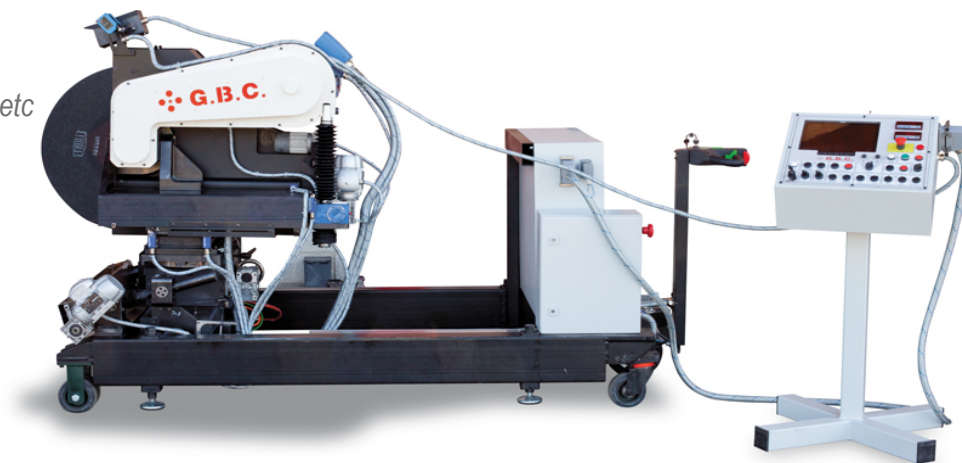


G400 Back Gouging Grinding Machine

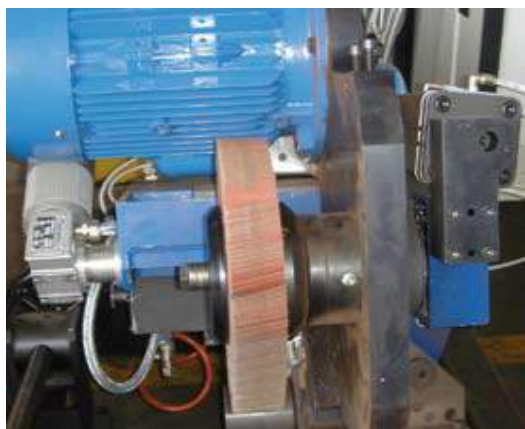
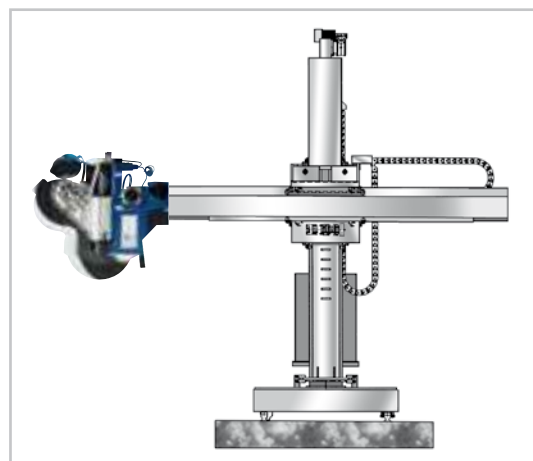
The GBC G400 is a light, powerful, compact and versatile grinder for rapidly grinding and finishing large diameter vessels, boiler shells etc.

- back gouging for weld root removal
- polishing of dish ends, vessels, cones, poles etc
- tack - welded edges preparation by grinding
- weld seam profile removal



GBC G400 shown mounted on trolley, during typical back gouging operation, circumferential on O.D. of pressure vessel. The trolley allows easy handling and moving of the grinding head.

GBC G400 mounted on column welding boom arm, equipped with needle bearing kit for 360° rotation. This layout allows back gouging circumferential, longitudinal, outside and inside on large diameter pressure vessels.



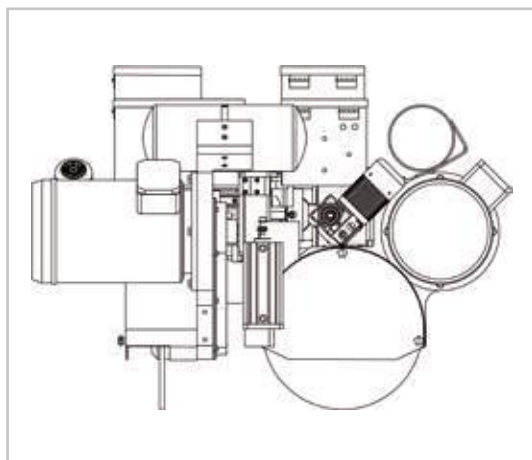
*Optional flap wheels for polishing, cleaning and removal or reduction of weld seam.
Equipped with different abrasive grits according to finishing grade requirement.*

G400 Back Gouging Grinding Machine

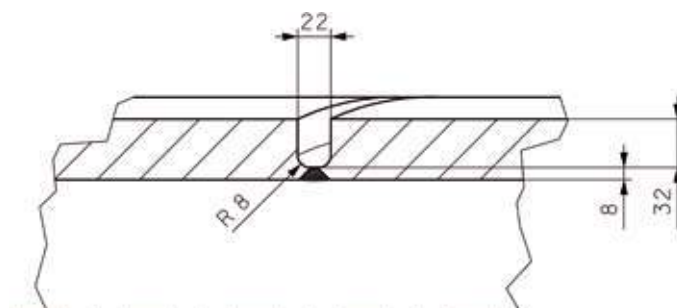
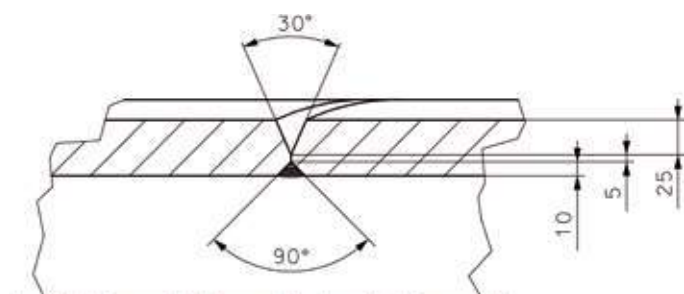
- Time save up 80% for back gauging operation
- High material rate removal
- No thermal alteration (heat affected zone) of welding area
- Same job accuracy all over work piece
- Vibrations free
- Safety & working condition improvement
- Drop of injury on duty (grinding sparks, tendinitis, sprains, stress fractures) due to extended angle grinder handling time



G 400 Grinder pneumatic feeding system compensator retracts the feeding piston when it encounters ovality to eliminate excessive material removal.



Grinding head can turn of 90° for dedicated set up when performing longitudinal back gouging (mounted on column welding boom arm only).



Example with ferrule diam. 2000mm wall thickness 40mm material A516 Gr. 70.

Step 1: execution of the submerged arc welding on the inside part.

Step 2: external back gauging for welding root removal with Grinder G 400, execution of "U" shape edge preparation ready for final submerged arc welding on the outside part.

Estimated time of execution with G400 and single operator: 30 min.

Estimated time of execution manual with angle grinder and single operator: 240 min.

G400 Back Gouging Grinding Machine

TECHNICAL FEATURES

O.D. Circular gauging mini diam.	mm	500
Longitudinal outside gauging mini diam.	mm	500*
Longitudinal inside gauging mini diam.	mm	1500
Max grinding disc diam.	mm	400
Grinding disc thickness	mm	8-16
Motor power	Kw	9,0
Max grinding wheel cutting speed	m/s	65
Max diam. flap wheel	mm	300
Flap wheel width	mm	40-75
Feeding stroke	mm	135
Drifting stroke	mm	95
Max grinding depth	mm	80**

Min. tube elevation from ground 1 meter
If using brand new grinding wheel

