

Idealarc® DC400

Processes

Stick, TIG, MIG, Flux-Cored,
Gouging

Product Number

K1308-12 230/460V w/meters and MPS
K1308-25 230/460/575V w/meters
and GFCI
K1309-17 230/400V CE w/meters
K1309-20 220/380/440V w/meters

See back for complete specs

Input Power (Voltage/Phase/Hertz)

K1308-12: 230/460V/3/60
K1308-25: 230/460/575V/3/60
K1309-17: 230/400V/3/50/60
K1309-20: 220/380/440V/3/50/60

Input Current at Rated Output (100% Duty Cycle)

220V: 81A
230V: 78A
380V: 47A
400V: 45A
440V: 40A
460V: 39A
575V: 31A

Rated Output

400A/36V/100%
450A/38V/60%

Output Range

60-500A / 12-42V

Weight/Dimensions (H x W x D)

473 lbs. (215 kg)
27.5 x 22.3 x 33.1 in.
(698 x 566 x 840 mm)

Industrial DC Multi-Process Welders

Rugged construction, simple controls and a 100% duty cycle output rating make these machines a sound investment for heavy duty shop applications. Add the outstanding traditional SCR rectifier arc action delivering high quality, attractive welds and your operators will agree – it's hard to go wrong with an Idealarc® DC400.

FEATURES

- ▶ **Full range output voltage control** for easy operation and precise control.
- ▶ **Standard analog ammeter and voltmeter.**
- ▶ **Mode switch** for selecting desired output characteristics.
- ▶ **115V, 15 amps, duplex auxiliary power receptacle** makes it easy to power lights, grinders and other shop tools at your work station (K1308-25 only).
- ▶ **Flat-top case** with a small footprint can be placed under a workbench or stacked up to 3 high on top of each other.
- ▶ **Windings and rectifiers** are protected against moisture and corrosive environments.
- ▶ **Seven-year warranty** on power rectifier.



Shown: K1308-25

APPLICATIONS

- ▶ **Metal Fabrication**
- ▶ **Maintenance and Repair**
- ▶ **Autobody/Farm**
- ▶ **Light Industrial**

INPUT



OUTPUT



UL/CSA Approval on 60 Hz models.



Two Year Extended
Warranty Available in
the U.S.A. and Canada.



KEY CONTROLS

1. Mode Switch
2. Arc Control Switch
3. Arc Force Control
4. Output Terminals On or Remote
5. Machine Output Local or Remote
6. 115 Volt Power Switch
7. Output Control
8. Power Source Pilot Light
9. Voltmeter Polarity Switch
10. Ammeter/Voltmeter
11. Circuit Breakers
12. Thermal Protection Light

Shown: K1308-12



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Multi-Process Switch

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

Order K804-1



Undercarriage

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

Order K841



Work Lead Package

15 ft. (4.5 m) 4/0 cable with 1/2 in. stud lug and work clamp.

Order K2149-1



Welding Fume Extractors

Lincoln Electric offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.

Request Publication MC08-70



Remote Output Control

Provides 25 ft. or 100 ft. (7.6 m or 30 m) of remote output control (6-pin plug connection). Requires K864 Control Cable Adapter.

Order K857 25 ft. (7.6 m)

Order K857-1 100 ft. (30 m)



Remote Control Adapter

Y connection adapter for connecting K857 Remote Output Control (6-pin plug connection) and wire feeder input cable (14-pin plug connection) to power source 14-pin receptacle.

Order K864



Control Cable Extension

Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. Available in 45 ft. (13.7 m) sections.

Order K937-45



Docking Kit

Allows you to "dock" the TIG Module on top of a flat-roofed power source, or any other flat surface measuring at least 10 x 15 in. (254 x 381 mm). Includes a latch and provisions for a user-supplied padlock to lock the TIG Module in place.

Order K939-1



Foot Amptrol™

Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).

Order K870



Amptrol™ Adapter Kit

Adapts Amptrol's 6-pin MS-type plug connection to terminal strip on power source.

Order K843



Deluxe Adjustable Gas Regulator and Hose Kit

Accommodates CO₂, Argon or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.

Order K586-1

STICK OPTIONS



Accessory Kit

For stick welding. Includes 35 ft. (10.7 m) 2/0 electrode cable with lug, 30 ft. (9.1 m) 2/0 work cable with lugs, headshield, filter plate, cover plate, work clamp and electrode holder. 400 amp capacity.

Order K704



TIG OPTIONS

TIG Module

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

Order K930-2



Control Cable

Connects TIG Module to power source.

Order K936-1 for 9-pin to 14-pin



Adapter Cable

Male 14-pin control cable to terminal strip of power source.

Order K1798

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC400 w/Meters and Multi-Process Switch	K1308-12	230/460/3/60	400A/36V/100%	78/39A	60-500A	27.5 x 22.3 x 33.1	473
Idealarc® DC400 w/Meters and GFCI	K1308-25	230/460/575/3/60	450A/38V/60%	78/39/31A	12-42V	(698 x 566 x 840)	(215)
Idealarc® DC400 CE w/Meters	K1309-17	230/400/3/50/60	500A/40V/50%	77/45A			
Idealarc® DC400 w/Meters	K1309-20	220/380/440/3/50/60		81/47/41A			

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

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 information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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THE WELDING EXPERTS®