

A compact blend of simplicity and reliability; small enough to fit in a service truck, yet capable enough to tackle aggressive field applications with ease.



HIGH QUALITY AND PRECISION

Swivel head provides torch adjustment through a simple and robust ball and seat arrangement, the simplest design in the industry.

Automated skip / fill is a simple cam operated feature that allows the operator to easily program WELD ONLY or NO WELD sections of the bore up to 180 degrees. Simply set the cams and the machine takes care of the rest. Machine fully rotates between skip / fill sections.

Reverse Rotation allows the operator to reverse the rotation direction. This is typically used when the borewelder is in the horizontal axis and the operator needs to weld multiple passes. This feature alternates the uphill weld over the downhill weld of the last complete pass, simplifying multi-pass welding.

Hand held pendant allows operator to control welder operations from one hand held control panel. Rotation jog, weld stop/start, arc interrupt, and rotation speed

FLEXIBLE AND VERSATILE

Free position allows the operator to move the spindle freely for torch placement, or move the spindle quickly to change consumables when the need arises.

Adjustable step feed allows adjustability of bead placement and eliminates weld void at ends of weld.

Run mode allows the operator to move the spindle with the worm gear knob, allowing incremental fine adjustment of the axial start point, or when small adjustments are needed when welding.

Step lock-out allows the ability to face weld, greatly expanding the versatility of the welder. This feature also allows operators to

reduce or eliminate axial feed for the first or last passes.

Boring Bar Interface Kit allows quick alignment and attachment of the BW2600 to Climax Line Boring Systems for quick turnover between welding and boring for fast completion of jobs.

Adjustable base allows mounting of the BW2600 to fit any workpiece when not using a boring bar. The non-magnetic mounting base makes welding in job shops, machine shops, or specialized applications simple and easy.

SAFETY

Hand held pendant allows operator to control the equipment from the most advantageous location, allowing precise adjustments that customers require for best results.

SPECIFICATIONS, APPLICATIONS

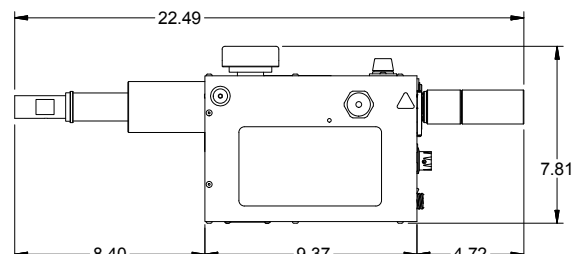
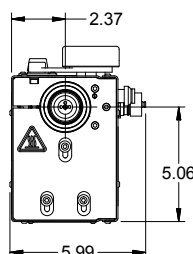
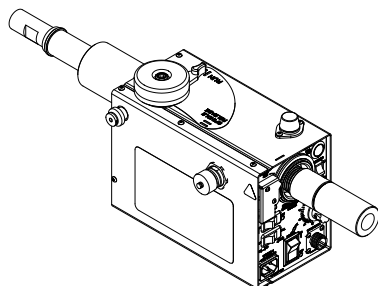
	US	Metric
Welding Process	Metal-Inert-Gas (MIG)	
Axial Travel / Stroke	9 inches	228.6 mm
Step Range (variable)	0.050 - 0.200 inches per rev.	1.27 - 5.08 mm per rev.
Wire Diameter Range	0.030 - 0.045 inches	0.76 - 1.14 mm
Base Package Extension Reach	21 inches	533.4 mm
Torch Extensions	3, 6, and 12 inches	76.2, 152.4 and 304.8 mm
Torch Welding Diameter Ranges		
ID Bores #00 - #10	0.88 - 24 inches	22.4 - 609.6 mm
OD Torches, max dia.	1 - 24 inches	25.4 - 609.6 mm
Face Torch	1 - 20 inches	25.4 - 508.0 mm
Unsupported Torch Reach	36 inches	914.4 mm
Max Continuous Welding Current	175 Amps	
Typical Voltage Operating Range	(short arc/.035 wire) 17 - 19 volts	
Power supply with burnback control required to use skip/fill function		
Weight (does not include mounting options)	41 Lbs	18 kg
Shipping Weight (does not include mounting options)	69 Lbs	31 kg
Shipping Dimensions	19.5 x 24 x 12 Inches	495.3 x 609.6 x 304.8 mm

WELD TIME IN MINUTES

		LENGTH OF BORE (INCHES)									
		1	2	3	4	5	6	7	8	9	10
DIAMETER OF BORE (INCHES)	1	1.3	2.5	3.8	5	6.3	7.5	8.8	10	11.3	12.6
	2	2.5	5	7.5	10	12.6	15.1	17.6	20.1	22.6	25.1
	3	3.8	7.5	11.3	15.1	18.8	22.6	26.4	30.1	33.9	37.7
	4	5	10	15.1	20.1	25.1	30.1	35.2	40.2	45.2	50.2
	5	6.3	12.6	18.8	25.1	31.4	37.7	44	50.2	56.5	62.8
	6	7.5	15.1	22.6	30.1	37.7	45.2	52.8	60.3	67.8	75.4
	7	8.8	17.6	26.4	35.2	44	52.8	61.5	70.3	79.1	87.9
	8	10	20.1	30.1	40.2	50.2	60.3	70.3	80.4	90.4	100.5
	9	11.3	22.5	33.9	45.2	56.5	67.8	79.1	90.4	101.7	113
	10	12.6	25.1	37.7	50.2	62.8	75.4	87.9	100.5	113	125.6
	11	13.8	27.6	41.4	55.3	69.1	82.9	95.7	110.5	124.3	138.2
	12	15.1	30.1	45.2	60.3	75.4	90.4	105.5	120.6	135.6	150.7
	13	16.3	32.7	49	65.3	81.6	95	114.3	130.6	147	163.3
	14	17.6	35.2	52.8	70.3	87.9	105.5	123.1	140.7	158.3	175.8
	15	18.8	37.7	56.5	75.4	94.2	113	131.9	150.7	169.6	188.4
	16	20.1	40.2	60.3	80.4	100.5	120.6	140.7	160.8	180.9	201

Weld deposition rate of 20 inches per minute & step of 0.125 inches

OPERATIONAL DIMENSIONS



All dimensions should be considered reference. Contact your Climax Representative for precision dimensions. Specifications are subject to change without notice.

TOOL CONFIGURATIONS

Configure your BW2600 in 3 easy steps.

- 1 Select Base Package
- 2 Select Conduit Assembly
- 3 Select Mounting Option

To configure the auto bore welder you require, simply select the option you need in each step, then contact your CLIMAX representative.

- 1 **Base Package** - Includes support rod, 7.5 foot (2.3 m) power cord, weld head, clamp collar, extensions 3, 6, and 12 inch (76.2, 152.4, and 304.8) tool kit, consumables starter kit, weld head, swivel torches #1 & #2, 2.75 - 12 inches (69.9 - 304.8 mm) diameter. **(Power supply with burnback control required to use skip / fill function)**

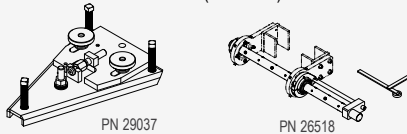
Machine Stroke, 9 inches (228.6 mm) **86686**

2 Conduit Assembly

Conduit Switch Assembly - Miller **85476**
 Conduit Switch Assembly - Euro Connection **85435**
 Conduit Switch Assembly - Tweco **85534**
 Conduit Switch Assembly - Lincoln **85536**
 Conduit Switch Assembly - Lincoln PowerMig **85527**
 Conduit Switch Assembly - Lincoln Tweco Style **86046**
 - with 5 pin Amp

3 Mounting Options

Adjustable Base, includes 5 inch (127 mm) radial mount **29037**
 Adapter Kit to BB3000 1-1/4 inch (31.8 mm) Bar **26795**
 Adapter Kit to BB4500 1-3/4 inch (44.5 mm) Bar **43731**
 Adapter Kit to BB5000 2-1/4 inch (57.2 mm) Bar **26518**



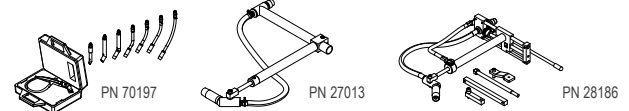
4 Options

Small Bore Kit, Torch #00 & #0, 0.88 to 3 inches (22.4 to 76.2 mm) - **Includes Standard Torch Adapter** **36750**
 Remote Control Pendant **85341**
 - **NOT REQUIRED to operate welder**



Image includes optional components

Swivel Torch Kit #1 & #2, - 2.75 - 12 inch (69.9 - 304.8 mm) Dia	70200
Torch & Bearing Clearance Kit, #00 to #5 - 0.88 - 24 inch (22.4 - 609.6 mm) Dia.	70197
Torch Bearing Clearance Kit - 12 - 24 inch (304.8 - 609.6 mm) Dia.	63916
Trammel OD Torch Package - up to 14 inch (355.6 mm) Dia.	27013
Trammel Torch 24 inch (609.6 mm) - Maximum OD Capability	38506
Face Torch 8 inch (203.2 mm)	28186
Compact Face Torch 6 inch (152.4 mm) Swing	48013
Conical Seat Torch	28020
Torch Counterbalance	30756
Torch Extension 3 inch (76.2 mm) *	29038
Torch Extension 6 inch (152.4 mm) *	29039
Torch Extension 12 inch (304.8 mm) *	29040
Torch Extension 18 inch (457.2 mm) *	29065
Torch Extension Support Kit	40877
Torch Adapter, Standard Torches to Swivel Assembly	33804



ACCESSORIES

Swivel Torches

#1 Swivel Torch 2.75 - 8.2 inches (70mm - 208mm) * 39725
 #2 Swivel Torch 8 - 12" inches (203mm - 305mm) * 39726

Torches (#00 - #11 torches require torch adapter, standard to swivel)

#00 Torch, 0.88 - 1.8 inches (22 - 46 mm) dia. 29063
 #0 Torch, 1.75 - 3 inches (44 - 76 mm) dia. 28448
 #1 Torch, 2.75 - 5.5 inches (70 - 208 mm) dia. 29064
 #2 Torch, 4.5 - 7.5 inches (114.3 - 190.5 mm) dia. 29032
 #3 Torch, 6 - 9 inches (152 - 228 mm) dia. 29033
 #4 Torch, 8 - 11 inches (203.2 - 279.4 mm) dia. 29034
 #5 Torch, 10 - 13 inches (254 - 330 mm) dia. 29035

Torches (#6 - #11 torches require counterbalance when used in horizontal axis)

#6 Torch, 12 - 15 inch (304.8 - 381.0 mm) Dia. **30345**
 #7 Torch, 14 - 17 inch (355.6 - 431.8 mm) Dia. **31792**
 #8 Torch, 16 - 19 inch (406.4 - 482.6 mm) Dia. **30346**
 #9 Torch, 18 - 21 inch (457.2 - 533.4 mm) Dia. **30710**
 #10 Torch, 20 - 23 inch (508.0 - 584.2 mm) Dia. **30711**
 #11 Torch, 22 - 25 inch (558.8 - 635.0 mm) Dia. **30712**

Torch Systems and Accessories

Torch Kit, #00 - #5, 0.88 - 13 inch (22.4 - 330.2 mm) Dia. 69896

Additional Consumables

Welding Tip #00, SPEZ Feed 0.045 inch (1.2 mm)	69554
Welding Tip #00, 0.035 inch (0.9 mm) *	69521
Welding Tip #00, 0.035 inch (0.9 mm) - Chromium/Zirconium	69891
Welding Tip #0, SPEZ Feed 0.045 inch (1.2 mm)	69555
Welding Tip #0, Standard 0.035 inch (0.9 mm) *	69520
Welding Tip #0, Standard 0.035 inch (0.9 mm) - Chromium/Zirconium	70204
Welding Tip, 0.035 inch (0.9 mm) *	69865
Welding Tip, 0.045 inch (1.2 mm)	70149
Diffusers *	69778
Nozzle #00, Braze On *	72974
Nozzle #0, Braze On *	36531
Nozzle, Screw On	69866

Mounting Options

Tool Alignment for BB3000 1-1/4 inch (31.8 mm) Bar	26656
Tool Alignment for BB4500 1-3/4 inch (44.5 mm) Bar	36062
Tool Alignment for BB5000 2-1/4 inch (57.2 mm) Bar	26487
Radial Mount 5 inch (127.0 mm), Radius Standard Spacer	28208
Radial Mount 10 inch (254.0 mm), Radius Spacer	35006
Mounting Rod Extender	30831

* INCLUDED IN BASE PACKAGE

CLIMAX APPLICATIONS, TRAINING AND SUPPORT

Applications



The BW2600 is widely used by these industries:

Mining & Heavy Construction
Pulp & Paper
On-site Maintenance and Repair
Factory Maintenance
Shipbuilding

Typical Applications:

- Bores, pivot points, buckets and hitches
- Valve and pump repairs
- Gears and gear boxes
- Motor housings and shafts

- Electric motor repair
- Loader bucket & hitch repair
- Shaft OD repair
- Mud pumps
- Hydraulic cylinder eyes
- Presses
- Castings and injection molds
- Continuous miners and drag lines
- Rotary crushers
- Jaw crusher pitman arms
- Diverter Vane

Training Program

CLIMAX has been teaching the fundamentals and fine points of portable machine tool operation for practically as long as we've been inventing and building the tools.

We offer several training facilities across the world - all facilities offer training for machine tool operators on safety and machine setup and operation. Trainees also receive technical tips and tools to improve operational efficiencies, with the vast majority of every program devoted to hands-on activities and skill development.

Whether it's a regularly scheduled course at one of our training facilities, or custom curriculum conducted at your facility, your machinists will benefit from courses developed by some of the most respected authorities in the business.

Call us today to register for a regularly scheduled class, or talk to us about how we can customize a training program for your specialized application.



Call CLIMAX for:

Rentals

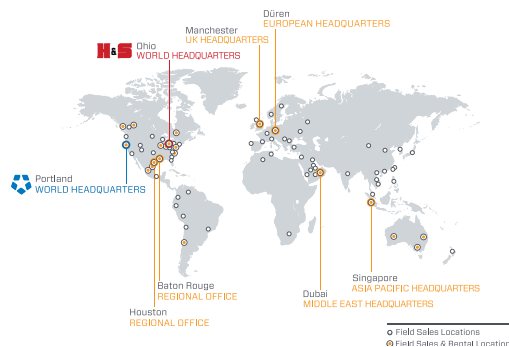
With worldwide rental depot locations, you are never far away from a CLIMAX tool.

On-site Training

Need some refresher courses in setting up and operating your CLIMAX machine tool?

Custom Projects

CLIMAX has been solving complicated machining, welding and valve testing problems for our customers since 1966



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