

## Nelweld<sup>®</sup> N4000<sup>™</sup> Auto-Feed Boiler System

*Stud welding system for linings of coal or gas fired steam boilers, paper mill boilers and EFW boilers*

This reliable auto-feed boiler stud welding package is ideal for boiler liner fabrication and maintenance. Computer controlled Nelweld 4000 can weld 3/8" and 1/2" refractory studs at high rate and can be configured to power single gun or dual gun output. Series 8000<sup>™</sup> vibratory feeder sorts studs and feeds them by compressed air through a plastic tube (up to 25 feet) to the front-end of a floating lift gun typically at 6-15 studs per minute rate. Drawn-arc with ceramic ferrule provides the best weld quality. The features and benefits include:

- Save time and labor in boiler liner installation and repair
- Clean, positive attachment. Driver or gunite refractory flows easily and completely around all studs
- Less downtime. Fast split second drawn-arc welding and stud is reloaded with auto-feed
- Nelson provides field support and boiler stud welding expertise for scheduled boiler maintenance

Manual or automatic feed equipment may be rented or purchased. Consult your local Nelson Sales Representative for details. The welding system carries a 2 year or 1,000,000 weld warranty.

### Applications

- Fabrication of new boilers, replacement panels and tubes
- Maintenance re-studding of boilers in service

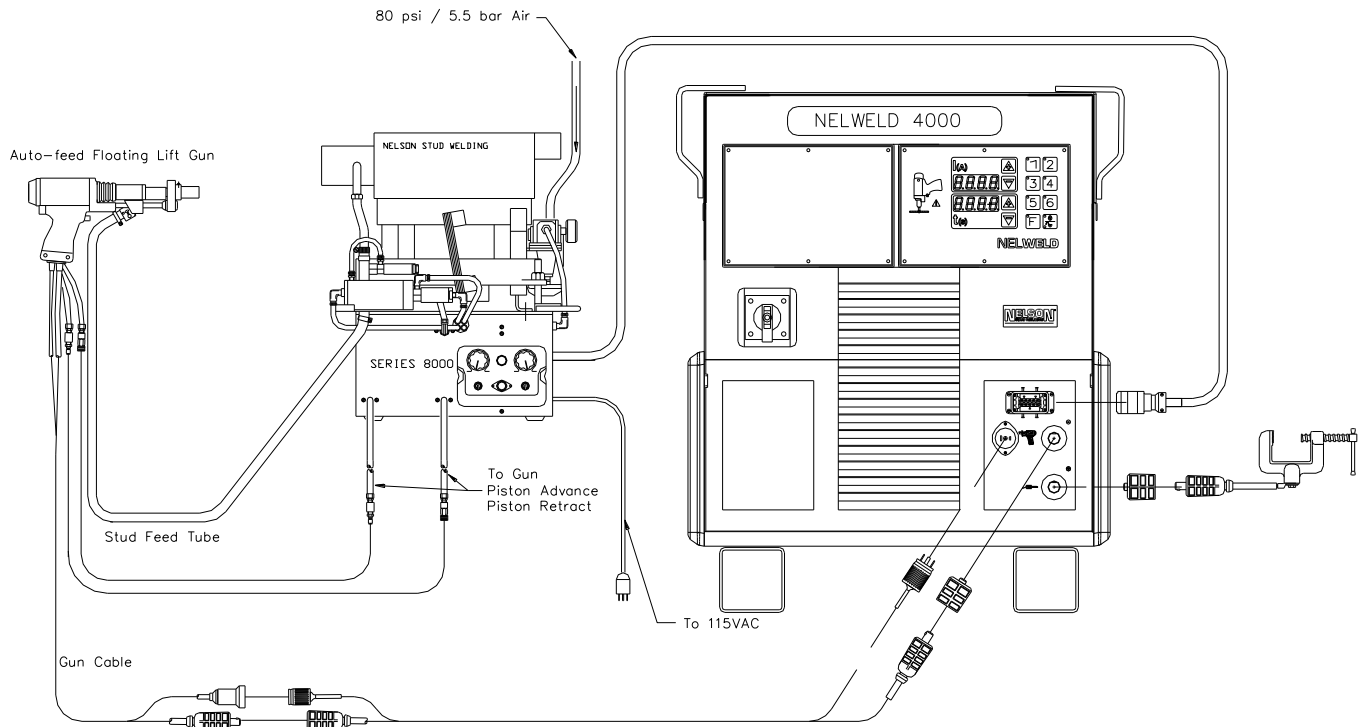
### Stud Materials

- Mild steel NBL studs for standard boilers
- Stainless steel 430 NBL studs for high erosion resistance
- New Alumna<sup>™</sup> alloyed studs for best performance and longest liner life

### Stud Functions

- Anchoring refractory material to tubes
- Heat transfer
- Slag retention
- Abrasion resistance





### N4000 Power Unit

<b>Weld Current</b>	300-2100A continuously adjustable
<b>Weld Time</b>	20-1400 ms continuously adjustable
<b>Dimensions</b>	24"W x 27" H x 33.5" D
<b>Power Input</b>	3 phase 230V/460V/575V, 50/60 Hz
<b>Weight</b>	725 lbs
<b>Weld Rate</b>	1/2" @ 19 studs/min, 3/8" @ 22 studs/min

### Auto Feed Boiler Gun

<b>Stud diameter</b>	3/8" and 1/2"
<b>Auto Feed</b>	350-900 studs per hour
<b>Weight</b>	4 lbs without accessories and cables
<b>Dimensions</b>	12-1/4" x 6-1/4" x 2-3/4"

### Series 8000 Feeder

<b>Feed Rate</b>	6-15 studs / min.
<b>Stud Capacity</b>	Approximately 1,000 studs
<b>Air pressure</b>	80 psi
<b>Air Flow Rate</b>	5 cfm
<b>Power Input</b>	Single phase 115VAC, 50/60 Hz
<b>Bowl Weight</b>	25 lbs
<b>Bowl Dimensions</b>	18" x 18" x 5"
<b>Drive Unit Weight</b>	82 lbs
<b>Drive Unit Dimensions</b>	9-1/2" x 11"x11"
<b>Base Weight</b>	57 lbs
<b>Base Dimensions</b>	8-1/2" x 19" x 16-1/2"
<b>Overall Dimensions</b>	23" x 23" x 23"

## Options

Nelware™ PC production monitor data recording

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