

MAESTRO 1200 (I)

1200 AMP CAPACITY SAW WELDER



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Key Attributes

- MAESTRO1200 (I): Inverter based submerged arc welder for a wide range of automatic welding applications.
- Key Components: Welding head, flux hopper, flux, wire feed unit, electrode, and flux recovery unit; welding head delivers filler and flux to the joint.
- Two motorized slides.

Applications

- Welding pressure vessels like boilers
- Structural fabrication, pipelines, earth moving equipment
- Shipbuilding, railroad construction, and locomotives
- Repair of machine components

Salient Features

- **IGBT Inverter Technology:** Digitally controlled welding head and power source.
- **Energy Efficient:** High efficiency and power factor for significant energy savings over conventional SAW systems.
- **CC-CV Power Source:** Supports SAW and gouging; SAW welding possible in CC or CV modes.
- **Adaptive Control:** In CC mode, advanced technology ensures stable arc, deep penetration, and excellent bead quality.
- **Complete System:** Includes inverter power source, tractor/boom mounted welding head, and interconnecting cables; SAW flux provides shielding.
- **Programmable Memory:** Save and recall up to 10 welding programs.
- **User Interface:** 128×64 LCD with buttons, LEDs, and indicator lamps for simple operation.
- **Auto Mode Selection:** Automatically configures SAW mode based on welding head connections.

Technical Specifications

Parameter	Value	Unit
Input Voltage, Phase, Frequency	415V +15%/-10%, 3 Ph, 50/60 Hz	V AC
Input Power @ 415 V AC	55 @ 100% Duty Cycle 66 @ 60% Duty Cycle	KVA
Input Supply Current @ 415V AC	76 @ 100% Duty Cycle 92 @ 60% Duty Cycle	A
Efficiency	> 85	%
Power Factor	UP TO 0.93	-
Open Circuit Voltage @ 415v Input Supply	90 V	VDC
Welding Current Range (CC - Gouging Mode)	100-1200	A
Welding Voltage Range (CV - SAW Mode)	26 - 44	V



Technical Specifications

Parameter	Value	Unit
Welding Current (40°C)	1000 @ 100% Duty Cycle 1200@ 60% Duty Cycle	A
Welding Electrode Sizes (Dia) in MMA Application	3.2, 4, 5, 6.3	MM
Gouging Electrode Sizes (Dia) In Gouging Application	Upto 12	MM
SAW Welding Wire Sizes (Dia)	2.5, 3.2, 4, 5	MM
Cooling	FORCED AIR	TYPE
Class Of Insulation	H	-
Degree Of Protection	IP23	-
Dimensions (LxWxH - Including Eye Bolt)	930 X 525 X 950	MM
Weight (approx.)	115	KG

Technical Specifications - Welding Heads

Parameter	Value	Unit
Max. Welding current		
@ 60 % duty cycle	1500	A
@ 100 % duty cycle	1250	A
Wire diameter		
Single wire	2.0, 2.5, 3.15, 4.0, 5.0	mm
Twin wire	2.0 & 2.5 (Optional)	mm
Speed range		
Wire feed	0.5 - 4.0	m/min
Carriage	0.1 - 1.5	m/min
Input to control unit	42 from the Power Source	V
Range of adjustment		
Vertical (motorized)	100	mm
Transverse to direction of travel (motorized)	140 (total) / ±70 (from center position)	mm
Along the direction of travel	NA	-
Maximum Swivel		
Transverse to head travel	45	Degree
Parallel to head travel	30	Degree
Horizontal open swing	270	Degree
Standard bore for spool	285 - 315 (adjustable)	mm
Weight of the spool (Max.)	25	Kg
Flux hopper capacity	7.5	Kg
Dimensions		
Length x Width x Height	1095 x 666 x 965	mm
Total weight without flux and wire (Approx.)	70	Kg



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