



## H Beam Welding Lines



VHA H beam welding lines are high performance H beam production lines combined with different equipments and tool that are manufactured by JINFENG WELDCUT who is the professional China manufacturer and supplier of H beam welding lines with affordable price. The H beam welding lines provide more safety and high efficiency for the H beams or T beam production.

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JINFENG WELDCUT will provide have 2 years warranty for the **H beam welding lines**. The main electric elements of the H beam productions are selected from the world famous brand that will bring more convenient for Users to find the parts in local without getting from long distance from China. The VHF **H beam welding lines** are the most advanced and high automation production lines to increase the productivity for End-users from different industries.

## Specifications

Model	VHF1500	VHF2000	VHF3200
H-beam web height	200-1500mm	200-2000mm	450-3200mm
Web thickness	6-32mm	6-40mm	6-60mm
H-beam flange width	200-800mm	200-800mm	200-1200mm
Flange thickness	6-40mm	8-60mm	8-80mm
H-beam length	4000-15000mm		6000-18000mm
Welding types	Tack welding by CO <sub>2</sub> /MAG		
	Full welding by SAW (submerged arc welding)		
H beam assembled position	vertical		
H-beam assembling machine	1 set		



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Cantilever submerged arc welding machine	4 sets	
H beam flange Straightening machine	1 set	1 set, Hydraulic type
Roller tables	~90 meters	~101 meters + ~10 meters
Beam flipper 180°overturn	3 sets (6 units)	3 sets (6 units)
Steel cart	2 sets (4 units)	2 sets (4 units)
Support data collection for MES		

## Feature And Application

1. The VHA **H beam welding lines** are high automation production lines to produce the welded I beam and H beam with lesser workers and lesser cranes.
2. The line can be fully integration with the MES system and complete the real-time communication between the upper computer and the control system, complete the data collection of the equipment, upload all collected data to the factory MES system (or the upper centralized control system), and ensure the timeliness and effectiveness of information transmission.
3. The design and protection must meet the requirements of relevant national standards and environmental protection; Equipment safety and protective devices must meet relevant industrial standards;.
4. This **H beam welding lines** are widely used in Shipbuilding, shipyard and steel construction and steel structures, offshore, onshore, for welding T-beam for shipyards and shipbuilding, H-beam for steel construction and steel structures, or bridges etc.
5. The flexible design of the welding equipments allow to support any brands of the welding power sources.
6. CE, ECA certificated are available.
7. This line provide the production from light duty beam to very heavy duty beam with big thickness without changing any tools or equipments.
8. From the assembling to the straightening the whole processing no need any cranes, which reduce greatly the risk of using cranes.



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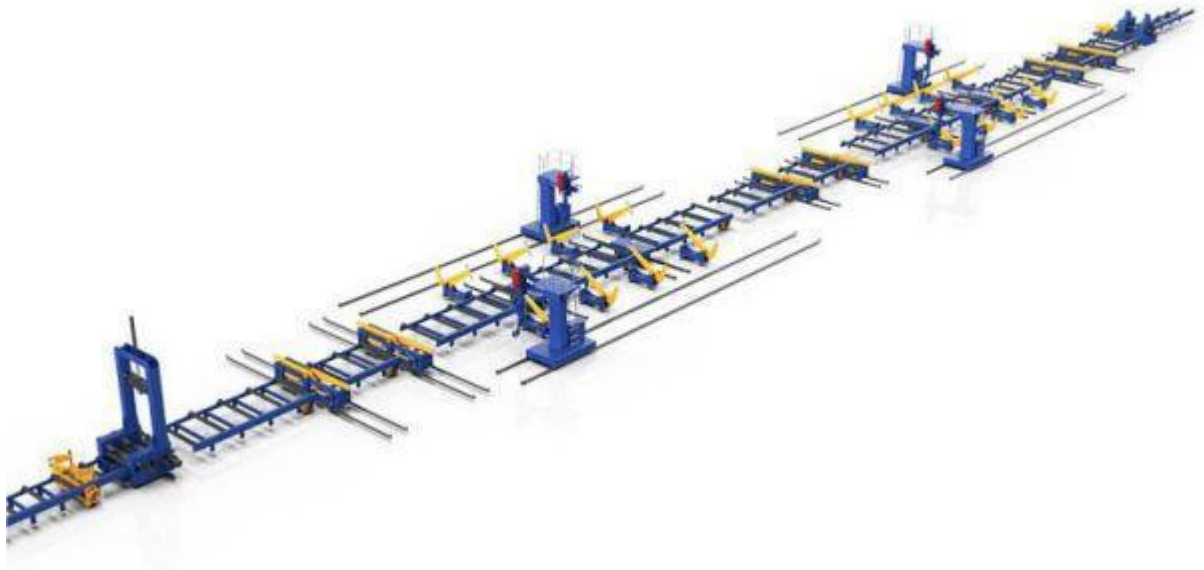
Structure view

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List of the equipments modules used in **H beam welding lines**

**1-Assembling area, includes:**

One Vertical H beam assembling machines - for CO<sub>2</sub>/MAG spot welding to assembly web and flanges in I-shape.

One set of Beam flipper to overturn the H beam from "I" position to "H" position for safety transporting on roller table of the line.



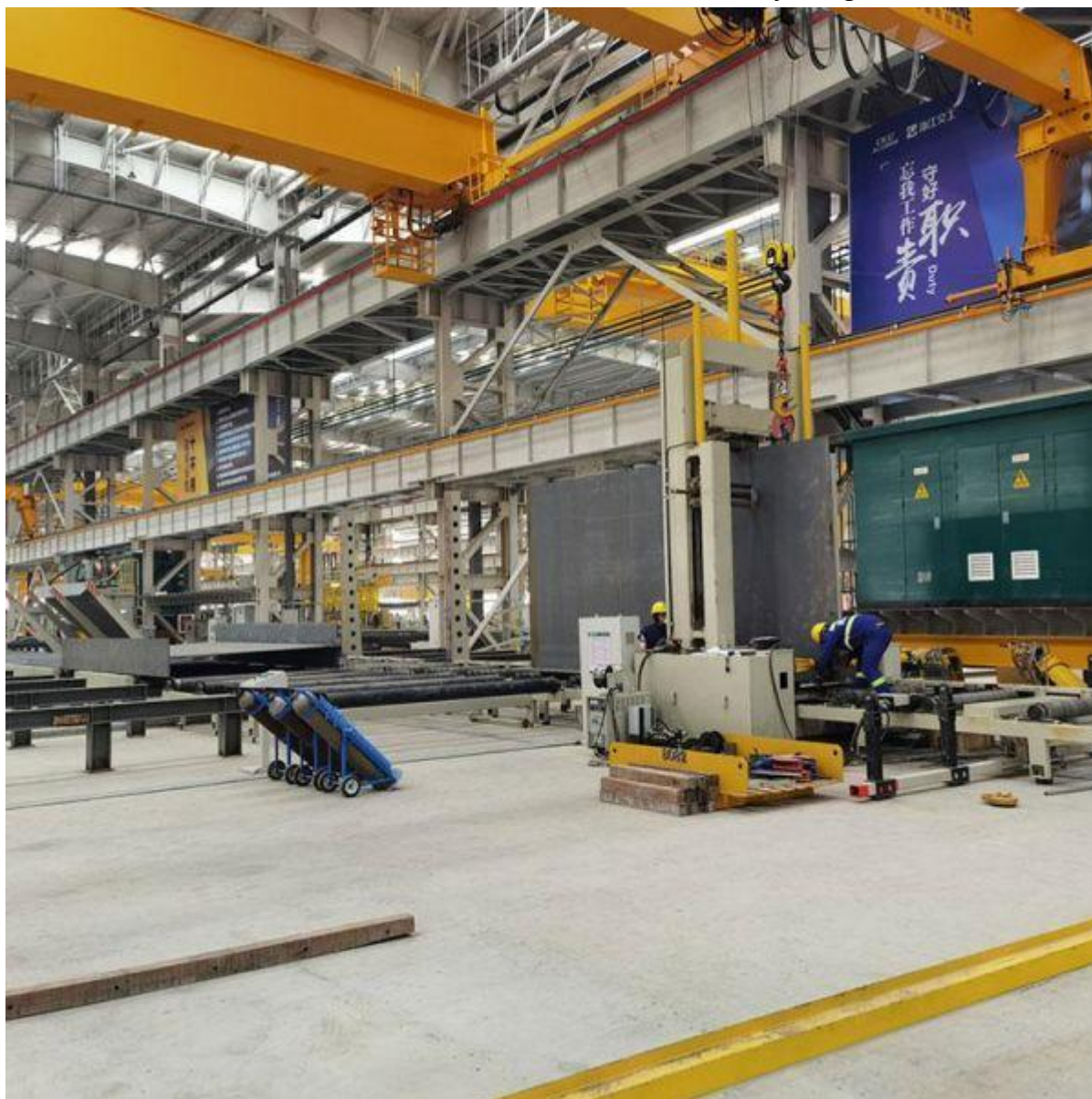
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## 2-Welding area

### **In Welding area #1, includes:**

Two sets of cantilever type H beam welding machines. One each welding machine equipped with 1 submerged arc welding head (supports Single arc welding or tandem arc welding technology).

Two sets of beam tilters to make the H beam sitting at 45 degrees to ensure to have good welding position.

One set of steel cart ( consists of 2 units of steel carts) for bringing the beam to 2nd cantilever SAW welding machine after complete the welding of 1st welding seam.



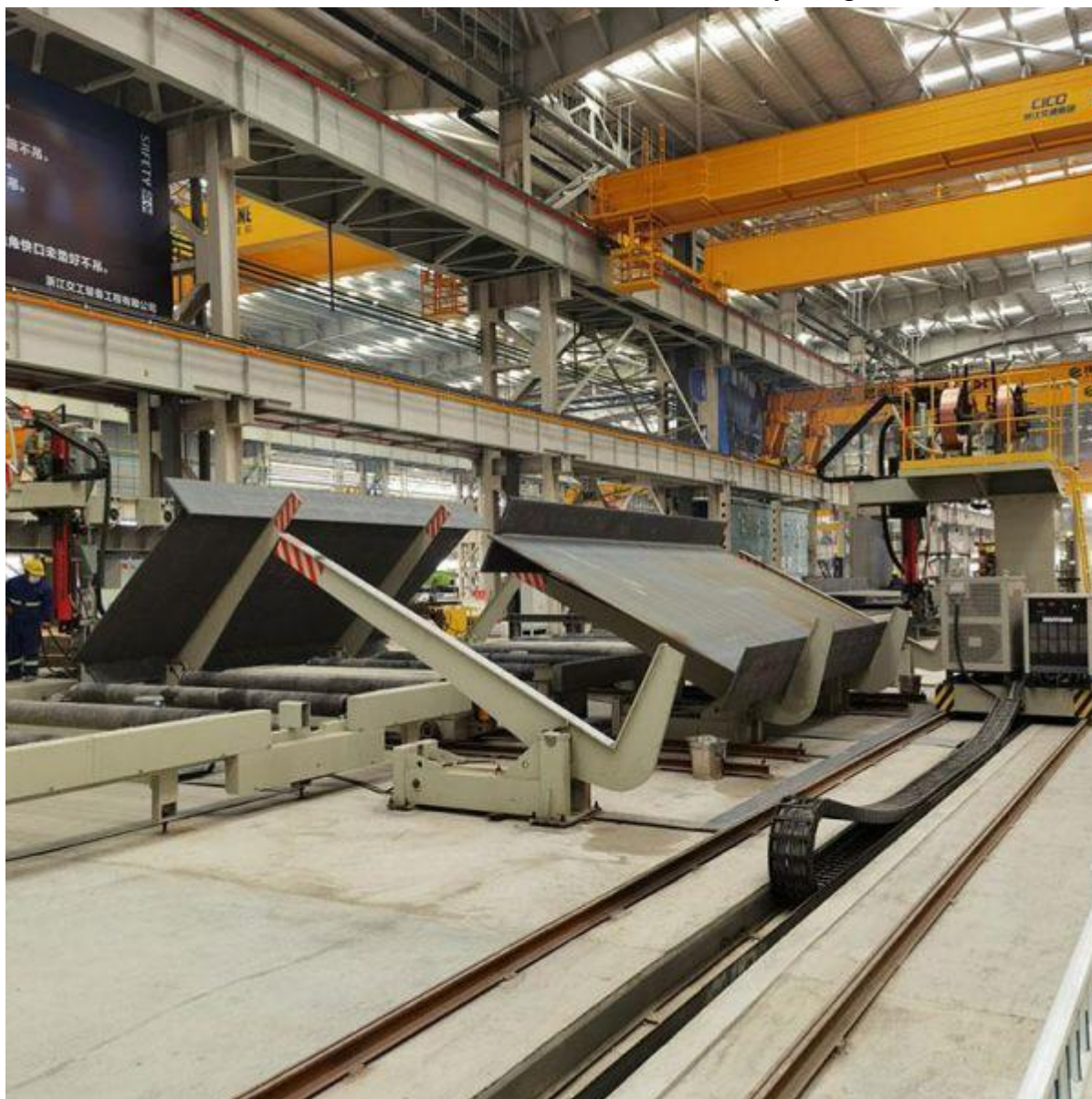
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Between Welding #1 area and #2 area, there is one set of beam flipper to overturn the beam that have been welded with 2 welding seams in 180 degrees to make the other 2 welding seams need welding to face top.





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In Welding area #2, includes the same as Welding area #1.

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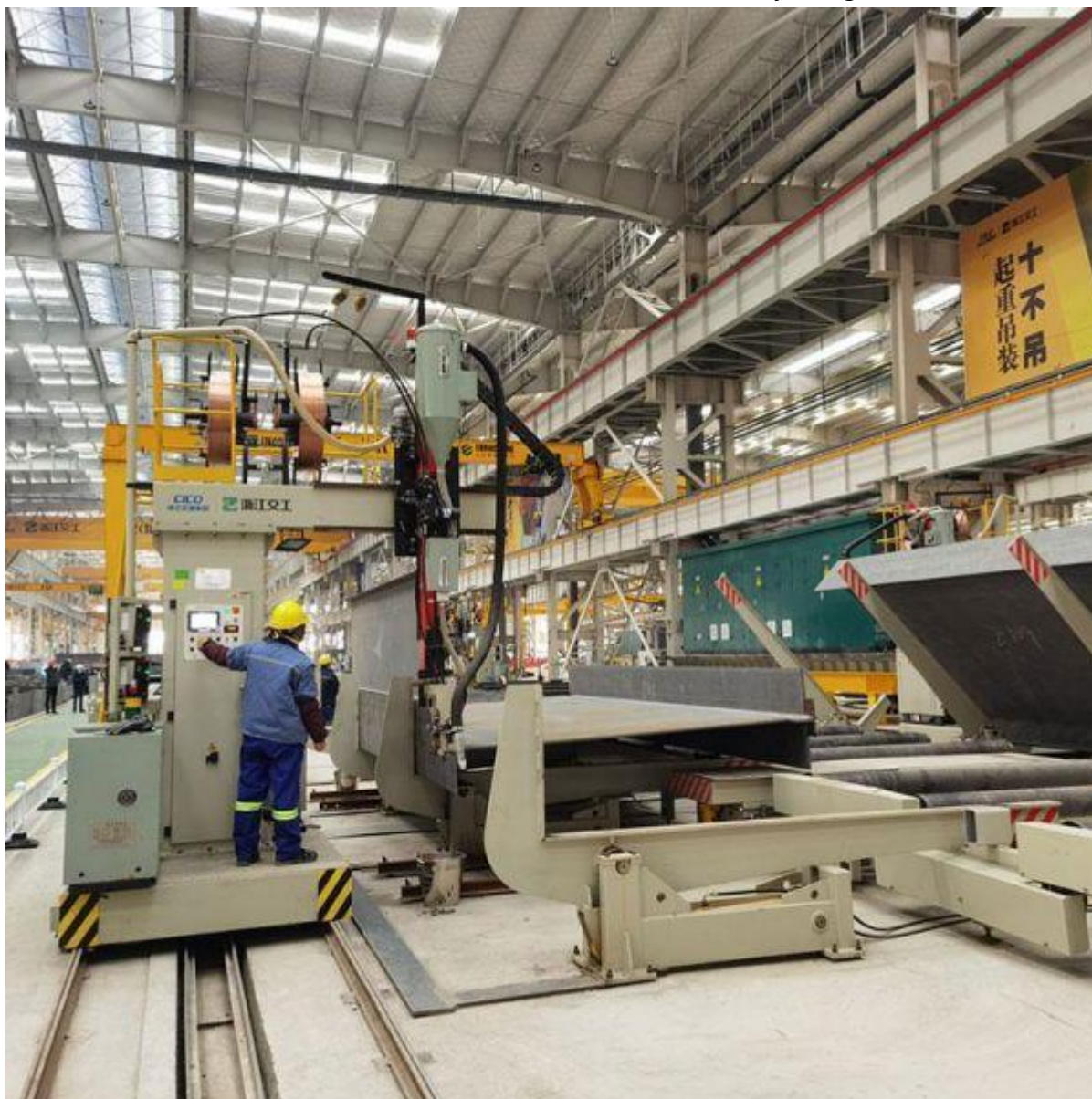
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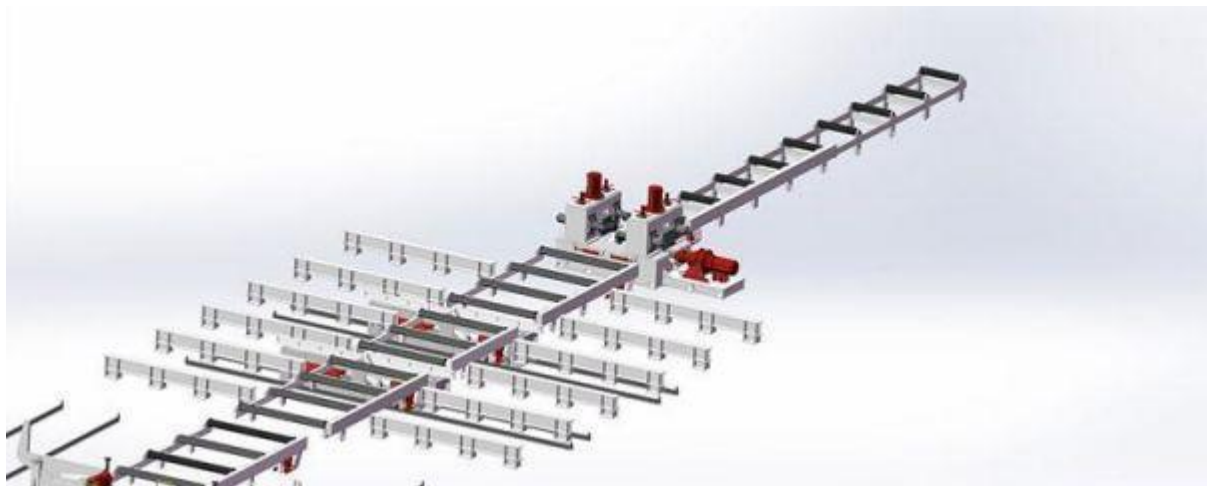
### **3-Straightening area, includes:**

One set of Beam flipper to overturn the H beam from “H” position to “I” position for the straightening on the flange of beam by straightening machine next.

One H beam flange straightening machines - for straightening the flanges of H beam. One H beam has 2 flanges. Both flanges need straightening. But the machine one time can straighten on one flange. So after complete the straightening of 1 flange, then the beam flipper will overturn the beam at 180 degree to make the flange that need straightening on bottom side.



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How to produce a welded H beam/ I beam from steel plate?

Following is the production flow chart for the production from plates till H beam and final inspection.

### **Production flow chart**

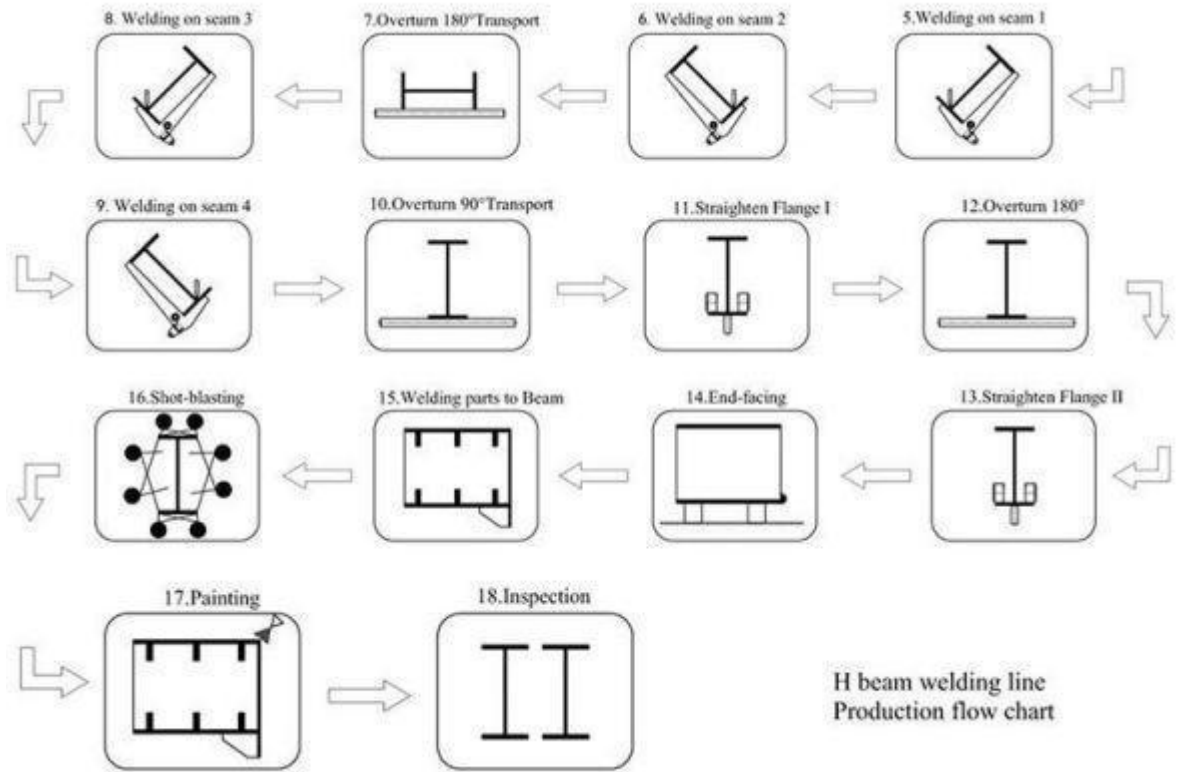
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