

For S and
MicorMIG series

MAXIMUM POWER WITH FLUX-CORED WIRE

Flux-cored wire packages with
Lorch Speed processes



New options for flux-cored wire welding

Flux-cored wires are a particularly popular choice for welders who need to weld thick and heavy components, which are subjected to great dynamic stresses. However, their use is limited to specified fields of application.

Lorch welding equipment and the new Lorch flux-cored packages combined with the advantages of the innovative Lorch Speed processes can expand the application fields of flux-cored wire welding extensively and enable improved welding speed.*

Customers will weld up to 30% faster
with Lorch welding system + Speed processes + flux-cored wire packages*

Challenges to overcome in flux-cored wire welding

Excessive heat input per unit length

For welding thin sheets and applications requiring low distortion, rutile flux-cored wire is not well applicable due to the spray arc.

Insufficient arc during full-penetration welding

The tulip-shaped arc characteristic of flux-cored wires creates more pressure on the sidewall rather than in the root, which is why full-depth penetration can not be guaranteed. Therefore a time- and cost-intensive gap preparation is necessary.

Extensive vertical seam welding

Since metal-cored wire does not produce any slag, the weld pool is not supported, making the task of welding vertical seams into a strenuous chore and, in some cases requires a change to rutile flux-cored wire.

Root penetration with thick wires

The lower voltage, which occurs with thick wires, makes good root penetration more difficult. Therefore, thinner wire is used for the root layer.



Innovative Lorch Speed processes

Speed Arc

SpeedArc (XT)

The SpeedArc (XT) convinces with a particularly focused arc and a significantly higher energy density than comparable processes. This achieves a particularly deep penetration into the base material which cannot be compared with the penetration performance of normal MIG-MAG systems. The greater arc pressure that flows into the weld pool makes MIG-MAG welding with the SpeedArc (XT) noticeably faster and, consequently, much more economical.

Speed Arc XT

Speed Up

SpeedUp

Up to now, vertical seam welding required a tremendous amount of experience and a steady hand. SpeedUp combines the hot high-current phase with the cold phase to offer a reduced heat input – thereby, offering good penetration, well proportioned weld seams and nearly perfect a-measurement dimensions. Unparalleled arc regulation delivers outstanding speed and produces results that show no flaws and virtually no spatter.

Rutile flux-cored wire with SpeedArc and SpeedArc XT

Reduced material distortion

Take advantage of the tremendous dynamic offered by the SpeedArc (XT) and weld with dramatically increased speed even with positional welding and with minimised distortion of the base material.

Option to weld thin metal sheets

Affording you maximum control of the arc and the weld pool, SpeedArc (XT) keeps you from operating with excessively high amperage when welding medium sheet metal. Weld sheets of thin to medium thickness (4–8 mm) in spite of the spray arc.

Root welding with thick diameter wires

Save yourself the trouble of changing the wire between root and fill layers by benefiting from the increased arc pressure of the SpeedArc, which ensures optimum root penetration even during work with larger, rutile flux-cored wires (e.g. 1.6 mm).



Speed Arc

Speed Arc XT

Metal-cored wire with SpeedArc and SpeedArc XT

No costly gap preparation

Do not waste your time and money on elaborate gap preparation. The SpeedArc (XT) provides for a tulip-shaped arc that is highly focused, transforming it into an arc offering the same properties as with a solid wire arc. This transformation allows the welder to achieve full-depth penetration on the root passes.



Speed Arc

Speed Arc XT

Metal-cored wire with SpeedUp**

No weaving when welding vertical seams (HotPass)

The reduced energy input made possible by the SpeedUp process allows to complete vertical seams exceedingly fast and with exceptional ease. The laborious weaving whilst welding the first layers of vertical pipe seams (HotPass) is made a thing of the past. This makes jobs significantly easier that require quick completion due to particular work or environmental conditions.

No additional wire changes

The optimised control technology built into SpeedUp makes it possible to weld vertical seams with metal-cored wire. The former need for a switch to rutile flux-cored wire has been eliminated, saving both time and money.



Speed Up

* Depending on the previously used welding system, the setting parameters and the application.

** Note: use metal powder cored wires approved for welding vertical seams.

The flux-cored wire packages for Speed processes

Complementing the Lorch Speed processes, Lorch's flux-cored wire packages are compatible with the most common rutile and metal-cored wires on the market and are available for MicorMIG, MicorMIG Pulse, and S-SpeedPulse XT machines.

MicorMIG and MicorMIG Pulse series:

Type of wire	Lorch Speed process	Wire diameter	Gas	
			82/18 Ar/CO ₂	CO ₂
Rutile flux-cored wire	SpeedArc	1,2	●	●
		1,6	●	●
Metal-cored wire	SpeedArc	1,2	●	●
		1,6	●	●
	SpeedUp	1,2	●	—



S series:

Type of wire	Lorch Speed process	Wire diameter	Gas	
			82/18 Ar/CO ₂	CO ₂
Rutile flux-cored wire	SpeedArc XT	1,2	●	●
		1,6	●	●
Metal-cored wire	SpeedArc XT	1,2	●	●
		1,6	●	●
	SpeedUp	1,2	●	—
		1,6	●	—



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