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GUARANTEE:

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QUALITY PRODUCTS
TECHNICAL SUPPORT
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International slogan of KOBE STEEL Welding Group

KOBELCO WELDING TODAY

Vol. 15
2012 No. 1

KOBELCO Puts the Customer First with All-in-One Product and Service

KOBELCO



FAMILIARC™ MX-Z200MP provides uniform weld toes in multi-layer fillet welding



FAMILIARC™ MX-Z200MP is a high-deposition-rate flux cored wire (metal-type FCW) developed primarily for multi-layer fillet welding in horizontal and flat positions. It can be classified as AWS A5.20 E70T-1C and JIS Z3313 T49J0T1-0CA-U and is suitable for mild steel and 490-MPa class high tensile strength steel used in steel structures, bridges, and water transmission pipes. For a shielding gas, 100% CO₂ is recommended.

Some of the hallmarks of MX-Z200MP include uniform slag covering, regular weld toes, glossy bead surface, and smooth lapping onto the preceding bead in multi-layer fillet welding, as shown in Figure 1.

Figure 1 : MX-Z200MP offers uniform slag covering, regular weld toes, glossy beads, and smooth pass-to-pass lapping.

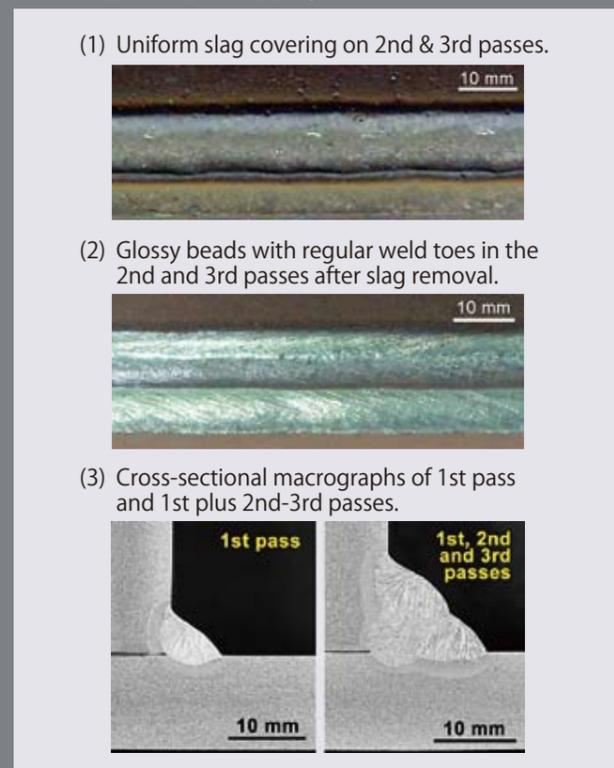


Figure 2 : Self-peeling slag of conventional FCW can cause the lapping bead to form irregular bead toes in multi-layer fillet welding.



In multi-layer fillet welding, the good slag removability of conventional FCWs, means that the succeeding bead is apt to exhibit irregular toes because the slag of the preceding bead peels off naturally (Figure 2). Such a good characteristic, however, can adversely affect the formation of the succeeding bead without adequate support for it.

By contrast, MX-Z200MP is designed to generate a uniform slag covering, which does not peel off until being tapped lightly with a chipping tool; hence, a preceding bead helps the succeeding one form a regular shape. Counterintuitively, therefore, the slag on the previous weld bead should not be removed before placing the next bead to be lapped on. Of course, the 1st pass as shown in Figure 1(3) must be free of solid slag before the 2nd pass.

With MX-Z200MP, the amount of spatter can be decreased by about 16% with 1.2-mm wire and about 10% with 1.4-mm wire compared with conventional FCW as shown in Figure 3. This is due to the stable arc and smooth droplet transfer, which also offers high resistance against porosity (such as pits and worm tracks), when welded on primer-coated steel plates in particular.

Figure 3 : Comparison of spatter emission rates between MX-Z200MP and conventional FCW.

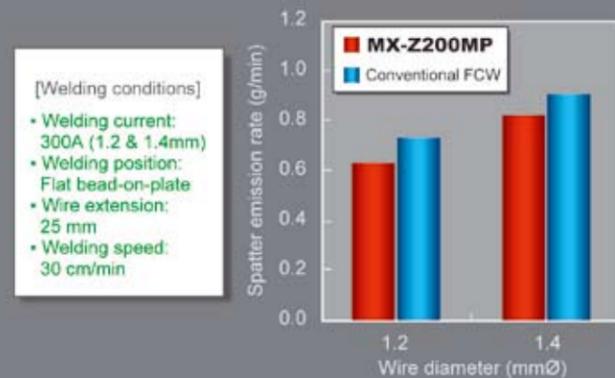


Table 1 shows the typical chemistries and mechanical properties of the all weld metal made with MX-Z200MP, which are sufficient for such applications as mentioned above.

Table 1: Typical chemistries and mechanical properties of MX-Z200MP all weld metal

Typical chemistries (%)					Typical mechanical properties			
C	Si	Mn	P	S	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J at 0°C)
0.05	0.62	1.55	0.010	0.009	498	587	28	98

Kobelco's welding business expands worldwide with systematic welding solutions combined with robots and consumables

I would like to sincerely wish all the Kobelco Welding Today readers a Happy New Year! And my heartfelt greetings to you as well! My name is Manabu Nagata, General Manager of the Welding System Section (WSS) of the Technical Development Department. I would like to express my warmest gratitude for your continuous patronage of Kobelco's robotic welding systems and equipment as well as welding consumables.

Since it is the first time WSS is introduced in this magazine, I would like to outline the section's activities, experiences, and strategies.

You may know that Kobe Steel has been developing, manufacturing and providing — besides welding consumables — welding processes and equipment, typically such mature products as the FCB™ one-side welding equipment for shipbuilders worldwide since the 1960s.

In addition, we have been developing, manufacturing and supplying robotic welding systems and power sources primarily to customers in the Japanese construction machinery and steel structure industries since the 1980s.

Nowadays, however, we have started to respond to demand for our robotic welding systems and dedicated power sources from customers around the world, particularly in China, Korea and South East Asian countries. Demand is highest among construction machinery fabricators, where medium/heavy-thick plates are major applications. Encouraged by the high marks our products receive from customers, we are determined to continue to expand our overseas business, step by step.

In the WSS, we research and develop welding robots, power sources, and special equipment that supports unique welding processes. Using the hardware created through R & D, we then design, manufacture and engineer the mechanical systems for individual welding fabricators. Our business strategy is to add value through tailor-made welding systems for both overseas and domestic customers.

While you may know Kobe Steel to be one of the world's leading manufacturers of welding consumables, we hope you will take a look at how we utilize our own technologies for the design and manufacture of ever-better robotic welding systems and power sources. As such, Kobe Steel is unequalled in the ability to provide total solutions by combining the best welding consumables and welding systems for highly efficient welding processes to improve total welding performance.

We aim to support our customers in steel fabrication with proposals for effective and automated welding systems that meet their specific requirements.

In the meantime, the Japan International Welding Show (JIWS) in 2012 will be held in Osaka from the 11th to 14th of April, at which Kobe Steel will emphasize welding-process-related products. We would like to welcome you to JIWS and look forward to seeing you there or in the course of business in the very near future.



Manabu Nagata
General Manager
Welding System Section
Technical Development Dept.
Welding Business
Kobe Steel, Ltd.

KOBELCO WELDING TODAY No.1 2012

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An unrivaled metal-type FCW for multi-layer fillet welding



ARCMAN™-GS shines in the steel structure welding



Kobelco at the 1st Brazil Welding Show from Oct 18-21, 2011



Int'l QC-Circle Convention, held in Ibaraki Plant in Japan

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Kobelco's ARCMAN™ welding robots and SENSARC™ power sources: unsurpassed performance across many applications



The Welding Business of Kobe Steel, Ltd., is the worldwide manufacturer that provides total welding solutions, including arc welding consumables, welding robots and power sources through its independent research and development.

Over the years, Kobe Steel has developed comprehensive robotic arc welding systems, comprising not only the robot, but the power source and peripheral equipment such as positioner and slider as well. In addition, customers are provided with welding procedures designed to meet their particular needs. This is one of Kobe Steel's strong points.

In this edition, we present and discuss the features of the ARCMAN™ series welding robots as well as the SENSARC™ series power sources.

The original ARCMAN™ models

The ARCMAN™ series welding robots are generally put to use on medium- and heavy-thick plates used in such fields as construction machinery, buildings steel structures, bridges, and rolling stock. Four ARCMAN™ models are available including the recently developed ARCMAN™-GS.

1. ARCMAN™-SR

This compact, lightweight robot lessens the weight of the entire system and requires less installation space. With high wrist torque comparable to the standard ARCMAN™-MP, it can be equipped with heavier torches, such as water-cooled or tandem torches.

2. ARCMAN™-MP

Kobe Steel's best selling model, ARCMAN™-MP utilizes a standard water-cooled torch and is applied on medium and heavy plates. Welding application software as well as sensors for searching welding grooves can be installed. It can be equipped with a long torch for handling confined spaces, and, because of its high payload and wrist torque, a tandem torch or a plasma cutting torch.

3. ARCMAN™-XLmkII

Featuring the world's largest arm, this robot's motion range can exceed a maximum of 3 meters of reach, allowing the robotic system to be configured along a simple axis structure without a slider. Another advantage of this model's long arm is the ability to access the deep part of a hollow workpiece, such as the basket of a hydraulic shovel.

The new ARCMAN™-GS

Well-suited for welding medium and heavy plates, ARCMAN™-GS is the product of Kobe Steel's wealth of experience in welding robotics; it was launched in September 2011. While its arm is equivalent in size to that of ARCMAN™-MP, its improved design features an arm with internal cabling as shown in Figure 1.

Figure 1 : ARCMAN™-GS shines in the medium and heavy plate welding.



1. Background to the development of ARCMAN™-GS

The ARCMAN™ series robots have highly been reputed, particularly in the construction machinery field, where the robotic systems increasingly utilize robots mounted upon overhead-suspended sliders. Overhead suspension is forecast to spread more widely in the future as it provides better ease of access to large-scale workpiece as well as superior safety and operation efficiency as the machinery is removed from the ground.

In the welding of construction machines, the welding torch must be able to reach deep inside the hollow workpiece. Additionally, the robot teaching operation must be free from interference occurring between the torch and workpiece as well as between the torch cable and workpiece. For these reasons, the torch cables should be strung inside the arm. Because ARCMAN™-GS has sufficient motion range for an overhead-suspended system and features the cable-integrated arm suitable for off-line teaching, it is an excellent robot for such a demanding application.

2. Features of ARCMAN™-GS

(1) Cable- or torch-integrated models are available to match system requirements

Two variations are available for ARCMAN™-GS: one with cables integrated with the upper arm, as shown in Figure 2, and the other in which the torch is integrated with the wrist axis, as shown in Figure 3.

Figure 2 : ARCMAN™-GS with the cable-integrated upper arm.



For the cable-integrated upper arm type, a wire feeder is mounted at the rear side of the upper arm; the torch cables extend from the wire feeder through the cable hole that runs alongside the upper arm. The torch body is supported at the wrist axis.

For the torch-integrated wrist axis type, the wire feeder is not mounted on the robot but is installed peripherally. The torch cables extend from the wire feeder on a cable hanger to connect to the torch body, which is supported at the wrist axis.

Figure 3 : ARCMAN™-GS with the torch-integrated wrist.

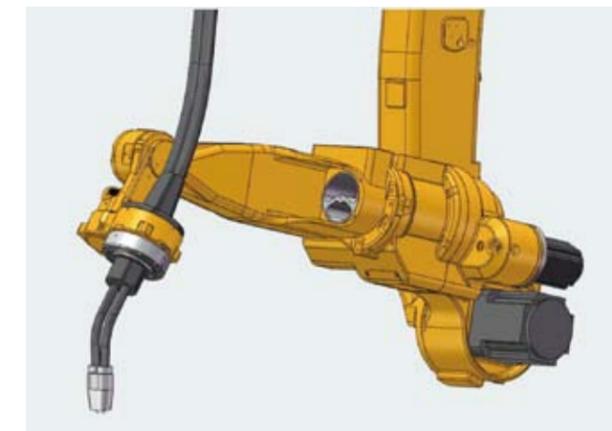


Figure 4 shows what can happen when the torch cable is not integrated with the upper arm: the cable dangling dangerously close to the inner rim of the workpiece can cause interference between the torch cable and the workpiece, and, over time, affect the durability of torch cable.

Figure 4 : Example of robotic welding where the interference between torch cable and workpiece is about to occur.



In this case, internal cabling could prevent interference between the torch cable and workpiece, allowing the teaching operation to be easily carried out. Also the cable-integrated model allows off-line teaching to be conducted on a personal computer because no unpredictable cable movement can occur.

If internal cabling is undesirable, the torch-integrated wrist arm model can be selected. With this model, the torch body is aligned at the center of the 6th axis, which allows accurate coordination of the torch with the movement of the robot, minimizing interference even if the torch is put into the narrow and deep part of the workpiece.

In the torch-integrated model, the wrist is cantilevered so as not to entangle the torch cable with the wrist, and the wrist axis motor is housed in the wrist frame so that the wrist edge does not protrude. This minimizes cable entanglement as well as interference between cable and workpiece during welding.

(2) Reverse-elbow positioning enables an operating envelope that is the largest in its class

In an overhead-suspended robotic system, the robot should be able to access as much of the workpiece as possible from above. Therefore, the robot's operation envelope should be large and able to cover the area behind as well as in front of the robot.

With ARCMAN™-GS, the reverse elbow position enables the upper arm to bend behind the robot, as shown in Figure 5, expanding the motion range. This advanced function of the ARCMAN™-GS is only possible because the arm is as long as that of ARCMAN™-MP.

As illustrated in Figure 5, the reverse elbow positioning with ARCMAN™-GS enables easy access to weld lines that lie behind obstacles without interference between the arm and the workpiece. In contrast, conventional robots require complex sliding movements in order to achieve similar results and avoid interference. Because ARCMAN™-GS is capable of reaching inaccessible spots without sliding, the slider it does use is short, reducing the complexity and weight of the entire system.

(3) Automatic exchange between tandem torch and single torch

Kobe Steel has supplied quite a number of ARCMAN™ series robots for tandem arc welding, and ARCMAN™-GS is particularly effective at this. With the tandem torch housed at the wrist axis center, the cable-integrated arm can extend into confined spaces that conventional robots would find impossible to tandem weld.

In addition, the tandem torch and single torch can be exchanged automatically with the installation of the automatic tool-exchanger, exclusively designed for ARCMAN™-GS. With this system, either tandem or single arc welding can be selected, depending on the shape of workpiece and the welding joint configuration. Figure 6 shows a robot with an automatic tool-exchanger.

Figure 7 shows the structures and dimensions of the ARCMAN™ series robots, and Table 1, the specifications for the ARCMAN™ series manipulators.

**A dedicated welding power source for robots:
SENSARC™ AB500**

Kobe Steel's SENSARC™ series is a lineup of welding power sources for CO₂/MAG welding that meet a variety of applications. SENSARC™ AB500, for example, is a sophisticated power source exclusively for ARCMAN™ robotic welding systems for medium and heavy plate welding (see Figure 8). It is ranked as the highest quality model of the SENSARC™ series, offering multifunctional welding performance.

1. Innovations in key capabilities

SENSARC™ AB500 offers an 8 times faster arithmetic capacity and a 2.5 times higher control frequency as compared with conventional power sources, thereby establishing an innovative output waveform control by an advanced control rule.

The combined wire feeder is equipped with four driving rolls to ensure a 1.5 times stronger wire feeding force, thus increasing the maximum wire feeding speed to 30 m/min, which is 20% higher than conventional ones. In addition, the wire feeding stability has been improved by employing an encoder that detects motor rotation, a four-roll driving method, high precision digital control, and a quick response motor.

These advanced capabilities, as well as a stable and smooth arc start and easy wire feeding through wire touch sensing, shorten idle time, thereby improving the welding performance by ARCMAN™ robots. Table 2 shows the specifications for SENSARC™ AB500.

Table 1 : Specifications for ARCMAN™ manipulators

Items	Specifications
Corresponding controller	CA type controller
Maximum motion range for each axis	S1 ±170 deg
	S2 -100/+155 deg
	S3 -210/+80 deg
	S4 ±180 deg
	S5 ±127 deg
	S6 ±360 deg
Maximum speed for each axis	S1 2.09 rad/s, 120 deg/s
	S2 2.71 rad/s, 155 deg/s
	S3 2.71 rad/s, 155 deg/s
	S4 6.98 rad/s, 400 deg/s
	S5 6.11 rad/s, 350 deg/s
	S6 10.47 rad/s, 600 deg/s
Payload	At the end of wrist: 15kgs At the mounting position of wire feeder: 20kgs
Allowable moment of wrist for each axis	S4 38.9 Nm
	S5 38.9 Nm
	S6 7.35 Nm
Allowable moment of wrist inertia for each axis	S4 1.05 kg·m ²
	S5 1.05 kg·m ²
	S6 0.038 kg·m ²
Installation position	On floor or overhead-suspended
Manipulator weight	286 kgs
Painting color	Dull yellow

Figure 8 : SENSARC™ AB500: a multifunctional power source for ARCMAN™ welding robots.



Figure 5 : Reverse-elbow position (left) can prevent arm-workpiece interference with overhead-suspended robotic system.

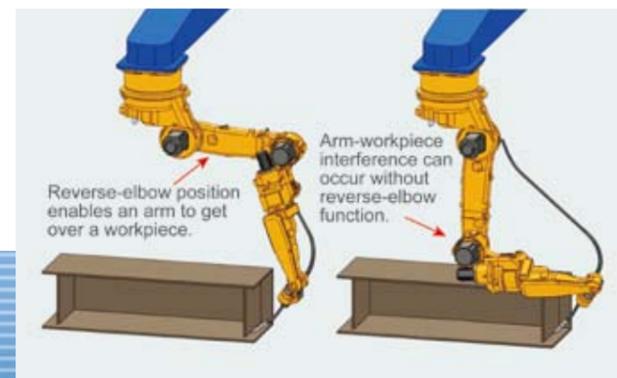


Figure 6 : The multifunctional ARCMAN™-GS with an automatic tool-exchanger.



Figure 7 : A lineup of ARCMAN™ series arc welding robots. (diagrams with dimensions)

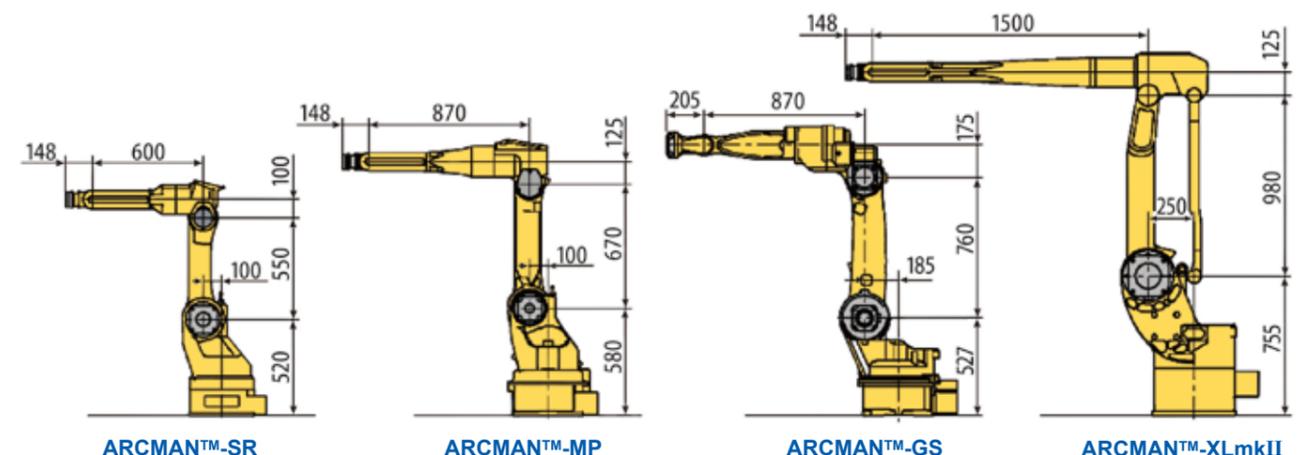


Table 2 : Specifications for SENSARC™ AB500

Items	Specifications
Rated input voltage	AC200V/AC220V
No. of phase	3 phases
Rated frequency	50Hz/60Hz
Rated input power	28.1kVA, 26.6kw
Rated current	81A/74A
Rated output current	500A
Rated load voltage	45V
Output current	30-500A
Output voltage	12-45V
Maximum no load voltage	86V/95V
Duty cycle	450A-100% 400A-100% (Pulsed welding)
Outer dimension (WxHxD)	370x685x665 (mm) (Input terminal head, eyebolt and hexagon bolt are not included)
Weight	69kgs

2. A variety of optimum welding modes for medium and heavy plate welding

SENSARC™ AB500 is equipped with, in addition to the innovations mentioned above, several new welding modes, including the Kobe Steel-developed arc welding process with unique pulse-current-waveform control. These modes are elaborately tailored to medium and heavy plate welding; thus, welding performance can be improved even in some of the more conventional modes as shown in Table 3.

Table 3 : Welding modes for SENSARC™ AB500

Shielding gas	Welding method	Kind of wire	Wire dia. (mm)
CO ₂	Single, Without pulse	Solid wire for mild steel	1.2
		Flux cored wire for mild steel	1.2, 1.4
		Flux cored wire for stainless steel	1.2
Ar+CO ₂	Single, Pulse	Solid wire for mild steel	1.2, 1.4, 1.6
		Solid wire for mild steel	1.2, 1.4
		Solid wire for mild steel	1.2

*1: REGARC™ is a unique pulse-current-waveform control process.

3. Tandem-pulsed MAG welding applications

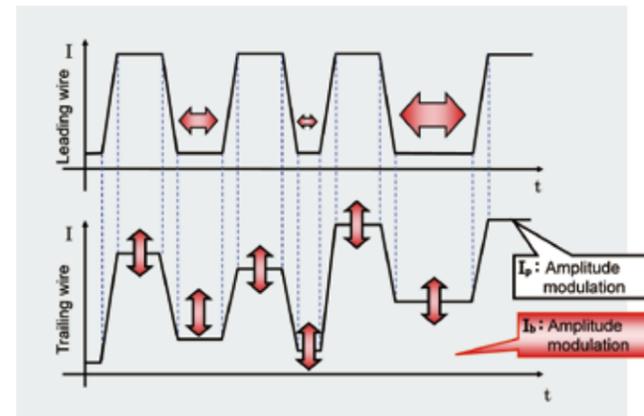
In 2001, Kobe Steel began marketing a robotic system that provides both high welding speeds and sound welds by using the two-electrode one-pool tandem arc welding technique featuring high deposition rates.

Through persistent research and development on the tandem arc welding method, an innovative welding current output control has been developed and applied to the present power source. With this technique, two tandem

pulsed arcs are controlled in such a way that the pulse peak and base currents are synchronized between the two arcs, thereby increasing arc stability and reducing spatter.

With SENSARC™ AB500, the arc length of the trailing electrode is optimized by the newly developed synchronous amplitude modulation control that increases or decreases the pulse peak and base current as shown in Figure 9.

Figure 9 : Conceptual diagram of synchronous amplitude modulation control.



With this mechanism, SENSARC™ AB500 allows a wider range of welding parameters because the arc lengths of both leading and trailing electrodes are controlled adequately, preventing disturbance effects and maintaining the constant arc lengths. Furthermore, unlike conventional power sources, a change in the leading electrode's welding parameter does not affect that of the trailing electrode; hence, welding parameters can easily be adjusted.

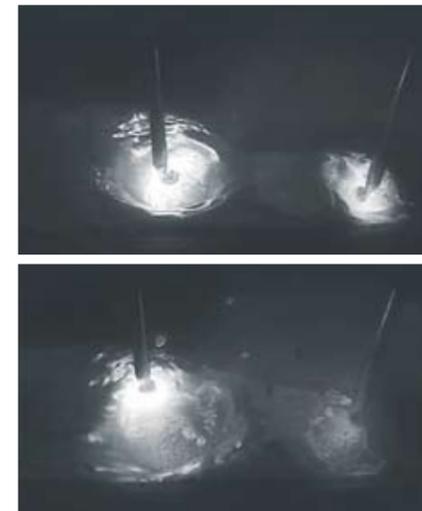
To obtain a stable arc and sound weld in one-pool tandem arc welding, control over the molten metal bulge generated between the two electrodes in the weld pool is essential.

With conventional power sources, when one electrode encounters a disturbance, the arc fluctuates, causing changes in arc length that affect the arc force, and this can cause the molten metal bulge to become unstable. And the destabilized bulge of molten metal affects the arc force of the other electrode, thereby causing an unstable arc.

By contrast, SENSARC™ AB500 can maintain stable arcs and cancel disturbances with the advanced high quality load-characteristic control.

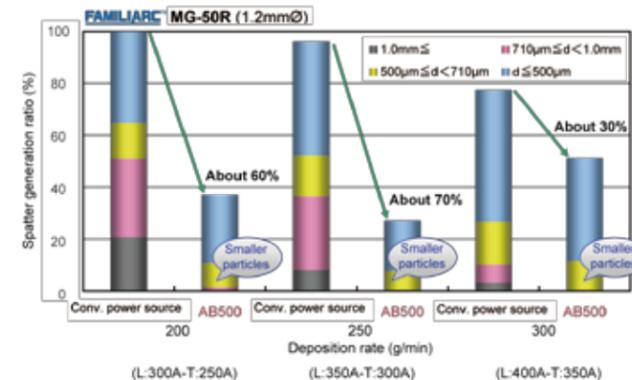
In Figure 10, the top picture shows a stable bulge of molten metal generated between the two electrodes by means of high quality load-characteristic control, thereby creating stable and low spatter arcs. In contrast, when load-characteristic control is not used, as shown in the bottom picture, the bulge fluctuates in shape, causing unstable arcs with much spatter.

Figure 10: One-pool tandem arc welding with (top)/ without (bottom) high quality load-characteristic control.



With SENSARC™ AB500, the high quality load-characteristic control reduces spatter generation by as much as 70% as well as spatter particle size, when compared with a conventional power source, as shown in Figure 11.

Figure 11: Spatter generation in tandem arc welding with SENSARC™ AB500 and conventional power sources.



4. Advanced performances in other applications

In pulsed MAG welding with solid wire for mild steel, arc stability and spatter generation can be improved (Figure 12) with some new technologies. For example, the immediate load-characteristic control as well as the high-quality disturbance-cancellation control can remove the instantaneous fluctuation associated with the fluctuation at the current-carrying point and the arc generation point on a welding wire, thereby reducing excessive arc force fluctuation.

With such advanced technologies, SENSARC™ AB500 can reduce the spatter generation ratio by up to 45% and spatter size, even at a high welding current of 300 A or more as is used commonly in the medium and heavy plate welding.

In CO₂/MAG welding in the medium welding current range, where large spatter particles tend to be generated, the advanced technology for suppression of molten droplet vibration can reduce the spatter generation ratio by as much as 25% in comparison with a conventional power source as shown in Figure 13. With this technology, excessive droplet growth and vibration are restrained by changing the operating characteristics according to the amount of droplet growth. As a result, it prevents droplets from scattering and reduces the spatter generation ratio.

Figure 12 : Comparison of spatter generation ratio between SENSARC™ AB500 and conventional power source by pulsed MAG welding.

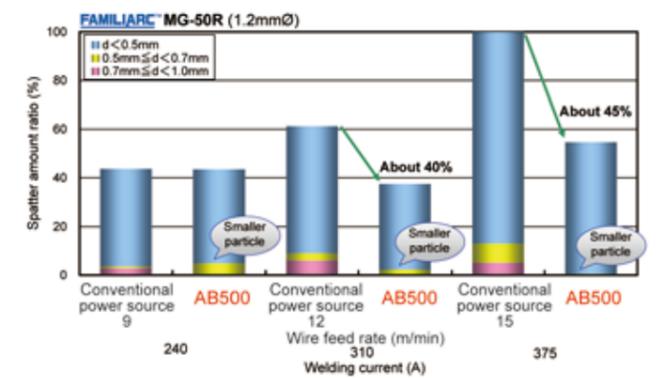
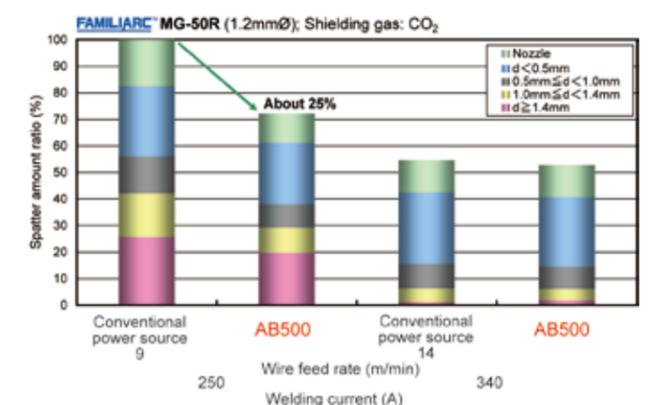


Figure 13 : Comparison of spatter generation ratio between SENSARC™ AB500 and conventional power source by CO₂ welding.



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- [1] Kobe Steel, Welding Technical Report, Vol. 50, 2010-6
- [2] Kobe Steel, Welding Technical Report, Vol. 51, 2011-9

KWAI sparked at the 1st Brazil Welding Show 2011

The 1st Brazil Welding Show was held at the Expo Center Norte in Sao Paulo from the 18th to 21st October, 2011. There were 132 exhibitors from not only Brazil but also the USA, Europe, and China. The welding show ran concurrently with the 6th Cutting & Metal Conformation, South America's largest metal forming and fabrication event, held this time in Sao Paulo, the most important city in Brazil and one of the major industrial centers in the world.

With support from the German Welding Society (DVS), the welding show was held in cooperation with Messe Essen, the German event organizer well-known for its successful staging of the "Schweissen & Schneiden" (Welding & Cutting) fairs in Germany as well as its subsidiary events in China, India and Russia. Other international welding associations that supported the Brazil Welding Show included the American Welding Society (AWS) and the Chinese Mechanical Engineering Society (CMES).

Kobelco Welding of America Inc. (KWAI) participated in the show with an exhibit focusing on flux cored wires for Ni-based alloys, stainless steels, low temperature steels, and carbon steels. The bead samples made by these flux cored wires attracted many visitors, and the leaflets written in Portuguese proved an effective sales tool. The KWAI display was also assisted by the people from Maxweld (the Brazilian partner) and Kanematsu America Do Sul (the pro-Kobelco trading-house located in Brazil).

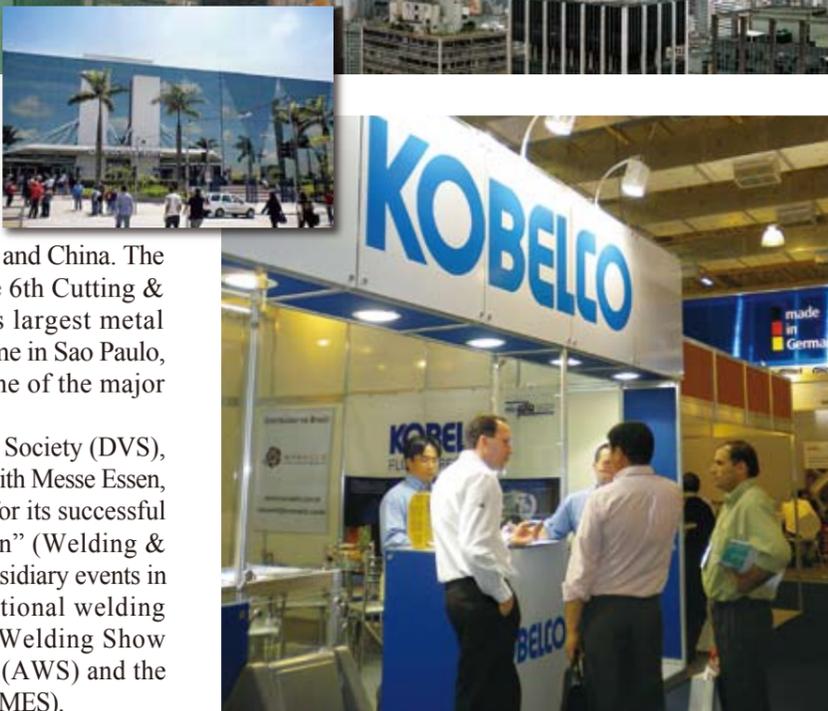
Kobelco's flux cored wires for stainless steels, Ni-based alloys, low temperature steels and carbon steels sparked at the KWAI booth.



▲ Avenida Paulista

▲ Marginal Pinheiros

Reported by Keito Ishizaki
Senior Welding Engineer, KWAI



Visitors asking about Kobelco's total welding solution capability and flux cored wires at the KWAI booth.

The excitement generated by the Brazil Welding Show reflects the growth in demand from infrastructure construction projects in Brazil. KWAI, as part of the Kobelco Group, plans to meet this brisk demand through advertising and publicity as well as by contacting potential customers in collaboration with a Brazilian partner and trading house. In these ways KWAI can best respond to the expectations of Brazilian customers. The welding show, which is to be held biennially, will help us transform these new challenges into successes.



Discussions with customers often turned to Brazil's breathtaking economic growth.

Kobelco's worldwide QC Circle activities: The power of innovation in the quality of products and services

Dear KWT readers! Have you ever heard of a "QC Circle" activity or ever been involved in one?

As an effective quality control activity, a QC Circle is systematically carried out by a group of co-workers who are experienced in their jobs at a particular section for production or customer service. Through such activities, they aim to improve product quality, production efficiency, or product delivery. Potential outcomes may include labor savings through process mechanization. Kobelco group companies at the domestic and overseas production bases have persistently made use of QC Circles.

On October 6 and 7, 2011, the 15th annual International QC Circle Convention was held at the Ibaraki plant of Kobe Steel in Japan. Through presentations and discussions, it was an excellent way for colleagues producing Kobelco welding consumables around the world to exchange the results of their QC Circle activities. At this convention, the delegates were able to study each other's activities and perhaps use them in a form of "horizontal development," at their factories.

The convention brought together about 190 delegates from seven countries where Kobelco welding consumables are produced: China, Thailand, Singapore, Korea, Netherlands, Indonesia, and Japan. Twelve presentations were made with the aid of simultaneous translation.

Active questions and answers followed each presentation, and finally all the presentations were judged according to a range of criteria.



Question and answer session after the presentation was quite active.

The judging resulted in two Gold Prizes being awarded: one was to Thai-Kobe Welding Co., Ltd. in Thailand for "Quality Improvement in the Covered Electrode Production Process" and another one to the Fukuchiyama Plant of Kobe Steel in Japan for "Efficiency Improvement in the Solid Wire Production Process."

In the closing speech, Tsuyoshi Kasuya, the Managing Director of the Welding Business, Kobe Steel, Ltd., expressed his intention to persistently carry out QCC activities, stressing, "I am confident that the QC Circle activities will become a big force for the welding business of Kobelco group companies to step forward in the worldwide markets."

All the representatives from seven countries who took part in the QC Circle Convention promised to reunite at the next year's meeting and left the Ibaraki Plant with big smiles on their faces.



A delegate from a Kobelco production base, presenting the results of their QCC activities.



All the presenters from production bases in seven countries, posing in front of the audience.