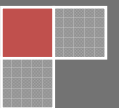




PRODUCT CATALOG

J. IRIZAR & COMPANY LTD



J. IRIZAR & COMPANY LTD

J. IRIZAR & COMPANY LTD is well known by our trade mark "IRIZAR". The company is headquartered in Edmonton Canada. We are a world-wide leading manufacturer of rotating and positioning equipment: Welding Rotators, Welding Manipulators, Welding Positioners, Tank Welders, Seam Welders, Tank Erection Equipments, Pipe Rotators and related equipments.

Our corporation was established in 1999 and since then we have manufactured top quality equipments at competitive prices. Our products have been sold to hundreds of customers world-wide. IRIZAR turnover per year exceeds US \$ 120 M dollars. Overseas markets constitute 95% of our company sales. Our manufacturing and warehouse space exceeds 40,000 square meters. IRIZAR is one of North America's largest rotating and positioning manufacturers. Our training facility is located in Alberta Canada.

In order to efficiently respond to our customers' needs either for buy or lease, our company has an available stock of US \$25 M dollars. Our manufacturing facility is located at the People's Republic of China and it is proudly Canadian owned. Our equipments are **TOP CLASS QUALITY** designed and built under supervision of our experienced Canadian Engineers. IRIZAR products exceed international standards. IRIZAR provides **FIRST CLASS SERVICE**. Our company is committed to building a life-long relationship with the customers we serve.

Visit us in Wetaskiwin warehouse located at only 20 minutes from Edmonton International Airport, or at Wuxi City Jiangsu Province in China located two hours from Pudong Shanghai International Airport. Also look for our products at the following Welding Shows: i) Fabtech Mexico: Monterrey Mexico from June 2-4, 2009. Booth 409; ii) Weldex: Crocus Expo Exhibition Center, Moscow Russia, October 13-16, 2009; iii) Fabtech International & AWS Welding Show: Chicago Illinois USA from November 15-18, 2009. Booth 40021

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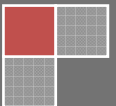
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Reader notes: i) For ordering down load the latest English version available online, ii) The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include, iii) Overload or misuse of an equipment can cause property damage, body injure or death. Before ordering read carefully and understand the information contained on this brochure. If you have any questions or concerns, please contact us @ 1 877 IRIZAR1 or jirizar@jirizar.com



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Conventional Tank Turning Rolls, WR Series

Tank Turning Rolls, Welding Rotators, Welding Rolls, Vessel Welding Rotators, Turning Rolls, Tank Welding Rolls, Tank Turning Rolls, Tank Rotators, Tank Rollers, Roller Beds, Roller Beds, Powered Rolls, Power Turning Rolls, Pipe Turning Rolls, Pipe Rotators, Pipe Rollers, Pipe Rolls, Idler Rotators, Conventional Rotators, Scissors Rotators, Vireur de Soudure, Rotadores de Soldadura Convencionales, Rotadores de Tanques, Rotadores de Virolas, Rotadores de Tubos, Viradores de Tanques, Viradores Locos, Viradores Motorizados, Viradores Convencionales, роликов вращатели



Model	Load & Rotation Capacity (tons)	Rotation variable speed (mm/min)	Power (kW) Two motors each	Driving Moment (Newtons -m)	Vessel Diameter Range (mm)	Wheel (mm)		Dimensions L*W*H (mm)		Weight (tons)
						Diam	Width	Power Roll	Idler Roll	
WR 3	3	100-1000	0.18	2391	120-2500	250	110	2320*455*410	2020*400*410	0.50
WR 5	5	100-1000	0.25	4915	150-3200	350	120	2320*560*535	2020*400*535	0.70
WR 10	10	100-1000	0.37	8768	150-4000	350	120	2440*695*575	2160*450*575	0.92
WR 20	20	100-1000	0.37	13903	150-4000	350	120	2440*695*575	2160*450*575	0.97
WR 40	40	100-1000	0.75	20500	300-4500	425	200	2600*735*700	2300*550*700	1.84
WR 60	60	100-1000	1.5	30600	300-5200	425	200	2600*810*790	2300*600*790	2.50
WR 80	80	100-1000	1.5	34100	300-5200	580	300	4380*1150*990	4100*650*990	4.50
WR 100	100	100-1000	2.2	47000	500-7800	580	300	4380*1250*990	4100*650*990	5.20
WR 150	150	100-1000	4.0	51250	1000-6000	600	220	4200*1600*1100	4200*650*1100	13.50
WR 250	250	100-1000	5.5	93600	1100-7500	660	260	4500*1600*1200	4500*750*1200	14.80
WR 400	400	100-1000	7.5	106500	1100-7500	750	320	4500*1600*1200	4500*750*1200	17.50
WR 600	600	100-1000	7.5	155000	1500-9000	900	380	5200*1800*1400	5200*900*1400	27.00
WR 800	800	100-1000	9.0	NA	1600-6000	1000	400	5500*1800*1500	5500*1000*1500	30.00
WR 1000	1000	100-1000	9.0	NA	1600-6000	1000	400	5800*1900*1600	5800*1100*1600	34.00
WR 1200	1200	100-1000	11.0	NA	1600-6000	1000	400	8500*1800*1600	7500*1230*1600	37.00

Notes:

- Variable rotation speed from 100 to 1000 mm/min: included
- Wheels padded with heavy duty rubber: Included on models WR- 100 and smaller
- Remote control box with 12 m span: included, and allows adjustment of rotating speed –digital display in mm/min-, forward and reverse rotation, and stop

- Shot blasted frame at SA 2 ½: included
- Variable Frequency Driver (VFD) made by Teco Westinghouse
- Custom built welding rotators available
- CE mark available only under customer request
- The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include. Latest revision available in English on line

Standard package includes

- One power roll with control box
- One idler roll
- Operation manual
- One year warranty

Optional

- Foot control pedal for changing rotation direction and stop

- Turning rolls mounted over manual or motorized bogies
- Adjustment device to modify center to center wheel distance by manual screw. Available for models WR-40 and smaller
- Anti-drift device to avoid longitudinal displacements (screw moving effect) while the vessel is rotating. Accuracy ± 1.7 mm considering the end working piece is machined with a tolerance of ± 0.20 mm
- Wheels padded with white rubber or polyurethane for steel tank construction
- Synchronization rotation speed of several power rotators

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Self Aligned Tank Turning Rolls, SAR Series

Self Aligned Rotators, Self Aligning Rotators, Rotadores de Soldadura Autoalineados, Viradores Autoalineables, роликовые вращатели



Model	Load & Rotation Capacity (ton)	Rotation variable speed (mm/min)	Power (kW)	Driving Moment (Newtons- m)	Vessel Diameter Range (mm)	Wheel (mm)		Dimensions L*W*H (mm)		Weight (tons)
						Diam	Width	Power Roll	Idler Roll	
SAR 5	5	100-1000	0.75	3188	250-2300	250	140	1620*690*700	1380*380*700	0.85
SAR 10	10	100-1000	1.1	7652	320-2800	300	170	1880*780*820	1454*390*820	1.50
SAR 20	20	100-1000	1.5	13093	500-3500	350	180	2250*930*950	1920*490*950	2.70
SAR 40	40	100-1000	3.0	20405	600-4200	400	200	2500*1015*1050	2180*530*1050	3.30
SAR 40 LD (*)	40	100-1000	0.55	20405	900-5200	425	200	2250*775*1130	2250*550*1130	2.80
SAR 60	60	100-1000	4.0	30608	750-4800	450	220	3000*1200*1100	2550*650*1100	4.50
SAR 80	80	100-1000	4.0	34009	850-5000	500	240	3200*1200*1250	2700*750*1250	6.00
SAR 100	100	100-1000	5.5	46800	1000-5500	500	260	3500*1410*1350	3000*780*1350	7.00
SAR 150 (*)	150	100-1000	5.5	51900	1100-6000	600	280	4200*1600*1450	3800*820*1450	8.00
SAR 250 (*)	250	100-1000	11.0	93600	1800-8000	700	300	4880*1813*1785	4070*860*1785	17.50
SAR 500 (*)	500	100-1000	15.0	124000	1800-8000	800	300	5800*1400*2000	5000*1000*2000	28.00

Notes:

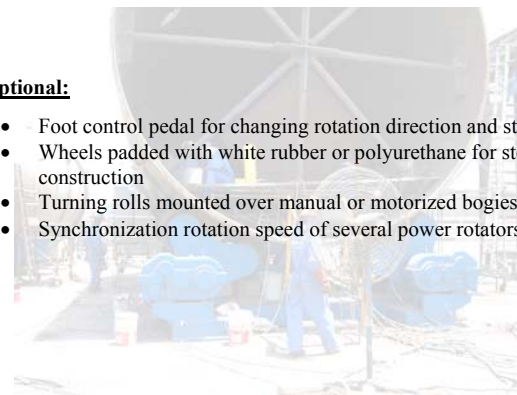
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|--|---|
| <p>a) Variable rotation speed from 100 to 1000 mm/min: included</p> <p>b) Wheels padded with heavy duty rubber: Included on models SAR 100 and smaller</p> <p>c) Remote control box with 12 m span: included, and allows adjustment of rotating speed –digital display in mm/min-, forward and reverse rotation, and stop</p> <p>d) Auto adjusted tilt angle of roller bed as per diameter of work piece</p> | <p>e) Shot blasted frame at SA 2 ½: included</p> <p>f) Variable Frequency Driver (VFD) made by Teco Westinghouse</p> <p>g) Custom built welding rotators: available</p> <p>h) CE mark available only under customer request</p> <p>i) Models marked with (*) have two motors, others only one</p> <p>j) The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include. Latest revision available in English on line</p> |
|--|---|

Standard package includes

- One power roll with control box
- One idler roll
- Operation manual
- One year warranty

Optional:

- Foot control pedal for changing rotation direction and stop
- Wheels padded with white rubber or polyurethane for steel tank construction
- Turning rolls mounted over manual or motorized bogies
- Synchronization rotation speed of several power rotators



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Welding Rotator Chain Type, CWR Series



Welding Rotators Chain Type, CWR Series are used for thin thickness vessels' applications. Chain rubber covered available for stainless application

Standard package includes: a) One power roll with control box and 6.00 meters long remote control for adjusting of rotating speed, stop, forward, and reverse. Digital speed indicator set for mm/min is included, b) One idler roll, c) Operation manual, d) One year guaranty.

Optional: a) Chain rubber covered, b) Foot control pedal for control forward, stop and reverse rotation; c) Rolls mounted over manual or motorized bogies

Model	Load & Rotation Capacity (tons)	Speed (mm/min)	Power (kW)	Driving Moment (Newtons – m)	Vessel Diameter (mm)	Wheel (mm)		Dimensions L*W*H (mm)		Weight (tons)
						Diam	Width	Power Roll	Idler Roll	
CWR -40	40	100-1000	2.20	13903	3200-3900	350	180	2980*1000*720	2980*600*720	5.00

Notes: a) Power rotator capacity 40 ton, load capacity 10 tons, b) Idler Rotator load capacity: 10 tons, c) Full set for 40 tons: 1 Power + 3 Idlers, d) Center to center distance between wheels: 2.40 m. Vessel on range above rest over chain only, e) Custom built Welding Rotators available

Pipe Rotator, PR Series



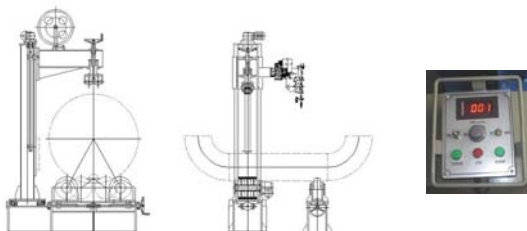
Pipe Rotators with assisting pressure column are used for handle high eccentric load.

Technical Information: a) Manual screw adjustment device to modify center to center wheel distance in both power and idler rolls, b) Column turning: $\pm 90^\circ$ (manual), c) Working height (floor to roll wheels): ~ 650 mm, d) Lifting speed: 145 mm/min, e) Elevation Power: 0.55 KW, f) Dimensions and weight subject to change without notice.

Standard package includes: a) One power roll with control box and 6.00 meters long remote control for adjustment of rotating speed, stop, forward, and reverse. Digital speed indicator set for mm/min is included, b) One idler roll, c) Operation manual, d) One year guaranty.

Model	Load & Rotation Capacity (tons)	Speed (mm/min)	Power (kW)	Pipe Diameter (mm)	Assist Pressure (kgs)	Dimensions L*W*H (mm)	Weight (tons)
PR-5	5	100 -1000	0.75	50 – 600	≤ 450	1500*1200*1800	1.25
PR-5L	5	100 -1000	0.75	100 – 1200	≤ 450	1500*1200*2300	2.50
PR-10	10	100 -1000	1.10	50 – 600	≤ 450	1900*1500*1800	3.00
PR-10L	10	100 -1000	1.10	100 – 1200	≤ 450	1900*1500*2300	5.00

Optional:



- Foot control pedal for control forward, stop and reverse rotation
- Positioning devices for welding (**NOT** included welding equipment): i) Wire reel and mountings, Irizar made, ii) Manual device for vertical and horizontal on circumferential seams. Vertical within the pipe diameter range. Horizontal for reach up to 750 mm from column center, iii) Manual or electric cross slide for fine adjustments both vertical and horizontal, iv) Support for mounting Lincoln wire feeder control NA 3S, v) Support for mounting Lincoln welding head NA 3S

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Longitudinal Seam Welders, LSW Series

Seam Welders, Longitudinal Seam Welders, Girth Seam Welders, Welding Seamers,
Seam Welds, Stake Bed Welders, Horn Welders, Flat Sheet Welders



Model	Welding Length		Vessel Diameter Range (mm)		Welding Speed (mm/min)	Welding thickness (mm)	Travel accuracy (mm/m)	Dimensions L*W*H (mm)	Weight (tons)
	Net (mm)	min-max (mm)	Inside Seam Weld	Outside Seam Weld					
LSW 500	500	700-1200	1400-2400	130-800	150-1500	0.2-6	± 0.2	1350*660*1400	0.7
LSW 1000	1,000	700-1700	1400-2400	150-800	150-1500	0.2-6	± 0.2	1700*660*1800	2.1
LSW 1500	1,500	700-2200	1400-2400	180-1000	150-1500	0.4-6	± 0.2	2500*800*2100	2.3
LSW 2000	2,000	750-2750	1400-2400	250-1000	150-1500	0.4-6	± 0.3	3100*900*2100	2.5
LSW 2500	2,500	800-3300	1400-2400	300-1000	150-1500	0.5-6	± 0.3	3700*900*2200	3.0
LSW 3000	3,000	1000-4000	1400-2400	340-1200	150-1500	0.5-6	± 0.3	4200*1000*2200	3.4
LSW 3500	3,500	1000-4500	1400-2400	400-1200	150-1500	1-8	± 0.4	4800*1000*2200	4.0
LSW 4000	4,000	1100-5100	1400-2400	450-1200	150-1500	1-8	± 0.4	5730*1200*2300	5.3
LSW 5000	5,000	1150-6150	1400-2400	500-1500	150-1500	1-10	± 0.5	7000*1250*2700	10.0
LSW 6000	6,000	====	1400-2400	500-1500	150-1500	====	====	====	====

Standard package includes: Longitudinal Seam Welder, Operation Manual, One year warranty.

Notes: a) Hold down fingers clamping force up to 25 kg/cm, b) Cooper back up mandrel with water cooling, c) Traveling carriage speed adjust is inverter control, d) Manual welding head cross slide, e) Shot blasted frame at SA 2 ½ before being painted, f) Custom built seam welders available, g) The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include. Latest revision available on line.

Circumferential Seam Welders CSW Series



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Welding Positioners, WP & AH-WP Series

Welding Positioners, Turntables (Turning Tables), Tool positioners, Pipe Welding Positioners, Head & Tail Stocks, Positionneur de Soudage, Posicionadores de Soldadura, Posicionadores para Soldadura, Platos Giratorios de Soldadura, Mesas Rotativas, Mesas Giratorias, роликовые вращатели.



Standard package includes:

- Welding Positioner with control box
- Remote control with span of 6.00 meters
- Operation manual
- One year warranty

WP Series, Fixed height

AH-WP Series, Adjustable height

WP Series (fixed height) Model	Load Cap.(tons)	Power (kW)	Gravity Center (mm)	Eccentricity (mm)	Table			Max Rotation Ø (mm) @ 90°	Driving Moment Newtons-meter		Tilt Angle (°)	Dimensions L*W*H (mm)	Weight (tons)
					Speed (RPM)		Diameter (mm)		Rotation	Tilt			
					Rotation (variable)	Tilt (constant)							
WP 0.3	0.30	0.37	200	150	0.10 -1.0	manual	600	800	529	705	0-90	930*660*720	0.30
WP 0.6	0.60	1.50	200	150	0.10 -1.0	1.10	1000	1500	1058	1764	0-90	1200*900*850	0.70
WP 1	1.00	2.70	250	200	0.05 -0.5	0.67	1200	2000	2352	2940	0-120	1400*1200*1200	1.00
WP 3	3.00	3.70	300	200	0.05 -0.5	0.23	1400	2100	7056	10584	0-120	2100*1500*1350	3.50
WP 5	5.00	5.20	300	200	0.05 -0.5	0.14	1500	2500	11760	17640	0-120	2200*1500*1450	5.00
WP 10	10.0	8.50	400	200	0.02 -0.2	0.14	2000	3200	23520	47040	0-120	2700*2000*1850	9.00
WP 20	20.0	13.0	600	200	0.015 -0.15	0.20	2300	3000	47040	94080	0-120	3300*2230*2000	15.0

Notes:

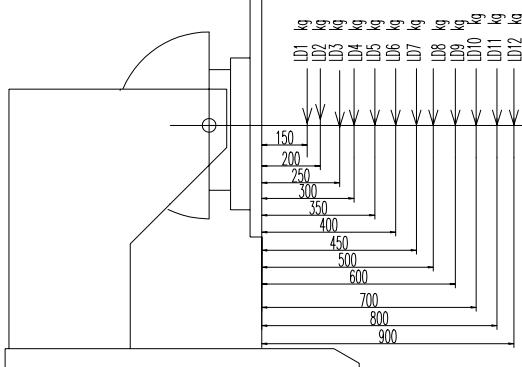
- Positoner sheets capacity see tables below
- Control cabinet includes: power indicator, speed indicator, speed adjustment, overturn (tilt) up and down, forward and reverse rotation, stop, fault & reset
- Remote control box allows adjustment of table rotating speed (digital display in RPM/min), forward and reverse rotation, and stop
- "T" shaped channels on work table surface
- Shot blasted frame at SA 2 ½ before being painted

- Available: i) Custom built Welding positioners, ii) For rent only in North America
- For ordering an adjustable height positioner add the prefix AH. Available for models WP 5 and smaller
- The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include.

Optional: i) Foot control pedal for changing rotation direction and stop, ii) variable speed on tilt

Centroid Height Table

Weight-Kilograms VS Centroid Height - mm



Model	WP 0.3	WP 0.6	WP 1	WP 3	WP 5	WP 10	WP 20
Capacity (tons)	0.3	0.6	1	3	5	10	20
Gravity Center (mm)	200	200	250	300	300	400	400
LD1, kg	-	-	-	-	-	-	-
LD2, kg	300	600	-	-	-	-	-
LD3, kg	240	480	1000	-	-	-	-
LD4, kg	200	400	833	3000	5000	-	-
LD5, kg	170	340	715	2571	4286	-	-
LD6, kg	150	300	625	2250	3750	10000	-
LD7, kg	-	260	555	2000	3333	8888	-
LD8, kg	-	240	500	1800	3000	8000	-
LD9, kg	-	-	415	1500	2500	6666	20000
LD10, kg	-	-	355	1285	2142	5714	17142
LD11, kg	-	-	-	1125	1875	5000	15000
LD12, kg	-	-	-	-	1666	4444	13333



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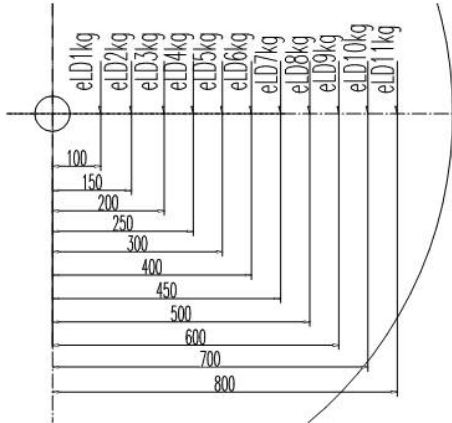
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Centroid Eccentricity Table

Weight-Kilograms VS Centroid Eccentricity- mm



Model	WP 0.3	WP 0.6	WP 1	WP 3	WP 5	WP 10	WP 20
Capacity (tons)	0.3	0.6	1	3	5	10	20
Eccentricity (mm)	150	150	200	200	200	200	200
eLD1, kg	-	-	-	-	-	-	-
eLD2, kg	300	600	-	-	-	-	-
eLD3, kg	225	450	1000	3000	5000	10000	20000
eLD4, kg	180	360	800	2400	4000	8000	16000
eLD5, kg	150	300	666	1998	3333	6666	13332
eLD6, kg	112	224	500	1500	2500	5000	10000
eLD7, kg		200	444	1333	2222	4444	8888
eLD8, kg			400	1200	2000	4000	8000
eLD9, kg				1000	1666	3332	6664
eLD10, kg					1428	2856	5712
eLD11, kg						2500	5000



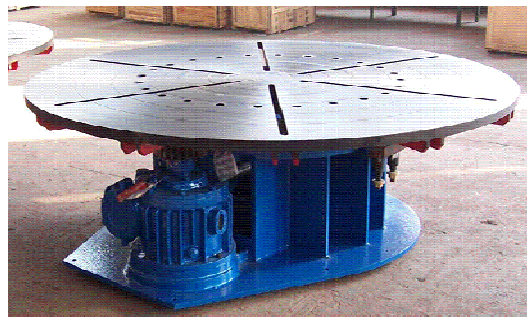
Overload or misuse of a Welding Positioner can cause PROPERTY DAMAGE, BODY INJURE OR DEATH. Before selecting or operating read carefully and understand the information contained on the sheets above. If you have any questions or concerns, please contact us @ 1 877 IRIZAR1 or jirizar@jirizar.com

Head & Tail Stock, HT Series



Head & Tail Stock HT Series Model	Load Cap. (tons)	Table Diameter (mm)	Rotation Center (mm)	Rotation Speed (RPM)	Power (kW)	Weight (tons)
HT 0.5	0.5	800	800	1.50	0.75	1.00
HT 1	1	800	800	1.50	0.75	1.50
HT 3	3	800	800	1.50	1.10	3.20
HT 5	5	800	800	1.50	1.50	5.10
HT 7.5	7.5	1000	1000	1.00	1.50	8.0
HT 10	10.0	1000	1000	1.00	2.20	10.0
HT 15	15.0	1000	1000	1.00	3.70	13.0
HT 20	20.0	1000	1000	1.00	3.70	14.0

Turntables, TT Series



TurnTables TT Series Model	Load Cap. (tons)	Table Diameter (mm)	Table height (mm)	Rotation Speed Variable (RPM)	Power (kW)	Weight (tons)
TT 0.5	0.5	750	600	0.1-1	0.37	0.86
TT 1	1	1000	600	0.1-1	0.55	1.20
TT 3	3	1500	600	0.05-0.5	0.55	2.50
TT 5	5	1500	600	0.05-0.5	0.75	5.00
TT 9	9	1500	600	0.05-0.5	1.10	6.80
TT 18	18	1800	750	0.05-0.5	2.20	7.50
TT 50	50	2500	750	0.05-0.5	4.00	9.30
TT 100	100	2900	800	0.03-0.30	7.50	15.0



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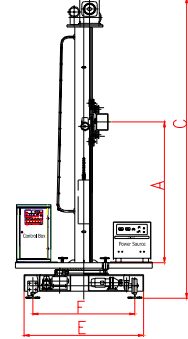
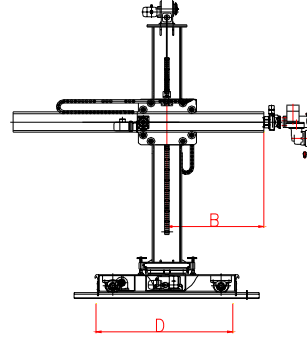
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Welding Manipulators, WM Series

Welding Manipulators, Welding Head Manipulators, Column and Boom Manipulators, Welding Booms, Industrial Manipulators



Model	Boom						Column		Trolley			Power (kW)	Estimated Packing Dimensions (Column & Boom) L*W*H (m)	Weight (tons)	
	(A) Vertical expansion (m)		(B) Horizontal expansion (m)	Lifting speed (m/min)	Expansion variable speed (m/min)	Traveling precision speed (%)	Max load at boom extremity (kgs)	Rotation Angle $\pm 180^\circ$	(C) Total height (m)	Estimated Pack Dim (D) x (E) x (H) (m)	(F) Rail ϕ to ϕ (mm)				Speed (m/min)
	Net	Min-Max													
WM 1515	1.5	0.53~2.03	1.5	0.30	0.12~1.20	$\pm 2\%$	100	manual	2.93	1.45*1.35*0.4	1052	1.50	0.91	3.00*1.20*0.50	1.50
WM 2020	2.0	0.53~2.53	2.0	0.30			100	manual	3.43	1.45*1.35*0.4	1052	1.50	0.91	3.50*1.30*0.60	2.25
WM 3030	3.0	0.75~3.75	3.0	1.00			200	motorized	5.49	2.40*1.90*0.5	1600	1.50	2.75	5.50*1.40*0.70	2.75
WM 4040	4.0	0.75~4.75	4.0	1.00			200	motorized	6.49	2.40*1.90*0.5	1600	1.50	2.75	6.50*1.50*0.80	5.50
WM 5050	5.0	1.10~6.10	5.0	0.90			300	motorized	7.80	2.40*2.10*0.5	1798	1.50	3.35	7.80*1.60*0.90	6.50
WM 6060	6.0	1.10~7.10	6.0	0.90			300	motorized	9.73	2.40*2.10*0.5	1798	1.50	3.35	9.80*1.70*1.0	7.50
WM 7060	7.0	1.20~8.20	6.0	0.90			300	motorized	10.73	3.20*2.40*0.5	2068	1.50	4.25	10.80*1.70*1.1	8.50
WM 8060	8.0	1.20~9.20	6.0	0.90			300	motorized	11.73	3.20*2.40*0.5	2068	1.50	4.25	11.80*1.70*1.2	10.00

Notes:

- Boom expansion variable speed from 0.12 to 1.20 m/min
- Boom lifting speed: see sheet above
- Column motorized rotation: included only WM 3030 and above
- Trolley motorized with constant speed: included
- Remote control box with 12 m span: included
- Manual welding head cross slide: included
- Boom cable organizer: included
- Boom anti-fall safety device on WM 3030 and above: included

- Trolley anti-fall safety device: included
- Power source platform on trolley: included
- Shot blasted frame at SA 2 1/2: included
- Custom built welding manipulators available
- CE mark only under customer request
- The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include. Latest revision available in English on line

Standard package includes

- Welding Manipulator and traveling cart
- Remote control box adjust: i) Vertical and horizontal boom movement; ii) Trolley motion
- Operation manual
- One year warranty

Optional

- Flux recovery unit
- Electric welding head cross slide
- Trolley cable organizer
- Rail track for trolley
- Variable speed on traveling cart from 0.12 up to 1.20 m/minute
- Work platform and operator's seat only in WM 5050 and larger

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Automatic Girth Welders, AGW Series

Tank Welders, 3 O' Clock Automatic Girth Welders, Circumferential Tank Welders

The AGW is a self propelled frame designed to apply efficient horizontal seam welds by means of the Submerged Arc Welding (SAW) Process. The AGW rides along the upper edge of a large diameter field storage tanks while applying inside and/or outside welding. Compared with conventional techniques, the AGW reduces construction times by 25 times and cuts welding times by 2.

Models:

Model	Description	Dimensions (mm)			Power (kW)	Weight (tons)
		L	W	H		
AGW-1	Single side horizontal tank welder	1400	1100	2900	5.0	1.90
AGW-2	Double side horizontal tank welder	1400	2200	2900	10.0	2.60

Specifications

- Traveling speed: 100 to 2,900 mm/min
- Plate's height: From 1.80 to 3.20 meters
- Plate's thickness: From 8 to 50 mm
- Tank's diameter: 5.00 meters and over

Notes

1. Irizar AGW-1 can drive hanged on upper edge of a tank, and also is easy to convert to drive on a rail floor mounted outside and around the tank, making the fixture compatible with Tank Erection Equipment (hydraulic lifting jacks)
2. To be provided by the buyer: Lincoln Power Source Idealarc DC- 600 or DC-1000
3. For Lincoln DC 600 add extra 40 kW to above table.
4. The information contained in this brochure is intended to be accurate. However the manufacturer retains the rights to make changes in design which may not be include.

Available

1. For Rent only in North America
2. Long neck AGWs for handling plates up to 5.00 m height
3. Stainless steel rollers suitable for stainless and cryogenic tank welding
4. Custom built AGWs to fit in dual LNG shells
5. Training at our Alberta Facility in Canada as well as at job site World Wide

Standard package includes

- ✓ Heavy duty motorized carriage
- ✓ IRIZAR wire feeder (equivalent to Lincoln NA-3S), wire reel and wire straightened
- ✓ Operator platform including seat, motorized frame, frequency inverter and control box with digital display for welding
- ✓ Manual welding head cross slide (100 mm horizontal x 100 mm vertical)
- ✓ Flux recovery system: Heavy duty flux recovery unit with blower and filter, flux belt assembly with large diameter steel rollers, flux primary separator tank, hose and flux pick up tools, flux vacuum and flux lifting pulley (100 kilograms @ 25 m of the ground)
- ✓ Aux-power supply system
- ✓ Control cables: 60 m
- ✓ Laser pointer on welding head for easy wire positioning
- ✓ Weather proof electrical cabinet
- ✓ Power source storage: 1300 mm (L)*1100 mm (W) *1400 mm (H), @ 260 Kg
- ✓ Operation manual
- ✓ Electric diagram
- ✓ One year warranty



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Three rolls Plate Bending Machines, IRIZAR Series

Bending Rolling Machine, Three Rolls Coiling Machine, Plate Rolling Machine, Three Rolls Hydraulic Rolling Machine



Model (A)	Pre-bending Capacity (mm)	Span (mm)	Top roller Pressure (tons)	Rollers Diameter (mm)		ϕ to ϕ distance of lower rollers (mm)	Power (kW)			Dimensions L*W*H (m)	Weight (tons)
				Top roller (B)	Lower rollers		Lower roller	Hydraulic	Shifting		
IRIZAR 9.50×3000	7	3000	55	275	145	200	5.5	4.0	0.75	4.20*1.25*1.65	8
IRIZAR 10.5×3000	8	3000	65	280	145	200	5.5	4.0	0.75	4.20*1.25*1.65	9.2
IRIZAR 13×3000	9	3000	75	290	150	245	7.5	4.0	1.1	5.15*1.45*1.85	11.5
IRIZAR 15×3000	11	3000	100	325	165	270	15	5.5	1.5	5.15*1.45*1.85	13.5
IRIZAR 20×3000	16	3000	160	375	200	330	18.5	7.5	2.2	5.40*1.90*2.25	17
IRIZAR 22×3000	19	3000	190	400	220	360	22	7.5	4.0	5.40*1.90*2.25	17.8
IRIZAR 27×3000	22	3000	230	425	235	380	30	11	4.0	5.80*2.05*2.55	23
IRIZAR 30×3000	25	3000	280	450	250	400	37	11	4.0	6.00*2.10*2.75	24.6
IRIZAR 32×3000	28	3000	320	480	260	420	37	15	5.5	6.10*2.15*2.80	25
IRIZAR 35×3000	32	3000	380	510	275	460	45	22	5.5	6.10*2.15*2.80	32
IRIZAR 38×3000	35	3000	430	540	290	500	55	22	7.5	6.10*2.15*2.80	37
IRIZAR 40×3000	35	3000	430	540	290	500	55	22	7.5	6.20*2.58*3.10	41
IRIZAR 50×3000	45	3000	610	620	360	650	75	30	15	7.50*3.00*3.80	59
IRIZAR 60×3000	50	3000	690	650	380	700	75	30	15	7.70*3.10*3.90	68
IRIZAR 70×3000	60	3000	850	710	420	780	75	37	15	8.00*3.50*4.20	80
IRIZAR 80×3000	70	3000	1050	770	460	880	90	37	18.5	8.00*3.70*4.40	92
IRIZAR 100×3000	90	3000	1350	860	480	920	110	45	22	8.00*3.85*4.60	130
IRIZAR 115×3000	100	3000	1600	900	560	1080	132	55	30	8.55*3.85*4.60	138
IRIZAR 125×3000	110	3000	1800	960	600	1120	160	75	37	9.00*4.00*5.00	168

Notes:

- Plate Bending Rolls are CNC computer controlled. Top roller is hydraulic and all directional adjusted. Lower rollers driven by mechanical through gear box. Upper rollers made 42CrMo, HB241-286. Lower Rollers # 45 steel quenched
- Capacities based on plate yield point limit: 245 MPa
- Bending speed: 3 ~ 3.5 m/min
- Min. inside diameter at full span: 2.5 ~ 3 × top roller diameter. See (B) above table.
- Pre-bending capacity is the max thickness capable to bend the machine at full span when rolling a circle. If bending a segment take (A) from above table
- Flat end after bending: 2.5 ~ 3 × plate thickness
- Frame shot blasted at SA 2 ½
- Custom built plate bending machines available
- The information contained in this brochure is intended to be accurate. However the Manufacturer retains the rights to make changes in design which may not be include

Standard package includes:

- Plate Bending Machine
- Foundation drawings
- Operation manual
- One year warranty

Optional:

- Feeding tables
- Cone bending device

Bending Flow:



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TANK JACKING EQUIPMENT, HLJ SERIES

Also known as Hydraulic Lifting Jacks, Tank Erection Equipment, Lift Jacks Hydraulic System



TANK JACKING SYSTEM IS SAFE, SIMPLE AND COST-EFFECTIVE

Advantages:

- Tank erection from top downwards shorter erection time, break the cost and improves the quality
- Work is done at ground level. Telescopic cranes are not longer required
- Safe for lifting and safe for job site workers. Accidents risk are reduced due to scaffolding is not longer needed
- Simple set up, operation and dismantle
- Flexible: Jacking equipment can split for erection of two smaller tanks or expanded for built larger tanks by means of adding extra jacks/trestles and/or power pack combined with the existing one
- Low maintenance required
- Work is practically unaffected by rain, snow, hail, and wind because it can be carried out under the protection of the tank itself. Welding takes place mainly under cover.
- Jacking System can be used for construction of new tanks, dismantling of tanks, replacing tank base or foundation repair, and increasing tank capacity

Operation: Jacks are connected to a common peripheral hydraulic circuit of high-pressure hoses, and operated from an electric pump unit (power pack) which works with repeated climbs of 10 cm. Each climb is retracted mating to consequent plate ring is achieved by controlled return of the previously made climb

Experience: Our Jacking System has been used for the erection of more than 2,000 tanks, up to 80 m in diameter and 1900 tons of lifting weight, on oil refineries, petrochemical plants, fertiliser plants, power generating stations, petroleum product installations & depots, and at liquid storage terminals at ports.

WORKING PRINCIPLE

- The tank foundation is made ready. Base plates are laid out and welded.
- The periphery of the tank is marked out on the base plates. Guide members for shell plates are erected.
- The top shell plates are erected and welded vertically. The roof trusses are assembled and joined to the top shell plate.
- Lifting trestles with hydraulic jacks are fitted internally along the periphery of the tank. The number of jacks required is determined by the size and weight of the tank. Stability calculations are carried out while determining the number of jacks to be deployed.

- Lifting lugs and guide lugs (fend-off lugs) are welded to the shell plates.
- The hydraulic jacks are connected in series by means of high pressure hoses and are connected to a high pressure pump from which all jacks are jointly served. A slipper with a lifting arm transfers the fitting power over a lifting lug welded to the shell plate.
- The top shell plate and roof construction are lifted one plate height. The slipper engages a guide lug and thus keeps the shell ring in the correct position during the hosting operation.
- The roof plates are fitted and welded in place. At the same time, the next shell plates are fitted and welded.
- The lifting lugs and guide lugs are removed from the top shell plate and are welded to the next shell plate. The hydraulic jacks are lowered to the original lifting position.
- The tank is lifted again to allow the continued erection of shell plates until the full height of the tank has been reached.
- When the last shell plate is fitted and welded in place, the finished tank is lifted slightly so that the guide members can be dismantled.
- The tank is lowered; the shell plates and the base plate are welded together.
- The jacking equipment is dismantled.

Jacks/Trestles Specifications:

Description	Model	HLJ 12	HLJ 18	HLJ 25
Working capacity (metric tons)		12	18	25
Testing load (tons)		18	27	37.5
Retracting system		spring	spring	double action
Plate thickness range (mm)		6 – 40 (See note #2)	8 and above	
Arc between jacks/trestles (m)		1.80 Min to 3.00 Max (See note 3)		
Max lifting plate height (m)		2.50 or 3.00 (See note # 4)		
Min lifting plate height (m)		1.40 m (See note # 5)		
Min soil bearing capacity (N/mm ²)		1.45 (See note # 6)		
Unitary climbs (cm/stroke)		10		
Time per stroke (minutes)		Approx 5		
Working pressure (kp/cm ²)		160		

Notes:

- Jacks **must not exceed** working capacity at any time
- Thickness plate less than 6.00 mm some restrictions apply. Contact technical support
- Arc spacing between jacks/trestles **must not exceed** 3.00 m otherwise some restrictions apply. Contact technical support
- Available trestles to handle plated height up to 2.50 and 3.00 m
- If spacer beams of 0.575 m height are used above tank bottom
- Soil bearing capacity just below the trestle base plate **must be** more than 1.45 N/mm² otherwise contact technical support.
- Tank height **must not exceed** tank diameter otherwise some restrictions apply. Contact technical support
- Available: a) Available equipment for rent, b) Training Facility in Alberta Canada and at job site World Wide



SHORT REFERENCE LIST

CANADA

Abraxus Construction Group Inc
Edmonton, AB
ADM Stainless Inc
Toronto, ON
Alberta Pipe & Vessels Ltd
Calgary, AB
All Pro Services Ltd
Port Coquitlam, BC
Alstom Canada Inc
Edmonton, AB
AnMar Mechanical Contractors Ltd
Lively, ON
Argo Sales Ltd
Calgary, AB
Atelier Gérard Beaulieu Inc
Saint-Quentin, NB
Axtion Incorporated
Delta, BC
Bromley Mechanical Services (1985)
Medecine Hat, AB
Brospec (2001) Inc
Quebec, QC
BWS Fabrication Inc
Red Deer, AB
Cimco Refrigeration Ltd
Toronto, ON
Construction LFG Inc
St Omer, QC
Cullicutt Energy Services Inc
Red Deer, AB
Derksen Mechanical Services Inc
Winnipeg, MB
Dodec Industries Inc
Chicoutimi, QC
Dow Chemical Canada Inc
Fort Sask, AB
Ebco Industries Ltd
Richmond, BC
Ellery Manufacturing Ltd
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EMW Ltd
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Fourstar Resources Inc
Nisku, AB
Fusion Production System Inc
Red Deer, AB
Henry Technologies Limited
Brantford, ON
Hooper Welding Enterprises Ltd
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Huge L Steel Inc
Regina, SK
JNE Welding Ltd
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Mactronic Enerflex Ltd
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Opsco Energy Industries Ltd
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Precision Steel & Manufacturing Ltd
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SaskArc Industries Inc
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Soudure Industrielle Du Richelieu Inc
Sorel-Tracy, QC
Stadco Industries Ltd
Calgary, AB
The Tank Shop Inc
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Thermo Design Engineering Ltd
Edmonton, AB
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UNITED STATES

Addison Fabricators Inc	Addison, AL
American Heating Inc	Portland, OR
ASC Process Systems Inc	Sylmar, CA
Bigbee Steel and Tank Co	Manheim, PA
Bird Equipment Llc	Burns Flat, OK
FWT Inc	Fortworth, TX
Gemstar Inc	Odessa, TX
Global Fab Inc	Hortonville, WI
Harris Thermal Transfer Products Inc	Newberg, OR
Highland Tank & Mfg. Co	Manheim, PA
Kobelco EDTI Compressors Inc	Corana, CA
Kvaerner Philadelphia Shipyard	Philadelphia, PA
Melco Steel Inc	Azusa, CA
Metal Services Group	Irwindale, CA
Mining Control Inc	Beckley, WV
Mitrowski Welding Equipment Ltd	Houston, TX
Palmer of Texas	Andrews, TX
Polytech Metals & Fabrication LLC	Tucson, AZ
Rockwood Corporation	Syracuse, NY
Skyline Steel Llc	Carterfield, GA
Skyline Steel Llc	Granite Falls, WA
Stainless Tank, Inc	Chattanooga, TN
Texas Welders Supply Co	Houston, TX
Universal Industries Sales Inc	Grove, UT
Val-Fab Inc	Neenah, WI
Westmor Criogenic Services	La Porte, TX
WM. A. Schmidt & Sons Inc	Chester, PA

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Burntisland Fabrications Ltd	Scotland, UK
Dukon Machine Trading Group	Moscow, Russia
Ekme S.A	Thessaloniki, Greece
Globalstroy-Engeneering PJSC	Moscow, Russia
JSC "Baltiysky Zavod"	Saint Petersburg, Russia
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Ingenieria Tizayuca S.A
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Hermosillo, Mexico
Quito, Ecuador
Queretaro, México
Santa Fe, Argentina
Nuevo León, México
Esperanza, Argentina
Queretaro, México
Lima Peru
Fortaleza, Brazil
México City, México
D.F, México
Ceará, Brasil
Huehuetoca, México
Montevideo, Uruguay
Caracas, Venezuela
Nuevo León, México

MIDDLE EAST

Al Ninr Machinery W. L.L
Consolidate Contractors Int Co SAL
Cylingas Co Ltd
Group Five Pipe
Maritime Industrial Services Co Ltd
Maritime Industrial Services Co Ltd
Metscco Steel Construction Co Ltd
Oil & Gas Construction Factory LLC
Olayan Descon Engineering Co
PGI Construction (L.L.C)
Saed Saleh Adulah Trading Est
Teyseer Trading and Contracting Co

Doha, Qatar
Dubai, UAE
Dubai, UAE
Damman, Saudi Arabia
Jubail, Saudi Arabia
Sharjah, UAE
Riyadh, Saudi Arabia
Abu Dhabi, UAE
Yanbu, Saudi Arabia
Dubai, UAE
Juabil, Saudi Arabia
Doha, Qatar

ASIA

Construction Company of Sinopec
Ecoscience Engineering Sdn Bhd
Fauji Fertilizer Company Ltd
G.R. Engineering Private Ltd
Hindustan Petroleum Corporation Ltd
Indian Oil Corporation Ltd
PT Tira Austenite Tbk
Unimit Engineering Public Co Ltd

China
Gudang, Malaysia
Ghotki, Pakistan
Mumbai, India
Mumbai, India
Mumbai, India
Jakarta, Indonesia
Samutprakarn, Thailand

AFRICA

Batpro S.A (Cimelta Madagascar)
BroKrewindustrial (Pty) Ltd
Companhia de Engenharia Angola S.A
Elca Engineering Co Pty
Frezone Plant Fabrication Int. Ltd
Hi Tech Pressure Engineering Ltd
Randgold Resources
Senet
Terramite CC

Antananarivo, Madagascar
Factoria K, South Africa
Luanda, Angola
Vanderbijlpark, South Africa
Lagos, Nigeria
Rossburgh, South Africa
Abdijan, Cote D'Ivoire
Edenglen, South Africa
Rossburgh, South Africa

OCEANIA

Culham Engineering Company Ltd
East Cost Development Eng Ptd
HRT Enterprises
J. Furphy & Sons Pty Ltd
ProTube Asia Pty Ltd

Whangarei, New Zealand
Mararrie, Australia
North McLean Q, Australia
Shepparton, Australia
Kent Town, Australia

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