



MAESTRO 1201 (F) / 1201 T (F)

1200 AMP CAPACITY SAW WELDER



Key Attributes

- MAESTRO 1201 (F) / 1201 T (F) outfits are Diode-based / Thyristor-based Submerged Arc Welders suitable for a wide range of automatic welding applications. The welding head is capable of supplying filler and flux metal to the joint for welding using main parts like Welding head, Flux hopper, Flux, Electrode wire feed unit, Electrode, and Flux recovery unit.
- The applications of submerged arc welding include the following:
 - Welding pressure vessels like boilers.
 - Fabricating structural outlines, pipes, earthmoving tools, shipbuilding, railroad construction, and locomotives.
 - Repairing machine parts.



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SALIENT FEATURES:

- The welder-friendly Tractor or boom mounted welding head with diode-based or thyristorized power sources is perfectly matched and adapted to local conditions, offering a range of models to suit every budget and need.
- The choice of boom mounted, or tractor mounted welding head models is offered with the power source.
- The boom mounted head comes with a choice of manual, semi-motorized, and fully motorized cross slides.
- The 'Dual Star Radial Rectifier' design enables smooth and stepless control of welding voltage for thyristorized systems.
- The diode-based system has provisions for adjusting the open circuit voltage over a wide range through tap changing switches on the front panel.
- Programmed sequential operations of power source, wire feed, and carriage speed control are achieved through built-in solid-state circuitry.

TECHNICAL SPECIFICATIONS

PARAMETERS	VALUE		UNIT
	PS 1201 (F)	PS 1201 T (F)	
STATIC CHARACTERISTICS	CV	CV	TYPE
SUPPLY VOLTAGE, PHASE, FREQUENCY	415 V, 3, 50	415 V, 3, 50	VOLTS AC, NO., HZ
INPUT KVA @ 100% duty cycle	54	63	KVA
RECOMMENDED SWITCH FUSE RATING	TP - 100	TP - 100	AMPS, AC
OPEN CIRCUIT VOLTAGE RANGE (MAX.)	35 - 63	62	VOLTS, DC
OPEN CIRCUIT VOLTAGE RANGE (ACTUAL)	29 - 54	NA	-
WELDING CURRENT RANGE	200 - 1200	200 - 1200	AMPS, DC
WELDING CURRENT @ 60% DUTY CYCLE	1200	1200	-
WELDING CURRENT @ 100% DUTY CYCLE	1000	1000	-
INSULATION	H	H	CLASS
COOLING	FORCED AIR	FORCED AIR	TYPE
DIMENSIONS (L X W X H)	1225 X 800 X 900	1225 X 800 X 1060	MM
WEIGHT	390	390	KG



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TECHNICAL SPECIFICATIONS

PARAMETERS	VALUE				UNIT
POWER SOURCE	PS 1201 (F) / PS 1201 T (F)				
SAW HEAD	WH -15 L1 (F) /L1 T (F)	WH -15-01 (F) /-01 T (F)	WH -15-02 (F) /-02 T (F)	WH -15-03 (F) /-03 T (F)	TYPE
MAX. WELDING CURRENT	1500 @ 60%, 1250 @ 100%	1501 @ 60%, 1250 @ 100%	1502 @ 60%, 1250 @ 100%	1503 @ 60%, 1250 @ 100%	AMPS, DC
RECOMMENDED POWER SOURCE	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	TYPE
RECOMMENDED WIRE DIAMETER SINGLE WIRE	2.0, 2.5, 3.15, 4.0 AND 5.0	2.0, 2.5, 3.15, 4.0 AND 5.1	2.0, 2.5, 3.15, 4.0 AND 5.2	2.0, 2.5, 3.15, 4.0 AND 5.3	MM
RECOMMENDED POWER SOURCE	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	PS 1201 (F) / PS 1201 T (F)	TYPE
SPEED RANGE WIRE FEED	0.5 - 4.0	0.5 - 4.0	0.5 - 4.0	0.5 - 4.0	M / MIN.
SPEED RANGE CARRIAGE	0.1 - 1.5	N. A.	N. A.	N. A.	M / MIN.
INPUT TO CONTROL UNIT	42 V, 1 PH, 50 HZ FROM POWER SOURCE				VOLTS, AC
RANGE OF ADJUSTMENT					-
VERTICAL (Z)	140 (MANUAL)	140 (MANUAL)	100 (MOTORIZED)	100 (MOTORIZED)	MM
HORIZONTAL (X) - TRANSVERSE TO] TRAVEL DIRECTION	140 (MANUAL)	140 (MANUAL)	100 (MOTORIZED)	100 (MOTORIZED)	MM
HORIZONTAL (Y) - IN DIRECTION OF TRAVEL		140 (MANUAL)	100 (MOTORIZED)	100 (MOTORIZED)	MM
MAXIMUM SWIVEL					-
TRANSVERSE TO HEAD TRAVEL	45				DEGREE
PARALLEL TO HEAD TRAVEL	30				DEGREE
HORIZONTAL SWING	270				DEGREE
STANDARD BORE FOR SPOOL	285 - 315 (ADJUSTABLE)				MM
WEIGHT OF SPOOL (MAX.)	25				KG
FLUX HOPPER CAPACITY (MAX.)	*10 / 7				KG / LITRES
DIMENSIONS (L X W X H)	1130 X 638 X 730	1500 X 1030 X 580	1500 X 1050 X 600	1500 X 1050 X 600	MM
WEIGHT (WITHOUT FLUX AND WIRE)	68	80	110	110	KG
NOTES:	* HOPPER 80 MM ADJUSTMENT FOR WELDING HEAD				
	# RANGE OF ADJUSTMENTS: THE THREE AXES OF WELDING HEAD ARE DEFINED AS FOLLOWS:				