

Operator's Manual

IDEALARC[®] DC-1000



For use with machines having Code Numbers:

12480



Register your machine:

www.lincolnelectric.com/register

Authorized Service and Distributor Locator:

www.lincolnelectric.com/locator

Save for future reference

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

Need Help? Call 1.888.935.3877

to talk to a Service Representative

Hours of Operation:

8:00 AM to 6:00 PM (ET) Mon. thru Fri.

After hours?

Use "Ask the Experts" at lincolnelectric.com
A Lincoln Service Representative will contact you
no later than the following business day.

For Service outside the USA:

Email: globalservice@lincolnelectric.com



THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

SAFETY DEPENDS ON YOU

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

WARNING

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

CAUTION

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



KEEP YOUR HEAD OUT OF THE FUMES.

DON'T get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

READ and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

USE ENOUGH VENTILATION or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

IN A LARGE ROOM OR OUTDOORS, natural ventilation may be adequate if you keep your head out of the fumes (See below).

USE NATURAL DRAFTS or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



WEAR CORRECT EYE, EAR & BODY PROTECTION

PROTECT your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

PROTECT your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

PROTECT others from splatter, flash, and glare with protective screens or barriers.

IN SOME AREAS, protection from noise may be appropriate.

BE SURE protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



SPECIAL SITUATIONS

DO NOT WELD OR CUT containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

DO NOT WELD OR CUT painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

Additional precautionary measures

PROTECT compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

BE SURE cylinders are never grounded or part of an electrical circuit.

REMOVE all potential fire hazards from welding area.

ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.



SECTION A: WARNINGS



CALIFORNIA PROPOSITION 65 WARNINGS



WARNING: Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to www.P65warnings.ca.gov/diesel

WARNING: This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 *et seq.*)



WARNING: Cancer and Reproductive Harm
www.P65warnings.ca.gov

ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2-1974. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.



FOR ENGINE POWERED EQUIPMENT.

- 1.a. Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- 1.b. Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- 1.c. Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- 1.d. Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- 1.e. In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- 1.f. Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- 1.g. To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- 1.h. To avoid scalding, do not remove the radiator pressure cap when the engine is hot.



ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- 2.a. Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- 2.b. EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- 2.c. Exposure to EMF fields in welding may have other health effects which are now not known.
- 2.d. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
 - 2.d.1. Route the electrode and work cables together - Secure them with tape when possible.
 - 2.d.2. Never coil the electrode lead around your body.
 - 2.d.3. Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
 - 2.d.4. Connect the work cable to the workpiece as close as possible to the area being welded.
 - 2.d.5. Do not work next to welding power source.



ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:

- Semiautomatic DC Constant Voltage (Wire) Welder.
 - DC Manual (Stick) Welder.
 - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
 - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
 - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
 - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
 - 3.g. Never dip the electrode in water for cooling.
 - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
 - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
 - 3.j. Also see Items 6.c. and 8.



ARC RAYS CAN BURN.



- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



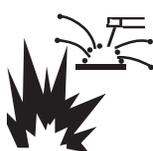
FUMES AND GASES CAN BE DANGEROUS.



- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer’s instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer’s safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.



WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 022690-9101.
- 6.j. Do not use a welding power source for pipe thawing.



CYLINDER MAY EXPLODE IF DAMAGED.

- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition. 
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
 - Away from areas where they may be struck or subjected to physical damage.
 - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



FOR ELECTRICALLY POWERED EQUIPMENT.



- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

Refer to
<http://www.lincolnelectric.com/safety>
for additional safety information.

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Content/details may be changed or updated without notice. For most current Instruction Manuals, go to parts.lincolnelectric.com.

TECHNICAL SPECIFICATIONS – Idealarc® DC-1000

INPUT: THREE PHASE ONLY						
INPUT AC VOLTAGE (U ₁)	FREQUENCY	AC INPUT CURRENT (I _{1MAX} , I _{1EFF}) AT RATED OUTPUT (I ₂ , U ₂)				
		I _{1MAX} AT 1250A 44V 50%DC	I _{1MAX} AT 1140A 44V 60%DC	I _{1EFF} AT 1000A 44V 100%DC		
380V _{RMS}	50/60Hz	139A _{RMS}	128A _{RMS}	116A _{RMS}		
440V _{RMS}	50/60Hz	120A _{RMS}	111A _{RMS}	100A _{RMS}		
RATED OUTPUTS (ALL MODES)						
	DUTY CYCLE ⁽¹⁾ (X)	DC AMPS _{AVG}		DC VOLTS _{AVG}		
MAXIMUM	50%	1250 (I ₂)		44 (U ₂)		
	60%	1140 (I ₂)		44 (U ₂)		
	100%	1000 (I ₂)		44 (U ₂)		
MINIMUM	100%	150		21.5		
ADDITIONAL OUTPUTS (ALL MODES)						
	DUTY CYCLE ⁽¹⁾ (X)	DC AMPS _{AVG}		DC VOLTS _{AVG}		
MAXIMUM	45%	1300		46		
MINIMUM	100%	150		16		
OCV VOLTAGE AND AUXILIARY POWER						
PEAK OPEN CIRCUIT (NO-LOAD) DC VOLTAGE (U ₀)			AC AUXILIARY POWER			
CV SUBMERGED ARC: 78V			115 VOLTS _{RMS} 8 AMPS _{RMS}			
CV INNERSHIELD: 78V						
CC SUBMERGED ARC: 78V						
RECOMMENDED INPUT WIRE AND FUSE SIZES FOR MAXIMUM RATED OUTPUT. IN ADDITION, FOLLOW LATEST NATIONAL ELECTRICAL CODE AND LOCAL CODE.						
INPUT AC VOLTAGE (U ₁)	FREQUENCY	MAXIMUM EFFECTIVE INPUT CURRENT (I _{1EFF})	TYPE 90°C COPPER WIRE IN CONDUIT AWG (mm ²)	COPPER GROUND WIRE IN CONDUIT AWG (mm ²)	BUSSMANN LIMITRON FUSE SIZE AND CATALOG NUMBER ⁽²⁾	
					FUSE SIZE	CATALOG NUMBER
380V _{RMS}	50/60HZ	116A _{RMS}	2 (35)	6 (16)	175A	KTS-R-175
440V _{RMS}	50/60HZ	100A _{RMS}	3 (25)	6 (16)	150A	KTS-R-150
PHYSICAL DIMENSIONS						
HEIGHT	WIDTH	DEPTH		WEIGHT		
30.75 IN.	22.25 IN.	39.0 IN.		821 LBS		
781 MM	565 MM	991 MM		372 KG.		
TEMPERATURE RANGES						
OPERATING TEMPERATURE RANGE			STORAGE TEMPERATURE RANGE			
14° F TO 104° F (-10° C TO +40° C)			-40° F TO 140° F (-40° C TO +60° C)			
INSULATION CLASS						
TRANSFORMER			CHOKE			
CLASS F (155° C)			CLASS F (155° C)			
STANDARDS COMPLIANCE						
CCC, CE, IP21S, IEC60974-1, IEC60974-10, GB 15579.1-2013, C-TICK						

(1) Based upon 10 minute time period (for 100% duty cycle, it is 10 minutes on and 0 minutes off).

(2) Use only Bussmann Limitron fuses specified. Other fuses may not protect the welder and may cause overheating and possible fire damage.

SAFETY PRECAUTIONS

Read this entire installation section before you start installation.

WARNING

ELECTRIC SHOCK can kill.

- Only qualified personnel should perform this installation.
- Turn the input power OFF at the disconnect switch or fuse box before working on this equipment. Turn off the input power to any other equipment connected to the welding system at the disconnect switch or fuse box before working on the equipment.



- Do not touch electrically hot parts.
- Always connect the grounding lug (located inside the reconnect input access door) to a proper safety (Earth) ground.

LOCATION

Even though the machine is designed to operate under a wide variety of environmental conditions, for maximum reliability and long life the machine should be located in a clean, dry place where there is free circulation of clean air in through the front and out the back of the machine. Dirt and dust that can be drawn into the machine should be kept to a minimum. Failure to observe these precautions can result in excessive operating temperatures and nuisance shutdown of the machine.

The case front incorporates a recessed control panel which protects the controls and minimizes the possibilities of accidental contact. This cover panel can be flipped open to permit access to the enclosed control section.

The individual case sides are removable for easy access for internal service or inspection.

The case rear is equipped with a removable cover plate, permitting easy access to the input panel.

The machine uses a 38" (965mm) long base. The low profile case facilitates installation of the machine under a workbench and stacking the machines two high to conserve floor space.

A permanent lifting eye is located at the top of the machine and is positioned so that it acts as nearly as possible through the center of gravity. This lift eye fits under the case of the second machine without interference when stacking.

This equipment is for industrial use only and it is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There can be potential difficulties in residential locations due to conducted as well as radiated radio-frequency disturbances. The EMC or RF classification of this equipment is Class A.

STACKING

WARNING



FALLING EQUIPMENT can cause injury.

- Do not lift this machine using lift bale if it is equipped with a heavy accessory such as trailer or gas cylinder.
- Lift only with equipment of adequate lifting capacity.
- Be sure machine is stable when lifting.
- Do not stack more than two high.
- Do not stack the DC-1000 on top of any other machine.

Two DC-1000's may be stacked by observing the following safety precautions:

1. Make sure the first or bottom unit is setting on a level, well-supported surface.
2. The units must be stacked with their fronts flush, making sure the two holes in the base rails of the top unit are over the two pins located on top of the bottom unit.

INPUT WIRING

Be sure the voltage, phase and frequency of the input power is as specified on the welder nameplate.

Dual voltage (e.g. 380/440) models are shipped connected for the highest voltage. To change the connection, see the connection diagram pasted to the inside of the access panel in the case back.

Have a qualified electrician remove the rear access panel and connect 3 phase AC power to terminals L₁, L₂ and L₃ of the input panel in accordance with the U.S. National Electrical Code, all local codes and the wiring diagram located inside the machine.

The welder frame must be grounded. A stud marked with the symbol  located inside the machine near the input panel is provided for this purpose. See the U.S. National Electrical Code for details on proper grounding methods. See Technical Specifications for recommended input wire and fuse sizes.

RECONNECT PROCEDURE

Multiple voltage machines are shipped connected for the highest input voltage listed on the machine's rating plate. Before installing the machine, check that the Reconnect Panel in the Input Box Assembly is connected for the proper voltage.



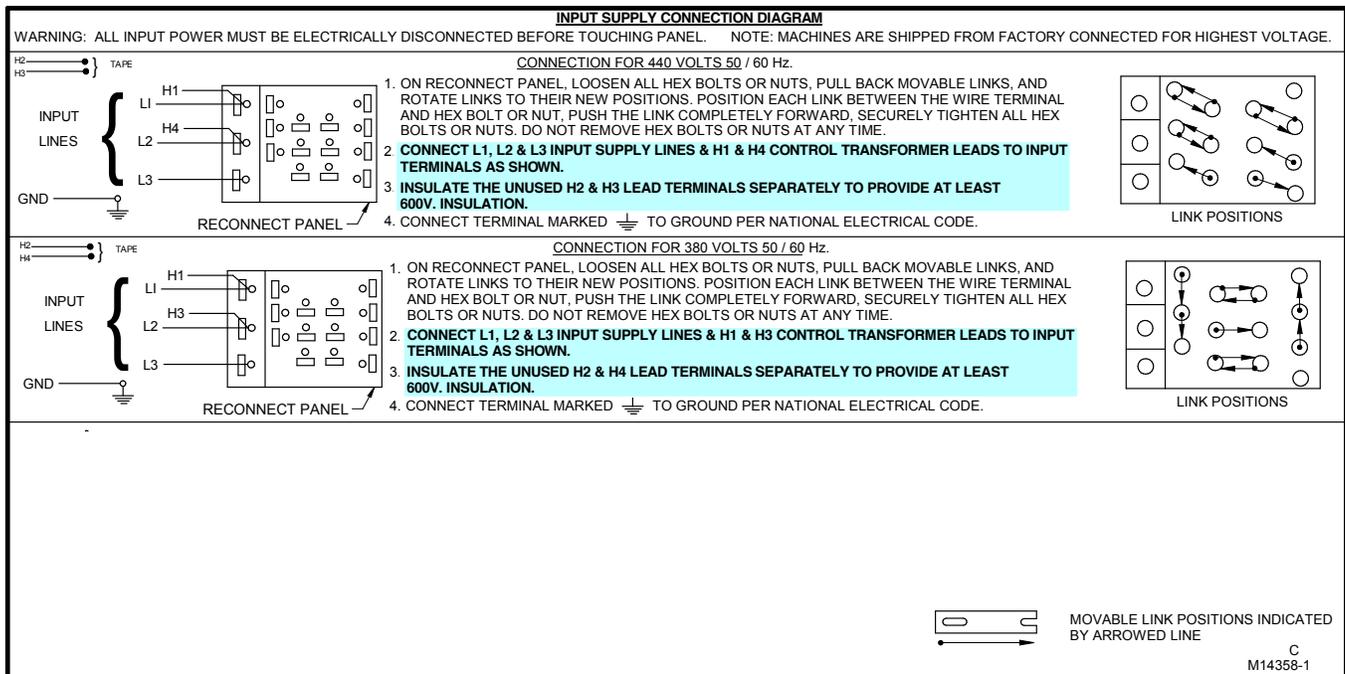
Failure to follow these instructions can cause immediate failure of components within the machine.

When powering welder from a generator be sure to turn off welder first, before generator is shut down, in order to prevent damage to the welder.

To reconnect a multiple voltage machine to a different voltage, remove input power and change the position of the reconnect board on the Reconnect Panel. Follow The Input Connection Diagram located on the inside of Case Back Input Access Door. These connection diagrams for the following codes are listed below.

1. For 380/440, see Figure 1, (M14358-1).
2. For Voltages not listed, see the Input Connection Diagram pasted on the inside of the Case Back Input Access Door.

FIGURE 1



OUTPUT CONNECTIONS

Output Studs

The output leads are connected to the output terminals. The output terminals are located on the lower case front and labeled “+” and “-”. There are 1000 amp rated “+” terminals on the right side, one 500 amp rated “+” terminal near the center and “-” terminals on the left side. They are fully recessed to minimize the possibility of accidental contact by an object or a person. Strain relief is provided by the oval holes in the base. The leads are run through these oval holes before they are connected to the output terminals.

An output stud cover protects against accidental contact with the output studs. Cover hinges upward for access to the studs.

The 1000 amp output connections provide the full rated output range of the machine. See Table 1 for recommended DC-1000 cable sizes for combined lengths of electrode and work cables.

The 500 amp output connections provide enhanced lower current arc characteristics, especially for submerged arc and GMAW procedures below 450 amps.

Auxiliary Power

This machine supplies the 115 volt, AC power needed for operating wire feeding equipment. The power is available from terminals #31 and #32 on the terminal strip. An 8 amp slow blow fuse on the machine control panel protects the auxiliary power from excessive overloads. The circuit has a 1000 volt-ampere rating.

Control Cable Connection

Terminal strips with screw connections are located behind the hinged door on the front of the power source to make all the control cable connections for operating wire feeding equipment. See the appropriate connection diagram for exact instructions covering the wire feeder being used.

With the DC-1000 turned off, the control cable from the automatic wire feeding equipment is connected to the terminal strip. A strain relief box connector is provided for access into the terminal strip section. A chassis grounding screw is also provided below the terminal strip marked with the symbol  for connecting the wire feeding equipment grounding wire. See the appropriate connection diagram for the exact instructions for the wire feeder being used. A spare hole is provided for an additional box connector if required.

Connecting for Air Carbon Arc:

- Turn off all power.
- Disconnect all wire feed unit control, electrode and work leads.
- Connect a jumper from 2-4 on terminal strip.
- Place mode switch in the CV Innershield position.

With the DC-1000 connected for air carbon arc welding, the output terminals will be energized at all times.

TABLE 1
DC-1000 Cable Sizes for Combined Lengths of Copper Electrode and Work Cable at 100% Duty Cycle

Cable Length	Parallel Cables	Cable Size
Lengths up to 150 ft. (46m)	3	1/0 (53mm ²)
150 ft.(46m) to 200 ft (61m)	3	2/0 (67mm ²)
200 ft.(61m) to 250 ft.(76m)	3	3/0 (85mm ²)

IDEALARC® DC-1000



OPERATING INSTRUCTIONS

⚠ WARNING



- ELECTRIC SHOCK** can kill.
- Do not touch electrically live parts or electrode with skin or wet clothing.
 - Insulate yourself from work and ground.
 - Always wear dry insulating gloves.



- FUMES AND GASES** can be dangerous.
- Keep your head out of fumes.
 - Use ventilation or exhaust to remove fumes from breathing zone.



- WELDING SPARKS** can cause fire or explosion.
- Keep flammable material away.
 - Do not weld on closed containers.



- ARC RAYS** can burn eyes and skin.
- Wear eye, ear and body protection.

See additional warning information at front of this operator's manual.

PRODUCT DESCRIPTION

The DC-1000 is an SCR-controlled three phase DC power source. It is designed with a single range potentiometer control for submerged arc or open arc automatic and semiautomatic welding. It can be used for air carbon arc cutting with carbon rods up to and including 5/8" (15.9mm) dia. GMAW procedures can be performed using the 500 amp output stud. This connection provides the enhanced lower current arc characteristics required for this type of welding.

The DC-1000 is provided with a three position mode switch that selects CV Innershield®, CV Submerged Arc or CC Submerged Arc.

The unit is designed to be used with the NA-5, NA-5R and NA-3 automatics, the LT-56 and LT-7 tractors, and can also be used with the LN-7, LN-8 or LN-9 semiautomatic wire feeders.

MEANINGS OF SYMBOLS

The DC-1000 nameplate has been designed to use international symbols in describing the function of the various components. Below are the symbols used.

POWER ON-OFF SWITCH



-----> Input (Power)



-----> On



-----> Off

OUTPUT CONTROL DIAL



-----> Output Control



-----> Increase/Decrease of Output (Voltage or Current)

OUTPUT CONTROL PANEL-REMOTE SWITCH



-----> Remote Output Voltage or Current Control



-----> Panel Output Voltage or Current Control

THERMAL PROTECTION LIGHT

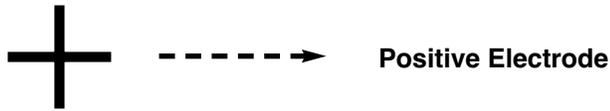


-----> High Temperature

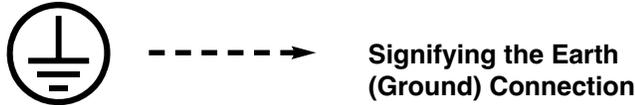


-----> Fuse

ELECTRODE POLARITY SWITCH



EARTH GROUND CONNECTION ON INPUT BOX



RATING PLATE



RATING PLATE

IP21S	----->	Degree of protection provided by the enclosure
CE	----->	Designates welder complies with low voltage directive and with EMC directive.
	----->	Designates welder complies with China Compulsory Certificate
 N80	----->	C-Tick symbol indicates conformity with Australian EMC regulations.
-10 Class A	----->	Designates welder complies with IEC 60974-10 Electromagnetic Capability (EMC) requirements for equipment used in industrial locations.
GB 15579.1-2013	----->	Designates welder complies with Chinese National Standard GB 15579.1-2013.
U_0	----->	Rated peak no-load voltage (DC_{peak}).
U_1	----->	Rated supply voltage (AC_{rms}).
U_2	----->	Conventional load voltage (DC_{avg}).
I_{1max}	----->	Rated maximum supply current (AC_{rms}).
I_{1eff}	----->	Maximum effective supply current (AC_{rms}).
I_2	----->	Rated welding current (DC_{avg}).
X	----->	Duty cycle (Based upon 10 minute time period).

TO SET POLARITY

Turn off the DC-1000 and connect the electrode cable to the "Positive" or "Negative" studs depending upon the electrode polarity desired. Connect the work cable to the other stud. (See "Output Connections").

Set the "Electrode Negative-Electrode Positive" switch to correspond to the polarity of the electrode cable connection. This switch setting is necessary for proper operation of some Lincoln wire feeders and does not change the welding polarity.

Starting the Machine - The push button power "on" switch at the extreme right side of the control panel energizes and closes the three phase input contactor from a 110 volt auxiliary transformer. This in turn energizes the main power transformer.

The white light below the stop-start button indicates when the input contactor is energized.

Output Control - The output control in the center of the control panel is a continuous control of the machine output. The control may be rotated from min. to max. while under load to adjust the machine output.

The machine is equipped with line voltage compensation as a standard feature. This will hold the output relatively constant except at maximum output of the machine, through a fluctuation of +/- 10% of input line voltage.

Output Control at DC-1000 or Output Control Remote Switch

The toggle switch on the control panel labeled "Panel" / "Remote" gives the operator the option of controlling the output at the machine control panel or at a remote station. For remote control, the toggle switch is set in the "Remote" position and controlled at the wire feed unit control or by connecting a K775 control to the appropriate terminals (as indicated on the connection diagram) on the terminal strip at the front of the machine. For control at the machine control panel, the toggle switch is set in the "Panel" position.

Remote Output Control - (Optional)

The K775 Remote Output Control consists of a control box with 28 ft. (8.4m) of four conductor cable. This connects to terminals 75, 76, 77 on the terminal strip, and the case grounding screw so marked with the symbol  on the machine. These terminals are made available by opening the terminal access cover on the left side of the case front. This control will give the same control as the output control on the machine.

Mode Switch

The toggle switch labeled CV Innershield, CV Submerged Arc, CC Submerged Arc is used to select the proper welder characteristics for the process being used.

SET-UP FOR VARIOUS PROCEDURES

1. **Selection of mode switch position** - There are several general rules to follow in the selection of the mode switch position.
 - a. Use the CV Innershield mode for all FCAW and GMAW processes. The CV Innershield mode is also used for air carbon arc using carbon rods up to and including 5/8" (15.9mm) dia.

Welding with NR®-151, 202, 203 and other electrodes below 20 volts, is not recommended.
 - b. Use the CV Submerged Arc mode for all submerged arc welding. This applies to both low and high travel speeds.
 - c. The CC Submerged Arc mode is available for high current large puddle submerged arc procedures that cannot be done as well with the constant voltage mode. CC mode should be used for 3/16" (4.8mm) diameter electrode and above where high current surges cause machine shutdown when starting. This occurs primarily when the slag ball is not cut from the electrode prior to starting. (Also requires a wire feeder that has a constant current mode - i.e. NA-3S).

NOTE: Some processes and procedures may be better with the mode switch in the other CV position. If the mode switch position initially selected is not producing the desired results, then place the mode switch in the other CV position and make a test weld. Then use the CV mode switch position that gives the desired results.

2. **NA-3** - The NA-3 should be set for the mode being used on the power source. If using either of the CV modes, the NA-3 CC board switch should be set for CV. If the power source is used in the CC mode, then the NA-3 CC board mode switch should be placed in the CC position.

All the NA-3's when used with the DC-1000 are capable of cold starting with the constant current board mode switch in CC. Cold starting permits the wire to be inched down to the work, automatically stop, and automatically energize the flux hopper valve. All NA-3's made after September, 1976 are capable of cold starting on either CV or CC settings of the constant current board.

On the NA-3, set the open circuit voltage control to the same dial setting as the arc voltage control. If the procedure has not yet been established, a good starting point is to set the OCV to #6.

Run a test weld, setting the proper current, voltage and travel speed. Once the proper welding procedure is established and if the start is poor - wire blast off, stub, etc. - adjust the NA-3 OCV and inch speed controls for optimum starting. In general, a low inch speed and an OCV dial setting identical to the voltage dial setting will provide the best starting.

To further optimize starting, adjust the OCV by making repeated starts and observing the NA-3 voltmeter action. With proper adjustment of the OCV control, the voltmeter needle will swing smoothly up to the desired arc voltage and thus provide repeatable starts.

If the voltmeter swings *above* the set voltage and then back to the desired welding voltage, the OCV setting is *too high*. This usually results in a bad start where the wire tends to "blast off".

If the voltmeter needle hesitates *before* coming up to the desired voltage, the OCV is set *too low*. This will cause the electrode to stub.

3. **NA-5** - Set the DC-1000 mode switch to the process being used - CV Innershield or CV Submerged Arc. Set the DC-1000 panel/remote switch in the remote position. Set the OCV control four volts higher than the welding voltage and the inch speed at 1/2 the welding wire feed speed for the initial test weld. Adjust the OCV and inch speed as required for optimum starting. Refer to the NA-5 instruction manual for data regarding the setup of controls and modes on the NA-5.
4. **LN-8** - Set the LN-8 mode switch (located on the CC board) to the CV position. Set the DC-1000 mode switch on CV Innershield or CV Submerged Arc according to the process being used.
5. **LN-7, LN-9 and other constant wire feed units** - Set the DC-1000 mode switch on CV Innershield or CV Submerged Arc according to the process being used. If using an LN-9, refer to the LN-9 instruction manual for further instructions on its use. If using an LN-7, it will be necessary to use either a K775 Remote Control or operate the DC-1000 with the panel/remote switch in the panel position.

SAFETY PRECAUTIONS

WARNING



ELECTRIC SHOCK can kill.

- Only qualified personnel should perform this installation.
 - Turn the input power OFF at the disconnect switch or fuse box before working on this equipment.
- Do not touch electrically hot parts.

The control board is designed with adequate protection so that no damage will occur if the remote control leads are shorted together or are grounded to the case. The machine will automatically shut down if such faults do occur.

An 8-amp fuse located on the machine control panel protects the 115 volt auxiliary AC circuit (#31 and #32) from overload. If replacing, use the same type and size fuse.

GENERAL MAINTENANCE

1. The fan motors have sealed bearings which require no service.
2. In extremely dusty locations, dirt may clog the air channels causing the welder to run hot. Blow out the welder with low pressure air at regular intervals as required to eliminate excessive dirt and dust buildup on internal parts.

OVERLOAD PROTECTION AND THERMAL PROTECTION LIGHT

The power source is thermostatically protected with two proximity thermostats against overload or insufficient cooling. One thermostat is located on the transformer secondary negative output lead, and the other thermostat is located on the choke coil. The thermostats are connected in series in the machine control circuit so that if an excessive overload is applied to the machine, or the machine should receive insufficient cooling on either the main transformer, SCR bridge assembly or choke, the input contactor would open and remain open until the machine cools. Pressing the "On" button will illuminate an amber light on the front of the machine indicating that one of the thermostats has opened. Once the machine cools, it can be manually restarted by operating the start push button.

The power source is also protected against heavy overloads on the SCR bridge assembly through an electronic protection circuit. This circuit senses an overload on the power source and opens the input contactor should the overload remain for a predetermined time. The predetermined time varies with the amount of overload; the greater the overload, the shorter the time. The input contactor will remain open until the power source is manually started with the start push button.

HOW TO USE TROUBLESHOOTING GUIDE

WARNING

Service and Repair should only be performed by Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed throughout this manual.

This Troubleshooting Guide is provided to help you locate and repair possible machine malfunctions. Simply follow the three-step procedure listed below.

Step 1. LOCATE PROBLEM (SYMPTOM).

Look under the column labeled "PROBLEM (SYMPTOMS)". This column describes possible symptoms that the machine may exhibit. Find the listing that best describes the symptom that the machine is exhibiting.

Step 2. POSSIBLE CAUSE.

The second column labeled "POSSIBLE CAUSE" lists the obvious external possibilities that may contribute to the machine symptom.

Step 3. RECOMMENDED COURSE OF ACTION

This column provides a course of action for the Possible Cause, generally it states to contact your local Lincoln Authorized Field Service Facility.

If you do not understand or are unable to perform the Recommended Course of Action safely, contact your local Lincoln Authorized Field Service Facility.

CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
Input contactor (1CR) chatters.	<ol style="list-style-type: none"> 1. Faulty input contactor (1CR). 2. Low line voltage. 3. Faulty 2CR relay. 	<ol style="list-style-type: none"> 1. Repair or replace. 2. Check input power. 3. Replace relay.
Machine input contactor does not operate.	<ol style="list-style-type: none"> 1. Supply line fuse blown. 2. Contactor power circuit dead. 3. Broken power lead. 4. Wrong input voltage. 5. Secondary or choke thermostat open. 6. Open input contactor coil. 7. Faulty stop/start push button switch. 8. Faulty 2CR relay. 9. Defective control board. 	<ol style="list-style-type: none"> 1. Replace if blown - look for reason first. 2. Check control transformer T2 and associated leads. 3. Check input voltage at contactor. 4. Check voltage against instructions. 5. Check for overheating; make sure fan is operating and there is no obstruction to free air flow. Replace faulty thermostat. 6. Replace contactor. 7. Replace switch. 8. Replace relay. 9. Replace control board. See P.C. board troubleshooting guide.
Input contactor pulls in when start button is pressed, but immediately drops out.	<ol style="list-style-type: none"> 1. Defective start/stop push button. 2. Defective 1CR interlock. 3. Ground fault between control terminals 73, 74, 75, 76 or 77 and negative output terminal. 4. Short on output terminals with 2-4 jumpered. 5. Defective control board. 	<ol style="list-style-type: none"> 1. Check and replace if necessary. 2. Repair or replace. 3. Check 73, 74, 75, 76 or 77 for ground to negative output circuit. 4. Remove short. 5. Replace control board. See P.C. board troubleshooting guide.
Machine input contactor operates but no output when trying to weld.	<ol style="list-style-type: none"> 1. Electrode or work lead loose or broken. 2. Open main power transformer (T1) primary or secondary circuit. 3. Output pilot relay 4CR not operating or faulty. 4. Firing circuit P.C. board not connected or is faulty. 5. If using 500 amp stud, choke circuit may be open. 	<ol style="list-style-type: none"> 1. Repair connection. 2. Repair or replace. 3. Check relay pull-in by connecting a jumper across terminals 2 and 4 on DC-1000 terminal strip. Replace if faulty. 4. All nine light emitting diodes (LED1 thru LED9) must be lit. See P.C. board troubleshooting guide. 5. Repair.

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

IDEALARC® DC-1000



Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
Machine has maximum output but not control.	<ol style="list-style-type: none"> 1. Output control switch (SW3) in wrong position. 2. Output control switch faulty. 3. Open in feedback circuitry. 4. Faulty control or firing circuit P.C. boards. 5. Output control potentiometer circuit open (Lead 75). 	<ol style="list-style-type: none"> 1. Check position of switch. 2. Check switch and replace if faulty. 3. Check wiring and control and firing circuit P.C. board wiring harness plugs. 4. All light emitting diodes must be lit, except LED4 on the control board. See P.C. board troubleshooting guide. 5. Check and replace potentiometer if faulty. Check wiring of Lead #75.
Machine has minimum output and no control.	<ol style="list-style-type: none"> 1. Terminals 73, 74, 75, 76 or 77 grounded to <i>positive</i> output. 	<ol style="list-style-type: none"> 1. Check 73, 74, 75, 76 or 77 for ground to positive output circuit.
Machine does not have maximum output. Variable or sluggish welding arc.	<ol style="list-style-type: none"> 1. One input fuse blown. 2. One phase of main power transformer open. 3. Faulty control or firing circuit P.C. boards. 4. Output control potentiometer defective. 5. Output control potentiometer leads open - 76, 77, 226, 236, 237, 238. 	<ol style="list-style-type: none"> 1. Check and replace if blown after checking for reason for blown fuse. 2. Check for open and repair or replace. 3. All light emitting diodes must be lit on both P.C. boards, except LED4 on control board. See P.C. board troubleshooting guide. 4. Check and replace if faulty. 5. Repair.
Machine has output but trips off immediately when wire feed unit start button is pressed.	<ol style="list-style-type: none"> 1. Machine has either an internal or external short circuit on the output. 2. Faulty control P.C. board. 3. Terminals 73, 74, 75, 76, 77 grounded to negative output terminal. 	<ol style="list-style-type: none"> 1. Check internally and externally for any shorts and remove or repair. 2. Replace control board. See P.C. board troubleshooting guide. 3. Check for grounded 73, 74, 75, 76, 77.
Machine will not shut off.	<ol style="list-style-type: none"> 1. Poor work or electrode connection. 2. Welding leads too small. 3. Welding current or voltage too low. 4. Defective main SCR bridge. 	<ol style="list-style-type: none"> 1. Check and clean all connections. 2. Check Table 1 in instruction manual. 3. Check procedures for recommended settings. 4. Check and replace if defective.
Output control not functioning on the machine ⁽¹⁾ .	<ol style="list-style-type: none"> 1. Input contactor contacts frozen. 	<ol style="list-style-type: none"> 1. Check and replace if necessary. 2. Check and replace if necessary.

⁽¹⁾ If connected to an LN-9 or NA-5, disconnect leads 73, 74, 75 before troubleshooting.

CAUTION

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IDEALARC® DC-1000



Observe all Safety Guidelines detailed throughout this manual

PROBLEMS (SYMPTOMS)	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
Output control not functioning on remote control.	<ol style="list-style-type: none"> 1. Output control switch (SW3) in wrong position. 2. Faulty output control switch. 3. Faulty remote control potentiometer. 4. Leads or connections open in control circuit. 5. Faulty firing or control circuit P.C. board. 	<ol style="list-style-type: none"> 1. Place switch in "Output Control Remote". 2. Check and replace if found faulty. 3. Check and replace if found faulty. (Voltage from 75 to 77 should be 3 to 5V). 4. Check all leads and connections, internal or remote, for continuity; repair if necessary. 5. All light emitting diodes must be lit on both P.C. boards, except LED4 on control board. See P.C. board troubleshooting guide.
Poor starting on CV Submerged Arc.	<ol style="list-style-type: none"> 1. Improper procedures or setting of controls. 2. Poor electrode or work connection. 3. 3CR reed switch inoperative. 4. Faulty control board. 	<ol style="list-style-type: none"> 1. See instruction manual and procedures. 2. Repair connections. 3. Check reed switch voltage leads 216 to 220. Idle voltage is about 8V; when welding, voltage must go to zero. 4. Replace. See P.C. board troubleshooting guide.
Poor bead shape or erratic arc on CV Submerged Arc.	<ol style="list-style-type: none"> 1. Improper procedures. 2. Defective 3CR reed switch. 3. Faulty control board. 4. Defective main SCR bridge. 	<ol style="list-style-type: none"> 1. See instruction manual and procedures. 2. Check reed switch per item 3 of previous Table above. 3. Replace. See P.C. board troubleshooting guide. 4. Check and replace if defective.
Poor starting on CV Innershield and CV Submerged Arc.	<ol style="list-style-type: none"> 1. Defective 3CR reed switch. 2. Faulty control board. 	<ol style="list-style-type: none"> 1. Replace. 2. Replace.
Poor arc characteristics on CV Innershield or other open arc processes.	<ol style="list-style-type: none"> 1. Mode switch in CV Submerged Arc mode. 2. Defective main SCR bridge. 	<ol style="list-style-type: none"> 1. Place mode switch in CV Innershield mode. 2. Check and replace if defective.
Poor arc characteristics on all processes.	<ol style="list-style-type: none"> 1. Defective control board. 2. Defective firing board. 3. Defective main SCR bridge. 	<ol style="list-style-type: none"> 1. Check and replace if defective. See P.C. board troubleshooting guide. 2. Check and replace if defective. See P.C. board troubleshooting guide. 3. Check and replace if defective.
Poor performance (including arc outages) while welding at low current (less than 450 amps) when connected to 1000 amp "+" output studs.	<ol style="list-style-type: none"> 1. Insufficient output inductance. 	<ol style="list-style-type: none"> 1. Use the 500 amp "+" output stud.
Machine frequently shuts off while using the 500 amp "+" output stud.	<ol style="list-style-type: none"> 1. Effective current demand well over 500 amperes. 	<ol style="list-style-type: none"> 1. Use the 1000 amp "+" output studs.

 **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

IDEALARC® DC-1000



Observe all Safety Guidelines detailed throughout this manual

P.C. BOARD TROUBLESHOOTING GUIDE

⚠ WARNING



ELECTRIC SHOCK can kill.

- Have an electrician install and service this equipment.
- Turn the input power off at the fuse box before working on equipment.
- Do not touch electrically hot parts.

Machine settings for P.C. board troubleshooting. Disconnect all leads to the wire feeder and jumper terminals #2 and #4 on DC-1000. Panel/Remote Switch in Panel position. Mode switch in the CV Innershield position.

CONTROL CIRCUIT P.C. BOARD

1. LED1 indicates AC input voltage is present at pins 282-283. If not lit, check the voltage across the secondary winding of the isolation transformer, T3. The voltage should be approximately 42 volts. If not, the problem is in the power supply and not the P.C. board.
2. LED2 indicates welder output voltage is being supplied to the control circuit. If not lit, check to make certain lead 222 from pin 2 of the 14-pin control circuit P.C. board connector is connected to the power source negative output lead and is not broken.
3. LED3 indicates power is being applied to fault protection pilot relay 2CR to turn on the input contactor.
4. LED4 indicates when overcurrent protection circuit is being activated.
5. LED5 indicates a control signal is being supplied to the firing circuit. As the output control is varied, LED5 should change brilliancy from bright at low output to dim at high output.

FIRING CIRCUIT P.C. BOARD

All nine light emitting diodes must be lit when the power source is turned on and the wire feed arc start button is pressed or a jumper is connected between 2 and 4.

1. Lights 7, 8, and 9 indicate AC power being supplied to the P.C. boards from T1 auxiliary winding. If a light is not lit, turn the machine off and unplug P5 from J5 on the firing P.C. board. Turn the machine on and check the following voltages:

Light That Was Off	Check AC Voltage Between Pins of Plug P5	Voltage Should Be Approx.
7	P5 Pins 2 & 4 (Wires 203, 204)	75 VAC
8	P5 Pins 7 & 3 (Wires 205, 206)	75 VAC
9	P5 Pins 9 & 8 (Wires 207, 208)	75 VAC

- If approximately 75 VAC is present, turn the machine off, plug P5 back into firing board. Turn the machine back on and check to see if the light or lights are on. If the light or lights are not on replace the firing P.C. board.
 - If the 75 VAC was not present, then check the wiring.
2. Lights 1 through 6 indicate gate signals are being supplied to the main power SCR's 1 through 6 respectively. If light 5 on the control circuit and lights 7 through 9 on the firing circuit are lit and lights 1 through 6 are not lit, check lead 231 between the firing circuit and the control circuit that it is not broken and is connected to each Molex connector. If the lead shows continuity and lights 1 through 6 are not lit, replace the firing circuit P.C. board. If any one of the lights 1 through 6 is not lit and lights 7 through 9 are lit, replace the firing circuit P.C. board.

⚠ CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

IDEALARC® DC-1000



Observe all Safety Guidelines detailed throughout this manual

PROCEDURE FOR REPLACING P.C. BOARDS

When P.C. board is to be replaced, the following procedure must be followed:

1. Visually inspect P.C. board in question. Are any of the components damaged?
 - a. If there is no damage to the P.C. board, insert a new one and see if this remedies the problem. If the problem is remedied, replace the old P.C. board and see if the problem still exists with the old P.C. board.
 - 1) If the problem is no longer present with the old board, check the P.C. board harness plugs and P.C. board plugs for corrosion, contamination, or oversize.
 - 2) Check leads in the harness for loose connections.
 - b. If there is damage to the P.C. board, refer to the Troubleshooting Guide

CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

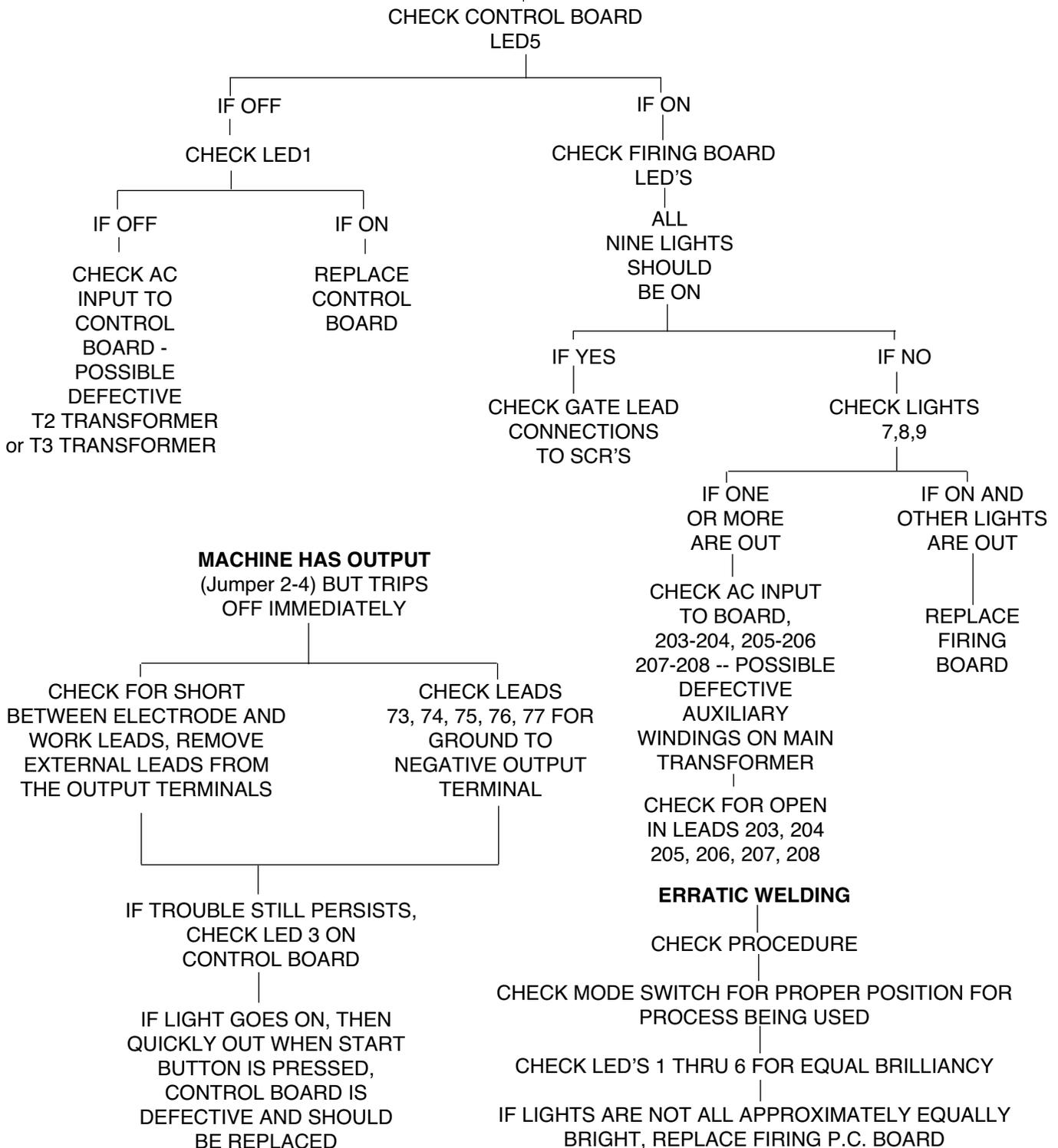
IDEALARC® DC-1000



OUTLINE FOR DC-1000 TROUBLESHOOTING GUIDE

If troubleshooting guide indicates a possible P.C. board problem, the following guide can be used to locate the problem.

NO WELDER OUTPUT (INPUT CONTACTOR "ON". 2 AND 4 CLOSED)



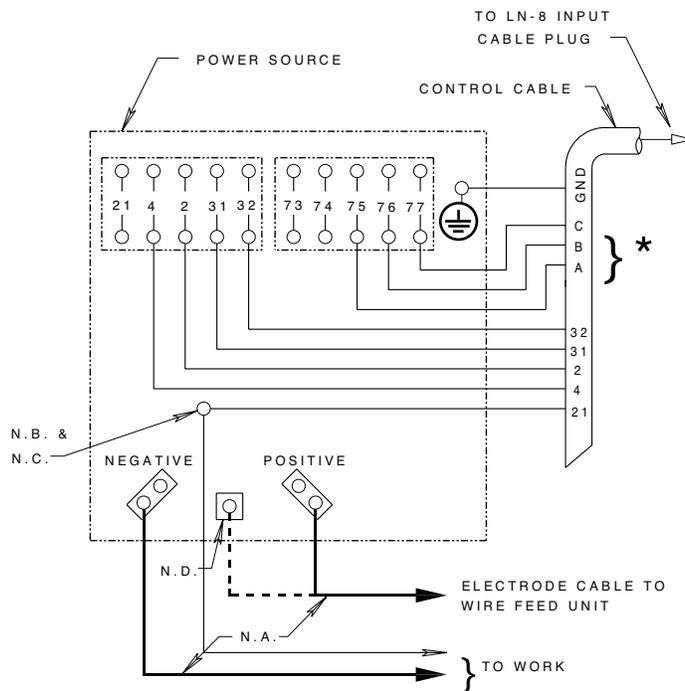
CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

IDEALARC® DC-1000



CONNECTION OF DC-1000 TO LN-8



S17176
8-2-90F

Connect the control cable ground lead to the frame terminal marked  near the power source terminal strip. The power source must be properly grounded.

*If using an older control cable: Connect lead #75 to #75 on terminal strip, connect lead #76 to #76 on terminal strip, connect lead #77 to #77 on terminal strip.

N.A. Welding cables must be of proper capacity for the current and duty cycle of immediate and future applications.

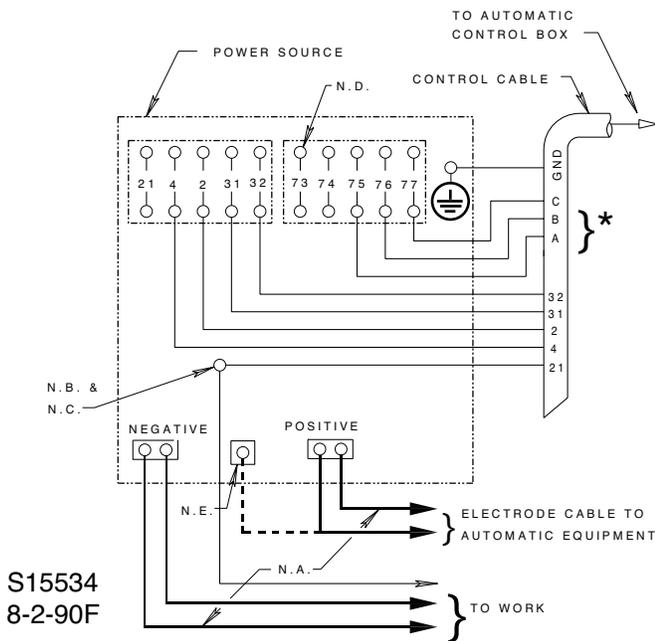
N.B. Extend lead 21 using #14 (2.5 mm²) or larger insulated wire physically suitable for the installation. An S16586-[] remote voltage sensing work lead is available for this purpose. Connect it directly to the work piece keeping it electrically separate from the welding work lead circuit and connection. For convenience, this extended #21 lead should be taped to the welding work lead.

N.C. Tape up bolted connection.

N.D. Alternative 500 amp positive terminal connection provided on DC-1000 models above code 9500 only.

Above diagram shows electrode connected positive. To change polarity, turn power source off, reverse the electrode and work leads at the power source and position the switch on power source to proper polarity.

CONNECTION OF DC-1000 OR DC-1500 to NA-3, LT-5 or LT-7



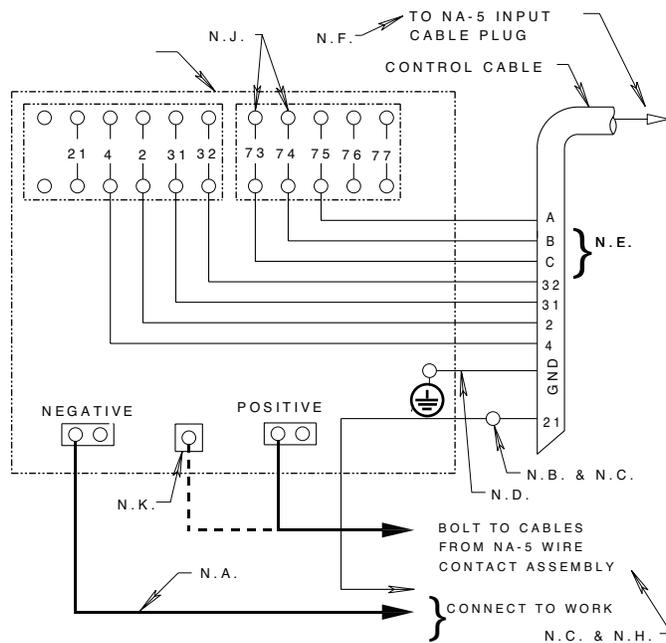
Above diagram shows electrode connected positive. To change polarity, turn power source off, reverse the electrode and work leads at the power source and position the switch on power source to proper polarity. Also reverse the leads on the back of the ammeter and voltmeter in the automatic control box.

Connect the control cable ground lead to the frame terminal marked  near the power source terminal strip. The power source must be properly grounded.

*If using an older control cable: Connect lead #75 to #75 on terminal strip, connect lead #76 to #76 on terminal strip, connect lead #77 to #77 on terminal strip.

- N.A. Welding cables must be of proper capacity for the current and duty cycle of immediate and future applications.
- N.B. Extend lead 21 using #14 (2.5 mm²) or larger insulated wire physically suitable for the installation. An S16586-[] remote voltage sensing work lead is available for this purpose. Connect it directly to the work piece keeping it electrically separate from the welding work lead circuit and connection. For convenience, this extended #21 lead should be taped to the welding work lead.
- N.C. Tape up bolted connection.
- N.D. Terminals 73 & 74 not present on earlier DC-1500.
- N.E. Alternative 500 amp positive terminal connection provided on DC-1000 models above code 9500 only.

CONNECTION OF DC-1000 to NA-5

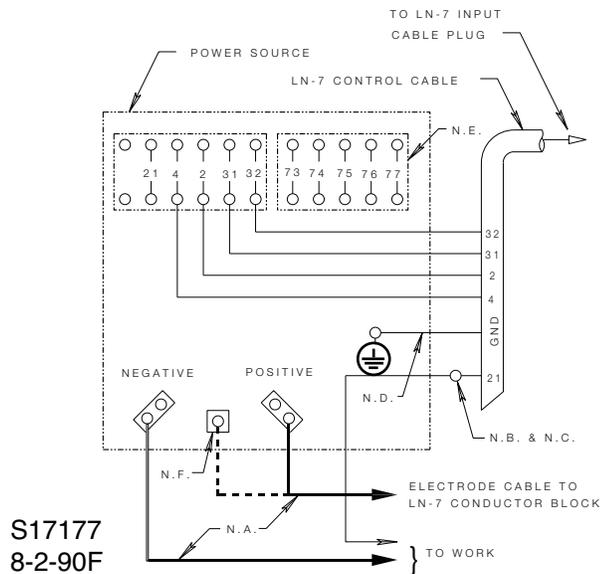


S16889
8-2-90F

Above diagram shows electrode connected positive. To change polarity turn power off, reverse the electrode and work leads at the power source, position the positive - negative switch on the power source to correspond to the polarity of the electrode cable connection. Refer to NA-5 operating manual for required NA-5 control box polarity connections.

- N.A. Welding cables must be of proper capacity for the current and duty cycle of immediate and future applications.
- N.B. Extend lead 21 using #14 (2.5 mm²) or larger insulated wire physically suitable for the installation. An S16586-[] remote voltage sensing work lead is available for this purpose. Connect it directly to the work piece keeping it separate from the welding work cable connection to work piece. For convenience, this extended #21 lead should be taped along the welding work cable.
- N.C. Tape up bolted connection.
- N.D. Connect the NA-5 control cable ground lead to the frame terminal marked \oplus near the power source terminal strip. The power source must be properly grounded.
- N.E. If using an older automatic control cable with leads 75, 76, 77: Connect lead 75 to #75 on terminal strip, connect lead #76 to #74 on terminal strip, connect lead #77 to #73 on terminal strip.
- N.F. Connect the jumpers on the NA-5 voltage board as follows: Connect RED jumper to pin "S", Connect WHITE jumper to pin "B".
- N.G. Set the DC-1000 or DC-1500 controls as follows: Set the control switch to "Output Control Remote". For Submerged Arc Processes set the switch to "C.V. Submerged Arc". For Open Arc Processes, set the mode switch to "C.V. Innershield".
- N.H. For proper operation, the electrode cable *must* be snugged under the clamp bar on the left side of the NA-5 control box.
- N.J. Terminals #73 and #74 were not present on DC-1500 machines below code 8294. These earlier code machines are not suitable for use with the NA-5.
- N.K. Alternative 500 amp positive terminal connection provided on DC-1000 models above code 9500 only.
- N.L. Alternate submerged arc mode available for improved arc stability in high current, large puddle, slow travel procedures by making special connections on both DC-1500 and NA-5.
- On DC-1500 Control Board (G1530-2 and superseding) remove red and blue jumpers from "FR" pins and reconnect to corresponding "SR" pins.
- On NA-5 Voltage Board (G1556-1 and superseding) white jumper must be connected to pin "D".
- NA-5 pin "D" connection may also be used for some procedures on DC-1500 without control board jumpers, DC-1500 with control board jumpers on "FR" pins or DC-1000.

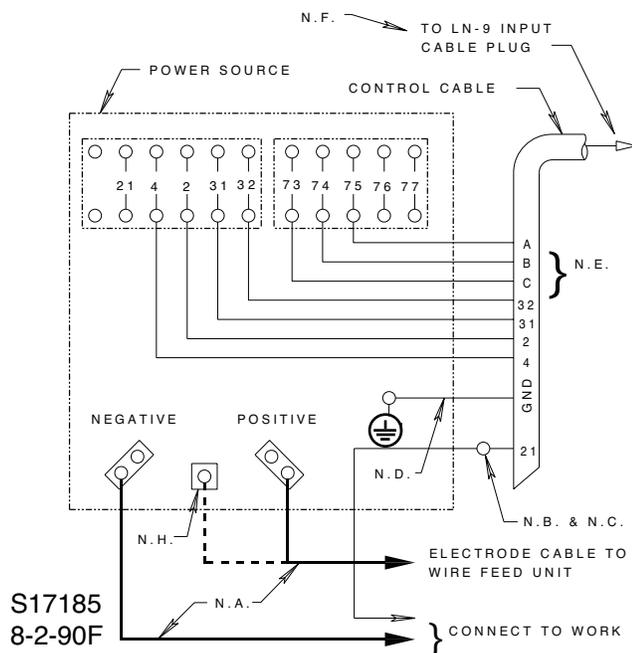
CONNECTION OF DC-1000 TO LN-7



Above diagram shows electrode connected positive. To change polarity, turn power off, reverse the electrode and work leads at the power source and position the switch on power source to proper polarity.

- N.A. Welding cables must be of proper capacity for the current and duty cycle of immediate and future applications.
- N.B. Extend lead 21 using #14 (2.5 mm²) or larger insulated wire physically suitable for the installation. An S16586-[] remote voltage sensing work lead is available for this purpose. Connect it directly to the work piece keeping it electrically separate from the welding work lead circuit and connection. For convenience, this extended #21 lead should be taped to the welding work lead. (This extended #21 lead connection replaces the need to employ the remote work lead accessory on LN-7 meter kits which have a direct work lead jack. An LN-7 not equipped with a meter kit does not require lead 21 to be extended.)
- N.C. Tape up bolted connection.
- N.D. Connect the control cable ground lead to the frame terminal marked \oplus near the power source terminal strip. The power source must be properly grounded.
- N.E. Terminal strip for remote voltage control pot. when used.
- N.F. Alternative 500 amp positive terminal connection provided on DC-1000 models above code 9500 only.

CONNECTION OF DC-1000 TO LN-9



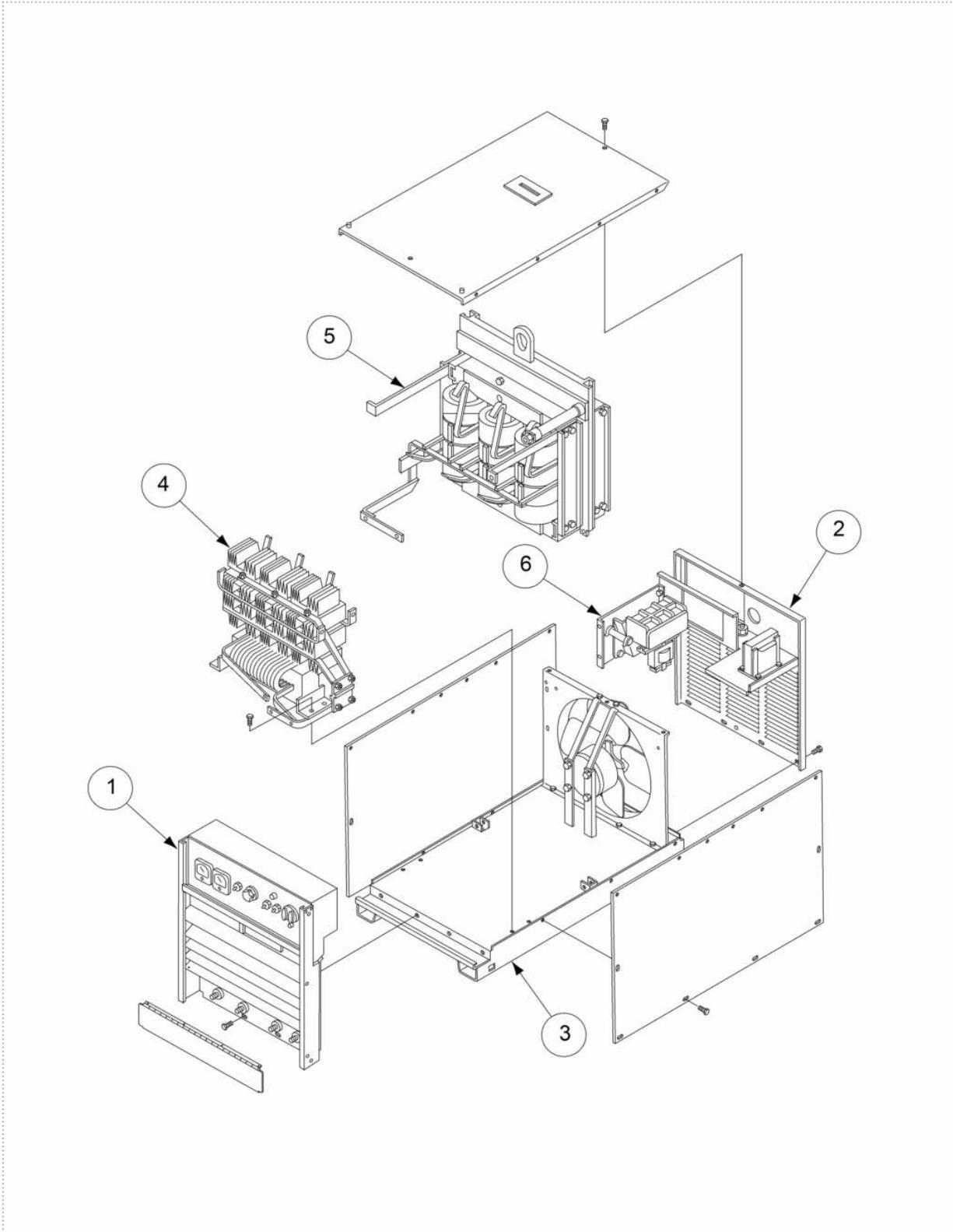
Above diagram shows electrode connected positive. To change polarity, turn power off, reverse the electrode and work leads at the power source, position the positive-negative switch on the power source to correspond to the polarity of the electrode cable connection. Refer to LN-9 operating manual for required polarity connections.

- N.A. Welding cables must be of proper capacity for the current and duty cycle of immediate and future applications.
- N.B. Extend lead 21 using #14 (2.5 mm²) or larger insulated wire physically suitable for the installation. An S16586-[] remote voltage sensing work lead is available for this purpose. Connect it directly to the work piece keeping it separate from the welding work cable connection to work piece. For convenience, this extended #21 lead should be taped along the welding work cable. (This extended #21 lead connection replaces the need to employ the remote work lead accessory on LN-9's which have a direct work lead jack.)
- N.C. Tape up bolted connection.
- N.D. Connect the LN-9 control cable ground lead to the frame terminal marked \oplus near the power source terminal strip. The power source must be properly grounded.
- N.E. If using an older automatic control cable with leads 75, 76, 77; Connect lead 75 to #75 on terminal strip, connect lead #76 to #74 on terminal strip, connect lead #77 to #73 on terminal strip.
- N.F. The LN-9 voltage control jumpers must be connected as follows (Refer to LN-9 operating manual): White jumper on voltage board to pin "S". Blue jumper on voltage board (later units only) or on start board (earlier units). To pin "B".
- N.G. Set the DC-1000 controls as follows: Set the control switch to "Output Control Remote". For Submerged Arc Processes, set the mode switch to "C.V. Innershield".
- N.H. Alternative 500 amp positive terminal connection provided on DC-1000 models above code 9500 only.

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KEY	PART NUMBER	DESCRIPTION	QTY
	P-720-A	Index of Sub Assemblies	AR
	P-720-B.2	Miscellaneous Items	AR
1	P-720-C_2	Case Front & Control Box	AR
2	P-720-D	Case Back Assembly	AR
3	P-720-E	Base Fan Roof and Case Sides	AR
4	P-720-F	Output Rectifier & Choke Assembly	AR
5	P-720-G	Lift Bale & Transformer Assembly	AR
6	P-720-H	S78 Contactor	AR

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P-720-A.jpg

Miscellaneous Items

KEY	PART NUMBER	DESCRIPTION	QTY
	9ST13260-4	DECAL-EARTH GROUND CONN	1
	9ST14798-1	IDENTIFICATION STICKER (CR1)	1
	9SS13504	DECAL-CAUTION	1
	9ST13470-3	DECAL-WARNING	1
	9SL8064-1	WARNING DECAL (INTERNATIONAL)	1
	9ST14753	INSTRUCTION DECAL	1
	9ST13259-4	GROUNDING DECAL	1

Miscellaneous Items

**NO IMAGE
AVAILABLE**

No Image

Case Front & Control Box

KEY	PART NUMBER	DESCRIPTION	QTY
	9SL7521-15	CASE FRONT WELDED ASBLY	1
1A	9SL7517-1	CASE FRONT SUPPORT	1
1B	9SL7517-2	CASE FRONT SUPPORT	1
1C	9SL9006	CONTROL BOX WELDED ASBLY	1
1G	9SM15391-2	LOUVER	3
1H	9SM15391-3	LOUVER	1
1J	9SL9005	OUTPUT PANEL	1
	9SS8025-91	SELF TAPPING SCREW	9
1L	9SM17097	OUTPUT STUD COVER ASBLY	1
12	9SS8025-92	SELF TAPPING SCREW	2
12	9SS8025-92	SELF TAPPING SCREW	2
2A	9SM14301	CONTROL BOX PARTITION	1
	9SS8025-91	SELF TAPPING SCREW	9
3	9ST14614-1	UNIVERSAL BUSHING	1
4A	9SS16656-4	OUTPUT TERMINAL ASBLY	5
4B	9SS9225-30	THREAD FORMING SCREW (CUTTING)	10
4C	9ST3960	FLANGE NUT	5
5A	9SS9225-36	THREAD FORMING SCREW (CUTTING)	1
5B	9ST9695-1	LOCKWASHER	1
	9SS9262-27	PLAIN WASHER	2
	9SCF000010	#10-24HN	2
6A	9SG8396-1	Control P.C. Board	1
	9SS9225-76	SELF TAPPING SCREW	3
7A	9SG5685-1	FIRING PC BD ASBLY	1
	9SS9225-76	SELF TAPPING SCREW	3
8A	9SS14293-8	RELAY	1
15C	9SS8025-62	SELF TAPPING SCREW	2
	9ST12286-4	IDENTIFICATION STICKER (4CR)	1
9A	9SS14293-12	RELAY	1
15C	9SS8025-62	SELF TAPPING SCREW	2
	9ST12286-2	IDENTIFICATION STICKER (2CR)	2
10A	9SM14312-1	OUTPUT SNUBBER PC BD ASBLY	1
10B	9SS8025-97	SELF TAPPING SCREW	2
11	9ST12380-1	BUSHING	1

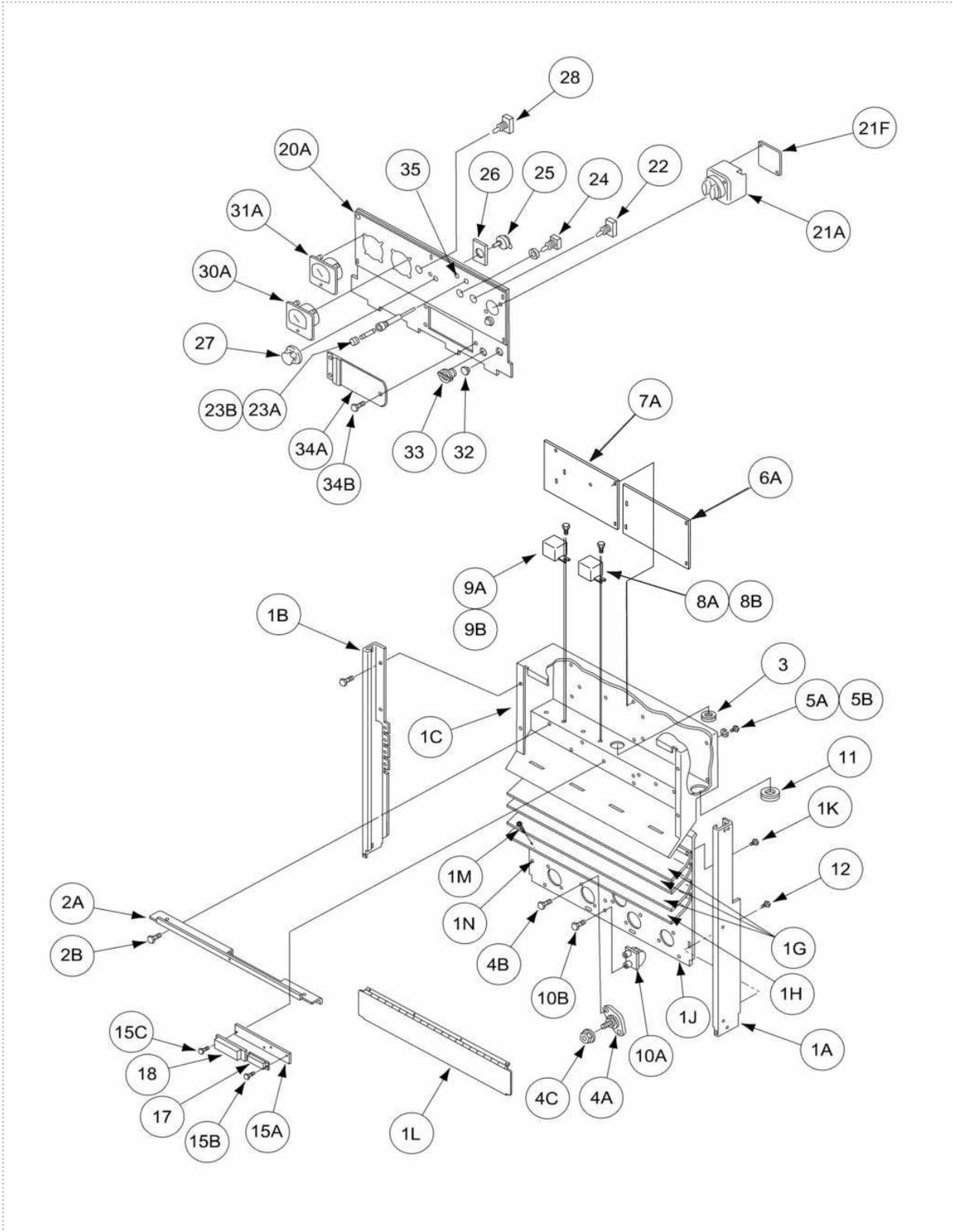
Case Front & Control Box

KEY	PART NUMBER	DESCRIPTION	QTY
12	9SS8025-92	SELF TAPPING SCREW	2
	9ST13260-4	DECAL-EARTH GROUND CONN	1
	9SS20641	OUTPUT TERMINAL DECAL	1
15A	9SS17160	NUMBER PLATE	1
15B	9SS8025-15	SELF TAPPING SCREW	2
15C	9SS8025-62	SELF TAPPING SCREW	2
	9ST14689	TERMINAL STRIP GASKET	1
17	9SS8542-7	TERMINAL STRIP	1
18	9SS14530-11	TERMINAL STRIP	1
	9SL9000	CONTROL BOX COVER	1
20A	9SL8237-3	Nameplate	1
	9SS8025-91	SELF TAPPING SCREW	9
21A	9SM6574-A	PUSH BUTTON ASBLY	1
	9SCF000104	#10-24X2.00RHS	2
	9SE106A-1	LOCKWASHER	2
	9SCF000154	#10-24SQN	2
	9SCF000108	#6-32X.375PRHS	5
21F	9ST8660	BOTTOM COVER	1
22	9ST10800-39	SWITCH-TOGGLE	1
23A	9SS10433-1	FUSE-HOLDER15A	1
23B	9ST10728-16	FUSE	1
24	9ST13381-4	SWITCH	1
25	9ST10812-122	POTENTIOMETER	1
26	9ST12792-1	INSULATION	1
27	9ST10491	KNOB	1
28	9ST13562-1	TOGGLE SWTICH	1
	9ST13486	PILOT LIGHT	1
30A	9SM20968-3A	DC AMMETER	1
	9SS9262-39	PLAIN WASHER	4
	9SCF000002	#4-40HN	4
	9ST4291-B	LOCKWASHER	4
31A	9SM20967-1A	DC VOLTMETER	1
	9SS9262-39	PLAIN WASHER	4
	9SCF000002	#4-40HN	4

Case Front & Control Box

KEY	PART NUMBER	DESCRIPTION	QTY
	9ST4291-B	LOCKWASHER	4
32	9ST13597-1	PLUG BUTTON	1
33	9ST9639-1	CLAMP	1
34A	9SS17293	ACCESS DOOR ASBLY	1
34B	9SS8025-65	SELF TAPPING SCREW	3
	9SS27359	METER SPACER	2
35	9ST13486-2	PILOT LIGHT	1

Case Front & Control Box



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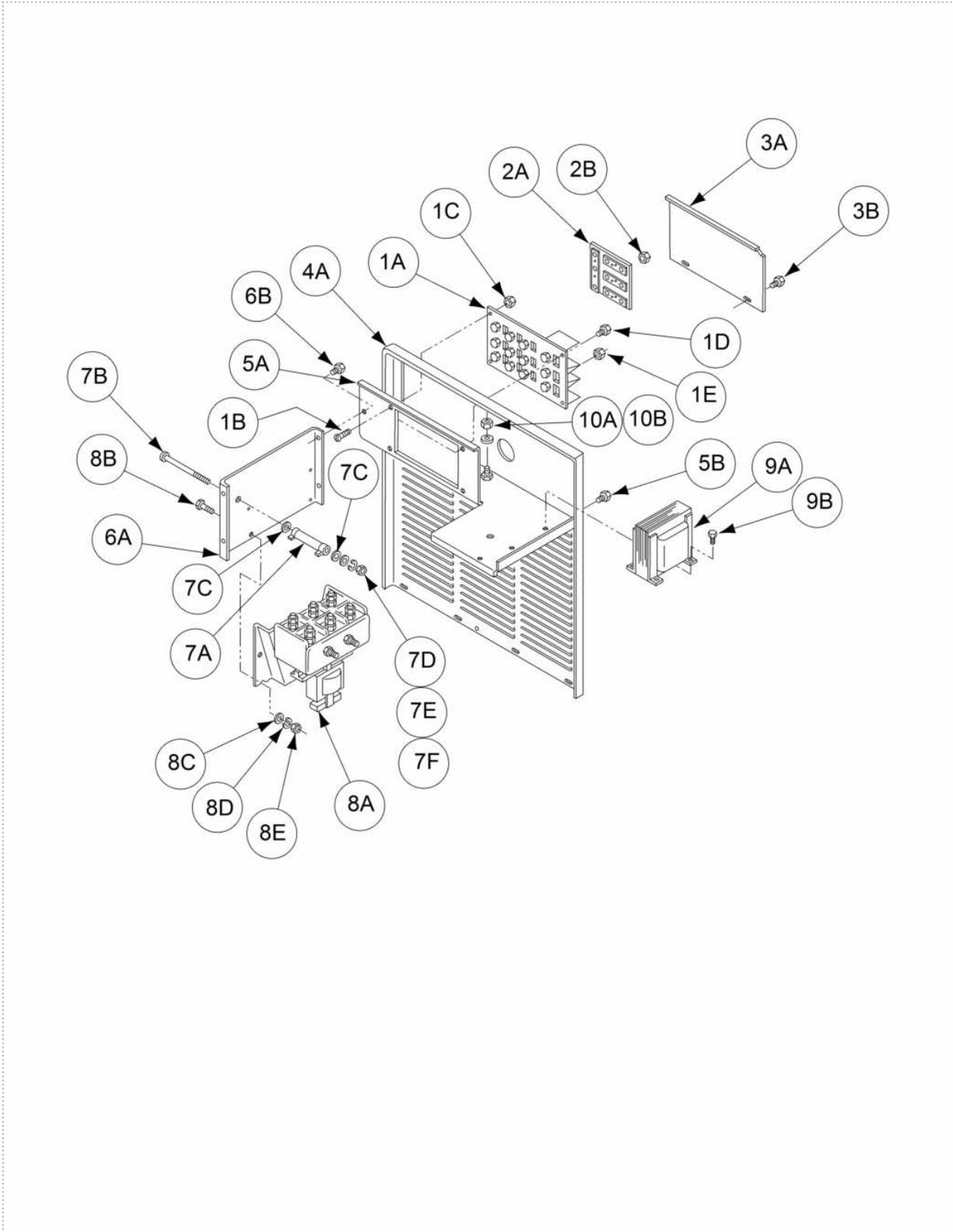
Case Back Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
1A	9SM13544	STATIONARY RECONNECT PANEL ASBLY	1
1B	9SS8025-92	SELF TAPPING SCREW	3
1C	9ST10082-3	SEMS SCREW	1
7F	9SCF000010	#10-24HN	1
1E	9ST10940-4	HEX JAM NUT	3
	9SS9262-4	PLAIN WASHER	3
2A	9SS16215	MOVABLE RECONNECT PANEL ASBLY	1
	9ST14190	RECONNECT PANEL LINK	9
	9ST14723	PRI CONNECTION LEAD	4
8E	9SCF000017	1/4-20HN	4
8C	9SS9262-98	PLAIN WASHER	2
8D	9SE106A-2	LOCKWASHER	4
	9SCF000012	1/4-20X.50HHCS	4
8E	9SCF000017	1/4-20HN	4
2B	9SCF000067	3/8-16HN	9
3A	9SM13448-2	INPUT ACCESS DOOR	1
5B	9SS8025-65	SELF TAPPING SCREW	3
4A	9SS16223-1	REAR PANEL REWORKING	1
5B	9SS8025-65	SELF TAPPING SCREW	3
5A	9SL5951	INPUT BOX & GROUND SCREW ASBLY	1
5B	9SS8025-65	SELF TAPPING SCREW	3
6A	9SM13589	CONTACTOR MTG PANEL	1
6B	9SS9225-8	THREAD FORMING SCREW (ROLLING)	4
7A	9SS10404-83	RESISTOR - FIXED WIREWOUND	1
7B	9SCF000045	#10-24X5.00RHS	1
7C	9SS10773-7	INSULATING WASHER	2
7D	9SS9262-27	PLAIN WASHER	1
7E	9SE106A-1	LOCKWASHER	1
7F	9SCF000010	#10-24HN	1
8A	9SL6200-36A	CONTACTOR ASBLY-W/O NVR COIL	1
	9SS1-9	NVR COIL	1
8B	9SCF000013	1/4-20X.625HHCS	4
8C	9SS9262-98	PLAIN WASHER	2
8D	9SE106A-2	LOCKWASHER	4

Case Back Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
8E	9SCF000017	1/4-20HN	4
9A	9SM12390-21	TRANSFORMER ASBLY	1
9B	9SS8025-91	SELF TAPPING SCREW	4
10A	9SS9262-121	PLAIN WASHER	2
10B	9SCF000029	5/16-18HN	1
	9SS24579-15	Rating Plate	1
	9SM12390-72	TRANSFORMER ASBLY	1

Case Back Assembly



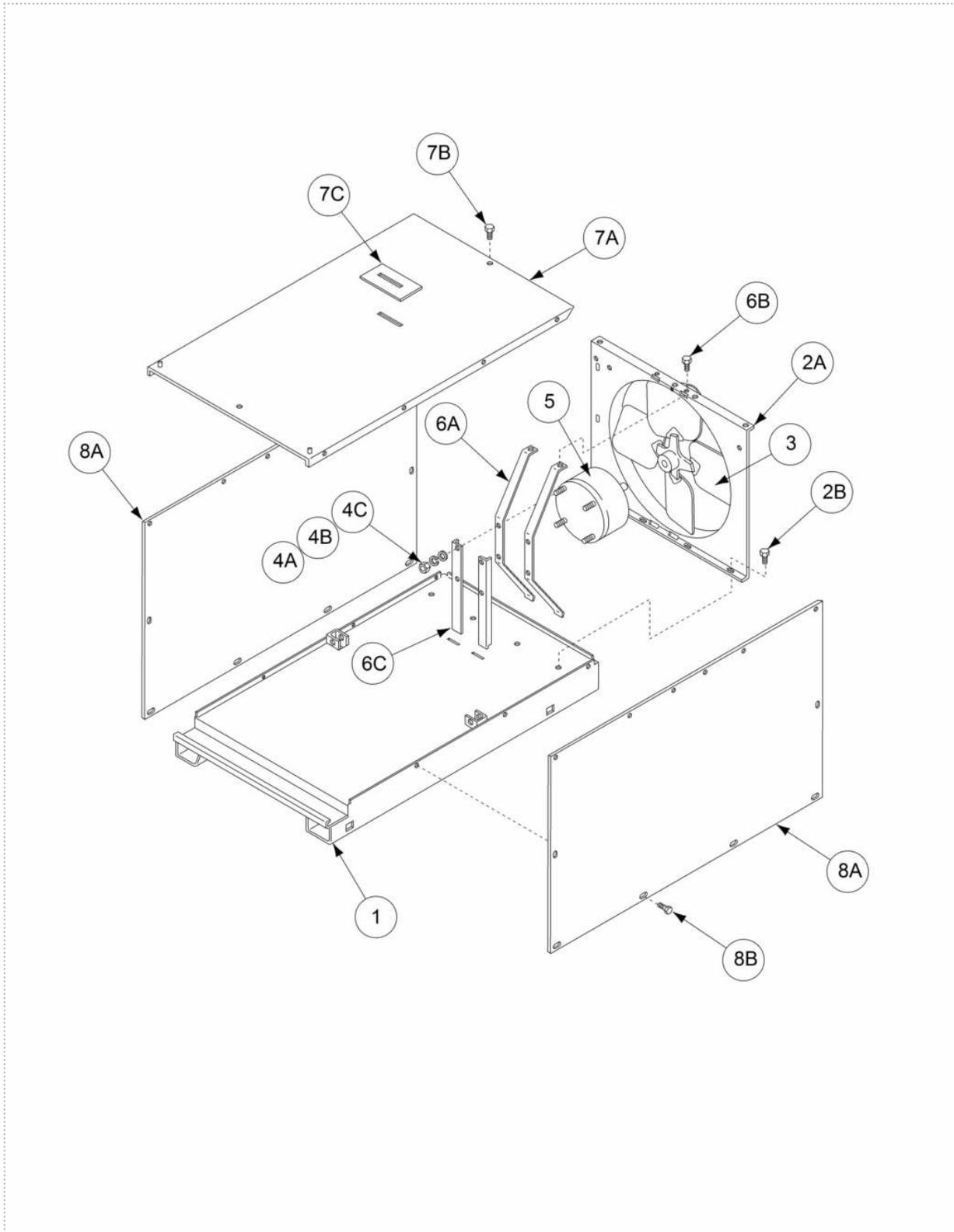
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Base, Fan, Roof and Case Sides

KEY	PART NUMBER	DESCRIPTION	QTY
1	9SL6598-1	BASE WELDED ASBLY	1
2A	9SL6247	FAN BAFFLE	1
8B	9SS8025-65	SELF TAPPING SCREW	12
3	9SM6819-12	FAN	1
4A	9SCF000011	10-32HN	4
	9SCF000042	#8-32HN	4
4B	9SE106A-1	LOCKWASHER	4
4C	9SS9262-27	PLAIN WASHER	4
5	9SM9983-6	FAN MOTOR	1
6A	9SM16525-2	FAN MOTOR MOUNTING BRACKET	2
6B	9SS8025-110	SELF TAPPING SCREW	2
7A	9SM12352-17	ROOF ASBLY	1
8B	9SS8025-65	SELF TAPPING SCREW	12
7C	9SS12934	COVER SEAL	1
8A	9SM14065-8	CASE SIDE	2
8B	9SS8025-65	SELF TAPPING SCREW	12

Base, Fan, Roof and Case Sides



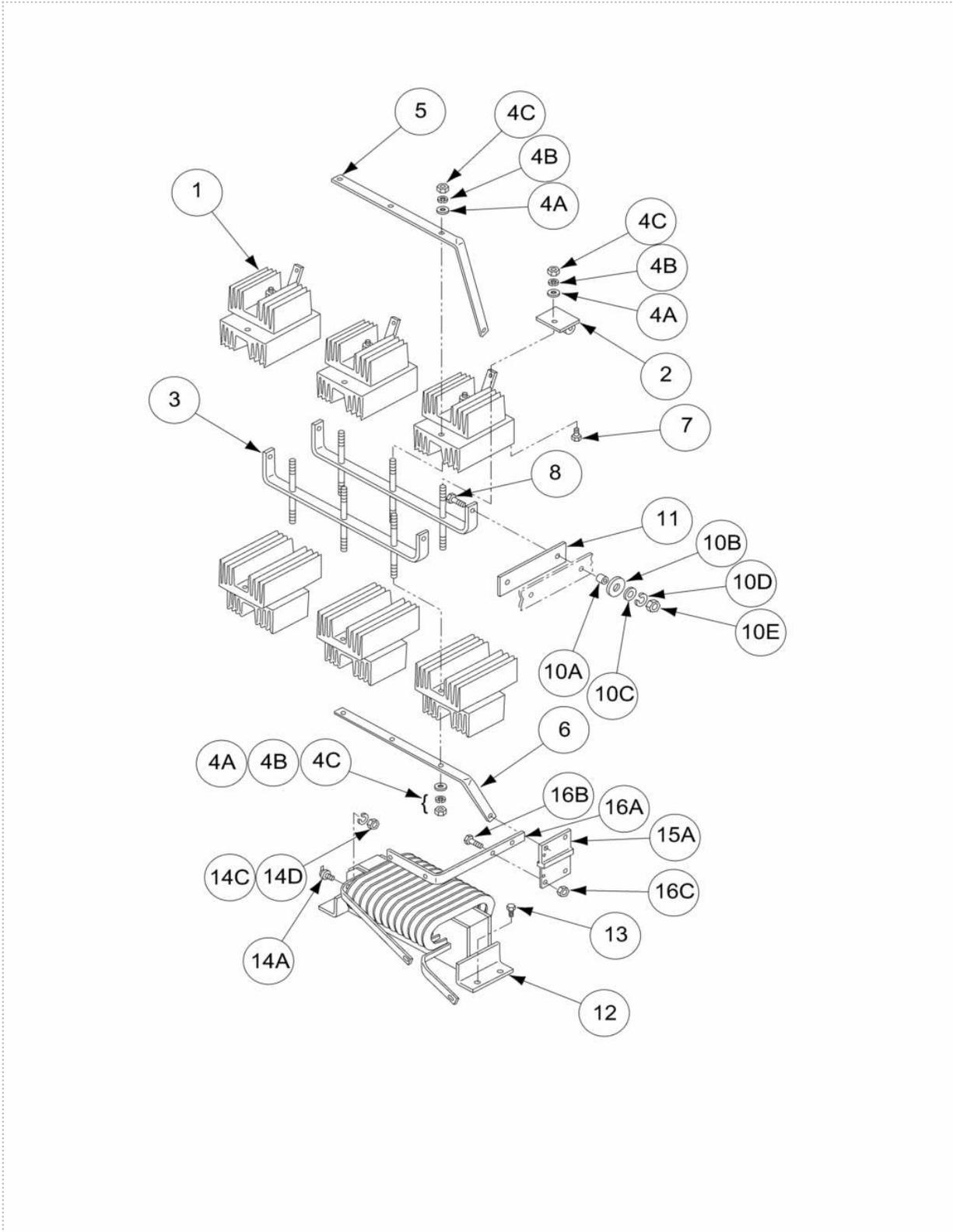
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Output Rectifier & Choke Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
	9SM16986	OUTPUT RECTIFIER ASBLY	1
1	9SM14604-1	SCR HEAT SINK ASBLY	6
2	9SS17163	SNUBBER ASBLY	6
3	9SS17154	HEAT SINK MTG BRKT ASBLY	2
10C	9SS9262-4	PLAIN WASHER	4
10D	9SE106A-16	LOCKWASHER	4
16C	9SCF000067	3/8-16HN	2
5	9SM14286-3	LEAD (SHUNT TO RECTIFIER)	1
6	9SM14286-4	LEAD (SHUNT TO RECTIFIER)	1
7	9SS8025-12	SELF TAPPING SCREW	7
8	9SCF000105	3/8-16X1.25HHCS	4
	9SS18250-270	PLUG & LEAD ASSEMBLY	1
10A	9ST7028-205	INSULATING TUBE	4
10B	9SS10773-19	INSULATING WASHER	4
10C	9SS9262-4	PLAIN WASHER	4
10D	9SE106A-16	LOCKWASHER	4
16C	9SCF000067	3/8-16HN	2
11	9ST11357-17	INSULATION	2
12	9SL9007	CHOKE ASBLY	1
13	9SS9225-26	THREAD FORMING SCREW (ROLLING)	4
14A	9ST13359-8	THERMOSTAT	1
	9SS9262-3	PLAIN WASHER	1
14C	9SE106A-13	LOCKWASHER	1
14D	9SCF000005	#6-32HN	1
15A	9SS17152	SHUNT ASBLY	1
	9SCF000018	3/8-16X.625HHCS	2
	9SCF000315	3/8-16HN	2
16A	9SM16987	LEAD (SHUNT TO POSITIVE OUTPUT)	1
16B	9SCF000034	3/8-16X.75HHCS	2
16C	9SCF000067	3/8-16HN	2

Output Rectifier & Choke Assembly



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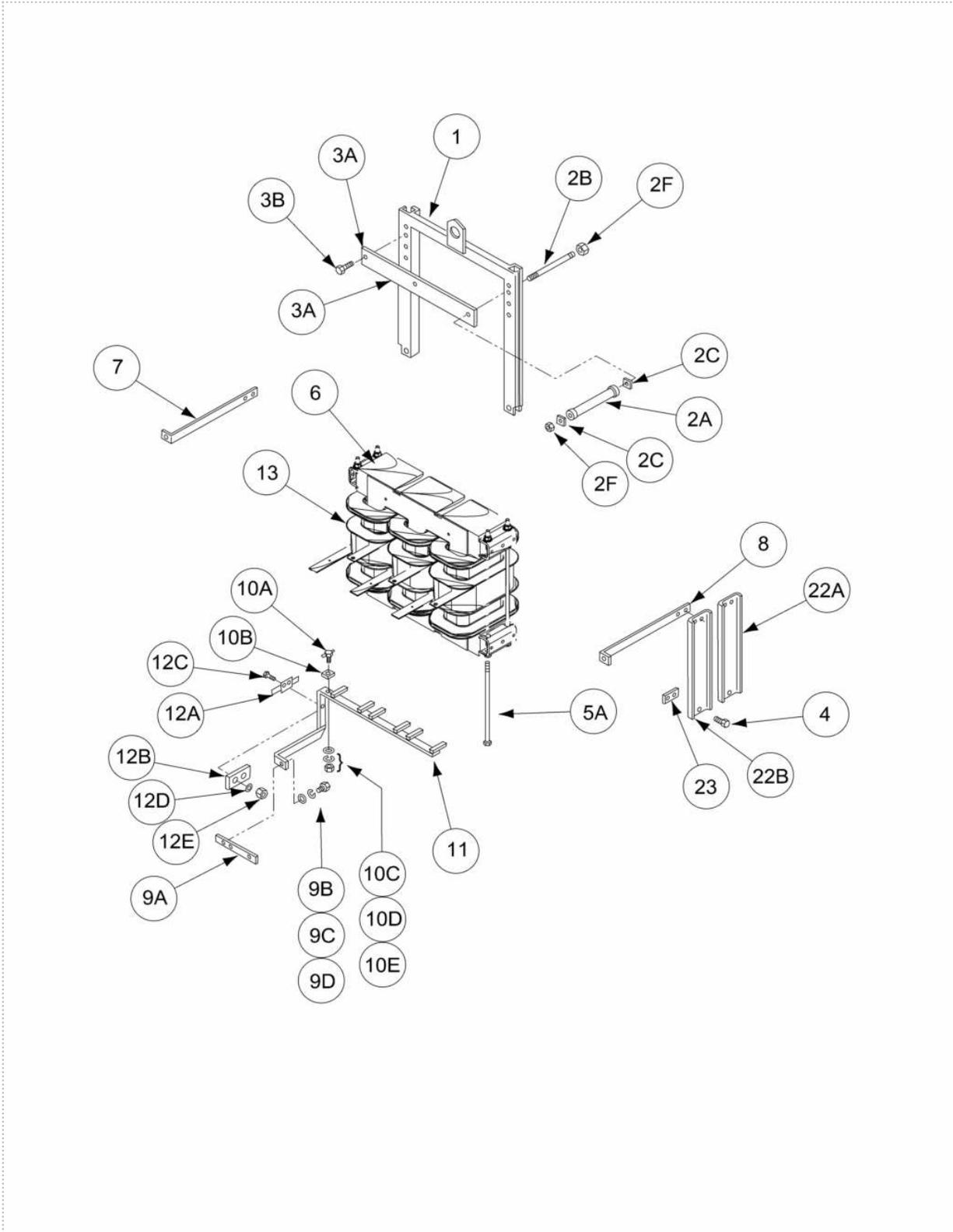
Lift Bale & Transformer Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
1	9SL6600	LIFT BALE ASBLY	1
2A	9SS10404-118	RESISTOR-WW300W3010%	1
2B	9ST9781-34	THRU BOLT	1
2C	9ST9764-6	INSULATOR	2
	9SS9262-98	PLAIN WASHER	1
	9SE106A-2	LOCKWASHER	1
2F	9SCF000017	1/4-20HN	2
3A	9SS17301	LIFT BALE BAFFLE	1
4	9SS9225-26	THREAD FORMING SCREW (ROLLING)	16
4	9SS9225-26	THREAD FORMING SCREW (ROLLING)	16
5A	9ST9781-45	MOUNTING STUD	6
	9SE106A-5	LOCKWASHER	6
	9SCF000027	1/2-13HN	12
7	9SM14292-1	OUTPUT RECTIFIER MTG BRKT	1
8	9SM14292-2	OUTPUT RECTIFIER MTG BRKT	1
9A	9SS20646	OUTPUT STUD JUMPER	1
9B	9SS9262-1	PLAIN WASHER	1
9C	9SE106A-15	LOCKWASHER	1
9D	9SCF000344	HEX HD SCREW	1
10A	9ST13359-2	THERMOSTAT	1
10B	9ST14779	THERMOSTAT INSULATION	1
10C	9SS9262-3	PLAIN WASHER	1
10D	9SE106A-13	LOCKWASHER	1
10E	9SCF000005	#6-32HN	1
11	9SM16988	NEGATIVE OUTPUT LEAD	1
12A	9SS12334-53	REED SWITCH ASBLY	1
12B	9SS11797-15	REED SWITCH PLATE	1
12C	9SCF000096	#8-32X.75RHS	2
12D	9ST4291-A	LOCKWASHER	2
12E	9SCF000042	#8-32HN	2
	9ST12286-3	IDENTIFICATION STICKER (3CR)	1
	9ST8970-17	LEAD CLAMP	2
	9SL9008-1	Wiring Diagram	1
	9SM14358	Input Connection Diagram	1

Lift Bale & Transformer Assembly

KEY	PART NUMBER	DESCRIPTION	QTY
	9SL6616-7	TRANSFORMER AND LIFT BALE ASBLY	1
13	9SL9002-4	Complete Transformer Assembly	1
	9SS16333	PRI-SEC INSULATION	6
22A	9SS17156-1	TRANS SIDE BRACKET	2
22B	9SS17156-2	TRANS SIDE BRACKET	2
23	9SS16090-3	MISC. FLAT	2

Lift Bale & Transformer Assembly

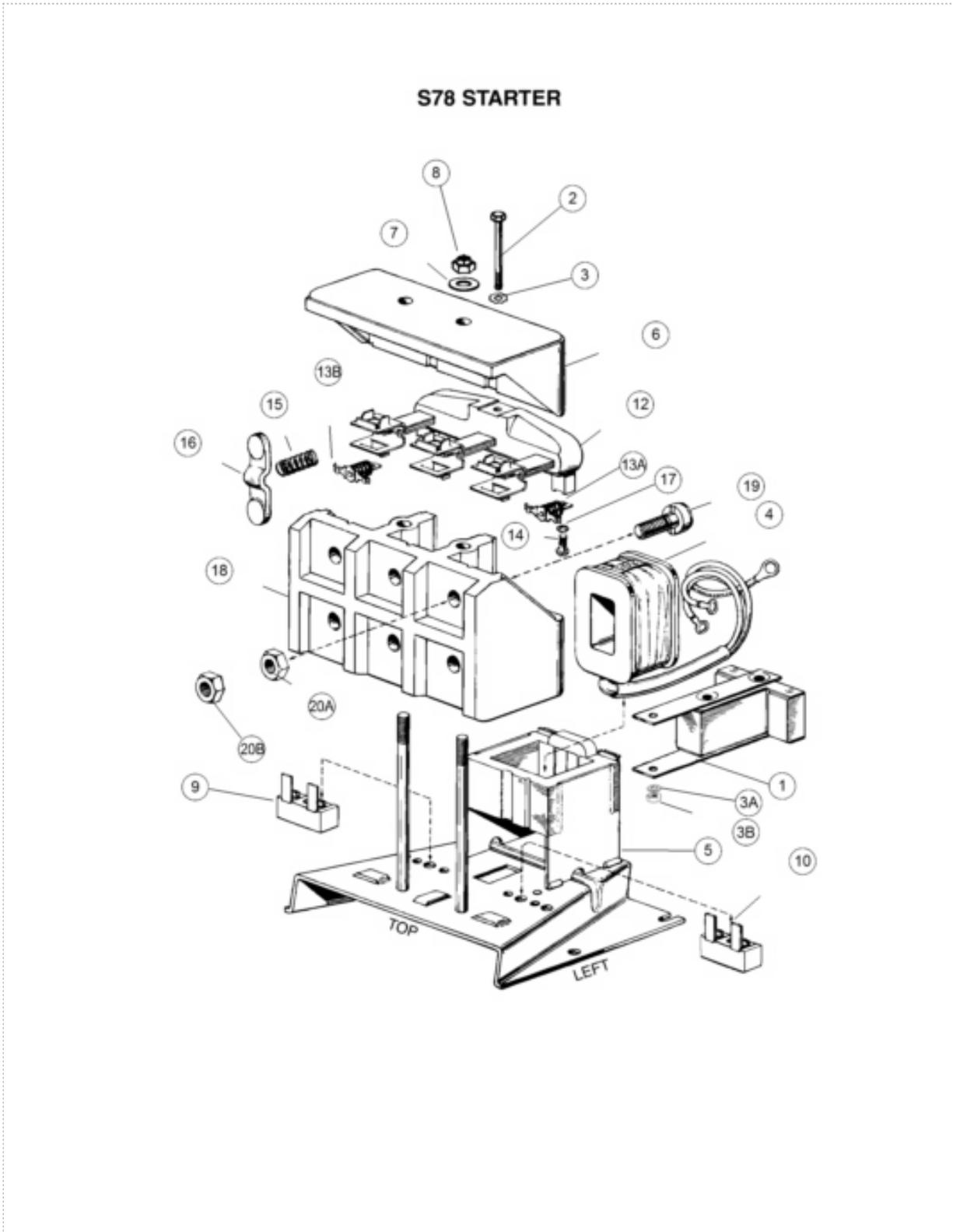


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S78 Contactor

KEY	PART NUMBER	DESCRIPTION	QTY
	9SL6200-36A	CONTACTOR ASBLY-W/O NVR COIL	1
1	9SS12851	MOVING LAMINATION ASBLY	1
2	9ST9031	SCREW	1
3	9ST9695-1	LOCKWASHER	1
3A	9SE106A-1	LOCKWASHER	1
3B	9SCF000011	10-32HN	1
4	9SS1-9	NVR COIL	1
5	9SM6888-9	MTG PANEL ASBLY	1
	9SS10425	GUIDE	1
6	9SM13771	CONTROL BLOCK COVER	1
7	9SS9262-121	PLAIN WASHER	2
8	9ST9187	LOCKNUT	2
10	9ST9453	INTERLOCK BLOCK ASBLY	1
	9SM6893-45	MOVING CONTACT ASBLY	1
12	9SM6892-D	CONTACT BASE ASBLY	1
13A	9ST9036	INTERLOCK ASBLY	1
14	9SCF000004	#6-32X.50RHS	As Req
15	9ST9029	SPRING	As Req
16	9ST9865-2R	MOVING CONTACT ASBLY	As Req
17	9SE106A-13	LOCKWASHER	As Req
	9SM13866-8	CONTACT BLOCK ASBLY	1
18	9SL6097	MAIN CONTACT BLOCK	1
19	9SS8029-3	CONTACT	As Req
20A	9ST10940-3	HEX JAM NUT	As Req

S78 Contactor



			
WARNING	<ul style="list-style-type: none"> Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground. 	<ul style="list-style-type: none"> Keep flammable materials away. 	<ul style="list-style-type: none"> Wear eye, ear and body protection.
Spanish AVISO DE PRECAUCION	<ul style="list-style-type: none"> No toque las partes o los electrodos bajo carga con la piel o ropa mojada. Aislese del trabajo y de la tierra. 	<ul style="list-style-type: none"> Mantenga el material combustible fuera del área de trabajo. 	<ul style="list-style-type: none"> Protéjase los ojos, los oídos y el cuerpo.
French ATTENTION	<ul style="list-style-type: none"> Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension. Isolez-vous du travail et de la terre. 	<ul style="list-style-type: none"> Gardez à l'écart de tout matériel inflammable. 	<ul style="list-style-type: none"> Protégez vos yeux, vos oreilles et votre corps.
German WARNUNG	<ul style="list-style-type: none"> Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung! Isolieren Sie sich von den Elektroden und dem Erdboden! 	<ul style="list-style-type: none"> Entfernen Sie brennbares Material! 	<ul style="list-style-type: none"> Tragen Sie Augen-, Ohren- und Körperschutz!
Portuguese ATENÇÃO	<ul style="list-style-type: none"> Não toque partes elétricas e electrodos com a pele ou roupa molhada. Isolate-se da peça e terra. 	<ul style="list-style-type: none"> Mantenha inflamáveis bem guardados. 	<ul style="list-style-type: none"> Use proteção para a vista, ouvido e corpo.
Japanese 注意事項	<ul style="list-style-type: none"> 通電中の電気部品、又は溶材にヒフやぬれた布で触れないこと。 施工物やアースから身体が絶縁されている様にして下さい。 	<ul style="list-style-type: none"> 燃えやすいものの側での溶接作業は絶対にしてはなりません。 	<ul style="list-style-type: none"> 目、耳及び身体に保護具をして下さい。
Chinese 警告	<ul style="list-style-type: none"> 皮肤或湿衣物切勿接触带电部件及焊条。 使你自已与地面和工件绝缘。 	<ul style="list-style-type: none"> 把一切易燃物品移离工作场所。 	<ul style="list-style-type: none"> 佩戴眼、耳及身体劳动保护用具。
Korean 위험	<ul style="list-style-type: none"> 전도체나 용접봉을 젖은 헝겍 또는 피부로 절대 접촉치 마십시오. 모재와 접지를 접촉치 마십시오. 	<ul style="list-style-type: none"> 인화성 물질을 접근시키지 마십시오. 	<ul style="list-style-type: none"> 눈, 귀와 몸에 보호장구를 착용하십시오.
Arabic تحذير	<ul style="list-style-type: none"> لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسد الجسم أو بالملابس المبللة بالماء. ضع عازلا على جسمك خلال العمل. 	<ul style="list-style-type: none"> ضع المواد القابلة للاشتعال في مكان بعيد. 	<ul style="list-style-type: none"> ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.

READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.

SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.

LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.

LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.

			
<ul style="list-style-type: none"> ● Keep your head out of fumes. ● Use ventilation or exhaust to remove fumes from breathing zone. 	<ul style="list-style-type: none"> ● Turn power off before servicing. 	<ul style="list-style-type: none"> ● Do not operate with panel open or guards off. 	WARNING
<ul style="list-style-type: none"> ● Los humos fuera de la zona de respiración. ● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases. 	<ul style="list-style-type: none"> ● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio. 	<ul style="list-style-type: none"> ● No operar con panel abierto o guardas quitadas. 	Spanish AVISO DE PRECAUCION
<ul style="list-style-type: none"> ● Gardez la tête à l'écart des fumées. ● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail. 	<ul style="list-style-type: none"> ● Débranchez le courant avant l'entretien. 	<ul style="list-style-type: none"> ● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés. 	French ATTENTION
<ul style="list-style-type: none"> ● Vermeiden Sie das Einatmen von Schweißrauch! ● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes! 	<ul style="list-style-type: none"> ● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!) 	<ul style="list-style-type: none"> ● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen! 	German WARNUNG
<ul style="list-style-type: none"> ● Mantenha seu rosto da fumaça. ● Use ventilação e exaustão para remover fumo da zona respiratória. 	<ul style="list-style-type: none"> ● Não opere com as tampas removidas. ● Desligue a corrente antes de fazer serviço. 	<ul style="list-style-type: none"> ● Mantenha-se afastado das partes moventes. ● Não opere com os painéis abertos ou guardas removidas. 	Portuguese ATENÇÃO
<ul style="list-style-type: none"> ● ヒュームから頭を離すようにして下さい。 ● 換気や排煙に十分留意して下さい。 	<ul style="list-style-type: none"> ● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切して下さい。 	<ul style="list-style-type: none"> ● パネルやカバーを取り外したままで機械操作をしないで下さい。 	Japanese 注意事項
<ul style="list-style-type: none"> ● 頭部遠離煙霧。 ● 在呼吸區使用通風或排風器除煙。 	<ul style="list-style-type: none"> ● 維修前切斷電源。 	<ul style="list-style-type: none"> ● 儀表板打開或沒有安全罩時不準作業。 	Chinese 警告
<ul style="list-style-type: none"> ● 얼굴로부터 용접가스를 멀리하십시오. ● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오. 	<ul style="list-style-type: none"> ● 보수전에 전원을 차단하십시오. 	<ul style="list-style-type: none"> ● 판넬이 열린 상태로 작동치 마십시오. 	Korean 위험
<ul style="list-style-type: none"> ● ابعد رأسك بعيداً عن الدخان. ● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها. 	<ul style="list-style-type: none"> ● أقطع التيار الكهربائي قبل القيام بأية صيانة. 	<ul style="list-style-type: none"> ● لا تشغيل هذا الجهاز اذا كانت الاغطية الحديدية الواقية ليست عليه. 	Arabic تحذير

LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有關勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

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