

**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 weld-

er. 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 turn-over 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

## Machine Performance Range

Welding Process	MIG (GMAW)
Axial Travel / Stroke	9 in. (228.6 mm)
Step Range (variable)	0.050 - 0.175 in. (1.27 - 4.45 mm) per rev.
Wire Diameter Range	0.030 - 0.045 in. (0.76 - 1.14 mm)
Base Package Extension Reach	21 in. (533.4 mm)
Torch Extensions	3, 6, and 12 in. (76.2, 152.4 and 304.8 mm)

## Torch Welding Diameter Ranges

ID Bores #00 - #4	0.88 - 5 in. (22.4 - 127 mm) the range can extend to 10 inches (254 mm) by resetting the clutch periodically between skip sections. To reset the clutch simply push the axial feed knob in and pull it out. <b>DO NOT</b> reset the clutch during a step process, this can damage the clutch.
OD Torches, max dia.	1 - 10 in. (25.4 - 254 mm)
Face Torch	1 - 20 in. (25.4 - 508.0 mm)
Unsupported Torch Reach	36 in. (914.4 mm)
Max Continuous Welding Current	175 Amps
Typical Voltage Operating Range (Power supply with burnback control required to use skip/fill function)	(short arc/.035 wire) 17 - 19 volts

## Weights and Measures

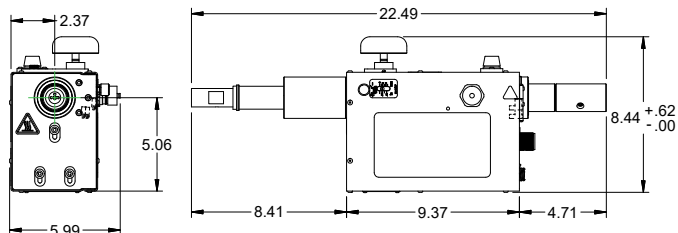
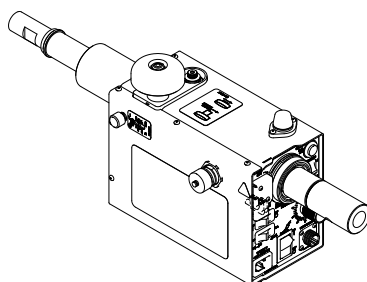
Weight (does not include mounting options)	41 lbs (18 kg)
Shipping Weight (does not include mounting options)	69 lbs (31 kg)
Shipping Dimensions	24 x 19.5 x 12 in. (609.6 x 495.3 x 304.8 mm)

## 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

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 Auto Bore Welder in 3 easy steps by selecting:

1. Base Package
2. Conduit Assembly
3. Mounting Option

**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 - 10 inches (69.9 - 254 mm) diameter, and pelican case. (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.- with 5 pin Amp **86046**

### 3. Mounting Options

Adjustable Base (Must be used with a 5 in/127 mm (28208) and/or a 10 in/254 mm (35006) 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**

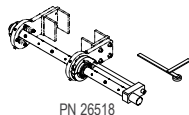
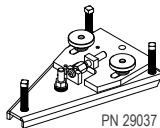


Image includes optional components

Face Torch 8 inch (203.2 mm) **28186**

Compact Face Torch 6 in. (152.4 mm) Swing\*\* **48013**

Conical Seat Torch **28020**

Torch Counterbalance **30756**

Torch Extension 3 in. (76.2 mm)\* **29038**

Torch Extension 6 in. (152.4 mm)\* **29039**

Torch Extension 12 in. (304.8 mm)\* **29040**

Torch Extension 18 in. (457.2 mm) **29065**

Torch Extension Support Kit **40877**

Torch Adapter, Standard Torches to Swivel Assembly **33804**

### Additional Consumables

Welding Tip #00, SPEZ Feed 0.045 in. (1.2 mm) **69554**

Welding Tip #00, 0.035 in. (0.9 mm) \* **69521**

Welding Tip #00, 0.035 in. (0.9 mm) - Chromium/Zirconium **69891**

Welding Tip #0, SPEZ Feed 0.045 in. (1.2 mm) **69555**

Welding Tip #0, Standard 0.035 in. (0.9 mm) \* **69520**

Welding Tip #0, Standard 0.035 in. (0.9 mm) - Chromium/Zirconium **70204**

Welding Tip, 0.035 in. (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 in. (31.8 mm) Bar **26656**

Tool Alignment for BB4500 1-3/4 in. (44.5 mm) Bar **36062**

Tool Alignment for BB5000 2-1/4 in. (57.2 mm) Bar **26487**

Radial Mount 5 in. (127.0 mm), Radius Standard Spacer **28208**

Radial Mount 10 in. (254.0 mm), Radius Spacer **35006**

Mounting Rod Extender **30831**

### Additional 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 - NOT REQUIRED to operate welder **85341**

**\* INCLUDED IN BASE PACKAGE**

## 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 in. (22.4 - 45.7 mm) Dia. **29063**

#0 Torch, 1.75 - 3 in. (44.5 - 76.2 mm) Dia. **28448**

#1 Torch, 2.75 - 5.5 in. (69.9 - 139.7 mm) Dia. **29064**

#2 Torch, 4.5 - 7.5 in. (114.3 - 190.5 mm) Dia. **29032**

#3 Torch, 6 - 9 in. (152.4 - 228.6 mm) Dia. **29033**

#4 Torch, 8 - 11 in. (203.2 - 279.4 mm) Dia. **29034**

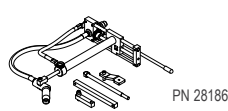
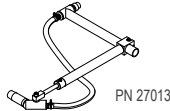
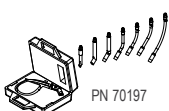
### Torch Systems and Accessories

Torch Kit, #00 - #5, 0.88 - 10 inch (22.4 - 254 mm) Dia. **69896**

Swivel Torch Kit #1 & #2, 2.75 - 12 inch (69.9 - 304.8 mm) Dia **70200**

Torch & Bearing Clearance Kit, #00 to #4, 0.88 - 10 inch (22.4 - 254 mm) Dia **70197**

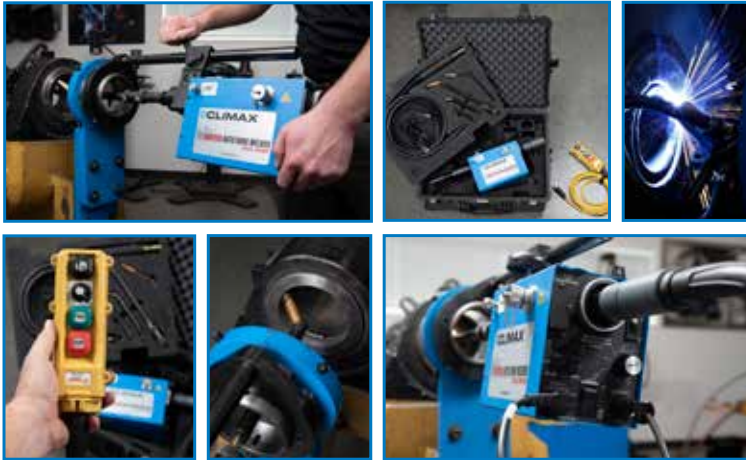
Trammel OD Torch Package, up to 10 inch (254 mm) Dia. **27013**





# GLOBAL LOCATIONS & TRAINING CENTER

## Applications



### The BW2600 is widely used by these industries:

- Mining & Heavy Construction
- Pulp & Paper
- Factory Maintenance
- On-site Maintenance & Repair
- 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 finer points of portable machine tool operation for more than 50 years.

Whether it's a regularly scheduled course at one of our seven Global Training Centers or a custom curriculum conducted with your team, at your facility, your technicians will benefit from courses developed by the most experienced and respected professionals in the business.

Regularly scheduled courses in basic and advanced tool operation are available. A vast majority of every program is devoted to hands-on activities, skills development, and OEM Certification covering the following subject matters: operator safety, tool component review, setup and mounting, standard and advanced operational techniques, overview of cutting tools and recommended usage, and maintenance procedures. Training is available at the following seven Global Training Centers: Portland, Oregon; Houston, Texas; Gonzales, Louisiana; Wadsworth, Ohio; Manchester, United Kingdom; Düren, Germany, Dubai; and United Arab Emirates. Call us today to schedule training for your team!



## Call CLIMAX for:

### RENTALS

With 20+ worldwide rental depot locations, you are never far away from a CLIMAX tool.

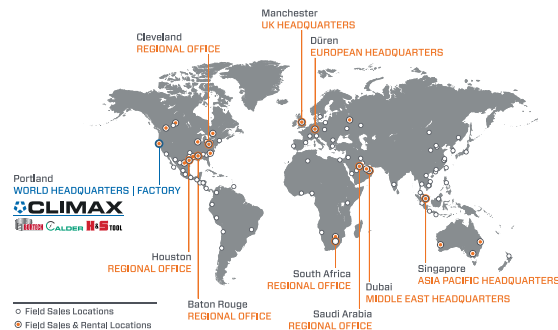
### ON-SITE TRAINING

If you need training or on-site consultation, we're famous for it!

### CUSTOM PROJECTS

Custom turn-key system design services from the most experienced engineers and portable machining and welding experts!

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