



WTC MACHINERY Engineered to perform. Built to last.

WTC Machinery is a global leader in designing and building machinery and tooling for heavy equipment repair facilities.

CG-4 Grouser Welder

Overview

The CG-4 Grouser Welder features bead oscillation and a high-current 1,000 Amp Submerged-Arc welding torch for maximum weld deposit and penetration without the need for special protective gear. The standard cut-off station works with a variety of fuel gases, and track shoe handling is easy with the included air hoist. The optional Wire Barrel holder increases run time for greater productivity.



Specifications:

Maximum Pad Width:	40 (1,02 m)
Welding Torch:	1 x 1000 Amps
Standard Wire Spool Size:	Weight - 120 lb (54 kg)
Inside Diameter:	6 in to 28 in (152 mm to 712 mm)
Optional Wire Barrel Size - Weight:	1,200 lb (540 kg)
Outside Diameter:	24 in (628 mm)
Air Hoist Capacity:	500 lb (225 kg)

Electrical

Electrical Supply:	77 kW
Standard Voltages:	Three Phase 208V / 60 Hz 220V / 50 Hz 230V / 60 Hz 385V / 50 Hz 415V / 50 Hz 460V / 60 Hz

D1660 CG-4 Grouser Welder Specifications

DIMENSIONS

Main Machine

Weight 5900 lbs (2680 kg) Width (Depth) 84 inches (2,1 m)
 Length 240 inches (6,1 m) Height 105 inches (2,7 m)

Welding Power Supply

Weight ... 820 lbs (373 kg) Width (Depth) 23 inches (0,6 m)
 Length 39 inches (1,0 m) Height 31 inches (0,8 m)

Operating Temperature Range 40° to 110° F (4° to 43° C)

MAXIMUM PAD SIZE

48 inches (1,22 m) long

MACHINE SUPPLY

Compressed Air Requirement - 60 to 80 p.s.i. (4,0 to 5,4 atm) 5.0 ft³/min (0,15m³/min)

Cutting Oxygen Requirement - Regulated between 20 to 30 p.s.i. (1.2 to 1.8 atm)
 (Regulator not supplied)

Cutting Acetylene Requirement - Regulated between 5 to 10 p.s.i. (0,34 to 0,68 atm)
 (Regulator not supplied - cutting torch suitable with other fuels available upon request)

WELDING POWER SUPPLY

Output	Power Requirements - (26.0 kVA)	
	Voltage	Current
Maximum Current 1000 Amperes	230 Volts	193 Amperes
Maximum Voltage 50 Volts	380 Volts	112 Amperes
Duty Cycle..... 100%	415 Volts	107 Amperes
	460 Volts	97 Amperes
	Other voltages available	

WIRE REEL

Capacity sized for all popular welding wire spools

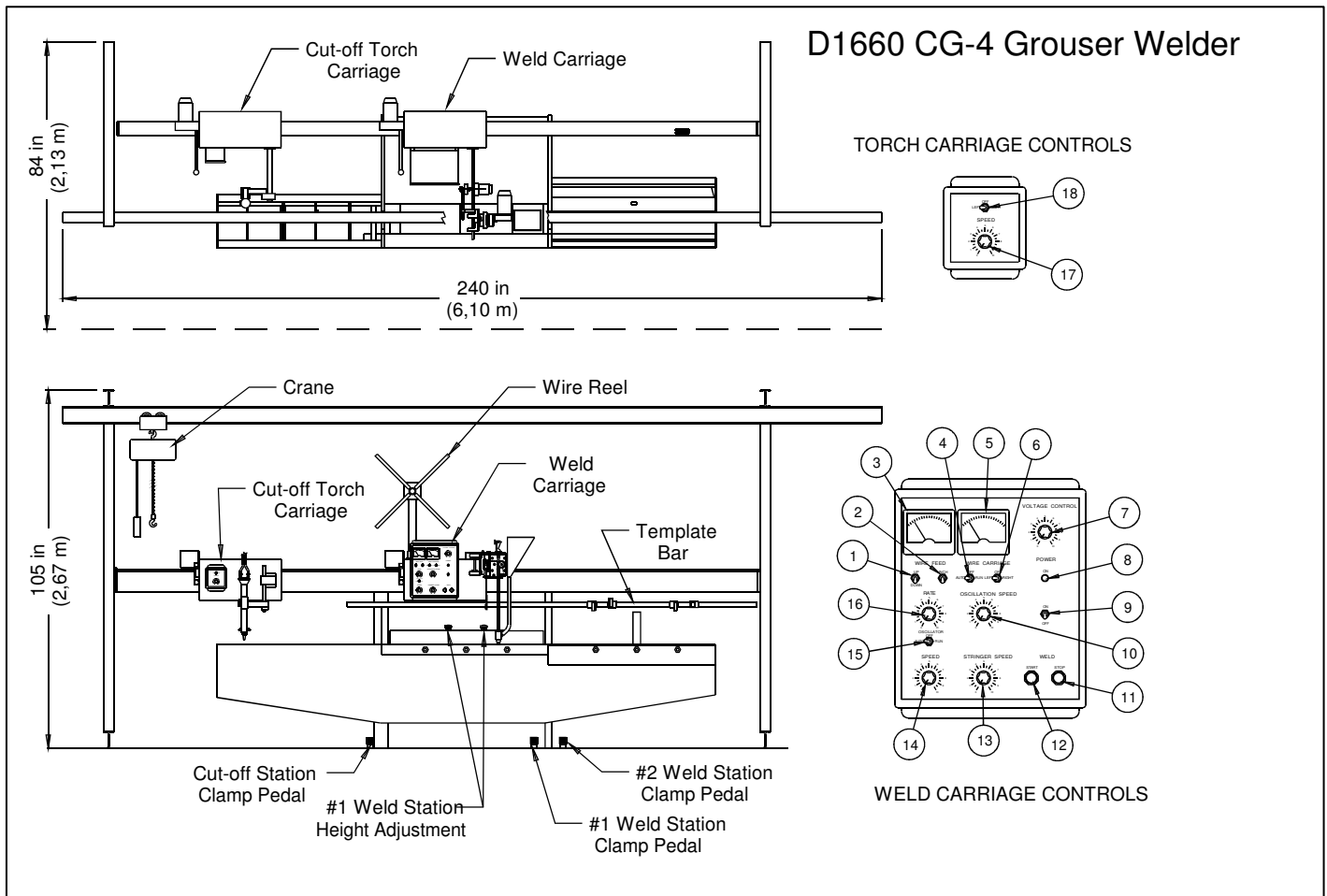
Maximum Wire Spool Diameter 28 in (712 mm)
 Minimum Wire Spool Diameter 6 in (152 mm)
 Maximum Wire Spool Weight 120 lb (54,0 kg)

CRANE

Capacity - 500 lbs (225 kg)

SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE

Control Identification



Welding Carriage Controls

- 1) ELECTRODE UP/OFF/DOWN - selects the direction of the welding wire. Welding happens in the DOWN position
- 2) WIRE INCH - advances the welding wire ARC START - Starts the welding cycle
- 3) WIRE FEED METER - shows the speed of the wire feeding through the Welding Torch Head. This is directly related to the Amps of the Welding Torch
- 4) WELD CARRIAGE TRAVEL MODE - selects for the Weld Carriage speed between AUTO, which follows the program from the Template Bar, and RUN, which travels at the speed set by the STRINGER CARRIAGE SPEED Control. Weld Carriage travel is stopped in the OFF position.
- 5) VOLTMETER - Displays the voltage of the Welding Torch Head
- 6) WELD CARRIAGE TRAVEL DIRECTION - selects whether the Weld Carriage travels to the left or right. Stops Weld Carriage travel in the OFF position.
- 7) VOLTAGE CONTROL - controls the voltage of the Welding Torch Head

Control Identification (Continued)

- 8) POWER LIGHT - lights when power is on
- 9) OSCILLATION CARRIAGE SPEED - controls the Weld Carriage speed during the oscillation part of the weld program
- 10) MAIN POWER SWITCH - controls power to the CG-3 controls
- 11) WELD STOP - stops the welding cycle
- 12) WELD START - starts the welding cycle
- 13) STRINGER CARRIAGE SPEED - controls the Weld Carriage speed during the stringer part of the weld program
- 14) OSCILLATOR SPEED - controls how rapidly the torch weaves during the oscillation part of the weld program
- 15) OSCILLATOR MODE - selects for Oscillator control between AUTO, which follows the program from the Template Bar, and RUN, which moves the Oscillator constantly at the speed set by the OSCILLATOR SPEED Control
- 16) WIRE FEED RATE - sets the speed of the welding wire. This is directly related to the Amps at the Weld Torch Head.

Torch Carriage Controls

- 17) TORCH CARRIAGE TRAVEL SPEED - controls the travel speed of the Torch Carriage
- 18) TORCH CARRIAGE TRAVEL DIRECTION - selects whether the Torch Carriage travels to the left or right. Stops Torch Carriage travel on the OFF position.



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MANUFACTURERS/BENEFICIARY'S WARRANTY CERTIFICATE WTC MACHINERY, LLC WARRANTY

WTC MACHINERY, LLC warrants its products to be free from defects in material and workmanship under normal use and service for a period of twelve (12) months after date of shipment. WTC MACHINERY, LLC undertakes to be responsible for any defect that may arise due to faulty raw materials, design, workmanship and defective parts and to replace them without extra cost. Freight charges are the customer's responsibility. Our warranty is not transferable.

WTC MACHINERY, LLC shall have the option of requiring the return of all parts claimed defective. Parts proved to be defective, due to defect in workmanship and/or material, shall be either repaired or replaced free of charge, F.O.B. our designated factory. All parts warranty claims are subject to inspection by WTC MACHINERY, LLC and acceptance at the factory

Our warranty does not obligate us to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts and the removal and/or remounting of the parts repaired or replaced under this warranty, unless specifically authorized in writing by WTC MACHINERY, LLC. All parts returned to the factory must be shipped freight prepaid; no collect freight will be accepted by the factory. Forms authorizing such returns for inspection must accompany all returns.

This warranty shall not apply to products not manufactured by WTC MACHINERY, LLC.

Outside purchased equipment and accessories (not of WTC manufacture) are warranted only to the extent of the original equipment manufacturer's warranty and subject to their allowance to WTC MACHINERY, LLC. In this respect, our warranty obligations must conform and be limited to the warranty extended to WTC MACHINERY, LLC by its suppliers as extended to the customer.

We shall, in no event, be liable for consequential damages or contingent liability arising out of the failure of any unit or part to operate properly, or that is subject to:

- Ordinary operating wear, abuse, misuse, or overloading;
- Repairs or alterations by parties other than WTC MACHINERY, LLC;
- The use of improper fluids, contaminated fluids or improper filtering;
- The use of improper voltage hookup in the electrical connections of any equipment;
- Negligence, accident or damages due to deterioration during periods of storage by the purchaser prior to installation and operation;
- Damages occurred in shipment after leaving factory en route to customers' delivery point, as title to equipment passes to customer when loaded onboard for shipment, f.o.b. factory, and customer must place his own claim against damaged goods directly to the shipping company and not against WTC MACHINERY, LLC, its factory, or any of its personnel.
- Damages due to circumstances beyond the control of WTC MACHINERY, LLC and in connection with fulfilling any obligation under this warranty.

To the maximum extent permitted by applicable law, in no event shall WTC Machinery, LLC be liable for indirect, special, incidental or consequential damages resulting from personal injury, loss of business profits or business interruption from the use of its products, or from the inability to use its products.

This warranty is exclusive and is in lieu of all other expressed and implied warranties, including but not limited to implied warranties or merchantability and fitness for a particular purpose. WTC MACHINERY, LLC shall not be subject to any other obligations or liabilities whatsoever with respect to equipment manufactured or supplied by WTC MACHINERY, LLC, or services rendered to it.