

IDEALARC DC-400



shown with multiprocess switch option



The Idealarc DC-400 is Lincoln's premium multi-process welder.

Universally considered to have the best welding arc characteristics in the market. A SCR controlled DC power source which provides both constant voltage and constant current output. It operates in three modes: CV Wire/Innershield, CV Submerged Arc and CC Stick/TIG and a great choice for arc gouging. Flexibility doesn't mean complicated – the DC-400 is easy to set-up and use. Changeover between processes is as simple as turning a switch with the factory or field fitted multi-process switch.

Applications include: field construction, shipbuilding, cross country pipelines, offshore oil platforms, heavy engineering, mining maintenance and general fabrication.

The DC-400 is especially suited for critical welding applications. Built-in arc force control also adds to the operator appeal of these units. By simply adjusting the Arc Force Control, you can either create a soft welding arc for

critical applications or a forceful crisp arc for cellulose, low hydrogen and carbon arc gouging.

Built to last – all weather protection features a totally enclosed control circuit compartment, designed to IP-23 requirements. Submerged dipping of all transformer base assemblies in a special epoxy based sealing/insulating enamel provides added protection against moisture or corrosive atmosphere such as salt air.

ADVANTAGE LINCOLN

- Large, conveniently located switch makes it easy to change between CC (Stick/TIG/arc gouging), CV (MIG/flux-cored) and CV (Submerged Arc) modes.
- Arc force control adjusts short circuit current for a soft arc or a forceful driving arc in the CC (Stick/TIG) mode.
- Arc control adjustment changes pinch effect of the arc to control spatter, fluidity and bead shape in the MIG/Flux-cored mode.
- Capable of stick and DC TIG welding and air carbon arc gouging with up to 8mm diameter carbon rods.
- Solid state circuitry provides extra long life for repetitive welding applications.
- Outstanding welding performance with a single range full output control potentiometer.
- Factory fitted analog amp/voltmeters.
- $\pm 10\%$ input line voltage compensation for maintaining weld consistency.
- Low profile case allows stacking machines up to three high to conserve floor space. (Stacking not recommended when using undercarriage).
- Fan cooled for long life expectancy. Electronic and thermostatic protection safeguard DC-400 from current overload and excessive temperatures.
- Windings and rectifiers protected against moisture and corrosive environments.
- 14 pin MS-style cable connection for remote control and wire feeder connections.
- Circuit breaker protected on-board power for a wirefeeder: 42V and 115V available from the 14-pin connector receptacle.
- 115V AC power on/off switch with pilot light provides added user safety.
- Three year warranty on parts and labour.
- Manufactured under a quality system certified to ISO 9001 requirements.

Idealarc DC-400

Recommended Options



Multi-Process Switch

3-position switch allows quick and easy change from electrode positive or negative semiautomatic/automatic welding to stick or air carbon arc gouging.

Order K804-1



Foot Amptrol

Varies current for making critical TIG welds. Depress pedal to increase current. Depressing pedal fully achieves maximum set current. Fully raising the pedal finishes the weld and starts the afterflow cycle.

Includes 7.6m control cable.

Order K870



Hand Amptrol

Varies current for making critical TIG welds. Fastens to the torch for convenient thumb control. Comes with a 7.6m cable. Fully extend the slide forward to achieve maximum current. Returning to the start position finishes the weld and starts the afterflow cycle.

Order K963-1 (for smaller handle 9, 17 or 20 series torches).

Order K963-2 (for larger handle 26 or 18 series torches)



Remote Output Control

Consists of a control box with choice of two cable lengths. Permits remote adjustment of output. 6 pin connection.

Order

K857-8.5-6 8.5 lead & 6 pin plug

K857-20-6 20m lead & 6 pin lead

K857-20-14 20m lead & 14 pin plug

K857-30-14 30m lead & 14 pin plug



Water Valve

For use with TIG Module. Shuts off water flow when the arc is extinguished when using Magnum water-cooled TIG torches.

Order K844-1



TIG Module

Supplies high frequency for superior starting, contactor control, remote control capability and a gas valve for TIG welding.

Order K930-2

Undercarriage

Platform undercarriage with mountings for two gas cylinders at rear of welder.

Order K841

VRD

Voltage reduction device, operates in the CC mode reducing the OCV, increasing the operator safety when welding is performed in environments with increased hazards of electric shock.

TECHNICAL SPECIFICATIONS

Part Number	Input Voltage	Rated Output Current/Voltage/Duty Cycle	Rated Input AS1966.1	Output Range	Dimensions H x W x D (mm)	Weight (kg)
KA1369-1	220/380/440/3/50/60	500A/40V/50%	73/42/37A	60-500A	698 x 566 x 840	215
KA1369-3	415/3/50/60	450A.38V/60%	39A			
		400A/36V/100%				

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice and assumes no responsibility, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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