



50/60  
Hz

3  
Phase

CC/CV

JSAW-630

## SUBMERGED ARC WELDING MACHINE



## FEATURES

- The main components of this welding equipment a powerful JSAW-630 inverter power source and a welding tractor, on which a WF-23 A wire feeder, a welding wire spool, a flux bin and a control unit are installed.
- The welding current of the Ambition JSAW-630 machine can be set on the control panel of the welding tractor with a wide range from 60 to 630 A.
- On the front panel having 2 digital displays about the values of welding current & voltage.
- Machine has a Hot Start function, which greatly facilitates the start of the welding process by automatically increasing the welding current at the moment the welding wire touches the surface and provides additional energy that allows to immediately ignite the arc and instantly start welding.
- Arc Force option is increases the welding current when the welding wire approaches the surface to be treated to prevent sticking and reduce spatter.
- Excellent Capable welding such materials as stainless steel, alloy steel, carbon steel, copper and other non-ferrous metals.
- Welding uses a unique control scheme, resulting in less spatter, stable welding arc, excellent weld quality and overall high productivity.
- JSAW-630 features a falling external current-voltage (CV) characteristic for automatic submerged arc welding (SAW), a falling characteristic for coated or carbon electrode welding (MMA) to ensure a stable welding process & a constant welding arc length.

## Technical Specification

|                              | UNIT  | Model JSAW-630       |
|------------------------------|-------|----------------------|
| Input Voltage                | V     | AC 415 ± 10%         |
| Frequency                    | Hz    | 50/60                |
| Phase                        |       | Three                |
| Open Circuit Voltage         | V     | 80                   |
| Input Power Capacity         | kVA   | 60                   |
| Max. Welding Current         | A     | 630                  |
| Consumed Current             | A     | 52                   |
| Operating voltage on the arc | V     | 24-44                |
| Wire feed speed              | m/min | 0.3-3.0              |
| Welding wire diameter        | mm    | 2.0-4.0              |
| Electrode diameter           | mm    | 4                    |
| Load Period                  | %     | 80                   |
| Efficiency                   | %     | 85                   |
| Power Factor                 |       | 0.93                 |
| Degree of Protection         | Class | IP21                 |
| Cooling                      | Type  | Welding flux cooling |
| Insulation Grade             |       | F                    |
| Dimensions (L *W*H)          | mm    | 530*320*600          |
| Weight                       | Kg    | 55                   |