

## **金属丝网机械 wire mesh machine**

### **◆ 护栏网焊机 Fencing mesh welding machine**

### **◆ 轻型卷网焊机 Welded wire mesh machine**

### **◆ 钢格板焊接设备 Steel grating welding machine**

#### **3-5mm 护栏网焊机**

#### **设备描述**

该电焊机采用电力电子同步技术，分控焊接与焊接时间均由数字化电路控制，控制精度高，性能稳定，焊点牢固，无烧痕。径丝和纬丝需经过校直机校直切断后放入落料机构中，该机构采用步进电机控制，从料斗自动取料，落料均匀准确，经丝从旋风中拉出，网片边缘整齐，无须裁边。拉网采用了弹性拉杆与网格定位装置，使网格微调容易，网格尺寸精度高，焊接可在规定范围内任意调整。该机焊接速度快，只需两人即可完成操作，简单易学。

我们的电焊机具有以下主要优势：

1. 主机框架焊接较厚的钢板和钢条，主要结构更坚固。
2. 横径送料料斗由步进电机自动送料，使得横径间距更加准确。
3. 拖网机构是由步进电机，保证横径间距的准确性。
4. 该网孔大小是多样化的，该生产线线间距可以通过调整相关零部件：横径间距调整由微电脑控制，可以有 10 种不同的尺寸。
5. 焊接采用最新高效焊接变压器。电压调节范围大，分为八个不同的等级，这样可以扩大线径的调节范围。
6. 为了更好地适应客户的主电源变压器容量和减少电流使用，电气和电子焊接控制采用分离控制高峰电力输入，即，焊接变压器不在同一时间工作，但在分次焊接时焊点在同一行。
7. 电气和电子焊接控制系统采用同步控制技术。焊接控制焊接时间和分离是由数字集成电路，它具有高控制精度和稳定的功能。

本机可用于生产的公路护栏，铁路护栏，山林护栏，护栏网和对建筑屋顶用网。

#### **3-5mm Fencing mesh welding machine**

Introduction of welded mesh fence machine:

Welded wire mesh machine is a kind of auto welding equipment designed and manufactured by ourselves based on absorbing the advanced electronic mechanical controlled resistance welding technology from home and abroad, of which the technologies have won the national patents. The welded wire mesh machine adopts electronic synchronization technology and the controlling welding and welding time are controlled by digital circuit with high control precision, stable performance, strong joints, and no burn marks etc. The mechanism uses step motor control, and obtains the material from the hopper automatically. The feeding mechanism is uniform and accurate, and the warp is pulled out from the cyclone, which made the mesh with regular edges, without cutting edge. Metal lath adopts the elastic rod with grid positioning device, so that the grid trimming is easy, and the mesh size is accurate. The welding can be adjusted in an approved scope and its fast speed made it being operated by just two persons, easy to learn.

Our welded wire mesh machine has the following major advantage:

1. Main machine frame is welded with the thicker steel panel and steel bar. The main structure is more well-set and compact.
2. The cross wire feeding is automatic and driven by step motor, which makes the cross wire aligning more accurate.
3. The mesh pulling system is controlled by step motor, which makes the pulling mesh aperture more standard and accurate.
4. The mesh aperture size welded is diversified. The line wire spacing can be adjusted through the related parts. The cross wire spacing adjusting is controlled by microcomputer and it can have 10 different styles.
5. Welding adopts late-model efficient welding transformer. The voltage adjusting range is big and it can fall into eight different grades, which enlarge the range of wire diameter size.
6. In order to adapt the capacity of the clients' main power transformer and reduce the rush of the current, electric and electronic welding control adopt the separating control electricity input, i.e., the welding transformers don't work at the same time but



in several times when welding the same row of cross wires.

7. Electric and electronic welding control system adopts synchronous control technology. The welding time and separating control welding is composed of numeric integrated circuit, which is with high control precision and stable function.

The machine can be used to produce the mesh for guard rail of road, railway, hills, fencing, mesh for casting of building roofs, etc.

### 3-5mm 护栏网焊机技术参数 (technical parameters)

型号 (model)	ABE-3/5-1500	ABE-3/5-2000	ABE-3/5-2500
网幅宽度 (mesh width)	1500mm	2000mm	2500mm
纵径间距 (line wire spacing)	50-100mm	50-100mm	50-100mm
焊点 Numbers of welding points	30	40	50
变压器(transformer)	4*125KVA	5*125KVA	6*125KVA
横径间距 Cross wire spacing	50-200mm		
丝径(wire diameter)	3-5mm		
焊接能力 Max welding capacity	5.0+5.0mm with standard quality		

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最大焊接速度 Max welding speed	30-40 次/分 (30-40 cross wires per min)
出料方式 Mesh pulling way	数控 (numerical control)
线缆(cable)	根截面积 95 平方毫米的铜线缆, 或者截面面积为 120 平方毫米的的铝电线 缆, 机器之间和电源变压器的距离应小于 30m 3pcs of copper cable with cross section area of 95mm or aluminium cable with cross section area of 120mm,the distance between the machine and the power transformer should be less than 30m.
焊接方式 Welding way	电阻焊由可控硅控制 (以下称 SCR) Resistance welding controlled by silicon-controlled rectifier(hereinafter called SCR)
焊接电压 Welding voltage	电压调节范围大, 分为八个不同等级 Adjustable in eight different grades through welding transformer
加压方式 Pressurizing way	通过加压拉杆和弹簧压缩的上电极 By changing the length of tie rod in pressurizing beam and the compress of the upper electrode spring
横径送料方式 Cross wire feeding way	横径从料斗中由伺服电机一根一根的送入 The cross wire fall off the feeding hopper into welding automatically one by one driven by step motor.

### 轻型卷网焊机设备描述 Description of the machine:

该电焊机采用电力电子同步技术, 分控焊接与焊接时间均由数字化电路控制, 控制精度高, 性能稳定, 焊点牢固, 无烧痕。径丝是从放线架上开卷下来, 径矫直辊矫直送入焊机, 纬丝需经过校直机校直切断后放入落料机构中, 该机构采用步进电机控制, 从料斗自动取料, 落料均匀准确, 经丝从旋风中拉出, 网片边缘整齐, 无须裁边。产品可成卷, 亦可出片。

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regular edges, without cutting edge. This product can be made in roll or pieces.

我们的电焊机具有以下主要优势:

Our welded wire mesh machine has the following major advantage:

1. 主机框架焊接较厚的钢板和钢条，主要结构更坚固。
2. 横径送料料斗由步进电机自动送料，使得横径间距更加准确。
3. 拖网机构是由步进电机，保证横径间距的准确性。
4. 该网孔大小是多样化的，该生产线线间距可以通过调整相关零部件：横径间距调整由微电脑控制，可以有 10 种不同的尺寸。
5. 焊接采用最新高效焊接变压器。电压调节范围大，分为八个不同的等级，这样可以扩大线径的调节范围。
6. 为了更好地适应客户的主电源变压器容量和减少电流使用，电气和电子焊接控制采用分离控制高峰电力输入，即，焊接变压器不在同一时间工作，但在分次焊接时焊点在同一行。
7. 电气和电子焊接控制系统采用同步控制技术。焊接控制焊接时间和分离是由数字集成电路，它具有高控制精度和稳定的功能。

本机可用于生产的公路护栏，铁路护栏，山林护栏，护栏网和对建筑屋顶用网。

1. Main machine frame is welded with the thicker steel panel and steel bar. The main structure is more well-set and compact.
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3. The mesh pulling system is controlled by step motor, which makes the pulling mesh aperture more standard and accurate.
4. The mesh aperture size welded is diversified. The line wire spacing can be adjusted through the related parts. The cross wire spacing adjusting is controlled by microcomputer and it can have 10 different styles.
5. Welding adopts late-model efficient welding transformer. The voltage adjusting range is big and it can fall into eight different grades, which enlarge the range of wire diameter size.
6. In order to adapt the capacity of the clients' main power transformer and reduce the rush of the current, electric and electronic welding control adopt the separating

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control electricity input, i.e., the welding transformers don't work at the same time but in several times when welding the same row of cross wires.

7. Electric and electronic welding control system adopts synchronous control technology. The welding time and separating control welding is composed of numeric integrated circuit, which is with high control precision and stable function.

The machine can be used to produce the mesh for guard rail of road, railway, hills, fencing, mesh for casting of building roofs, etc.

轻型卷网焊机的主要技术参数： Main parameters

型号 (model)	ABE-3/5-1500	ABE-3/5-2000	ABE-3/5-2500
网幅宽度 (mesh width)	1500mm	2000mm	2500mm
纵径间距 (line wire spacing)	50-100mm	50-100mm	50-100mm
焊 点 Numbers of welding points	30	40	48
变压器(transformer)	4*75KVA	5*75KVA	6*75KVA
横径间距 Cross wire spacing	50-200mm		
丝径(wire diameter)	3-5mm		
焊接能力 Max welding capacity	5.0+5.0mm with standard quality		
最大焊接速度 Max welding speed	30-40 次/分 (30-40 cross wires per min)		
出料方式 Mesh pulling way	数控 (numerical control)		
线缆(cable)	根截面积 95 平方毫米的铜线缆, 或者截面面积为 120 平方毫米的铝电 缆, 机器之间和电源变压器的距离应小于 30m 3pcs of copper cable with cross section area of 95mm or aluminium cable with cross section area of 120mm,the distance between the machine and the power transformer should be less than 30m.		
焊接方式 Welding way	电阻焊由可控硅控制 (以下称 SCR) Resistance welding controlled by silicon-controlled rectifier(hereinafter called SCR)		

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焊接电压 Welding voltage	电压调节范围大，分为八个不同等级 Adjustable in eight different grades through welding transformer
加压方式 Pressurizing way	通过加压拉杆和弹簧压缩的上电极 By changing the length of tie rod in pressurizing beam and the compress of the upper electrode spring
横径送料方式 Cross wire feeding way	横径从料斗中由伺服电机一根一根的送入 The cross wire fall off the feeding hopper into welding automatically one by one driven by step motor.

### **ABE-GYH-1000-8 钢格板焊接设备描述:**

钢格板焊接生产线是完成扁钢与圆钢（或扭绞方钢）纵横交叉焊接成型的自动生产线，广泛应用于石油、化工、电力、码头、市政、环保、国防等行业的平台、吊顶、围栅、走道等。该焊机采用电力电子同步控制技术，焊接时间与分控焊接均由数字集成化电路组成，控制精度高，性能稳定，焊接牢固。传动机构使用进口气动元件，具有焊接压力均匀，故障率低，使用寿命长等特点。

### **Introduction of semi-auto Steel grating welding line:**

Steel grating electric welding machine is to weld the steel strip and round wire (twisted square steel) crossed together, the steel grating plate is widely applied as platform, ceiling, fence, walkway, etc, in the field of petroleum, chemical, electric power, wharf, municipal, environmental protection, national defense. The steel grating welding machine applies electric synchronous technique, welding time and welding are controlled by digital integrated circuits, it is high accuracy, stable, and firm welding, transmission parts are pneumatic and imported, so the welding pressure is even and low failure and can service for long time.

## ABE-GYH-1000-8 钢格板焊接

### 设备规格(parameters)



钢条厚度 (Bar range): 2.5-5mm  
钢条宽度 (Bar width): 25mm-60mm  
扭花直条 (Cross bar range): 5-8mm  
焊接宽度 (Welding panel width): 1M;  
长度 (length): 6M

型号 (Model)	ABE-GYH-1000-2	ABE-GYH-1000-4	ABE-GYH-1000-8
产能 (Production capacity)	70-100M2/8 小时, 两个小时一片 70-100M2/shift (8hours), one panel per two hours	150-200M2/8 小时, 一个小时一片 150-200M2/shift (8hours), one panel per one hour	100-150M2/8 小时, 一个小时一片 100-150M2/shift (8hours), one panel per one hour
每次焊点个数 Welding points at one time	一次焊两个点 2welding points	一次焊四个点 4welding points	一次焊八个点 8welding points

产量 (production): 150-200M2/班, 8 小时一班, 一小时一片  
(150-200M2/shift (8hours), one panel per one hour )

间距 (Pitch of flat bar): 25,30,40.50,60 mm

横向间距 (Pitch of cross bar): 30,50,100.160mm

变压器 (Welding transformer): 200 KVA

外观尺寸 (Overall size): 16\*2.5\*1.5M

重量 (weight): 4000kg

送料台和出料台, 按照 6M 的产品尺寸, 台面长度要大于 6.5 米

Feeding and discharging outlet, designing according to the 6M product size, and the length should be larger than 6.5 meters.

气动压料, 气动压料杆要粗

Pneumatic press feeding, the rod is rough enough.

伺服电机拉料: 3 kw 松下品牌 (Servo motor pulling: Panasonic, 3kw)

PLC 控制柜: 松下 (PLC Control cabinet: Panasonic)

### 辅助设备 (Auxiliary Equipment)

扭花机: 扭花机器电机为变频调速, 22kw

(Twisted square bar drawing machine, frequency motor 22kw)

钢格板调直台 ( Bracket and grating flatting table)

轧尖机 (Tip roller)

对焊机 ( Butt welding machine )