Subarc AC/DC 1250

April 2013 • Index No. AD/7.2

Submerged Arc Welding Power Source

Quick Specs

Heavy Industrial Applications
Railcar
Shipbuilding
Heavy Fabrication
Pipe Manufacturing
Pressure Vessel

Process
Submerged Arc (SAW)
Electroslag (ESW)
Air Carbon Arc Cutting and Gouging (CAC-A)

Input Power:	380-400 VAC, 3-phase
Rated Output:	1000 A at 44 VDC 100% Duty Cycle
Weld Output Range:	250 – 1250 A in CC modus 25-44V in CV modus
Weight:	540 kg

The Power of Blue.®

Easier setup and operation. The improved user interface of the Subarc AC/DC makes setting up and operating the power source relatively simple. The operator is presented only with the necessary functions to set process and control output.

AC balance is set using a rotary switch mounted on the front control panel. There is no need for a laptop PC connection to do complex wave shaping before operating. In multiple arc configurations, the power source interface control does the phase shifting for you.

Easily change the amount of electrode positive and electrode negative polarity from the front control panel of the power source.

Greater control of deposition, penetration, and heat input. Miller SAW solutions are designed to deposit large amounts of filler material and achieve deep penetra - tion on thick or large surface area weldments.



Enhanced distortion control. The AC output of the Subarc AC/DC enhances user control of heat input into the weldment, minimizing dis- tortion, and reducing structural or fit-up problems during or after final assembly.

Multi-arc capable. AC welding output enables the Subarc AC/DC to be used in tandem arc welding systems with a DC lead arc and AC trailing arc, or with AC / AC arc combinations. Using multiple arcs further increases deposition rate, resulting in shorter welding cycles for very thick weldments without compromising quality.

AC or DC operation provides versatility and outstanding arc performance.

Part of a customized system. Miller power sources and system components enable users to implement a customized SAW solution that best fits their operations when combined with the travel and manipulation equipment they prefer.

TRUE BLUE® 3YR. WARRANTY

Power source is warranted for 3 years, parts and labor.

MADE IN USA
APPLETON, WI

Miller

Distribuito da:
TECNOWELD di ROBERTO GAMBERINI
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Specifications

IP- Rating	Rated output	A/V Range	Max. Opencircuit Voltage	Dimensions	Weight
IP 21S	1000A 100% Duty Cycle	25 – 44 V 250 – 1250 A	71 V	H: 1118 mm W: 692 mm D: 1168 mm	540 kg

Ordering Information

Power Source	Stock No.	Description
Subarc AC/DC 1250	**907 456**	400 V, 50/60Hz
Accessories		
HDC 1500 A	**300 439**	Analog controller
HDC 1500 DX	**300 438**	Digital controller
RAD - 100	**300 474**	Heavy-duty, right-angle drive motor for automated strip clad applications
RAD - 400	**195 265**	Standard-speed, right-angle drive assembly for 1/8 in or larger wires
RAD - 780	**195 266**	High-speed, right-angle drive assembly for 1/8 in or larger wires
OBT 600	**043 923**	600 amp, 100% duty cycle, air-cooled
OBT 1200	**043 900**	1200 amp, 100% duty cycle, air-cooled
Fluxhopper	**194 775**	25 lb capacity
Parallel Control Box	**194 711**	Must be used when paralleling two units
Wire Straightener	**199 733**	For RAD-400 and RAD-780
Spool Support Assembly	**119 438**	Support for 27 kg reels
Wire Reel	**108 008**	For 27 kg coil
Cable Kit for HDC 1500 Controllers	**195 308**	Includes 9 m 14-pin interconnect cable and 3 m motor cable

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