



# **CPRA 1250i + SAW**

# **Tractor CPRA**

## **Rugged and Reliable SAW Systems**

# Rugged and Reliable



- Rugged
  - Heavy Duty – 1250A / 100%
  - Wire diameter – 2.0 to 6.0mm
- Compact
  - Volume / Floor Space – 60% lower than conventional
  - Weight – 70% lower than conventional



CPRA 1250i

Parameter	CPRA 1250i
Output current at 100% duty cycle, A	1250
Output current range	60 – 1250
Dimensions, l x w x h, mm	840 x 380 x 900
Weight, Kg	115
Parameter	SAW Tractor CPRA
Wire (single) diameter range, mm	2.0 – 6.0



SAW Tractor CPRA

# Flexibility



- Multi-process Equipment
  - Submerged Arc Welding (SAW)
  - Manual Metal Arc Welding (MMAW)
  - Air Arc Gouging (AAG)
- Wide mains voltage band – 415V +/- 15%



CPRA 1250i

Parameter	CPRA 1250i
Process suitability	SAW, MMAW, AAG
Mains supply, V/Ph, Hz	415 ± 15% / 3, 50/60
Output current at 100% duty cycle, A	1250
Output current range	60 – 1250



SAW Tractor CPRA

# SAW Applications



- Designed for wide range of applications
  - IGBT based Inverter – excellent welding output
  - Solid and Cored wires - 2.0 to 6.0mm diameter
  - 4-Roll Drive – smooth and reliable wire feeding
  - Tractor mounted welding head (standard)
  - Boom mounted welding head (optional)



*CPRA 1250i*



*SAW Tractor CPRA*

# Controls and Display

## CPRA 1250i



- Digital display
  - Voltage
  - Current
- Welding process selection switch
- Fault indication
  - Under-voltage
  - Over-heating
- Adjustable controls
  - Current
  - Arc force
  - Ignition current (hot start)





# Controls and Display SAW Tractor CPRA



- Power ON/OFF switch
- Digital display
  - Voltage
  - Current
  - Trolley speed
- Push buttons
  - Welding Start
  - Welding Stop
- Stepless controls
  - Welding voltage
  - Welding current
  - Trolley speed
- Selector switch
  - Welding wire Forward / Back
  - Operating mode - Welding / Testing
  - Trolley direction – Forward / Reverse
  - Characteristics – CV / CC



# Safety and Reliability



- Wide mains voltage tolerance: 415V +/- 15%
- In-built protection
  - Over-heating
  - Over-current
  - Under-voltage
- Insulation class H - longer operational life
- 4-Roll drive – smooth and reliable wire feeding



*CPRA 1250i*



*SAW Tractor CPRA*



# Technical Specifications

## CPRA 1250i



Parameter	CPRA 1250i
Process suitability	SAW, MMAW, AAG
Mains supply, V/Ph, Hz	415 ± 15% / 3, 50/60
Input power, KVA (max)	71.9
Open Circuit Voltage (OCV), V	84
Output current at 100% duty cycle, A	1250
Output current range	60 – 1250
Dimensions, l x w x h, mm	840 x 380 x 900
Weight, Kg	115
Enclosure class	IP21S
Insulation class	H



CPRA 1250i

# Technical Specifications

## SAW Tractor CPRA



Parameter	SAW Tractor CPRA
Welding head	Tractor Mounted (Standard) Boom Mounted (Optional)
Wire (single) diameter range, mm	2.0 – 6.0
Welding speed (trolley), m/min	0.1 – 2.2
Wire feed speed, m/min	0.2 – 2.5
Height of cross beam, mm (adjustable)	100
Distance of tractor head, mm (adjustable)	100 x 100 x 70 (longitudinal, transverse, front and rear)
Rotation angle of cross-beam around vertical, deg	± 90
Tractor head inclination, deg	± 45
Torch inclination, deg	± 45
Flux container volume, ltr	6
Wire reel capacity, Kg	30
Dimensions, l x w x h, mm	1020 x 480 x 740
Weight (without wire spool), Kg	65



SAW Tractor CPRA

# Features and Benefits



Features	Benefits
Compact	Volume – 60% & Weight – 70% lower than conventional
Multi-process – CC/CV	SAW, MMAW & Air Arc Gouging (AAG)
Duty cycle – 1250A / 100%	Suitable for 24 x 7 usage
4-Roll Drive	Smooth and reliable wire feeding
Arc force (adjustable)	Control of spatter and penetration
Hot start (adjustable)	Smooth arc striking in MMAW
Mains voltage – 415V $\pm$ 15%	Wide mains supply operating window
Insulation class H (upto 180° C)	Improved operational life



CPRA 1250i



SAW Tractor CPRA

# Best Suited Application Areas



## CPRA 1250i + SAW Tractor CPRA

- Heavy fabrication
- Construction and projects
- Repair and maintenance



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