



IMPROVEMENT IN CONTAINER MANUFACTURING PROCESS

PROCESS IMPROVEMENT CASE. GPS 4000 EQUIPMENT IMPLEMENTATION

Manufacture: Metal containers for outdoor use (ships, industrial buildings, electric-electronic equipment...).
Welding engineering service, going from standard arc welding process to combined welding processes with pulsed arc. GPS 4000 equipment implementation.



Analysis of current situation:

Welding with solid carbon steel wire ER 70S6, ER 90SS6, 1.2 mm diameter. Gas mix.

Equipment used: 400 A electromechanical.

Standard Welding Process at current levels:

- 80 A; 140 A: short-circuit transfer
- 190 A: globular transfer
- 230 A: transfer in input to spray.
- 300 A. Spray

The welding process incorporates a high activity percentage. 2 shift high duty cycle. A significant part reworking time is observed.

A high splash rate is observed in current welding.

The gas and wire consumption levels are significant. A large amount of anti-splash spray is used.

Wire consumption per day and centre: 7 kg (approx.).

Objective:

Improve and optimise processes. Save quality requirement-based reworking time costs



WELDING ENGINEERING SERVICE

Treatment:

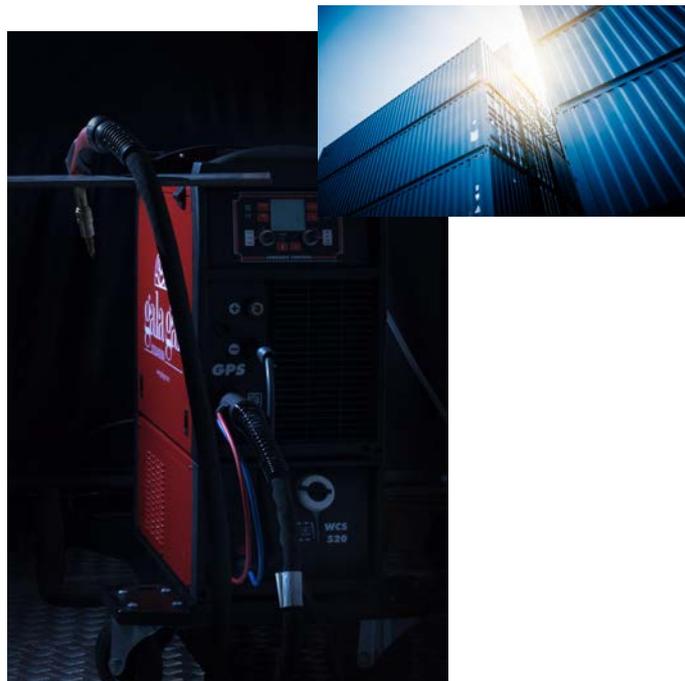
Welding engineering study. Incorporation of GPS 4000 pulsed arc MIG/MAG equipment to welding process replacing MIG/MAG electromechanical welding equipment.

Study of beads, adjusting parameterisation in pulsed arc and standard processes.

(Narrower) beads with adjusted arc and low splash level.

Consecuencias:

- Reduction of wire consumption (-8%) and electrical consumption (-15%).
- Considerable decrease in splash level. Rework time reduced to minimum. Rework time reduced to minimum. Anti-splash spray elimination.
- 18 to 20% cost reduction.



CHARACTERISTICS GALA PULSE SYNERGIC 4000:

Industrial multi-process equipment for MIG/MAG –PULSED MIG/MAG, MMA and TIG – PULSED TIG welding with Inverter technology.

Especially suitable for aluminium and stainless steel welding and for applications in which a reduction of the thermal input and deformation becomes necessary

Based on a basic initial configuration and with the addition of another wire feeder, we will convert our system into a DUAL system. Two work centres that can be used alternately via two totally independent work programs.

MORE INFORMATION ABOUT THIS EQUIPMENT AT WWW.GALAGAR.COM

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