

**“SANDBERG”  
LASER WELDING MACHINE**



## Technical Parameter

Item	DHH1000	DHH1500	DHH2000
Laser Power	1000W	1500W	2000W
Laser Wavelength	1070nm	1070nm	1070nm
Fiber Length	10m	10m	10m
Operation Model	Continuous/Modulated	Continuous/Modulated	Continuous/Modulated
Positioning	Red laser dot	Red laser dot	Red laser dot
Air Pressure	5-15L/min	10-15L/min	10-15L/min
Input Voltage	220V	220V	220V
Power Consumption	5KW	7KW	9KW
Frequency	50/60Hz	50/60Hz	50/60Hz
Currency	25A	40A	40A
Focal Length	150mm	150mm	150mm
Cooling	Distilled Water Cooling		
Welding Wire Diameter	0.8mm, 1.0mm, 1.2mm, 1.6mm		
Net Weight	220KGS		
Gross Weight	240KGS		
Machine Size	100*60*110cm(L*W*H)		
Wooden Package	140*70*130cm (L*W*H)		

## Machine Configuration

No.	Components	Brand	Note
1	Fiber Laser Source	MAX	China
2	Welding Gun	SUP	China
3	Water Chiller	Hanli	China
4	Control System	SUP	China
5	Wire Feeder	SUP	China
6	Electricity	Schneider	France
7	Welding Accessories	DMK	China

## Fiber Laser Source

Basic Advantage of MAX Technology:

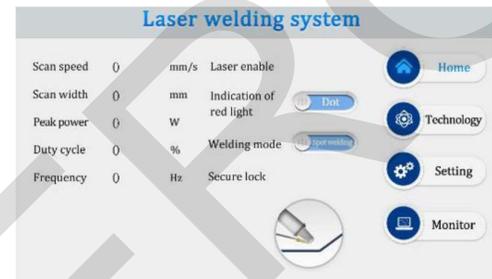
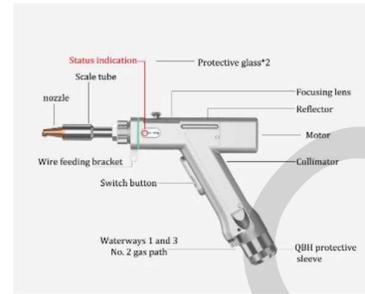
- Technology is constantly developed and improved.
- Low operating and maintenance costs
- High efficiency and stability of the machining process
- Significant reduction of production costs
- Possibility of welding highly reflective materials, e.g. aluminum, copper or brass
- Possibility of welding steel in various grades and dimensions
- The estimated operating time of the fiber source is approximately 100,000 man-hours.
- Technology friendly and safe for the environment and the workplace



## Welding Head System

### Handheld Laser Welding Head

- Light-weight, flexible, and the handle with comfortable ergonomics design.
- Independent R&D of security detection system
- Hard tightness, long lifetime
- Convenient replacement of collimating, focusing and optics
- Dual protective lens, reduce the consumption of the focusing lens, more stable.
- Optical structure optimization, high welding strength, small deformation, high penetration



## Wire Feeder

- Automatic wire feeding and withdrawal functions.
- Adjustable wire feeding speed, wire feeding frequency.



## Industrial Water Chiller

- Multiple alarm protection functions
- Industrial chiller with dual temperature and dual control, adjustable high and low temperature



## Welding Parameters

SS--Stainless Steel

AL—Aluminum

DHH1000					
Material	Laser Power (%)	Speed (mm/s)	Gas Pressure (L/min)	Wobble Width (mm)	Wobble Frequency (Hz)
0.5 SS	40--50	50--75	10	0.8--2.0	80--100
1.0 SS	50--60	50--85	10	0.8--2.0	80--100
1.5 SS	60--75	45--60	15	1.0--3.6	80--100
2.0 SS	75--95	35--50	15	1.4--6.8	60--80
1.0 AL	75--85	45--55	5	0.8--2.0	60--80
1.5 AL	85--98	35--45	5	0.6--2.2	60--80
DHH1500					
Material	Laser Power (%)	Speed (mm/s)	Gas Pressure (L/min)	Wobble Width (mm)	Wobble Frequency (Hz)
1.0 SS	50--60	60--95	10	0.8--2.0	80--100
1.5 SS	60--75	50--85	15	1.0--2.6	80--100
2.0 SS	75--95	45--65	15	1.4--2.8	60--80
3.0 SS	85--95	35--45	15	1.2--2.8	60--80
4.0 SS	95--98	30--40	15	1.2--2.8	60--80
2.0 AL	85--95	45--60	10	0.6--2.2	60--80
2.5 AL	88--98	35--40	10	0.6--2.2	60--80
3.0 AL	90--98	30--35	10	0.6--2.2	60--80
3.5 AL	95--98	25--30	10	0.6--2.2	60--80
DHH2000					
Material	Laser Power (%)	Speed (mm/s)	Gas Pressure (L/min)	Wobble Width (mm)	Wobble Frequency (Hz)
1.0 SS	50--60	75--105	10	0.8--2.0	80--100
2.0 SS	75--95	80--95	15	1.0--2.6	80--100
3.0 SS	85--95	55--65	15	1.4--2.8	60--80
4.0 SS	90--98	35--45	15	1.2--2.8	60--80
5.0 SS	95--98	30--40	15	1.2--2.8	60--80
2.0 AL	85--95	75--85	10	0.6--2.2	60--80
3.0 AL	90--98	50--65	10	0.6--2.2	60--80
4.0 AL	95--98	40--55	10	0.6--2.2	60--80

## Packing:



Complete tool for wire feeders and maintenance spare parts



Customs-free fumigation non-solid wood packaging



Vacuum sealed moisture-proof packaging



Customs-free fumigation non-solid wood packaging

## Application:



Precision parts welding



Steel structure welding