

TRACKLESS WELDING CARRIAGE WITH WIRE FEEDER - 400 MOGGY®



Carriage Features

- Integrated Wire Feeder for Improved Efficiency and Productivity
- Holds up to 12" Diameter Spools
- Continuous or Stitch Welding Modes
- Step Back Feature Reduces Weld Cracks
- Programmable Control

Additional carriage options are available:

- Lap Weld Guide Wheels
- Attachment for Internal Radius Welding
- Protective Pelican® Case
- V-Groove Track

GM-04-100-G - GAS/AIR COOLED

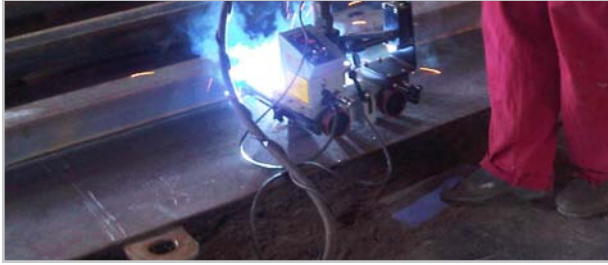
GM-04-100-W - WATER COOLED



Automate Fillet, Lap, and Butt Welds with Precision

AUTOMATED WELDING CARRIAGE WITH INTEGRATED WIRE FEEDER





The 400 MOGGY® is a trackless welding carriage with an integrated wire feeder, used to automate and improve manual welding processes in Shipbuilding, Tank Construction, and other heavy fabrication applications. The carriage is a lightweight, portable, four wheel friction drive travel carriage that can be used with or without track to automate welding operations. A speed potentiometer provides infinite speed selection within the speed range.

The 400 MOGGY® can be adapted for use on standard 6" (152.4mm) v-groove track by reversing the wheel assemblies. Safety is assured by using Gullco low voltage 24 volt DC highly advanced control power supply system that is available in 3 line voltage inputs 42, 110 and 230 volt AC 50/60 Hz.

Please specify line voltage when ordering.
(see part number configuration)

SPECIFICATIONS:

Carriage Travel Speed: 1.6 to 54 IPM (4 to 137 cm/m)

Wire Feed Speed Range: 24 to 791 IPM (0.6 to 20 m/m)

Manual Adjustment Vertical and Horizontal Slides: 1-3/4" (44.4 mm) adjustable range

Welding Spool Size: The standard spool holder, 2" (50 mm) hub diameter, will accept both 8" and 12" diameter wire spools

Wire Feeder Drive Rolls: 0.8 mm to 1.6 mm V-groove wheels, 1.0 mm to 2.0 mm V-groove knurled wheels (1.0/1.2 mm V-groove knurled comes standard, see chart on reverse for available options)

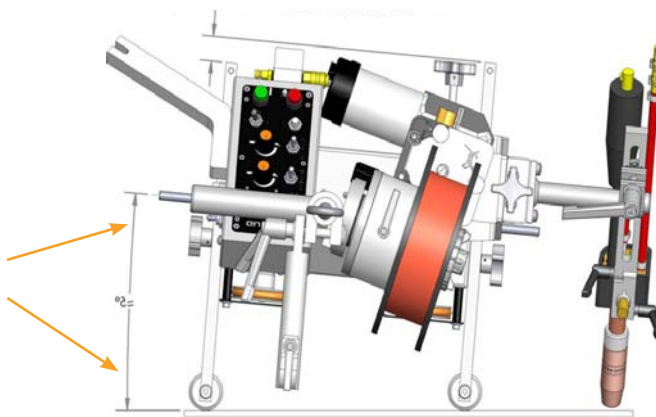
Carriage Umbilical: 25 ft. (7.6 m) in length and protected by a 500°C (932°F) rated cover. Contains torch power cable, shielding gas hose, carriage power cable, arc start cable, and water hoses if equipped

Optional 400 MOGGY® Carrying Case (Pelican): GM-04-050

PRECISE TORCH ALIGNMENT TO THE SEAM

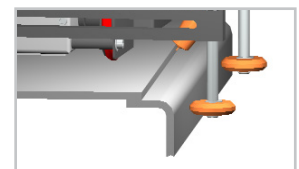
Adjustable guide rolls mounted on the front or back of the carriage monitor the slightest seam variations following straight or curved surfaces, maintaining optimum torch positioning.

Carriage wheel assemblies maintain constant guide roll pressure on vertical component through the 4 wheel friction drive system. The guide arms are offset to allow for this.



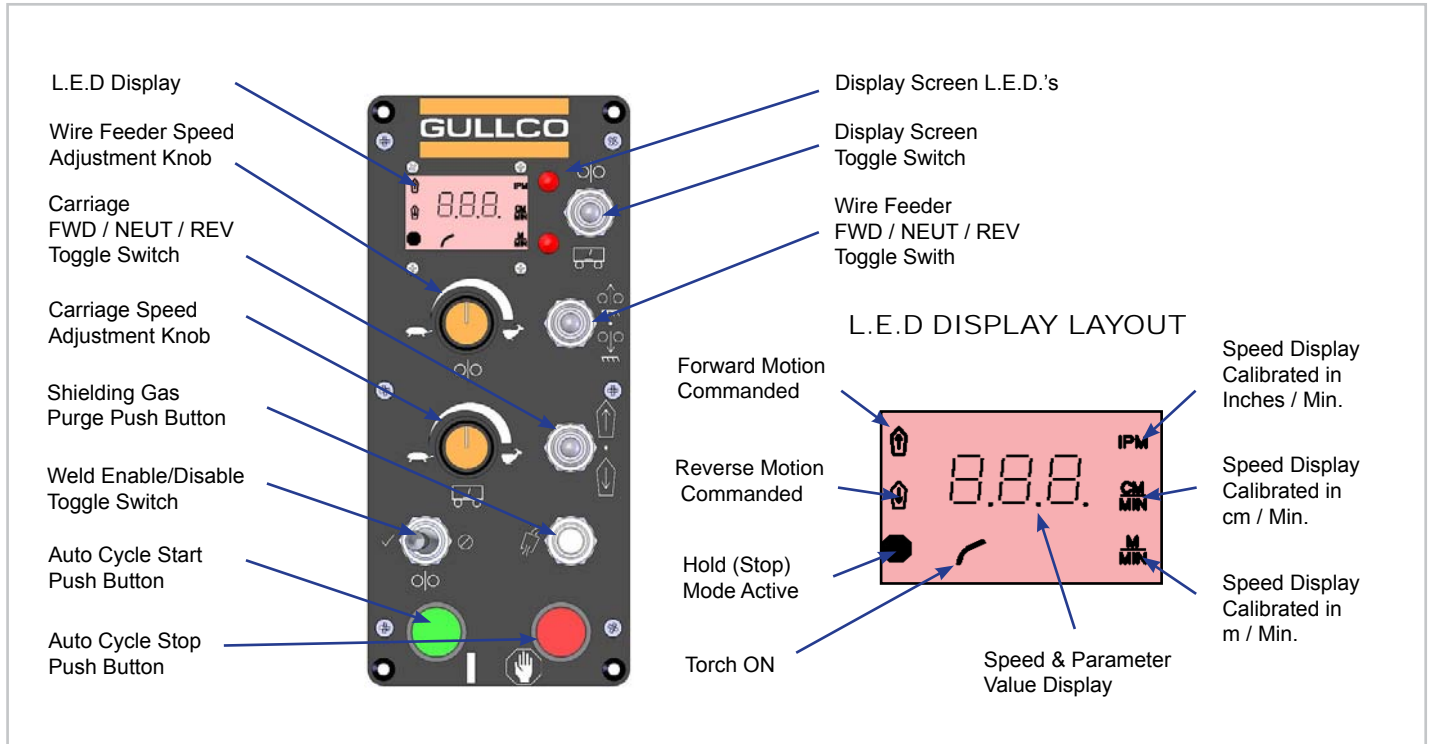
Operates along straight or curved surfaces...

The 400 MOGGY® guide roller assemblies can be configured in a variety of ways enabling the carriage to be used in a variety of applications

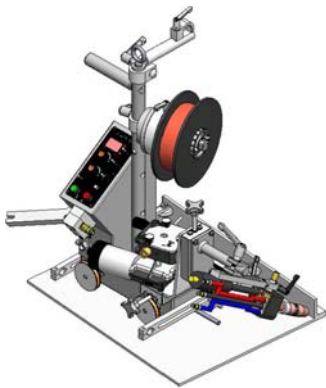


CARRIAGE CONTROL LAYOUT

The Series 400 MOGGY® carriages use the Gullco GSP-2030 a sophisticated microprocessor motor control which provides precise control of the application parameters. The L.E.D screen allows for increased visibility of the display during welding and the large controls allow for easy adjustment during operation.

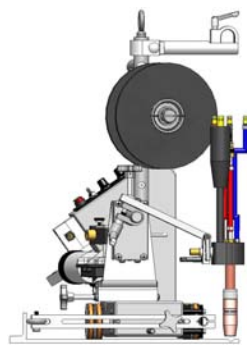


FILLET JOINT WELDING



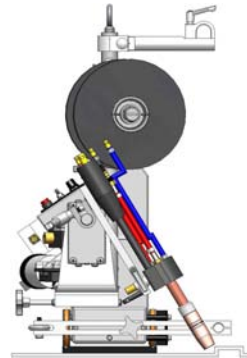
The 400 MOGGY® can perform fillet welds using the workpiece as a guide or a template, guide or fence positioned parallel to the workpiece.

BUTT JOINT WELDING



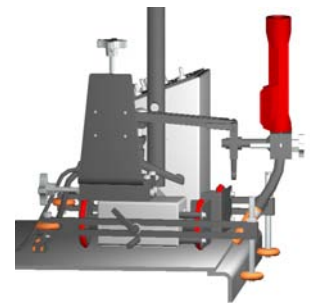
The 400 MOGGY® can perform butt joint welds. Here the 400 MOGGY® is using a parallel fence to guide it accurately along the desired path. Standard V-groove track can also be used.

LAP JOINT WELDING



The 400 MOGGY® can perform a lap joint weld. It is guided by various options including Industry Standard 6" (152.4mm) v-groove track running parallel to the joint.

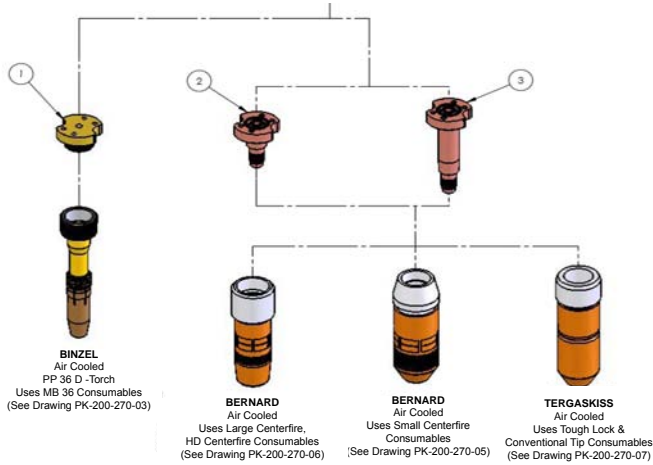
JOINT TRACKING



Adjustable height guide roller assemblies are available to track joints higher or lower than the set height of guide roller wheels.

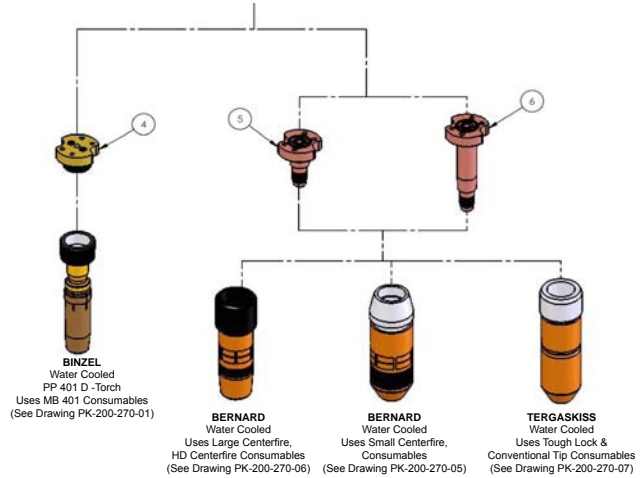
GM-04-100-G

For use with gas/air cooled welding torch necks and consumables. Additional items are required.

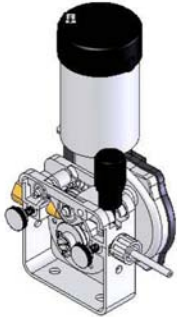


GM-04-100-W

For use with water cooled welding torch necks and consumables. Additional items are required.



WIRE FEEDER ROLL ORDERING SPECIFICATIONS



PART #	DESCRIPTION	QTY.
PK-200-035-10	Feed Roll V-groove 0.8 mm + 1.0 mm	2
PK-200-035-12	Feed Roll V-Groove 1.0 mm + 1.2 mm	2
PK-200-035-16	Feed Roll V-Groove 1.2 mm + 1.6 mm	2
PK-200-035-12-K	Feed Roll V-Groove 1.0 mm + 1.2 mm Knurled	2
PK-200-035-14-K	Feed Roll V-Groove 1.2 mm + 1.4 mm Knurled	2
PK-200-035-20-K	Feed Roll V-Groove 1.6 mm + 2.0 mm Knurled	2

*The 400 MOGGY® has a selection of feeder rolls available for different requirements.
400 MOGGY® comes standard with PK-200-035-12

400 MOGGY® PART NUMBER CONFIGURATION

GM-04-100- -

TORCH TYPES	
MODEL	DESCRIPTION
G	Gas/Air cooled torch - Binzel, Tregaskiss and Bernard
W	Water cooled torch - Binzel, Tregaskiss and Bernard
H	Water cooled torch - Dedicated Binzel torch

VOLTAGES*	
MODEL	INPUT SUPPLY
A	42 VAC
B	115 VAC
C	230 VAC

* All above voltage supplies are single phase, 50/60 hz, 100 watts

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