

DWP

14th, December 1961

Reference PFT/SG P 284

ACTION COPY SENT TO ENGINE SUPT

COPY SENT TO SUPPLY SUPT.

Mngr.....	Eng. Supt.....	
Sec.....	A/F. Mngr.....	
Asst. Sec.....	Ch. Eng. A/D.....	
	Pers. Supt.....	
Ch. Acct.	27 DEC 1961	Supply Sales
Stores.....		
Ansd.....	Init.....	

MISSION AUSTRALIENNE
S.N.E.C.M.A.
70, bld Kellermann

PARIS 13e

COMMONWEALTH AIRCRAFT CORPORATION PTY. LTD.
BOX 779 H P.O.
Elizabeth Street

MELBOURNE
Australia

France	
CIRCULATION / COPIES / 15	
E.F. MNGR	FCT. ADM. SUPT.
DSGN. ENGR	MC. SHOP. SUPT.
DEV. ENGR ✓	PRODUCN. SUPT.
SERV. ENGR	ASSM. LY. SUPT.
QUAL. ENGR	FOUNDRY SUPT.
PRD. ENGR	METCAL. SUPT.
MATL. ENGR	PROCESS SUPT.
CH. TL. DSGR	TOOL. PROD. SUPT.
CH. INSP. E.F.	TOOL. ROOM. SUPT.
A/F MANAGER	SUPT. INSPECTION
MR HENRY ✓	

Subject : Argon Arc Hand Torches.

Dear Sir,

Enclosed herewith is a quotation for the Argon Arc welding torches required to be purchased for use with the RIOU Argon Arc generators.

The present practice at C.A.C. is to strike the arc by hand and quickly position the arc, however due to the higher standard of welding required on the engine, the practice at S.N.E.C.M.A. is to position the torch, start the arc by means of a micro switch fitted on the welding torch and proceed to weld. The high frequency starting current cuts off at the set time, and at the end of the weld, the decay cycle operates.

This practice applies to machine welding, hand welding and tack welding, therefore at least two torches are required for welding the heavy gauges and 2 sub miniature torches required for the light gauges of material.

The machine argon arc torches shown on the quotation will be supplied with the circumferential and longitudinal positioners, therefore they are not required unless they are purchased as spares, which no doubt should be considered.

On receiving the quotation we noted that the quoted price seemed rather high and decided to investigate what was available from Soudure Autogène Française, one of the largest welding companies in France.

Mr. P.F. THOMPSON and Mr. SIMPSON visited the company which appeared to be similar to C.I.G. of Australia and examined the complete range of Automatic and hand welding equipment, set up in working condition in the demonstration room.

Handwritten signature

The design of the equipment indicated that S.A.F. are associated with the American welding equipment group which is also connected with British Industrial Gases in a similar manner to the C.I.G. group in Australia. Liquid Air of Australia is a subsidiary of Soudure Autogène Française, therefore, in future we will have technical information in Australia on equipment which is supplied by Soudure Autogène Française (SAF) to SNECMA.

The design of the Automatic equipment built by SAF is suitable for the general class of work required by industry and although fully automatic, lacks the rigid mountings, freedom from backlash on the driving equipment and a fixture capable of holding light gauge material. The variation in arc length is controlled automatically and this feature will allow for slight contours of the metal sheet, however seam tracking with the SCIAXY transducer principle is not available.

It was apparent that SNECMA have a problem similar to CAC to obtain semi-automatic welding equipment at a reasonable price and have little option but to purchase longitudinal argon arc equipment from the same source as the proposed new C.A.C. equipment.

The approximative price of the SAF longitudinal welder on view in the demonstration room although it had a very small fixture was approximatively £ 6,000, therefore it is considered that the estimate obtained from "COMEPRE" for equipment built to SNECMA requirements could be considered quite reasonable.

It is recommended that we consider purchasing Australian hand argon arc torches and fit a push button miniature micro switch on the handle and take a standard twin P.V.C. covered lead back to the terminal point on the generator. This switch operates a 24 volt relay which in turn operates the main contactors on the power supply, therefore there are no insulation problems and the switch may be fitted to the handle by "PK" screws.

It may be that CIG or EMF have a similar argon arc torch available or would consider supplying the torches fitted with an inbuilt switch. This type of torch would be available from Liquid Air Company, however it is rather cumbersome and unsuitable for all applications of welding.

We are still awaiting the proposal for the longitudinal welder and have been informed that SNECMA has studied the design and requested minor changes, therefore we expect to receive a proposal in the next few days.

One enclosure.

Yours faithfully,



G.H. FOSTER

PFT/SG

E^{TS} RIOU

MATÉRIEL DE SOUDAGE
ÉLECTRIQUE



TRANSFOS - REDRESSEURS
- INSTALLATIONS SPÉCIALES -
ACCESSOIRES

R. C. SEINE N° 56 A 6.986

CONSTRUCTEUR

37

ENT. 40-71

ENT. ~~10221X~~ 47.56

~~13~~ RUE DE CHARENTON
ALFORTVILLE
(SEINE)

ALFORTVILLE, LE 27 NOVEMBRE 1961

MISSION AUSTRALIENNE
S.N.E.C.M.A.
93 BOULEVARD HAUSSMANN
PARIS.

N.REF.AR.TO.4.29I

Messieurs,

Comme suite à votre demande,

Nous vous prions de trouver ci-dessous notre meilleur proposition pour la fourniture des accessoires suivants:

2 TORCHES TYPE MACHINE COMPLETES 500A	
<u>prix unitaire</u>	2.040NF
2 TORCHES 250A à refroidissements par eau	
cable ali 6m	
<u>prix unitaire</u>	950NF
2 TORCHES 75A à refroidissement par air	
<u>prix unitaire</u>	600NF

DELAI- 15 jours apres réception de commande pour les 2 derniers
 postes
 1 mois environ pour le 1er poste.

les prix remis ci-dessus sont établis-T.V.A.incluse pour 20%
sans emballage- départ usine.

REGLEMENT- à convenir.

Restant à votre disposition pour tous renseignements
complémentaires,

Veuillez agréer, Messieurs, l'expression de nos
sentiments dévoués.

A.RIOU-