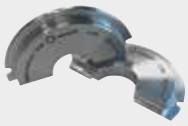
Accessories for ORBIWELD, ORBIWELD S and ORBIWELD X

Clamping inserts

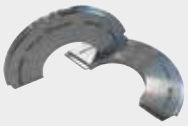
Made of aluminum. One clamping insert is comprised of two half shells for one clamping side.

Two clamping inserts (i.e. 4 half shells) are required for each tube diameter.
For ORBIWELD 115S and 170 you can select between the wide "W" and small (narrow) "S" clamping inserts which can be combined randomly with each other.

Clamping insert blanks for unscrewing.



Clamping insert
for OW 38S and OWX 1.5, 2-part
for a clamping insert



Clamping insert
for OW 76S and OWX 3.0, 2-part
for a clamping side



Clamping insert "S" (small/narrow)
for OW 115S, 2-part
for a clamping side



Clamping insert "W" (wide)
for OW 115S, 2-part
for a clamping side



Clamping insert "S" (small/narrow)
for OW 170, 2-part
for a clamping side



Clamping insert "W" (wide)
for OW 170, 2-part
for a clamping side

TUBE OD		OW 38S / OWX 1.5	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
3.00	0.118	826 002 120	-		-	-	-	-
3.18	0.125	826 002 122	-		-	-	-	-
4.00	0.157	826 002 124	-		-	-	-	-
4.76	0.187	826 002 125	-		-	-	-	-
4.78	0.188	826 002 126	-		-	-	-	-
5.95	0.234	826 002 127	-		-	-	-	-
6.00	0.236	826 002 128	827 002 120		-	-	-	-
6.35	0.250	826 002 129	827 002 121		-	-	-	-
7.00	0.276	826 002 130	-		-	-	-	-
7.50	0.295	826 002 131	-		-	-	-	-
7.94	0.313	826 002 132	827 002 124		-	-	-	-
8.00	0.315	826 002 133	827 002 125		-	-	-	-
9.00	0.354	826 002 134	827 002 126		-	-	-	-
9.53	0.375	826 002 135	827 002 127		-	-	-	-
9.95	0.392	826 002 136	-		-	-	-	-
10.00	0.394	826 002 137	827 002 129		-	-	-	-
10.10	0.398	826 002 138	827 002 130		-	-	-	-
10.20	0.402	826 002 139	827 002 131		-	-	-	-
11.00	0.433	826 002 140	827 002 132		-	-	-	-
11.95	0.470	826 002 142	827 002 134		-	-	-	-
12.00	0.472	826 002 143	827 002 135		-	-	-	-
12.10	0.476	826 002 144	827 002 136		-	-	-	-
12.70	0.500	826 002 145	827 002 137		-	-	-	-
13.00	0.512	826 002 146	827 002 138		-	-	-	-
13.20	0.520	-	827 002 139		-	-	-	-
13.50	0.531	826 002 148	827 002 140		-	-	-	-
13.70	0.539	826 002 149	827 002 141		-	-	-	-
14.00	0.551	826 002 150	827 002 142		-	-	-	-
14.30	0.563	826 002 151	827 002 143		-	-	-	-
14.70	0.579	826 002 152	-		-	-	-	-
15.00	0.591	826 002 153	827 002 145		-	-	-	-
15.30	0.602	826 002 154	827 002 146		-	-	-	-
15.60	0.614	826 002 155	827 002 147		-	-	-	-
15.70	0.618	826 002 156	827 002 148		-	-	-	-
15.88	0.625	826 002 157	827 002 149		-	-	-	-
16.00	0.630	826 002 158	827 002 150		-	-	-	-
16.70	0.657	826 002 159	-		-	-	-	-
17.00	0.669	826 002 160	827 002 152		-	-	-	-
17.20	0.677	826 002 162	827 002 154		-	-	-	-
17.30	0.681	826 002 163	827 002 155		-	-	-	-
18.00	0.709	826 002 164	827 002 156		-	-	-	-
19.00	0.748	826 002 165	827 002 157		-	-	-	-

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TUBE OD		OW 38S / OWX 1.5	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
19.05	0.750	826 002 166	827 002 158		-	-	-	-
19.50	0.768	826 002 167	827 002 159		-	-	-	-
20.00	0.787	826 002 168	827 002 160		824 002 120	-	-	-
21.00	0.827	826 002 169	827 002 161		-	-	-	-
21.30	0.839	826 002 170	827 002 162		824 002 122	824 002 322	-	-
21.70	0.854	826 002 171	827 002 163		824 002 123	-	-	-
22.00	0.866	826 002 172	827 002 164		824 002 124	-	-	-
22.22	0.875	826 002 173	827 002 165		-	-	-	-
22.23	0.875	826 002 174	827 002 166		824 002 126		-	-
22.55	0.888	826 002 175	-		-	-	-	-
23.00	0.906	826 002 176	827 002 168		824 002 128	824 002 328	-	-
24.00	0.945	826 002 177	827 002 169		824 002 129	-	-	-
25.00	0.984	826 002 179	827 002 171		824 002 131	824 002 331	-	-
25.25	0.994	826 002 180	827 002 172		-	-	-	-
25.40	1.000	826 002 181	827 002 173		824 002 133	824 002 333	-	-
26.00	1.024	826 002 182	827 002 174		-	-	-	-
26.70	1.051	826 002 183	827 002 175		824 002 135	-	-	-
26.90	1.059	826 002 184	827 002 176		824 002 136	824 002 336	-	-
27.00	1.063	826 002 185	827 002 177		-	-	-	-
27.20	1.071	826 002 186	827 002 178		824 002 138	-	-	-
28.00	1.102	826 002 187	827 002 179		824 002 139	-	-	-
29.00	1.142	826 002 188	827 002 180		824 002 140	824 002 340	-	-
30.00	1.181	826 002 189	827 002 181		824 002 141	-	-	-
30.53	1.202	826 002 190	827 002 182		824 002 142	-	-	-
31.75	1.250	826 002 191	827 002 183		824 002 143	824 002 343	-	-
31.80	1.252	826 002 192	827 002 184		824 002 144	-	-	-
32.00	1.260	826 002 193	827 002 185		824 002 145	824 002 345	-	-
33.00	1.299	826 002 194	827 002 186		824 002146	-	-	-
33.40	1.315	826 002 195	827 002 187		824 002 147	-	-	-
33.70	1.327	826 002 196	827 002 188		824 002 148	824 002 348	-	-
34.00	1.339	826 002 197	827 002 189		824 002 149	-	-	-
35.00	1.378	826 002 198	827 002 190		824 002 150	824 002 350	-	-
36.00	1.417	826 002 199	827 002 191		824 002 151	-	-	-
38.00	1.496	826 002 200	827 002 192		824 002 152	824 002 352	-	-
38.10	1.500	826 002 201	827 002 193		824 002 153	824 002 353	-	-
40.00	1.575	-	827 002 194		824 002 154	-	-	-
41.00	1.614	-	827 002 195		824 002 155	824 002 355	-	-
42.00	1.654	-	827 002 196		824 002 156	-	-	-
42.16	1.660	-	827 002 197		824 002 157	-	-	-
42.30	1.665	-	827 002 198		-	-	-	-
42.40	1.669	-	827 002 199		824 002 159	824 002 359	-	-
42.70	1.681	-	827 002 200		824 002 160	-	-	-
43.00	1.693	-	827 002 201		824 002 161	824 002 361	-	-
44.00	1.732	-	827 002 203		-	-	-	-
44.45	1.750	-	827 002 204		824 002 164	824 002 364	-	-
44.50	1.752	-	827 002 205		824 002 165	-	-	-
45.00	1.772	-	827 002 206		824 002 166	-	-	-
48.00	1.890	-	827 002 208		824 002 168	-	-	-
48.26	1.900	-	827 002 209		824 002 169	-	-	-
48.30	1.902	-	827 002 210		824 002 170	824 002 370	-	-
48.60	1.913	-	827 002 211		824 002 171	-	-	-
50.00	1.969	-	827 002 212		824 002 172	824 002 372	825 002 120	-
50.80	2.000	-	827 002 213		824 002 173	824 002 373	825 002 121	825 002 321
51.00	2.008	-	827 002 214		824 002 174	824 002 374	-	-
52.00	2.047	-	827 002 215		824 002 175	824 002 375	-	-
53.00	2.087	-	827 002 216		824 002 176	824 002 376	825 002 124	-
54.00	2.126	-	827 002 217		824 002 177	824 002 377	-	-
57.00	2.244	-	827 002 218		824 002 178	-	-	-
60.00	2.363	-	827 002 219		824 002 179	-	-	-
60.10	2.366	-	827 002 220		-	-	-	-
60.30	2.374	-	827 002 221		824 002 181	824 002 381	825 002 129	825 002 329
60.45	2.380	-	827 002 222		824 002 182	-	-	-
60.50	2.382	-	827 002 223		824 002 183	-	-	-
63.00	2.480	-	827 002 224		824 002 184	824 002 384	-	-
63.20	2.488	-	827 002 225		-	-	-	-
63.50	2.500	-	827 002 226		824 002 186	824 002 386	825 002 134	825 002 334
65.00	2.559	-	827 002 227		824 002 187	-	-	-

CLOSED ORBITAL WELD HEADS

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TUBE OD		OW 38S / OWX 1.5	OW 76S	OWX 3.0	OW 115S "S" (SMALL/NARROW)	OW 115S "W" (WIDE)	OW 170 "S" (SMALL/NARROW)	OW 170 "W" (WIDE)
[MM]	[INCH]	CODE	CODE		CODE	CODE	CODE	CODE
70.00	2.756	-	827 002 228		824 002 188	824 002 388	825 002 136	825 002 336
70.20	2.764	-	-		824 002 189	824 002 389	-	-
73.00	2.874	-	827 002 230		824 002 190	-	-	-
73.03	2.875	-	827 002 231		824 002 191	-	-	-
75.00	2.953	-	827 002 233		824 002 193	-	-	-
76.00	2.992	-	827 002 234		824 002 194	-	-	-
76.10	2.996	-	827 002 235		824 002 195	824 002 395	825 002 143	825 002 343
76.20	3.000	-	827 002 236		824 002 196	824 002 396	825 002 144	825 002 344
76.30	3.004	-	827 002 237		824 002 197	824 002 397	-	-
80.00	3.150	-	-		824 002 198	824 002 398	-	825 002 346
82.00	3.228	-	-		824 002 199	-	-	-
82.30	3.240	-	-		824 002 200	-	-	-
85.00	3.346	-	-		824 002 201	824 002 401	-	825 002 349
88.90	3.500	-	-		824 002 203	824 002 403	825 002 151	825 002 351
89.00	3.504	-	-		824 002 204	-	-	-
89.10	3.508	-	-		824 002 205	824 002 405	-	-
90.00	3.543	-	-		824 002 206	-	-	-
100.00	3.937	-	-		824 002 209	-	-	-
101.60	4.000	-	-		824 002 210	824 002 410	825 002 158	825 002 358
104.00	4.094	-	-		824 002 211	824 002 411	825 002 159	825 002 359
108.00	4.252	-	-		824 002 212	-	825 002 160	-
110.00	4.331	-	-		824 002 213	-	-	-
114.00	4.488	-	-		824 002 215	-	-	-
114.30	4.500	-	-		824 002 216	824 002 416	825 002 164	825 002 364
115.00	4.528	-	-		824 002 217	824 002 417	825 002 165	-
127.00	5.000	-	-		-	-	825 002 167	825 002 367
127.05	5.002	-	-		-	-	-	-
129.00	5.079	-	-		-	-	825 002 169	825 002 369
133.00	5.236	-	-		-	-	825 002 170	-
139.70	5.500	-	-		-	-	825 002 171	825 002 371
152.40	6.000	-	-		-	-	825 002 173	825 002 373
154.00	5.063	-	-		-	-	825 002 174	825 002 374
159.00	6.260	-	-		-	-	825 002 175	-
165.20	6.504	-	-		-	-	825 002 177	-
168.30	6.626	-	-		-	-	825 002 178	825 002 378
170.00	6.693	-	-		-	-	825 002 179	825 002 379

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Clamping insert blanks

Clamping insert blanks

Ideal for special applications.
Completely closed clamping inserts for turning out yourself to customer-specific diameter areas.

ITEM	CODE	KG
Clamping insert blank for OW 38S/ OWX 1.5, 2-part	**826 002 210**	0.066
Clamping insert blank for OW 76S/OWX 3.0, 2-part	**827 002 241**	0.280
Clamping insert blank for OW 115S "S" (small/narrow), 2-part	**824 002 220**	0.590
Clamping insert blank for OW 115S "W" (wide), 2-part	**824 002 420**	1.445
Clamping insert blank for OW 170 "S" (small/narrow), 2-part	**825 002 185**	1.010
Clamping insert blank for OW 170 "W" (wide), 2-part	**825 002 385**	1.000



Packagings for clamping inserts

Packagings for clamping inserts

All clamping inserts are delivered as pairs in a plastic cover.
In case of a loss of the original packaging it can be reordered as a replacement.

ITEM	CODE	KG
Packaging clamping insert OW 38S/ OWX 1.5	**826 002 010**	0.019
Packaging clamping insert OW 76S/OWX 3.0	**827 002 010**	0.065
Packaging clamping insert OW 115S "S" (small/narrow)	**824 002 010**	0.101
Packaging clamping insert OW 115S "W" (wide)	**824 002 011**	0.129



Chamber insert for fittings

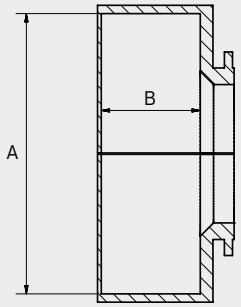
Chamber inserts for fittings

Clamping inserts for welding of fittings (e.g. flanges, flanged wheels and screw joints in the food processing industry).

1 chamber insert consists of 2 half shells.

Dimensions of the different chamber inserts:

ORBIWELD		DIMENSION "A"(Ø)	DIMENSION "B"
38S	[mm]	85.0	30.0
	[inch]	3.346	1.181
76S	[mm]	130.0	35.0
	[inch]	5.118	1.378
115S	[mm]	179.0	39.0
	[inch]	7.047	1.535
170	[mm]	214.0	44.0
	[inch]	8.425	1.732



ITEM	CODE	KG
Chamber inserts for fittings for OW 38S/ OWX 1.5	**836 050 016**	0.146
Chamber inserts for fittings for OW 76S/OWX 3.0	**837 050 017**	0.266
Chamber inserts for fittings for OW 115S /OWX 4.5	**838 050 016**	0.660
Chamber inserts for fittings for OW 170	**825 050 002**	0.852

T-piece clamping inserts

Clamping inserts with holding possibility of the collared hose and the hose to be welded. One complete T-piece clamping insert, 1 electrode adapter as well as 1 standard clamping insert (to be ordered separately) are required per task and dimension.

Please request respective questionnaire for order and submit together with a drawing.

Special clamping inserts for other orbital weld heads on request.
Internal centering with simultaneous shaping device on request.



T-piece clamping inserts

ITEM	TUBE OD MAX. [MM]	TUBE OD MAX. [INCH]	CODE	KG
T-piece clamping insert for OW 38S/ OWX 1.5	25.0	0.984	**826 050 038**	
T-piece clamping insert for OW 76S/OWX 3.0*	48.0	1.890	**827 050 005**	0.720
T-piece clamping insert for OW 115S	85.0	3.346	**824 050 004**	1.825
T-piece clamping insert for OW 170	144.0	5.669	**825 050 003**	3.700

Inserts for arc welding

For welding with standard arcs without straight leg root at tubes.
When using these inserts on a weld head side (right or left) only the gas protection around the arc is ensured; clamping does not take place so that the arc has to be crimped.

Insert consisting of:
- 2 basic retainer halves, independent of tube diameter
- 2 cover retainer halves, dependent of tube diameter*



Insert for arc welding
(Basic retainers/covers)

Basic retainers/covers
The covers are inserted into the basic retainers and can be turned so that the side of the elbow can exit at any angle from the weld head. The tube to be welded on the other side of the weld head is held via a standard clamping insert (standard clamping inserts are not included in the scope of delivery).

Arc covers for OW 38S
With the weld head OW 38S the customer-specifically manufactured covers (2 halves) are inserted directly in the head without basic retainer. A basic retainer is therefore not required.

Please specify or submit at order:
- The desired tube outer diameter and arc inner radius.
- **Drawing of the arc or sample part – a corresponding drawing template for this can be requested in advance.** We subsequently check whether an electrode adapter can additionally be used, if necessary.

ITEM	CODE	KG
Arc covers OW 38S complete*	**826 050 031**	0.017
Basic retainer for arc insert for OW 76S/OWX 3.0	**827 002 018**	0.150
Cover for arc insert for OW 76S/OWX 3.0*	**827 050 021**	0.030
Basic retainer for arc insert for OW 115S	**824 050 006**	0.150
Cover for arc insert for OW 115S*	**828 050 016**	0.054
Basic retainer for arc insert for OW 170	**825 050 005**	0.250
Cover for arc insert for OW 170*	**825 050 020**	0.045

* Please submit drawing of the arc or sample part at order.

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Electrode adapters

Robust brass adapter for lateral offset of the tungsten electrode.

Standard electrode adapter

For fillet weld applications and applications where lateral electrode offset is required. Can be ordered as a set or individually. Please note that the maximum weldable tube diameter is reduced during the use of an electrode adapter.

Complete sets consisting of:
- Basic part for extension
- 1 extension each for 15°, 30°, 45° and 90°
- Mounting screw(s)

FOR ELECTRODES WITH 1.6 MM DIAMETER.
ELECTRODE ADAPTERS USABLE UP TO MAX. TUBE OUTER DIAMETER

	[MM]	[INCH]
OW 38S	25,4	1.000
OW 76S	48,0	1.890
OW 115S	85,0	3.346
OW 170	144,0	5.669



Electrode adapters for OW 38S, OW 76S

ELECTRODE ADAPTER SETS	CODE	KG
Electrode adapter set OW 38S, standard	**826 050 034**	0.033
Electrode adapter set OW 76S/OWX 3.0, standard	**827 050 027**	0.089
Electrode adapter set OW 115S, standard	**828 050 022**	0.064
Electrode adapter set OW 170, standard	**825 050 022**	0.094
INDIVIDUAL PARTS FOR OW 38S		
Basic part electrode adapter OW 38S	**826 004 003**	0.013
Extension 10 mm/0.394", 15° for electrode adapter OW 38S	**823 004 008**	0.003
Extension 10 mm/0.394", 30° for electrode adapter OW 38S	**823 004 009**	0.003
Extension 10 mm/0.394", 45° for electrode adapter OW 38S	**823 004 010**	0.003
INDIVIDUAL PARTS FOR OW 76S		
Basic part electrode adapter OW 76S/OWX 3.0	**827 004 003**	0.024
Extension 15 mm/0.591", 15°/90° for electrode adapter OW 76S/OWX 3.0	**823 004 002**	0.005
Extension 15 mm/0.591", 30°/90° for electrode adapter OW 76S/OWX 3.0	**823 004 003**	0.005
Extension 15 mm/0.591", 45°/90° for electrode adapter OW 76S/OWX 3.0	**823 004 004**	0.005
INDIVIDUAL PARTS FOR OW 115S		
Basic part electrode adapter OW 115S	**828 004 004**	0.037
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 115S	**823 004 006**	0.009
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 115S	**823 004 005**	0.009
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 115S	**823 004 007**	0.009
INDIVIDUAL PARTS FOR OW 170		
Basic part electrode adapter OW 170	**825 004 001**	0.067
Extension 25 mm/0.984", 15°/90° for electrode adapter OW 170	**823 004 006**	0.009
Extension 25 mm/0.984", 30°/90° for electrode adapter OW 170	**823 004 005**	0.009
Extension 25 mm/0.984", 45°/90° for electrode adapter OW 170	**823 004 007**	0.009



Electrode adapter for OW 170

Electrode adapter for front seam welding

FOR ELECTRODES WITH 1.6 MM DIAMETER.
ELECTRODE ADAPTER APPLICABLE UP TO MAX. TUBE OUTER DIAMETER

	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW 38S	6,0	0.236	25,0	0.984
OW 76S/OWX 3.0	6,0	0.236	48,0	1.890
OW 115S	20,0	0.787	85,0	3.346

A chamber insert is mandatory for the non-workpiece-receiving weld head side and must be ordered separately.



Front seam adapter (without rotor)

ELECTRODE ADAPTER SETS FOR FRONT SEAM WELDING	CODE	KG
Electrode adapter set OW 38S front seam	**826 050 036**	0.045
Electrode adapter set OW 76S/OWX 3.0 front seam	**827 050 038**	0.045
Electrode adapter set OW 115 S front seam	**828 050 023**	0.070

Electrode adapter for internal welding

FOR ELECTRODES WITH 1.6 AND 2.4 MM DIAMETER.
ELECTRODE ADAPTER APPLICABLE UP TO MAX. TUBE INNER DIAMETER

	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW38S	18,0	0.709	36,6	1.441
OW76S/OWX 3.0	18,0	0.709	75,5	2.972
OW115S	20,0	0.787	113,5	4.469
OW170	20,0	0.787	168,5	6.600

MAX. ADJUSTABLE WELDING DEPTH (ROTOR CENTER TO ELECTRODE)

	ELEKTRODE 1,6 MM		ELEKTRODE 2,4 MM	
	[MM] min.	[INCH] min.	[MM] max.	[INCH] max.
OW38S	52,0	2.047	47,0	1.850
OW76S/OWX 3.0	52,0	2.047	47,0	1.850
OW115S	110,0	4.331	105,0	4.134
OW170	110,0	4.331	105,0	4.134

A clamping insert blank is mandatory for the non-workpiece-receiving weld head side and must be ordered separately.

ELECTRODE ADAPTER SETS FOR INTERNAL WELDING	CODE	KG
Electrode adapter set OW 38S internal welding	**826 050 037**	0.071
Electrode adapter set OW 76S/OWX 3.0 internal welding	**827 050 039**	0.071
Electrode adapter set OW 115 S internal welding	**828 050 024**	0.193
Electrode adapter set OW 170 internal welding	**825 050 026**	

Table mounts

Practical and sturdy aluminum table mount (anodized).
The mount allows a convenient and secure placing and fixating of the ORBIWELD orbital weld heads.

The mount can be mounted rapidly and easily at the worktop by means of the integrated table clamp. Thus the weld head can be firmly fixed in the mount – also ideal for temporary placement of the weld head between individual weldings.

TECHNICAL SPECIFICATIONS	TABLE MOUNTS
Dimensions (LxDxH)	180 x 140 x 185 mm 7.1" x 5.5" x 7.3"
Clamping range (from bottom surface of table to maximum extended screw clamp)	max. 65 mm / 2.56"

ITEM	CODE	KG
Table mount OW 38S/ OW 76S/ OW 12*	**826 030 006**	1.250
Table mount for OW 65, OW 115S, OW 170	**823 030 006**	1.070

*For OW 12 via adapter included in scope of delivery





Table mounts

Other accessories for orbital welding

- ESG electrode grinders
- ORBmax residual oxygen meter
- ORBIPURGE forming set
- Hose package extensions
- WS2 tungsten electrodes
- Welding current connection adapter set

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