

IRIZAR HEAVY INDUSTRIES INC

PRODUCT CATALOG 2024



July 2017. Irizar Welding Rotator Model WR 1200 MT
At Nuclear Construction Site in Georgia Power Plant Vogtle, USA
Westinghouse Nuclear Power Generator AP 1000 PWR

| | |
|-----------|----------------|
| Revision: | April 15, 2024 |
|-----------|----------------|

Readers note: The information in this brochure is intended to be accurate.
However, Irizar Heavy Industries reserves the right to make changes in design
that may not be included.



IRIZAR HEAVY INDUSTRIES INC

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Irizar Heavy Industries Inc. is a Canadian company based in Edmonton. We take pride in manufacturing and offering the world's largest stock of Welding Rotators (up to 2,400 MT), Welding Manipulators (up to 9 m effective vertical column reach), and Tank Lifting Jacks for welded and bolted field erected tanks (up to 3,000 MT).

INDUSTRIAL SEGMENT

Our products work among other industries: Oil & Gas, Nuclear Power Generation, Aerospace, Pipes and Pressure Vessels, Onshore & Offshore Wind Towers and Monopiles, Rail Tanks, Mining, and Food Industry.

PRODUCT RANGE

1. Conventional Welding Rotators: From 1 to 2,000 MT
2. Self Aligned Rotators: From 5 to 500 MT
3. Anti-Drift Turning Rolls: From 250 to 3,000 MT
4. Self Aligned Rotators: From 5 to 500 MT
5. Track Welding Rotators: 5 & 20 MT
6. Pipe Rotators: From 1 to 25 MT
7. Welding Positioners: From 0.3 to 100 MT
8. Head & Tail Stock: From 1 to 100 MT
9. Welding Manipulators: From 2 x 2 m to 9 x 6 m (vertical x horizontal)
10. Girth Welders: AGW-1, AGW-1-C, AGW-2, LNG AGW-1 & Shell Buggies
11. Tank Lifting Jack with a load capacity of 12 MT and 25 MT. Applicable for lifting API 650 Field Erected Tanks, LNG API 620 Welded Tanks and Bolted Tanks.

DESIGN: Our products are **Designed & Engineered** in Canada and made in our factories in China and India. We are proud to own the **World Largest Stock of Welding Positioning Equipment and Tank Lifting Jacks**. Our warehouse is located in Wetaskiwin, Alberta, Canada in a thirty acres lot; at thirty-five minutes from Edmonton International Airport. Welcome to visit our Show Room.

STOCK & DELIVERY: We are proud to own a **Huge Stock** in our warehouse in Alberta, Canada. Ninety-Five percentage of the orders can be found in stock. Our delivery time in Canada is three to five business days. In USA & US-Mexican border, delivery time is one week. In Latino America, approx. four weeks; and World-Wide, around five to six weeks.

EXPORTATION: Over sixty countries, among them: Angola, Antigua & Barbuda, Argentina, Australia, Belgium, Bahamas, Bolivia, Brazil, Canada, Chad, Chile, China, Colombia, Costa Rica, Cote D' Ivoire, Denmark, Ecuador, Egypt, France, Germany, Greece, Guatemala, India, Indonesia, Ireland, Italy, Japan, Jordan, Kazakhstan, Kuwait, Madagascar, Mali, Martinique & Guadeloupe, Mali, Mexico, Morocco, Netherlands, New Zealand, Nigeria, Norway, Oman, Pakistan, Panama, Paraguay, Peru, Philippines, Poland, Romania, Russia Federation, Saudi Arabia, Singapore, Senegal, Serbia, South Africa, Spain, Tanzania, Taiwan (China), Thailand, Ukraine, United Arab Emirates, United Kingdom, Uruguay, USA and Venezuela.

OUR GOALS: 1. To **Build State of the art High-Tech Products** exceeding International Standards. 2. To provide **Top-Quality Products**. 3. To provide **Safety Products**. 4. To provide **First-Class Service**. 5. To offer the **Most Competitive-Price**. 6. To have our products in **Stock & Ready for Shipping**. 7. To **Build a Long-Term Business Relationship** with our customers.

Our company produces finished products, but there is more to it. Passionate employees in every department that captivate what we stand for; to do our best. **Research & Development** always raise the bar of our products, again and again; our design engineers only aim for the best. **Sales & Marketing:** Our multinational team covers more than sixty countries all over the World. **Technical Support:** Our trust, know-how, integrity, as well as our fast and flexible service is always appreciated.

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Anti-Drift Welding Rotator Model WR 3000
3000 MT load and rotation capacity

Notes:

[Limited Warranty](#)

[Terms and Conditions of Sale](#)

Product Catalog

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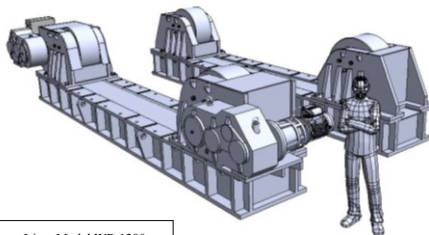
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Conventional Tank Turning Rolls, WR Series

Tank Turning Rolls are used for positioning cylindrical workpieces. The set comprises one power rotator with variable speed and one idler roller. Bolts and nuts adjust center to center between wheels. Welding Rotators automatize the welding process by applying SAW (Submerged Arc Welding) on longitudinal and circumferential seams with the help of a Welding Manipulator. **Conventional Welding Rotators**, also known as **Tank Rollers, Welding Rollers, Tank Rotators, Weld Rotators, Pipe Rotators, Welding Rolls, Welding Rotators, Vessel Rollers, Tank Rolls, Welding Tank Turning Rolls, Turning Rolls, Rotador de Soldadura, Virador de Soldadura, Virador de Tanques, Rotador de Tanques and Rotador de Tuberia**



Irizar Model WR 1200



| Model | Load & Rotation Capacity (MT) | Rotation speed (mm/min) | Power (kW) | Vessel Diameter Range (mm) | Wheel (mm) | | Dimensions L*W*H (mm) | | Weight (MT) |
|-------------------------|-------------------------------|-------------------------|------------|----------------------------|------------|-------|-----------------------|----------------|-------------|
| | | | | | Diam | Width | | | |
| WR 3 | 3 | 100-1000 | 2*0.25 | 150-2500 | 200 | 112 | 1900*500*450 | 1350*300*450 | 0.35 |
| WR 5 | 5 | 100-1000 | 2*0.37 | 150-3200 | 250 | 140 | 2000*500*480 | 1600*380*480 | 0.80 |
| WR 10 | 10 | 100-1000 | 2*0.55 | 250-4800 | 300 | 170 | 2440*610*550 | 2320*450*550 | 1.00 |
| WR 20 | 20 | 100-1000 | 2*1.10 | 250-4800 | 350 | 180 | 3000*675*600 | 2500*500*600 | 1.50 |
| WR 40 | 40 | 100-1000 | 2*1.50 | 250-4800 | 400 | 200 | 3100*700*650 | 2610*700*650 | 2.30 |
| WR 60 | 60 | 100-1000 | 2*2.20 | 300-5200 | 450 | 220 | 3450*820*830 | 3000*820*830 | 2.40 |
| WR 80 | 80 | 100-1000 | 2*3.00 | 300-5200 | 500 | 240 | 4380*900*890 | 3400*700*890 | 2.90 |
| WR 100 | 100 | 100-1000 | 2*3.00 | 800-7800 | 500 | 260 | 4380*970*980 | 3800*760*980 | 4.80 |
| WR 150 | 150 | 100-1000 | 2*4.00 | 800-7800 | 500 | 260 | 4210*1000*980 | 3800*800*980 | 5.50 |
| WR 250 | 250 | 100-1000 | 2*5.50 | 1200-9000 | 660 | 260 | 4900*1060*1100 | 4380*920*1100 | 10.00 |
| WR 400 | 400 | 100-1000 | 2*5.50 | 1200-9000 | 700 | 300 | 5900*1140*1180 | 5500*920*1180 | 17.50 |
| WR 600 | 600 | 100-1000 | 2*7.50 | 1200-9000 | 900 | 360 | 6900*1300*1600 | 6000*1200*1600 | 27.50 |
| WR 800 | 800 | 100-1000 | 2*15.0 | 1200-9000 | 900 | 400 | 7100*1400*1600 | 6500*1260*1600 | 35.00 |
| WR 1000 | 1000 | 100-1000 | 2*15.0 | 1200-9000 | 900 | 500 | 7500*1600*1800 | 7000*1320*1800 | 40.00 |
| WR 1200 | 1200 | 100-1000 | 2*18.5 | 1500-12000 | 950 | 550 | 7500*1600*1875 | 7500*1320*1875 | 48.00 |
| WR 1600 | 1600 | 100-1000 | 2*22.0 | 3000-12000 | 950 | 550 | 8150*1850*2025 | 8150*1850*2025 | 79.00 |
| WR 2000 | 2000 | 100-1000 | 2*7.5 (*) | 3000-12000 | 1050 | 700 | 8150*1850*2025 | 8150*1850*2025 | 86.00 |
| WR 2500 | 2500 | 100-1000 | 2*11.0 (*) | 3000-12000 | 1100 | 800 | 8500*2000*2150 | 8500*2000*2150 | 100.00 |
| WR 3000 | 3000 | 100-1000 | 2*15.0 (*) | 3000-12000 | 1200 | 900 | 8500*2150*2300 | 8500*2150*2300 | 120.00 |

(*) The planetary reducer is being used instead of a gear reducer.

[3D: WR 3 - WR 400](#)

[3D: WR 600 - WR 1200](#)

[Photos/Video](#)

Features

1. Prototype static and dynamic tested at full capacity by a **Canadian Testing Laboratory**
2. Rotator's wheels from Model WR 3 to WR 100 are of **Cast Iron**, covered with heavy duty-rubber HSA80, and two steel rings at the side. Rotator's wheels of WR 150 and larger are of **Cast Steel ASTM 80-40** or equivalent; Then quenched and tempered at 43 ~ 45 HRC (Rockwell C).
3. Remote Control Box with 6 m cable: Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min
4. Center to center distance between wheels adjustable through bolts and nuts.
5. Angle between wheel's center and vessel center must be 45° to 110°. Never use less than 45° since produce un-safe conditions. To increase traction, use angles from 90° to 110°
6. [Selection Rules on Welding Rotators](#)



In Stock Rotators
From 3 to 1200 MT

Quality

1. Engineered in Canada, made in China.
2. Intertek label SPE 1000 on main control box; available under request.
3. Available [CE Mark](#) Certificate of Conformity No 181108/JIR/05; issue by Consultants Europe BV, The Netherlands.
4. Gearbox's shells made of cast iron ASTM-A48-A48M or equivalent.
5. Open gears made of Q235 steel or equivalent.
6. Shafts made of ANSI-1045 or equivalent.
7. Motors and control box with IP 54 protection against dust and heavy rain.
8. Frequency driver made by [TECO Westinghouse or Delta](#);
9. Shot blasted ISO 8501-SA2.5

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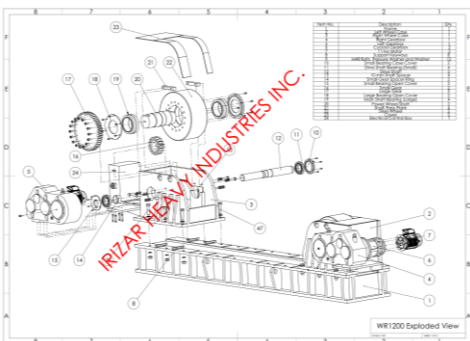
Standard Package: 1. One Power Roll, dual motor, with Control Box and Remote Control Box, 2. One Idler Roll, 3. [Operation Manual](#) with Electric Diagram, 4. One year [Warranty](#)

Optional

1. Foot Pedal with 6 m cable. Forward/Stop/Reverse
2. [Wireless Remote Control](#): With 60 m reach and 128 channels. Control: Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min
3. Turning rolls mounted idler or motorized bogies with a constant speed of 1.5 m/minute; or, variable speed 0.15 to 1.5 m/minute
4. [Screw Device](#) (manual or motorized) for adjust center to center wheel distance. Available for models up to WR 150
5. Rotator with large eccentricity (offset G.C from tank rotation center line) require brake motors. Available.
6. Rotator's wheel covered with polyurethane HSA95. Ideal for construction of stainless-steel tanks. Available on rotators up to WR 250.
7. [Rotators for shot blasting and painting](#) with an explosion-proof on motors and main control box
8. [Synchronized Device](#): Synchronize rotation speed of two power rotators



Irizar Welding Rotator Model WR 1200
Engineered in Canada. Load & Rotation Capacity: 1,200 MT
At Work in the USA, Spain & China



Irizar Power Welding Rotator Model WR 1200 MT
Engineered in Canada. Tested at C-FER, Canadian Laboratory



Irizar Model WR 1200 [video](#)
1200 MT Load and Rotation Capacity

[Selection Rules on Welding Rotators](#)



January 2017. Irizar Welding Rotator Model WR 1200 MT
Nuclear Power Generator at VC Summer, South Carolina USA
Westinghouse AP 1000 PWR



March 2013. Irizar Welding Rotator Model WR 1200 MT
Nuclear Power Generator at Haiyang, Shandong, China
Westinghouse AP 1000 PWR

March 2014. Irizar Welding Rotator Model WR 1200 MT
Nuclear Power Genertor at CNNC in Sanmen, Tazhou Zhejiang, China
The world's first AP1000 third-generation nuclear unit

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Self-Aligned Tank Turning Rolls, SAR Series

Self-Aligned Welding Rotators are used for positioning cylindrical workpieces allowing better weight distribution because of their eight wheels; they self-adjust the vessel diameter providing zero downtime lost. The set comprises one power rotator with variable speed and one idler roller. Self-Adjusted Turning Rolls automatize the welding process by applying SAW (Submerged Arc Welding) on longitudinal and circumferential seams with the help of a Welding Manipulator. Self Aligned Welding Rotators, also known as Self Aligning Welding Rotators, Self Adjusted Turning Rolls, Self Alignment Rollers, Self Adjustment Welding Rollers, Self Adjusting Tank Rolls, Rotador Soldadura Auto Ajustable, Virador Soldadura Auto Ajustable, Virador Tanques Auto Ajustable, Rotador Tanques Auto Ajustable and Rotador Tuberia Auto Ajustable



| Model | Load & Rotation Capacity (MT) | Rotation speed (mm/min) | Power (kW) | Vessel Diameter Range (mm) | Wheel (mm) | | Dimensions L*W*H (mm) | | Weight (MT) |
|-------------------------|-------------------------------|-------------------------|------------|----------------------------|------------|-------|-----------------------|----------------|-------------|
| | | | | | Diameter | Width | Power Roll | Idler Roll | |
| SAR 5 | 5 | 100-1000 | 0.75 | Chart Next Page | 250 | 140 | 1620*690*700 | 1380*380*700 | 0.85 |
| SAR 10 | 10 | 100-1000 | 1.10 | | 300 | 170 | 1880*780*820 | 1454*390*820 | 1.20 |
| SAR 20 | 20 | 100-1000 | 1.50 | | 350 | 180 | 2150*960*850 | 1700*480*850 | 2.00 |
| SAR 40 | 40 | 100-1000 | 3.00 | | 400 | 200 | 2600*1000*1100 | 2200*500*1100 | 3.00 |
| SAR 60 | 60 | 100-1000 | 4.00 | | 450 | 220 | 3000*1100*1150 | 2500*540*1150 | 4.00 |
| SAR 80 | 80 | 100-1000 | 4.00 | | 500 | 240 | 3200*1200*1200 | 2700*620*1200 | 4.50 |
| SAR 100 | 100 | 100-1000 | 5.50 | | 500 | 260 | 3500*1200*1400 | 3000*750*1400 | 5.50 |
| SAR 150 | 150 | 100-1000 | 3.0*2 | | 500 | 220 | 3500*1200*1400 | 3000*750*1400 | 6.00 |
| SAR 250 | 250 | 100-1000 | 5.5*2 | | 660 | 260 | 5010*1200*1600 | 3800*790*1600 | 12.00 |
| SAR 500 | 500 | 100-1000 | 7.5*2 | | 800 | 300 | 5800*1400*2000 | 5000*1000*2000 | 28.00 |

[3D: SAR 5 - SAR 100](#)

[3D: SAR 150 - SAR 500](#)

[Photos/Video](#)

Features

1. Prototype static and dynamic tested at full capacity by a **Canadian Testing Laboratory**.
2. Rollers align itself with the vessel diameter. Enable weight distribution in four idler wheels on idler roll and four motorized wheels on the powered rotator.
3. Rotators wheels from SAR 5 up to SAR 100 are of Cast Iron, covered with heavy duty-rubber HSA80, and two steel rings at the side. Rotator's wheels from SAR 150 up to SAR 500 are of Cast Steel ASTM 80-40 or equivalent; then quenched and tempered at 43 ~ 45 HRC (Rockwell C)
4. Remote Control Box with 6 m cable: Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min.
5. [Selection Rules on Welding Rotators](#)

Quality

1. Engineered in Canada, made in China. 2. Intertek label SPE 1000 on main control box; available under request. 3. Available [CE Mark](#) Certificate of Conformity No 181108/JIR/05; issue by Consultants Europe BV, The Netherlands. 4. Gearbox's shells made of cast iron ASTM-A48-A48M or equivalent. 5. Open gears made of Q235 steel or equivalent. 6. Shafts made of ANSI-1045 or equivalent; 7. Motors and control box with IP 54 protection against dust and heavy rain. 8. Frequency driver made by [TECO Westinghouse or Delta](#); 9. Shot blasted ISO 8501-SA2.5



Standard Package

1. One Power Roll, dual motor, with Control Box and Remote Control Box
2. One idler roll
3. [Operation Manual](#) with Electric Diagram
4. One year [Warranty](#)

Optional

1. Foot Pedal with 6.0 m cable. Forward/Stop/Reverse
2. [Wireless Remote Control](#): With 60 m reach and 128 channels. Control: Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min
3. Turning rolls mounted over idler or motorized bogie with a constant speed of 1.5 m/min; or, variable speed from 0.15 to 1.5 m/minute
4. Rotator with large eccentricity (offset G.C from tank rotation center line) require brake motors. Available.
5. Rotator's wheels covered with polyurethane HSA95. Ideal for construction of stainless-steel tanks. Available for rollers up to SAR 250.
6. [Synchronized Device](#): Synchronize rotation speed of two power rotators.

In Stock Rotators
From 5 to 500 MT

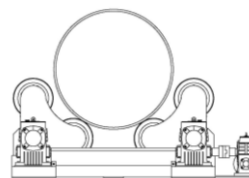
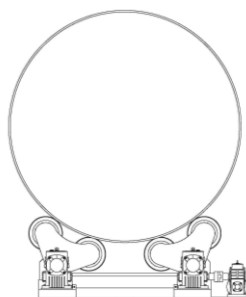
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| Four Wheels Load Full Load Capacity Table # 1 | | |
|---|-------------------------------------|---|
| Model | Vessel Diameter Range (mm) | Max Load and Rotation Capacity (MT) |
| | | 1 Power + 1 Idler |
| SAR 5 | 770-2300 | 5 |
| SAR 10 | 920-2800 | 10 |
| SAR 20 | 1170-3500 | 20 |
| SAR 40 | 1400-5200 | 40 |
| SAR 60 | 1550-4800 | 60 |
| SAR 80 | 1730-5000 | 80 |
| SAR 100 | 2010-5500 | 100 |
| SAR 150 | 2810-6000 | 150 |
| SAR 250 | 2810-8000 | 250 |
| SAR 500 | 3110-8000 | 500 |

| Two Wheels Load Half Load Capacity Table # 2 | | |
|--|-------------------------------------|---------------------------|
| Model | Vessel Diameter Range (mm) | Max Load Capacity (MT) |
| | | 1 Power + 1 Idler |
| SAR 5 | 250-750 | 2.50 |
| SAR 10 | 320-900 | 5 |
| SAR 20 | 500-1150 | 10 |
| SAR 40 | 900-1380 | 20 |
| SAR 60 | 750-1530 | 30 |
| SAR 80 | 850-1710 | 40 |
| SAR 100 | 1000-1990 | 50 |
| SAR 150 | 1100-2800 | 75 |
| SAR 250 | 1800-2800 | 125 |
| SAR 500 | 1800-3100 | 250 |



SELECTION RULES ON WELDING ROTATORS CONVENTIONAL & SELF ALIGNED

Rule # 1:

- Conventional Welding Rotators have a fixed load capacity that remains the same across the roller's range of vessel diameters.
- Self-Aligned Welding Rotators, on the other hand, have a reduced load capacity by half only when the vessel is supported solely by the bottom wheels. These rotators adjust to the vessel's diameter within the Roller's range, thus eliminating downtime. Besides, with eight wheels, they provide better weight distribution.
- Conventional Welding Rotators require manual adjustment of the distance between wheels (center to center) through nuts and bolts. This adjustment leads to downtime every time the vessel's diameter changes, and re-torque is required.

Rule # 2: Workpiece with concentric loads

Select a Welding Rotator within the load and rotation capacity of the rollers. The workpiece *must not* exceed 30 m in length.

Rule # 3: Large Workpieces

For a large workpiece from 30 to 60 m in length, use two power rotators and a [Synchronized Device](#).

Rule # 4: Workpiece with eccentric loads

Rule 4.1: Select a Welding Rotator with the greater of:

- Load and rotation capacity.
- Below formula

$$\geq \frac{5 \times \text{Vessel Weight (MT)} \times \text{C.G. (in.)}}{\text{Vessel Radius (in.)}}$$

Rule 4.2: Brake's motor is required if:

$$\text{Vessel Radius (inches)} \times 0.7 \geq \text{C.G.}''$$

Rule # 5: Increase load and rotation capacity.

Increase load and rotation capacity by 100% by adding an extra set (power rotator & idler rotator) and a [Synchronized Device](#). It is valid only if the workpiece does not exceed the roller's capacity.



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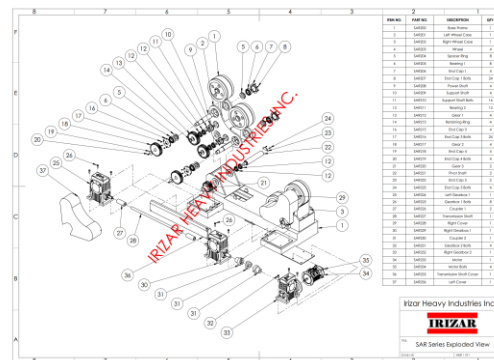
500 MT, Irizar Model SAR 500



500 MT Irizar Model SAR 500 at work in Saudi Arabia



500 MT, Irizar Model SAR 500 at work in UAE



Welding Rotator Model SAR 100
Engineered in Canada



Self Aligned Welding Rolls Model SAR 100



Self Aligned Welding Rolls Model SAR 150



Self Aligned Welding Rolls Model SAR 80



Welding Rotator's wheels tested on Irizar UTM



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Anti-Drift Turning Rolls, AD-WR Series

Anti-Drift Turning Rolls minimize the screw effect [longitudinal displacement] while the vessel rotates. It has an axial vessel accuracy of ± 3.0 mm through a PLC and a Sensor Automatic Anti-Drift Controller. **Anti-Drift Turning Rolls**, also known as **Anti-Creep Rotators** and **Anti-Drift Rotators**

Standard Package

1. One Power Roll with Control Box and Remote-Control Box
2. One Idler Roll with up/down servo motor on both wheels
3. **PLC & Sensor Automatic Anti-Drift Controlled**
4. Operation Manual with Electrical Diagram
5. One year Warranty

In Stock
AD-WR 100 MT



[Video](#)



3000 MT, Irizar Anti-Drift Welding Rotator
Model AD-WR 3000

| Model | Load & Rotation Capacity (MT) | Rotation speed (mm/min) | Power (kW) | Vessel Diameter Range (mm) | Wheel (mm) | | Dimensions L*H*W1*W2 (mm) | Weight (MT) |
|----------------------------|-------------------------------|-------------------------|------------|----------------------------|------------|-------|---------------------------|-------------|
| | | | | | Diameter | Width | | |
| AD-WR 100 | 100 | 100-1000 | 2*3.0 | 1000-8000 | 500 | 260 | 5300*1070*1000*600 | 6.24 |
| AD-WR 150 | 150 | 100-1000 | 2*4.0 | 1000-8000 | 500 | 260 | 5700*1140*1050*650 | 7.15 |
| AD-WR 250 | 250 | 100-1000 | 2*5.5 | 1000-9000 | 660 | 260 | 5700*1250*1140*700 | 13.00 |
| AD-WR 400 | 400 | 100-1000 | 2*5.5 | 1200-9000 | 700 | 300 | 6600*1450*1320*830 | 22.75 |
| AD-WR 600 | 600 | 100-1000 | 2*7.5 | 1500-9000 | 900 | 360 | 7200*1845*1650*1000 | 35.75 |
| AD-WR 800 | 800 | 100-1000 | 2*11.0 | 2000-9000 | 900 | 380 | 7900*1845*2000*1300 | 45.50 |
| AD-WR 1000 | 1000 | 100-1000 | 2*11.0 | 2000-9000 | 1000 | 400 | 7900*1860*2100*1500 | 52.00 |
| AD-WR 1200 | 1200 | 100-1000 | 2*11.0 | 2000-9000 | 1000 | 450 | 7900*1860*2150*1600 | 62.40 |
| AD-WR 1600 | 1600 | 100-1000 | 2*20.0 | 2000-9000 | 1200 | 600 | 7900*1860*2400*1800 | 143.00 |
| AD-WR 2000 | 2000 | 100-1000 | 2*24.0 | 2000-9000 | 1200 | 600 | 8500*1960*2560*1900 | 182.00 |
| AD-WR 3000 | 3000 | 100-1000 | 2*24 + 30 | 2000-4000 | 1500 | 800 | 10000*2695*3210*2440 | 300.00 |



500 MT, Irizar Model WR 500 with Anti-Drift



3000 MT, Irizar Anti-Drift Welding Rotator Model AD-WR 3000



1600 MT, Irizar Model Anti-Drift Power WR 1600



1600 MT, Irizar Model Anti-Drift Idler IR 1600

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Stainless Steel Vessel on TWR-20

TRACK Welding Rotator, TWR Series

Track Welding Rotators are used to construct light gauge vessels made of stainless steel or aluminum, which are common in the brewing, dairy, cosmetic, and pharmaceutical industries. Tanks/vessels are accommodated on the Roller's track cover with heavy-duty rubber, preventing the vessel from surface indentations produced by the contact between a light gauge vessel and the conventional rollers' wheels.



Model TWR-5: Fixed frame.

Model TWR-20 has idler bogies on the frame bottom. They allow easy tank length adjustment and mobility.

[Video](#)

| Model | Load & Rotation Capacity (MT) | Speed (mm/min) | Power (kW) | Vessel Diameter (mm) | Wheel (mm) | | Dimensions L*W*H (mm) | | Weight (MT) |
|------------------------|-------------------------------|----------------|------------|----------------------|------------|-------|-----------------------|---------------|-------------|
| | | | | | Diameter | Width | Power Roll | Idler Roll | |
| TWR-5 | 5 | 150 -1500 | 2 @ 0.37 | 500 – 2,500 | 320 | 150 | 2800 *600*500 | 2500*500*500 | 1.50 |
| TWR-20 | 20 | 100-1000 | 2 @ 1.50 | 2,000 – 5,000 | 420 | 240 | 4200*1000*660 | 3700*1000*660 | 3.50 |

Features

1. TWR-5: Fix frame.
2. TWR-20: Idler Bogies on power and idler rotator. Center to center distance between wheels: 2,250 mm.
3. Motors and Control Box IP54

Standard Package

1. One Power Roll with Control Box and Remote-Control Box with 6 m cable. Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min
2. One Idler Roll
3. Operation Manual
4. Electric Diagram
5. One year [Warranty](#)

Optional

1. **For Fit Up** we can supply additional two idler rotators. Therefore, the first shell sits on one power and one idler; the second shell sits on two extra idlers.
2. [Wireless Remote Control](#): With 60 m reach and 128 channels. Control: Forward/Stop/Reverse/Variable speed adjustment with a digital display in mm/min
3. **Foot Pedal** with 6.0 m cable. Forward/Stop/Reverse



[TWR-20](#)



Track Welding Rotator Model [TWR-20](#)



Track Welding Rotator Model [TWR-5](#)

I Beam Rotators



Roller Beds



Custom Built Rolls

1. [Roller Beds](#)
2. Cone Rotators,
3. I Beam Rotators
4. Rotators with Idler or Motorized Bogies
5. Rollers w/screw adjustment device
6. Rotators for Shot Blasting & Painting
7. Turbine Rotator

Product Catalog

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Fit-Up Rollers, FUR Series

Fit Up Rollers are used to assemble -tack weld- the shells to conform up to a 30 m section of a Wind Tower or a Large Pressure Vessel/Tank/Pipe. Then, the section is moved parallel to a Welding Station by Transfer Cars. If required, two sections can be assembled and welded by a larger set of Fit-Up Rolls or assembled by flanges and bolts at the job site. **Fit-Up Rolls**, also known as **Tank Fit-Up Rollers, Fit-Up Rotators, Fit Up Turning Rolls, Fit-Up Turning Rolls, Fit-Up Bed Rollers, Tank Fit Up Line, Vessel Fit-Up Rollers, Welding Fit Up System and Tank Growing Line.**

Application: Wind Tower Construction

- Tower weight: From 40 up to 1,200 MT
- Diameter range: From 1.50 to 8 m
- Section length: Up to 30 m



In stock Fit- Up Rollers
40 MT & 100 MT

[Video](#)

Elements:

- One Power Rotator
- One Idler Rotator
- Two Fit-Up Rotators



Fit Up Rolls
Model FUR 250

| Specifications | Model | FUR 40 | FUR 80 | FUR 150 | FUR 250 | FUR 350 |
|---|-------|------------------------|------------------------|-------------------------|-------------------------|-------------------------|
| Power Roll rotation capacity, MT | | 40 | 80 | 150 | 250 | 350 |
| Power Roll load capacity, MT | | 20 | 40 | 75 | 125 | 175 |
| Idler Roll load capacity, MT | | 20 | 40 | 75 | 125 | 175 |
| Fit-Up-Roll load capacity, MT | | 20 x 2 units | 40 x 2 units | 75 x 2 units | 125 x 2 units | 175 x 2 units |
| Tower/Vessel diameter range, m | | 1.0 to 6.0 | 1.0 to 6.0 | 1.50 to 7.0 | 1.5 to 8.0 | 1.5 to 8.0 |
| Tower/Vessel length, m | | Up to 30 m | Up to 30 m | Up to 30 m | Up to 30 m | Up to 30 m |
| Power Roll rotation speed, mm/min | | 100 -1000 | 100 -1000 | 100 -1000 | 100 -1000 | 100 -1000 |
| Power Roll translation speed, mm/min mounted on motorized bogie with | | 1000-6000 | 1000-6000 | 1000-6000 | 1000-6000 | 1000-6000 |
| Idler Roll mounted on idler bogie | | Yes | Yes | Yes | Yes | Yes |
| Fit-Up Roll mounted on idler bogie | | Yes | Yes | Yes | Yes | Yes |
| With hydraulic fixture (up & down, left & right) | | Yes | Yes | Yes | Yes | Yes |
| Power Rotation, kW | | 2 x 1.5 | 2 x 3 | 2 x 4 | 2 x 5.5 | 2 x 7.5 |
| Power Translation, kW | | 2 x 1.1 | 2 x 2.2 | 2 x 3 | 2 x 5.5 | 2 x 5.5 |
| Wheel diameter, covered with PU, mm | | 400 | 500 | 500 | 600 | 650 |
| Wheel width on P & I Rolls, mm | | 220 | 350 | 500 | 600 | 650 |
| Wheel width on Fit Up Rolls, mm | | 200 | 320 | 400 | 600 | 650 |
| Bogies bolted to the frame | | Yes | Yes | Yes | Yes | Yes |
| Rail G-G, mm | | 2,500 | 2,500 | 2,500 | 2,500 | 2,500 |
| Estimated Weight/set, MT | | 7.0 | 12.0 | 18.0 | 34.0 | 43.0 |

Quality: 1. Gearbox's shells made of cast iron ASTM-A48-A48M or equivalent. 2. Open gears made of Q235 steel or equivalent. 6. Shafts made of ANSI-1045 or equivalent; 3. Motors and control box with IP 54 protection against dust and heavy rain. 4. Frequency driver made by TECO Westinghouse or Delta; 9. Shot blasted on frame ISO 8501-SA2.5

Taken from **Offshore Magazine**



Custom Build Fit Up Rolls. Model FUR 800 MT



Product Catalog



Pipe Rotators, PR Series

In stock
PR-1, PR-3 & PR 5

Pipe Rotators are used for positioning and welding pipes with concentric loads. It comes with variable speed.

Pipe Rotator Model PR-1

[Video](#)

Load & Rotation Cap: 1 MT
Pipe diameter: From 20 up to 1,000 mm
Variable speed: From 80-2,400 mm/minute
Input power: 110V, 50/60Hz, 1P
Power: 0.18 kW, DC motor

Control box: forward/stop/reverse/analog speed control.
Rollers: PU, 200 mm Ø, 50 mm (W)
Foot control: Included
Power (L*W*H): 500*400*370 mm
Idler (L*W*H): 500*250*370 mm
Weight: 65 kilos

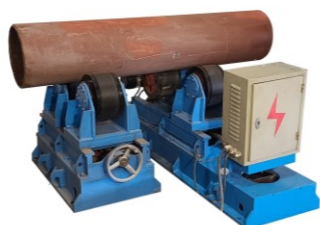


Pipe Rotator Model PR-3

NEW!

Load and Rotation Capacity: 3 MT
Pipe diameter: From 20 up to 1,000 mm
Variable speed: From 100 - 2,000 mm/minute
Input power: 110V, 50/60Hz, 1P
Power: 0.55 kW, DC motor

Control box: forward/stop/reverse/analog speed control.
Rollers: PU, 200 mm Ø, 50 mm (W)
Foot control: Included
Power (L*W*H): 850*335*450 mm
Idler (L*W*H): 850*230*450 mm
Weight: 180 kilos



Pipe Rotator Model PR-5

[Video](#)

Load and Rotation Capacity: 5 MT
Pipe diameter: From 50 up to 600 mm
Variable speed: From 100 - 1,000 mm/minute
Screw device: Adjust distance between wheels
Input power: 240V, 60Hz, 3P
Power: 0.75 kW, AC motor

Control box: forward/stop/reverse/analog speed control.
Wheel diameter: 200 mm
Wheel width: 50 mm
Dim: (L*W*H): 1500*1200*550 mm
Weight: 820 kilos
Foot control (optional): Forward/Stop/Reverse

Pipe Positioners PP Series. It provide quick positioning and welding pipes with elbows or tee pieces; and, pipes with eccentric (offset) loads. It comes with variable speed, $\pm 45^\circ$ tilt angle, and assisting pressure column for pipe clamping without chuck.

| Model | Load & Rotation Capacity (MT) | Rotation Speed (mm/min) | Tilt Angle | Pipe Diameter (mm) | Column | | Dimensions L*W*H (mm) | Power (kW) | Weight (MT) |
|-------|-------------------------------|-------------------------|----------------|--------------------|-------------------------|------------------------|-----------------------|------------|-------------|
| | | | | | Assisting Pressure (kg) | Lifting Speed (mm/min) | | | |
| PP-1 | 1 | 70-1700 | $\pm 45^\circ$ | 50-426 | ≤ 450 | 300 | 1200*800*1800 | 0.75 | 1.00 |
| PP-2 | 2 | 70-1700 | $\pm 45^\circ$ | 50-630 | ≤ 450 | 300 | 1200*800*1800 | 1.10 | 1.25 |
| PP-3 | 3 | 70-1700 | $\pm 45^\circ$ | 50-800 | ≤ 450 | 300 | 1300*800*1800 | 1.10 | 1.50 |



[Photos](#)

[Video](#)

Standard Package

1. Power Roll with 12 m control box.
Include: Forward / Stop / Reverse / Variable speed adjustment with a digital display in mm/minute
2. Operation Manual
3. Electric Diagram
4. One year [Warranty](#)

Optional: Foot Pedal



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Welding Positioners, WP Series

Welding Positioner, also called Weld Positioner, moves the workpiece under the welding process equipment; instead, the Welding Manipulators move the equipment over the workpiece. The Positioner provides powered 360° variable speed rotation and table tilt from horizontal (0°) to 120°.



[WP Series](#), Fixed height Irizar Model WP 5



[AH-WP Series](#), Adjustable height



88,000 # @ 47.25" C.G, Irizar Model CWP 40

| Model | Load Cap (MT) | Power (kW) | | Max GC (mm) | Max Eccentricity (mm) | Table | | | | Max Work Piece Dia. @ 90° Tilt (mm) | Torque (Nm) | | Tilt Angle (°) | Dimensions L*W*H (mm) | Weight (MT) |
|------------------------|---------------|------------|------|-------------|-----------------------|-------------|------|-------------------------|---------------|-------------------------------------|-------------|--------|----------------|-----------------------|-------------|
| | | Rotation | Tilt | | | Speed (RPM) | | Surface rotation φ (mm) | Diameter (mm) | | Rotation | Tilt | | | |
| | | | | | | Rotation | Tilt | | | | | | | | |
| WP 0.3 | 0.30 | 0.37 | N/A | 200 | 150 | 0.10~1.0 | N/A | 150 | 600 | 800 | 1286 | N/A | 0-90° | 930*660*720 | 0.3 |
| WP 0.6 | 0.60 | 0.75 | 0.75 | 200 | 150 | 0.10~1.0 | 1.09 | 210 | 1000 | 1500 | 2600 | 2676 | 0-90° | 1200*900*850 | 0.7 |
| WP 1 | 1 | 1.10 | 1.50 | 250 | 200 | 0.05~0.5 | 0.80 | 240 | 1200 | 2000 | 8345 | 7257 | 0-120° | 1400*1200*1200 | 1.0 |
| WP 3 | 3 | 1.50 | 2.20 | 300 | 200 | 0.05~0.5 | 0.23 | 250 | 1400 | 2100 | 8519 | 37617 | 0-120° | 2100*1500*1350 | 2.5 |
| WP 5 | 5 | 2.20 | 3.00 | 300 | 200 | 0.05~0.5 | 0.16 | 280 | 1500 | 2500 | 14913 | 71119 | 0-120° | 2200*1500*1450 | 3.7 |
| WP 10 | 10 | 3.00 | 5.50 | 400 | 200 | 0.05~0.5 | 0.24 | 280 | 2000 | 3200 | 71720 | 91029 | 0-120° | 2700*2000*1850 | 5.8 |
| WP 20 | 20 | 4.00 | 7.50 | 450 | 200 | 0.05~0.5 | 0.10 | 290 | 2300 | 3200 | 90000 | 315000 | 0-135° | 3300*2230*2000 | 11 |
| WP 30 | 30 | 7.50 | 11.0 | 500 | 200 | 0.05~0.5 | 0.10 | 290 | 3000 | 3400 | 120000 | 420000 | 0-135° | 3675*3000*2750 | 18 |
| WP 40 | 40 | 11.0 | 11.0 | 500 | 200 | 0.05~0.5 | 0.10 | 300 | 3500 | 3400 | 142000 | 500000 | 0-135° | 4000*3000*3300 | 22 |
| WP 50 | 50 | 11.0 | 15.0 | 500 | 200 | 0.05~0.5 | 0.10 | 300 | 3500 | 4200 | 163000 | 550000 | 0-135° | 4525*3500*4100 | 27 |

[3D: WP 0.6 - WP 1](#)

[3D: WP 3 - WP 10](#)

[Photos](#)

[Video](#)

Features

- Designed and engineered in Canada; made in China
- Main Control Box controls tilt rotation (*): Forward/Stop/Reverse
- Remote Control Box with 6 m cable. Control: Forward/Stop/Reverse /Variable speed adjustment on table rotation with a digital display in mm/min
- Tilt with electric brake motor
- "T" shaped channels on the table surface
- Octagonal Table on WP 30 and larger. Octagon size has an inscribed circumference of 2.3 m Ø.
- Quality: 1. Gearbox's shells are made of cast iron ASTM-A48-A48M or equivalent; 2. Open gears made of Q235 steel or equivalent; 3. Shafts made of ANSI 1045 or equivalent; 4. Motors and control box with IP 54 protection against dust and heavy rain; 5. Frequency driver made by [TECO](#) [Westinghouse](#) or [Delta](#);
- Shot blasted: Ensure the paint holds longer
- WP 20 and larger adopt for safety double motor and double gear on tilt

Standard Package: 1. Welding Positioner with Control Box and Remote Control Box, 2. Operation Manual with Electric Diagram, 3. One year [Warranty](#)



Optional

- Foot Pedal with 6.0 cable. Forward/Stop/Reverse
- Variable speed on tilt
- [Wireless remote control](#): With 60 m reach and 128 channels. Control table rotation: Forward/Stop/Reverse/ Variable speed adjustment with digital display.
- Table extension arms to reach larger work pieces. Available on WP 30 and larger.
- [Synchronized Device](#): Synchronize rotation speed of two WP of same model. Increase capacity 100% when both positioners have tables at 90° (vertical position)
- [CE mark](#)

In stock Positioners from 0.3 MT to 10 MT

| Model | Work Piece GC (mm)* VS Load Capacity (kg or MT) ** | | | | | | | | | | | | | | | |
|--------|--|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | (mm) | 200 | 250 | 300 | 350 | 400 | 450 | 500 | 600 | 700 | 800 | 900 | 1000 | 1200 | 1400 | 1800 |
| WP 0.3 | Kgs | 300 | 240 | 200 | 171 | 150 | 133 | 120 | 100 | | | | | | | |
| WP 0.6 | Kgs | 600 | 480 | 400 | 342 | 300 | 266 | 240 | 200 | | | | | | | |
| WP 1 | Kgs | | 1000 | 833 | 714 | 625 | 555 | 500 | 416 | 357 | 312 | 277 | | | | |
| WP 3 | Kgs | | | 3000 | 2571 | 2250 | 2000 | 1800 | 1500 | 1285 | 1125 | 1000 | | | | |
| WP 5 | Kgs | | | 5000 | 4285 | 3750 | 3333 | 3000 | 2500 | 2142 | 1870 | 1666 | | | | |
| WP 10 | MT | | | | | 10 | 8.8 | 8.0 | 6.6 | 5.7 | 5.0 | 4.4 | 4.0 | 3.3 | 2.8 | 2.2 |
| WP 20 | MT | | | | | | | | 20 | 17.1 | 15 | 13.3 | 12 | 10 | 8.5 | 6.6 |
| WP 30 | MT | | | | | | | | 30 | 25.7 | 22.5 | 20 | 18 | 15 | 12.8 | 11.2 |
| WP 40 | MT | | | | | | | | | 40 | 35 | 31.1 | 28 | 23.3 | 20 | 17.5 |
| WP 50 | MT | | | | | | | | | | 50 | 44.4 | 40 | 33.3 | 28.5 | 22.2 |

| Max Eccentricity y (mm) |
|-------------------------|
| 150 |
| 150 |
| 200 |
| 200 |
| 200 |
| 200 |
| 200 |
| 200 |
| 200 |
| 200 |

(*) Max GC measured from the table surface

(**) Max load capacity when the positioner's table is at 90° tilt

Product Catalog

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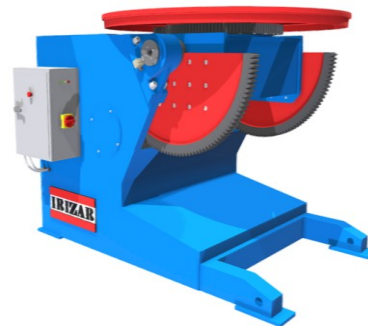
1 MT (2,200 #) @ 250 mm **GC** on Irizar Model WP 1



Adjustable height [AH-WP 5](#)



0.6 MT (1,320 #) @ 200 mm **GC** on Irizar Model WP 0.6



5 MT (11,000 #) @ 300 mm **GC** on Irizar Model WP 5



10 MT (22,000 #) @ 400 mm **GC** on Irizar Model WP 10
At Work in Edmonton, AB, Canada



20 MT (44,000 #) @ 600 mm **GC** on Irizar Model WP 20
Shipped to Topeka, Kansas USA & Tatsumo, Japan



40 MT @ 1,200 mm **GC** on Irizar Model CWP 40
At work Portland, Oregon, USA



88,000 # @ 47.25" **GC** on Irizar Model CWP 40
At work Portland, Oregon, USA

Product Catalog

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Cradle Welding Positioners, CWP Series

Gear Drive Positioners are used for lifting, tilting and turning extra-large and wide workpieces



60 MT @ 1,800 mm C.G, Irizar Model CWP 60



132,000 # @ 70.86" C.G, Irizar Model CWP 60



60 MT @ 1,800 mm C.G, Irizar Model CWP 60

| Model | Load Cap (MT) | Power (kW) | | Max GC (mm) | Max Eccentricity (mm) | Table | | | Max Work Piece Dia. @ 90° Tilt (mm) | Torque (N-m) | | Tilt Angle (°) | Dimensions L*W*H (mm) | Weight (MT) |
|-------------------------|---------------|------------|--------|-------------|-----------------------|-------------|------------|---|-------------------------------------|--------------|---------|----------------|-----------------------|-------------|
| | | Rotation | Tilt | | | Speed (RPM) | | Table Surface to rotation ϵ (mm) | | Rotation | Tilt | | | |
| | | | | | | Rotation | Tilt | | | | | | | |
| CWP 30 | 30 | 11 | 2*5.5 | 1200 | 400 | 0.05 ~ 0.50 | 0.01 ~ 0.1 | 200 | 4000 | 120000 | 420000 | 0-90° | 6370*2800*2300 | 33 |
| CWP 40 | 40 | 11 | 2*7.5 | 1200 | 400 | | | 200 | 4000 | 142000 | 500000 | 0-90° | 6370*2800*2300 | 34 |
| CWP 50 | 50 | 15 | 2*7.5 | 1200 | 400 | | | 350 | 4000 | 163000 | 550000 | 0-90° | 6370*2800*2300 | 35 |
| CWP 60 | 60 | 18.50 | 2*11 | 1800 | 300 | | | 400 | 5500 | 195000 | 670000 | 0-90° | 8100*4000*3100 | 65 |
| CWP 70 | 70 | 22 | 2*11 | 1800 | 300 | | | 450 | 5500 | 250000 | 950000 | 0-90° | 8100*4000*3100 | 67 |
| CWP 80 | 80 | 22 | 2*15 | 1800 | 300 | | | 500 | 5500 | 335000 | 1460000 | 0-90° | 8100*4000*3100 | 68 |
| CWP 90 | 90 | 2*15 | 2*18.5 | 2000 | 300 | | | 500 | 6000 | 425000 | 1700000 | 0-90° | 9300*4300*3500 | 72 |
| CWP 100 | 100 | 2*15 | 2*18.5 | 2000 | 300 | | | 550 | 6000 | 470000 | 1900000 | 0-90° | 9300*4300*3500 | 75 |

Features

1. Designed and engineered in Canada; made in China
2. Control Box with emergency stop
3. Remote Control Box with 12 m cable.
Forward/Stop/Reverse/Variable speed adjustment on table rotation and tilt. Digital display in RPM
4. Rotation variable speed from 0.02 to 0.20 RPM
5. Tilt variable speed from 0.01 to 0.10 RPM
6. Self-lock worm gearboxes with electric brake motor
7. Octagon table within an inscribed circumference from 2.20 up to 3.00 m Ø.
8. Include "T" shaped channels at 45° on the table surface



[Photos/Video](#)

3. Gearbox's shells made of cast iron ASTM-A48-A48M or equivalent
4. Open gears made of Q235 steel or equivalent.
5. Shafts made of ANSI-1045 or equivalent.
6. Motors and control box with IP 54 protection against dust and heavy rain
7. Frequency driver made by [TECO Westinghouse or Delta](#)
8. Shot blasted ISO 8501-SA2.5
9. Safety tilt device composed of a gas cylinder support on gear to prevent table tilt in case a gearbox brake

Standard Package

1. Welding Positioner w Control Box and Remote-Control
2. Operation Manual with Electric Diagram
3. One year [Warranty](#)

Quality

1. Intertek label SPE 1000 on main control box. Optional
2. [CE Mark](#) Certificate of Conformity No 181108/JIR/05; issue by Consultants Europe BV in The Netherlands

Optional: 1. Table extension arms to reach larger work pieces. Arm's length: work piece OD + 0.70 m, 2. Tilt angle from 0° to 135° forward

| Model | Work Piece C.G (mm)* VS. Load Capacity (MT)** | | | | | | | | | | |
|---------|---|------|------|------|------|-------|------|------|------|------|------|
| | (mm) | 1200 | 1400 | 1600 | 1800 | 2000 | 2200 | 2400 | 2600 | 2800 | 3000 |
| CWP 30 | MT | 30.0 | 25.7 | 22.5 | 20.0 | 18.0 | 16.3 | 15.0 | 13.8 | 12.8 | 12.0 |
| CWP 40 | MT | 40.0 | 34.2 | 30.0 | 26.6 | 24.0 | 21.8 | 20.0 | 18.4 | 17.1 | 16.0 |
| CWP 50 | MT | 50.0 | 42.8 | 37.5 | 33.3 | 30.0 | 27.2 | 25.0 | 23.0 | 21.4 | 20.0 |
| CWP 60 | MT | | | | 60.0 | 54.0 | 49.0 | 45.0 | 41.5 | 38.5 | 36.0 |
| CWP 70 | MT | | | | 70.0 | 63.0 | 57.2 | 52.5 | 48.4 | 45.0 | 42.0 |
| CWP 80 | MT | | | | 80.0 | 72.0 | 65.4 | 60.0 | 55.3 | 51.4 | 48.0 |
| CWP 90 | MT | | | | | 90.0 | 81.8 | 75.0 | 69.2 | 64.2 | 60.0 |
| CWP 100 | MT | | | | | 100.0 | 91.0 | 83.3 | 76.9 | 71.4 | 66.6 |

| Max Eccentricity (mm) |
|-----------------------|
| 400 |
| 400 |
| 400 |
| 300 |
| 300 |
| 300 |
| 300 |
| 300 |

Notes:

(*) Max GC measured from the table surface.

(**) Max load capacity when the positioner's table is at 90° tilt



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Head & Tail Stock, HT Series

[Photos-Video](#)



In stock HT
From 3 to 20 MT

Head & Tailstock Positioner rotates long rectangular steel structures supported from both ends. Headstock Positioner is fixed to the floor and has 360° variable powered rotation speed and adjustable center rotation height (up/down). Tailstock has idler rotation and adjustable height-powered center rotation. The unit is mounted over idler bogies to adjust the workpiece length. The set allows the welder to have ergonomic accessibility to the workpiece welds. **Headstock and Tailstock Welding Positioner**, also known as **Headstock Positioner, Tailstock Positioner**

| Model | Load Cap. (MT) | Table Diameter (mm) | Adjustable Rotation Center (mm) | Rotation Speed (RPM) | Elevation Speed (m/min) | (*) Max ECC (mm) | Torque (Kg-m) | Power (kW) | Weight (MT) |
|--------|----------------|---------------------|---------------------------------|----------------------|-------------------------|------------------|---------------|------------|-------------|
| HT 1 | 1.0 | 800 | 800~1,500 | 0.15~1.50 | 1.0 | 150 | 210 | 2.00 | 1.50 |
| HT 3 | 3.0 | 800 | 800~1,500 | 0.10~1.00 | 1.0 | 150 | 640 | 3.70 | 4.50 |
| HT 5 | 5.0 | 1,000 | 900~1,800 | 0.10~1.00 | 0.6 | 200 | 900 | 4.40 | 6.60 |
| HT 10 | 10 | 1,000 | 1,100~1,800 | 0.10~1.00 | 0.6 | 200 | 1,880 | 7.00 | 10.00 |
| HT 15 | 15 | 1,200 | 1,350~2,350 | 0.10~1.00 | 0.6 | 200 | 3,360 | 12.00 | 13.0 |
| HT 20 | 20 | 1,700 | 1,350~2,350 | 0.10~1.00 | 0.5 | 250 | 6,700 | 16.50 | 15.0 |
| HT 30 | 30 | 1,700 | 1,350~2,350 | 0.10~1.00 | 0.5 | 250 | 8,500 | 24.00 | 25.0 |
| HT 40 | 40 | 1,700 | 1,350~2,350 | 0.05~0.50 | 0.5 | 250 | 12,000 | 30.00 | 35.0 |
| HT 50 | 50 | 1,700 | 1,350~2,350 | 0.05~0.50 | 0.5 | 250 | 15,000 | 32.00 | 50.0 |
| HT 75 | 75 | 1,700 | 1,350~2,350 | 0.05~0.50 | 0.5 | 250 | 23,000 | 35.00 | 65.0 |
| HT 100 | 100 | 1,700 | 1,350~2,350 | 0.05~0.50 | 0.5 | 250 | 31,000 | 45.00 | 80.0 |



HT-20

| Model | Load Capacity (MT) vs Work Piece GC (mm) | | | | | | | | | | ECC (mm) must NOT exceed above table (*) |
|--------|--|------|------|------|------|------|------|------|------|------|--|
| | (mm) | 250 | 350 | 450 | 550 | 650 | 750 | 850 | 950 | 1000 | |
| HT 1 | MT | 0.5 | 0.4 | 0.3 | 0.2 | 0.2 | | | | | Load capacity (MT) of Head stock only (overhung) must NOT exceed this table. GC (mm) measured from the Headstock table surface. Notes: HT applicable for use on SAW/positioning. Table play tolerance of 5 mm on 1.70 m Ø |
| HT 3 | MT | 1.5 | 1.0 | 0.8 | 0.7 | 0.6 | 0.5 | | | | |
| HT 5 | MT | 2.5 | 1.7 | 1.4 | 1.1 | 0.9 | 0.8 | 0.7 | | | |
| HT 10 | MT | 5.0 | 3.5 | 2.7 | 2.2 | 1.9 | 1.6 | 1.4 | | | |
| HT 15 | MT | 7.5 | 5.0 | 4.0 | 3.5 | 2.8 | 2.5 | 2.0 | | | |
| HT 20 | MT | 10.0 | 7.0 | 5.5 | 4.5 | 3.5 | 3.3 | 3.0 | 2.5 | | |
| HT 30 | MT | 15.0 | 10.0 | 8.3 | 6.5 | 5.5 | 5.0 | 4.3 | 4.0 | | |
| HT 40 | MT | 20.0 | 14.0 | 11.0 | 9.0 | 7.0 | 6.0 | 5.5 | 5.0 | | |
| HT 50 | MT | 25.0 | 17.0 | 14.0 | 11.0 | 9.5 | 8.3 | 7.0 | 6.5 | 6.0 | |
| HT 75 | MT | 37.5 | 26.0 | 20.0 | 17.0 | 14.0 | 12.0 | 11.0 | 10.0 | 9.0 | |
| HT 100 | MT | 50.0 | 35.0 | 27.0 | 22.0 | 19.0 | 16.0 | 14.0 | 13.0 | 12.0 | |



Turntables, TT Series

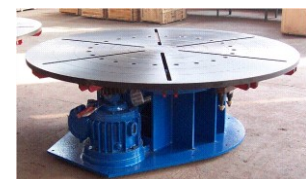
[Photos-Video](#)



In stock TT
From 0.5 to 10 MT

Welding Turntable is used to rotate 360° a workpiece around a vertical axis in a flat (horizontal position). They come with variable speeds and use for welding, flame cutting, X-ray and machining. **Welding Turntable**, also known as **Welding Floor Turntable and Horizontal Welding Turntable**

| Model | Load Cap. (MT) | Table Diameter (mm) | Rotation Speed (RPM) | Max Eccentricity (mm) | Dimensions L*W*H (mm) | Torque (Nm) | Power (kW) | Weight (MT) |
|--------|----------------|---------------------|----------------------|-----------------------|-----------------------|-------------|------------|-------------|
| TT 0.5 | 0.5 | 800 | 0.10~1.00 | 200 | 800*800*400 | 80 | 0.18 | 0.90 |
| TT 1 | 1 | 1000 | 0.10~1.00 | 200 | 1000*1000*500 | 100 | 0.25 | 1.00 |
| TT 3 | 3 | 1500 | 0.05~0.50 | 200 | 1500*1500*600 | 400 | 0.55 | 1.10 |
| TT 5 | 5 | 1500 | 0.05~0.50 | 200 | 1500*1500*650 | 600 | 0.75 | 1.30 |
| TT 10 | 10 | 1800 | 0.05~0.50 | 200 | 1800*1800*650 | 1200 | 1.10 | 1.50 |
| TT 20 | 20 | 2000 | 0.02~0.20 | 200 | 2000*2000*750 | 2400 | 1.50 | 2.50 |
| TT 50 | 50 | 2500 | 0.015~0.15 | 200 | 2500*2500*750 | 6000 | 2.20 | 4.50 |
| TT 75 | 75 | 2800 | 0.015~0.15 | 200 | 2600*2600*850 | 9000 | 3.00 | 6.00 |
| TT 100 | 100 | 2800 | 0.010~0.10 | 200 | 2800*2800*1000 | 12000 | 4.00 | 7.80 |



Features

1. Designed and engineered in Canada; made in China
2. Remote Control Box with 6 m cable: 1) **On Head Stock Model HT**. Includes: Variable speed on table rotation: Forward / Stop / Reverse; Digital display in RPM; and, adjustable center rotation height: Up / Down; 2) **On Turntable Model TT**: Variable speed on table rotation: Forward / Stop / Reverse; Digital display in RPM; 3) **On Welding Positioner Model PL**. Includes: Variable speed on table rotation: Forward / Stop / Reverse; Digital display in RPM; and, tilt speed control, and height adjustment: Up / Down
3. "T" shaped channels on the table surface

Standard Package: 1. Welding Positioner PL or Head & Tail Stock or Turntable, 2. Control Box and Remote-Control Box, 3. Operation Manual with Electric Diagram, 4. One year [Warranty](#)

Optional: 1. Foot control pedal. Control: Forward/Stop/Reverse, 2. Extension arms on Turntable for increase table diameter, 3. [CE mark](#)

Product Catalog

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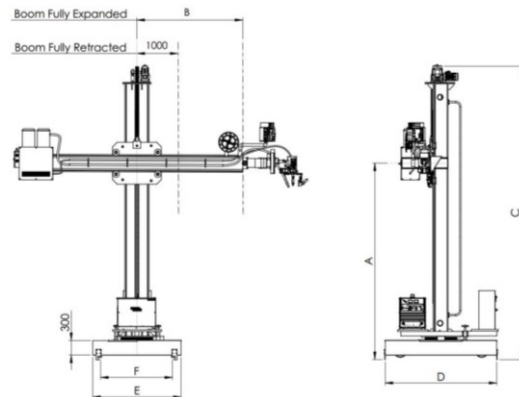
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Welding Manipulators, WM Series



In stock Manipulators
From 3030 to 9060



Welding Manipulator is used for automated SAW / MIG / FACA / TIG welding on pipe, tank and pressure vessels combined with Tank Turning Rolls, Welding Positioners or Head & Tailstock Positioners. Irizar manipulators mainly comprise a column, boom and motorized trolley (travelling car). We supply the manipulator itself or equipped with a power source, welding head, welding controller, flux recovery system, motorized cross slide & seam tracker. **Welding Manipulators** are also known as **Welding Booms, Welding Columns or Welding Column and Boom (C&B)**

| Model WM YYXX | Boom | | | | | | | | Column | | Trolley or Base Self Stand | | | Power (kW) | Estimated Packing Dim. Column-Boom (L*W*H) (m) | Weight (MT) |
|----------------------------|----------------------------------|------------|------------------------------------|---------|--------------------------|-------------------------|----------------------------------|---|--------------------------|----------------|--|----------------------|---------------|------------|--|-------------|
| | (A) Vertical Expansion (m) | | (B) Horizontal Expansion (m) | | Up-Down Speed (m/min) | In-Out Speed (m/min) | Traveling Precision Speed (%) | Max load at boom extremity (Kilos @ 12" GC. | Rotation Angle ± 180° | (C) height (m) | Packing Dimension D*E*F*0.30 (m) | (F) Rail c to c (mm) | Speed (m/min) | | | |
| | Effective | Min-Max | Effective | Min-Max | | | | | | | | | | | | |
| WM 3030 | 3.0 | 0.75~3.75 | 3.0 | 1.0~4.0 | 1.00 | 0.12 to 1.2 | ± 2% | 200 | motorized | 5.50 | 2.40*1.90*0.3 | 1600 | 1.50 | 2.75 | 5.50*1.40*0.70 | 3.00 |
| WM 4040 | 4.0 | 0.75~4.75 | 4.0 | 1.0~5.0 | 1.00 | | | 200 | | 6.50 | 2.40*1.90*0.3 | 1600 | | 2.75 | 6.50*1.50*0.80 | 4.00 |
| WM 5050 | 5.0 | 1.10~6.10 | 5.0 | 1.0~6.0 | 0.90 | | | 300 | | 7.80 | 2.40*2.10*0.3 | 1798 | | 3.35 | 7.80*1.60*0.90 | 5.00 |
| WM 6060 | 6.0 | 1.10~7.10 | 6.0 | 1.0~7.0 | 0.90 | | | 300 | | 9.00 | 2.40*2.10*0.3 | 1798 | | 3.35 | 9.80*1.70*1.00 | 6.50 |
| HD WM 7060 | 7.0 | 1.10~8.64 | 6.0 | 2.0~8.0 | 0.80 | | | 400 | | 10.35 | 3.15*3.00*0.3 | 2000 | | 6.00 | 10.80*1.70*1.3 | 12.00 |
| HD WM 8060 | 8.0 | 1.10~9.34 | 6.0 | 2.0~8.0 | 0.80 | 0.20 to 1.50 | | 400 | | 11.35 | 3.15*3.00*0.3 | 2000 | 2.00 | 6.00 | 11.80*1.70*1.3 | 14.50 |
| HD WM 9060 | 9.0 | 1.10-10.24 | 6.0 | 2.0~8.0 | 0.80 | | | 400 | | 12.25 | 3.15*3.00*0.3 | 2000 | | 6.00 | 11.80*1.70*1.3 | 17.00 |

Standard Package: 1) Welding Manipulator mounted on motorized trolley; 2) Control Box & Remote-Control Box, 3) [Operation Manual](#) with Electrical Diagram. 4) One year [Warranty](#)

[3D Model](#)

[Photos](#)

[Video # 1](#)
[Video # 2](#)

[Video](#)
[Features](#)

Features

- Engineered in Canada; made in China
- Boom expansion speed (in-out): From 0.12 to 1.20 m/min
- Boom lifting (up-down) speed: Constant
- Trolley motorized travel speed
- Column rotation angle: ± 180°
- Column rotation speed: Approx. 0.30 RPM
- Main Control Box fixed on the trolley: Control column rotation & Forward/Stop/Reverse.
- Remote Control Box with 12 m cable length. Control: Variable speed on boom in-out: Forward/Stop/Reverse. Digital display in mm/min Also control boom lifting: Up/Stop/Down
- Boom Features:
 - Standard: For Min 1.50 m ID.
 - Custom Built: Min 20" ID using WM 3030
 - Counterweight system to ensure smooth vertical travel
 - Cable organizer: Included
- Power Source Platforms: Available on the trolley. Max load capacity of 1.5 MT. Platforms can handle: Lincoln Power Waves AC/DC 1000, or DC-1500/AC-1200, or equivalent

- Gearbox's shells made of cast iron ASTM-A48-A48M or equivalent
- Open gears made of Q235 steel or equivalent
- Shafts made of ANSI 1045 or equivalent
- Motors and control box with IP 54 protection against dust and heavy rain
- Frequency driver made by [TECO Westinghouse or Delta](#)
- Stress Relieved on Column and Boom
- Shot blasted ISO 8501-SA2.5
- Welding Cables **NOT** included.

Guide Selection: 1) Determine the largest tank diameter to be fabricated, 2) Determine the largest longitudinal seam to be weld, 3) Select the WM YYXX, 4) Y = Maximum effective boom vertical expansion (up-down) in m, 5) X = Maximum effective boom horizontal expansion (in-out) in m, 6) Check if the column height of the selected WM fits below your overhead crane; otherwise, we can custom-built the column height

Safety: 1) Boom anti-fall safety device on WM 3030 and up, 2) Trolley anti-fall safety device, 3) Limit switches in all directions

Quality: 1) Engineered in Canada, 2) Intertek label SPE 1000 on main control box. Available under request, 3) [CE Mark](#) Certificate of Conformity No 181108/JIR/05; issue by Consultants Europe BV in The Netherlands

Custom Built: 1) Self-Stand Welding Manipulator (Fixed base): SS WM, 2) [WM 4040 for welding Steel Box Columns](#), 3) For TIG applications: a) WM with linear drive. b) Welding rotator with servomotors, c) Arc Length Controller, 4) [Welding Gantry](#)

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Custom Built Set up Configuration.
for Longitudinal and Circumferential (SAW)
Including Seam Tracker

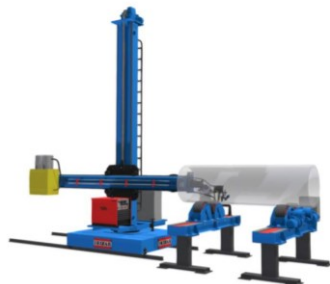


[3D Model for Single Head](#)



[3D Model for Tandem Head](#)

[Seam Tracker Video Model 100](#)



Welding Manipulator with SAW Lincoln Welding Head and Controller; Wire Reel, Seam Tracker Model 100 & Flux Recovery Model FRU-50.

Minimum ID 25" (63.5 mm) with boom effective horizontal stroke from 3 up to 6 m (10' up to 20')

[3D Model for Welding Small Diameters](#)

Note: Mounting brackets for the welding head, welding controller and wire reel are **NOT** included in our supply scope. There are many possible configurations; each user should decide the best suit for their application.

Standard Welding Manipulator:

1. [Lincoln PowerPlus 1000HD](#)
2. Welding Head Controller & Wire Feeder
3. Flux hopper & 50 lbs wire rail
4. [Manual cross slide Single Head](#)
Stroke (mm) 80 x 80.
Max load 50 kilos @ 6" GC
5. Mounting Brackets
6. [Boom Wireless Remote Control](#)
7. [Flux Recovery FRU-50](#) itself
8. Welding cable of 23 m*2 Nos of 120 mm² Ø
9. Communication and interface cables (only with Irizar Rollers)
10. WhatsApp Tech Support

Welding Cross Slide. Position welding head up/down & left/right. Also known as **Manual Welding Cross Slide, Motorized Welding Cross Slide and Powered Welding Cross Slide**

Models

1. [Motorized Single Head Cross Slide](#)
Stroke (mm) 80 x 80
Max load 50 kilos @ 12" GC
2. [Motorized Tandem Head Cross Slide](#)
3. Main Cross Slide, one unit
Max load 300 kilos @ 23" GC
Stroke (mm) 200 x 200
4. Horizontal Manual Cross Slide, one unit
200 kilos @ 12" GC
Stroke (mm) 200 with pivot

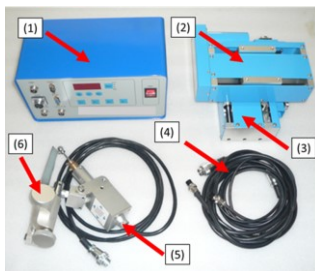
Seam Tracker. Self position welding head up/down & left/right. Also known as **Welding Seam Tracking, Weld Tracking, and Welding Seam Tracker.**

Seam Tracker Model 100

Includes:

| | |
|-------------------|---------------------------|
| Max load capacity | 100 kg @ 12" GC |
| Weight | 70 kg |
| Slide Stroke | X & Y 200 mm ea |
| Slide Speed | 170 mm/min |
| Accuracy | ± 0.25 mm |
| Welding Method | SAW |
| Motors Style | DC |
| Unit Weight | 50 kg |
| Packing (mm) | Four boxes 400*270*210 |
| Input Power | 240/60/1P |

- 1) Main control box, 2) Left/Right cross slide, 3) Up/Down cross slide, 4) Cables, 5) Finger probe, 6) brackets & Tracking probes.



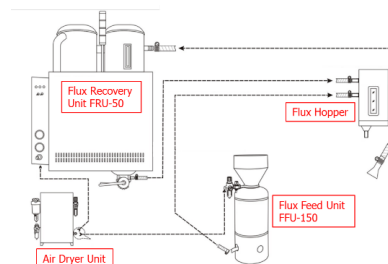
Flux Recovery System is used for recycling flux in SAW (Submerged Arc Welding) operations. It reduces operational costs for recovering and re-using flux before being contaminated with dust. It also prevents the flux from getting wet because of its heating device, avoiding welding porosity. It is also known as **Flux Vacuum, Flux Recycling System, Submerged Arc Flux Recovery and SAW Flux Recovery**



Models:

1. Flux Recovery System FRU-50, 50 kilos.
2. Flux Recovery System FRU-100, 100 kilos.
3. Flux Recovery System FRU-150, 150 kilos.

| | | |
|--------------------------------------|----------------------|----------------|
| Flux Recovery Unit Model - FRU-50 | Flux capacity | 50 kg |
| | Air pressure | 80 to 90 psi |
| | Air flow | 20 cfm |
| | Heat | 0-150°C |
| | Motor Power | 3 kW |
| | Flux recovery | 8 to 15 Kg/min |
| | Flux feeding | 2 to 20 kg/min |
| | Flux delivery | Up to 9 m |
| | Bottom flux valve | Included |
| Flux Feed Unit Model - FFU-150 | Pulse dust removal | Included |
| | Weight | 200 kg |
| | Input Power | 240/60/3 |
| | Flux capacity | 150 kg |
| | Air pressure | 80 to 90 psi |
| Air Dryer Unit | Air flow | 20 cfm |
| | Heat | 0-150°C |
| | Flux low level alarm | Included |
| | Weight | 300 kg |
| | Input Power | 240/60/3 |



Advantages FRU-150: 1. Air Dryer removes water and humidity from the air supply. 2. Heated Flux prevents porosity in welding. 3. Flux is supplied to the boom top at the ground label. 4. Flux level alarm prevents low flux.

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Automatic Girth Welder, AGW Series

Automatic Girth Welder (AGW) is a self-propelled frame with variable speed that applies efficient circumferential Submerged Arc Welding (SAW) on Field Erected Tanks (Vertical Tanks). It is compatible with Conventional Construction Method (Down-Top) and Jack up Method (Top-Down). SAW is mostly used on carbon steels, stainless steels and some nickel alloys; it improves productivity and consistently enables high-quality welds. The AGW reduces the manual welding process up to 25 times. The AGW comes with Power Source, Welding Head, Welding Controller, Flux Belt and Flux Recovery System. **Girth Welder, also known as 3 O'Clock Welder, Automatic Girth Welder, AGW Welding, Automatic Tank Welder and Soldadura Arco Sumergido**

Application

1. [Girth Welder Model AGW-1 \(Single Side\)](#)

[3D AGW-1 Traditional Method](#)

[3D AGW-1 Tank Jacking Method](#)

[3D Jacking Method Set Up](#)

[Video clip](#)

Compatible with the **Traditional Construction Method** (Bottom to Top). Apply SINGLE circumferential SAW (Submerged Arc Welding) seams **INSIDE** or **OUTSIDE** the tank. It drives hanging on the tank's upper edge.

Compatible with the **Tank Jacking Construction Method** (Top to Bottom). Apply circumferential SAW (Submerged Arc Welding) seams **ONLY** from the **OUTSIDE** of the tank. It drives on a temporary rail. Include: [Lincoln PowerPlus 1000HD](#) with Intertek certification SPE-1000; plus, welding head controllers and wire feeder. For other items read the next page. For welding circumferential seams from the **INSIDE** of the tank use a [Girth Welder Model AGW-1-C](#).

2. [Girth Welder Model AGW-1-C \(Single Side - Compact\)](#)

[3D AGW-1-C](#)

[3D Jacking Method Set Up](#)

[Video](#)

Compatible with the **Tank Jacking Construction Method** (Top to Bottom). Apply SINGLE circumferential SAW (Submerged Arc Welding) seams **ONLY** from the **OUTSIDE** of the tank. It drives on a 1/2" x 4" flat bar hanging on brackets (see sketch below). The unit can be used on LNG tanks; it fits 750 mm of space between inner and outer tanks. Include: [Lincoln PowerPlus 1000HD](#) with Intertek certification SPE-1000; plus, welding head controllers and wire feeder. For other items, read the next page.

3. [Girth Welder Model AGW-2 \(Double Side\)](#)

[3D AGW-2: Traditional Method](#)

Compatible with the **Traditional Construction Method** (Bottom to Top). Apply DOUBLE circumferential SAW (Submerged Arc Welding) seams **INSIDE and OUTSIDE** simultaneously. It drives hanging on the tank's upper edge. Include: Two [Lincoln PowerPlus 1000 HD](#) with Intertek certification SPE-1000; plus, two welding head controllers and two wire feeders. For other items, read the next page.

4. LNG AGW-1: Apply circumferential SAW seams on LNG Double Wall Tanks. The unit fits in a 1,000 mm space between the inner and outer tanks.

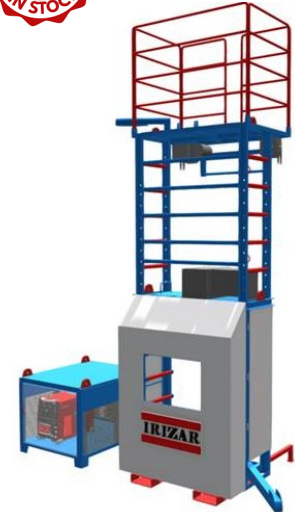
5. [Shell Buggy](#): It is a self-propelled basket. It provides quick access to vertical and horizontal welding seams without a need for scaffolding. It is helpful for install vertical up FCAW Welding Oscillator Tractor. It also provides quick access for welding inspection and repairs, installation and remove tank fittings tools. Compatible with Traditional Construction Method (Down to Top) and Tank Jacking Construction Method (Top to Down)

6. [FCAW Welding Oscillator Tractor](#): Apply Flux Cored Arc Welding on vertical welding seams up to 3,000 mm and circumferential seams on pipes diameter $\geq 1,200$ mm. It is recommended to use with [Shell Buggy](#) for quick access on vertical seams outside the tank.

7. [SAW Welding Tractor](#): It is a self-propelled Tractor. Apply SAW Butt or Fillet welds on the Tank's Floor and/or circumferential Fillet welds on Annular-Plate to Tank-Shell Bottom, both inside and outside the tank. [Magnetic Device](#), [3D Model](#) & [Video](#)



AGW-1



Product Catalog

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Specifications

| Model | AGW-1 | AGW-2 | AGW-1-C | LNG AGW-1 | Shell Buggy |
|----------------------------------|---|------------------------------------|-------------------------------------|-------------------------|---|
| Application | Traditional Method & Jacking Method | Traditional Method | Traditional Method & Jacking Method | Traditional | Traditional Method & Jacking Method |
| Type | Single Side | Double Side | Single Side | Single Side | Single Side |
| Trolley motorized speed (mm/min) | 200 to 2,900 | 200 to 2,900 | 200 to 2,900 | 200 to 2,900 | 200 to 2,900 |
| Trolley manual with clutch lever | Yes | Yes | Yes | Yes | Yes |
| Plate Height (m) | 1.50 to 3.0 | 1.50 to 3.0 | (*) Min 0.80 m | 1.50 to 3.0 | 1.50 to 3.0 |
| Tank Diameter (m) | Min 5.0 | Min 8.0 | Min 2.50 | Min 8.0 | Min 5.0 |
| Plate Thickness (mm) | 8 to 50 | 8 to 50 | 4.76 to 50 | 8 to 50 | 8 to 50 |
| Weight (kgs) | Fixture Itself | 1,360 | 208 | 580 | 380 |
| | Storage Box & Cables | 150 + 70 = 220 | 150 @ 2 + 140 = 440 | 150 + 70 = 220 | NA |
| | FlexTee 650X / DC 1000 | 75 / 372 | (75 / 372) x 2 | 372 | NA |
| | Total Weight Sum | 975 / 1,272 | 1,950 / 2,544 | 1,172 | 380 |
| Dimensions L*W*H (m) | Unit Package | 1.55 x 1.20 x 2.65 | 3.10 x 2.50 x 2.65 | 1.10 x 0.62 x 1.73 | 1.55 x 0.85 x 2.65 |
| | Power Source Storage Box | 1.30 x 1.10 x 1.30 | 1.30 x 1.10 x 1.30 @ 2 | NA | 1.30 x 1.10 x 1.30 |
| Input Power AGW | 120/240 V, 50/60 Hz, 1P | 120/240 V, 50/60 Hz, 1P | 120/240 V, 50/60 Hz, 1P | 120/240 V, 50/60 Hz, 1P | 120/240 V, 50/60 Hz, 1P |
| AGW Power (kW) | 0.19 | 0.19 | 0.19 | 0.19 | 0.19 |

Notes

1. Designed and engineered in Canada; made in China.
2. (*) AGW-1-C plate height: Minimum 0.8 m; only on the first/top shell. Storage box included.
3. The AGWs and the [Shell Buggy](#) include an arm support for lifting a maximum load of 100 kilos. Optional electric winch.
4. The Welding Procedure Specifications (WPS) and the Procedure Qualifications Records (PQR) must qualify by the user, taking into consideration the applicable Codes and Standards. It should be designed by a welding engineer who selects the essential welding parameters such as plate bevelling, wire and flux specifications, amperes and voltage, welding speed, etc. The user is responsible for certifying WPS & PQR before deploying the equipment at the job site.
5. The Welder Qualification Test (WQT) remains the user's responsibility. Irizar does not train welder operators; the Girth Welders must be operated by an experienced user operator with an update ticket.

Standard Package

| Item | Description | AGW-1 Single Side | AGW-2 Double Side | AGW-1-C Single Side Compact |
|-------|--|--------------------------------------|--------------------------------------|--|
| 1 | Electric Power Source Lincoln PowerPlus 1000HD , 480/3/60 or 380/3/50 | 1 set | 2 sets | 1 set |
| 2 | Lincoln Welding Head Controller and Irizar Wire Feeder. Includes: 1) Wire reel for 60 lbs coil, 2) One contact nozzle assembly for wire of 3/32" (2.4 mm), 1/8" (3.2 mm) and 5/32" (4 mm); 3) One contact tip 3/32" (2.4 mm). | 1 set | 2 sets | 1 set |
| 3 | Heavy-duty motorized carriage | 1 unit | 1 unit | 1 unit |
| 4 | Control Box: Forward/Stop/Reverse/Speed Adjustment with a display in mm/min. | 1 unit | 1 unit | 1 unit |
| 5 | Flux recovery & delivery system; flux belt 4" width x 40". Flux assembly 150 mm wheel's diameter. Flux capacity: 25 kg on AGW-1/AGW-2; and 20 kg on AGW-1-C | 1 set | 2 sets | 1 set |
| 6 | Manual welding head (X-Y) cross slide with 6" stroke | 1 unit | 2 units | 1 unit |
| 7 | Operator seat with toolbox | 1 unit | 2 units | N/A |
| 8 | TECO Westinghouse frequency driver | 1 unit | 1 unit | 1 unit |
| 9 | Power source and cables storage steel box | 1 unit | 2 units | 1 unit |
| 10 | Cables included: 1) Power cable 2.5 mm ² *4 wires* 60 m; 2) Control cable 1.5 mm ² *10 wires* 60 m. | 1 set | 2 sets | 1 set |
| 11 | Electric control panel | 1 unit | 1 unit | 1 unit |
| 12 | Operation Manual & Electric Diagram | 1 set | 1 set | 1 set |
| 13 | Warranty | 1 year | 1 year | 1 year |
| Notes | <ol style="list-style-type: none"> 1. Welding cables are NOT included and required: One cable of 120 mm² x 60 m for welding up to 600 amps. Two cables for welding up to 800 amps. Three cables for welding up to 1000 amps. 2. Item # 9: Power Source Storage Box keeps the power source and cables free from rain, snow, and thieves 3. Irizar AGW-1, AGW-2 & AGW-1-C are designed and fabricated to be powered by Lincoln Power Source; nevertheless, some customers have modified our brackets to fit welding heads and welding controllers made by ESAB, Miller, and other brands. | 1 set | 2 sets | 1 set |

Product Catalog



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Notes

- Item # 9: Power Source Storage Box keeps the power source and cables free from rain, snow, and thieves
- Irizar AGW-1, AGW-2 & AGW-1-C are designed and fabricated to be powered by Lincoln Power Source; nevertheless, some customers have modified our brackets to fit welding heads and welding controllers made by ESAB, Miller, and other brands.
- Optional:
 - 3-Slide Pre-heating Torch Adjustment Device: Adjustment: 1 3/8" (35 mm) left/right, 1 3/8" (up/down), 1 3/4" (44 mm) deep. Torch diameter range: 5/8" to 1 3/8". Torch angle adjustment: 90 degrees. Capacity: 10 lbs. Torch and LPG cylinder and rack are not included.
 - [3D Stand Frame](#): Required for the qualification of WPS, PQR and WQT; also, for hanging the unit when it is not in service at jobsite.
 - Conversion Kit: Split one AGW-2 into two AGW-1; or to convert one AGW-2 in two AGW-1

Features

- Control Box: a) Forward/Stop/Reverse with Digital display with variable speed, b) Flux recovery: On/Off, c) Emergency Stop
- Motors & Control Box: IP 54 protection; against dust and heavy rain
- Frequency Driver: Made by [TECO Westinghouse or Delta](#)

Quality, Safety & Liability Insurance

- Irizar AGW-Fixture: Engineered in Canada; made in China
- Assemble and Tested in Canada
- Intertek Certification label SPE-1000 on main control box. Available under request
- [CE Mark](#) Certificate of Conformity No 181108/JIR/05; issued by Consultants Europe BV Netherlands
- Safety: Meets OSHA and CAN/CSAS269.2-M87 standards

Power source and cables
Storage steel box: Included



Girth Welder Model
[3D AGW-1-C](#) & [Video](#)



AGW-1 (Traditional Method)
Circumferential Welding for Outside the Tank



AGW-2 (Traditional Method)
Circumferential Seam Inside/Outside simultaneously



AGW-1 (Compatible with Lifting Jacks)
Circumferential Welding for Outside the Tank

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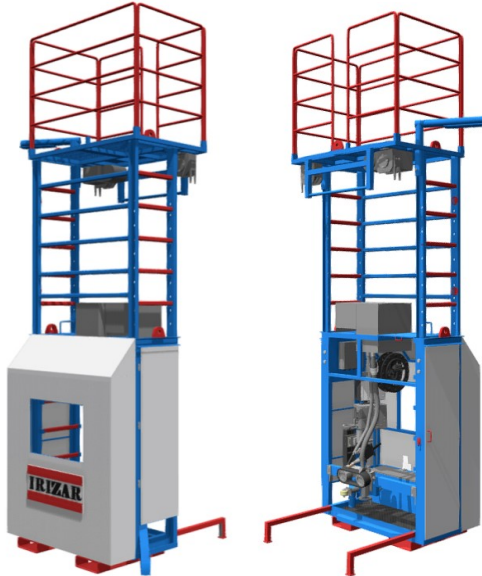
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3D AGW-1: Traditional Method driving hung on the upper edge of tank.
This machine can be used with the Traditional Construction Method (Down-Top) or Tank Jacking Method (Top-Down).

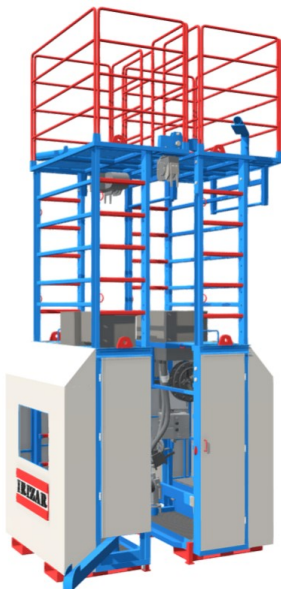


3D AGW-1 for Tank Jacking Method

This unit drives on rail outside and around the tank
3D Tank Construction



3D AGW-2: Traditional Construction Method



Shell Buggy

Motorized Shell Buggy provides quick access to vertical and horizontal welding seams on Field Erected Vertical Tanks without scaffolding. It helps install upright FCAW oscillator welding tractors made by [Irizar](http://www.irizar.com), Gullco Kat, Bug-O and ESAB. It also provides quick access for installing and removing tank fittings tools, welding inspection and repairs. Compatible with Traditional and Tank Jacking Methods. **Shell Buggy**, also know as **Platform Shell Buggy** or **Shell Work Platform Buggy**



3D Shell Buggy for Traditional Construction Method



3D Shell Buggy for Jacking Method



Video clip

Product Catalog

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FCAW Welding Oscillator Tractor

Welding Oscillator Tractor, also known as **Welding Carriage**, **Welding Automation Carriage**, **Welding Oscillator Carriage** and **Track Welding Carriage with Oscillator**.

[Video Tractor Model 3000](#)

[Video Tractor Model 150-1000](#)

Features

| Description | FCAW Welding Oscillator Tractor Model 3000 | FCAW Welding Oscillator Tractor Model 150-1000 |
|---------------------------|---|---|
| Application | Vertical welding Up 3000 mm & Circumferential on pipe diameters $\geq 1,200$ mm | Circumferential welding on pipe diameters from 150 up to 1,000 mm |
| On/Off Switch | Included | Included |
| Control box | Forward, Stop, Reverse, Variable Speed with digital display | Forward, Stop, Reverse, Variable Speed with digital display |
| Variable speed | From 100 to 1,040 mm/min | From 0 to 700 mm/minute |
| Flexible rail track | Two pcs of 1.8 m each | 3.7 m of rail included |
| Magnets | Twelve pieces | NA |
| Power Supply | 110 AC, 50/60 Hz. 1P | 110 AC, 50/60 Hz. 1P |
| Gun clamping torch holder | Included | Included |
| Torch adjustment | | |
| Up/Down | ± 50 mm | ± 60 mm |
| Left/Right | ± 100 mm | ± 85 mm |
| Angle | $\pm 45^\circ$ | $\pm 45^\circ$ |
| Oscillation adjustment | | |
| Left/Right (stroke) | ± 17 mm | ± 15 mm |
| Angle | $\pm 10^\circ$ | $\pm 10^\circ$ |
| Pattern Selection |  |  |
| Knob Mode | | |
| Dimensions and Weight | | |
| Tractor (L x W x H) mm | 580 x 250 x 345 @ 11 kgs | 410 x 360 x 430 @ 22 kgs |
| Tracks (L x W x H) mm | 1600 x 50 x 50 @ 8 kgs | 540 x 420 x 140 @ 5 kgs |
| Magnets (L x W x H) mm | 500 x 200 x 200 @ 25 kgs | NA |
| Total Weight | 44 kgs | 27 kgs |

Tractors Welding Control



FCAW Vertical Seams with Tractor Model 3000

The tractor is recommended to apply vertical welding seams on API tanks. It can be used in combo with [Shell Buggy](#). It provides quick access for welding, repair and inspection of vertical seams without scaffolding.



FCAW Welding Tractor Model 3000

For Vertical Seams on API Tanks up to 3,000 mm

For Circumferential Seams on pipe diameters $\geq 1,200$ mm



FCAW Welding Tractor Model 150-1000

For Circumferential Seams on pipe diameters from 150 up to 1,000 mm

On pipe diameters from 150 to 600 mm with Tractor Magnet

On pipe diameters from 600 up to 1,000 mm on rail truck



Full-Set ready to work.

1. **Oscillator Tractor Model 3000 or Model 150-1000**
2. [Lincoln PowerPlus II 650](#): Rated Output: 500 A/39 V @ 100%
3. Wire Feeder: Speed: 1.5-22 m/min, four drive rolls, wire size on solid wire (0.8-1.6 mm) & flux core wire (1.6 to 2.0), wire spool of 20 kg
4. Wire feed roller 1.2-1.6 mm x 2 pcs
5. Welding torch long neck with 5 m cable length
6. Welding earth cable 70 mm², 30 m
7. Control cable, 40 m
8. Remote Voltage Control, 15 m length

Optional: Consumables

1. Contact Tips
2. Drive Rolls Kit
3. Welding Torch Spare
4. Wire Feeder Spare

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SAW Welding Tractor

SAW Welding Tractor is a self-propelled Tractor with Electric Flux Recovery System and Magnetic Device. The Tractor applies Submerged Arc Welding, more commonly abbreviated to SAW or Sub Arc Welding. SAW is mostly used on carbon steels, stainless steels and some nickel alloys; it improves productivity and consistently enables high-quality welds. **SAW Welding Tractor**, also known as **Submerged Arc Welding Tractor**, **SAW Tractor**, **LT-7 Tractor**, **LT-7 Submerged Arc Welding Tractor**, and **Lincoln LT-7 Tractor**

Applications:

1. Apply SAW Butt or Fillet welds on API Tank's Floors
2. Apply SAW circumferential Fillet welds on Annular-Plate vs API Tank-Shell Bottom
3. Apply circumferential SAW Butt weld on Tanks or Pressure Vessels while the tank rotates in the opposite direction then Tank Welding Rotators.



Scope:

1. Irizar SAW Welding Tractor
2. [Lincoln PowerPlus 1000HD](#)
3. Welding Control
4. Welding Head
5. Electric Flux Recovery System
6. Magnetic Device



[Video](#)

Welding Tractor, Specs:

- Tractor variable speed: From 0.20 to 2.20 m/minute
- Controls: ON/OFF, FWD/REV & speed potentiometer
- Cross slide: 100 mm (up/down) x 100 mm (left/right)
- Vertical head lifting adjustment: 70 mm
- Head rotation: $\pm 90^\circ$
- Head inclination: $\pm 45^\circ$
- Torch inclination: $\pm 45^\circ$
- Wire reel for 60 lbs coil. ID: 300 mm x 5" width
- Guide Rail: 1 m/each x 3 units
- Control Cable 14 Pins, male/female w/quick connectors: 30 m

- Consumables:
 - Contact Tips, one each: 1.6, 2.0, 2.4, 4.0 & 5.0 mm
 - Nozzles, one each: Nozzle Assembly & 10 mm Nozzle Extender.
- Electric Input Power: 110 V, 50/60 Hz, 1P
- Packing (mm): 480 (L) x 740 (W) x 1008 (H) @ 55 kgs

Note: Welding cable(s) **NOT** included. Required: 30 m of welding cable 120 mm² x 1 wire; rated up to 600 amps. Two cables required for 800 amps. Three cables required for 1000 amps

Electric Flux Recovery System, Specs:

- Flux hopper with 4 liters capacity & heater
- Electric Input Power: 110 V, 50/60 Hz, 1P
- Packing (mm): 260 (L) x 220 (W) x 550 (H) @ 6.20 kgs

Magnetic Device, Specs:

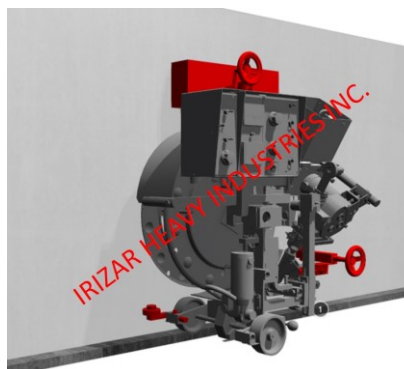
This device is required to apply circumferential **Fillet welds on Annular-Plate vs Tank-Shell Bottom**. The magnetic device upholds vertical SAW Welding Tractor while one wheel is floating, and it runs fastened by magnets to the Tank-Shell, either inside or outside the tank.

Features

- Minimum Tank OD: 9 m
- Outside annular-plate: Min 50.8 mm (2")
- Device can roll over vertical tank welding seams with a maximum crown of 3 mm (1/8")
- Packing (m): 0.60 (L) x 0.40 (W) x 0.28 (H) @ 17 kg

[Video](#)

[3D Model](#)



Product Catalog

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Tank Lifting Jacks

Tank Jacking, also known as Tank Erection, Hydraulic Tank Jacks



Constanta Romania
LNG Tank, 76 m diameter, 490,000 barrels

Applications

I) 3D Tank-Construction

1. API 650 Welded Tanks for Oil Storage
2. API 620 Welded Low-Pressure LNG Double Wall Storage Tanks
3. API 653 Tank Repair and Maintenance
4. UL STD 142 Tanks for Flammable and Combustible Liquids
5. ANSI/AWWA D100 Water Welded Tanks
6. ANSI/AWWAD D103 Water Bolted Tanks
7. Grain Bin & Corrugated Bolted Tanks

II) Modifications & Alterations

1. Dismantling & Removal
2. Tank Floor & Bottom Shell Replacement
3. Tank Capacity Expansion

Industry Segments: Oil refineries, petrochemical plants, fertilizer plants, power generating stations, petroleum product installations & depots, and liquid storage terminals ports.

Experience: Irizar lifting jacks have been used worldwide for the construction of over five thousand field erected tanks. The maximum tank lifted until now is 2,650 MT.

Standard Package:

1. Jacks with Trestles
2. Power Pack
3. [Operation Manual](#) and Electrical Diagram
4. One year [Warranty](#)

Features

1. Engineered in Canada: Jacks are assembled, tested, and shipped from our shop in Wetaskiwin Alberta Canada.
2. Constructing Procedure: Tank erection is made from top course downwards; opposite, to the traditional construction method.
3. Erection Safe: Tank is lifted hydraulically and holds mechanically. It means, the tank does not slide down, even in the case of power pack failure/removal, electrical power shutdown or hydraulic hose burst.
4. Flexible: Tank jacking equipment can be split for erection of small tanks; or expanded, by adding extra jacks.
5. Cost- Effectiveness: a) Large cranes are no longer required; roof is built over the first ring at floor level. Our system saves thousands of dollars in crane rental. b) Tank shell plates are fed at floor level; therefore, scaffolding is minimized
6. Productivity Increase: Personal at jobsite works from inside the tank; under roof cover at a maximum height of 6.50 m. Personal working from outside the tank, do their job at a maximum height of 3.50 m. Therefore, construction process increase productivity in all the steps, from assembling, tack welding, circumferential and longitudinal welding, inspection, and repairs.

Tank Lifting Jacks Specifications

| Concept | Jack Model | 12 MT-3000 3D & Video | 25 MT-3000 3D & Video |
|--|------------|--|--|
| | | Bolted / Welded Tanks | Welded Tanks |
| Application | | Bolted / Welded Tanks | Welded Tanks |
| Working capacity (metric tons) | | 12 | 25 |
| Double action jack | | Yes | Yes |
| Minimum OD tank (m) | | 5.00 | 5.00 |
| Minimum shell thickness (mm) | | 3.175 (1/8") | 3.175 (1/8") |
| Min (°1) - Max shell height (m) | | 1.60 to 3.0 | 1.60 to 3.0 |
| Min - Max (°2) arc-dis between jacks (m) | | 1.50 to 3.0 | 1.5 to 3.0 |
| Jack unitary climb (mm/stroke) | | 100 | 100 |
| Lifting time/stroke (minute) | | 0.45 to 1.55 | 0.63 to 0.71 |
| Jack weight (kg) | | 60 | 90 |
| Accessories weight (kg) | | 260 | 430 |
| Packing weight (kg) | | 40 | 50 |
| Total weight (kg) | | 360 | 570 |

Power Pack Specifications

| Description | Tank Capacity (Liters) | Pump Flow (LPM) | Working Pressure (PSI) | Weight (Kilos) |
|--|------------------------|-----------------|------------------------|----------------|
| Power Pack for Jack 12 | | | | |
| 10 HP, Max 34 jacks | 350 | 22 | 1,750 | 350 |
| 20 HP, Max 65 jacks | 350 | 45 | 2,500 | 445 |
| 40 HP, Max 115 jacks | 500 | 96 | 2,500 | 575 |
| 60 HP, Max 150 jacks | 800 | 96 | 3,000 | 700 |
| Power Pack for Jack 25 | | | | |
| 40 HP, Max 38 jacks | 500 | 96 | 2,500 | 575 |
| 60 HP, Max 150 jacks | 800 | 96 | 3,000 | 700 |



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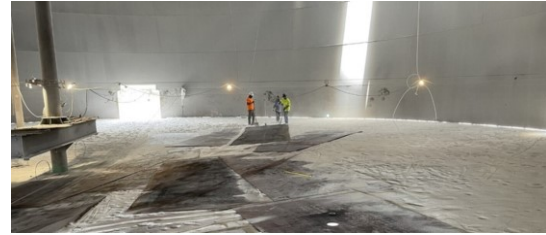


Tank Floor Replacement Jacks

Tank Floor Replacement, also known as **Tank Bottom Plate Replacement, Tank Annular Plate Replacement, Tank Foundation Remove, Tank Foundation Restoration, Tank Repair & Maintenance**

Standard Package:

- Single Action Jack with lock-nut**
Model 40 MT - 150
Stroke: 150 mm
Jacks' maximum working capacity: 40 MT
- 7.50 HP Power Pack, Max 70 jacks**
Tank capacity: 200 litres
Pump flow: 5 to 10 LPM
Working pressure: 9,000 PSI
Input Power: 380/480 V, 50/60 Hz, 3 P
- Include:**
 - Hydraulic hose 7.0 m length with male fittings in both ends
 - Quick couplers
 - Operation Manual and Electrical Diagram
 - One year [Warranty](#)
- Not Included:** L-Shape Lifting Bracket & Footing Steel Plate
- Optional:** Power Pack Oil Heater. Required for working below sub-zero Celsius degrees



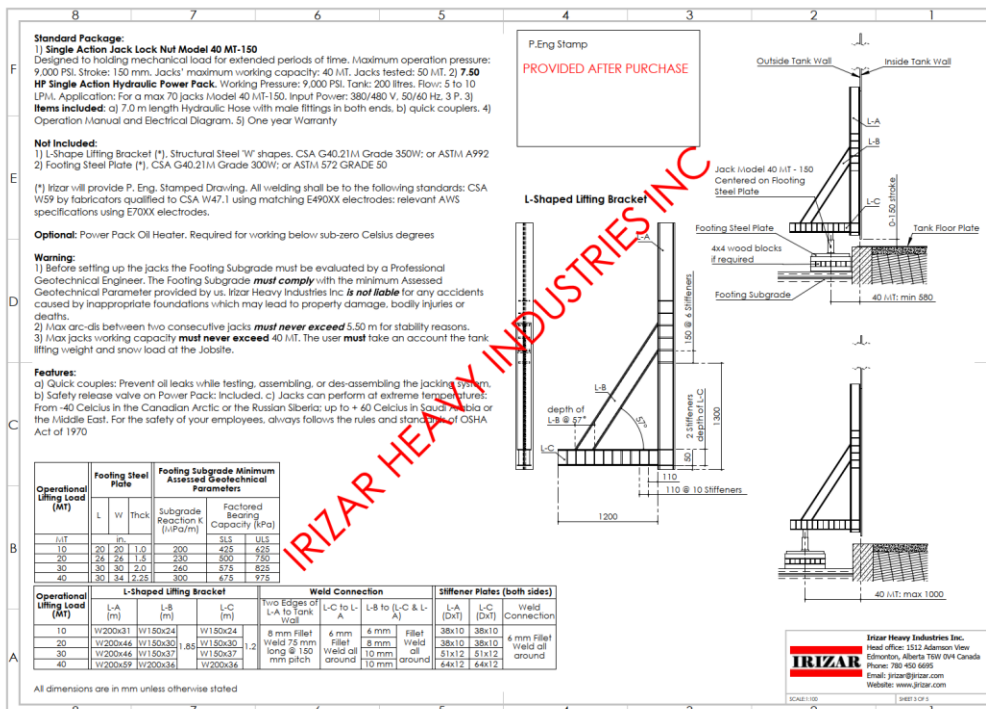
Facts:

- Jacks have a Safety Lock Nut for mechanical load holding.
- The Jacks are installed outside to avoid expensive foundation work.
- Reparation work is performed without obstructions inside the tank.

Features: a) Quick couples: Prevent oil leaks while testing, assembling, or dis-assembling the jacking system, b) Safety release valve included on Power Pack, c) Jacks perform at extreme temperatures: From -40°C in the Canadian Arctic or the Russian Siberia; or, up to + 60°C in Saudi Arabia or the Middle East, d) For the safety of your employees, always follows the rules and standards of [OSHA Act of 1970](#)

Warning:

- Before setting up the jacks the Footing Subgrade must be evaluated by a Professional Geotechnical Engineer. The Footing Subgrade **must comply** with the minimum Assessed Geotechnical Parameter provided by us. Take into consideration local or federal foundation regulations.
- Irizar Heavy Industries Inc **is not liable** for any accidents caused by inappropriate foundations which may lead to property damage, bodily injuries or deaths.
- Max arc-dis between two consecutive jacks **must never exceed** 5.50 m for stability reasons.
- Max jacks working capacity **must never exceed** 40 MT. The user **must** take an account the tank lifting weight and snow load at the Jobsite.



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