



DATA SHEET

Features	Advantage	Benefits
1 Adjustable Legs	Removes the requirement for Leg setup	<ol style="list-style-type: none"> 1 Does not need adjusting for differing pipe sizes 2 No need for a stock of fixed legs 3 No problems during weld from leg movement 4 Cuts down on set up time 5 Simplifies field maintenance procedure
2 Industry Standard Controller (PLC)	Eliminates custom programming languages and protocols	<ol style="list-style-type: none"> 1 Allows for rapid replacement should it ever be needed 2 Allows for simple update procedure for programme or firmware as required by Customer or IPWL 3 Allows simple expansion of functions or integration into other systems if required 4 Allows simple customisation if required 5 Allows incredibly fine control up to 3 decimal places positional and timing
3 Operator Remote Control	Ergonomically designed operator control	<ol style="list-style-type: none"> 1 Minimum operator fatigue 2 Intuitive operation 3 Ability to check operational parameters on in-built screen 4 Rugged machined aluminium construction for long life 5 Military grade switches for reliability
4 Touchscreen HMI (Human Machine Interface)	Visual Programming and set up system	<ol style="list-style-type: none"> 1 Simplifies the parameter set up 2 12 parameter memories as standard, more can be added if required 3 Diagnostic and electronic set-up functions 4 Parameter and set-up functions individually password protected 5 Simple to use touch screen unit
5 Band Clamping System	Sprung Steel Clamshell Design	<ol style="list-style-type: none"> 1 allows quick installation 2 maintains distance from pipe, even if not truly round
6 Hard Wire and Flux Core Capability	Allows both hard wire and flux core welding	<ol style="list-style-type: none"> 1 Both available from one machine with no mechanical set up; just change the resistance
7 On Board Monitoring of service schedules	Simplifies technicians job	<ol style="list-style-type: none"> 1 Ensures that maintenance schedules are met 2 Increases reliability
8 Lightweight and Compact Design	Improves operational health and safety by minimising lifting related injuries	<ol style="list-style-type: none"> 1 Minimise operator fatigue 2 Minimise required clearance for confined areas 3 Minimise storage space 4 Minimise transport costs

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Specifications		Applications	
1	Minimum Weld Diameter*	10 inches (250mm)	1 Oil gas and water pipelines
2	Maximum Weld Diameter	Flat (∞)	2 Large diameter vessels
3	Maximum Wall Thickness*	3 inches (75mm)	3 Chemical
4	Maximum Oscillation Width	2 inches (51mm) Independently adjustable in 0.001 inch (0.01mm) increments	4 Stream pipes
5	Dwell Time	0 - ∞ . Independently adjustable in 0.01s increments	5 Tubular structures
6	Travel Speed*	0 - 270 inches (0.6858mm) per minute	6 MOD applications
7	Wire Capacity*	0.8 - 1.0 -1.2 mm flux core or hard wire width 5kg spool	
8	Machine Weight	16kg gross, 11kg net	
What's included with your Firefly Orbital Welding Bug?		Optional extras	
1	The Firefly	1	HMI technician/programmer's remote (minimum of one required per customer)
2	The operator remote control	2	Memory Card for parameter back up
3	Starter kit - spares kit and operator tool kit	3	Band system for all standard pipe sizes
4	High impact carry case	4	Custom band system for unusual pipe sizes
5	Gas box	5	Track based system for large vessel or custom welding projects
6	Service manual including recommended spares list	6	Full spares kit
7	Operator manual	7	Service manual on CD
8	Free access to our helpline for one month after delivery	8	Service manual for HMI permanently stored in the technician's remote for easy access by technician
9	Free product familiarisation (one day) for up to one technician and one weld supervisor to take place at IPWL or on-site (subject to travel costs)	9	Tear-proof hardcopy service manual
		10	Custom modifications to the base model where applicable
		11	Annual inspection and service