Welding Example ‚Restricted Area', METRO Rome/Italy

Restricted Area

5 Point Teach – In

After Grinding
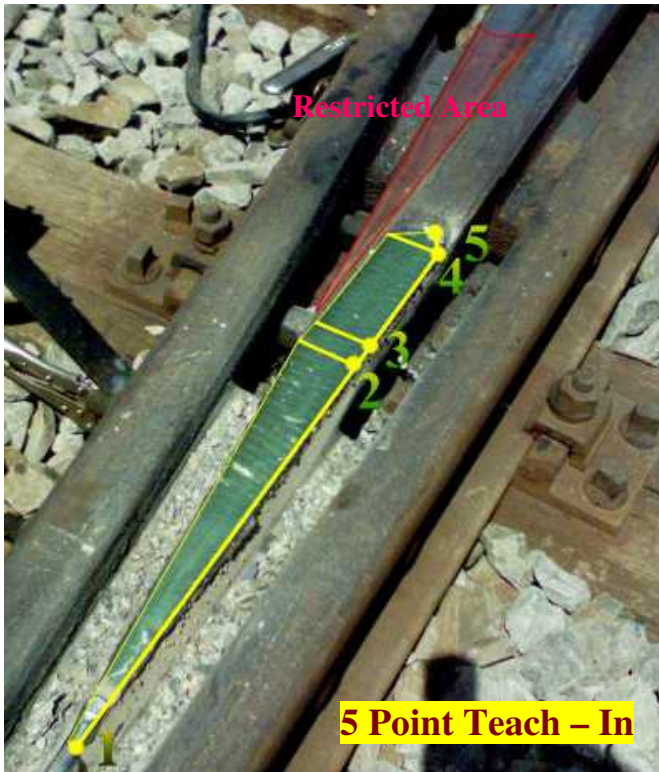
To prevent the welding of the restricted area, the amplitude at point 3 is reduced from 62 (full rail) to 55%. The end of welding at point 5 is set closer to mid of rail, to get a save filling (no drop down) at stop dwell time.

E:\Dorn-Systeme\Tools\Surfacing.rdo

R 00235234 P00 ⊙1 10 ⊙□ 25

X:-00001 Y:+00000 Z:+00081

30	58	30	14	14
88 cm/min	117 cm/min	58 cm/min	33 cm/min	33 cm/min

P1 ←→01 / ←→12 /
P2 ←→62 / ←→12 /
P3 ←→55 / ←→12 /
P4 ←→55 / ←→12 /
P5 ←→01 / ←→12 /
P6 ←→00 / ←→00 /
P7 ←→00 / ←→00 /

15 40
35 cm/min 4.4 mm

	X/Y Point	X/Y mm	←→ mm
P1:			1
P2:	0/-3785	0/-423	50
P3:	0/-4041	0/-452	44
P4:	0/-5295	0/-593	44
P5:	48/-5453	9/-610	1
P6:	0/0	0/0	0
P7:	0/0	0/0	0

This picture has been captured from the data transfer program *RD2000-S*. All movement and positioning parameters can be memorized at a local computer.
This software could be part of a quality management system and for later use at same works.