



WIRE BUTT WELDERS STRONG AND RELIABLE



Draw resistant welds in wire drawing mills,
cable factories and at wire fabricators



PERFECT EASE OF OPERATION

- High welding capacity and superior repetitive welds in all material grades within a wide diameter range
- Rigid and long-lasting construction for tough working conditions
- Ease of operation by unskilled labour due to central setting of jaw distance, upsetting way and pressure.



DSH 035



DSH 025/EGV with mounted shear and annealing device EGV



DSH 015 with undercarriage, shear and grinding motor for deburring

A PARTICULAR SUBJECT: ANNEALING OF CARBON STEEL WIRE



DSH 070



DSH 090 with anneal device SGV for carbon steel

- Anneal device – included in each standard machine – operated by push button for short-cycle annealing according to visual control for low carbon steel qualities
- Anneal device **type SGV** for annealing of steel with medium carbon content having separate adjustable clamps, selection of anneal voltage by step switch
- Anneal device **type EGV** for annealing of steel with medium to high carbon content having separate adjustable clamps, potentiometer for manual continuous voltage adjustment and timer for limitation of anneal time
- Automatic anneal device **type GSS** for precise heat treatment of the welds, independent from the operator for controlling of heat process with regard to change of microstructure – device having separate adjustable clamps for soft transit of heat, with possibility of storing upto 99 programmes for anneal current and time in various temperature/time zones



DSH 090 with automatic anneal device GSS, with operator

CONSTANT DRAW RESISTENT WELDS

- Low maintenance machines offering ease of access to all machine components
- Clamping devices easily accessible offering a free view of wire ends for precise clamping
- Long-lasting, maintenance-free parallel guiding of the weld jaw within ball bearing bushes on a ground hardened shaft
- Optional extra: separate adjustment of jaw distance, upsetting way and pressure for individual adjustment of parameters for materials and alloys being difficult to weld



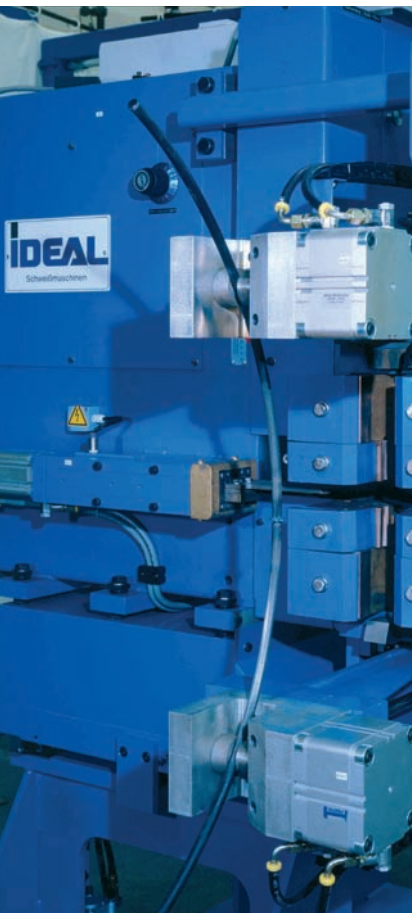
DSH 130 with anneal device SGV,
abrasive cutting tool and grinding motor



DSH 180

BUTT WELDER

type DCE 018 for steel cord



Flash Butt Welder type AS 15 V-D

Vertical welding of coil ends

- Ease of welding of wire coils in vertical position, hanging on a spike
- Ease of handling of wire by vertical uncoiling
- Vertical Welding Machines offered as Press Butt Welders (operated like type „DSH“) or alternatively as Flash Butt Welders – range 5 upto 12 mm diameter, alternatively 8 upto 16 mm diameter
- Machines equipped with undercarriage for driving to prepared wire ends, with inserting stop and separate clamping device for moving wire out of weld position for manual deburring by an operator

Butt welding of steel cord from 0,5 upto 1,8 mm diameter – also for strands with twisted wire

Machine equipped with:

- Clamping device in special design offering free view on wire ends for precise clamping of wire ends, with upper and lower current supply
- Cutting unit for cutting via electrical heating and sealing of single wires
- Testing device for checking of strength through rolls – optional: testing device for tensile strength
- Grinding motor with two disks for grinding of wire ends preparing a precise weld

Butt Welders for larger diameters upon request.

Further machines for special applications upon request.



DCE 018



TECHNICAL DATA

Type	Steel mm ø	Copper mm ø "NE" version	Aluminium/Brass mm ø "NE" version	kVA	Weight net/gross kg	Packing sizes mm
DSH 015	0,15 - 1,5	0,4 - 0,8	0,5 - 1,0	0,6	30 / 50	720 x 590 x 660
DSH 025	0,4 - 2,5	0,5 - 1,8	0,8 - 2,0	0,8	15 / 21	570 x 400 x 380
DSH 035	0,5 - 3,5	0,6 - 2,5	0,8 - 3,0	1,2	16 / 22	570 x 400 x 380
DSH 070	0,8 - 7,0	1,0 - 4,0	1,0 - 6,0	3,0	69 / 107	720 x 590 x 660
DSF 070					100 / 175	980 x 860 x 1350
DSH 090	1,5 - 9,0	1,5 - 5,0	2,0 - 8,0	4,5	76 / 114	720 x 590 x 660
DSF 090					105 / 180	980 x 860 x 1350
DSH 130	4,0 - 13,0	3,0 - 9,0	4,0 - 12,0	16,0	290 / 360	860 x 1000 x 1350
DSH 160	5,0 - 16,0	5,0 - 11,0	6,0 - 14,0	25,0	310 / 390	860 x 1000 x 1350
DSH 180	7,0 - 18,0	6,0 - 14,0	8,0 - 18,0	45,0	650 / 720	1350 x 1000 x 1600

- Due to the different electric conductivity of steel and non-ferrous metals the machines are equipped with appropriate welding transformers. For non-ferrous metal the „NE“ version will be used.
- Option for types DSH 015 upto DSH 160: Separate adjustment of jaw distance, upsetting way and pressure for optimal welding of especially non-ferrous metals.
- Types DSF 070 and DSF 090 with pedal clamping device and undercarriage = both hands free for handling of wire ends.

ACCESSORIES

■ Types DSH 015 – DSH 035 (manual clamping, manual upsetting)

- undercarriage with two wheels
- incorporated wire shear
- vertical grinding motor
- double filing tool for deburring
- magnifying glass

■ Types DSH/DSF 070, DSH/DSF 090 (manual clamping, manual upsetting)

- undercarriage with two wheels (type DSF incl.)
- work bench stand with four wheels
- vertical grinding motor
- pedal operated wire shear

■ Types DSH 130, DSH 160 (manual clamping, manual upsetting)

- undercarriage with four wheels
- vertical grinding motor to remove burr
- abrasive cutting device for steel or circular saw for non-ferrous wire

■ Type DSH 180 (pneumatic clamping, pneumatic upsetting, machine moveable on four wheels)

- work tables / vice
- abrasive cutting device for steel or circular saw for non-ferrous wire
- hand operated grinder / vertical grinding motor