

Tech Talk: An Optimal All Position Production Welding Solution

By Bob Page, September 25, 2013



Dual wire feeders have never really caught fire, in part, because fabricators see the price tag and think justification is probably not there. Connected to ROI, there may be some misunderstanding with regard to in position vs. out of position wire deposition rate and efficiency.

Let's look at a single wire vs. dual wire all position solution. Fabricators love 045 E71T-1 wires for their operator appeal and ability to weld in all positions. And while these gas shielded fluxcore wire's maximum out of position deposition rate is a very respectable 9 lbs/hr; its in position deposition rate is only 11 lbs/hr with an efficiency of 86%. If we wanted a more productive in position wire, and 045 E70C-6 metalcore wire could give us 18 lbs/hr deposition and 98% efficiency. While 18 lbs/hr would be extremely difficult for a human to deposit, perhaps 13 or 15 lbs/hr wouldn't be. And, most importantly, metalcore wires don't incur the labor cost of chipping slag (because there isn't any) which translates to increased arc on time.

What's more, both wires can run on the same shielding gas as long as argon content is between 82-85% (the balance being CO₂). For all position welding, dual wire feeders represent a great productivity enhancing opportunity for all position welding.



If you would like more information on this or other cost reduction ideas, please contact our **Productivity Enhancement Team** at **303-892-7003**.