

# Guild International

## A world supplier of superior coil joining equipment

Guild International offers a complete line of coil end welding machines for almost any steel processing and tube producing application. Our patented product line includes Zipwelders™, resistance welders, semi-automatic shearwelders, and strip accumulators including the Supercoil® and Superloop™. Guild International also produces a full line of uncoilers, speed funnels, and flatteners. Plus, our team of engineers will help you determine your needs and ensure proper equipment design and compatibility with your existing equipment. With Guild's coil processing machinery, you can improve your processing line's productivity and stay competitive in today's business world.

Since 1958, Guild International, Inc. has maintained the status of a world leader in the designing and manufacturing of coil joining and strip accumulating machinery. We continue to meet the rigorous engineering and design expectations that our clients have come to value. Guild's equipment continues to increase productivity and yield on thousands of installations around the world on virtually all types of coil processing lines and materials.

Resistance welders are used on clean strip without scale and usually on a thickness range from 0.2–3.0 mm thick. These resistance welders make a weld on overlapped coil ends. The more expensive welders have a shear and they accurately position the sheared ends, with a very small overlap, to the weld and planish wheels. The resultant weld is just slightly over parent metal

thickness. The lower cost resistance welders produce an overlapped weld joint of about 16 mm, and the copper weld wheel travels over the strip creating heat and thereby joining the two coil ends together, with a double parent metal thickness at the weld area.

The MIG, Plasma, Sub Arc, and Laser weld is used for the thicker strips where there may be scale. The MIG Overlap weld can be used for overlap welding on strip from 0.3–1.0 mm thicknesses and MIG Butt welding can be used for strip from 1.0–16 mm thicknesses. The welders used on the coil build-up lines (CBL) typically include MIG and or Plasma welding and strip notchers. Sometimes milling machines are supplied to mill the top and or bottom of the MIG weld flat so, as the weld is recoiled, it does not mark the subsequent wraps on the recoiler. Typical coil build-up lines are for strip 1.5–10 mm thick. Sometimes a carbon steel leader strip is welded to the ends of the coil to reduce scrap during the rolling process on a Z mill. The welders supplied on Hotrolled Annealing Pickle Lines (HAPL) are for strip ranging from 0.3–16 mm thick, but this range is not for one line. Some of the HAPLs are for strip from 0.3–6.0 mm thick. A thin gauge MIG welder with an automatic overlap feature for strip from 0.3–1.0 mm is provided for these lines. This way, the thin strip can be welded with a very small controlled overlap and the thicker strips, 1.0–6.0 mm are butt welded.

For the standard HAPL, for strip from 2–16 mm, a MIG butt weld is used. The



coil ends are sheared and MIG Butt welded, typically with a small welding gap between the two strip edges. The welders supplied on the White Rolling Annealing and Pickling Lines (WRAPL), make welds that pass through the rolling mill without any top or bottom milling of the weld. Reductions in thickness up to 50% are achieved with this type of line. Grinding or Grind and Polish Lines (GL) typically cover a range of strip thicknesses from 0.2–7.0 mm thick. For these lines, an overlap resistance welder is typically used. For strips up to 1.6 mm thick, a continuous seam weld is used and for strip above this thickness, a rolling spot weld is used. The weld is twice the parent metal thickness, so the grinding heads in the line are opened as the weld is pulled through the line.

For coil end welders for all applications, put Guild International to work on your strip processing lines today.



### Company details:

Name: Guild International  
Address: G7273 Division Street,  
Bedford, OH  
Postcode: 44146  
Country: United States of America  
Phone: +1 440 232 5887  
Fax: +1 440 232 5878  
Email: sales@guildint.com  
Website: www.guildint.com