Digital Wire Feeder

MAXsa™ 19 Controller

Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

The MAXsa® 19 controller is specifically designed to relay wire feed commands to the MAXsa® 29 when a customer-supplied user interface is used in place of the MAXsa® 10 controller. Typically, this occurs in a variety of third party integrator solutions that include integration hardware like turning rolls, panel lines, seamers and pipe mills fixturing.

Features

- Compact size – makes it easy to position in custom integrator solutions.
- Fast digital communication – with the Power Wave® AC/DC 1000® SD via ArcLink® cable and to the wire drive via a 14-pin control cable.
- Standard I/O connector block – for start/stop, forward/reverse feed and shutdown input interfacing with external accessories.
- Standard status indicator – aids diagnostic system troubleshooting.
- IP23 rated – tested to withstand harsh environments.

Processes
- Submerged arc

3 Year warranty Parts & Labour

ArcLink® COMMUNICATIONS PROTOCOL

INPUT 40 VDC *OUTPUT* 40 VDC

Technical Specifications

Product	Item Number	Input Power	Weight (kg)	Dimensions HxWxD (mm)
MAXsa™ 19	K2626-4	40V DC	3.2	229 x 267 x 76

Digital Wire Feeder

MAXsa™ 29 Feed Head

Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

The compact MAXsa® 29 Feed Head is intended for integrator solutions, as well as the latest submerged arc robotic applications.

Features

- Closed loop speed control – facilitates full control over starting, running and stopping wire feed speed.
- 32V DC permanent magnet, high torque motor – delivers plenty of torque to push up to 5.6 mm diameter solid wire. Top speed of up to 12.7 m/min can be achieved by changing the gear ratio.
- IP23 rated – tested to withstand harsh environments.
- Standard conversion kits – used to change the speed ratio to match the requirements of your application.
- Standard adjustable wire straightener.
- Multi-axis rotation – rotational feed head adjustment in one plane allows flexible, accurate setup for fixturing.

Processes
- Submerged arc

3 Year warranty Parts & Labour

Key Options
- **K2163-60** Weld Power Cable, 18 m
- **K1842-110** Weld Power Cable, 33 m
- **K219** Flux Hopper Assembly
- **K231-1** Contact Nozzle (2.4, 3.2, 4.0 mm)
- **K148A** Positive Contact Nozzle (2.4-3.2 mm)
- **K148B** Positive Contact Nozzle (4.0-4.8 mm)
- **KP2721-1** Nozzle Extension, 5 inches
- **K149-5/32** Nozzle Extension (4.0 mm)
- **K386** Narrow Gap Nozzle
- **KP2108-1B1** Contact tip
- **K285** Concentric Flux Cone Assembly
- **K225** Sub Arc Twinarc® Nozzle for 2.0-2.4 mm
- **K129-x** Tiny Twinarc® (1.6/2.0/2.4 mm)
- **K281** Tiny Twinarc® Solid Wire Straightener
- **K162-1** Spindle Kit, 2 Inch Hub
- **K29** Vertical Lift Adjuster, 100 mm
- **K96** Horizontal Adjuster, 50 mm
- **K278-1** Spreadarc Oscillator

ArcLink® COMMUNICATIONS PROTOCOL

INPUT 40 VDC *OUTPUT*

Technical Specifications

Product	Item Number	Input Power	Rated Output	Gear Box [1]	Wire Feed Speed Range[1] (m/min)	Wire size Range [1] Solid (mm)	Weight (kg)	Dimensions HxWxD (mm)
MAXsa™ 29 Head	K2312-2	40V DC	1000A / 100%	142:1 95:1[1] 57:1[1]	0.4-5.0 0.4-7.6 1.3-12.7	2.4-5.6 1.6-3.2 1.6-2.4	35	330 x 406 x 254

[1] 142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-2, K2312-2, or K2311-1)