



# Kjellberg®

## FINSTERWALDE

## SUBMERGED ARC WELDING

## WELDING AUTOMAT



### KA 1-UP 5 mm

Application: SA single arc welding and cladding on even surfaces with or without guide rails

Welding wire: 2.4-5.0 mm

Article no.: .11.300.105.N

### Advantages

- ✓ Mobile, self-propelled welding automat, which easily can be moved to any working place
- ✓ Easy control by pre-set controls for welding current, arc voltage and travel speed in connection with Kjellberg power sources
- ✓ Start and stop circuit for optimising the welding process; start and crater filler parameters to adjust separately
- ✓ Exact positioning of the welding head with cross slides in horizontal and vertical direction or guidance along bars, profiles etc.
- ✓ Reliable wire feed
- ✓ Encoder-controlled tractor with all-wheel drive (rubber or optional grooved rims)
- ✓ Dust-protected manual drive coupling and optional axle extensions for additional stabilisation
- ✓ Control elements on two service levels
- ✓ Quick adaptation to other process variant thanks of modular system (e.g. single wire to double wire)

### Standard equipment

**Carriage**  
**Wire feeder**  
**Laser pointer**  
**KA control**  
**Flux hopper**



Robust feeding gear for wire up to Ø 5.0 mm



SA parallel wire nozzle for KA 7-UPP

Technical data	KA 1-UP 3 mm	KA 1-UP 5 mm	KA 7-UPP
Article no.	.11.300.103.N	.11.300.105.N	.11.300.700.N (double wire)
Welding current max.	800 A	1200 A	1200 A
Wire diameter	1.6-3.2mm	2.4-5.0 mm	2x 2.0-2x 3.0 mm
Wire feed speed	0.1-10 m/min	0.1-6.5 m/min	0.1-10 m/min
Travel speed		0.1-1.5 m/min	
Cross/height adjustment		100/100 mm	
Column swivel range		360 °	
Welding head inclination		45 ° (to both sides)	
Mass KA+wire reel	57 kg + max. 30 kg	66 kg + max. 30 kg	68 kg + max. 2x 25 kg
Travel gauge		265 mm Option: 330 oder 395	
Dimensions L x W x H ca.	1110 x 560 x 940 mm	1050 x 600 x 900 mm	1050 x 600 x 900 mm
Control voltage		42 V AC/50 Hz	
Recomm. power source	GTH 802	GTH 1202	GTH 1202

### Options

**Flux recovery unit**  
**Rails**  
**Gap welding nozzle**  
**Grooved wheels**

Kjellberg is certified acc. to  
**DIN EN ISO 9001**

**www.kjellberg.de**

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