



FLEET 400
FLEET 500

ENGINE-DRIVEN WELDER/GENERATOR





FLEET 400 K3427-2



FLEET 500 K4338-2

Simple and Rugged

Stick, TIG and Pipe/Gouging Modes

Built for operation in remote locations, the FLEET™ 400 and 500 are simple, rugged diesel engine-driven welders for stick welding, TIG, and arc gouging. The design features time-tested Chopper Technology,® and the popular Kubota® and Perkins® industrial diesel engines. This means high reliability in jungles, deserts and other extreme environments.



Easy to Set

A Weld Mode selector gives the operator the choice of Pipe, Stick, Gouge, or TIG modes. The output can be easily adjusted with the output control knob providing dedicated ranges for each mode. The Arc Force control allows the operator to adjust for a soft, buttery arc or a more forceful, digging arc.

Dependable

Lincoln's proven Chopper Technology delivers easy arc starting, smooth arc action, low spatter levels and excellent bead appearance.

Plenty of Auxiliary Power

The Fleet 400 and Fleet 500 provide 5,025 watts of continuous single-phase power through a combination of a 240V Euro style receptacle and a 120V Euro style receptacle.

Reliable

The Fleet product line is designed for the harshest and most extreme environments. The Desert Duty™ rating displayed on every welder indicates optimal performance in temperatures up to 55 degrees Celsius

Product Numbers

K3427-2 FLEET 400

K4338-2 FLEET 500

Processes »

Stick, TIG, Gouging

Applications »

Maintenance and Repair,
Construction, Pipeline

Rated Output -

Current/Voltage/Duty Cycle

FLEET 400

At 40°C 400A/23V/100%

FLEET 500

At 40°C 500A/30V/40%

Output »



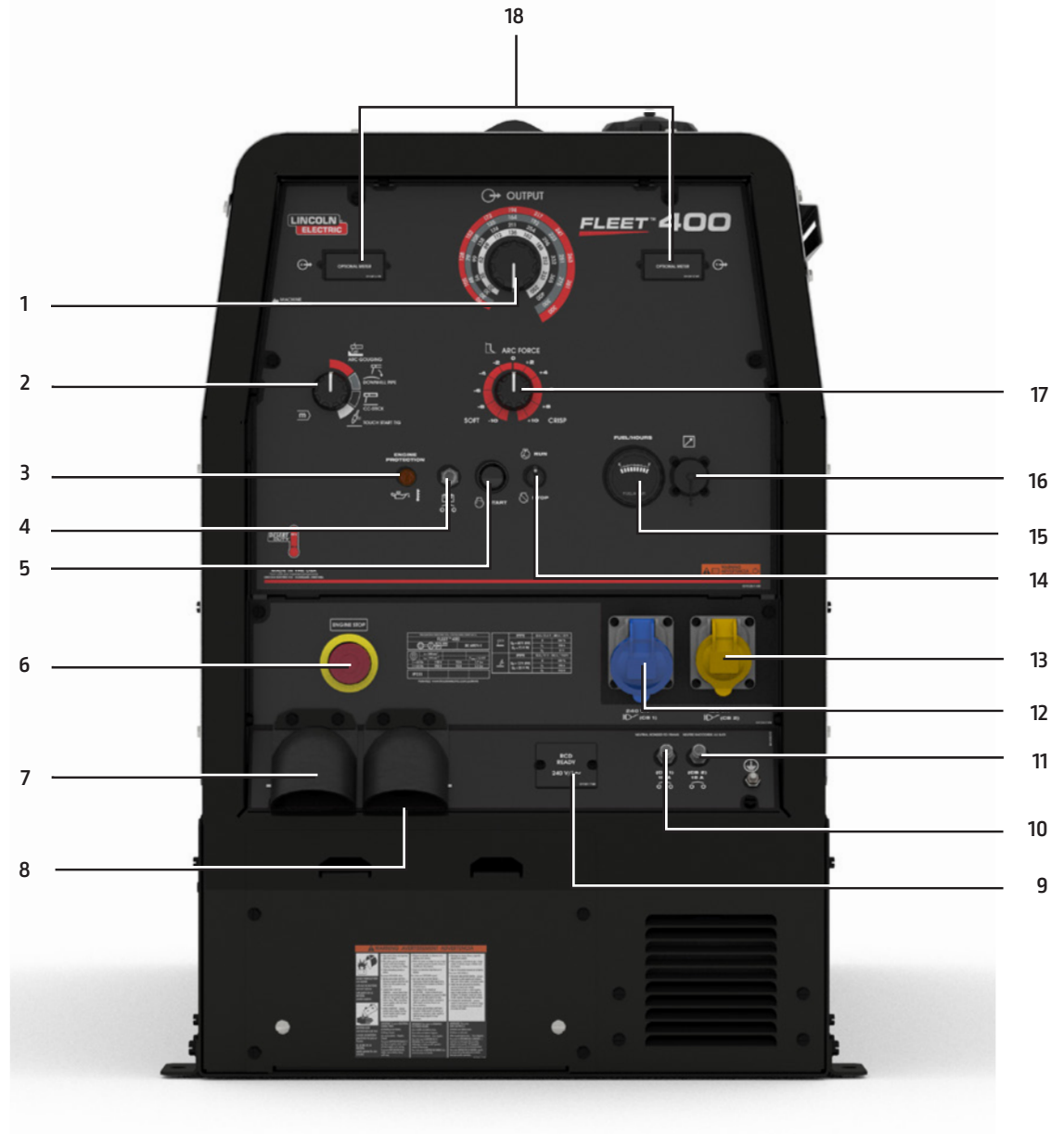
Input »



FLEET 400 / FLEET 500

Controls »

1. OUTPUT CONTROL
2. MODE SELECT
3. ENGINE PROTECTION LIGHT
4. BREAKER FOR 12V BATTERY CIRCUIT
5. START PUSH BUTTON
6. ENGINE STOP BUTTON
7. POSITIVE TERMINAL
8. NEGATIVE TERMINAL
9. RCD READY PORT COVER
10. 240V AC CIRCUIT BREAKER
11. 120V AC CIRCUIT BREAKER
12. 240V AC EURO PLUG
13. 120V AC EURO PLUG
14. RUN / STOP SWITCH
15. FUEL / HOUR GAUGE
16. 6-PIN REMOTE OUTPUT CONTROL CONNECTION
17. ARC FORCE CONTROL
18. DIGITAL METERS (OPTIONAL)





MACHINE SPECIFICATIONS

Product Name	Product Number	Description	Rated DC	DC Current	Auxiliary Power	Dimensions HxWxD in (mm)	Net Weight lb (kg)
FLEET 400	K3427-2	400A DC Engineered DC Generator	AT 40°C 400A/23V/100%	Stick Mode 20-410A Pipe Mode 40-300A TIG Mode 20-250A Gouge Mode 90-300A	60Hz / 240V / 15A 60Hz / 120V / 15A (5025 Watts Total)	35.9 x 25.3 x 60.0 [913 x 643 x 1524] To top of exhaust tube 43.8 [1063.6]	1056 (479)
FLEET 500	K4338-2	500A DC Engineered DC Generator	At 40°C 500A/30V/40%	Stick Mode 30-500A Pipe Mode 30-300A TIG Mode 20-250A Gouge Mode 90-450A		35.9 x 25.3 x 60.0 [913 x 642 x 1524] To top of exhaust tube 46.2 [1174]	1230 (559)

ENGINE SPECIFICATIONS

Product Name	Engine Model	Description	Horsepower & Displacement	Capacities	Operation Load	Fuel Consumption
FLEET 400	Kubota® V1505	4 Cylinder Naturally Aspirated Water Cooled Diesel Engine With Dry Cartridge Air Filter	21.7 HP @ 1800 RPM 91.41 cu in. [1.5L]	FUEL: 20gal. (75.7L) OIL: 6.4 qts (6.0L) RADIATOR COOLANT: 7.2 qts (6.8L)	High Idle - No Load	0.40 gals/hr - 1.52 L/hr
					Rated Output	1.17 gals/hr - 4.41 L/hr
FLEET 500	Perkins® 404D-22 EPA Tier 4i	4 Cylinder, 4 Cycle Water-Cooled Diesel Engine, 12V Electric Start, Dry Type Air Cleaner, Fuel filter with Water Separator, Mechanical Governor	32.7 HP @ 1800 RPM 136 cu. in. [2.2L]	FUEL: 20gal. (76.0L) OIL: 8.45 qts (8.0L) RADIATOR COOLANT: 8.0 qts (7.6L)	High Idle - No Load	0.42 gals/hr - 1.57 L/hr
					Rated Output	1.18 gals/hr - 4.46 L/hr



Additional Accessories	Product Number	FLEET 400 K3427-2	FLEET 500 K4338-2
GENERAL			
Medium Two-Wheeled Welder Trailer with Duo-Hitch® – For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13 in. (330 mm.) wheels. Overall width 60 in. (1524 mm.) Stiff .120 in. (3.0 mm.) welded rectangular steel tube frame construction is phosphate-etched and powder coat painted for superior rust and corrosion resistance. Features a Duo-Hitch 2 in. (51 mm.) Ball/Lunette Eye combination hitch.	K2636-1	•	•
Fender & Light Kit – Allows use of trailer at night and as required by local regulations. Includes fenders, lights with guards, mounting brackets, wiring and hardware.	K2639-1	•	•
Cable Storage Rack – For storage of approximately 100 ft. (30.5 m.) of 2/0 (70 mm ²) welding cable per side.	K2640-1	•	•
Four-Wheeled Steerable Yard Trailer – Includes a Duo-Hitch™ and a 2" Ball and Lunette combination hitch.	K2641-2	•	•
Spark Arrestor Kit – Mounts to muffler exhaust tube. Virtually eliminates spark emissions.	K1898-1	•	
	K903-1		•
Cold Weather Kit – Includes 120V AC engine block heater and radiator grill tarp.	K2679-1		•
Digital Weld Meters Kit – Digital display of amps for volts.	K2467-1	•	•
Service Kit – Includes air filter, fuel filter, oil filter, and fuel water separator.	K3599-1	•	
	K3598-1		•
STICK			
Remote Output Control (25 ft) – Includes control box, cable and 6-pin MS-Type connector.	K857	•	•
Remote Output Control (100 ft) – Includes control box, cable and 6-pin MS-Type connector.	K857-1	•	•
TIG			
Pro-Torch™ PTA-26V TIG Torch – Air-cooled 200 amp torch (2 piece) equipped with valve for gas flow control. 25 ft. (7.6 m) length.	K1783-9	•	•
Parts Kit for PTA-26V – Includes collets, collet bodies, a back cap, alumina nozzles, and a variety of tungstens.	KP509	•	•
Foot Amptrol – Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6 pin plug connection).	K870	•	•
Hand Amptrol – Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6 pin plug connection). Velcro straps secure torch.	K963-3	•	•

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications 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, or to provide engineering advice in relation to a specific situation. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

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