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Alternative annealing methods – an overview

Why is annealing necessary?

Depending on the carbon content and other alloy components in steel, a hardened joint will form in the welded zone. This must be corrected to avoid breakage in the following production steps.

Which possibilities are available?

Manually-controlled annealing

The operator holds a button until the desired annealing colour has been reached. This method depends on the operator's experience and the lighting conditions at the workspace.
The annealing device either has a fixed annealing length (NV) or the annealing length is variable (LNV).

NV – Standard annealing device
Suitable for steel wire with low carbon content.

LNV – Optional annealing device
Suitable for steel wire with a carbon content of more than 0.5 %. Used for steel wire, steel cables and prestressed concrete wire.

Programmable annealing with the V20 controller

The annealing process is controlled by a program. The programs use power and time values to achieve an annealing and welding result that can be accurately reproduced.
The controller, which has been continuously developed for 20 years, offers users a high level of reliability and intuitive operation.

Controlled annealing with a pyrometer

The annealing temperature is measured by a pyrometer and controlled based on a preset temperature curve. This special method is used for processing steel with the highest quality standards.

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V20 welding and annealing controller

The new generation of welding controllers combines trusted functionality with intuitive operation.

The large 5.7" display makes navigation within the menu particularly easy.

Highlights of the V20

- Intuitive menu navigation
- Large 5.7" display
- Standard SD card slot
- Fully backwards compatible
- Existing welding programs can be imported

The integrated SD card slot allows for simple and quick exchange of welding programs between controllers.

Existing welding programs from prior versions of the controller can also be transferred.

The SD cards can be read at any PC using a standard card reader. This allows for simple archiving, editing and managing of welding programs.

Certain data, such as edit permissions for welding parameters, can be protected against unauthorized access with a password.

The V20 can recognize and compensate for voltage variations of ±8%. The supply frequency is automatically recognized.

Annealing can now be performed in up to three time-controlled segments. This allows for optimal post-treatment of even the most critical materials.

Conversion of the V12 to the new V20 is performed with a simple replacement of the controller unit.

User-defined naming of welding programs allows the user to use company-internal names.

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AUGUST STRECKER GmbH & Co.KG

P.O. Box 1337 – D-65533 Limburg/Lahn
Germany

Phone: + 49 64 31 96 10 - 0
Fax: + 49 64 31 96 10 - 600
e-mail: sales@strecker-limburg.de
Internet: www.strecker-limburg.de