

# Submerged Arc Welding Series (SAW)

SA1000/SA1250



## Product Features

- Available with submerged arc, gouging and MMA functions;
- CC/CV welding modes and both can realize excellent welding performance;
- Input voltage allows wide fluctuation range (-15%~+25%);
- Enclosure protection level is IP23, suitable for welding in harsh environments;
- Intelligent detection and alarm functions such as overheating protection;
- Duty cycle is 100%, which can ensure high current welding for a long time;
- Supports U disk upgrade, RFID card management, SMARC IoT, etc.;
- Meet with long-distance welding and can weld stably when the cable is extended by 100 meters.

## Applications

Widely used in welding of medium and thick plates in the industries such as boilers, pressure vessels, shipyards, steel structures, and wind power, etc.



### Submerged Arc Function

- Available with fixed-point arc starting and scratch arc starting functions, effectively ensuring arc starting success rate under various working conditions;
- Both arc starting parameters and arc ending parameters can be adjusted;
- Intelligent closed-loop wire feeding control brings stronger consistency of penetration depth.



### Gouging Function

- Multiple-uses, quickly clean and repair weld beads;
- High duty cycle ensures long-term and high-current root cleaning of medium and thick plate welding.



### MMA Function

- A multiple-purpose machine can quickly repair weld gaps;
- Adjustable in arc starting current and welding current is suitable for long-cable welding.



## Technical Specification

Machine Model	SA 1250	SA 1000
Control mode	Full-digital	
Wire feeding drive control mode	High frequency back electromotive force control	
Input voltage	3-ph AC 380V (-15%~+25%)	
Input frequency	50/60Hz	
Input capacity	65.3kVA	52.5kVA
Power factor	≥0.92	
Efficiency	≥0.9	
Rated no-load voltage	78V	
Rated output current	100~1250A	100~1000A
Rated output voltage	20~44V	
Manual welding current	100~1250A	100~1000A
Arc gouging current	100~1250A	100~1000A
Rated duty cycle	100%	
Electromagnetic compatibility	Class A	
Lightning protection level	D级	
JOB storage	9	
Insulation level	Transformer F, Reactor H	
Protection level	IP23	
Environment degree	-10°C~+40°C	
Volume(L x W x H)	646×386×823mm	
Main machine weight	84kg	

## SAW Tractor Technical Specification



Wire feeding motor model	90ZY01
Bracket type	Dual drive
Wire feeding motor rated voltage	DC110V
Wire feed motor rated current	2A
Travel motor rated voltage	DC110V
Travel motor rated current	1A
Welding current	1250A@100%
Wire feed speed range	3.6m/min
Travel speed range	0.2~1.8m/min
Applicable wire diameter	Φ3.2、4、5、6mm
Applicable wire spool weight	25kg
Volume (L x W x H)	1020×480×740mm
Weight	60kg

## Tractor Control Module Technical Specification



Model	SA 1000 / SA 1250
LED Display	Preset and actual voltage, current value display, error code display
Output control	Close control (gouging), remote control (submerged arc)
Wire diameter setting	Φ3.2、4、5、6mm
Welding control	Fixed-point arc ignition, scratch arc ignition, arc starting, welding, arc ending, wire feeding
Interface pin number	6 pins
Welding mode	CC、CV
Wire feeding	Manual wire inspection, variable-speed wire feeding, constant-speed wire feeding
Communication with main machine	High-voltage CAN
Motor control way	High-frequency back electromotive force control
Wire feeding speed	3.6m/min

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