



GULLCO



KAT Oscillation carriage combination welding overhead on Scottish bridge construction.

THE PROJECT

The M74 completion project will complete a vital part of the west of Scotland's motorway network with a new eight kilometres (five miles) stretch of road continuing the M74 from Fullarton Road Junction, near Carmyle to the M8 motorway west of the Kingston Bridge. This project is part of a massive infrastructure investment in Scotland's transport network which includes a new rail link to Glasgow airport, a new rail link between Airdrie in the West and Bathgate in the East, and further improvements to the central Scotland motorway network. The M74 project is a partnership project between Transport Scotland, Glasgow City Council, South Lanarkshire Council and Renfrewshire Council.

THE APPLICATION

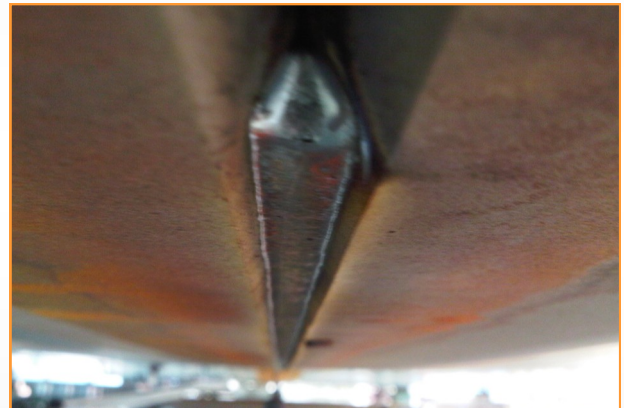
At first Cleveland Bridge approached Gullco to automate/mechanise the overhead welding of short welds in the workshop to eliminate the need to turn large beams risking twisting and bending of the beam as well as saving time. This was successful and the process was to be repeated on site where the need to automate was even greater with a large quantity of overhead welds to be performed on joints many meters in length. The welds are partial penetration butt joints of various depths from 15mm to 20mm on plates 50mm to 85mm thick with the first and second passes made in one run and thereafter split weaves to suit the joint.

PRODUCT CASE STUDY FILE

Overhead Welding (4G) with KAT® Oscillator Combination

THE PARAMETERS

- Travel speed: 22cm/min
- Arc Voltage: 24
- Amperage: 210
- Torch Angle: 5° - 10° pull
- Oscillation: root none, thereafter 4mm
- Side Dwells: none



THE CHALLENGE

The brief was to use welding machines already in the possession of Cleveland Bridge, which is in line with Gullco policy as Gullco do not manufacture or supply welding machines, leaving the supply of such parts to their local distributor.

In addition the following was used:-

- Gullco Kat Oscillator Combination running on rigid track (flexi track also available)
 - 1.2mm diameter gas shielded rutile flux cored wire
 - Gas: Argon 80% CO2 20%
- Cleveland Bridge are using 3 Kat® oscillator packages on a continuous basis on site in Glasgow.

Trevor Powley from Cleveland Bridge said: *"We are very happy with the Gullco product as well as after sales service and on site welder training"*.

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