SKS
WELDING SYSTEMS

WELD PACKAGE DUAL WIRE 2.0

The Weld Package for your Welding Tasks from the Power Source to the Contact Tip

WATER-COOLED

CONTENT

Power Source • Weld Process Controller • Software • Interface • Wire Feeder Unit • Wire Guidance • Cable Bundle • Control Cable • Torch System • Torch Necks • Consumables

WELDING PROCESSES

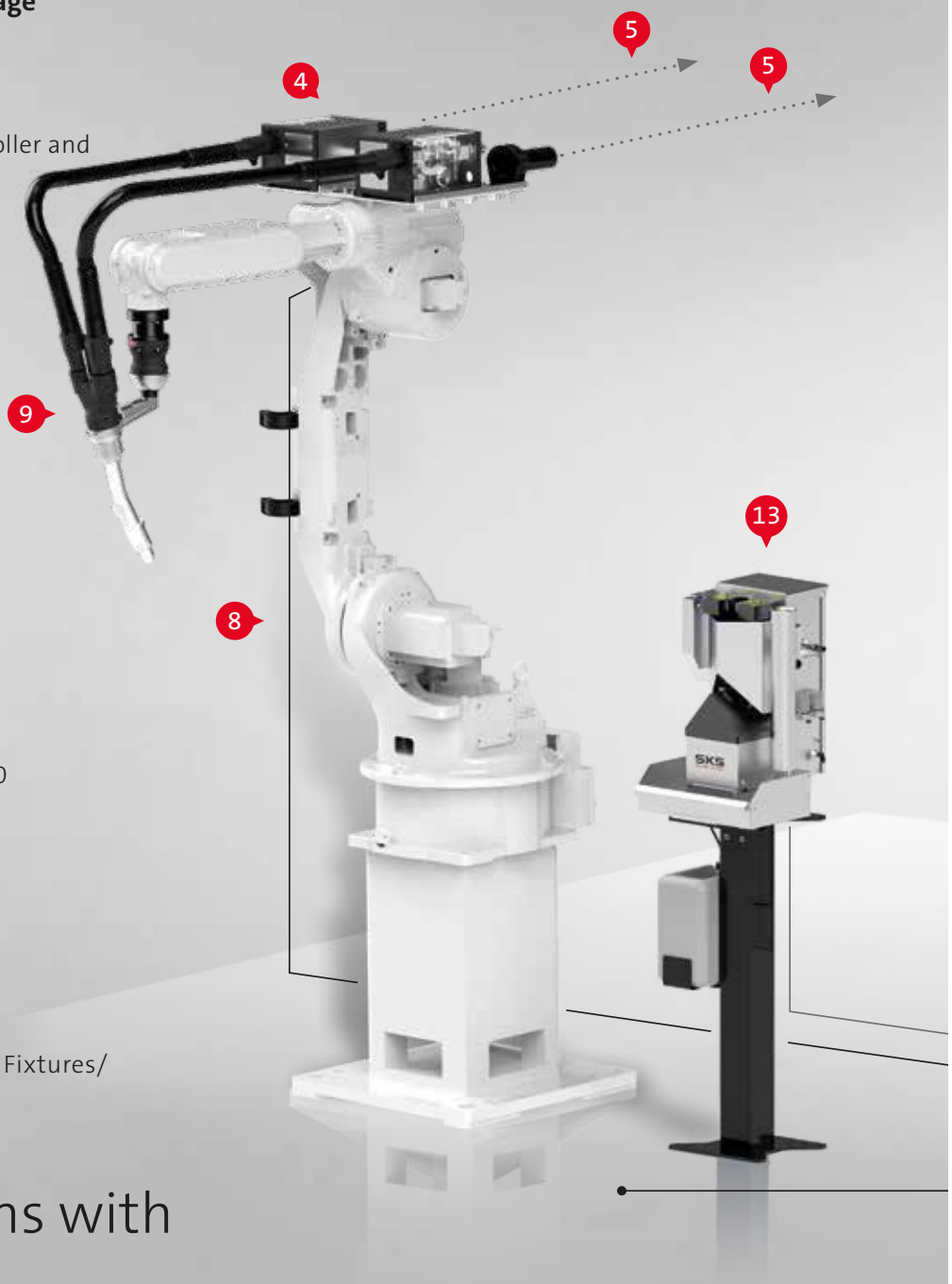
Dual Wire 2.0
GMAW
KF-pulse
Pulse
MIG-Brazing

STEEL

SKS Weld Package: System design

The Dual Wire 2.0 Weld Package contains:

- A Integrated solution: power source, weld process controller and interface in one device
- 1 Power Source
- 2 Weld Process Controller and Software/IT
- 3 Robot Interface
- 4 Wire Feeder
- 5 Wire Guidance
- 6 Ground Cable
- 7 Control Cable
- 8 Cable Bundle
- 9 Torch System Dual Wire 2.0
- 10 Torch Neck/ Consumables
- 11 Water Cooling
- 12 Reamer Blades
- 13 TCP Dimensions/Checking Fixtures/ Torch Cleaning Stations



For installations with outer cable dress.

This brochure contains information about the SKS Weld Package, the torch system Dual Wire 2.0, as well as consumables and spare parts. There are various features of the welding machine components and torch systems available depending on the robot system and the welding task.

The **Dual Wire 2.0 Weld Package** can be used with all common industrial robots.

Dual Wire 2.0 – water-cooled for steel applications

Processes:	Dual Wire 2.0, GMAW, KF-pulse, Pulse, MIG-Brazing
Wire materials:	high-alloy steels, low-alloy steels
Compatibility:	for all common industrial robots
Weight:	7.5 kg
Max. power:	420 A – 60 % duty cycle/40 °C, water-cooled
Wire diameter:	2 x 0.8-1.6 mm
TCP accuracy:	± 0.5 (400 mm)

LSQ COMPACT

The LSQ COMPACT IoT was designed as an integrated welding system, combining the weld process controller, Fieldbus interface, and power supply into one unit, resulting in a compact size with fewer external connections – for easy installation. Even with its compact size and integrated design, this machine is powerful and incorporates 35 years of technological knowledge. Whether you are welding thick aluminum plates or thin stainless steel, a process is available to support your specific needs. All processes are unlocked and readily available. You do not need an additional license or passcode to use them.

Up Front Pricing:

No hidden costs for welding processes and software functions.

A Integrated Solution LSQ COMPACT

Compact: All in One, All Inclusive. Compatible with
SKS Weld Packages: Power Clutch, Power Joint and Frontpull.

POWER SOURCE
+ PROCESS CONTROLLER
+ ROBOT INTERFACE

420 A
60% DUTY CYCLE
AT 40°C

READY FOR GLOBAL USE
CE, UL & CCC CERTIFIED

MATERIALS:

steel
low- & high-alloy steel
copper alloys
galvanized steel
aluminum*

INCLUDES THE WELDING PROCESSES AND FUNCTIONS:

GMAW
I-pulse
KF-pulse
microMIG*
microMIG-cc*
MMT-x*
DP-Fast
MIG-Brazing
Synchroweld
AutoComp

MQTT
OPC UA**
+ TRACEABILITY

Q8 TOOL

FREE WELD DATA DOCUMENTATION & MANAGEMENT

* Only in combination with Frontpull torch system. Further information can be found in the Frontpull Weld Package
** Only available in LSQ COMPACT IoT

A Integrated Solution LSQ COMPACT

LSQ5 COMPACT IoT

Please note:

A single LSQ5 is still required when setting up with LSQ COMPACT. A setup with 2x LSQ COMPACT is not possible.

Integrated power source

The LSQ COMPACT Lite and IoT are available with LSQ 3 and LSQ 5 power sources to provide the best solution for your application. The technical data can be found on the following pages.

Integrated weld process controller

While the LSQ COMPACT Lite is designed for maximum cost efficiency, the LSQ COMPACT IoT offers additional features such as the Internet of Things (IoT), MQTT, and OPC UA support. This advanced weld process controller enables extended real-time monitoring and analysis of welding processes, resulting in improved quality assurance and more precise control of the process.

Specifications	Lite	IoT
Operation via	buttons	touch screen
Programs	15.872	15.872
Ports	USB, SD card slot	Ethernet, SD card slot
MQTT / OPC UA	No	Yes
Remote Control	Q8Tool	Q8Tool, VNC client

Integrated interface

With the included Fieldbus Interface FB5 the system can be perfectly integrated into existing Fieldbus environments. Various Fiedbus types are available e.g. EtherNet/IP, Profinet CU.

Overview LSQ COMPACT	Part-No.
LSQ5 COMPACT Lite	**77-1185-71x**
LSQ3 COMPACT Lite	**77-1184-78x**
LSQ5 COMPACT IoT	**77-1185-77x**
LSQ3 COMPACT IoT	**77-1184-81x**
LSQ5 CCC COMPACT Lite	**77-1185-73x**
LSQ3 CCC COMPACT Lite	**77-1184-73x**
LSQ5 CCC COMPACT IoT	**77-1185-79x**
LSQ3 CCC COMPACT IoT	**77-1184-79x**

Please note:

Various field bus types available. Please enter the number you require in place of the x:
1 = EtherNet/IP | 2 = Profinet CU | 3 = EtherCAT

Option

Accessories: Wall mount for LSQ5
Space-saving design that makes for easy cleaning/ maintenance.

Wall mount

Overview of wall mounts	Part-No.
Wall mount for power source LSQ5 and LSQ5 COMPACT	**77-1180-01**
Wall mount for power source LSQ3 and LSQ3 COMPACT	**integrated**

1 Power source

LSQ5 power source

LSQ5 power source with Direct Control Technology (DCT)

The LSQ5 ensures the optimum arc energy. It uniquely adjusts to different weld processes. Unlike conventional power sources with inverter technology, the LSQ5 with Direct Control Technology controls its switching transistors without any fixed clock frequency according to the needs of the weld process. Without any delay, the energy needed for the process is provided instantly. The flexible fine tuning is done by a central processor. The CPU continuously analyzes the weld process and current/voltage values on the basis of data obtained and optimally drives the switching transistors of the power section. This results in an extremely high efficiency and a low temperature development.
The power source can be configured with only two buttons and four LED indicators. For worldwide usage, voltages can be configured without opening the power source.

The main benefits are:

- DCT provides a speed regulation up to ten times higher compared to conventional inverter technology. This leads to excellent control behavior and shorter response times.
- The weld properties are substantially improved. Software replaces hardware: Fewer components also increase the reliability in continuous operation.

Specifications	LSQ5 (-CCC)
Performance	420 A - 60 % duty cycle/40 °C (400 A)
Processes and functions	GMAW, I-pulse, KF-pulse, microMIG*, microMIG-cc*, MMT-x*, DP-Fast, MIG-Brazing, Synchroweld, AutoComp
Weight	49 kg
Primary voltage	3 x 400 (480) V
Wall mounting	Yes (optional)
Conformities	CE, CSA, UL (CCC)
Dimensions	450 x 400 x 540 mm

* Only in combination with Frontpull torch system. Further information can be found in the Frontpull Weld Package.

Innovative Control Concepts with Touch Screen.

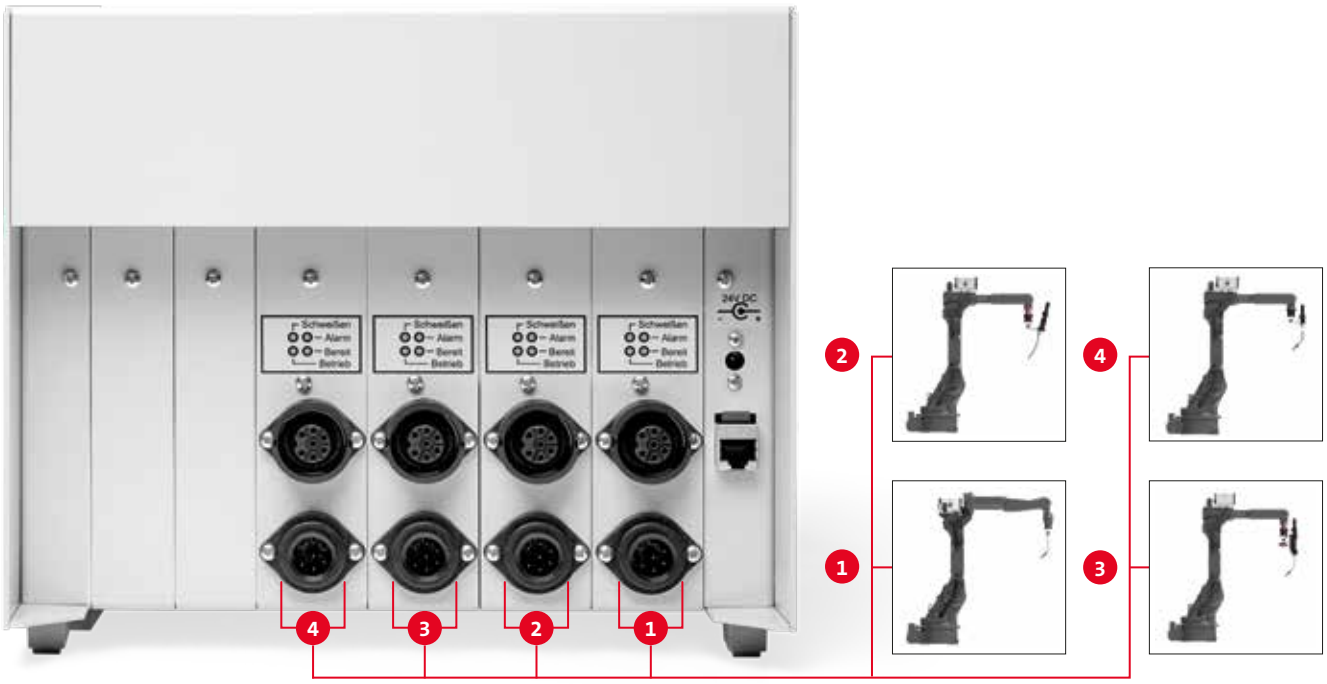
With the new Q84r and the compact Q84s up to four weld machines can be controlled centrally.

- **Parameter settings** completely integrated in the SKS software
- **Documentation** of measurements + TCP speed

- All settings on a single screen
- All measurements on a single screen
- All SKS welding processes and functions available
- Ready to use Industry 4.0 protocols (MQTT + OPC UA) and data traceability!

Q8 TOOL

2 Weld process controller



Controlling up to four weld machines at the same time

The new Q84r and Q84s are equipped with a touch screen, an innovative usability concept and an advanced visualization technology for much easier operating. The user interfaces have the look and feel of the Q8Tool4 software. Individual weld process controllers are in card slots in the Q84r/s. This new weld process controller concept can host up to four weld process controller cards. Each card independently controls a weld machine. As an alternative to the Q84r/s weld process controllers, the Q80 has been developed to control a single weld machine.

Q84r weld process controller

Q84r Weld process controller

Please note:

The Q84r/s can be equipped with up to four weld process controller cards.

Weld process controller Q84r/s

The universal weld process controllers Q84r and Q84s calculate the optimal parameters for each welding process. Only basic data such as material, wire type, wire feed speed and type of gas must be entered. The Q84r is equipped with a 10" touch screen, the space-saving Q84s with a 7" touch screen. For wall mounting the display of the Q84s can be rotated by an angle of 180°.

- Processes and functions: GMAW, I-pulse, KF-pulse, microMIG*, microMIG-cc*, MMT-x*, DP-Fast, MIG Brazing, Synchroweld, AutoComp
- Programs: 15.872 (x4)
- General functions: Display and saving of readings, alarms
- Monitoring functions: Weld current monitoring, auto compensation, arc and ignition monitoring, motor current, gas and water monitoring
- Easy to network via Ethernet: Traceability
- Ports: RJ45-Ethernet, SPW-Bus, SD card slot
- Remote Control/Administration: Q8Tool, VNC client
- Supports MQTT / OPC UA

Overview weld process controllers	Part-No.(Q84s)	Part-No. (Q84r)
Q84s/r weld process controller with one weld card	**77-7410-001**	**77-7310-001**
Q84s/r weld process controller with two weld cards	**77-7420-001**	**77-7320-001**
Q84s/r weld process controller with three weld cards	**77-7430-001**	**77-7330-001**
Q84s/r weld process controller with four weld cards	**77-7440-001**	**77-7340-001**

Overview Q84r/s mounting kits	Part-No.
Bracket for Q84r for mounting onto power source LSQ3/5	**77-7240-01**
Mounting brackets for Q80/Q84s for mounting onto power source LSQ3/5	**77-7240-06**
Bracket for Q84r for wall mounting	**77-7240-02**
Bracket for Q84r mounting in the robot cabinet	**77-7240-05**

Overview Q84r/s accessories	Part-No.
Connection cable for Q84r/s 5m with open end (optional)	**77-3305-00**
Plug for external power supply of Q84r/s	**77-7240-96**
USB adapter for SD/microSD cards	**91-8-1**

Overview Q84r/s replacement parts	Part-No.
Touchpen for Q80 / Q84r/s weld process controller (spare part)	**77-7240-03**
SDHC card 8GB for Q84r/Q84s/Q80 weld process controllers	**91-8-6**

* Only in combination with Frontpull torch system. Further information can be found in the Frontpull Weld Package.

2 Weld process controller

Q80 weld process controller – front view


Q80 weld process controller – back view

Weld process controller Q80

The Q80 is the alternative to the Q84r/s. It has the same functionality/features as a single weld card of the Q84r/s - optimized for a single weld machine. With the universal Q80 all parameters and values needed for the weld task can be optimally calculated

- Processes/functions/general functions see Q84r/s
- Easy to network via Ethernet: up to traceability
- Ports: RJ45-Ethernet, SPW-Bus, SD card slot
- Wall mounting capability
- Remote Control / Administration: Q8Tool
- Supports MQTT / OPC UA

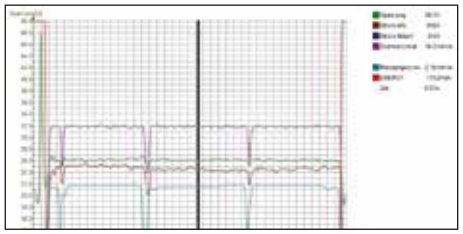
Overview weld process controller	Part-No.
Q80 weld process controller	**77-7260-001**

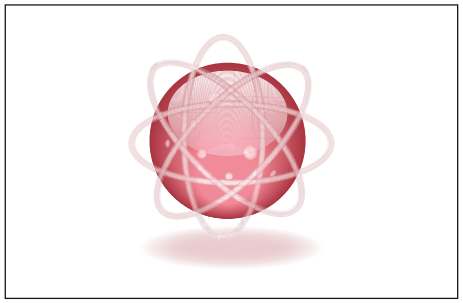
Overview Q80 mounting kits	Part-No.
Bracket for mounting onto power source LSQ5	**77-7240-06**

Overview Q80 accessories	Part-No.
USB adapter for SD-/microSD card	**91-8-1**

Overview Q80 replacement parts	Part-No.
Touchpen for Q80 / Q84r/s weld process controller (replacement part)	**77-7240-03**
SDHC card 8GB for Q84r/Q84s/Q80 weld process controllers	**91-8-6**

2 Software/IT





Q8Tool software

The Q8Tool software provides accurate and comprehensive process monitoring. The user can store weld parameters for documentation on a PC and/or administrate them. It offers basic functions such as reading, modifying and documenting of weld parameters.
Additionally, new weld parameters can be created and transferred to the universal weld process controllers. The weld data is portable and the installation of further control units on new equipment is easy. Also, the software allows reading and exporting of measurements and alarms. Graphical and numerical recording of measures helps defining and optimizing parameters for new parts. Users have a powerful tool for analyzing and documenting their weld results.

Network

The weld process controller units can easily be networked via Ethernet ports: Time savings through centralized administration of all controllers within the corporate network. There is a central backup of all welding parameters, management of user rights and access, process monitoring up to traceability. The Q8Tool software is provided free of charge with the weld process controller. No additional hardware or software is required.

Perfect integration.

Interfacing all industrial robot types.

By the use of Fieldbus Interface FB5 the system can be perfectly integrated into existing Fieldbus environments. For analog and digital environments the universal interface UNI5 is available on request.

Standard application

Fieldbus systems exchange signals via serial communication. The Fieldbus master, usually the robot controller or overall system controller, bundles and processes the signals of the connected Fieldbus, including the welding machine. Standard Fieldbus systems are e.g., Interbus-S, Profibus DP or DeviceNet.

The Fieldbus interface FB5 translates the Fieldbus signals for the welding machine using a standardized protocol. It makes no difference which type of Fieldbus system is used. The signals are always at the same place on the Fieldbus. This makes the preparation of the robot or system controller much easier.

3 Robot interface

FB5 Fieldbus Interface: mounting onto the power source


FB5 Fieldbus Interface: mounting onto the cabinet

Fieldbus application

Various Fieldbus types are supported (e.g. Profibus DP, DeviceNet). The Fieldbus interface has drilled bore holes for flexible mounting within the weld cell. Two additional mounting kits provide easy installation at the power source or into the cabinet. Additionally, external power can be connected to the interface. More details on solutions for the specific Fieldbus types are available on request.

Overview FB5 interfaces	Part-No.
Fieldbus interface FB5 Interbus-S (copper line)	**77-3-1**
Fieldbus interface FB5 Profibus DP	**77-3-2**
Fieldbus interface FB5 DeviceNet	**77-3-3**
Fieldbus interface FB5 EtherCAT	**77-3-4**
Fieldbus interface FB5 Profinet IRT (copper line)	**77-3-5**
Fieldbus interface FB5 Profinet IRT (LWL 2 Port)	**77-3-6**
Fieldbus interface FB5 Interbus-S (LWL FSMA)	**77-3-7**
Fieldbus interface FB5 Ethernet/IP	**77-3-8**

Cabinet mounting	Part-No.
Mounting kit for cabinet	**77-1182-02**
Cabinet cable 2m FB5 with device plug and cable socket	**77-3102-02**

Power source mounting	Part-No.
Bracket for FB5/Q6pw for mounting onto LSQ3/5	**77-1182-03**

Optional power supply (24V)	Part-No.
Connection cable 2.0 m (with open end)	**77-1182-04**

SYNCHROWELD

Synchroweld unites the weld system and robot by a communication protocol (RWDE). This technology allows the weld system to get the actual robot speed and automatically adjusts the weld parameters and laser power within defined limits. The result is a constant energy per unit length. At the same time, the programming effort can be significantly reduced.

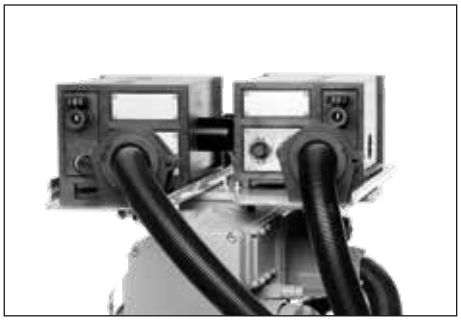
Please note:

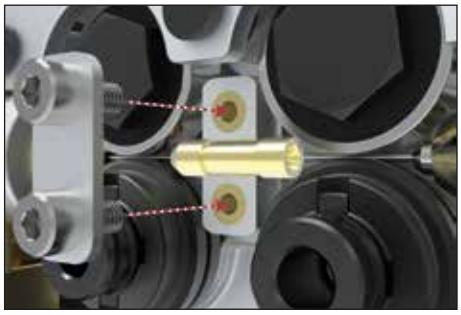
Further information on Synchroweld with ABB, Fanuc, KUKA, Yaskawa can be found in our Synchroweld brochure.

Strong, lightweight and precise.

The PF6 wire feeder.

Smaller and with less weight accompanied by improved efficiency over conventional wire feeders the PF6 goes along with the steady development of arc welding robots.





Power Feeder PF6

The industrially proven wire feeder PF6 has been enhanced with an additional control and monitoring function - an integrated gas regulation system in addition to the gas flow sensor. The ability to regulate gas flow for the actual weld seam is a crucial factor for seam quality. This also leads to cost savings, as only the amount of gas currently required is passed through the torch system. The proven gas flow sensor, used to monitor the flow rate, is also implemented in this wire feeder variant. Especially with complex components, not having the required gas flow rate can result in high costs, as the component may become unusable - in the best case, it can only be salvaged through extensive rework. The target and actual gas quantities can be read on the welding process control system. Additionally, an alarm can be triggered if the values fall below or exceed the set limits.

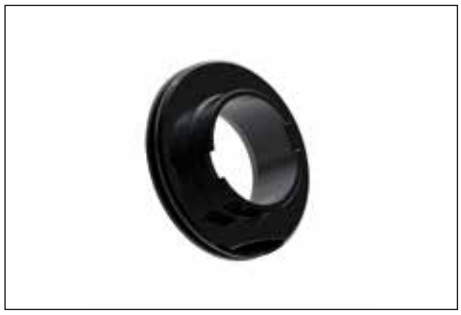
Overview PF6	Part-No.
PF6 L wire feeder	**10-3-8**
PF6 R wire feeder	**10-3-4**
PF6 L wire feeder with integrated gas regulation	**10-3-508**
PF6 R wire feeder with integrated gas regulation	**10-3-504**

Specifications	
Weight	4.1 kg
Motor	70 W
Wire feeding speed [v]	2.5 - 25 m/min
Drive roll for wire diameter	0.8 - 1.6 mm

Mittelführung

Die Mittelführung dient zur definierten Führung des Schweißdrahtes im Vierrollenantrieb.

Übersicht Mittelführungen	Part-No.
Mittelführung f. Drahtvorschub PF5/6, Stahl Draht-Ø 0,8-1,6mm	**12-2-1-15**



Please note:

Four drive rolls per system are needed.

Please note:

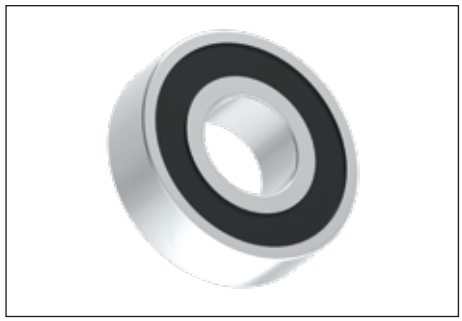
Drive rolls for wires in inch sizes available on request.

Drive roll

Our drive rolls are available in several groove shapes for different welding filler materials (V-groove for steel and knurled U-groove for filler wire applications).

Overview drive rolls	Part-No.
Wire-ø 0.8 mm, V-groove	**12-2-4-08**
Wire-ø 0.9 mm, V-groove	**12-2-4-09**
Wire-ø 1.0 mm, V-groove	**12-2-4-10**
Wire-ø 1.2 mm, V-groove	**12-2-4-12**
Wire-ø 1.4 mm, V-groove	**12-2-4-14**
Wire-ø 1.6 mm, V-groove	**12-2-4-16**

Overview drive rolls	Part-No.
Filler Wire-ø 1.0 mm, U-groove	**12-2-4-310**
Filler Wire-ø 1.2 mm, U-groove	**12-2-4-312**
Filler Wire-ø 1.6 mm, U-groove	**12-2-4-316**



Please note:

Two pressure rolls and two locating bolts are needed per system.

Pressure roll

The pressure roll ensures a defined pressure of the welding wire into the specific groove shape of the drive roll.

Overview pressure rolls	Part-No.
Pressure roll – DIN 625 T1 for PF5/6 wire feeder series	**12-2-3-0**
Locating bolt for pressure roll on two/four roller drive	**12-13-5**

Please note:

Wire feeder brackets for further robot types are available on request.

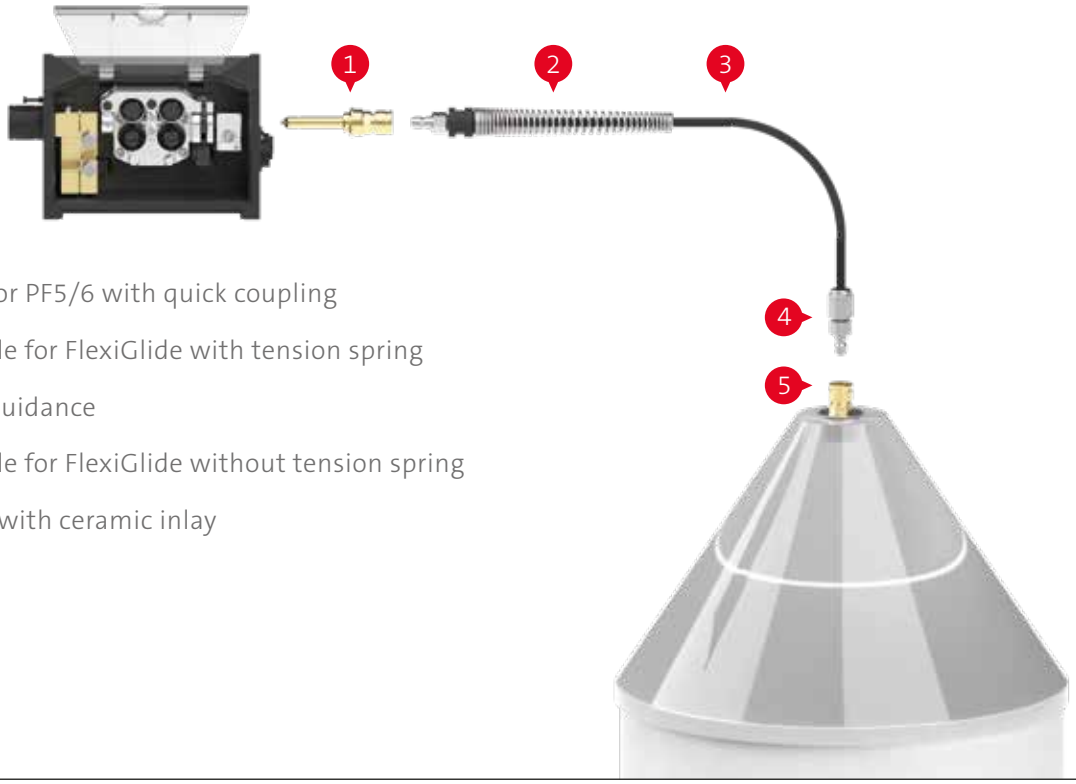
Wire feeder bracket

For easy and quick installation every wire feeder bracket is prepared with robot specific mounting patterns and also includes all necessary mounting materials.

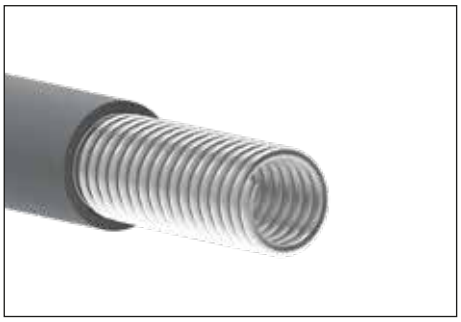
Overview wire feeder brackets	Part-No.
For robot type-ABB (single wire)	
IRB 2600-12/1.85	**14-2-8**
IRB 4600-40/2.55	**14-2-19**
For robot type-FANUC (single wire)	
AM 100iD / AM 120iD / M-10iD/8L / M-20iD/12L	**14-1-27**

For robot type-KUKA (single wire)	
KR 12 R1810-2/ KR 16 R2010-2/ KR 20 R1810-2	**14-3-3**
KR 16 R1610-2	**on request**
For robot type-YASKWAWA (single wire)	
AR 2010 / AR 3120 / GP 20 / GP 25-12	**14-1-27**

5 FlexiGlide wire guidance



1. Wire inlet body for PF5/6 with quick coupling
2. Connection Nipple for FlexiGlide with tension spring
3. FlexiGlide Wire Guidance
4. Connection Nipple for FlexiGlide without tension spring
5. Drum connector with ceramic inlay



FlexiGlide Wire Guidance

Please note:

Further information can be found in our brochures "FlexiGlide" (PIN-0168) and "Wire guidance" (DOC-0193).

SKS Wire guidance FlexiGlide with a high limit of elasticity and very low friction. The constructive design, a coil made from chrome/nickel spring steel with a plastic coating, creates robustness, resulting in a high lifetime.

Benefits with FlexiGlide:

- Optimized for use in robotic applications
- High lifetime
- Very low friction
- Flame retardant and abrasion resistent

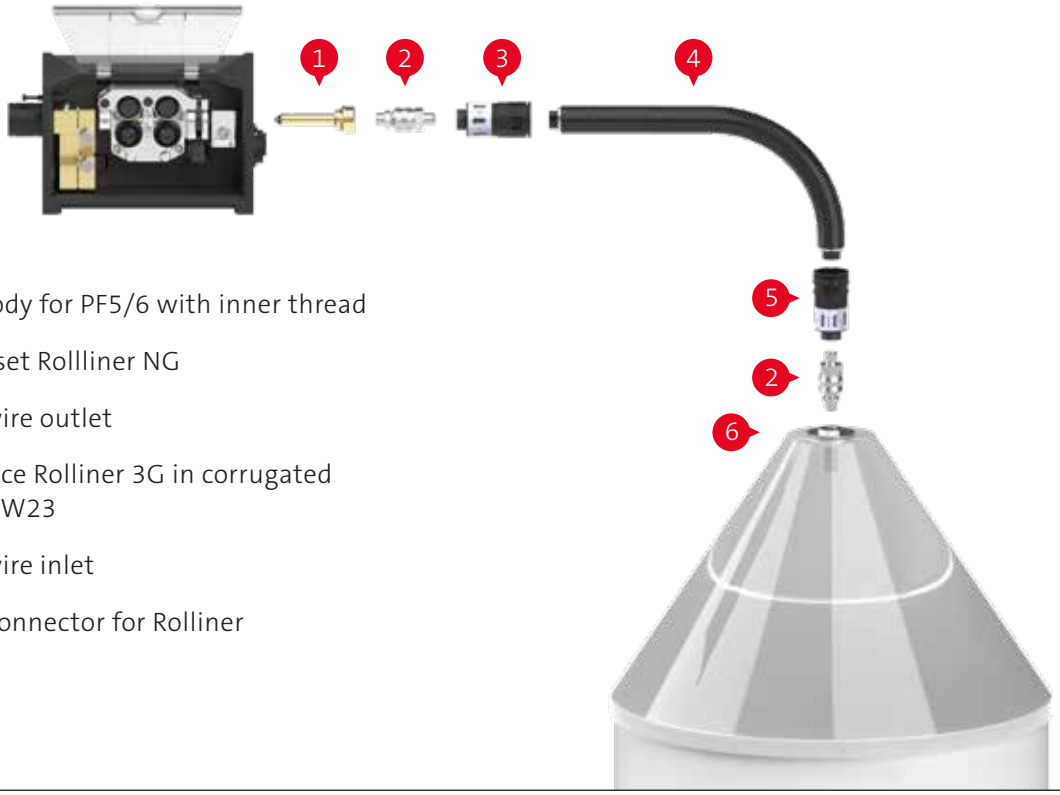
FlexiGlide wire guidance

Overview of FlexiGlide wire guidance	Part-No.
Wire Inlet Body for PF5/6 with Quick-Connector	**10-2-0-61**
Connection Nipple insulated for FlexiGlide with tension spring	**44-3-11**
FlexiGlide wire guidance, Type B, per meter	**44-3-1**
Connection Nipple for FlexiGlide without tension spring	**44-3-4**
Drum Connector with ceramic inlet	**44-40-1**

Option

Overview strain-relief on wire guidance	Part-No.
Strain-relief for wire guidance on wire feeder bracket	**14-10-6**
Through-Wall Mount for wire guidance FlexiGlide incl. suspension	**44-3-8**
Wall Duct for FlexiGlide wire guidance	**44-3-9**

5 Rolliner 3G wire guidance



1. Wire inlet body for PF5/6 with inner thread
2. Connection set Rollliner NG
3. Connector wire outlet
4. Wire Guidance Rolliner 3G in corrugated tube black NW23
5. Connector wire inlet
6. Wire drum connector for Rolliner

Rolliner 3G Wire guidance is suitable for all applications where higher wire feeding requirements are needed.

Benefits:

- Optimized sliding properties with roller-supported wire guidance
- High flexibility due to segmentation of roller parts
- Suitable for use in harsh environments
- Universally application (steel, stainless steel, filler wire, aluminum)

Overview of Rolliner 3G wire guidance	Part-No.
Wire inlet body for PF5/6 with ¼" NPTF inner thread	**10-2-0-60**
Connection set Rollliner NG for drum or wire feeder	**44-60-21**
Connector wire outlet for Rolliner 3G	**44-60-42**
Mounting clip for Rolliner 3G	**44-60-45**
Wire Guidance Rolliner 3G per meter	**44-60-40**
Corrugated tube PUR black NW23 per meter	**91-3-2**
Connector wire inlet for Rolliner 3G	**44-60-41**
Wire drum connector for Rolliner NG	**44-60-30**

Option

Overview of strain-relief on wire guidance	Part-No.
Strain-relief wire guidance for Rolliner	**14-10-8**
Clamping Piece Rollliner 3G on Cable Bundle -W-	**44-60-48**

Please note:

Two connection sets are needed.

Alternative

Wire inlet bodies for additional systems

Beside the wire inlet body for the SKS wire guidance, inlet bodies for additional systems are available.

Overview of wire inlet bodies for additional systems	Part-No.
Wire inlet body for PF5/6 with M10 internal thread for ESAB	**10-2-0-50**
Wire inlet body for PF5/6 with 9.6 mm bore hole	**10-2-0-52**
Wire inlet body for PF5/6 with 13 mm bore hole	**10-2-0-53**
Wire inlet body for PF5/6 with PG9 thread	**10-2-0-56**
Wire inlet body for PF5/6 with internal thread ¼" NPTF	**10-2-0-60**

6 Ground cable

Please note:

Two ground cables per system are needed. Further lengths and diameters available on request.

Ground cable with 70 mm² connector and cable lug

The use of highly pure copper reduces the electric resitance supporting the welding process. Manufactured as of DIN VDE 0285-525-2-81 / DIN EN 50525-2-81.

Overview of ground cables	Part-No.
Ground cable 70 mm² 6 m with DIX plug and cable lug	**228078106**
Ground cable 70 mm² 10 m with DIX plug and cable lug	**228078100**

Option

Overview of ground cables	Part-No.
Ground cable 95 mm² 6 m with DIX plug and cable lug	**228080106**
Ground cable 95 mm² 10 m with DIX plug and cable lug	**228080110**

7 Control cable

Please note:

For the Dual Wire 2.0 system four control cables are needed. One control cable is already included in the cable bundle.

Please note:

Further lengths available on request.

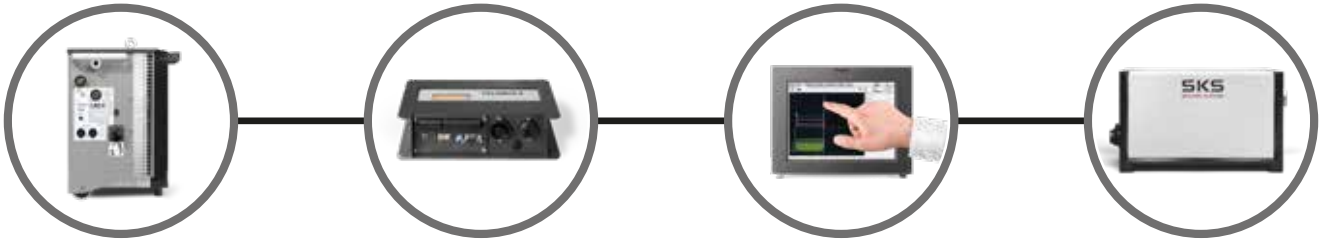
Control cable: L700/SPW-Bus

One cable to connect power source, weld process controller, interface and frontpull module. By use of one cable stock and installation is simplified. The power is supplied via this cable. An external supply is not neccesary.

Overview of control cables	Part-No.
Control cable 0.5m L700/SPW-Bus	**541031050**
Control cable 1m L700/SPW-Bus	**541031001**
Control cable 2m L700/SPW-Bus	**541031002**
Control cable 3m L700/SPW-Bus	**541031003**
Control cable 5m L700/SPW-Bus	**541031005**
Control cable 7m L700/SPW-Bus	**541031007**
Control cable 10m L700/SPW-Bus	**541031000**
Control cable 12m L700/SPW-Bus	**541031012**
Control cable 15m L700/SPW-Bus	**541031015**

Plug & Play: Control cable L700

The advantages of a system concept are revealed by its details: One standard control cable (L700) connects all system components (power source, robot interface, weld process controller and wire feeder) within the welding system. The system is expandable: Other components can be integrated at any time into an existing system. New devices are automatically detected.



Power Source | Robot Interface | Weld Process Controller | Wire Feeder

8 Cable bundle

Cable bundles: Power source to PF6

Coaxial power cable 72 mm² with internal gas flow, control cable L700, corrugated tube and cable holder. Water-cooled version.

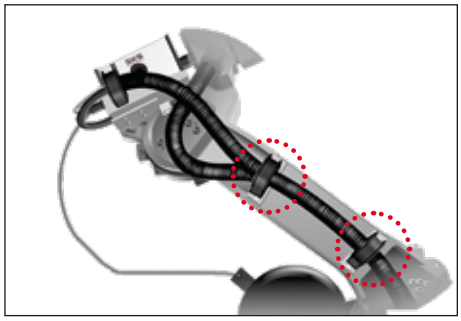
Overview of cable bundles	Part-No.
Cable bundle 72mm² 5m -W- LSQ-PF5/6	**20-8-5**
Cable bundle 72mm² 7m -W- LSQ-PF5/6	**20-8-7**
Cable bundle 72mm² 10m -W- LSQ-PF5/6	**20-8-10**

Overview of cable bundles with air-blast function	Part-No.
Cable bundle 72mm² 5m -W- LSQ-PF5/6 with air-blast function	**20-23-5**
Cable bundle 72mm² 7m -W- LSQ-PF5/6 with air-blast function	**20-23-7**
Cable bundle 72mm² 10m -W- LSQ-PF5/6 with air-blast function	**20-23-10**
Air blast valve for mounting on the wire feeder bracket	**93-50**

Please note:

Further lengths available on request.

8 Cable bundle: Clamping set



Mounting cable bundle: clamping set -W-

Provides perfect installation of the cable bundle for all different robot types. Undesired cable movements are prevented. This results in higher lifetime.

Overview of clamping sets	Part-No.
For robot type-ABB	
IRB 2600-12/1.85 / I RB 4600-40/2.55	**91-3-0-51-4**
For robot type-FANUC	
AM 100iD / AM 120iD / M-20iD/12L	**91-3-0-51-15**
M-10iD/8L	**on request**

For robot type-KUKA	
KR 12 R1810-2 / KR 20 R1810-2	**91-3-0-51-18**
KR 16 R1610-2 / KR 16 R2010-2	**on request**
For robot type-YASKAWA	
AR 2010 / GP 25-12	**91-3-0-51-19**
AR 3120	**91-3-0-51-12**
GP 20	**91-3-0-51-14**

Please note:

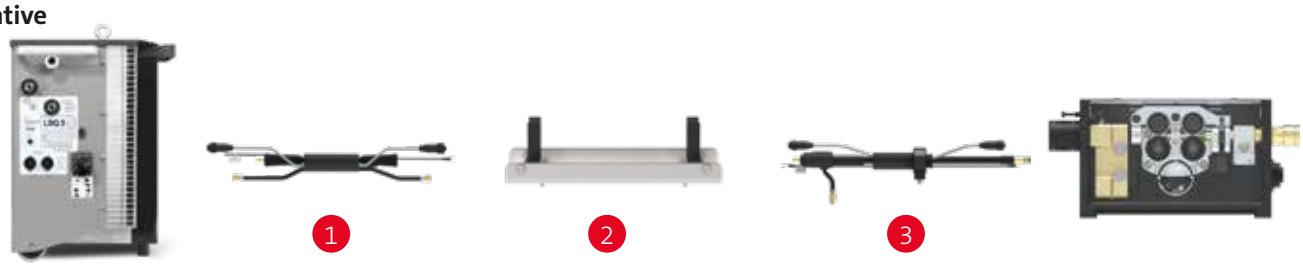
Clamping sets for further robot types are available on request.

Alternative

Mounting for WF-bracket	Part-No.
Mounting for WF-bracket for external guided cable bundle	**14-10-10**

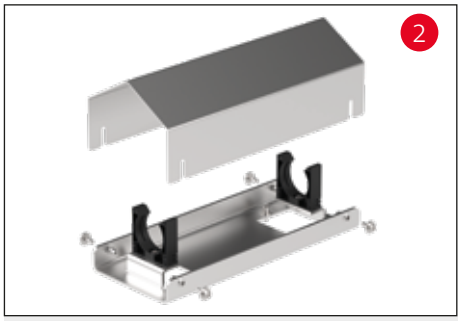
8 Dividable cable bundles

Alternative



70 mm² Connection from power source to connection bracket -W-

Length	Part-No.	Part-No. (with air-blast function)
5 m	**20-18-5**	**20-28-5**
7 m	**20-18-7**	**20-28-7**
10 m	**20-18-10**	**20-28-10**



Connection bracket for cable bundles (PF5/6) -W-

	Part-No.
Connection bracket	**20-17-0-3**

Connection 72 mm² from connection bracket to PF5/6 -W-

Length	Part-No.	Part-No. (with air-blast function)
3 m	**20-17-3**	**20-24-3**
5 m	**20-17-5**	**20-24-5**
7 m	**20-17-7**	**20-24-7**

Please note:

Further lengths available on request.

Please note:

For use of the air blast function the air blast valve (Part-No. 93-50) is required.

Cable bundle with separation between power source and wire feeder PF6

The moving parts of the cable bundle (next to the robot) are separated from the non-moving parts (power source). In case of maintenance work, only the moving parts have to be changed. The quick and easy replacement concept results in time and cost savings.

High welding speed and high deposition rate.

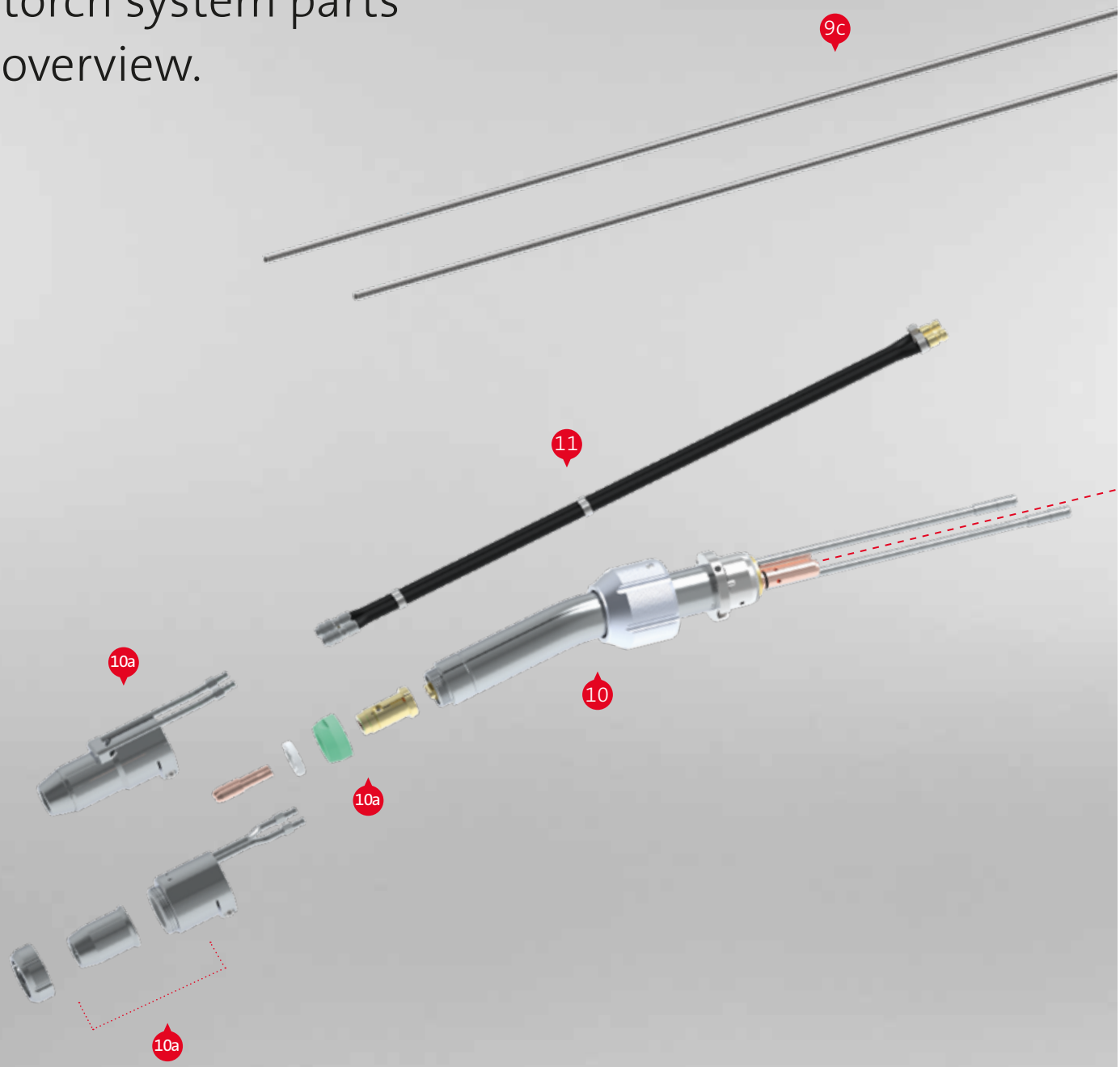
With the torch system Dual Wire 2.0, materials thicker than 3 mm can be joined fast and easy. The bajonet quick change system is integrated into the torch, so this new torch system supports a toolless change of the torch neck; this with a guaranteed TCP of ± 0.5 mm. We integrated two separate cooling circuits to increase the operational time of the welder and achieve a better cooling effect with this separation. The heat at the gas nozzle is already reduced and doesn't reach the torch. With its parallel wires and its round gas nozzle, the system is easier to clean and much easier to programm, especially in curves.

Dual Wire 2.0 – water-cooled for steel applications

Processes:	Dual Wire 2.0, GMAW, KF-pulse, Pulse, MIG-Brazing
Wire materials:	high-alloy steels, low-alloy steels
Compatibility:	for all common industrial robots
Weight:	7.5 kg
Max. power:	420 A – 60 % duty cycle/40 °C, water-cooled
Wire diameter:	2 x 0.8-1.6 mm
TCP accuracy:	± 0.5 (400 mm)

9 Torch system Dual Wire 2.0: Parts overview

Dual Wire 2.0 torch system parts overview.



9a Collisions Detection Power Clutch HD 9b TCP-Extension + Robot Flange
9c Torch cablel and Accessories 9d Torch Mounting Arm 10 Torch Neck
10a Consumables 11 Water Cooling

9 Torch system Dual Wire 2.0: Parts overview

9a Torch system: Collision Detection

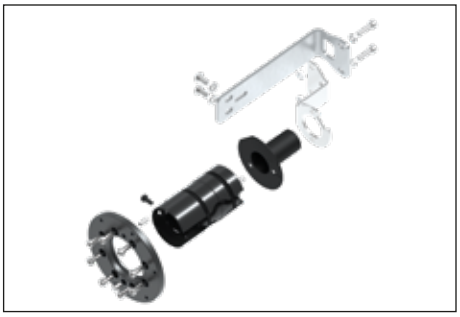
Collision Detection Power Clutch HD

The SKS collision protection is based on the Power Joint concept, continuing the modular structure of the SKS components. This ensures the same high precision TCP accuracy in the Dual Wire 2.0 as found in SKS Power Joint systems.

Power Clutch HD	Part-No.
Power Clutch 2 HD	**71-16**

Technical details	
Collision protection	deflection 10°
Reset accuracy	± 0.5 mm with TCP 400 mm
Weight	1.5 kg

9b Torch system: Robot mounting



Please note:

Robot flanges for further robot types are available on request.

Dual Wire 2.0 robot flange

With the robot flange the Dual Wire 2.0 torch system is mounted simply and safely on the sixth robot axis.

Overview of robot flanges	Part-No.
For robot type-ABB	
IRB 2600-12/1.85 / IRB 4600-40/2.55	**63-4-5**
For robot type-FANUC	
AM 100iD / AM 120iD / M-10iD/8L / M-20iD/12L	**63-4-24**
For robot type-KUKA	
KR 12 R1810-2 / KR 16 R1610-2 / KR 16 R2010-2 / KR 20 R1810-2	**63-4-3**
For robot type-YASKAWA	
AR 2010 / AR 3120 / GP 25-12	**63-4-8**
GP 20	**63-4-1**

TCP-extension

The TCP-extension increases the freedom of accessibility and depth of immersion into the weld part/fixturel.

Overview TCP-extension	Part-No.
50 mm	**93-29**

9c Torch system: Torch cable and accessories

Please note:

Pro System sind zwei Brennerkabel notwendig. Brennerkabel für weitere Robotertypen on request erhältlich.

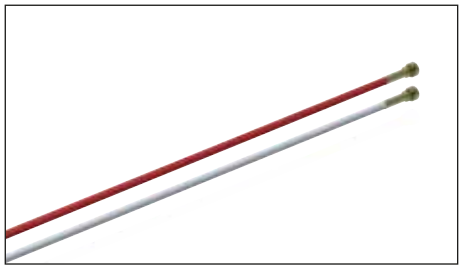
Torch cable for Dual Wire 2.0 torch system

Highly flexible coaxial cable 72 mm² with Power Pin and Power Clutch connector including switch-off cable for the robot

Overview recommended torch cable lengths for robots	Part-No.
For robot type-ABB	
IRB 2600-12/1.85	**61-5-10**
IRB 4600-40/2.55	**61-5-18**
For robot type-FANUC	
AM 100iD	**61-5-10**
AM 120iD	**61-5-12**
M-10iD/8L / M-20iD/12L	**61-5-15**

For robot type-KUKA	
KR 12 R1810-2 / KR 20 R1810-2	**61-5-135**
KR 16 R1610-2 / KR 16 R2010-2	**on request**
For robot type-YASKAWA	
AR 2010	**61-5-12**
AR 3120	**61-5-20**
GP 20	**61-5-10**
GP 25-12	**61-5-15**

Overview torch cable length	Part-No.
0.75 m	**61-5-075**
0.9 m	**61-5-09**
1.0 m	**61-5-10**
1.2 m	**61-5-12**
1.35 m	**61-5-135**
1.5 m	**61-5-15**
1.8 m	**61-5-18**
2.0 m	**61-5-20**
2.4 m	**61-5-24**



Please note:

Two liners and two sleeves are required for a single system. Additionally, two power pin caps are required when using aluminum wire.

Liner for torch system

For the following diameters and filler materials:

Steel, bronze (wire-ø 0.8 - 1.0 mm)	Part-No.
Length 2 m	**44-24-0810-20**
Length 3.5 m	**44-24-0810-35**
Sleeve	**44-30-2**

Steel, bronze (wire-ø 1.2 - 1.6 mm)	Part-No.
Length 2 m	**44-24-1216-20**
Length 3.5 m	**44-24-1216-35**
Sleeve	**44-30-3**

Y-Wire guidance

Wire guidance for defined guidance of both torch cables

Y-Wire guidance	Part-No.
Y-Wire guidance	**91-3-0-90**

9d Torch system: Torch mounting arm

Dual Wire 2.0: Torch mounting arm

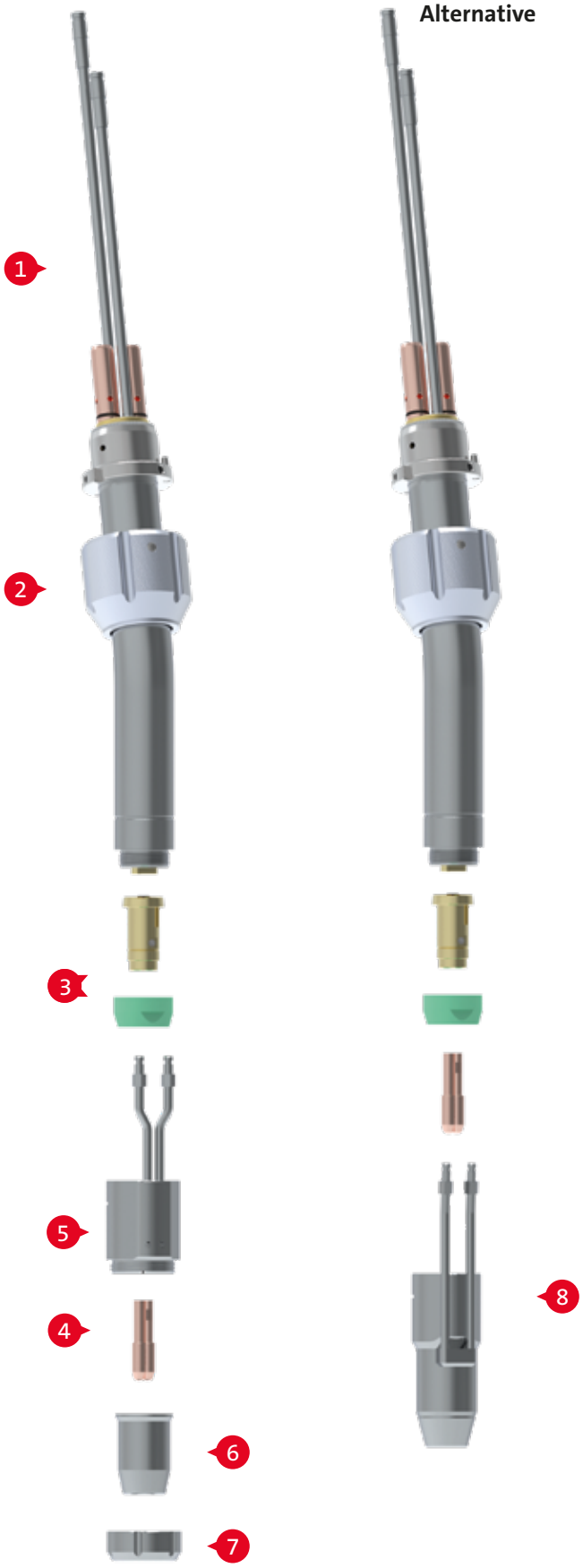
Precise torch body with mounting arm, air blast connector and proven bayonet quick-changeconnectors for torch cable and torch neck

Torch mounting arm	Part-No.
Torch mounting arm	**54-5-1**

10 Torch necks

Info:

The torch neck of the Dual Wire 2.0 torch system can be configurated with two different types of gas nozzles: For standard or heavy duty applications.



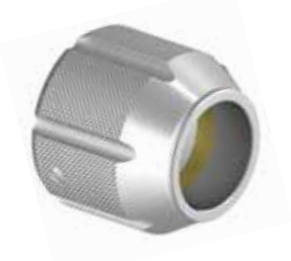
Configuration:
Standard (560 A 60 % ED/40 °C)

Configuration:
Hochleistung (840 A 60 % ED/40 °C)

10 Torch necks: Accessories

1

2



Torch necks for Dual Wire 2.0

SKS torch necks for easy installation with the innovative bayonet lock system for quick replacement. Aside from a toolless change of the torch neck, a TCP ± 0.5 mm is guaranteed. Two separated cooling circuits (torch neck and consumables) provide high cooling efficiency.

Overview torch necks TCP in mm	Part-No.
Torch neck 15° (complete system 30°) / 550 with retaining head and clamping nut	**54-5-5-15-550-1-1**
Clamping cap	**54-5-2-9**

Further information about cooling with ordering numbers can be found in section 11.

*** Please note:**

For aluminum applications SKS recommends a Frontpull torch system.

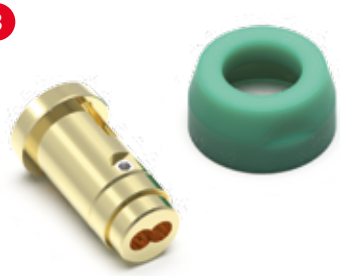
Advantages of SKS Dual Wire 2.0 System

Welding with a single potential enables the use of a round gas nozzle with parallel wires. The advantages:

- Smaller dimensions for better accessibility in different positions (punching, dragging)
- Easier programming
- Use of standard cleaning equipment
- Just a single Weld Process Control is necessary for the whole process. Moreover the entire system is realized with standard components. This makes the operation much easier and reduces investment.

10a Torch necks: Consumables

3



4

Please note:

Two contact tips are required for a single system.

Retaining head and clamping nut (spare part)

Heavy duty retaining head

Overview retaining head	Part-No.
Düsenstock (Ersatzteil)	**54-5-2-12**
Isolierring Doppeldraht	**54-5-5-5**

Contact tip

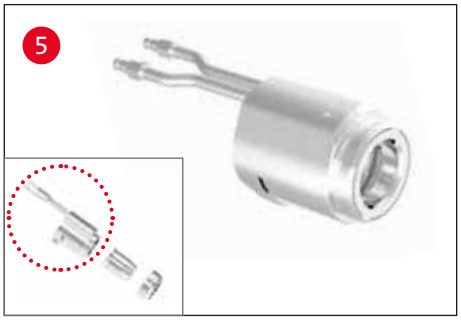
- Improved heat transfer extends lifetime
- Improved power transition: constant arc qualityng

Overview of contact tip	Part-No.
0.9 m	**54-5-8-0.9S**
1.0 m	**54-5-8-1.0S**
1.2 m	**54-5-8-1.2S**
1.4 m	**54-5-8-1.4S**
1.6 m	**54-5-8-1.6S**

Please note:

Lengths in inches available on request.

5

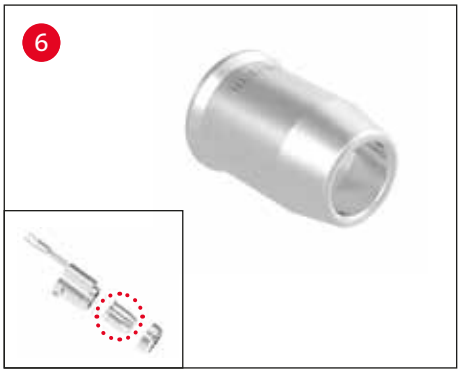


Cooling jacket for consumables

Extra cooling of consumables

Cooling jacket	Part-No.
Cooling jacket for nozzles	**54-5-70-1**

6

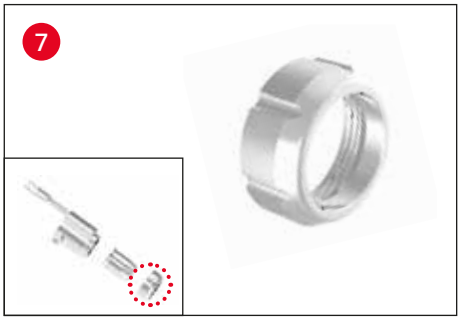


Standard gas nozzles

Overview gas nozzles	Part-No.
tapered, flush, ø 18 mm	**54-10-18-TF**
tapered, long, ø 18 mm	**54-10-18-TR**

Please note:
An overview with dimensions can be found on the last page.

7



Lock nut for gas nozzle

For fixation of the gas nozzle at the cooling jacket

Lock nut	Part-No.
Lock nut	**54-5-70-2**

Alternative

8

Heavy duty gas nozzle with direct cooling

When using the HD gas nozzle the parts 5, 6, 7 are not needed.

Heavy duty gas nozzle with direct cooling	Part-No.
tapered, long, ø 18 mm	**54-11-18-TR**
tapered, long, ø 20 mm	**54-11-20-TR**

Option

Gas diffuser Dual Wire 2.0

Gas diffuser	Part-No.
Ceramics gas diffuser	**54-5-20**

10b Torch necks: Checking fixtures

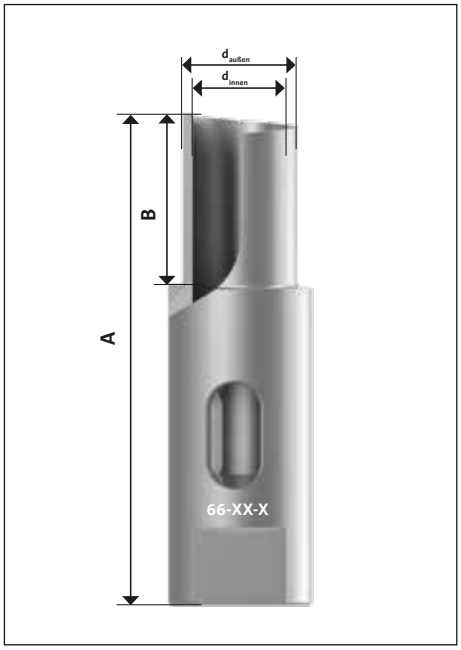
Checking fixture to check TCP of torch necks and the complete torch system.

Checking fixtures are available for all listed torch necks with Dual Wire 2.0 torch system. Please contact us for detailed information

Please note:

Further iInformation can be found in our brochure "Checking fixtures" (DOC-0137EN).

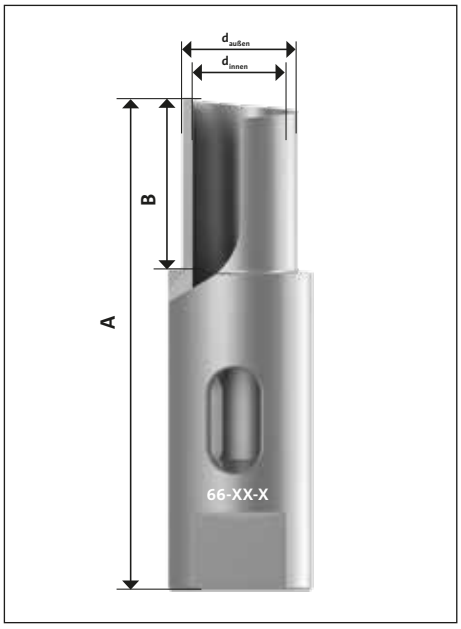
10b Torch necks: Reamer blades



Reamer blade (internal thread UNF 3/8“ x 24)

Overview of reamer blades	flush	long
Inner diameter of the gas nozzle	**Part-No.**	**Part-No.**
18 mm	**66-18-F**	**66-18-R**
20 mm	—	**66-20-R**

Dimension A	Dimension B	Dimension d_{outer}	Dimension d_{inner}	Part-No.
75	21	17,5	14,5	**66-18-F**
75	26	17,5	14,5	**66-18-R**
75	26	19,5	14,5	**66-20-R**



Reinigungsfräser (Innengewinde M10 x 1 – eReam)

Overview of reamer blades	flush	long
Inner diameter of the gas nozzle	**Part-No.**	**Part-No.**
18 mm	**67-18-F**	**67-18-R**
20 mm	—	**67-20-R**

Dimension A	Dimension B	Dimension d_{outer}	Dimension d_{inner}	Part-No.
79	21	17,5	14,5	**67-18-F**
84	26	17,5	14,5	**67-18-R**
84	26	19,5	14,5	**67-20-R**

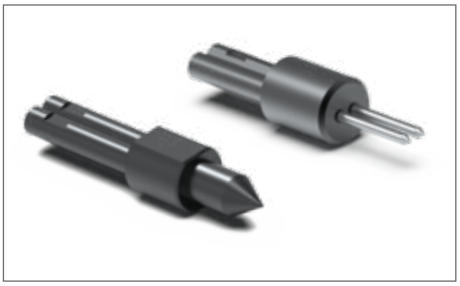
Please note:

Dimensions in mm.

10a Torch necks: Tools

Tool for lock nut (at cooling jacket)

Tool for lock nut	Part-No.
Tool for lock nut	**54-5-70-3**



Programming tips

Dual Wire programming tips for precise seam programming

Overview of programming tips	
Stickout	**Part-No.**
18 mm	**542053400**
20 mm	**542053500**
18mm (Dual Tip)	**65-25**
20mm (Dual Tip)	**65-26**

11 Water cooling

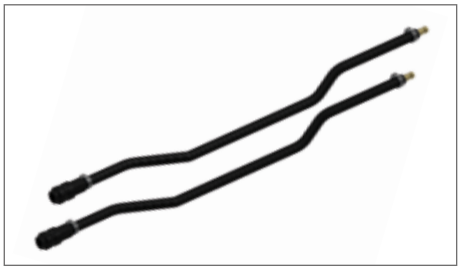
Water cooling

The SKS Dual Wire 2.0 torch system comes with two separate cooling circuits to increase the cooling efficiency. The first circuit cools down the consumables while the second cooling circuit cools down the torch neck. We achieve a better cooling effect with this separation. That because the reflected energy of the welded part can be dissipated easily. The heat at the gas nozzle is already reduced and doesn't reach the torch.
The cooling equipment consists of a water flow / return for the cooling jacket for cooling down the consumables, a water conduit for cooling inside the torch neck and a water cooler with two circuits. Additionally, the system has a water flow control for safemables.

Water cooler eChilly

The water cooler eChilly is active cooled and has two separated cooling circuits and provides best possible cooling efficiency next to the process. Up to two torch systems can be cooled independantly at the same time. Tank capacity 6.4 L.

Overview water cooler eChilly	Part-No.
Water cooler eChilly 1-special (active, two circuits)	**541018400**



Water conduit for Dual Wire 2.0 torch neck

The torch neck is cooled down from the inside. With this conduit the cooling unit of the torch neck is connected with the cooling circuit.

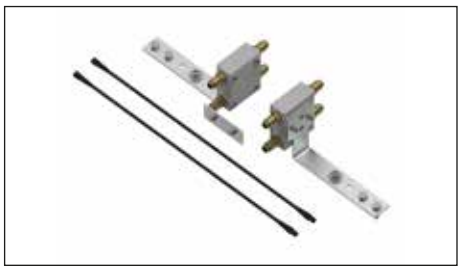
Water conduit for cooling unit of the torch neck	Part-No.
Water conduit for cooling unit of the torch neck	**93-11-10**

Water cooling conduit for cooling jacket

Conduit for cooling jacket to dissipate heat from the consumables.

Water cooling conduit for cooling jacket	Part-No.
Water cooling conduit for cooling jacket	**71-8-16**
Water lines (flow & return) torch to water module	**71-8-23**
Velcro® strip set (10 pcs. each 30 cm)	**571040320**

11 Water cooling



Water monitoring

For monitoring water flow

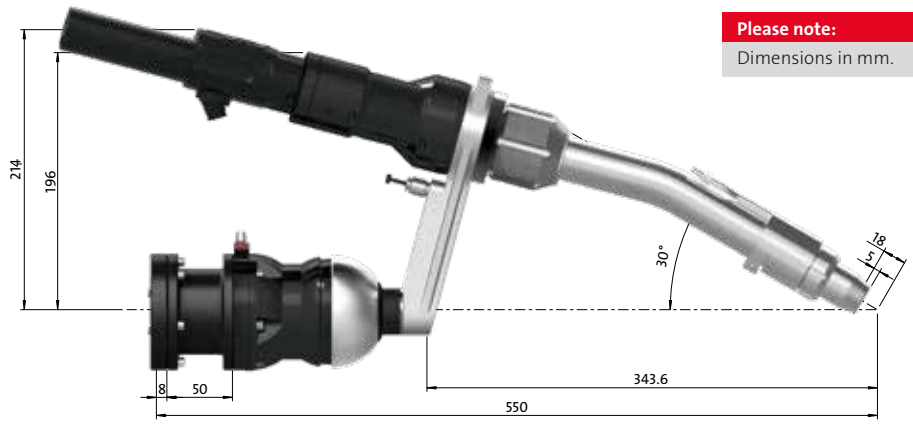
Water monitoring	Part-No.
Water monitoring	**93-11-0**

Water filter

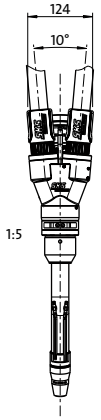
Cooling fluid may be contaminated with small particles, affecting the cooling efficiency. The water filter filters these particles out of the cooling fluid.

Overview water filter	Part-No.
Water filter with inset	**93-11-6**
Inset (replacement part)	**91-60-F1060691350**
Glysantin G40, 1,5l bottle, for mixing 1:2	**D-100-0159**
Water hardness test strip	**91-78-1**

11 Torch necks: TCP dimensions



Please note:
Dimensions in mm.



Torch 15° (complete system 30°) **Part-No. 54-5-3-15-550-1-1**

eReam 2.0 and pReam for a precise cleaning of the torch frontend

Further information can be found here:

Please note:
Further information can be found in our eReam 2.0 brochure (DOC-0205EN).

SKS

WELDING SYSTEMS

Contact:

sales@de.sks-welding.com

SKS Welding Systems GmbH

Marie-Curie-Str. 14 | 67661 Kaiserslautern | Germany | Phone +49 6301 7986-0

www.sks-welding.com

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