



MODEL 327 WDR



COMPACT, MULTI-PHASE/VOLTAGE POWER SUPPLY

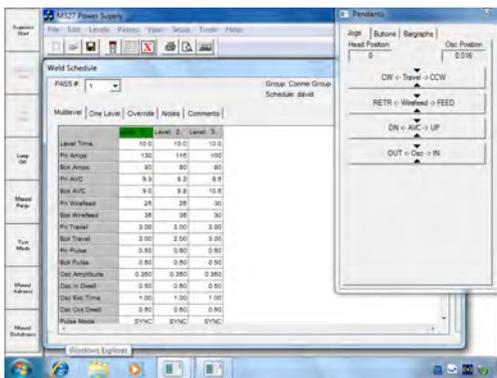
Portable Heavy Duty Power Platform for Orbital Welding



M327 WDR with detachable water cooling unit

The new Model 327 WDR is a 300A compact yet powerful, intelligent, and flexible power supply and process controller. It was designed and built to be easily carried from site to site and to support single or 3-phase multi-voltage service, eliminating the worry of adequate input power. This portable unit is capable of welding all alloys which can be welded by the GTAW (TIG) process.

While this “all-in-one” computer controlled system is primarily designed for automated orbital pipe welding applications (with wire fill), the Model 327 WDR is also practical for fusion welding (no wire fill), tube-to-tubesheet, and custom weld fixture based projects (both orbital and non-orbital). Built upon AMI’s 35+ years of experience in automated orbital welding, the Model 327 WDR incorporates AMI’s latest “smart” servo control technology to provide reliable and precise automatic weld process control.



M327 Program Execution Screen

The M327 WDR is operated by an industrial computer programmed via a large 12” touch screen or keyboard. The intuitive Graphical User Interface (GUI) makes programming easy by using standard welding industry terminology and clearly organized input fields.



QUICK SPECS

Input Power
220 - 480 VAC service
1 or 3-phase
50/60 Hz

Dimensions
Height: 16.5” (419 mm)
Width: 30.75” (781 mm)
Depth: 23.5” (597 mm)

Weld Current
5 - 300A peak

Weight
140 lbs. (63.5 kg)
(without water cooler)
195 lbs (88 kg)
(including water cooler)

I/O Devices
2 USB ports (2.0),
1 Ethernet port

Water Cooler
Optional

Memory Capacity
Virtually unlimited



STANDARD HARDWARE

The Model 327 WDR power supply has many standard hardware and software features. The power supply contains all the hardware and control elements of a welding automation cell in a highly integrated compact package. It can easily be switched between orbital and fixed automation applications.



M327 WDR with Remote Pendant

- Computer controlled, solid state, pulsed, and air cooled GTAW inverter for accurate cc output. (DC only)
- 12" (300 mm) touch screen graphical user interface (GUI) to display weld schedules and data.
- R.F. or H.F. arc initiation.
- High capacity, programmable memory for storage of weld schedule information.
- Current servo plus 4 standard motor servos.
- 2 USB ports.
- 1 Ethernet port.
- Full function remote pendant.
- Data acquisition output.
- Internal printer.

OPTIONAL HARDWARE

1. High resolution, digital Remote Vision Systems.
2. Camera Illumination. (not shown)
3. Extension cables. (not shown)



1. Remote Vision System

PROGRAMMABLE FUNCTIONS



Welding Current Control



Arc Voltage Control (AVC)



Wire Feed



Rotation/Travel Control

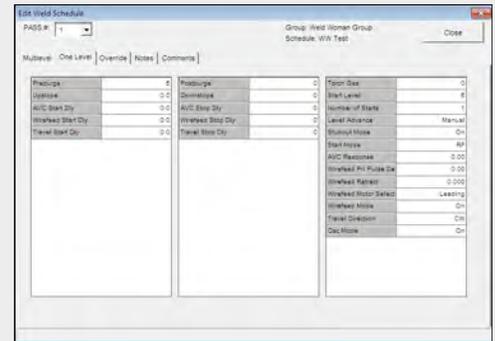


Oscillation

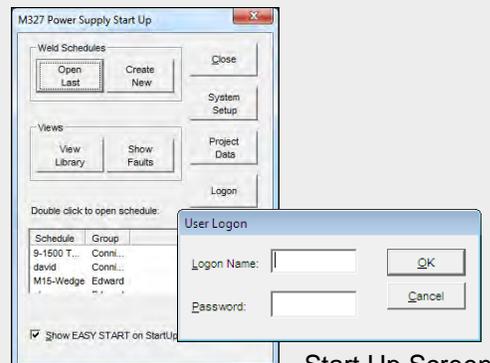
MODEL 327 WDR PORTABLE HEAVY DUTY POWER PLATFORM

STANDARD SOFTWARE

- WDR (Weld Data Recording): recording and saving weld data and exporting them to a storage device in their native or other file formats; saving project weld data records as a single file.
- Single or multipass weld schedule programming.
- Up to 20 levels in one pass and up to 100 individual passes.
- Pulsed current, travel, wire feed, oscillation, and wire feed synchronization.
- Stepped or spiral travel programming.
- Level programming in time or distance.
- Data acquisition output.
- User-defined programming field descriptions.
- Multi-level password protection.
- Graph bar presentation of real-time welding parameters.
- Foreign language software versions.
- 2 User programmable fault I/Os.



One Level Edit Screen



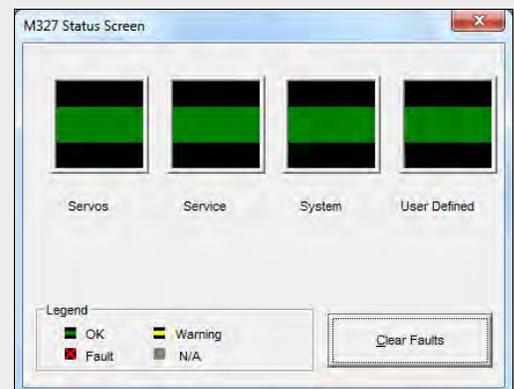
Start Up Screen

OPTIONAL SOFTWARE

- Offline programming on a PC.

SENSORS & FAULT MONITORS

- Torch Gas Flow Sensor.
- Coolant Flow Sensors - insures adequate weld head coolant flow.
- Over Temperature Sensors - located in critical assemblies, will create ALL STOP conditions if certain component assemblies overheat.
- Ground Fault - prevents Sequence Start if the work piece ground is not connected.
- External Fault - allows the user to input up to 2 outside signals.
- Servo Faults - limit switches halt sequence if weld head faults occur.



System Status Screen

MODEL 327 WDR

PORTABLE HEAVY DUTY POWER PLATFORM

WHAT'S INCLUDED

M327 WDR Package

1. M327 WDR remote pendant.
2. Pendant cable extension - 40 ft. (12m).
3. Ground cable with 400A ground clamp - 40 ft. (12m).
4. Weld head control cable extension - 40 ft. (12m).
5. Weld head services cable extension - 40 ft. (12m).
6. 10 ft. (3m) shielding gas hose.
7. Input power cable
8. Input AC cable - 25 ft. (7,62 m)
9. Shipping crate.
10. Software package and operator's manual.

COMPATIBLE WELD HEADS

Outside Diameter Welding



Model 15



Model 79
Open Frame



Model 81
Low Radial Clearance

In-Place Welding



Model 2

Soon to be compatible weld heads:

for I.D. welding - M94, M43; for O.D. welding - M88; for tube welding - M8-series, M9-series; for tubesheet welding - M6, M96

The Global Welding Company

For further information please visit our website



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