



TECHNICAL DATA SHEET
Miller PipePro® Auto XCS
Product: XCS

Pg. 1/7

Rev. 03

Miller PipePro® Auto XCS



Digital Automatic Welding System specific to weld the root pass with or without backing support in the pipeline.

Note: the system needs to be fed with an electric generator having a minimum output power of 60kW.

System Composed by:

CONTROL BOX



The Box contains the two Power Sources Miller PipePro® 400XC-CE, Electric panel (RAD), Dual welding gas mixer for Argon –CO₂, one Display to visualize the welding parameters.

Technical data:

Length (mm): 1000

Width (mm): 1000

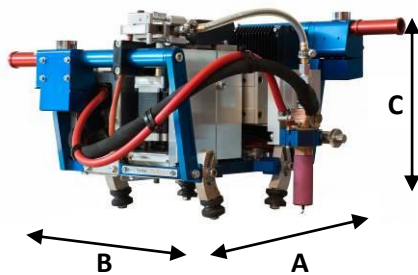
Height: (mm): 1200

Weight (Kg): 340 with Power Source

Input voltage: 48V Three phase

Degree of protection: IP 23

WELDING BUG:



N°2 Welding bugs (NO Right and LEFT bug) equipped with standard welding torches and External Standard welding wire spool (15 Kg.).

Technical data:

Length "A" (mm): 380

Width "B" (mm): 450 (with the handles)

Height "C" (mm): 300

Weight (Kg): 16

Vertical Axis stroke (mm): 30

Horizontal stroke (mm): 55

Tilt sensor: accurate to +/- 1°

Torch Inclination: +/- 10°, accurate to +/- 1°

Oscillation amplitude (mm): from 0 to 25

Dwell time: 0-2 sec.

Wire feed speed: 0-15 m/min

Travel speed: 0-150 cm/min

Wire feed motor: Digital Stepper Motor

Travel motor: Digital Stepper Motor

Oscillation and Horizontal motor: Digital Stepper Motor

Vertical motor and CTWD (Control tips work distance) motor: Digital Stepper motor

Tilt motor: Digital Stepper Motor

Minimum Cutback Distance (bevel to coating): 140 mm

Minimum Cutback Distance (bevel to concrete): 305 mm

Operating temperature: -30°C / + 60°C

Pipe diameter capacity: minimum 6"

MILLER PIPEPRO® 400 XC-CE



N°2 Miller PipePro® 400XC-CE with Adv-Pulse program (Advanced Pulse). The Adv-Pulse process can guarantee constant root penetration, low spatter level and High Speed without Copper Back support.

Technical data:

Length (mm): 381

Width (mm): 705

Height (mm): 464

Weight (Kg): 57

Welding processes: Adv-Pulse and Pulsed Mig (P-GMAW), Mig and RMD (GMAW), Flux Cored (FCAW), Stick(SMAW), Stick), Multi-process Welding

Input Voltage: 380-400, 50/60Hz

Welding current Range: SMAW: 40 - 350A

GMAW / FCAW: 0 – 400A

External optional Wire Feeder for Semiautomatic Welding

SPOOL HOLDER WITH MONITOR



N°2 Spool Holders complete with monitor to visualize and change the welding parameters during the weld.

Technical data:

Length (mm): 450

Width (mm): 320

Height (mm): 555

Weight (Kg): 5 (Without spool)

Degree of protection: IP 54

Operating Temperature: -30°C / + 60°C

Input Voltage: 12V

COMUNICATION AND SUPERVISOR MODULE



The module SCS is used by Miller PipePro® Auto XCS system to supervise and to communicate.

It is located into the welding cabin and it is fixed on an insulating plate. It supplies fast connections between all the cables that have to enter in the welding cabin.

Technical data:

Length (mm): 450

Width (mm): 320

Height (mm): 555

Weight (Kg): 2

Degree of protection: IP54

Operating temperature: -30°C / +60°C

Input voltage: 65V – 24V – 12V

SET of CONTROL and POWER CABLES



Set of Control and Power Cables are composed with:

- N°4 Power cables (+ and -) 95mmq – L=25mt
- N°4 Power cables (+ and -) 95mmq – L=7.5mt
- N°1 Control Cable L=25mt
- N°2 Control Cables L=7.5mt
- N°2 Cables for Monitor
- N°1 Cable for Emergency
- N°2 Hoses for Mix Gas
- N°2 Hoses for Pneumatic

PRESSURE REDUCER FOR ARGON AND CO2



Pressure reducer group composed by: manifold to connect, at the same time, 4 gas bottles, one way valves, high pressure tap, pre heater (for CO2 only) pressure reducer.

Technical data:

- Inlet pressure: 300 bar Max.
- Outlet pressure: 15 Bar Max.
- Input Voltage: 220V mono phase
- Degree of protection: IP 23

TRANSFORMER 380/48 V



Transformer 380V – 48V Three-phase, with voltmeter on output and plugs for auxiliary devices 220V.

Technical Data:

- Length (mm): 380*
- Width (mm): 610*
- Height (mm): 650*
- Weight (Kg): 75*
- Voltage: Input 380V 3-Phase, 50/60 HZ*
- Power: 6KVA*
- Output Voltage: 1 x 220V mono phase, 1 x 48V mono phase, 1 x 48V three phase*
- Degree of protection: IP 44*
- All sockets are provided with adequate circuit breaker according to the specific loads.*

General Features:

- Optional Bluetooth technology on the remote control
- On board display shows key parameters
- Touch screen panel into the cabin allows to modify key parameters (Travel Speed, Wire Speed, Oscillation width and Frequency).
- Easy parameters programming with a standard Windows notebook and dedicated PWT software.
- Wireless data transfer for welding parameters and data logging
- Each bug can be programmed independently
- Interpolation of welding parameters between two sectors
- Possibility to program up to 12 welding passes
- Up to 20 welding sector programmable
- Smart software allows different welding processes for the same joint
- Possibility to tilt/drag torch angle during welding
- Auto setting and centering of all stepper motors
- Easy voltage and current sensors calibration
- Auto Control Tip Work Distance maintains the torch at a constant distance to the pipe
- Actual Heat Input shown on the welding panel
- Complete tracking of welded joint with the PWT data log (.xls or .pdf)
- Burn Through prevention and Penetration Control.

Programmable welding parameters:

- Client.
- Project.
- WPS.
- WPQR.
- Note.
- Pipe Diameter.
- Code.
- Welding Process.
- Welding Run (Max 12).
- Welding Run Name.
- Angle (Max 20 sectors).
- Wire Feed Speed.
- Wire Feed Adjust (it Depends of the process)
- Travel Speed.
- Torch Inclination.
- Oscillation Amplitude.
- Oscillation Frequency.
- Dwell Time.
- Stick Out (it Depends of the process).
- Volt.
- Amp.
- Arc Length (it Depends of the process).
- Arc Control (it Depends of the process).

-
- Gas Mixing.
 - Starting Position.
 - Ending Position.
 - Down Hill Movement.
 - Up Hill Movement.

Stick Out Parameters (it Depends of the process).

- Manual override.
- Sampling time.
- Limits.
- Sampling Move.
- Hysteresis.
- Stick Out Management.

-
- Dwell Time Adjust Right.
 - Dwell Time Adjust Left.
 - Wire Diameter.
 - Wire Code.