

118-009, 82020, PCS20, 3W722

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Item	Lincoln Stock #	Customer #	Description
1	NLA	410-589-166	Front Panel
2	312-067-666	312-067-666	Foot
3	216-086-666	216-086-666	Fan Motor
4	316-007-300	316-007-666	Fan Blade
5	NLA	412-300-666	Fan Mounting Bracket
6		413-045-666	Axle, 3/8" X 15 5/8"
7		413-046-666	Wheel, 6" X 1.25 (1.5 hub)
8	880-027-666	880-027-666	Resistor, 5Ω, 50 watt
9	246-199-666	246-199-666	Relay
10		880-106-888	Control Transformer
11	244-076-666	244-076-666	Rectifier
12	S15599-2	248-216-666	Powercord 12/3, 7'
13	246-165-666	246-165-666	Main Contactor
14	245-105-666	245-105-666	2Ω, 420 Watt Resistor
15	NLA	880-129-888	Reactor coil
16	NLA	880-128-888	Main Transformer
17	NLA	880-031-666	Wire Harness (9-pin)
18	NLA	880-127-666	Wire Harness (10-pin)
19	880-102-666	880-102-666	Circuit Board
20		252-003-666	Air pressure switch
21	246-086-666	246-086-666	Solenoid

Model	Primary Input	Input Plug	Duty Cycle at Rated Output
118-009	230V, 35 amp	50A	20%

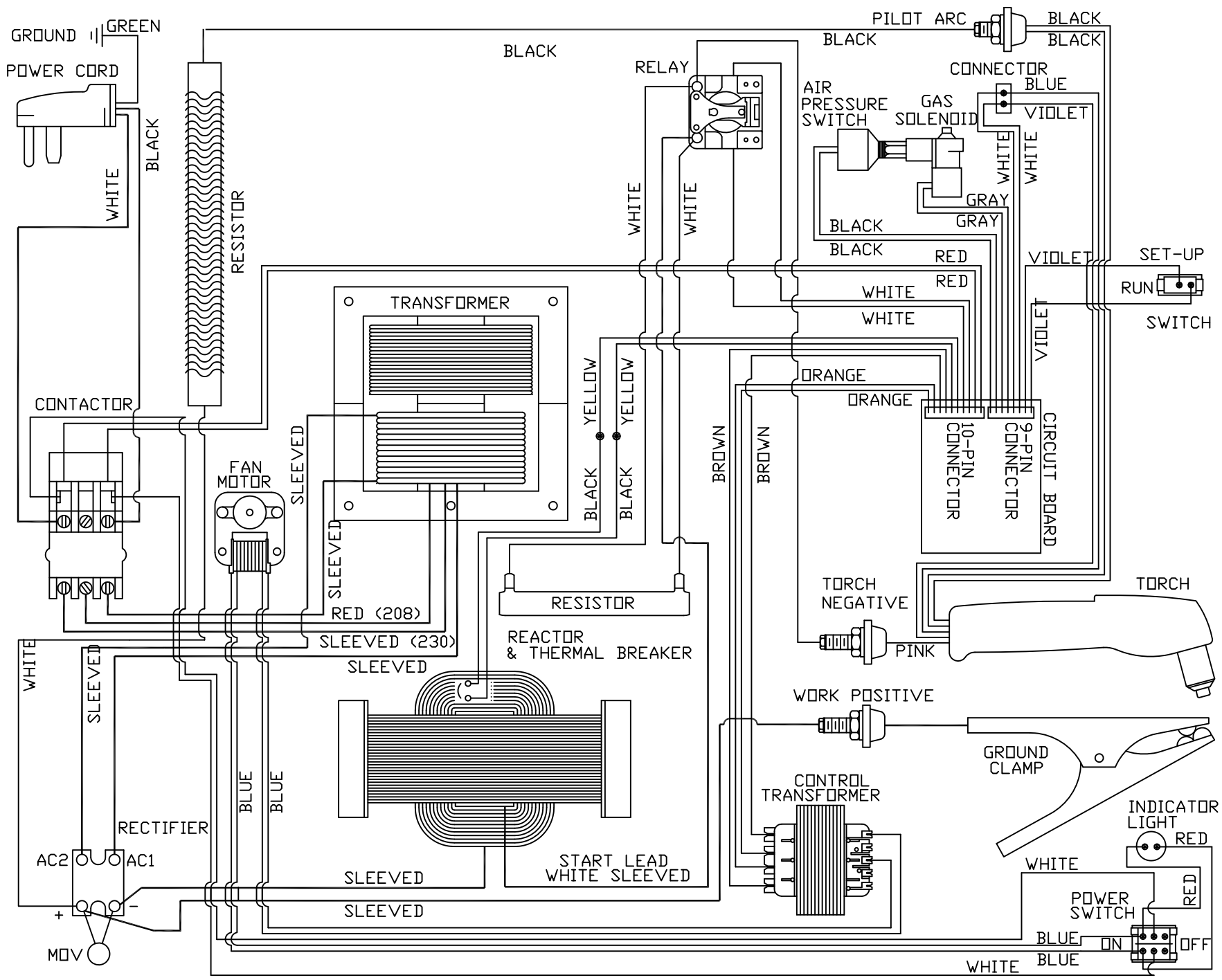
Item	Lincoln Stock #	Customer #	Description
22		253-069-666	Nylon Adapter
23		246-163-666	Power Switch, DPST
24		245-078-666	Indicator Light
25		246-164-666	Run/Setup Switch, SPDT
26	254-004-666	254-004-666	Regulator
27	NLA	412-299-666	Nose Support Plate
28		251-003-666	Pressure Gauge
29	NLA	312-098-666	Molded Nose
30	S11609-18	238-244-666	Ground Cable (9') only
	M12033	41007	Ground Clamp only
31	238-240-100	238-240-100	15' Torch Assembly
32	NLA	410-926-010	Base

Not Shown

33	NLA	440-151-156	Cover
34	412-750-666	442-020-166	Handle
35		512-087-908, 44050	O-Rings (2)
36	334-278-908	44220	Swirl Ring
37	334-277-908	44200	Electrodes (5)
38	334-279-908	44210	Nozzles (5)
39	334-280-908	44230	Nozzle Cap
40		44160 (131-280-906)	Standoff
41		239-029-300, 40210	6-50R 230V Receptacle

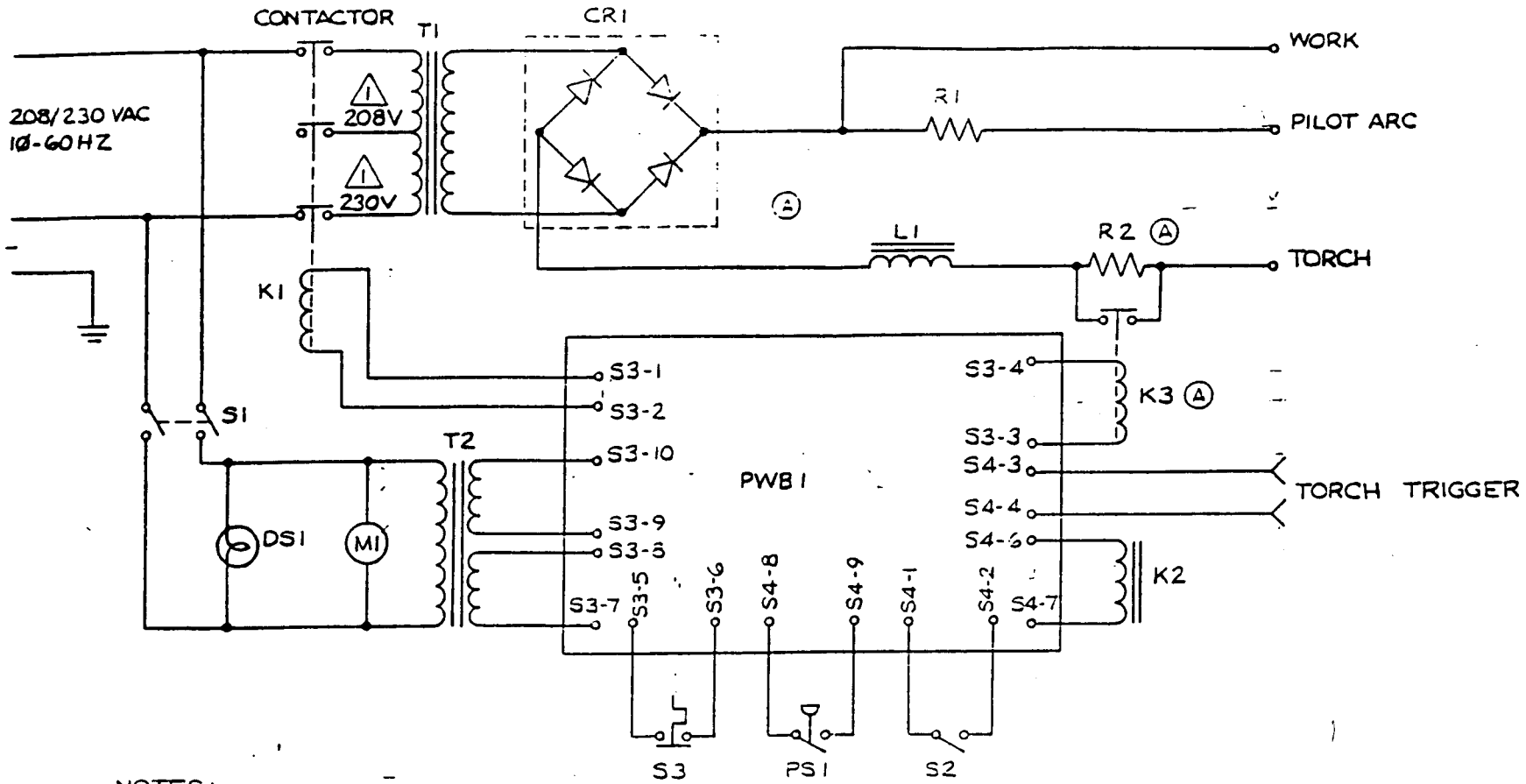
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Rated Output	Voltage Settings	Agency Listing	Max Output
20 amps	1	CSA	20 amps



118-008,009,010

WIRING DIAGRAM



NOTES:

⚠ SHOWN WIRED FOR 230V OPERATION. FOR 208V OPERATION EXCHANGE WIRES INDICATED AT CONTACTOR.

118-009 Schematic Legend

Symbol Description

CR1	Rectifier, 40a, 600v
K1	Contactator, 40a, 3 pole, 24vac coil
K2	Gas Solenoid, 24vac coil
K3	Contactator, 30a, spst, 24vdc coil
L1	Reactor coil, 55mh, 20a
M1	Fan Motor, 230vac
PS1	Pressure switch, 55psi to close
PWB1	Control circuit board
R1	Resistor, 2 Ω , 420 watt
R2	Resistor, 5 Ω , 50 watt
S1	Power Switch, spst
S2	Run/set up switch, spst
S3	Thermal breaker
T1	Main cutting transformer
T2	Control transformer, 230vac to 24vac and 20vac