

TUBE-TO-TUBESHEET WELD HEADS



RBK 38 S

With tube-to-tubesheet weld heads, it is possible to achieve consistently high-quality, reproducible welding of tubes to tubesheets, with or without additional wire. The tubes to be welded can be flush with the tubesheet, offset, protruding or behind the tubesheet.

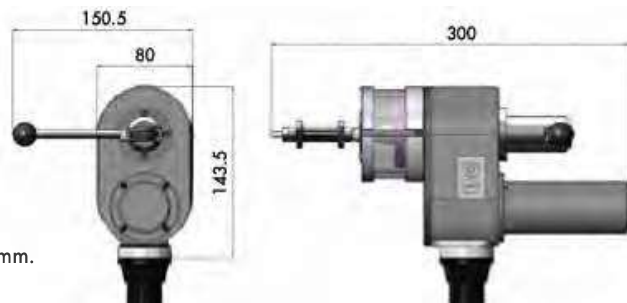
The RBK 38 S and the RBK 60 S are our two new tube-to-tubesheet weld heads.

The RBK 38 S is a small, handy water-cooled head for welding tubes to tubesheets up to an ID of 36.7 mm, without additional wire.



RBK 38 S WELD HEAD incl. 8 m hose package

Dimensions table for the RBK 38 S tube-to-tubesheet weld head



Dimensions in mm.

Technical data:	RBK 38 S
Tube size range mm inch	ID 9.3 – 36.7 mm 0.366" – 1.445" (optimal from ID 6.0 mm 0.236")
Max. welding current	125 A
Rotation speed	Max. 5 rpm
Centring	mechanical
Weight	5 kg

Package includes:

- Weld head
- Water-cooled hose package, 6 m
- Pull bar B
- Gas hood ID 35 mm
- 0° electrode holder
- Transport case



0° ELECTRODE HOLDER FOR TUNGSTEN Ø 2.4 MM

7° ELECTRODE HOLDER FOR TUNGSTEN Ø 2.4 MM

MULTI-POSITION ELECTRODE HOLDER FOR AN ELECTRODE Ø OF 1.6 MM

MULTI-POSITION ELECTRODE HOLDER FOR AN ELECTRODE Ø OF 2.4 MM



GAS HOOD ID 28 MM FOR RBK 38 S

GAS HOOD ID 35 MM FOR RBK 38 S

GAS HOOD ID 48 MM FOR RBK 38 S

Item number

1.3.3703

1.3.3004

1.3.3005

1.3.3703004

1.3.3703003

1.3.3007

1.3.3006

1.3.3008

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TUBE-TO-TUBESHEET WELD HEADS



RBK 38 S, SPRING SLEEVES



Spring sleeve for RBK 38 S

PULL BAR SET A

Tube size range 9.3 mm – 16.2 mm
(0.366" – 0.638")

1.3.3002



PULL BAR SET B

Tube size range 16 mm – 36.7 mm
(0.630" – 1.445")

1.3.3003



Tube size range ID	
mm	inch
9.3 – 9.7	0.366 – 0.382
9.8 – 10.2	0.386 – 0.406
10.7 – 11.1	0.421 – 0.437
11.3 – 11.7	0.445 – 0.461
11.8 – 12.2	0.465 – 0.480
12.8 – 13.2	0.504 – 0.520
13.8 – 14.2	0.543 – 0.559
14.0 – 14.4	0.551 – 0.567
14.6 – 15.0	0.574 – 0.591
15.8 – 16.2	0.622 – 0.638
16.0 – 16.4	0.630 – 0.646
16.4 – 16.8	0.646 – 0.661
16.8 – 17.2	0.661 – 0.677
17.2 – 17.6	0.677 – 0.693
17.8 – 18.2	0.701 – 0.717
18.4 – 18.8	0.724 – 0.740
18.8 – 19.2	0.740 – 0.756
19.4 – 19.8	0.764 – 0.780
19.8 – 20.2	0.780 – 0.795
20.4 – 20.8	0.803 – 0.819
20.8 – 21.2	0.819 – 0.834
21.0 – 21.4	0.827 – 0.843
21.3 – 21.7	0.839 – 0.854
21.8 – 22.2	0.858 – 0.874
22.3 – 22.7	0.877 – 0.894
22.8 – 23.2	0.897 – 0.913
23.2 – 23.6	0.913 – 0.929
23.4 – 23.8	0.921 – 0.937
23.6 – 24.0	0.929 – 0.945
23.8 – 24.2	0.937 – 0.952
24.3 – 24.7	0.957 – 0.974
25.4 – 25.8	1.000 – 1.016
25.8 – 26.2	1.016 – 1.031
26.4 – 26.8	1.039 – 1.055
26.8 – 27.2	1.055 – 1.071
27.4 – 27.8	1.079 – 1.094
28.4 – 28.8	1.118 – 1.134
28.8 – 29.2	1.134 – 1.150
29.4 – 29.8	1.157 – 1.173
29.8 – 30.2	1.173 – 1.189
30.4 – 30.8	1.197 – 1.213
30.8 – 31.2	1.213 – 1.228
31.5 – 31.9	1.240 – 1.256
33.8 – 34.2	1.331 – 1.346
34.8 – 35.2	1.370 – 1.386
35.5 – 35.9	1.398 – 1.413
35.8 – 36.2	1.409 – 1.425
36.3 – 36.7	1.429 – 1.445

Gas hood DI 28 mm

Gas hood DI 35 mm

Gas hood DI 48 mm

Item number

1.3.370493
1.3.370498
1.3.3704107
1.3.3704113
1.3.3704118
1.3.3704128
1.3.3704138
1.3.370414
1.3.3704146
1.3.3704158
1.3.370416
1.3.3704164
1.3.3704168
1.3.3704172
1.3.3704178
1.3.3704184
1.3.3704188
1.3.3704194
1.3.3704198
1.3.3704204
1.3.3704208
1.3.370421
1.3.3704213
1.3.3704218
1.3.3704223
1.3.3704228
1.3.3704232
1.3.3704234
1.3.3704236
1.3.3704238
1.3.3704243
1.3.3704254
1.3.3704258
1.3.3704264
1.3.3704268
1.3.3704274
1.3.3704284
1.3.3704288
1.3.3704294
1.3.3704298
1.3.3704304
1.3.3704308
1.3.3704315
1.3.3704338
1.3.3704348
1.3.3704355
1.3.3704358
1.3.3704368

TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S



Item number

The RBK 60 S is an extremely robust water-cooled weld head for a standard heat exchanger application up to an ID of 60 mm, modified to an ID of 99 mm or 120 mm. The head is pneumatically centred and is available with a rotating wire device and/or arc voltage control (AVC) as an option. The head can also be used with a pneumatic positioner instead of a balancer.



RBK 60 S WELD HEAD with pneumatic centring incl. 8 m hose package, water-cooled

1.3.3702

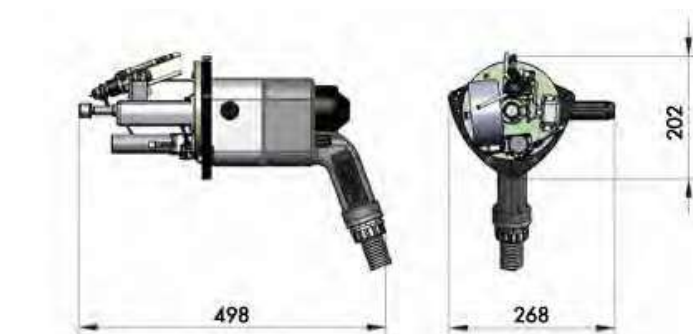
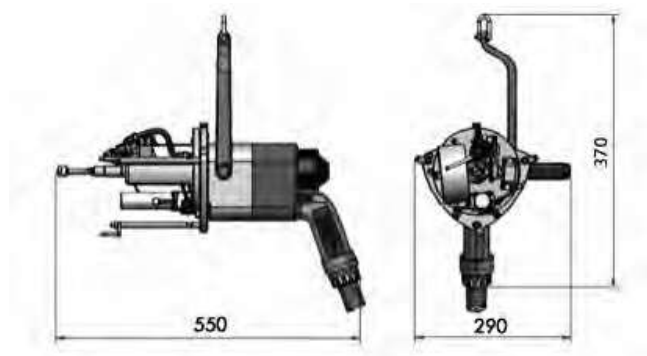
RBK 60 S WELD HEAD with pneumatic centring and wire feed unit incl. hose package, 8 m, water-cooled

1.3.3701

RBK 60 S WELD HEAD with pneumatic centring, wire feed unit and AVC incl. hose package, 8 m, water-cooled

1.3.3700

With pneumatic centring



Dimensions in mm.

Orbital
welding systems

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TUBE-TO-TUBESHEET WELD HEADS

RBK 60 S, SPRING SLEEVES

With a pneumatic positioner

Item number

Technical data:

Tube size range mm | inch

Max. welding current

Wire motor

Rotation speed

Wire spool

Wire diameter

Weight without wire feed

Weight with wire feed

Weight with wire feed / AVC

Centring

RBK 60 S

ID 9.5 – 60.5 mm | 0.374" – 2.381"

(optional up to 99.10 mm | 3.901" or 120 mm | 4.724")

200 A

24 V DC

Max. 5 rpm

1 kg, D100

0.8 – 1.2 mm

8 kg

10.5 kg

11 kg

pneumatic

Package includes:

- Weld head
- Small torch incl. torch consumables and tungsten electrode Ø 2.4 mm
- Water-cooled hose package, 8 m
- Pull bar B
- Transport case

Up to an ID of 30 mm, the spring sleeves are made of steel; in the case of larger diameters, the package also includes four stainless steel jaws.



Spring sleeve for RBK 60 S

Tube size range ID	
mm	inch
9.5 – 10.5	0.374 – 0.413
10.5 – 11.5	0.413 – 0.453
11.5 – 12.5	0.453 – 0.492
12.5 – 13.5	0.492 – 0.531
13.5 – 14.5	0.531 – 0.571
14.5 – 15.5	0.571 – 0.610
15.5 – 16.5	0.610 – 0.650
16.1 – 17.1	0.634 – 0.673
17.2 – 18.2	0.677 – 0.717
18.5 – 19.5	0.728 – 0.768
19.5 – 20.5	0.768 – 0.807
20.5 – 21.5	0.807 – 0.846
21.7 – 22.7	0.854 – 0.894
22.4 – 23.4	0.882 – 0.921
22.7 – 23.7	0.894 – 0.933
23.5 – 24.5	0.925 – 0.965
24.5 – 25.5	0.965 – 1.004
25.5 – 26.5	1.004 – 1.043
26.5 – 27.5	1.043 – 1.083
27.5 – 28.5	1.083 – 1.122
28.5 – 29.5	1.122 – 1.161
29.5 – 30.5	1.161 – 1.201
30.5 – 31.5	1.201 – 1.240
31.5 – 32.5	1.240 – 1.280
32.5 – 33.5	1.280 – 1.319
33.5 – 34.5	1.319 – 1.358
34.5 – 35.5	1.358 – 1.398
35.5 – 36.5	1.398 – 1.437

- 1.3.370595**
- 1.3.3705105**
- 1.3.3705115**
- 1.3.3705125**
- 1.3.3705135**
- 1.3.3705145**
- 1.3.3705165**
- 1.3.3705161**
- 1.3.3705172**
- 1.3.3705185**
- 1.3.3705195**
- 1.3.3705205**
- 1.3.3705217**
- 1.3.3705224**
- 1.3.3705227**
- 1.3.3705235**
- 1.3.3705245**
- 1.3.3705255**
- 1.3.3705265**
- 1.3.3705275**
- 1.3.3705285**
- 1.3.3705295**
- 1.3.3705305**
- 1.3.3705315**
- 1.3.3705325**
- 1.3.3705335**
- 1.3.3705345**
- 1.3.3705355**

TUBE-TO-TUBESHEET WELD HEADS



RBK 60 S SPRING SLEEVE, ACCESSORIES



Spring sleeve for RBK 60 S

PULL BAR SET A

Tube size range 9.5 mm – 19.5 mm
(0.374" – 0.768")

1.3.3065



PULL BAR SET B

Tube size range 19.5 mm – 99.1 mm
(0.768" – 3.902")

1.3.3069



36.5 – 37.5	1.437 – 1.476
37.5 – 38.5	1.476 – 1.516
38.5 – 39.5	1.516 – 1.555
39.5 – 40.5	1.555 – 1.594
40.5 – 41.5	1.594 – 1.634
41.5 – 42.5	1.634 – 1.673
42.5 – 43.5	1.673 – 1.713
43.5 – 44.5	1.713 – 1.752
44.5 – 45.5	1.752 – 1.791
45.5 – 46.5	1.791 – 1.831
46.5 – 47.5	1.831 – 1.870
47.5 – 48.5	1.870 – 1.909
48.0 – 49.0	1.890 – 1.929
49.5 – 50.5	1.949 – 1.988
50.5 – 51.5	1.988 – 2.028
51.5 – 52.5	2.028 – 2.067
52.5 – 53.5	2.067 – 2.106
53.5 – 54.5	2.106 – 2.146
54.5 – 55.5	2.156 – 2.185
55.5 – 56.5	2.185 – 2.224
56.5 – 57.5	2.224 – 2.264
57.5 – 58.5	2.264 – 2.303
58.5 – 59.5	2.303 – 2.343
59.5 – 60.5	2.343 – 2.382
60.6 – 61.6	2.386 – 2.425
61.5 – 62.5	2.421 – 2.461
62.5 – 63.5	2.461 – 2.500
63.5 – 64.5	2.500 – 2.539
64.5 – 65.5	2.539 – 2.579
65.5 – 66.5	2.579 – 2.618
66.5 – 67.5	2.618 – 2.657
67.5 – 68.5	2.657 – 2.697
68.5 – 69.5	2.697 – 2.736
69.5 – 70.5	2.736 – 2.776
70.5 – 71.5	2.776 – 2.815
71.5 – 72.5	2.815 – 2.854
72.7 – 73.7	2.862 – 2.902
73.5 – 74.5	2.894 – 2.933
74.5 – 75.5	2.933 – 2.972
75.5 – 76.5	2.972 – 3.002
76.5 – 77.5	3.012 – 3.051
77.5 – 78.5	3.051 – 3.091
78.5 – 79.5	3.091 – 3.130
79.5 – 80.5	3.130 – 3.169
80.5 – 81.5	3.169 – 3.209

With extension kit

Item number

1.3.3705365
1.3.3705375
1.3.3705385
1.3.3705395
1.3.3705405
1.3.3705415
1.3.3705425
1.3.3705435
1.3.3705445
1.3.3705455
1.3.3705465
1.3.3705475
1.3.370548
1.3.3705495
1.3.3705505
1.3.3705515
1.3.3705525
1.3.3705535
1.3.3705545
1.3.3705555
1.3.3705565
1.3.3705575
1.3.3705585
1.3.3705595
1.3.3705606
1.3.3705615
1.3.3705625
1.3.3705635
1.3.3705645
1.3.3705655
1.3.3705665
1.3.3705675
1.3.3705685
1.3.3705695
1.3.3705705
1.3.3705715
1.3.3705725
1.3.3705735
1.3.3705745
1.3.3705755
1.3.3705765
1.3.3705775
1.3.3705785
1.3.3705795
1.3.3705805

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TUBE-TO-TUBESHEET WELD HEADS



RBK 60 S SPRING SLEEVE, ACCESSORIES

81.5 – 82.5	3.209 – 3.248
82.0 – 83.0	3.228 – 3.268
82.5 – 83.5	3.248 – 3.287
84.5 – 85.5	3.327 – 3.366
98.1 – 99.1	3.862 – 3.902

1.3.3705815
1.3.370582
1.3.3705825
1.3.3705845
1.3.3705981



LARGE TORCH FOR RBK 60 S FOR 3.2 MM ELECTRODES

1.3.3708



EXTENSION KIT FOR RBK 60 S FOR AN ID GREATER THAN 60 MM

1.3.3707



TITANIUM DISTRIBUTION NOZZLE SET FOR RBK 60 S
 (can only be mounted for large torch)

1.3.3052



BALANCER (4,5 – 9 KG)
BALANCER (9 – 15 KG)
BALANCER (15 – 22 KG)

1.2.3617
1.2.3614
1.1.3615

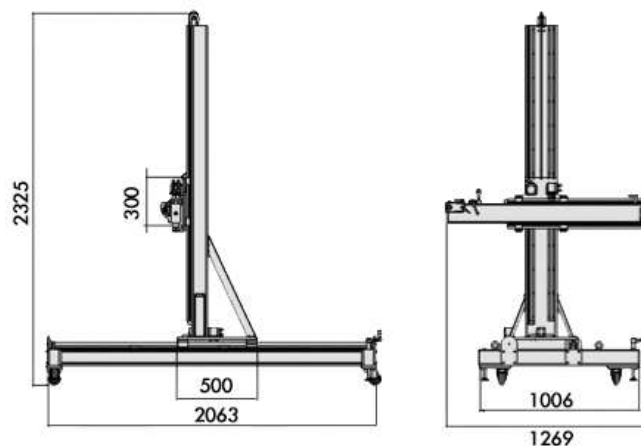


TUBE-TO-TUBESHEET POSITIONER (pneumatic)

1.3.3001

With the tube-to-tubesheet positioner, the RBK 60 S can easily be positioned without a balancer and centred pneumatically with the lever on the positioner.

The head is aligned with a matching centring on the tubesheet. The positioner stands on castors and is fixed in front of the tubesheet with a screw adjustment.



Dimensions in mm.

Centrings for positioner for RBK 60 S available on request.

