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.

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.
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.

- 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.

STANDARD HARDWARE

2. Camera Illumination. (not shown)
3. Extension cables. (not shown)

OPTIONAL HARDWARE

1. Remote Vision System

PROGRAMMABLE FUNCTIONS

- Welding Current Control
- Arc Voltage Control (AVC)
- Wire Feed
- Rotation/Travel Control
- Oscillation

www.arcmachines.com  www.theglobalweldingcompany.com
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.

OPTIONAL SOFTWARE

- Offline programming on a PC.

SENSORS & FAULT MONITORS

- 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.
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

www.arcmachines.com   www.theglobalweldingcompany.com

Distributed by:
Practical Tools Inc.
P.O. Box 233 Aurora, Ontario L4G 3H3
905-727-0014 / 888-847-8880
ing email: practicaltools@bellnet.ca