

Narrow-Gap-Welding System MIG “NG”



The **Narrow-Gap Welding System “NG”** is typically designed to fit on torch SB400W/500W or identical. It is designed for groove depths 60mm up to 150mm. Special lengths as well as systems for other brands or types of torches are possible at any time. Equipped with a Protection Cap made out of high quality Ceramic which is current insulating, extremely heat- and thermal shock resistant with excellent spatter repelling properties. Because of the “slim” design of the Gas Nozzle the work-piece accessibility is excellent. Besides the Gas Nozzle is coated with a spatter repelling coating.

Improved view of welding seam

Improved root welding and root quality. A far smaller chamfer angle of <math><60^\circ</math> can be used.

Therefore a smaller cross-section of weld seam results in a lower consumption of filler material and of course less labor.

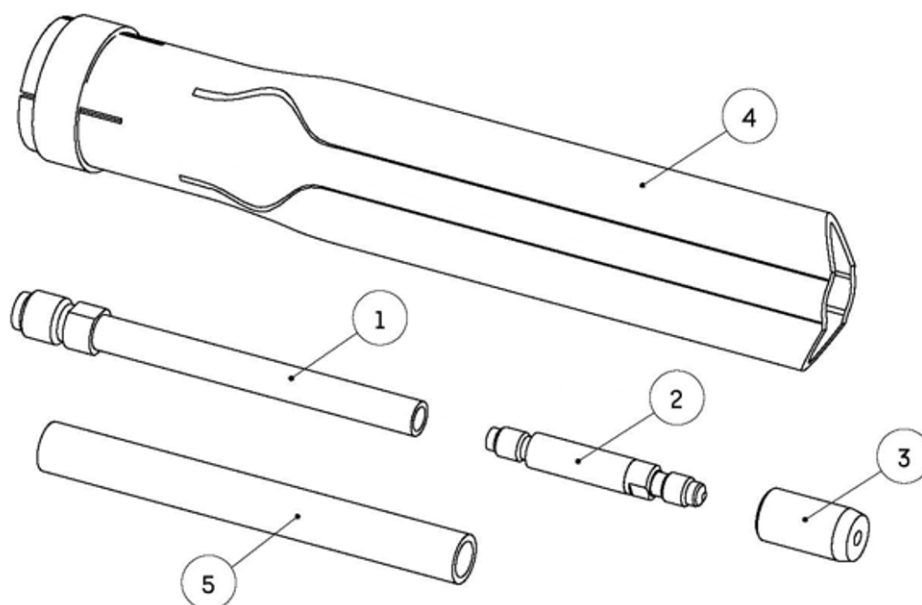
Significant reduction of harmful spatter because of the coating and the Boron Nitride Ceramic Obviates the need for expensive and toxic anti stick sprays and pastes

Short circuits while welding narrow gaps are reduced to zero



Wire Diameter mm	Wire Feeding Speed m/min	Voltage V	Current A
1.2 8.0...8.5		26.0...27.0	260...280
1.0 10.5...11.0		25.0...26.0	220...230
1.0 (gas-cooled torch)	6.0	19	160

Narrow-Gap-Welding System MIG "NG"



	MZ-NG.61060012	Narrow-Gap-Weld.-System "NG" MIG cpl.60 mm . 1.2 mm tip
	MZ-NG.61090012	Narrow-Gap-Weld.-System "NG" MIG cpl.90 mm . 1.2 mm tip
	MZ-NG.61120012	Narrow-Gap-Weld.-System "NG" MIG cpl.120 mm . 1.2 mm tip
	MZ-NG.61150012	Narrow-Gap-Weld.-System "NG" MIG cpl.150 mm . 1.2 mm tip
2	MZ-NG.610010	Contact Tip \varnothing 1.0 mm
2	MZ-NG.610012	Contact Tip \varnothing 1.2 mm
2	MZ-NG.610016	Contact Tip \varnothing 1.6 mm
3	MZ-NG.600801	Protection Cap "NG" MIG
4	MZ-NG.600605	Narrow-Gap-Gas-Nozzle "NG" 60 mm
1	MZ-NG.610608	Contact Tube 60 mm
4	MZ-NG.600905	Narrow-Gap-Gas-Nozzle "NG" 90 mm
1	MZ-NG.610908	Contact Tube 90 mm
4	MZ-NG.601205	Narrow-Gap-Gas-Nozzle "NG" 120 mm
1	MZ-NG.611208	Contact Tube 120 mm
4	MZ-NG.601505	Narrow-Gap-Gas-Nozzle "NG" 150 mm
1	MZ-NG.611508	Contact Tube 150 mm
5	MZ-NG.610060	Conduit "NG" MAG 60
5	MZ-NG.610090	Conduit "NG" MAG 90
5	MZ-NG.610120	Conduit "NG" MAG 120
5	MZ-NG.610150	Conduit "NG" MAG 150

MIG Narrow-Gap-Welding-Systems „NG“ are available in different designs for almost any application. Standard-Systems are for SB 400W/500W in standard welding joint depths from 60 mm to 150 mm. Special lengths are possible.

Position 1 and 2 are uncoated, so the conduit (position 5) has to be put on for isolation.