

Lorch SpeedArc SpeedArc XT

Classification

SpeedArc and SpeedArc XT are synergetic waveform controlled welding process control variants applied in MSG welding (ISO 857 process no. 13) which are distinguished by their short and particularly forceful arc in the spray arc range. Since there is no bottom limit to the power range, this process also produces excellent welding results with the familiar short arc.

Benefits

Automation

Short spray arc that delivers exceptional directional stability

Full operating range from short arc to spray arc

Optimised for spray arc applications

Short and forceful arc with exceptional focus in the spray arc range

Extremely deep penetration

XT advantages

Particularly short and forceful spray arc that delivers exceptional directional stability

Arc characteristic is flexibly adjustable thanks to dynamic control

Operating ranges

Material	Inert gas [Ar/CO ₂]	Wire diameter [mm]	Additional data
SG Fe	82/18	0.8 - 1.6	WPS
	92/8	XT: 1.0 - 1.2	
Cr Ni 308	98/2	0.8 - 1.2	
Cr Ni 316		XT: 1.0 - 1.2	
Al Mg 4.5 Mn	Ar	1.0 - 1.6	
Al Mg 5		XT: 1.0 - 1.2	
Al Si 5			

- Welding programs for other operating ranges available on request
- Operating ranges may vary with the type of power source used
- Allows for using the welding current as an arc sensor tracking the seam

Notices

Settings

- Guiding parameters (primary settings): Wire feed speed, forecast value voltage
- Derived guiding parameters (forecast values): Sheet thickness, current, voltage
- Correction options: Wire feed speed, process dynamics (dynamics)

Readouts

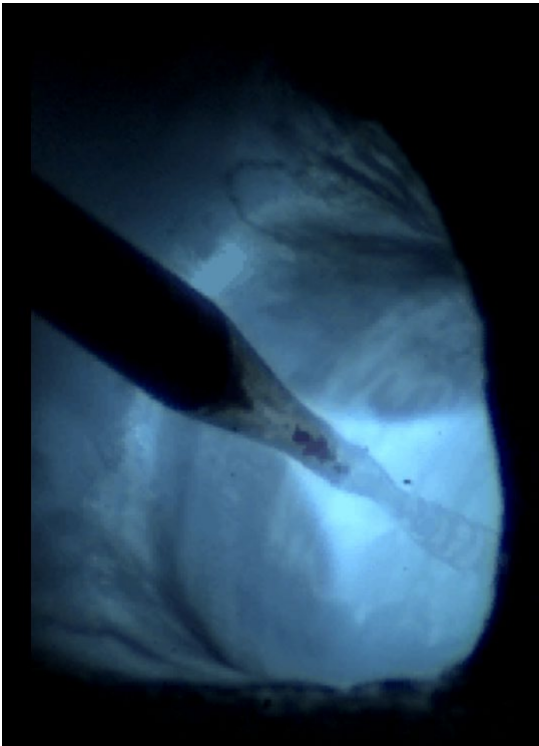
- Set value wire feed speed
- Forecast current [A] and voltage [V] (arithmetic means)
- output of electric heat [kW]
- Actual values (during welding) and hold values (after welding)

Availability

- Types of power sources: Lorch S-series, P-series, MicorMIG series
- WPS available, see operating ranges

More information

www.lorch.eu



SpeedArc

Steel with M21 inert gas and fillet weld

High speed image of the spray arc, the melting wire electrode, the fused cavern, the base material, and the metal transfer