

TRACKLESS WELDING CARRIAGE - MAGNETIC MOGGY®



Magnetic base allows for out of position welding applications

Ideal for automatic horizontal fillet, lap or butt welding applications

Controls available for continuous or stitch welding operations

Dual gun holder assemblies make automated simultaneous welding efficient

The MOGGY® can be equipped with a variety of accessories including: weld oscillator, cutting torch attachment and internal radius guide wheels

GM-03-300 - STITCH WELDING

GM-03-350 - CONTINUOUS WELDING

GM-03-400 - DUAL TORCH MOGGY



*Automate Fillet, Lap, and Butt Welds with Precision*

VERSITILE TRACKLESS AUTOMATION CARRIAGE FOR A VARIETY OF APPLICATONS



# TRACKLESS AUTOMATION WELDING CARRIAGE



The Magnetic MOGGY® is intended to automate and improve the quality of welding and cutting operations by carrying the welding gun or cutting torch, at precisely controlled speeds, along the path of the joint as well as providing the interface between the welding and cutting motion and the arc start and stop signal. The Magnetic MOGGY® is normally guided by adjustable guide wheels which are used to keep a set distance from the joint path.

The carriage is flexible enough to allow it to be easily configured for horizontal lap, butt and fillet weld joints as well as a variety of cutting processes. The GM-03-350 model provides continuous mode welding and cutting and the GM-03-300 models also offer accurate distance stitch weld functionality, regardless of travel speed adjustment. Using the Magnetic MOGGY® automation carriage system will add accuracy and uniformity to welding and cutting operations while increasing productivity. Typical applications include shipbuilding, offshore construction, steel fabrication industries, etc.

## Continuous Welding MODEL GM-03-350

Magnetic MOGGY® Carriage with control for continuous travel, and with forward/stop/reverse switch, wire feed start on/ off switch, travel speed potentiometer, auto wire feed start with delay carriage start, travel speed displayed in LED window, wire feed connector with 15 ft. (4572mm) control cable.

## Stitch Welding MODEL GM- 03-300

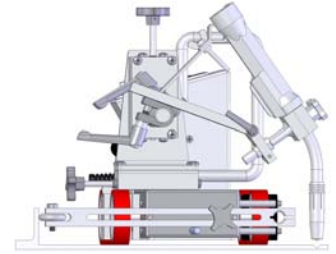
Magnetic MOGGY® Carriage with control for continuous or stitch welding, and with a control that uses a Gullco microprocessor to provide accurate repeatability regardless of travel speeds for weld distance on and weld distance off. It has a forward/stop/reverse switch, wire feed start on/off switch, travel speed potentiometer, auto wire feed start with delay carriage start, wire feed connector with 15 ft. (4572mm) control cable. All functions displayed in an LED window.

## FILLET JOINT WELDING



The MOGGY® performing a fillet weld using a template, guide or fence positioned parallel to the workpiece. The actual workpiece is often used as the guide.

## BUTT JOINT WELDING

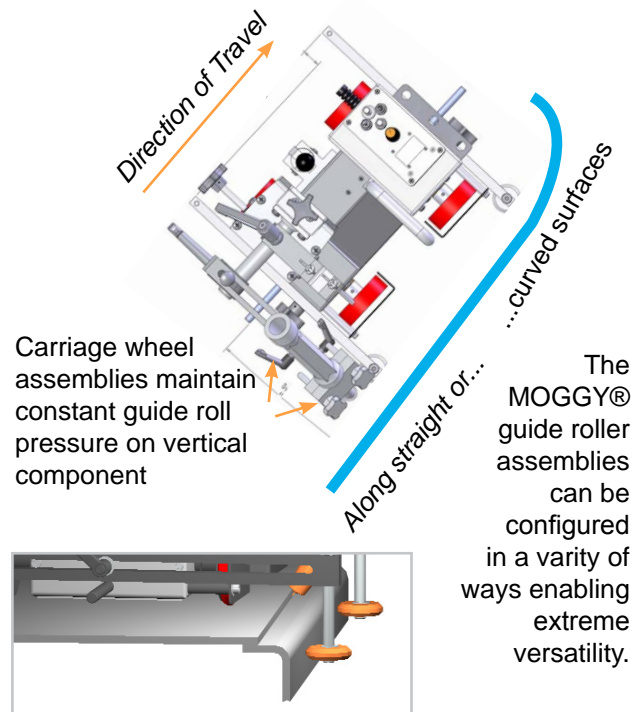


The MOGGY® is ideal for butt joint welding. Here the MOGGY® is using a fence to guide it accurately along the desired path. Standard v- groove track can also be used.

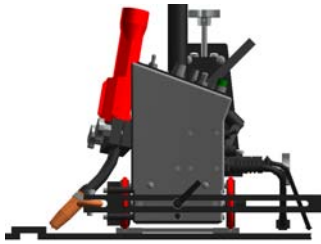


## Precise Torch Alignment To The Seam

Adjustable guide rolls mounted on the front or back of the carriage monitor the slightest seam variations following straight or curved surfaces...maintaining optimum torch positioning as the carriage travels.

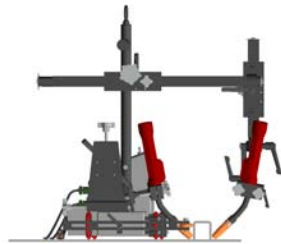


### LAP JOINT WELDING



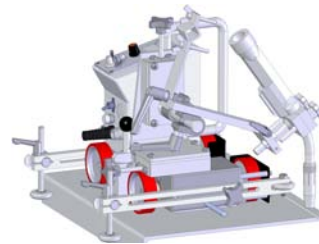
The MOGGY® is performing a lap joint weld. It is guided by Industry Standard 6" (152.4mm) v-groove track running parallel to the joint.

### DUAL GUN WELDING



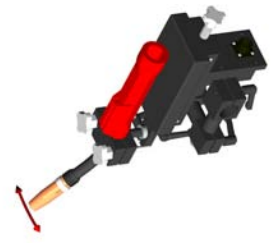
Dual gun holder assembly mounted on the MOGGY® enables positioning of two guns and simultaneous activation of two wire feed signals. MOGGY® is guided by the workpiece.

### JOINT TRACKING



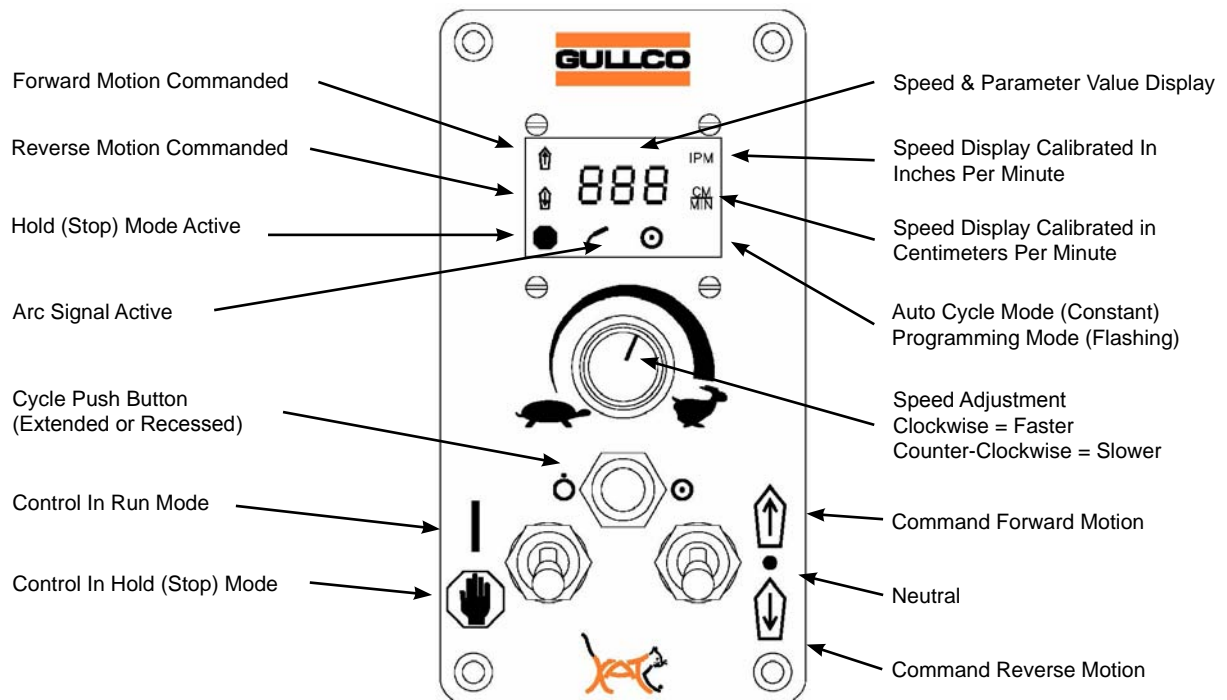
Adjustable height guide roller assemblies are available to track joints with a vertical member higher or lower than the set height of guide roller wheels.

### RADIAL OSCILLATOR



Replaces the standard gun holder assembly in order to weave the gun across the joint while the MOGGY® provides the weld travel motion.

## CARRIAGE CONTROL LAYOUT



#### Accessories available:

**GK-194-O-330** - Radial Oscillator complete with bracketry for mounting on Gullco MOGGY® Carriage.

**GM-03-059** - Adjustable Guide Roller Assembly enables joint tracking where the vertical member is lower/higher than set height of guide roller wheels.

**GM-01-065** - Cutting Torch Holder Assembly enables automated torch cutting operations.

**GM-01-070** - Dual Gun Holder Assembly enables the use of two independently positioned welding guns with two wire feed signals simultaneously activated.

#### Also available as a SUBMERGED ARC MOGGY®

For more information on the submerged arc welding carriage and other products visit.

[www.gullco.com](http://www.gullco.com)





## SPECIFICATIONS

**Speed Range:** 3 - 54 in/min (7.6 - 137 cm/min)

**Gun Positioning Slides:** 1-3/4" (44.5 mm)  
Vertical and Horizontal Stroke

**Weight of MOGGY®:** 31 lbs. (14.1 kg)  
complete with all attachments (single gun model)

**Supply Voltage:** Either 42, 115, or 230 VAC,  
single phase, 50/60 Hz., 30 watts

**Drive Motor:**  
24 VDC permanent magnet gear motor

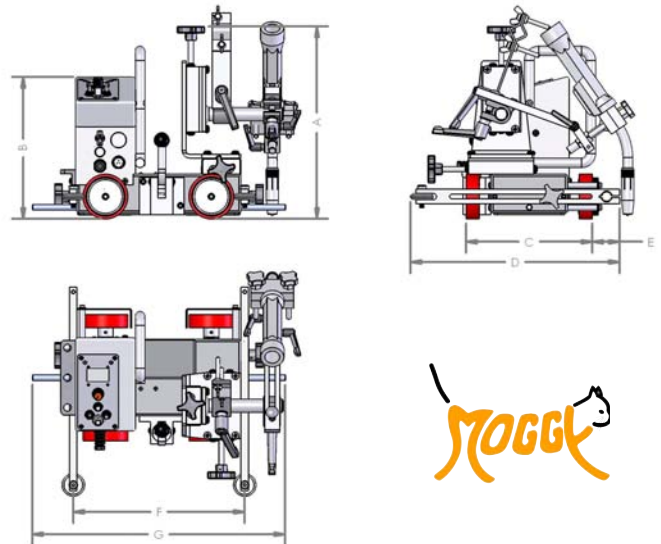
**Drive Wheel Temp Range:**  
-40°F to 180°F (-40°C to 82°C)

**Complies with:** C.S.A. & N.R.T.L.  
(file #LR35006-8) & C.E. Certification.



## CARRIAGE DIMENSIONS

	IMPERIAL	METRIC
<b>A</b>	12.90"	327.3 mm
<b>B</b>	9.50"	241.3 mm
<b>C</b>	8.45"	214.6 mm
<b>D</b>	14.01"	355.7 mm
<b>E</b>	Min 1.95" Max 5.46"	Min 4.93 mm Max 138.7 mm
<b>F</b>	11.50"	292.1 mm
<b>G</b>	17.00"	431.8 mm



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SPECIFICATIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE. ALL DIMENSIONS ARE NOMINAL

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