HEAT TREATMENT EQUIPMENT & ACCESSORIES
Dear Customer,

ElectroHeat Sweden AB is an innovative company based in Gothenburg, Sweden, and has been operating since 1975. We manufacture industrial furnaces and heat treatment equipment to industrial companies all over the world.

We deliver to some of the largest companies in Sweden such as ABB, Siemens and Volvo but also equipment to research carried on at technical universities. A significant segment of our production is exported to Europe and the Middle East.

Our furnaces are fully adapted to our customers’ needs and requirements, which make each heating system unique.

We make products with outstanding quality and we deliver fast!

Kimmo Ainassaari, CEO
Mobile Heat Treatment Center

Stress relieving means to slowly heat the work piece to a specific temperature, which is then held constant for some time, followed by slow de-cooling. The temperature is elected between 550 and 800°C, depending on the material composition. Stress relieving is carried out to reduce internal tensions in welding areas, which reduces the risk for stress corrosion, and secondly to remove contained hydrogen from steel.

The mobile heat treatment centers are used for stress relieving and pre-heating for pipes and steel constructions. The cabinet is manufactured in stainless steel enabling it to be used in tough environments.

TF 4056 / 8056 / 80512

Control system
- Own-developed hardware and software for Windows CE Industrial PC
- No computer needed to get started
- Extremely user-friendly
- Multi-language support
- Fully automatic processing with alarm control
- Full master/slave programming flexibility
- T/C fault alarm
- Low effect alarm
- Alarm for faulty +/- connection on T/C
- Comprehensible display to show trends and SP/PV (set control and process value)

- 12” high resolution TFT touch screen
- Stainless steel chassis
- Easy to service and easy to change spare parts (relay, screen etc.)
- Standard components (contactors etc.) to facilitate tracking of spare parts at local supplier
- Filter on all T/C inputs to avoid any disturbance
- Documentation can be written directly at the unit for further processing by computer
The main screen shows the overview information for all six channels. You can also see master/slave relations and the temperature on all channels. The user interface is easy to understand. To program a channel press on the desired channel.

In the channel control screen you program the parameters such as ramp, master/slave and the program is initiated from this screen.

This graph shows the temperature curves for all six channels in their respective colour. The graph displays the channel's performance for the entire duration of the heat treatment so you can follow the curve history and it is possible zoom in for details. Here is also where you can save data to a USB memory stick.

This is a printout after processing in the PC. You can see all the necessary information such as object information, sensor locations, client information, temperature curves etc. This information can be inserted before the heat treatment procedure as well as afterwards. You can choose whether you want to print information for one or more curves in the same printout.
TF 8036 / 80312

• Simple programming
• 6 + 6 channel program controllers
• Manage pre-heating and stress relieving
• Up to 4 elements per channel
• Program Controller FGH P256
• Graph writer for logging of temperature (0-1000°C)
• Stainless steel chassis
• Easy to service and easy to change spare parts (relay, contactors etc.)
• Standard components (contactors etc.) to facilitate tracking of spare parts at local supplier
TF 4046

- Easy to program
- 6 separate channels
- Manage pre-heating and ramp/hold time
- Up to 2 elements per channel
- PID controller
- Graph writer for logging of temperature (0-1000°C)
- Switch for turning of diagram writer
- Stainless steel chassis
- Easy to service and easy to change spare parts (relay, contactors etc.)
- Standard components (contactors etc.) to facilitate tracking of spare parts at local supplier
TF 4013

- Easy to program
- 3 separate channels
- Specifically constructed for pre-heating
- Up to 4 elements per channel
- PID controller
- Stainless steel chassis
- Easy to service and easy to change spare parts (relay, contactors etc.)
- Standard components (contactors etc.) to facilitate tracking of spare parts at local supplier
## Specifications TF

<table>
<thead>
<tr>
<th></th>
<th>TF 4013</th>
<th>TF 4046</th>
<th>TF 8036</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Supply voltage</strong></td>
<td>3x400V/440V 50Hz 63A*</td>
<td>3x400V/440V 50Hz 63A*</td>
<td>3x400V/440V 50Hz 63A*</td>
</tr>
<tr>
<td><strong>Secondary current</strong></td>
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<td>220A</td>
<td>440A</td>
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<td><strong>Secondary voltage</strong></td>
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<td>0/30/60V**</td>
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<td><strong>Channels</strong></td>
<td>3</td>
<td>6</td>
<td>6</td>
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<tr>
<td><strong>Heater/channel</strong></td>
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<td>2</td>
<td>4</td>
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<td><strong>Total amount of heaters</strong></td>
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<td>12</td>
<td>24</td>
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<tr>
<td><strong>Preheat treatment</strong></td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
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<td><strong>Automatic Postheat treatment</strong></td>
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<td>Yes</td>
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<tr>
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<td>Yes</td>
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<tr>
<td><strong>Master/Slave</strong></td>
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<td>No</td>
<td>No</td>
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<tr>
<td><strong>Temperature recording</strong></td>
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<td>Analogue 100 mm</td>
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<td><strong>Controller</strong></td>
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<td>6 individual PID</td>
<td>1 FGH P256</td>
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<td><strong>Contactors</strong></td>
<td>3 250A</td>
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<td>250 Kg</td>
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* Also available in other voltages

** 48 volt is available
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<td>3x400V/440V 50Hz 125A*</td>
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<td>220A</td>
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<td>0/30/60V**</td>
<td>0/30/60V**</td>
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<td>Yes, TFT 12”</td>
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<td>415 Kg</td>
<td>265 Kg</td>
<td>Approx. 415 Kg</td>
<td>Approx. 435 Kg</td>
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**Flexible Ceramic Elements (FCE)**

For preheating and stress relieving of pipes, pressure vessels etc. The elements consist of multistrand nickel-chrome resistance wires which run through small “two-hole” ceramic insulators. The insulators together with the resistance wires are very flexible and give a good heat radiation and effective heat transmission. The cold nickel tails and resistance wire are welded together. It is designed to provide a temperature up to 1000°C.

<table>
<thead>
<tr>
<th>Ref.nr</th>
<th>Length</th>
<th>Width tail to tail</th>
<th>Volt</th>
<th>kW</th>
<th>CP</th>
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<tr>
<td>4-110-01</td>
<td>2350</td>
<td>25</td>
<td>60</td>
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<tr>
<td>4-55-02</td>
<td>1170</td>
<td>50</td>
<td>60</td>
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<td>NA</td>
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<td>4-34-03</td>
<td>725</td>
<td>80</td>
<td>60</td>
<td>2.7</td>
<td>NA</td>
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<tr>
<td>4-32-03</td>
<td>670</td>
<td>75</td>
<td>60</td>
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<td>CP3</td>
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<td>4-25-04</td>
<td>540</td>
<td>100</td>
<td>60</td>
<td>2.7</td>
<td>NA</td>
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<td>4-24-04</td>
<td>500</td>
<td>100</td>
<td>60</td>
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<td>CP4</td>
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<td>4-20-05</td>
<td>420</td>
<td>130</td>
<td>60</td>
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<td>NA</td>
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<td>4-17-06</td>
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<td>4-15-07</td>
<td>320</td>
<td>180</td>
<td>60</td>
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<td>NA</td>
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<td>4-12-08</td>
<td>250</td>
<td>205</td>
<td>60</td>
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<td>CP8</td>
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<td>4-10-10</td>
<td>306</td>
<td>255</td>
<td>60</td>
<td>2.7</td>
<td>CP10</td>
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<tr>
<td>4-08-12</td>
<td>165</td>
<td>305</td>
<td>60</td>
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<td>CP12</td>
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<td>4-07-13</td>
<td>150</td>
<td>330</td>
<td>60</td>
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<td>NA</td>
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<td>4-07-15</td>
<td>145</td>
<td>380</td>
<td>60</td>
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<td>CP15</td>
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<tr>
<td>4-06-16</td>
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<td>410</td>
<td>60</td>
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<td>4-05-19</td>
<td>100</td>
<td>490</td>
<td>60</td>
<td>2.7</td>
<td>NA</td>
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<td>4-05-21</td>
<td>105</td>
<td>525</td>
<td>60</td>
<td>2.7</td>
<td>CP21</td>
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<td>85</td>
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<td>60</td>
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<td>630</td>
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<td>4-02-48</td>
<td>45</td>
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<td>4-04-10</td>
<td>85</td>
<td>250</td>
<td>30</td>
<td>1.35</td>
<td>CP20L</td>
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</table>

Other sizes and voltages on request.

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**Flexible Ceramic Elements (FCE)**

For preheating and stress relieving of pipes, pressure vessels etc. The elements consist of multistrand nickel-chrome resistance wires which run through small “two-hole” ceramic insulators. The insulators together with the resistance wires are very flexible and give a good heat radiation and effective heat transmission. The cold nickel tails and resistance wire are welded together. It is designed to provide a temperature up to 1000°C.

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Flexible Preheater Elements (FPE)

For preheating of pipes, pressure vessels etc. The elements are supplied with Superwool blanket enclosed in mesh. The blanket is attached to a stainless steel plate which protects from weld splatter. The plate is provided with hooks where magnets can be fixated, which make elements easy to attach. Banding of element is also possible. The FPE can be used on flat surfaces as well as curved. It is designed to provide preheating up to 700°C.

<table>
<thead>
<tr>
<th>ref. nr.</th>
<th>Dimensions</th>
<th>Volt</th>
<th>kW</th>
</tr>
</thead>
<tbody>
<tr>
<td>5-25-04</td>
<td>600x100x30</td>
<td>60</td>
<td>2.7</td>
</tr>
<tr>
<td>5-34-03</td>
<td>800x100x30</td>
<td>60</td>
<td>2.7</td>
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</table>

Channel Elements

Used in temporary or stationary ovens and special heating devices. Can be used for preheating or stress relieving. The coiled resistance wire is double inside the element and ceramic insulated. Multi wired tails reduces the resistance and lowers the heat at the connection points. The elements are supported in an inconel stainless steel tray. A working temperature of 950°C can be achieved.

Suitable for a wide range of heat treatment applications.

<table>
<thead>
<tr>
<th>ref. nr.</th>
<th>Dimensions</th>
<th>Volt</th>
<th>kW</th>
</tr>
</thead>
<tbody>
<tr>
<td>3-41-34</td>
<td>700x60x35</td>
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<td>3.4</td>
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<td>3-42-17</td>
<td>350x60x35</td>
<td>30</td>
<td>1.7</td>
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Spare parts for heating elements

1. Tail beads ref.nr 6-501
2. Finisher beads ref.nr 6-502
3. Main body beads ref nr 6-503
4. Main body hole beads ref.nr 6-504
5. Starter beads ref.nr 6-505
6. 19 strand 80/20 core wire ref.nr 6-510
6. 19 strand nickel 212 cold tail wire ref.nr 6-520
Spare wire with cold tail 2.7 kW 60V ref.nr 6-530
Magnet
For quick and reliable fastening of preheat elements.  
ref.nr 6-131-1

Banding tools
For simple and stable mounting of heating elements and thermal insulation.

1. Complete set  
   ref.nr 6-107  
2. ACME C1204 Banding tool  
   ref.nr 6-108-30  
3. ACME C2A5 Sealer  
   ref.nr 6-108-40  
4. BAND-IT C001 Banding tool  
   ref.nr 6-108-10  
5. BAND-IT C075 Bantam tool  
   ref.nr 6-108-20  
6. BAND-IT Band Boxed 201 SS  
   ref.nr 6-107-12  
7. BAND-IT Buckles 201 SS  
   ref.nr 6-107-13  
8. Mild Steel Band  
   ref.nr 6-107-10  
9. Mild Steel Buckles  
   ref.nr 6-107-11

Superwool Blankets

1. Sold in rolls with dimension 7300x600x25 mm  
   Superwool, max 1250°C  
   ref.nr 6-117-7

2. Ref.nr  
   Length  
   Width  
   6-SS-1000x300 1000 300  
   6-SS-1000x600 1000 600  
   6-SS-2000x300 2000 300  
   6-SS-2000x600 2000 600  
   6-SS-3000x300 3000 300  
   6-SS-3000x600 3000 600

For other dimensions, send an inquiry to our sales staff. Can also be fitted with Iconel wire mesh (1100°C).
**Splitter cable**
Cables for connection of more than one heating element parallel to the secondary power cable.
- 2-way splitter  ref.nr 6-122-2
- 3-way splitter  ref.nr 6-122-3
- 4-way splitter  ref.nr 6-122-4
- 6-way splitter  ref.nr 6-122-6

**Secondary cable**
From transformer to splitter cable. Complete with 300A plug and socket connectors, compensating cable and thermocouple connectors.

<table>
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<tr>
<th>Length</th>
<th>Max Current</th>
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<th>Camlock 300A</th>
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Other lengths on request.

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**Camlock connectors 60A**
1. Plug Complete  ref.nr 6-122-70
2. Plug Brass  ref.nr 6-122-71
3. Plug Sleeve  ref.nr 6-122-72
4. Socket Complete  ref.nr 6-122-80
5. Socket  ref.nr 6-122-81
6. Socket sleeve  ref.nr 6-122-82
7. Pin  ref.nr 6-122-85

**Camlock connectors 300A**
8. Plug Complete  ref.nr 6-122-90
9. Plug Brass  ref.nr 6-122-91
10. Plug Sleeve  ref.nr 6-122-92
11. Socket Complete  ref.nr 6-122-100
12. Socket Brass  ref.nr 6-122-101
13. Socket Sleeve  ref.nr 6-122-102
14. Pin  ref.nr 6-122-105
15. Panel socket  ref.nr 6-122-110

**Dinse connectors**
16. Plug  ref.nr 6-123
17. Socket  ref.nr 6-124
18. Panel socket  ref.nr 6-125

**Contactors**
Contactor for 0-60V heat treatment units  ref.nr 6-40-401
**Recorders**

1. CHINO EH 180mm paper width 0-1200°C 12 channels
   ref.nr 6-710-1200

CHINO EH 180mm paper width 0-1200°C 12 channels
Enclosed in stainless steel casing with thermocouple panel sockets
   ref.nr 6-720-1200

2. CR06 100mm with casing
   ref.nr BTCCR06

**Recorder Accessories**

1. CR06 Ribbon cassette
   ref.nr 6-825

2. CR06 0-400
   ref.nr 6-820-400
   CR06 0-600
   ref.nr 6-820-600
   CR06 0-800
   ref.nr 6-820-800
   CR06 0-1000
   ref.nr 6-820-1000
   CR06 0-1200
   ref.nr 6-820-1200

3. CHINO Recorder ink
   ref.nr 6-725

4. CHINO Chart paper 180mm
   ref.nr 6-725-1200

**Compensating cable**

1. For thermocouple VX wires
   ref.nr 6-112-21

2. For thermocouple type K wires
   ref.nr 6-112-22
1. Digital surface temperature meter for Type K
   ref.nr 6-101-1

2. High temperature surface measurement probe for Type K
   ref.nr 6-101-2

3. Calibration device
   Simulates and measures temperature.
   ref.nr 6-101-3

Thermocouple connectors
1. Plug
   ref.nr 6-112-3
2. Socket
   ref.nr 6-112-4
3. Socket Panel
   ref.nr 6-112-1

4. Thermocouple wire type K
   Insulated with high temperature glass braid (100m).
   ref.nr 6-112-5

5. Inconel sheated thermocouple probe
   With standard connector ø 3.0- ø 4.5.
   Max temperature 1150°C.
   ref.nr 6-150-ø-length mm

Other types and dimensions on request.

6. Putty
   For protection of thermocouple from thermal radiation from elements.
   ref.nr 6-115-45

Thermocouple welding unit TW-16
The TW16 is housed in a stainless steel chassis with a tool storage compartment within the casing lid to enable neat storage and complete with a shoulder strap for hands free use.

The unit is fully automatic to allow technicians to operate ‘hands free’, a manual option is also available.

The unit is operated by both a mains supply and its own internal rechargeable battery and also has a membrane panel to reduce unwanted ingress.

The TW16 has a high efficiency converter for extended time between battery recharge, we estimate several hundred uses before re-charge is required.

This includes a mains LED which shows when the battery is on charge and has a recharging necessity shown by ‘Low Battery’ LED. This unit comes complete with a magnet, pliers and a mains charging lead.

Discharge Energy: Variable (21 watts per Second to 50 watts per second)
Battery Recharge Time: 6–8 Hours
Supply Voltage: 100–130 VAC or 200–260 VAC
Product Code: TW-16
ElectroHeat – Innovation, Design and Production

• Furnaces and industrial ovens
• Heat treatment services for pipes and steel constructions
• Mobile heat treatment equipment
• Ovens for heating or drying of welding rods
• Standard ovens
• High temperature fan units with recirculation
• Design and construction of control cabinets
• Climate chambers with cooling/heating/humidity

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