

Idealarc® R3R-400 & 500

Processes

Stick, TIG, Gouging

Product Number

K1285-16 R3R-400 230/460
K1286-16 R3R-500 230/460
K1286-25 R3R-500 230/460/575

See back for complete specs

Input Power (Voltage/Phase/Hertz)

K1285-16/K1286-16: 230/460/3/60
K1286-25: 230/460/575/3/60

Input Current at Rated Output

(60% Duty Cycle)
R3R-400: 74/37A
R3R-500: 88/44A

Rated Output

R3R-400: 400A/36V/60% Duty Cycle
R3R-500: 500A/40V/60% Duty Cycle

Output Range

R3R-400: 60-500A, Max. OCV: 67V
R3R-500: 72-625A, Max. OCV: 67V

Weight/Dimensions (H x W x D)

R3R-400: 402 lbs. (183 kg)
R3R-500: 446 lbs. (203 kg)
27.5 x 22.3 x 32 in.
(699 x 566 x 813 mm)

Heavy Duty Stick Welding and Arc Gouging

Look to the R3R-400 and R3R-500 for your heavy duty stick welding needs. Whether you are using cellulosic, low hydrogen, stainless steel or hardfacing electrodes, the Idealarc® R3R-400 and R3R-500 produce a smooth, quality arc for consistent results day-in and day-out.

FEATURES

- ▶ **Substantial amperage ranges** include the R3R-400 at 60-500 amps and the R3R-500 at 72-625 amps.
- ▶ **Easy to operate** - Calibrated current control knob makes procedure setting simple and easy.
- ▶ **Polarity switch, voltmeter and ammeter are standard** on the K1285-16 R3R-400 and K1286-16 R3R-500.
- ▶ **Arc gouge** with the R3R-400 using up to 5/16 in. (7.9 mm) diameter carbon electrode and the R3R-500 using up to 3/8 in. (9.5 mm) diameter carbon electrode.
- ▶ **Smooth arc** - Makes it easy to weld with mild steel, low hydrogen, stainless steel and hardfacing electrodes.
- ▶ **Stackable case design** - With built-in lift hook allows for easy storage and handling. Machines can be safely stacked three high to conserve floor space.



- ▶ **Both the R3R-400 and R3R-500 can be used for limited DC TIG welding** – Simply add TIG accessories and shielding gas.
- ▶ **Seven-year warranty** on the power rectifier.

INPUT



OUTPUT



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



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Undercarriage
Platform undercarriage with mounting for two gas cylinders at rear of welder.
Order K841



Work Lead Package
15 ft. (4.5 m) 4/0 cable with 1/2 in. (12.7 mm) stud lug and work clamp.
Order K2149-1



Arc Tracker™
Connect the Arc Tracker™ between any DC welding power source and the work clamp to access a wide array of data monitoring information regarding your welding arc, including True Energy™ and Production Monitoring™.
Order K3019-1



Welding Fume Extractors
Lincoln Electric offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.
Request Publication MC08-70

STICK OPTIONS



Accessory Kit – 400 Amp
For stick welding. Includes 35 ft. (10.7 m) 2/0 electrode cable with lug, 30 ft. (9.1 m) 2/0 work cable with lugs, headshield, filter plate, work clamp and electrode holder.
Order K704



Remote Output Control
For remote output of welding voltage. Consists of control box with 25 or 100 ft. (7.6 or 30 m) of four conductor cable and 6 pin MS-type connector.
Order K857 for 25 ft. (7.6 m)
Order K857-1 for 100 ft. (30 m)



TIG OPTIONS

Pro-Torch™ TIG Torch
A full line of air-cooled and water-cooled torches available.
Request Lincoln Electric publication E12.150



TIG Module
Portable, high frequency unit with gas valve for TIG welding. Rated at 300 amps/60% duty cycle. Requires TIG Module Control Cable.
Order K930-2



Docking Kit
Provides a means to “dock” the TIG Module on top of a flat surface measuring at least 10 x 15 in. (254 x 381 mm). Includes a latch and provisions for a user-supplied padlock to lock the TIG Module in place.
Order K939-1



Hand Amptrol™
Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6-pin plug connection). Velcro straps secure torch.
Order K963-3 (One size fits all Pro-Torch™ TIG Torches.)



Foot Amptrol™
Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).
Order K870



Contactor Kit
Installs in the K930-2 TIG Module for use with welders without a contactor. Makes the TIG torch electrode electrically “cold” until the Amptrol™ is activated.
Order K938-1



Control Cable
Connects TIG Module to power source.
Order K936-3 for 9-pin to 6-pin plus 115V.



Control Cable Extension
Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. Available in 45 ft. (13.7 m) sections.
Order K937-45



Deluxe Adjustable Gas Regulator & Hose Kit
Accommodates CO₂, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.
Order K586-1

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® R3R-400	K1285-16	230/460/3/60	400A/36V/60%	74/37A	60-500A Max. OCV: 67V	27.5 x 22.3 x 32 (699 x 566 x 813)	402 (183)
Idealarc® R3R-500	K1286-16 K1286-25	230/460/3/60 230/460/575/3/60	500A/40V/60%	88/44A	72-625A Max. OCV: 67V		446 (203)

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

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.