, handpiece for attachment, magnetic earth cable with 150 cm cable, stereo welding microscope with glare protection filter, 10x, LED lighting, swivel arm, switchable magnetic foot (1200 N) flowmeter, welding rod holder.

### Complete with accessories:

Brass brush, 10 special electrodes Ø 0.6 mm with 1 diamond disc, foot switch, 5 m gas hose, handpiece racks

**NOTE: Kemwelder IV requires argon (shielding) gas**

Welding fillers (length 333 mm, Ø 0.4 mm)															
Hardness	For	Al	C	Cr	Cu	Fe	Mg	Mn	Mo	Ni	Si	Ti	Zn	Zr	Code
Soft	1.2311, 1.2312, 1.2162, <b>1.2738</b>	0.1				#	1.1	0.5		0.6					339108
42 - 46 HRc	1.2082, 1.2083, 1.2343, 1.2367-1.2606, <b>1.2767</b>	0.25		5.0		#	0.7	4.0		0.5	0.6				339109
53 - 58 HRc	1.2082, 1.2083, 1.2343, 1.2344, 1.2367-1.2606, <b>1.2767</b>	0.35		7.0		#	1.2	2.0		0.3	0.3				339110
53 - 58 HRc	1.2082, 1.2083, 1.2311, 1.2312, <b>1.2343</b> , 1.2344, 1.2367-2606, 1.2767, 1.2842	0.35		7.0		#	1.2	2.0		0.3	0.3				339120
54 - 60 HRc	1.2379, <b>1.2436</b> , 1.2601	0.5		9.5			0.5			3.0					339121
54 - 60 HRc	2.4060, 2.4061, <b>2.4066</b> , 2.4068		0.1			#	3.5	55.0			+				339122
54 - 60 HRc	GG (grey cast iron) and GGG (globular grey cast iron) materials, miscellaneous types of cast iron		0.1			#	3.5	55.0			+				339123
54 - 60 HRc	connections of various different materials. 1.2316		0.10		30	#	1.6			0.4					339124
220 HB	Cu-Al multi-alloy bronzes, platings on cast and steel materials	7.5				#	2.5	13.0		2.5					339125
140 HB	Cu-Al multi-alloy bronzes, platings on cast and # steel materials, in addition to mixed joints of different materials	8				#	2.0	2.2		2.2					339126
140 HB	aluminium	#					<0.4	<0.2		5.0					339127
140 HB	aluminium	#					0.2			12					339128
140 HB	ALMg2,7Mn, AKLMg4,5Mn, ALMg5, <b>ALMgSi0,7</b> , ALMgSi1, ALMgSiCu, ALZn4,5Mg1, G-ALMg3, G-ALMg5	#		0.05			4.5	0.7			0.25	0.15	0.25	0.1	339129
				0.25			5.2	1.1						0.2	

# - Remainder

Other Ø sizes available on request (0.2 - 0.8mm)



Spares & Accessories	Description	Code
Handpiece		339111
Handpiece with longer cable	Handpiece (2.5 m), magnetic earth cable (2.5 m) and 2 x extension cables (microscope, 2 m)	339112
Electrode grinding motor	complete with diamond grinding disc and T-plug	339106
Fine welding nozzle Ø 3 mm		339113
Collet	for electrodes	0.6 mm 339114 0.8 mm 339115
Lock nut		
Electrodes 50 mm	ground on both sides, Contents = 10 pieces + 1 diamond grinding disc on shank	0.6 mm 339116 0.8 mm 339117
Gas hose Ø 6 mm		339118
Fine welding nozzle Ø 3 mm	30 mm longer than 32-8613	339119
Protection Shield		339104

