

**ISUM** N° 8695-8916  
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## Instructions for Safety Use and Maintenance

WELDRY CW 3: W 000 120 466  
WELDRY CW 6: W 000 120 467  
WELDRY CW 9: W 000 120 468



### 1. GENERAL INFORMATION

This instruction for safety, use and maintenance manual is an integral and essential part of the product and is supplied together with the oven. It is suggested to read carefully this manual and observe any stated indication in order to use the equipment correctly. Please take care of this manual for any further consultation.

#### Typographic convention



Danger signal which indicates to observe carefully the instructions for avoiding possible damages to the equipment or accident.

This manual wants to be an instructions and maintenance guide for **Re-baking Ovens for Electrodes model CW3 - CW6 - CW9** which are designed for WELDLINE - Air Liquide Welding: 13 rue d'Epluches - Saint Ouen l'Aumône - 95315 CERGY PONTOISE France

- It must be used and read by the operators, maintenance employees and by the staff and purchaser for what it concerns spare parts.
- It must be located with care in a known place, protected by dirty and humidity and it must be always available for consultation by the operators.
- Read it and give to read carefully to all the operators in all parts before proceeding to install, to use, or for maintenance or dismantling of the oven and/or equipment.
- Check always that the operator has understood very well how to proceed for use and the safety symbols fitted on the oven.
- Do not damage or remove the labels or the name-plate fitted on the oven.
- It is possible to prevent accidents if the given instructions are respected.
- Before connecting the oven be sure that the name-plate data correspond to the electrical distribution system ones.
- Do not expose the oven to the inclemency of the weather or install in high humidity environments, that is bathrooms, etc.
- In case of emergency, that is fire starting, anomalous noise, overheating, etc. disconnect immediately the system electrical connection.

When this manual has been completely damaged, it is possible to ask for a copy directly to WELDLINE - Air Liquide Welding: 13 rue d'Epluches - Saint Ouen l'Aumône - 95315 CERGY PONTOISE France, giving the following references:

- Type of oven and Model
- Serial Number
- Supplier/Reseller
- Name and address of the User
- Correct address where to deliver the copy of the manual.

In case the oven is given to someone else, please inform us of the change in order to communicate to the new owner the up-to-date information.

This manual respects the state of the art at the moment of sale and it could not be considered inadequate if it is reviewed due to improvements.

The producer is not obliged to up-to-date the manual and/or the oven of the users if, in the meantime, due to the evolution of the technology, he has modified and/or improved the equipment and/or the manual.

### 2. SPECIFICATIONS

#### 2.1. General specifications

The drying ovens are mainly used for drying and keeping the treatment of welding electrodes to avoid hydrogen inclusion into the welding puddle during the welding process.

Three basic models are available and the same equipped with fan ventilation (see Table 1).

Table 1 – Available versions

Model	Description	Power	Load capacity
<b>WELDRY CW3</b>	Drying and keeping oven with 3 removable trays	4,6 kW	4500 - electrodes ø 3,25 mm
<b>WELDRY CW6</b>	Drying and keeping oven with 6 removable trays	9,1 kW	9000 - electrodes ø 3,25 mm
<b>WELDRY CW9</b>	Drying and keeping oven with 9 removable trays	13,6 kW	13500 - electrodes ø 3,25 mm

On request each model can be supplied with fan ventilation system

#### 2.2. Oven general description

The oven has an external structure made of sheet steel painted with epoxy powder coating to withstand heavy working conditions as humidity, corrosion and salty atmosphere.

The inner chamber is made of aluminium coated sheet steel for a better thermal reflectance.

The door has a heavy latch system that compresses fiber glass seal against the oven exterior wall to insure maximum oven efficiency. Two vents are located on top of the oven to release any moisture present inside the oven on start up.

The oven is equipped with removable trays to hold the electrodes. The quantity of trays in the oven chamber will depend on the oven size. On the top of the oven a control box is located with the main switch, the thermoregulators and the signal pilot lamps. On the back of the oven there is the power supply plug.

#### 2.3. Thermal insulation

Rock wool insulation installed between the external structure and the internal chamber for a better heat distribution throughout the oven chamber. A door gasket made of glass fiber insures a minimum amount of heat loss.

#### 2.4. Heating elements

The armoured heating elements, situated below the removable trays in the oven chamber, are made of stainless steel for longer life. The heating element electrical connections, located in the back of the oven, are protected by a metal cover. The heating elements in the oven chamber are supported by a bar. The quantity of heating elements is in accordance with the oven dimension.

#### 2.5. Electrical connections - Consumption

**WELDRY CW 3:** 3 heating elements - Total nominal power: 4,6 kW

**WELDRY CW 6:** 6 heating elements - Total nominal power: 9,1 kW

**WELDRY CW 9:** 9 heating elements - Total nominal power: 13,6 kW

The drying ovens are provided with IEC plug and socket suitable for the power supply type.

#### 2.6. Weight and dimensions

	WELDRY CW3	WELDRY CW6	WELDRY CW9
External size (mm)	800 x 880 x 1030	800 x 880 x 1480	800 x 880 x 1880
Internal size (mm)	560 x 740 x 560	560 x 740 x 980	560 x 740 x 1430
Oven weight (kg)	140	200	266
Packaging size (mm)	820 x 900 x 1050	820 x 900 x 1500	820 x 900 x 1900
Weight for transport (kg)	150	215	280

### 3. ASSEMBLING INSTRUCTIONS

The oven is packaged in heavy duty cardboard packaging for shipment. The oven is equipped with eyebolts so that it can be handled by a lifting device.

Connect the oven electrical cable to the power supply in accordance with all local and national electrical and safety standards; The working voltage and power rating are listed on a label located on the oven. The oven is now ready for use.

### 4. OPERATING INSTRUCTIONS

After checking the connections supply power to the oven, act on the general switch and the zone selectors; the white pilot lights are now on.

After a self-control phase of 10 seconds, the thermo regulators are on and start doing the ON/OFF symmetrical adjustment with 5°C hysteresis according to the temperatures and times set up in advance.

### 8. DISASSEMBLY AFTER USE

When the utilisation is completed, switch the main power supply off and remove the remaining electrodes putting them in a keeping oven.

If the electrodes have soaked up humidity, provide for a new dryer treatment before using them again.

Store the oven in a sheltered and dried place protected by accidental impacts.

### 9. DISMOUNTING INDICATIONS

#### General indications

Do not waste the oven in the ambient.

Make a separation of the components selecting by category for a possible reuse or separate waste.

In any case please refer also the local regulations about waste.

#### Separation of the components

The materials composing the drying ovens are:

Steel ..... main body  
 Stainless Steel (inox) ..... inner structure  
 Copper ..... wires, transformer winding  
 Plastic ..... switches, thermoregulator body and contactor  
 Glass fiber ..... door gasket  
 Rock Wool ..... inner insulation  
 Other materials ..... electronic components

### 10. WARRANTY

#### 10.1. General conditions

WELDLINE guarantees the product mentioned in this manual for a period of 24 (twenty-four) months from the date of delivery.

The warranty is valid for the above mentioned period and only for the parts that will have defect of design or defective material.

Complaints have to be sent directly to WELDLINE mentioning the reason of the defect. WELDLINE will give you further instructions for repairing or replacing the complained parts.

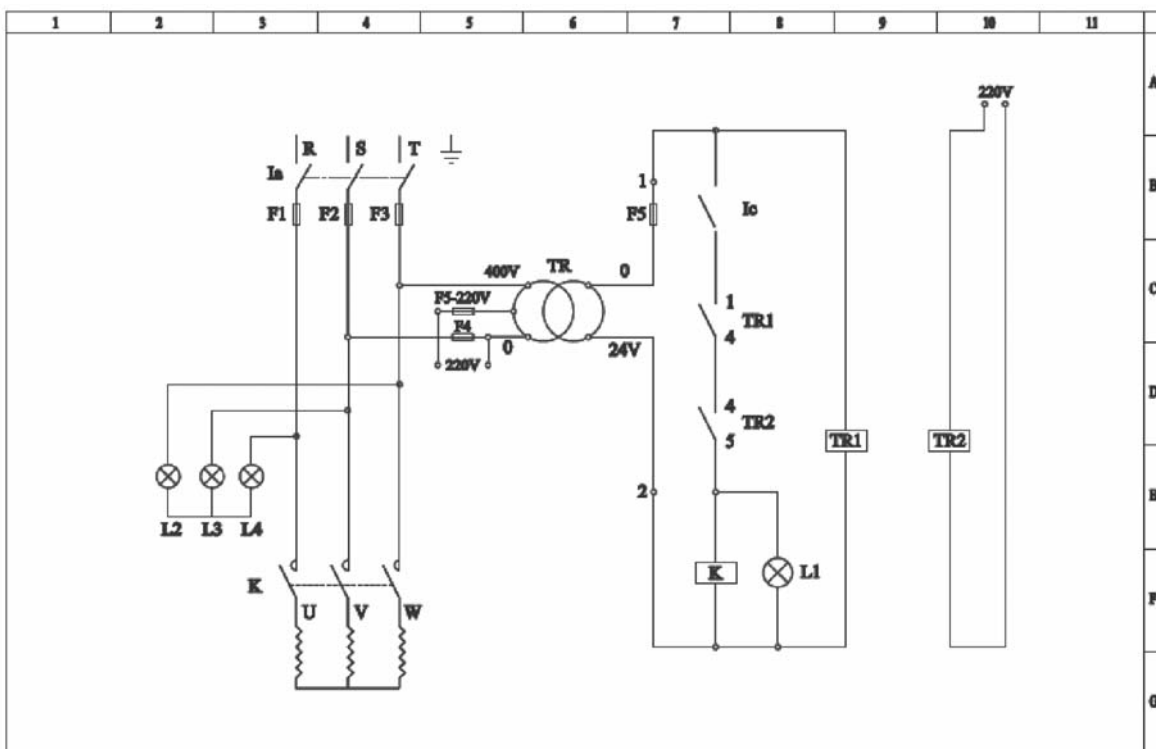
Any transport expenses will be covered by the customer.

#### 10.2. Limitations

WELDLINE is not and will not be responsible for:

- Improper use of the oven
- A use against the national and/or International regulations in force
- Improper or wrong connection
- Bad fault on maintenance
- Unauthorized modifications and/or services
- Use of non-original spare parts or non-specific components
- Inobservance of the instructions, also only partially
- Unusual events as natural disasters, wars, strikes or similars.

### WIRING DIAGRAMS



ELECTRICAL DRAWING RELEVANT TO DRYING OVENS WELDRY CW 3 / CW 6 / CW 9

Caption:

Ia	Main switch sectioner 3x16 / 3x25 / 3x32 A
Ic	Door micro-switch
Tr2	Heating element thermoregulator
Tr1	Oven air thermoregulator
L1	Heating element "ON" signal - green
L2 / L3 / L4	Electric connection signal - white
K	Heating elements remote control switch

R1 / R2 / R3	Heating elements 230 V. 1500 W x F3-F6-F9-Fm2 / 2750 W x Fm-Fm1 / 1300 W x F100-F200-F400
TR	Transformer 220-380/24 V - 380/220 V - 50 VA
F1 - F2 - F3	Fuses 16-20-25-32A
F4 - F5	Fuses 2A
S	Selector - A - B -