



Horizontal H Beam Welding Lines

HW15 Horizontal H beam welding lines are high performance H beam production lines combined with different equipments and tool, which are manufactured by JINFENG WELDCUT who is the professional China manufacturer and supplier of HW Horizontal H beam welding lines with affordable price. The HW Horizontal H beam welding lines provide more safety and high efficiency for the H beams or T

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JINFENG WELDCUT will provide have 2 years warranty for the HW **Horizontal H beam welding lines**. The main electric elements of the H beam productions are selected from the world famous brand that will bring more convenient for Users to find the parts in local without getting from long distance from China. The HW **Horizontal H beam welding lines** are the most advanced and high automation production lines to increase the productivity for End-users from different industries.

Specifications

Model	HW3015	HW2015
H-beam web height	300-1500mm	200-1500mm
Web thickness	5-14mm	5-14mm
H-beam flange width	150-500mm	150-500mm
Flange thickness	6-25mm	6-25mm
Tapper angle of beam	Max 15°	Max 8°
H-beam length	5000-15000mm	
Welding types	Pre-tack welding by CO2/MAG by hand	



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	Full welding by SAW (submerged arc welding)
H beam assembled position	Horizontal
H-beam assembling machine	1 set, with input and output roller table, for pre-tack welding
Pull through H beam welding machine	1 set, front machine with output roller table, for full welding
	1 set, rear machine with input and output roller table, for full welding
Chain type H beam overturn machine	1 set, max loading for 4 tons

Feature And Application

1. HW **Horizontal H beam welding lines** are high automation production lines to produce the welded I beam and H beam with lesser workers and lesser cranes.
2. High production efficiency for light weight welded beam.
3. One pass welding on 2 welding seams at same time;
4. Need only one type overturning 180 degrees.
5. HW **Horizontal H beam welding lines** are widely used in steel construction and steel structures for producing H beam to make workshop, warehouse, factory workshop etc.
5. The flexible design of the welding equipments allow to support any brands of the welding power sources.
6. CE, ECA certificated are available.

Structure view

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List of the equipments modules used in HW **Horizontal H beam welding lines**

1-Assembling area, includes:

One horizontal H beam assembling machines with roller table – clamping and fit the 3pcs of plate (1 web and 2 flanges) in H-position and make the web in the center position of 2 flanges. Then the worker can use CO₂/MAG welding machine to spot weld the head of the 3 plates at length about 300mm by hand . then open the clamp and the 3pcs of plates with the head pre-welded in H-shape and be transported on roller table to the next welding station.

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Assembling H beam in horizontal position

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2-Welding area #1, includes:

One sets of pull through welding machine. With one set of web and flanges fixture for fitting the web in the center position of 2 flanges.

The machine here using the twin wire welding technology for full welding with submerged arc welding technology.

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Welding H beam in horizontal position

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3-H beam overturning, includes:

After full welding on top side of the H beam, the H beam will be moved out from the front pull through H beam welding machines and move to the area for overturning.

The overturning device is a frame with hoisting tools with chains. The chains lifts up the H beam and operate to make the chain moving, thus to make the H beam overturn 180 degrees to let the bottom sides that need welding face upward.

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Overturn device

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4-Welding area #2, includes:

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The pull through welding machine in this area is for welding the H-beam that already have 1 side welding on #1 pull through welding machine.

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5-Straightening area.

This is an option machine for the line of horizontal H beam welding line. The Users can select to add one set of mechanical H beam flange straightening after the line, to straighten the flanges of the H beam after welding.

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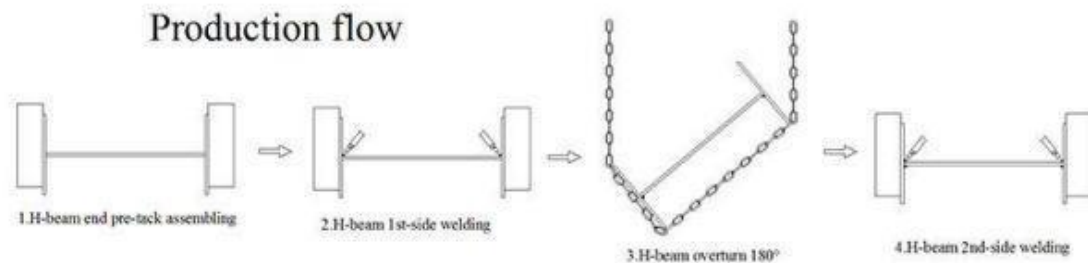


Straightening machine

How to produce a welded H beam/ I beam in horizontal position?

Following is the production flow chart for the production of a welded H beam in horizontal position

Production flow chart



H-beam welding lines installed in Users' factory