

Wel-Handy Multi

Multi-Purpose Mechanized Welding Carriage



Portable Welding Automation

Automation of welding not only improves quality and production times, it saves money in measurable ways that are very often overlooked. Welding wire and shield gas use are greatly reduced. Working conditions are improved for the welder by reducing fatigue, fumes and sparks. Wel-Handy Multi portable welding carriages are used by a wide range of customers, from one man mobile welding businesses to large shipyards with hundreds of welders.

Features & Benefits

- **Two Models Available**
Standard and Programmable
Stitch/Tack
- **Multi Weld Process**
Standard and Programmable
Stitch/Tack
- **Multiple Welding Options**
Twin-Torch, Weaver/ Oscillator,
Corner Welding
- **Horizontal and Vertical Use**
Base machines can be used for
out-of-position welds
- **Light Weight at 7kgs (15lbs)**
Makes transport and set-up easier
- **Pulling Power of 30kgs (66lbs)**
Provides stable welding even under
heavy loads
- **No Track Required**
Fillet welds and corner joints can
be done without the need for track.
Butt and Lap Joints are possible by
using angle iron as a guide
- **Permanent Magnet**
Rare earth magnet holds unit secure
to the work piece without the need for
electricity
- **Multiple Weld Positions**
Horizontal, overhead, and vertical welds



KOIKE ARONSON, INC. / RANSOME

Lightweight, Compact, Welding Carriage

Easy Set Up

No guide rails means fast and easy setup. In most cases existing welding equipment can be used.

Automatic Height Control

The Wel-Handy Multi runs directly on the work piece. On a fillet weld this keeps the contact tube to work distance set without the need for a torch height control.

Automatic Shut Down at the end of the weld

Limit switches at each end of the carriage allow the operator to set up a pre-determined stop point using a magnetic block. Once the limit is tripped, the machine travel and welding stops.

Standard Features on All Carriages

- A solid aluminum body design makes for a lightweight and durable machine
- Use on steel, stainless steel and aluminum plate in horizontal position
- Vertical weld position use, when steel base plate is min 25mm (1in) thick
- Wide range of torch adjustment for flux core or solid wire use
- Various welding attachments options available

Key Features Make Setup Faster and Operation Simple



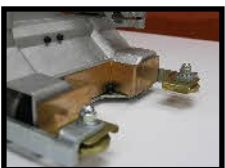
Standard Model Panel



Stitch Model Panel

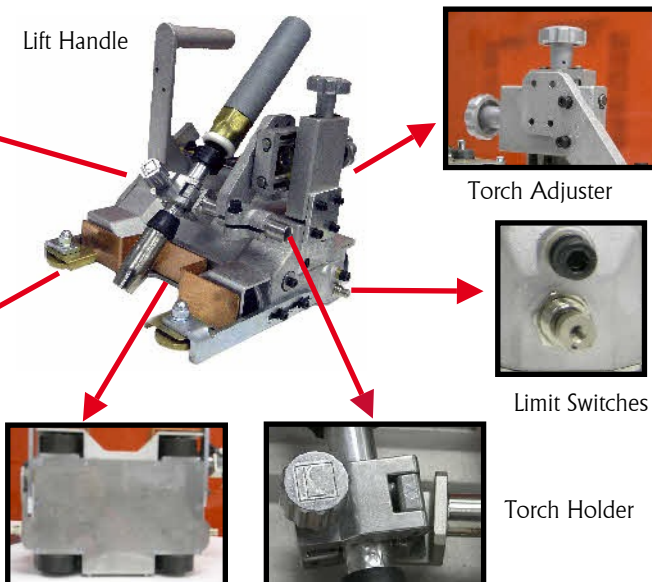


Magnet On/Off



Guide Rollers

Bottom Stainless Heat Shield All Wheel Drive System



Lift Handle



Torch Adjuster



Limit Switches



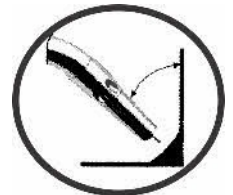
Torch Holder

Welding automation provides precise control over the below welding parameters

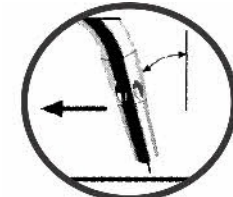
Travel Speed



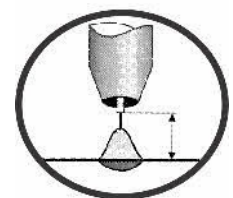
Transverse Gun Angle



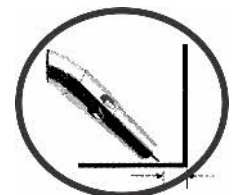
Gun Travel Angle



Contact Tube to Work Distance



Electrode Position



One of our many customers describes Koike's portable Wel-Handy Multi carriage:

"Basically, we were able to take the hand torch from the welder and mount it on the carriage. It was really that simple! We were able to use the same welding settings, only now the welder was able to concentrate on the actual weld without becoming fatigued. The most obvious increase in production was the amount of weld that was done in a day. The same welder that was producing 110 feet of weld a day was now able to produce 250 to 300 feet of weld a day." Miller Marine Inc.

Options



WU-1 Weaver (torch oscillator)
Part#BUH21007,
BUH21008

The WU-1 weaver option can be used with the Standard or Stitch models. The WU-1 can also be used as a stand alone weaver (oscillator) or on a welding manipulator .

Weaving functions include: weave width, oscillator frequency, torch dwell (left, center and right) and torch origin control. Settings can be stored in memory and can be changed during operation.



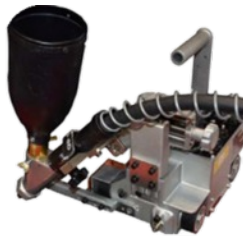
Twin Torch Part#: 61001071

The Twin Torch option features dual torch holders for welding both sides of a vertical plate (rib or stiffener). May be used with the Wel-Handy Multi Standard or Stitch model. Easy to set up with two welding guns. Torch slides are designed to allow optimum torch positioning.



Corner Welding Kit
Part# 1115109500

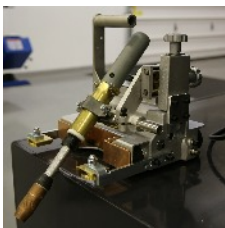
The corner welding kit option is designed for building custom box beams or can be used in any application where an edge of a plate can be followed. Lapp joints and butt joints can be accomplished by using the plate edge as the guide. Therefore the need for track is eliminated. The included welding arm set allows a wide range of welding torch positions to be archived.



Sub-arc Torch Kit
Part#WHMSUBL15
(Lincoln)
Part#WHMSUBM15
(Miller)

Several options are available for a sub arc use with wire sizes ranging from 1/16 to 3/32 in. Applications that previously may have been unachievable using larger

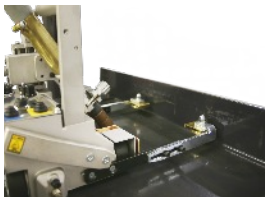
and heavier mechanized system can now be accomplished with this compact sub arc welding option. The Sub Arc Torch Option can be used together with the Corner Welding Kit.



Large Torch Holder Kit
Part# 1115992900

The large torch holder option allows the use of larger diameter torches such as a machine torch, water cooled torch or models with fume extraction capabilities. A machine plasma torch can also be added to the machine for gouging or cutting.

Allows 30 ~ 45mm (1 1/8 ~ 1 3/4 in) torch diameter use.

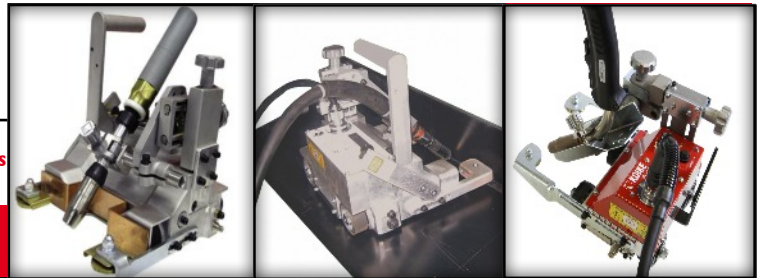



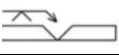






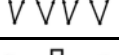



Guide Wheel Extension Bracket
Part#K115976300

Guide wheel extensions allow moving the guide rollers further away from the machine. These extensions position the machine and torch further away from the edge of

the plate. They are useful for performing lapp joints and butt joints. These extension can be extremely useful when combined with the Corner Welding Kit to reach into difficult welding positions.

Wel-Handy Multi Series
Application Guide



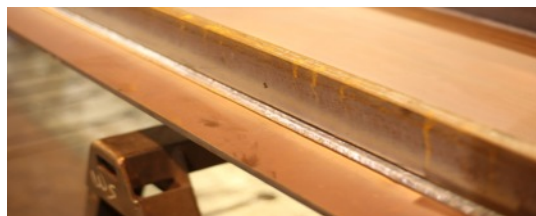
Type of Application	Wel-Handy Multi Standard Part# 61000705	Wel-Handy Multi Stitch Part# 61001072	Wel-Handy Multi Mini V Part# 61005824
Fillet Weld 	x	x	x
Butt Weld 	x	x	x
Stitch 	-	x	-
Vertical Weld 	x	x	x
Horizontal Position 	x	x	x
Overhead Position 	x	x	x
Out of Position 	Add Corner Kit + Guide Roller Extension	Add + Corner Kit + Guide Roller Extension	-
Contour Weld 	Add Follower Kit or Magnetic Wheel Kit	Add + Follower Kit or Magnetic Wheel Kit	Add Magnetic Wheel Kit
Oscillation 	Add WU-1 Weaver	Add + WU-1 Weaver	
Dual Pass 	Add Twin Torch	Add + Twin Torch	
Overhanging Weld 	Add + Guide Wheel Extension Bracket	Add + Guide Wheel Extension Bracket	Add Guide Wheel Extension Bracket
Sub-Arc 	Add + Miller Subarc Kit or Large Torch Holder	Add + Miller Subarc Kit or Large torch holder	Add Miller Subarc Kit or Large torch holder

Follower Kit: 1115109100

Miller SubArc Kit: WHMSUBM15

Magnetic Wheel Kit: 1138520400

Lincoln SubArc Kit: WHMSUBL15



Perform consistent welds every time no matter what your experience is. With constant tip to work distance being automatically configured by the machine; the only thing to monitor is your wire feed rate and your carriage speed.

WEL-HANDY MULTI CARRIAGE TYPES				WEL-HANDY MULTI OPTIONS			
SPECIFICATIONS	STANDARD		STITCH	SPECIFICATIONS	WU-1 WEAVER	TWIN TORCH OPTION	
Part Number	61000705	61002052	61001072	Part Number(s)	BUH21007 & BUH21008	61001071	6100478401
Input Power	120 Volt	220 Volt	120 ~ 220 Volt	Input Power	120 Volt	120 Volt	220 Volt
Standard Machine Connection	Lincoln Electric® Connection Standard Miller Electric® Connection Adapter Available			Weight	2.2kg (5.0lb)	16.1kg (35.7lb)	
Weight	6.9kg (15.2lb)		6.8kg (15.0lb)	Dimensions L x W x H	175 x 85 x 230mm (7.0 x 3.4 x 9.0in)	513 x 280 x 642mm (20.2 x 11.0 x 25.3in)	
Dimensions L x W x H	259 x 259 x 264mm (10.2 x 10.2 x 10.4in.)			Operating Panel Controls	1. Start/Stop 2. Direction 3. Travel Speed 4. Arc Test/Jog/Run	N/A	
Pulling Power	30 kg (66 lb.)			SPECIFICATIONS	CORNER WELDING KIT	Miller Electric® Connector Adapter	
Drive System	All Wheel Drive, attached by permanent rare earth magnet			Part Number	1115109500	0868583600	
Travel Speed	152~1524mm/min (6~60 in/min)			Dimensions L x W x H	254 x 357 x 152 mm (10 x 14 x 6 in)	457 mm long (18 in long)	
Tracking Method	Automatically follow rib of fillet joint using guide rollers or optional attachments			Description	Add on kit allows tracking and positioning torch on edge of plate or box type weld. Perform fillet, lapp, and butt joint welds	Wire feeder control connector adapter. Change from Lincoln to Miller connector	
Guide Roller Height	Adjustable 10 ~ 25mm (.39~1in.)			SPECIFICATIONS	Large Torch Holder Adapter	7" Guide Wheel Extensions	
Torch Angle	0 ~ 90°			Part Number	1115992900	K115976300	
Torch Up/Down	45mm (1.77in.)			Dimensions L x W x H	Torch Dia from 30 ~ 45mm (1.187 ~ 1.75 in.)	Qty (2) 178 x 19 x 13mm (7 x .75 x .5 in)	
Torch Fwd/Bwd				Description	Allows larger torch diameters to be used for welding or cutting. Subarc torch holder	Allows positioning the carriage farther from the weld. Maybe used with Corner Welding Kit.	
Un-Welded Area	Start 124mm (5in.) / Eng 140mm (5.5in.)			SPECIFICATIONS	Subarc Kit Option		
Automatic Stop	Limit Switch on both ends of carriage - shuts off welding and machine travel			Part Number	WHMSUBM15	WHMSUBL15	
Operating Panel Controls	1. Start / Stop 2. Direction 3. Travel Speed 4. Arc Test/Jog/Run	1. Start/Stop 2. Direction 3. Travel Speed 4. Arc Test/Jog/Run 5. Digital Display (high intensity display) 6. Programming Buttons		Description	Wel-Handy Multi Miller® style connector Subarc Option, 550A @ 60% Duty 15' leads. Specify Wire Size when ordering (3/32, 5/64, 1/16)	Wel-Handy Multi Lincoln® style connector Subarc option, 550A @60% Duty 15' leads. Specify wire size when ordering (3/32, 5/64, 1/16)	
Stitch Model Parameters	1. Welding Length 10 ~ 1000mm (.4~40in.) 2. Skip Length 10 ~ 1000mm (.4~40in.) 3. Crater Fill Time 0.1 ~ 9.9 sec 4. Puddle Fill Time 0.1 ~ 9.9 sec						
WU-1 Weaving Option Parameters	1. Welding Width 3~25mm (.12~1.0 in.) 2. Weaving Cycle 3 ~ 120 /min 3. Dwell Time -(Left, Center, and Right) 0 ~ 3 sec 4. Adjust Midpoint of Weld 0 ~ 360 degree 5. Save parameters in Memory						



JQA-2093

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