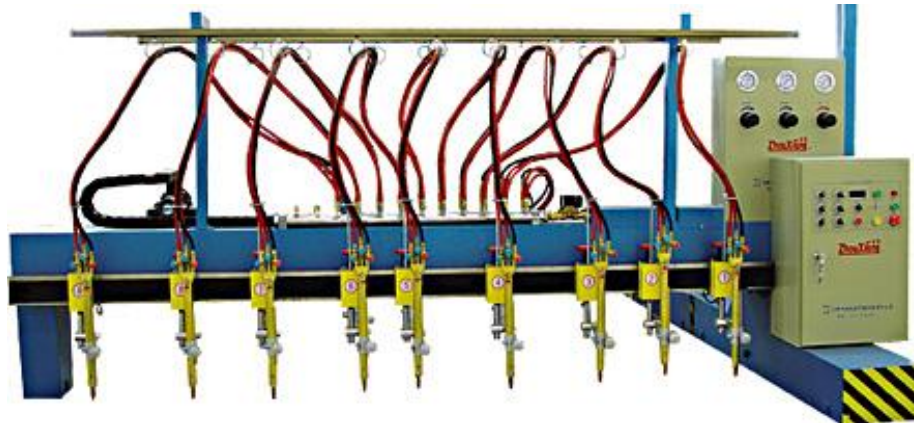


# H-BEAM STRUCTURE MANUFACTURING PROCESS

## 1. Phase I

### P Multi-head Strip Cutting Machine



Gauge	4000mm	3000mm
Width of cutting	80-3300mm	80-2300mm
Length of gauge	15000mm	
Effective stroke	12500mm	
Cutting speed	0.1-1m/min	
Transverse Cutting gun	one set	
Longitudinal Cutting gun	9 sets, deployed according to the need	
Overall power	0.4kw	

The vertical combined machine which the flange plate, web plate, fastening and calibrating, positioning, and auto spot welding equipped, all of which accept the Japanese Mitsubishi programmable controller and the AC frequency converter so as to increase the productivity one times above comparing with common products, with the features of stable and reliable working state and the welding gun is equipped by the arc-tracing device to ensure the quality of spot welding.



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## 2. Phase II

### **P** Verical Combined Machine For H-type steel PRODUCTS



Size of the web	Height	200-1500mm
	Thickness	6-32mm
	Length	4000-15000mm
Size of the flange	Width	200-800mm
	Thickness	6-40mm
	Length	4000-15000mm
Assembling speed	0.5-6m/min	
Power Overall	Two welding machines are excluded	

The vertical combined machine which the flange plate, web plate, fastening and calibrating, positioning, and auto spot welding equipped, all of which accept the Japanese Mitsubishi programmable controller and the AC frequency converter so as to increase the productivity one times above comparing with common products, with the features of stable and reliable working state and the welding gun is equipped by the arc-tracing device to ensure the quality of spot welding.



### 3. Phase III

## P COMLUMN-BEAM WELDING MACHINE

PRODUCTS



XBH type column-beam welding machine adopted the imported AC transducer. The equipment is stable and reliable is operation, and has the quick move-back function. The tracking arc-guide mechanism is three-spindle tracking system to guarantee the alignment and not bias arc on the weld. The main frame and the welding machine are performed integrated interlocking and the equipment is provided with flux auto-recovering system and it is easy controlled, and highly efficient.

型号Type	XBH
腹板高度 Height of web (mm)	200-2000mm
翼板宽度 Width of flange(mm)	200-800mm
H型钢长度 Longth of H-beam	4000-15000mm
焊机型号 Welding machines	MZ-1-1000型自动埋弧焊机1台 MZ-1-1000Auto-submerged two sets of model MZ-1-1000 auto union melt welder
焊接形式 Welding mode	船型焊 Ship-welding
焊接速度 Welding velocity	0.15-2.5m/min
返程速度 Reverse velocity	4.5m/min
轨 距 Track distance	1150mm
气源压力 Pressure from the gas source	0.2-0.8Mpa
整机功率 Power of the assembling machine	2.2kw(不含焊机Welding machine is excluded)



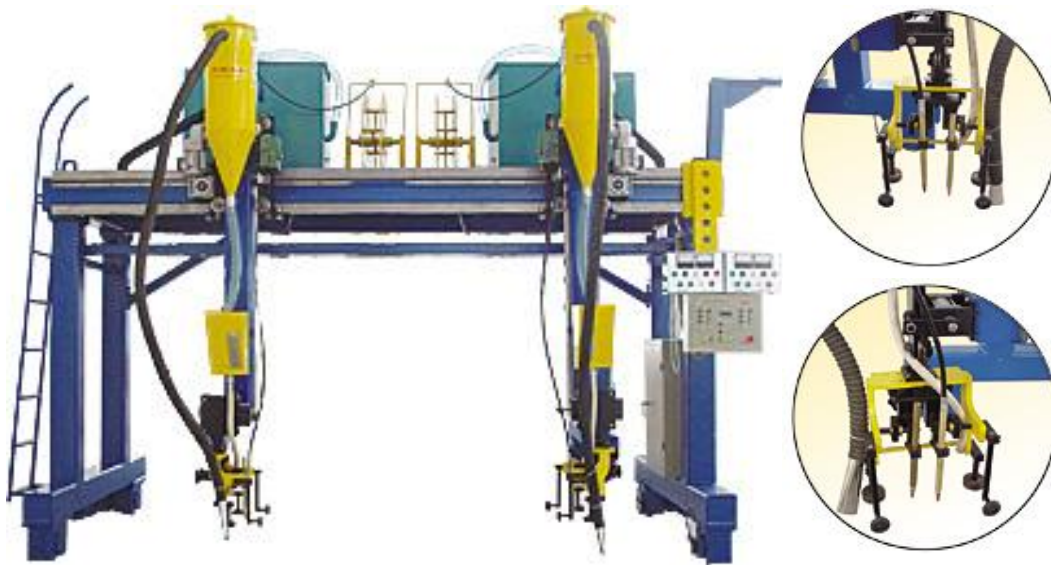
#### 4. Phase IV

### **P** Gantry Auto-Welding Machine PRODUCTS

Height of web plate	200-1200mm
width of flange plate	200-800mm
Model of welder	two sets of model MZ-I-1000 auto union melt welder
Form of welding	boat-type welding
Welding speed	0.15-1.0m / min
Retuning speed	3m / min
Gauge	4000mm
Gas pressure	0.2-0.8
Overall Power	10 KW (excluding the welder )



The auto-welding machine for H-type steel accepts the AC frequency conversion speed-changing mechanism with the merits of stable and reliable running and quick stroke returning. It use the arc-auto tracing & calibrating mechanism to ensure the welding gun being auto operating and calibrating correctively to the target working piece. Meanwhile, it is equipped by the auto welding flux delivering and collecting system, easy operating with high effectiveness.



It is the welding supplementary machine for special use that design for bix-beam welding(flat angle welding seam).The machines use gantry style main structure, driving in double-sides, controlled the speed sleeplessly by converter; Tracing of welding seam uses the type of mechanic guiding roller; The up-down and right-left operation is controlled by pneumatic technology; In order to improve the efficiency of big fillet welding, it is equipped with big electric current and double machine head(single welding seam)to process double arcs and double wires weddings, installation of the machine head is separated from arc-guiding mechanism; The device which is used to protect solder, avoiding too much solder drop down; lay-up of work piece can use fixed frame and it can also be transmitted by roller, so it can from an assembly line with other sets of machines



## 5. Phase V

### **P** H-TYPE STEEL FLANGE STRAIGHTENING MACHINE PRODUCTS

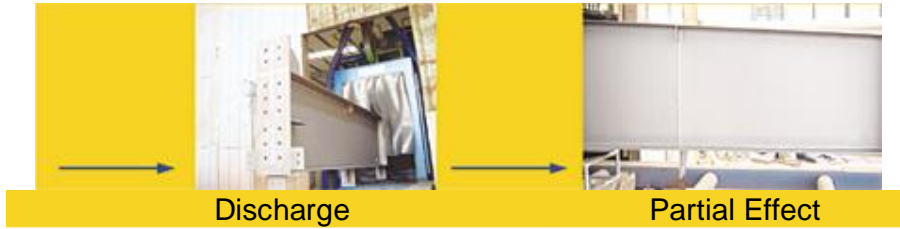
Model	JZJ-600	JZJ-800
width of flange plate	150-600	200-800
Thickness of Flange Plate	=20mm	=40mm
Min height of web plate	160mm	350mm
Material	Q235A	Q235A
Speed of leveling	8.5m/min	18m/min
Power of over all machine	7kw	25kw

This machine is special equipment for leveling the H-type steel flange plates which its figure was deformed when it being welded. It has the feature of easy operating, high efficiency, reliable working etc.



**6. Phase VI**

**P H-TYPE SHOT-BLASTING AND CLEANING MACHINE**  
PRODUCTS



H-beam shot-blasting and cleaning machine with HGP continuous rolling series is researched and developed in accordance with the features of the steel structure. The machine is adopted with computer 3-dimension dynamic simulating design to locate the position of the shot-blasting machine. The machine is equipped with a highly efficient filter-barrel pulse back-blowing dust.



FILTER CYLINDER DUST REMOVAL



## 7. Phase VII

### P OVERTURNING AND CONVEYING OF WORKPIECE PRODUCTS



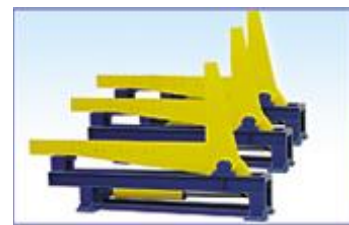
In order to improve manipulating and conveying efficiency and to reduce the usage frequency of moving the machine, we provide the chain manipulator, the conveyer for steel, overturning support to realize automatic conveying and manipulating for the whole welding and straightening course.



60°overturning machine



conveying machine



90°overturning machine



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