

The Minidryer-350

supplies the welder with dry electrodes at the work site. The dryer may be used with electrodes of both 350 and 450 mm length. With the cover in an open position, the electrodes will protrude approximately 40 mm outside and are easily accessible.

Minidryer-350 is equipped with a thermostat for continuous selection of the temperature from 100 °C to 350 °C (212 °F to 662 °F). The dryer is very robust in design and insulated with 40 mm mineral wool. It can also stand permanently in a tilted position. When the dryer is in a tilted position, the cover cannot stand open, but always closes to prevent the intrusion of unwanted moist air. When the dryer is tilted a rim around the opening prevents rainwater from entering.

The dryer is supplied for AC mains voltage 230 V 50/60 Hz.

Caution:

Use gloves when handling warm electrodes from inside the Minidryer-350. No chemical products are to be used in the dryer. This product should be used for drying electrodes only.



Type	Mains Voltage V	Heater Output W	Primary Current A	Operating Temperature °C	Width x Depth x Height		Electrode Capacity kg	Net Weight kg
					Inner Dimensions mm	Outer Dimensions mm		
Mini-dryer-350	230, 50/60 Hz	400	1.8	100 to 350	Ø100 x 460	170 x 170 x 570	8	7

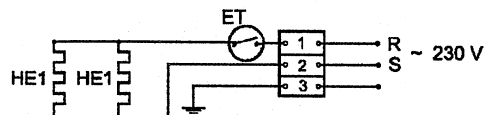
Ordering Information:

Minidryer-350, Product number: 094-637827.

Spare Parts:

H Heating element. Product number: 094-637835. The heating element is rated 200W. There are two of this elements inside the Minidryer-350 (400W). This heating element can also be used for the old Unitor Minidryer.

T Thermostat w/reg. knob for Minidryer-350. Product number: 094-637843.



Re-drying of Electrodes

Customers are recommended to re-dry low hydrogen electrodes before use whenever there are application requirements relating to weld metal hydrogen content and / or radiographic soundness. This information is given on the box label for the individual electrodes. Failure to follow these recommendations may produce pores and weld failure.

Unitor Minidryer-350 (094-637827) 100–350 °C (212–662 °F) can be used for this purpose.

Recommended re-drying temperatures, holding time two hours, for Unitor electrodes:

GPO-302 N	Normally no need for re-drying	
GPR-300 H	Normally no need for re-drying	
SPECIAL- 303 N	300 °C	(572 °F)
LH- 314 N	350 °C	(662 °F)
LHH-314 H	350 °C	(662 °F)
LHV-316 N	350 °C	(662 °F)
LHT-318 N	350 °C	(662 °F)
LHL-319 N	350 °C	(662 °F)
LHR-320 N	350 °C	(662 °F)
TENSILE-328 N	250 °C	(482 °F)
IMPACT-329 S	250 °C	(482 °F) 1 hour
WEARMAX-327	250 °C	(482 °F) 1 hour.
18/8-321 N	350 °C	(662 °F)
23/14-322 N	350 °C	(662 °F)
DUPLEX-325 N	350 °C	(662 °F)
NIFE-334 N	200 °C	(392 °F)
NICKEL-333 N	80 °C	(176 °F)
TINBRO-341	200 °C	(392 °F) 1 hour
ALBRONZE-344	250 °C	(482 °F) 1 hour
ALUMIN-351 N	In vacuum packing and therefore no need for re-drying.	
CH-2-382	120°C	(248 °F) 1 hour
ACA-384	180°C	(356 °F) 10 hours*

* The copper coating will oxidize during the process, but this will not influence the performance of the product

Re-drying time is measured from the point at which the re-drying temperature has been reached. After re-drying, the electrodes can be returned to a heating cabinet and kept at a minimum temperature of 70 °C (158 °F).

Unitor Heating Cabinet-85 (094-637850) 85 °C (185 °F) can be used for this purpose.

Mild steel rutile and rutile / organic electrodes such as GPO-302 N normally need no re-drying

Re-drying covered electrodes more than three times is not recommended.