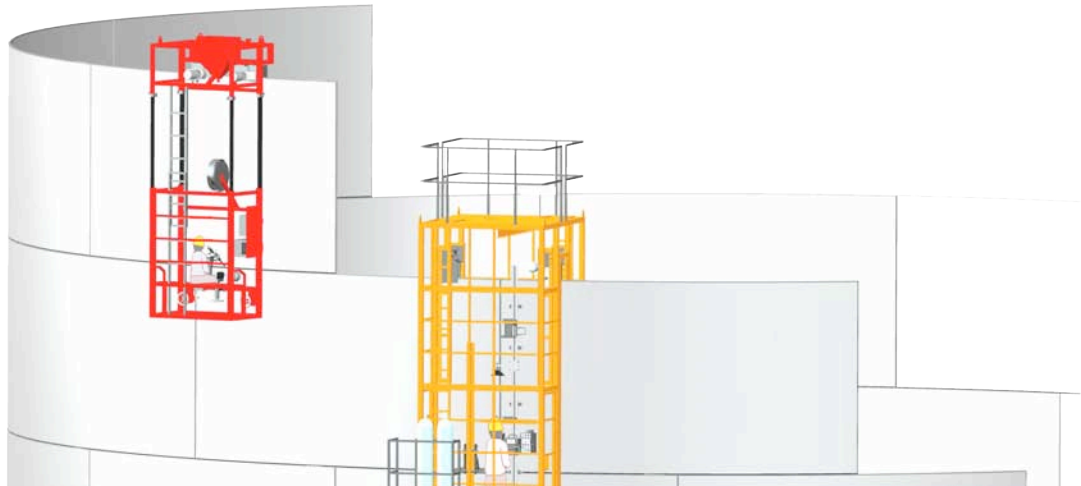


ALL TIME

COMPLETE SOLUTION FOR TANK FRABRICATION





ALL TIME TEAM

OUR EXPERTIES & EXPERIENCE IN AUTOMATIC WELDING FOR FIELD CONSTRUCTION OF STORAGE TANKS MEAN WE CAN OFFER YOU A COMPLETE RANGE OF AUTOMATIC TANK WELDERS TO COVER ALL SITE WELDING REQUIREMENTS.

With our board range of automatic tank welders, we can assist you with any aspect of welding involving all kinds of site erected storage tanks. Appropriate welding processes can be proposed for a multitude of tank dimension, wall thicknesses and materials.

Our activities are not limited to the supply and assembly of welding hardware. A full range of support services is integral to our business approach. These services include onsite training, welding procedure support and the supply of specific welding consumables geared to specific production needs

Furthermore, we will keep you informed about new developments and improvements in the practice of automatic tank welding. You are always welcome to visit our demonstration facility to witness our technology, discuss your application with us and contribute your own ideas to our development process.

All Time offers:

1. Automatic Girth Welder
2. Automatic Vertical Welder
3. Hydraulic Jack System
4. Modified Submerge Arc Welding Tractor



First-Class
Customer Focus

Understand what our customer need is our priority

Tank configuration is a major consideration of Storage tank construction; factor such as capacity, dimensions, orientation, placement, roof design and shell structure are all major variables.

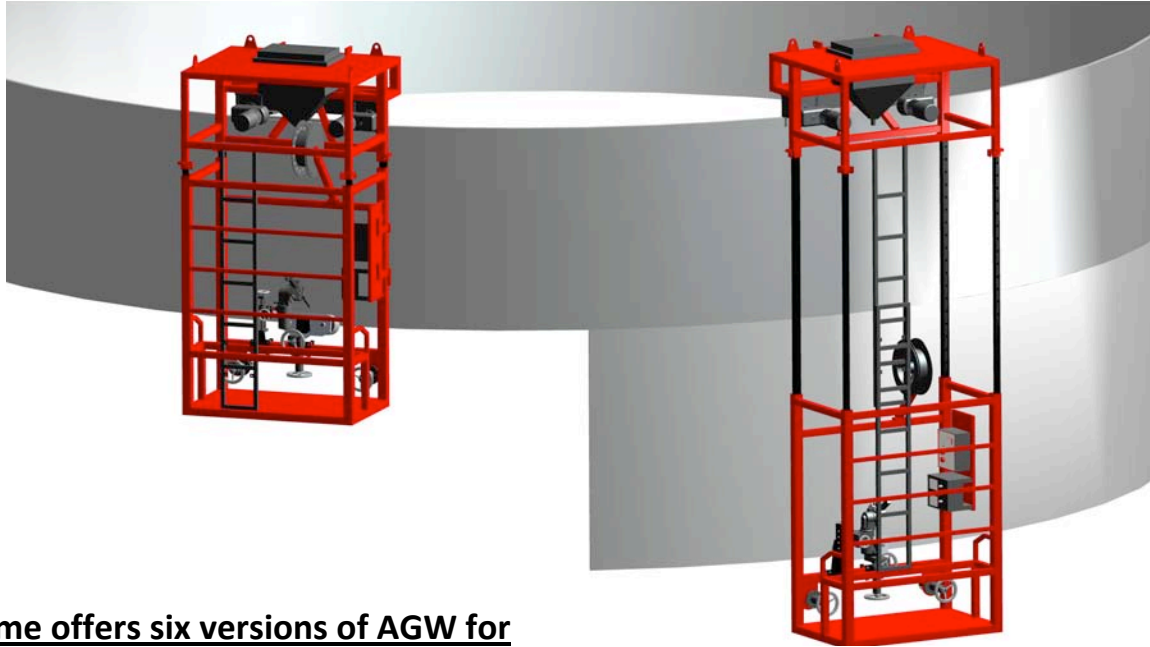
Storage tanks are used in numbers of applications for various storing purposes, which it is highly determined by the choice of construction materials.

The most important parameters to consider when specifying storage tanks are their capacity and dimensions. The capacity of the tank is known as the available internal volume for the specific storing materials. The diameter of tank is one of the most concerned factors.

With All Time's technology in automatic welding systems and experience in site storage tank welding, we provide you with true time saving methods for field constructions of various storage tanks.

Automatic Girth Welders

Satisfy the needs of various tank configurations



All Time offers six versions of AGW for various tank configurations:

- 1) **AGW I** - Single sided horizontal girth welder
- 2) **AGW II** - Double sided horizontal girth welder
- 3) **AGW I/II-LNG** - Girth welder for double shell cryogenic tanks
- 4) **AGW I-D** - Girth welder with special modular frame for both Traditional & jack up storage tanks
- 5) **AGW I-Mini** – Lightweight version of girth welder for small thin wall tanks
- 6) **AGW-P** – Portable girth welder for easy transportation

Advantages:

Utilize mechanized SAW process to weld storage tank horizontal seams 20 times faster than traditional manual welding processes.

Power propelling frame & operator platform allows welder to perform various welding operations in different tank courses with comfort.

Provides high quality continuous weld seams around the tank circumference.

The All Time Automatic Girth welder (AGW) is an automatic system that is applied to reduce the welding time for joining tank courses during field erection. It straddles the shell plates riding on adjustable flange wheels and travels at a controllable speed for mechanized SAW. Basic components that make up an AGW are machine frame, welding head, controls, flux support belt, flux recovery system, and welding power supply with storage case.

Key components



Dual Motor Drive

All Time Dual AC motor drive provides steady travel across the entire tank circumference. Speeds for two SEW motors are electronically synchronized and governed by an ABB inverter for accurate speed travel.



Weld Head Assembly

The AGW weld head is mounted on a manual cross slide system, which allows the operator having the complete control of wire placement and joint tracking. Due to the lack of visibility of the submerged arc welding process, a laser pointer is mounted on the nozzle to provide a position reference for operator while welding. Motorized torch control is available as an option.



Power Source

Rugged Lincoln USA CC/CV power supply with excellent welding performance is a standard component for every All Time girth welder.



Welding Control

Lincoln USA welding control is normally supplied with All Time girth welder. It is mounted on the main frame (right below the Master Control) for operator easy access.



Master Control

The AGW Master control houses the necessary electronic components of the system; it provides a mean of integrated control of all accessories of the girth welder. The Control panel includes the required control knobs and switches such as the speed control potentiometer, direction switch, rapid speed travel switch as well as emergency stop button. The control operates under 24VDC for safety and its ventilation system enables it to operate at high temperature condition.

Our Experience

All Time has installed over 400 units of Automatic Girth welder worldwide and is becoming one of the market leaders of the field.

General Technical Data

- Diameter: 4.5m & up
- Welding Wall Thickness: 8 – 45mm
- Plate width capacity:
1.8 – 3.2m (Standard)
2.2 – 4.5 m (LNG model)

Field Application

- 1) Tradition top down constructed tanks
- 2) Top down constructed (Jack Up) tanks
- 3) Stainless steel tower
- 4) Heavy wall Steel mill blast furnaces
- 5) Double shell cryogenic (LNG / LPG) tanks



AGW-I/D welding "Jack Up" tanks



AGWII – LNG Outside 9% LNG tank



All Time AGWII Double sided girth welder

Strong Field Experience

Electro Gas Welders

Satisfy the needs of various tank configurations



EGW V



EGW V/D



EGW BUG

All Time offers 3 versions of vertical welders for various needs:

- 1) **EGW V** – Single Pass Electro Gas Vertical Welder for bottom up constructed tanks
- 2) **EGW V/D** – Single Pass Electro Gas Vertical Welder for Top down constructed tanks
- 2) **EGW BUG** – Multi Passes Vertical Welder for applications where single pass electro gas welding is not applicable.

Advantages for EGW V and EGW V/D:

High Deposition Rate – approximately 20 X faster than manual welding when electro gas welding is being adopted. An operator can weld over 2.5m long vertical seams in less than 1 hour.

Weld can be done in single pass with no inter-pass cleaning.

The EGW (Electro Gas Welding) is a high deposition welding process that uses retaining shoes to confine a molten metal for vertical progression welding.

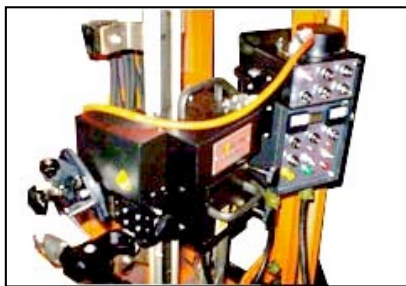
EGW is considered as a highly automatic process as it requires closed loop current sensing or other means, to govern travel speed & to maintain electrode stick-out automatically without operator interference.

Key components



Self-Propelling Wind Shielding Frame

Rides on top of the tank Shell and travel laterally along the tank diameters. Provides the “indoor” condition that is critical for high quality site welding.



Travel Carriage & Linear Oscillator (required for over 25mm plate)

Travel carriage raises the special welding torch vertically upward and the Linear Oscillator manipulates the welding arc in and out of the joint.

In case of single pass electro gas welding, a close loop sensing control is attached to the travel carriage to maintain travel speed of the carriage automatically.



Elevated Operation Platform

The Powered Operation Platform (lifted by a power Winch) is designed for the comfort of the operator to travel with the welding carriage.

The operator can easily control the travel direction of the platform by pressing the up/down button on the pendent.



Power Source

Rugged Lincoln USA CC/CV power supply with excellent welding performance is a standard component for every All Time girth welder.



Wire Feeder

Lincoln USA wire feeder is normally supplied with All Time girth welder. It is mounted on the power elevated stand for operator easy access.

Our Experience

All Time has installed over a hundred unit of Electro Gas welder worldwide.

General Technical Data

- Auto Travel speed: 0 – 250mm/min
- Rapid – Travel speed: 550mm/min
- Oscillation stroke: 50mm
- Dwell time: 0 – 3sec
- Carriage weight: 15kg
- Frame weight: 2000kg

Field Application

- 1) Tradition top down constructed tanks
- 2) Top down constructed (Jack Up) tanks
- 3) Stainless steel tower
- 4) Heavy wall Steel mill blast furnaces
- 5) Double shell cryogenic (LNG / LPG) tanks
- 6) Ship panel



Keep Doing The Best

ALL TIME Welding Tractor LT



“ALL TIME LT”

All Time LT

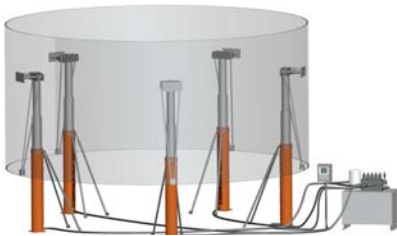
The ALL Time LT welding tractor is a self-propelled tracking system with submerged arc welding process. It is used for tank base plate welding (e.g. lap, butt, and O.D. fillet joint with magnetic guide kit).

Process:
SAW

Features:

- Comes with Magnetic Guild Assembly
- Used for tank base plate I.D. and O.D. fillet welds, lap and butt joint welds

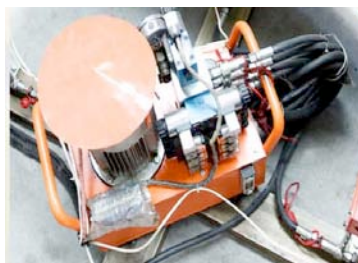
Hydraulic Jack Up System

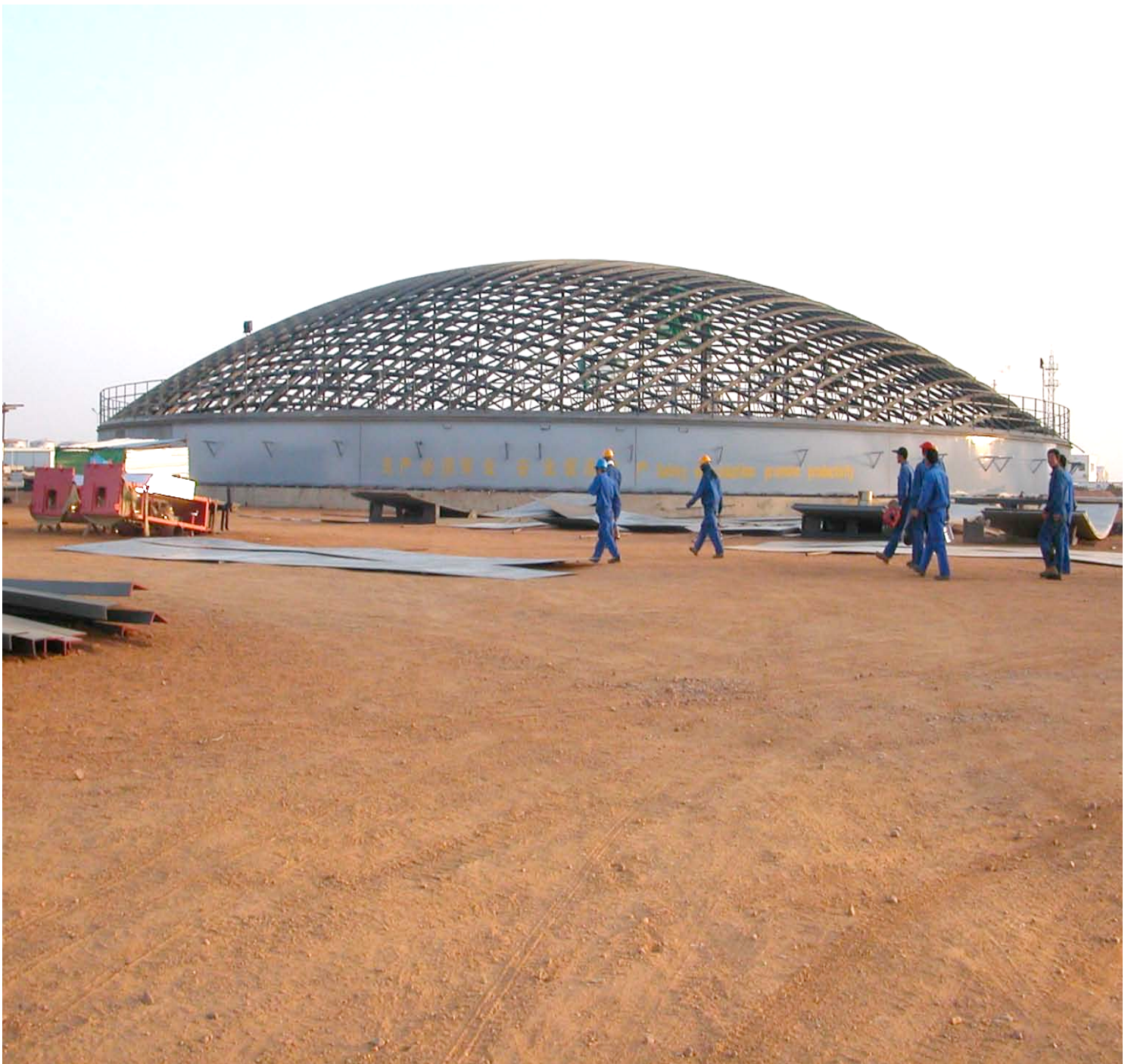


“ALL TIME hydraulic jack up system”

All Time Hydraulic Jack Up System

All time offers a high quality hydraulic jack up system to lift and level tank course for top-down constructed storage tanks, which allows shell plates horizontal and vertical welding to be done efficiently and safely on the ground manually or with ALL TIME Automatic tank welder.





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