Gas Blending Systems

655 Series Oxygen Blendmaster

The 655 Series BlendMaster is designed to supply argon-oxygen shielding gas mixtures on-site for mild and stainless steel Mig (GMAW) welding. The blender provides up to 850 SCFH over the range of 0-10% oxygen balance argon. Balance stem seat inlet regulators maintain mix accuracy by eliminating pressure fluctuation effects encountered while filling micro-bulk and bulk supply sources. This makes the 655 Series BlendMaster the right choice where blend tolerances are critical to the manufacturing process.

Advanced Features

- Lockable Enclosure
  Process control
- 0 - 10% Ratio Adjustability
  Process flexibility
- Wall or Bench Mountable
  Installation flexibility
- Integral Line Regulator
  Supports flowmeter and regulator plus flowmeter installations

Applications

<table>
<thead>
<tr>
<th>Stainless Steel</th>
<th>Mild Steel</th>
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</thead>
<tbody>
<tr>
<td>0-1% Oxygen</td>
<td>2-3% Oxygen</td>
</tr>
<tr>
<td>Stabilized spray transfer</td>
<td>Spray transfer with enhanced wetting action</td>
</tr>
<tr>
<td>1-2% Oxygen</td>
<td>3-5% Oxygen</td>
</tr>
<tr>
<td>Spray transfer with enhanced wetting action</td>
<td>High travel speeds with fluid weld puddle</td>
</tr>
</tbody>
</table>

Materials

- **Case**
  Powder coated steel
  Not designed for use outdoors
- **Surge Tank**
  Seven gallon (26.5 Liters)
- **Pressure Control Mechanism**
  Brass barstock
  Gas piloted

Specifications

- **Flow Capacity**
  850 SCFH (24.1 M³/H)
- **Inlet Supply Pressure Requirements**
  100 - 125 PSIG (7 - 8.6 BAR)
- **Mixed Gas Outlet Pressure**
  10 - 45 PSIG (.7 - 3.1 BAR)
- **Power Requirements**
  110 or 220 VAC (50 - 60 Hz)
- **Ambient Atmosphere and Gas Supply Temperature**
  32°F to 100°F (0°C to 38°C)
- **Accuracy**
  ± 0.5%
- **Weight**
  102 lbs. (kg)
Available Mounting Information for the 655 Series Blendmaster

Ordering Information

<table>
<thead>
<tr>
<th>Series</th>
<th>A Primary Scale Major Gas</th>
<th>B Primary Scale Minor Gas</th>
<th>C Monitoring</th>
<th>D Assembly</th>
</tr>
</thead>
<tbody>
<tr>
<td>655</td>
<td>1: Argon</td>
<td>1: Oxygen</td>
<td>0: No Alarm</td>
<td>1: 110V, Floor Mount</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td>7: Low Pressure Alarm Capability*</td>
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<td>2: 110V, Wall Mount</td>
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<td>5: 220V, Floor Mount</td>
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<td>6: 220V, Wall Mount</td>
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</tbody>
</table>

* Alarm sold separately

Related Options

<table>
<thead>
<tr>
<th>Option</th>
<th>Order Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Advantium 2 Remote Alarm</td>
<td>529-5106</td>
<td>Provides audible and visual notification of a depleted supply bank to a remote location. (See page 46 for full list of options)</td>
</tr>
</tbody>
</table>