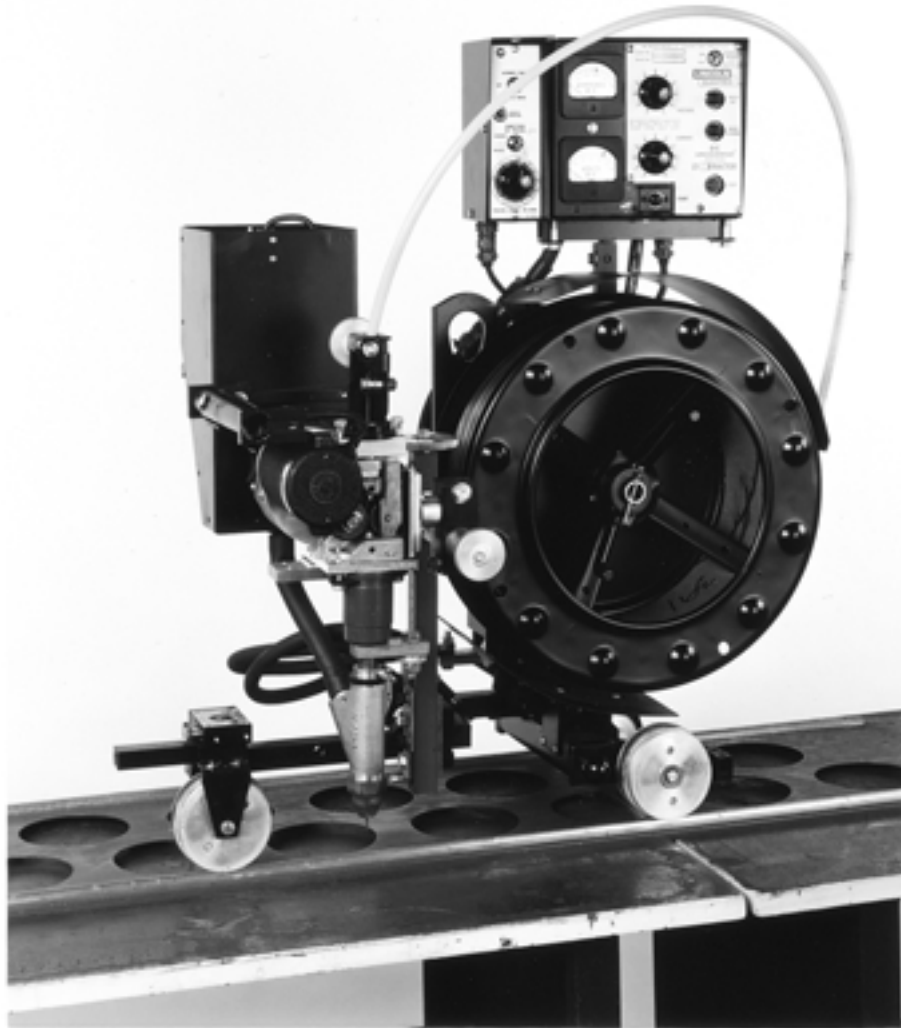
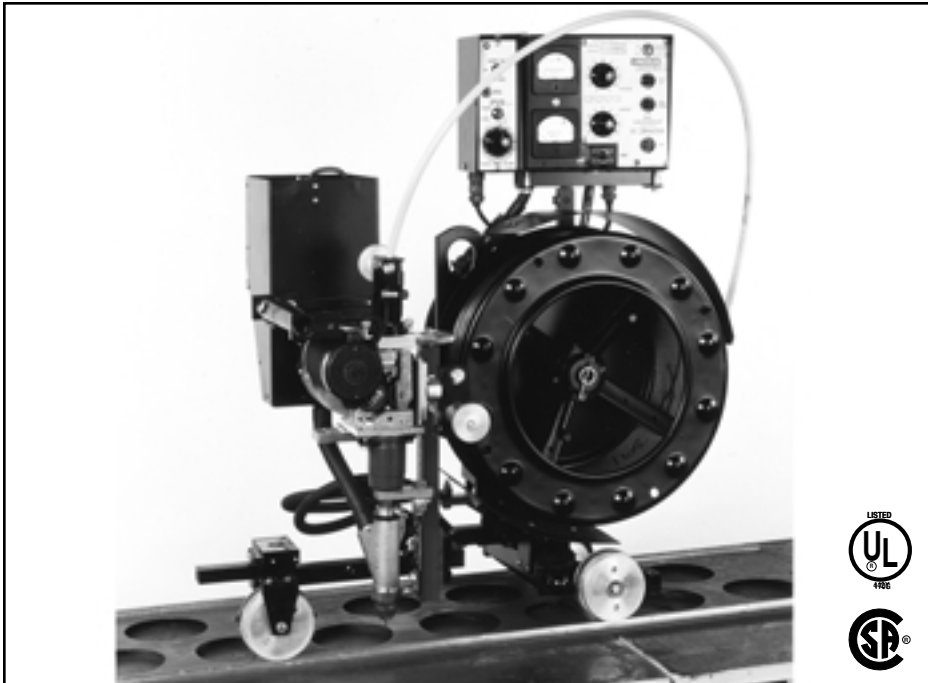


LT-7 TRACTOR



Self-Propelled Mechanized Submerged Arc DC Wire Feeder

LT-7 TRACTOR



LT-7 Tractor shown here with K400 Track Conversion Kit and K396 Track Section.

The LT-7 Tractor is a self-propelled mechanized wire feeder, designed for the submerged arc process with track system capabilities. It is self-guiding and easy to operate — only one operator is usually required. It is designed to be used with a variety of Lincoln DC constant voltage and constant current power sources; DC-600, DC-655, DC-1000 and DC-1500.

The rugged, lightweight unit permits quick movement to the next joint. Its compact size fits through small openings and confined spaces. Butt, fillet and through welds can be made on heavy plate or steel as light as 12 gauge (2.5mm). The LT-7 Tractor is ideal for the following applications:

- Ship and Barge Building
- Storage Tank Erection
- Bridge Deck Installation
- Beam, Girder or Column Fabrication
- Long Seams on Heavy Weldments

ADVANTAGE LINCOLN

- Solid-state control system precisely regulates procedures for reliable starting and economical welding.
- Automatic compensation for input voltage and tractor loading variations.
- Control box is conveniently located on the tractor (can be mounted either left or right), eliminating the need to return to the power source for routine procedure changes.
- Close mechanical alignment between wire and joint maximizes weld quality with no fixturing costs.
- Exceptional tracking control and self-steering in most applications leave the operator free for quality control, joint cleaning and flux handling.

- Welds butt, horizontal fillet and lap joints to the left or right side of the tractor frame for convenience.
- Quick, easy installation of optional guides for different joints.
- Rugged wire feeder is built for worry-free, hardworking operation.
- Function lights built into the solid-state printed circuit boards minimize down time.
- 3 year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9002 requirements.

FEATURES

- Flux hopper capacity of 15 lbs. (6.8 kg). Includes a manual flux flow rate control valve and can be mounted at four locations to the left or right.
- Head feeds 3/32 to 3/16" (2.4 to 4.8mm) electrode diameters.
- Vertical head lift adjuster for adjusting electrical stickout from 1/2" to 5".
- Cross seam adjuster speeds setup and lets operator track irregular joints while welding.
- Reel for 60 lb. (27.2 kg) coils.
- Travel clutch operates from either side of the tractor.
- Calibrated tractor drive adjusts continuously from 6 to 70 in./min. (0.15 to 1.8 m/min.)
- Weld angle is up to 50° from vertical on either side.
- Drag angle is up to 30° from vertical.
- Cross Seam Adjustment: 3-1/8" (7.9mm) with clamp and 2-1/2" (63mm) with handwheel.
- Continuous Vertical Adjustment: 1-1/2" (38mm) handwheel variation for electrical stickout setting.

ADAPTER KITS AND GUIDE KITS

Horizontal Fillet and Lap Adapter Kit

(Figure 1) Includes a rear guide wheel, head tension spring and front guide wheel assembly on an adjustable arm which rides in the joint to maintain alignment and electrode angle. Kit includes separate front guide wheel assemblies for fillet and lap joints. Welds to the left (Figure 2) or right (Figure 3) of the tractor center line. **Order K232.**

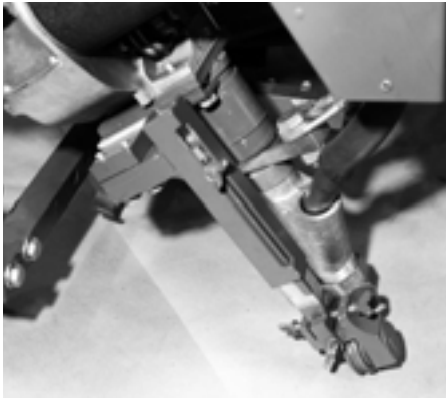


Figure 1

Horizontal fillet/lap adapter kit setup for lap guide.

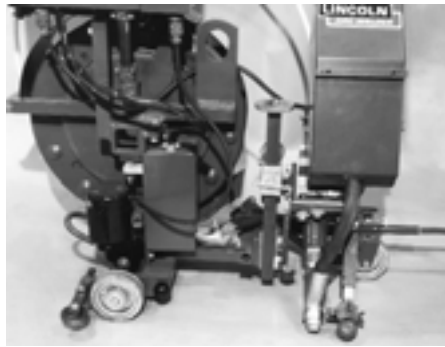


Figure 2
Horizontal Fillet Guide (Left Side)

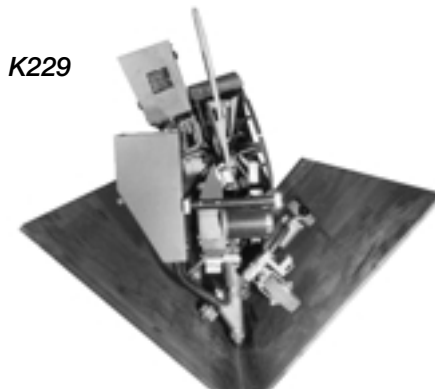


Figure 3
Horizontal Fillet Guide (Right Side)

Flat Fillet Adapter Kit

Includes front and rear guide wheels for operating the tractor in 30° or 45° flat fillet joints.

Order K229

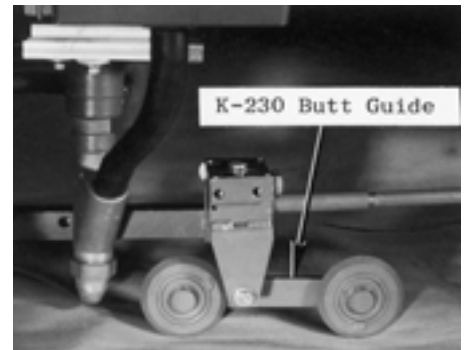


K229

Butt Seam Guide Kit

Mount in place of the standard front wheel to ride in a V-groove or open 1/8 to 3/8" (3.2 to 9.5 mm) butt joint keeping the wire in required alignment.

Order K230.



Track Section

Each provides 70" (2 meters) of travel.

Order K396.

Track Conversion Kit

Converts the standard K227-1 model for track guidance.

Order K400.



K396

TECHNICAL SPECIFICATIONS

Product Name	Model	Ordering Information	Wire Speed Range IPM (m/min)	Wire Size Range Solid	Input	Net Weight	Dimensions H x W x D in. (mm)
				Inches (mm)			
LT-7	Standard	K227-1	6 to 70 (0.15 to 1.8)	3/32 - 3/16" (2.4 - 4.8)	115 VAC 50/60 Hz	120 lb (54 kg)	27.5 x 33 x 14 (698 x 840 x 360)
LT-7 (1)	Track	K395-1				130 lb (59 kg)	

(1) For use with K396 Track Sections.

RECOMMENDED OPTIONS

Flux Screen

For submerged arc welding. Removes large particles from reused flux. Includes air-driven vibrator.

Order K310



K310

Magnetic Flux Screen Separator

For submerged arc welding. Removes foreign magnetic particles from reused flux. Order K58.

Input Cable Assembly

For power sources with terminal strip wire feeder connections and stud output terminals. Specify Length.

Order K228-25, -50, -75, -100, -FT.

Contact Nozzle Assembly

Specify electrode diameter.

Order K231-3/32, -1/8, -5/32, -3/16.

Positive Contact Nozzle Assembly

Specify electrode diameter.

Order K148A for 3/32 – 1/8"

Order K148B for 3/32 and 3/16"

Linc-Fill™ Attachments

Extension for K148. Specify electrode diameter.

Order K149-3/32, -1/8, -5/32

Concentric Flux Cone Assembly

For use with K148B nozzle. Gives concentric flux coverage around the electrode.

Order K285.

Tiny Twinarc Adapter Kit

Converts basic tractor to Tiny Twinarc unit using 5/64" (2.0mm) diameter electrode.

Order K277-1 - Twinarc Butt Seams

Order K277-2 - Twinarc Flat Fillets

These kits may also be used for horizontal fillets with the addition of the K232 Adapter Kit.

SYSTEM SELECTION

Power Source (Choose One)

DC-600

DC-655

DC-1000

DC-1500

LT-7 Tractor (Choose One)

K227-1 (Standard Model)

K395-1 (Track Model)

Input Cable (Choose Length)

K228-25, K228-50,

K228-75, K225-100

Nozzle Assembly (Choose Diameter)

K231-3/32, K231-1/8,

K231-5/32, K231-3/16

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 liability, 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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