

Pipe Turning Positioners

LJ's pipe turning positioners are used for positioning heavy-wall, large diameter pipe for spooling application with large offset loads.

**LARGE HEIGHT ADJUSTABILITY
ACCOMMODATES A WIDE
RANGE OF SWING DIAMETERS**



NEW - UP TO 60,000 LBS CAPACITY

SPECIFICATIONS	16P-700	30P-200	P12PS-100	P24PS-100	P60PS-200
	3,000 lbs	5,400 lbs	12,000 lbs	24,000 lbs	60,000 lbs
Load Capacity:	3,000 lbs (at Mounting Plate)	5,400 lbs (at Mounting Plate)	12,000 lbs (at 12" overhung load)	24,000 lbs (at 12" overhung load)	60,000 lbs (at 12" overhung load)
Footprint:	72" x 42" x 77"	72" x 42" x 77"	96" x 71" x 62"	96" x 71" x 69"	133" x 96" x 105"
Turning Torque:	20,000 in-lbs (With Counterweight)	40,000 in-lbs	125,000 in-lbs	250,000 in-lbs	800,000 in-lbs
Height Adjustability:	45" – 69" in 4" increments	33" – 69" in 4" increments	48" – 96" in 6" increments	48" – 96" in 6" increments	73" – 145" in 8" increments
Power Requirements:	110V, 1-ph*	480V, 3-ph*	480V, 3-ph*	480V, 3-ph*	480V, 3-ph*
Operation Speed:	0.3–3.0 RPM	0.2–2.4 RPM	0.05–2.2 RPM	0.05–1.2 RPM	0.04–0.8 RPM
Ground Capacity:	400 Amps	800 Amps	1,500 Amps	1,500 Amps	1,500 Amps

* 208–600V, 50 or 60 Hz input power options available. Ground Capacity: up to 2500 Amps available. Pipe Stands: various capacities with gear or manual elevation. Specifications subject to change; consult factory for all specifications.

Features & Options



Cabled or wireless hand pendant with or without digital readout.



Bi-directional or variable speed foot switches.



Maximize your productivity
with fully integrated welding systems

High Volume Pipe Spooling Cell

LJ's pipe spooling cells significantly accelerate pipe fabrication cycle times, compared to conventional material handling and low deposition rate welding processes.

The high volume pipe spooling cell removes cumbersome and time-consuming steps, streamlining your entire pipe spool welding process, while efficiently utilizing limited shop floor space.



**MAXIMUM EFFICIENCY
MATERIAL HANDLING**



**INNOVATIVE WELDING
AUTOMATION**



**MAXIMUM PIPE FABRICATION
PRODUCTIVITY & ROI**

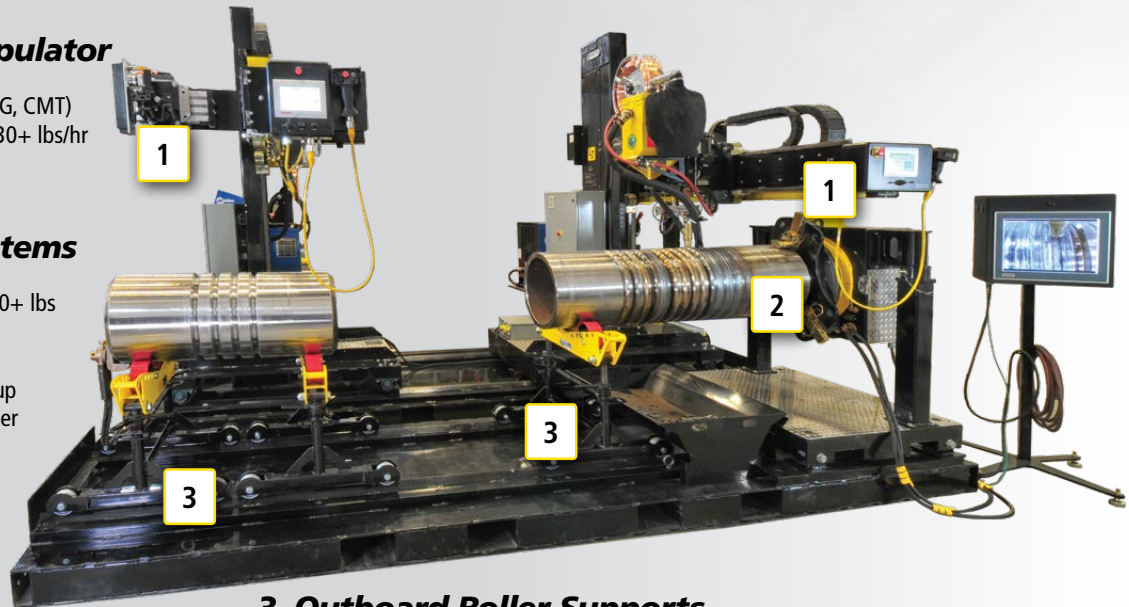
Customize Your Own System

1. Welding Manipulator

- ✓ Subarc or Open Arc (MIG, CMT)
- ✓ Deposition rates up to 30+ lbs/hr

2. Positioner Systems

- ✓ Capacity: 1,000 - 20,000+ lbs
- ✓ Grippers: up to 72" OD, 24,000 lbs capacity
- ✓ Elbow Jigs or Fixtures: up to 48" OD or to customer specifications



3. Outboard Roller Supports

- ✓ Modular design accommodates a range of roller top, base, and functionality options
- ✓ Typically up to 60" diameter and 16,000 lbs capacity available

Turnkey Welding Systems

LJ's unique modular and flexible design allows for multiple pieces of equipment to be integrated into fully automated welding cells. Integrated systems ranging from standard positioners, fixtures and manipulators through to fully automated robotic welding systems are available to suit any application.

Subarc Overlay System



ACDC-1000 Submerged Arc manipulator integrated with custom 5-ton capacity tilt positioner for high-deposition overlay rebuild of pipe mill rollers.



Aerospace Welding Manipulator and Positioner System

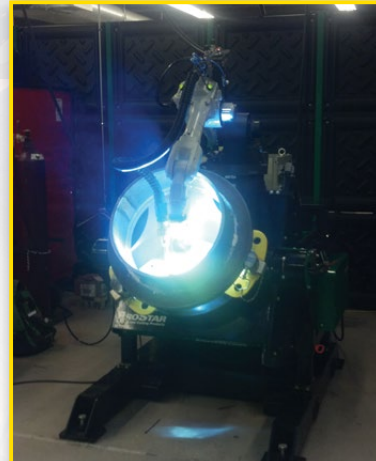


High precision aerospace GTAW+PAW welding manipulator with integrated servo positioner, used for welding of a variety of heat input sensitive turbine components. HMI interface, remote viewing camera and specialized Liburdi Automation welding system.

Robotic Welding and Positioner System

Fully integrated robotic welding process with coordinated motion tilt/rotate positioner, for up to 2,000 lbs high batch welding parts.

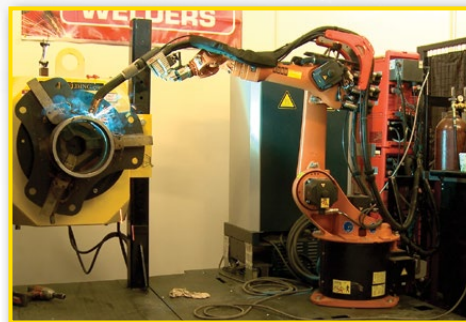
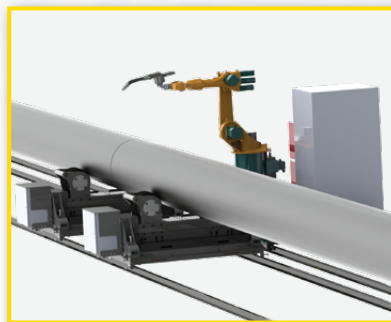
- ✓ Ideal for high-volume repetitive welding
- ✓ Fully integrated positioner, fixture, robot and welding package options
- ✓ Easy to use



Robotic Pipe Joining System

Fully integrated robotic welding process with servo positioner and material handling system for automated joining of heavy wall large bore pipe up to 60" diameter.

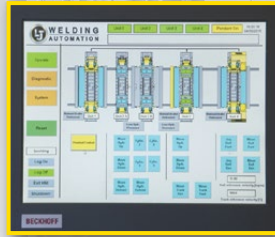
- ✓ Servo headstock for precise rotation speed
- ✓ Full alignment capabilities for roller supports for quick fit up of weld joint
- ✓ Robotic welding system automatically tracks seam for maximum productivity



Automation & Controls

Controls Panels

- Input power supply: 110-600 Volts and 50/60 Hz optional
- Master variable speed, direction, on/off local/remote controls
- PLC based HMI touchscreen or conventional push button controls to customer preference



FS-FR Forward/Reverse Foot Switch

- Heavy Duty Cast steel body with heavy duty guard/handle
- Momentary actuation (normally off)
- Heavy rubber 8 m (25 ft) cable with 4-pin metal plugs



HP-100 Single/Dual Axis Hand Pendants

- Ergonomic, easy to use, lightweight design, c/w protective guard
- Optional LCD digital speed readout
- Heavy rubber 8 m (25 ft) cable with 19-pin metal plugs



15 m (50 ft) Extension Cables Available!

FS-V Variable Speed Foot Switch

- Plug & Play with optional controller upgrade
- Main panel controls master speed range, foot switch used for variable speed in master range



Wireless Pendants

- For multiple-axes control or complex functions



Automation Capabilities

LJ utilizes user-friendly touch screen controls for plug and play integration of multiple machines to create fully integrated welding and material handling systems.

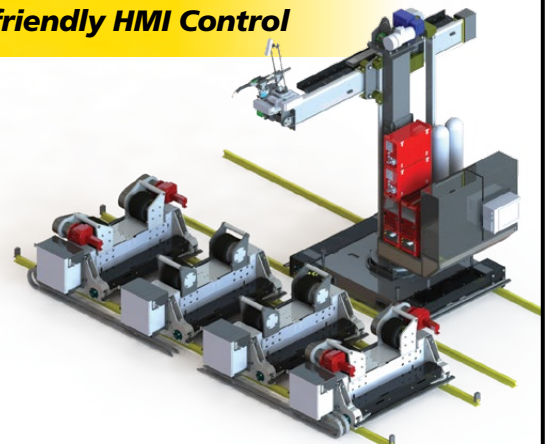


Fully integrated automated welding systems.

Robotic or fixed welding automation.

User friendly HMI Control

Material handling systems.



Positioner Accessories

Grippers & Chucks

High-quality, cost-effective welding grippers and chucks are a standard accessory on all welding positioners.

3-jaw self centering scroll chucks with reversible top jaws available in 8", 12", 16" gripping diameter ranges.

HIGHEST CAPACITY GRIPPERS AVAILABLE ON THE MARKET

For oversized or heavy gripping requirements with smooth, serrated or carbide insert top jaws.

Gripper Options

SPECS	T30-200	T50-200	T60-100
Load Capacity:	5,000 lbs	10,000 lbs	10,000 lbs
Diameter Range:	2" – 30"	2" – 50"	2" – 60"

V72-100 Gripper now available for up to 72" OD & 24,000 lbs load capacity

**SAFER, EASIER
ELBOW FIXTURING**

Elbow Jigs

SPECS Elbow Jigs (2" – 48") | 30E-200 AND LARGER DO NOT COME WITH CLAMPING PIPE

	02E-200	03E-200	04E-200	06E-200	08E-200	10E-200	12E-200	14E-200	16E-200	18E-200	20E-200	24E-200	30E-200	36E-200	42E-200	48E-200
Nominal Diameter:	2"	3"	4"	6"	8"	10"	12"	14"	16"	18"	20"	24"	30"	36"	42"	48"
Capacity:	250 lbs	250 lbs	250 lbs	250 lbs	500 lbs	500 lbs	500 lbs	500 lbs	1,000 lbs	1,000 lbs	1,000 lbs	1,000 lbs	2,000 lbs	2,000 lbs	2,000 lbs	2,000 lbs

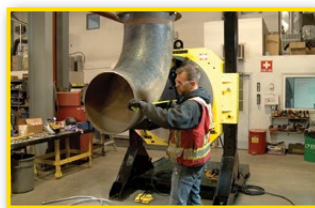
45° and 90° Elbows: Precision fit and clamp allows for quick and easy fitting, prepping and welding of elbows for use with welding positioners.



Remove hold down u-bolt.



Load elbow into jig.



Measure the fit.



Fasten elbow into the jig.

www.LJwelding.com

