



Shown with
multiprocess switch
option



THE HEAVY DUTY INDUSTRIAL MULTIPROCESS SOLUTION

The DC-400 is a multiprocess DC arc welding power source that produces outstanding arc characteristics on both constant voltage and constant current processes. This provides great welding versatility in a single power source.

The DC-400 is designed for MIG/MAG, flux cored and Innershield. The machine can also be used as a Stick or TIG welder. It produces outstanding welding performance with a single range full output control potentiometer.

Flexibility does not 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 installed multi-process switch. On-board ammeter and voltmeter

make monitoring of key welding parameters a snap. Inductance and arc force controls allow the operator to efficiently refine the arc for the job at hand.

The basic unit is enclosed in a rigid case on a frame dimensioned for stacking up to three high, with the side panels removable for service of the main parts. These are cooled by a fan, taking air through front panel louvers.

The assembled transformer, reactor, rectifier and base unit is coated in a special epoxy based sealing/insulating material resistant to moisture and corrosive atmospheres. The control circuit compartment is completely enclosed but easy to access from the front panel.

ADVANTAGES

- ✓ 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 5/16" (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.
- ✓ Analog ammeter/voltmeter are standard.
- ✓ $\pm 10\%$ 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.)
- ✓ Three year warranty on parts and labor.

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Technical Details

Found on the recessed front panel are all the controls, switches, the voltmeter and ammeter, the output control and connection points for field options.

The output of the machine is electronically controlled by SCR's (thyristor), providing extra long life for highly repetitive welding

applications.

The complete unit can be lifted with the lug on top. The frame has four holes for bolting on the optional undercarriage.



TECHNICAL SPECIFICATIONS

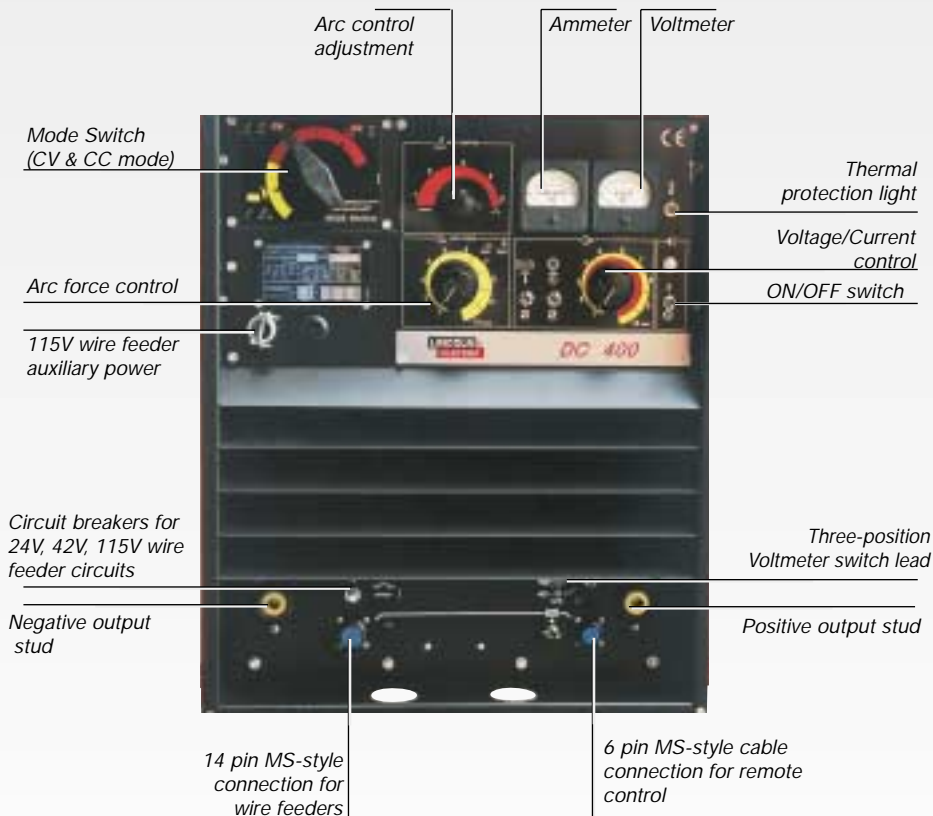
Product Name	Item Number	Standard Voltage	Input Power	Weight	Dimensions H x W x L	Protection Class	Compliance
DC400	K1309-17	230/400V 3ph	30,2 KVA	227	700x561x813	IP23	EN 60974-1 / IEC974-1

WELDING OUTPUT

Current Range	Rated Output	O.C.V.
60 - 500A	400A/ 36V /100%	54Vdc
12 - 42 V	450A/38V/60%	

ACCESSORIES

Item Number	Description
K804-1E	Multiprocess switch
K10095-1-15M	Remote output control - 15m
K10398	15m-extension cable for remote control box
K841	4-wheel in-plant undercarriage (2 cylinders)
K10081	4-wheel in-plant undercarriage
K10019	3-wheel in-plant undercarriage
K10103	Air arc torch, model K3000 (600A max.)
K799-1-O	High frequencykit (TIG welding)



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