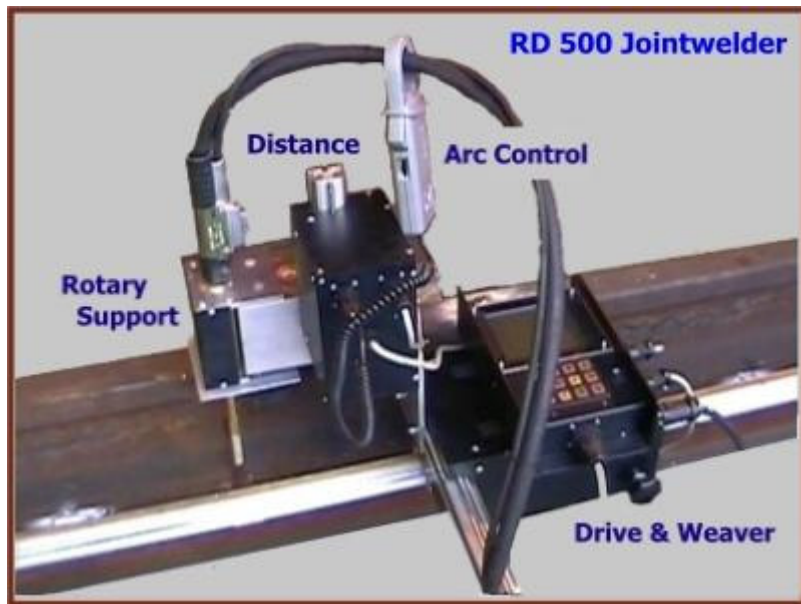




## Welding Example ‚Joint Welder’

### RD 200J / RD 500J Joint Welder

Special automat for joint welding of all kind rails (railroad rails, tramway rails, crane rails).  
 30 types of rail can be selected, easy upgrade with other types is possible.  
 4-axis unit with rotary support and automatic stick out control.



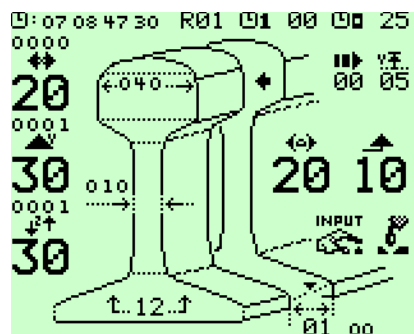
Because of the rotation of the welding nozzle and a special welding tip, both sides will be reached reliable. At first layer, a save welding bridge is created, which spares the bottom backing (copper).



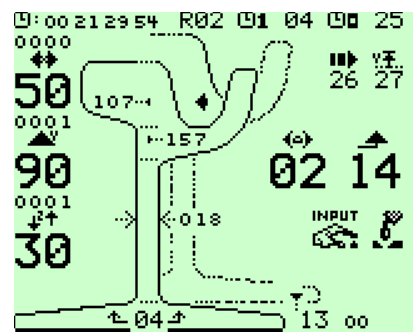
```
RD 2000 JOINTWELDER
Choose your rail: MEM 2
```

|        |      |     |     |     |
|--------|------|-----|-----|-----|
| MEM 1  | 0000 | 45  | P   | 6   |
| MEM 2  | 0000 | 49  | P   | 00  |
| Pa 75  | 0000 | 54  | P   | 15  |
| Pa 100 | 0000 | 54  | P   | X   |
| Pa 120 | 0000 | 54  | P   | X   |
| Pa 150 | 0000 | 65  | INI | 73  |
| UIC 54 | UU   | 33  | B   | 129 |
| UIC 60 | UU   | 36  | B   | 140 |
| Ri 52  | JIS  | 60  | CR  | 73  |
| Ri 60  | JIS  | 50N | CR  | 100 |

30 Standard Rail Types

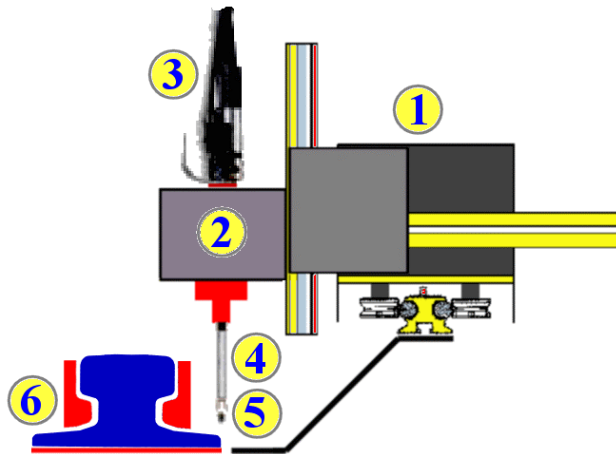


Display Railroad Rail



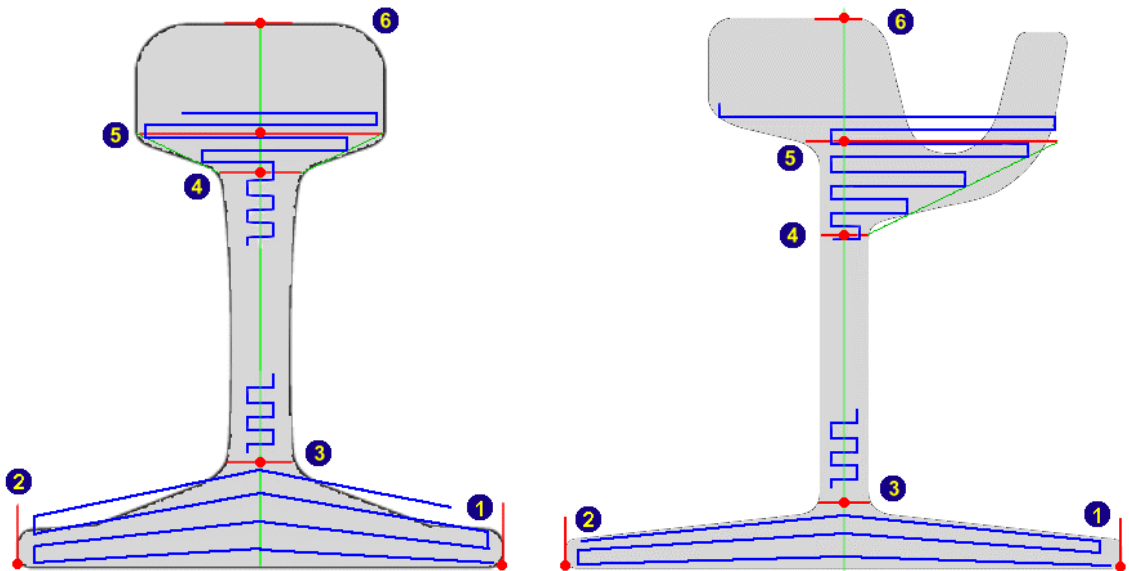
Tramway Rail

### Overview



- 1 Welding System RD200J / RD500J
- 2 Rotary Support
- 3 Standard Gun
- 4 Welding Nozzle
- 5 Special Welding Tip
- 6 Backings (Copper)

### Welding Sequences with 6 Teach-In Points



Permanently memorized Data for up to 30 Rail Types, easy to change and adjust.

|                 | Time          | Rail Type | Dwell | START |                     |
|-----------------|---------------|-----------|-------|-------|---------------------|
|                 | 0:07 08 47 30 | R01       | 01    | 00    | 05 25               |
| Pos X           | 0000          |           |       |       | Dwell STOP          |
| Width Head      | ←→            |           |       |       | Medial Move         |
| Speed WEAVER    | 20            | ←-0.40-→  |       | 00 05 | Edgewise Step       |
| Pos Y           | 0001          |           |       |       | Drive Direction     |
| Speed DRIVE     | 30            | 010       |       | 20 10 | Center Speed Weaver |
| Pos Z           | 0001          | ←→        |       |       | Drive Speed         |
| Width Main      | ↑↓            |           |       | INPUT | INPUT / Adjustment  |
| Speed UP / DOWN | 30            |           |       | INPUT | TEST / Torch active |
| MOVE Upwards    | ↑.12.↑        |           |       |       | Indicator Teach-In  |
|                 |               |           |       | 01 00 | Amplitude           |
|                 |               |           |       |       | ARC - Control       |