

# **GALAXIE** **CORPORATION**

*Worldwide Metalworking Equipment Dealer*

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## **Continuous Welded I-Beam Line**

Misc Steel Processing  
Miscellaneous

### **Description**

Beam Line Incoming Coil Data:

Max. Coil Weight: 20,000 lbs.

Max. Coil O.D: 72"

Coil I.D Range: 20 - 29"

Width Range: 1 1/2 - 18 1/4"

Thickness Range: .087" - .375"

Material Specification

Material: Mild Steel & Carbon Steel

Yield Strength: 45,000 PSI - 80,000 PSI

Line Performance:

Line Operating Speed: 25 - 100 FPM

Process: Continuous for Max. 0.250" Flange

Thickness

Start-Stop to 0.375" Thickness

Strip Accumulation: Horizontal (3)

Strip Storage Capacity: Gauge Line Speed FPM Storage

.087" 100 1250'

.125" 100 1000'

.134" 100 900'

.156" 100 800'

.165" 100 700'

.188" 70 650'

.200" 60 600'

.250" 50 500'

Means of Cut-Off: Digitally Controlled Measuring System with Flying Saw (Hot)

Cut-Off Tolerances:

Flying Saw: +/- 1/2"

Annual Tonnage at Continuous Welding Process Based on a Single 8 Hr. Shift  
(2000 hrs./ annum): 45,000 tons

Equipment List:

Note: Items marked \* are New or Rebuilt in 1997/1998

Welded Beam Line

Flange Strip Feeding Section

Two (2) Floor-Type Coil Cars

Two (2) Single Mandrel Uncoilers

Two (2) 5-Roll Flatteners (overhauled) with Pinchrolls/ Peeler Tables

Two (2) Strip Joiners (Shear & End Welder)

Two (2) Hump Tables (overhauled)

Two (2) Strip Twist Guides

Two (2) Horizontal Strip Accumulators

c/w Infeed Pinchroll

Rotating Strip Support Table

Inner Outfeed Tower

Exit Pinchrolls

Strip Guides

Web-Strip Feeding Section

One (1) Floor-Type Coil Car

One (1) Single Mandrel Uncoiler

One (1) 5-Roll Flattener

c/w Pinchrolls

Peeler Table

One (1) Shear & End-Welder (Strip Joiner)

One (1) Strip Turning Device

One (1) Horizontal Strip Accumulator (Similar to flange accumulator)

One (1) Strip Orientation Section

Process and Cut-Off Section

One (1) 'Thermatool' Weld Fixture

c/w Web-Strip Upsetting Tools

Removable Upsetting Units

Guiding Devices for Flange Strips

H.F. Weld-Stand with Contacts

Two (2) Thermatool H.F. Power Units

Model VT 300

Upgraded in 1998  
One (1) Beam Cooling Booth  
c/w Water Pumps & Spray Pipes  
Three (3) Beam Pull-Out Stands (rebuilt)  
One (1) Beam Straightener (rebuilt)  
One (1) Flying Cut-Off Saw (rebuilt)  
c/w 'Tallyrand' Acceleration/Measuring System  
Saw Pull-Out Stand  
One (1) Beam Run-Out Conveyor & Stacking Ramps  
One (1) Beam Reclaim Ramps with Horizontal Band Saw

This is a complete line still installed.  
Condition is very good as this line has been upgraded extensively:

The following components have been rebuilt and upgaded: Welders, Eletrical Controls,  
Tallyrand Controls for Cut-Off, 3 Accumulators.

ABB Switch Gear

Phazecon Digital Drives, 12500

Allen Bradley PLC

Spare Parts

Spare Saw Blades

Complete line can be inspected under power and operating.

## Image(s)

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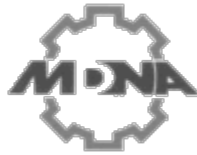
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