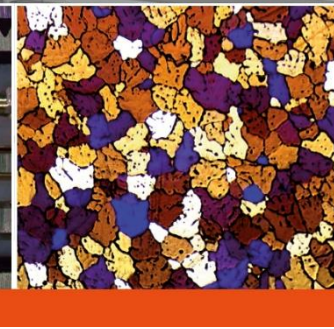
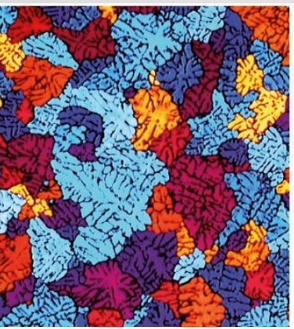


Application lab report

Cutting of a welded steel sample



QATM-Preparation method

Objective:

We have received one welded steel sample. The sample should be cut horizontally and vertically. All cuts were made with the Qcut 350 A and the Qtool 80 Vario. Detailed parameters and pictures can be found in the following report.



Figure 1: Overview sample with the Qtool 80 Vario.

QATM-Preparation method

Cutting

 Cutting			
Device	Cut-off disc	Anti-corrosion coolant	Clamping tool
Qcut 350 A	FS-D300A (95012533)	QATM – CoolCut (95004146)	Qtool 80 Vario - 100 mm (Z2231201) Clamping jaw, cross prism (02231230) Universal vice mono 132 (Z1350011)
Cutting method			
Cut 1 and 2: Vertical Cut (Y-axis) Rest of the cuts: Horizontal cut (X-axis)			
Parameters			
Feed speed	Pulse parameter	Cut-off disc rotational speed	
0,4 mm/s	Without Pulse	2700 RPM	
Notes			

QATM-Preparation method

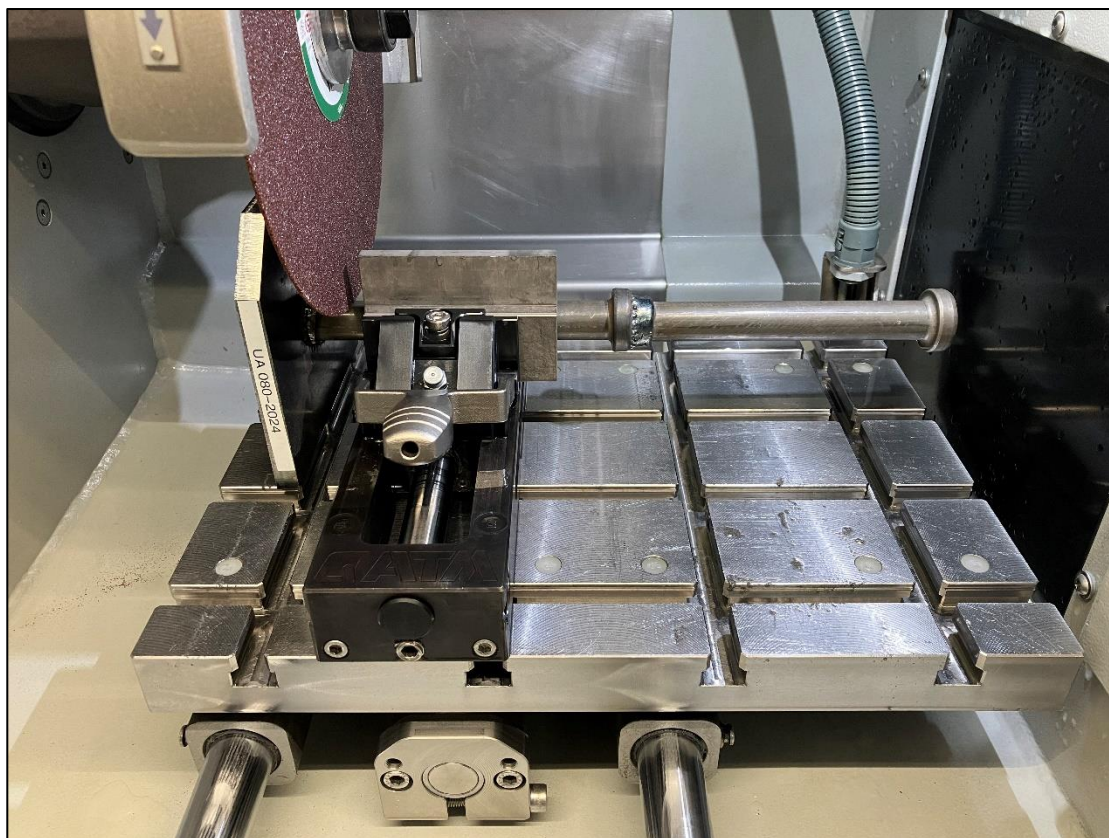


Figure 2: Samples before cut 1 and 2.

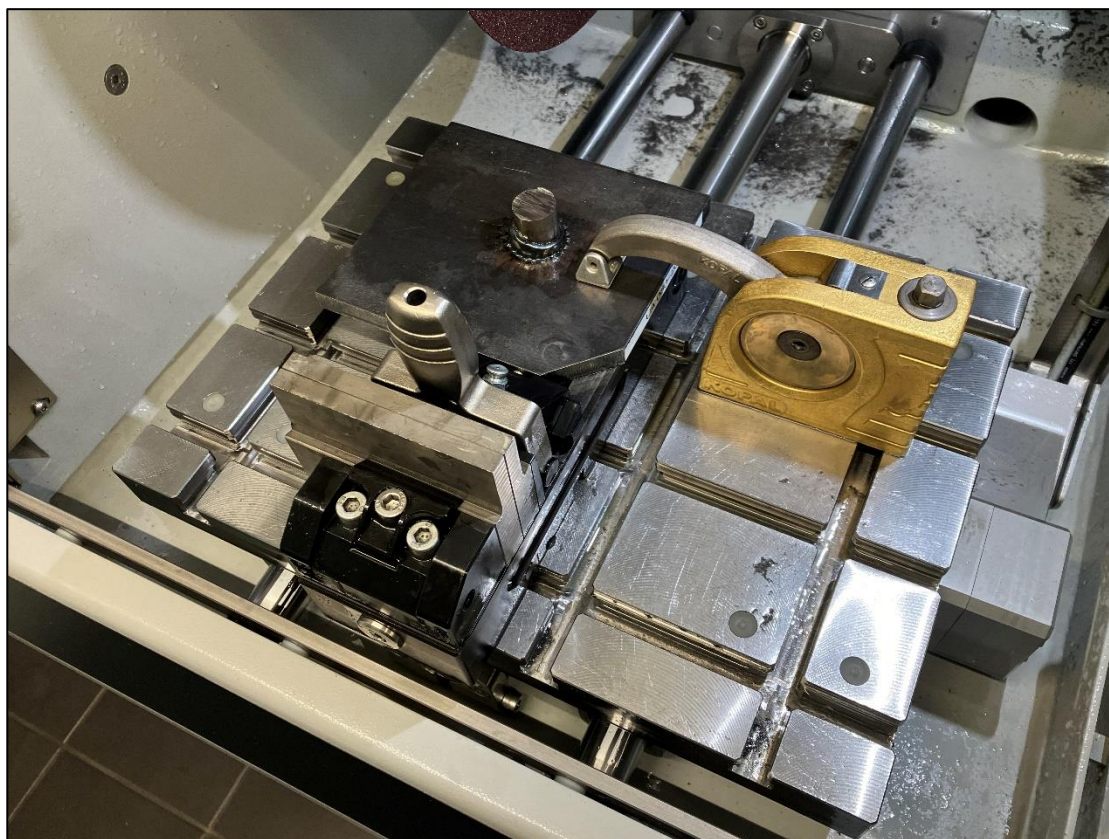


Figure 3: Clamping solution for weld seam 1 before cutting.

QATM-Preparation method

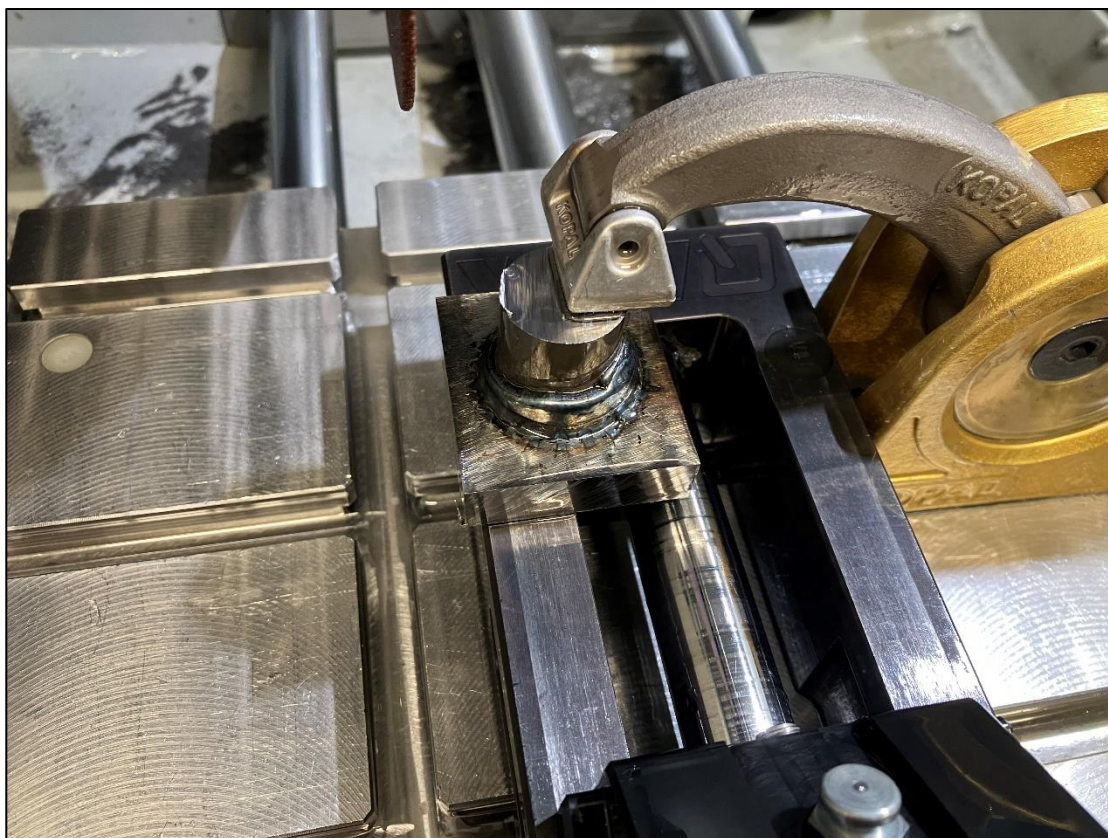


Figure 4: Clamping solution for weld seam 1 after the cutting process.

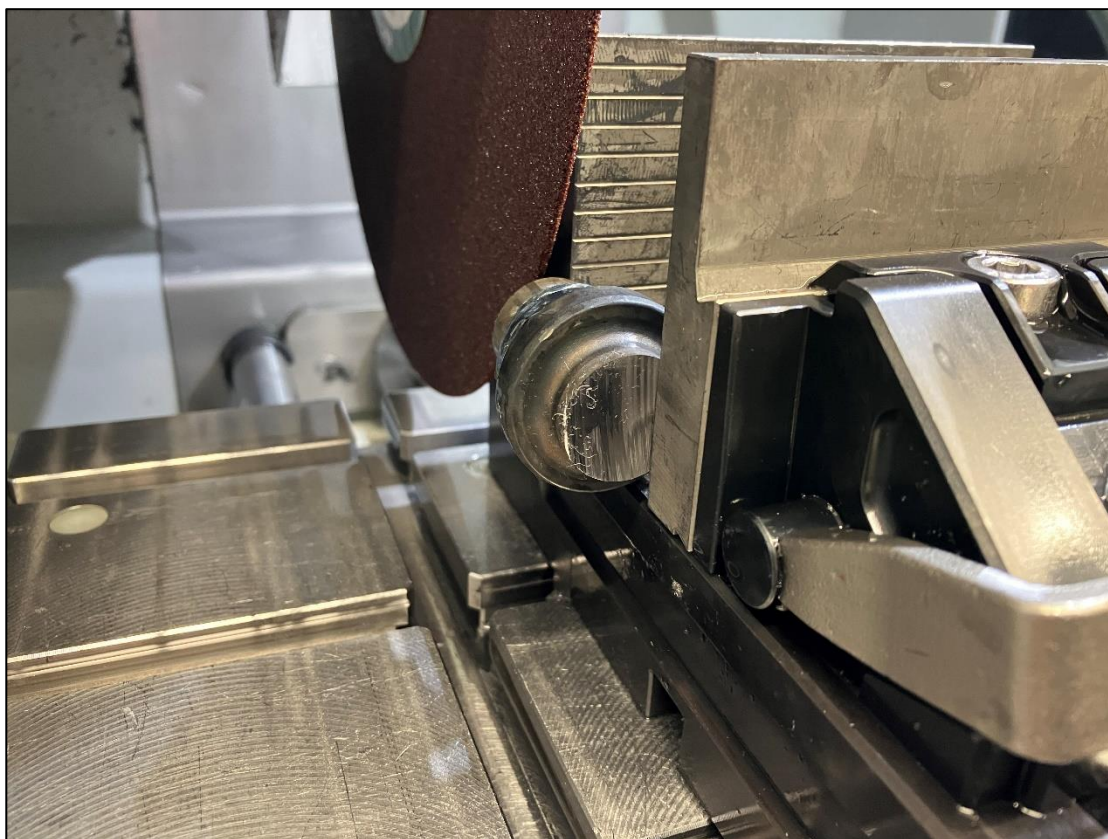


Figure 5: Longitudinal cut weld seam 2.

QATM-Preparation method

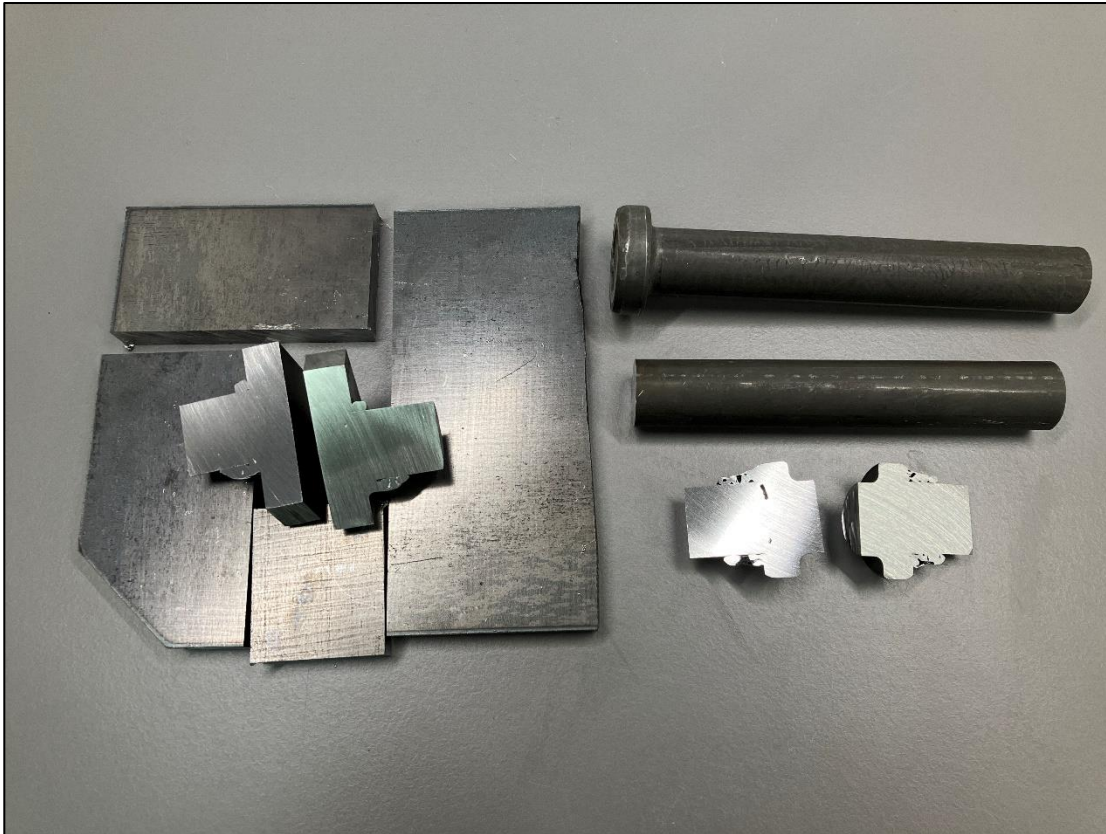


Figure 6: Sample after the cutting process.