STICK WELDING RANGE

INVERTEC® 150S / 170S / 160SX / 165S / 165SX / V270 S 2V / 270SX / 400SX
LINC 405-S / 405-SA / 406 / 635-S / 635-SA
HOT ROD 500S

www.lincolnelectric.eu

LINCOLN® ELECTRIC

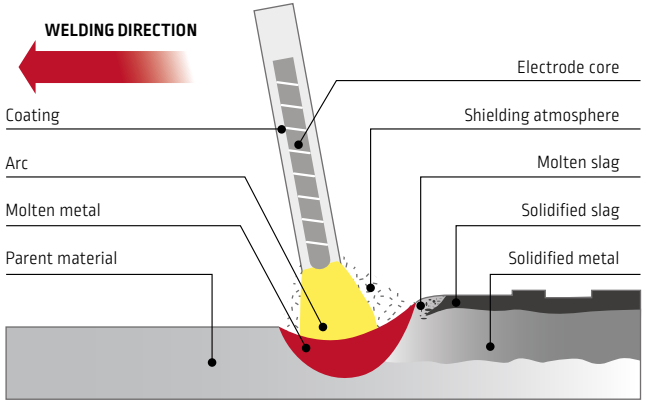
MMA PROCESS

In this welding process, an electric arc is created between a coated consumable electrode and the workpiece to be welded, causing the parent material to fuse and the electrode to melt. The electrode is of a similar material to the parent material, and melting both together provides the weld (or joint) with a reinforcing filler material. The electrode has a flux coating of either basic, rutile or cellulose type. As the coating burns, it protects the arc and weld pool from the surrounding atmosphere with a gaseous shroud. The slag which solidifies over the newly deposited weld also protects it from the atmosphere while cooling.

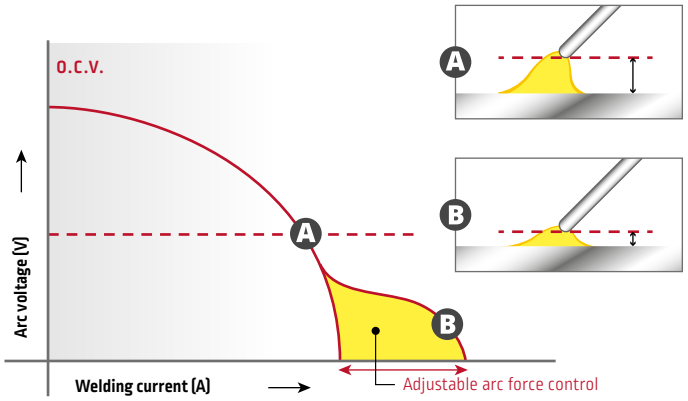
Advantages:

- For general purpose welding
- All positions
- Easy to use
- With excellent start and restart properties
- Smooth weld appearance
- Producing few spatters

Manual Metal Arc Welding



Arc Force Control



FEATURES

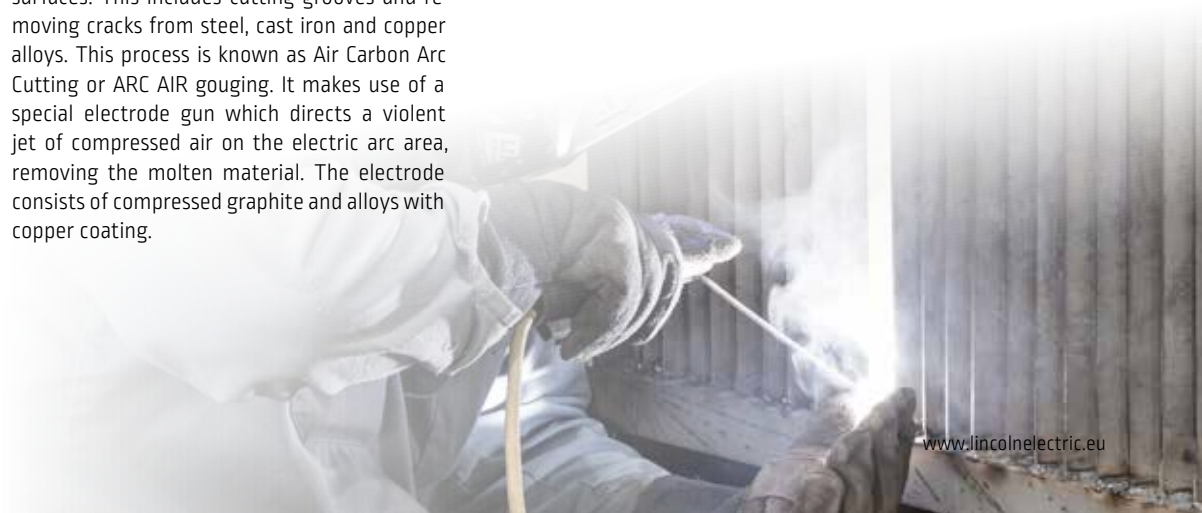
Arc Force
This prevents the electrode from sticking during welding. Arc force is a temporary increase of the output current during welding when the arc is too short. This feature supports production with consistently excellent arc performance. It also enhances simple position welding, making the job easier. In order to achieve an outstanding weld performance on a variety of electrodes (Rutile, Basic or Cellulose), the Arc Force can be finely adjusted with a simple knob. To have a smooth arc with fewer spatters, set the knob to minimum (Rutile, Basic). For a crisper arc, with more penetration, set it to maximum.

Hot start
This is a temporary increase of the output current (0,5s) during the start of a weld, which helps ignite the arc quickly and reliably. Hot Start provides excellent arc ignition avoiding the electrode sticking and any matallurgical default in the weld.

Anti-sticking
This electronic device minimizes the short circuit current in the event of the electrode sticking to the workpiece for a prolonged period. If a short circuit does occur, it will be easy to remove the electrode from the workpiece, and the electrode gun and cable will remain undamaged. It also serves as a safety device while protecting the operator.

AIR ARC GOUGING

An industrial stick welder with adequate power and voltage load can be used to cut and remove surfaces. This includes cutting grooves and removing cracks from steel, cast iron and copper alloys. This process is known as Air Carbon Arc Cutting or ARC AIR gouging. It makes use of a special electrode gun which directs a violent jet of compressed air on the electric arc area, removing the molten material. The electrode consists of compressed graphite and alloys with copper coating.



STICK RANGE

	Product	Reference	Voltage (V)	Frequency (Hz)	Phase	Fuse Size (A) (slow)	No load voltage	Display	PFC	Current Range DC	Electrode diameter	Warranty (Years)	Weight (kg)	Rated Output	Protection Class
Inverter	**Invertec® 150S**	K12034-1	230	50 / 60	1	17	45			10-140	3,2	2	6,7	140A / 25,6V@25% 80A / 25,6V@100%	IP23 / F
	Invertec® 150S Pack	K12034-1-P													
	Invertec® 170S	K12035-1	230	50 / 60	1	23	45	•		10-160	4	2	7	160A / 26,4V@20% 80A / 24,0V@ 100%	IP23 / F
	Invertec® 170S Pack	K12035-1-P													
	Invertec® 160SX	K12050-1	115 / 230	50 / 60	1	16	48	•	•	5-160	4	3	9	160A / 24V@15% 100A / 26,4V@100%	IP23 / H
	Invertec® 165S	K14171-1	230	50 / 60	1	16	48			5-160 / 10-160	4	2	7	160A@20% / 160A@30% 100A@60% / 140A@60%	IP23
	Invertec® 165SX	K14170-1	230	50 / 60	1	16	48		•		4	2	7		IP23
	Invertec® V270 S 2V	K12022-3	230 / 400	50 / 60	3	35 / 20	48	•		5-270	5	2	13,5	270A / 30,8V@35% 200A / 28V@100%	IP23S / H
	Invertec® 270SX	K12040-1	400	50 / 60	3	20	45	•		5-270	5	3	22		IP23 / H
	Invertec® 400SX	K12042-1	400	50 / 60	3	30	45	•		5-400	6,3	3	36	400A / 36V@35% 300A / 32V@100%	IP23 / H
Conventional	**LINC 405-S**	K14002-2	230 / 400	50 / 60	3	63 / 40	78			15-400	6,3	3	126	400A / 36V@35% 240A / 29V@100%	IP23 / H
	LINC 405-SA	K14002-1						•							
	LINC 406	K14104-1	230 / 380 / 440	50 / 60	3	63 / 40 / 32	78	•		40-400	6,3	3	135	400A / 36V@35% 240A / 29V@100%	IP23 / H
	LINC 635-S	K14038-2	230 / 400	50 / 60	3	100 / 63	78			15-670	6,3	3	150	670A / 44V@35% 400A / 36V@100%	IP23 / H
	LINC 635-SA	K14038-1						•							
	HOT ROD 500S	K14089-1	380 / 415	50 / 60	3	63		•		50-625	6,3	3	203	600A/44V/35% 375A/35V/100%	IP23 / H

INVERTEC® 150S

Small, powerful and robust

- Robust design – Unique rubber corners, metal housing and push control buttons to withstand tough environmental conditions.
- Premium arc – Advanced Lincoln technology and knowhow guarantee performance every time.
- Power Surplus – Additional power for superior arc control.
- Soft and Crisp mode – Selectable arc modes for different electrode types.
- Auto Adaptive Arc Force – For stable arc with low spatter levels as standard.

Input

1 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, Lift TIG

Applications

- Small maintenance
- Light construction
- Light metal fabrication
- Repair on site
- Outside and workshop welding jobs
- Hobby

Unit Includes
Input cable (2 m)

Unit Includes (K12034-1-P)
Suitcase with cables
Shield
Brush

THE LINCOLN ELECTRIC GREEN INITIATIVE
Inverter Technology reduces energy demand
www.lincolnelectric.com/green

INVERTEC® 170S

Small, powerful and robust

- Robust design – Unique rubber corners, metal housing and push control buttons to withstand tough environmental conditions.
- Premium arc – Advanced Lincoln technology and knowhow guarantee performance every time.
- Power Surplus – Additional power for superior arc control.
- Soft and Crisp mode – Selectable arc modes for different electrode types.
- Auto Adaptive Arc Force – For a stable arc with low spatter levels as standard.

Input

1 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, Lift TIG

Applications

- Small maintenance
- Light construction
- Light metal fabrication
- Repair on site
- Outside and workshop welding jobs

Unit Includes (K12035-1)
Input cable (2 m)

Unit Includes (K12035-1-P)
Suitcase with cables
Shield
Hammer
Brush

THE LINCOLN ELECTRIC GREEN INITIATIVE
Inverter Technology reduces energy demand
www.lincolnelectric.com/green

Product	Reference	Primary Voltage (50-60Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
Invertec® 150S	K12034-1	230V / 1Ph	140A / 25,6V@25% 80A / 25,6V@100%	10-140	17	6,7	244 x 148 x 365	IP23 / F
Invertec® 150S Pack ready to weld	K12034-1-P							
Invertec® 170S	K12035-1		160A / 26,4V@20% 80A / 24,0V@ 100%	10-160	23	7		
Invertec® 170S Pack ready to weld	K12035-1-P							

INVERTEC® 160SX

Professional Performance Industrial Innovation

- More Power- 30% more output current with the same input current allows welding with up to 4,0mm electrode from a 16A input.
- Portable Everywhere – Lightweight, easy to handle; able to operate with up to 100m mains extension cables and suitable to use with a generator.
- Robust Design, Industrial Use – Electrical safety (IP23), potted PC boards and optimum airflow reduces contamination to extend the equipment's lifespan in the harshest environmental conditions.
- Excellent Welding Experience – Good arc ignition with a smooth stable arc, Soft and Crisp mode, Auto Adaptive Arc Force – an optimal choice for welding with every type of electrode.
- Cellulosic Capability – No electrode is too difficult to weld with. Suitable for small diameter pipe welding.

Input

1 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY | PFC

Processes

Stick, Lift TIG,
EL Cellulosic

Applications

- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Light industry
- Pipeline repair

Unit Includes

Input cable (2 m)

THE LINCOLN ELECTRIC GREEN INITIATIVE
Inverter Technology reduces energy demand
www.lincolnelectric.com/green

INVERTEC® 165S & 165SX

Professional performance, industrial perfection

- Exceptional performance: high duty cycle at 40 °C.
- Easy to use: Hot Start function to improve the arc striking and Arc Force function to avoid electrode sticking.
- Versatile: welding with any coated electrode (except cellulosic) and LIFT TIG (165SX).
- Compatible with motor-generators.
- Power Factor Correction (PFC) for 165SX. PFC delivers low current consumption, energy saving, low current harmonics and the reduction of the total CO_2 produced by the welding process.
- Lightweight: less than 9 kg.
- Handy: thanks to the handy carrying strap.

Input

1 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, TIG Scratch (165S),
Lift TIG (165SX)

Applications

- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Process industry

Unit Includes

Input cable (3 m)

THE LINCOLN ELECTRIC GREEN INITIATIVE
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Product	Reference	Primary Voltage (50-60Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
Invertec® 160SX	K12050-1	115 / 230V / 1Ph PFC	160A / 24V@15% 100A / 26,4V@100%	5-160	16	9	389 x 247 x 489	IP23 / H
Invertec® 165S	K14171-1	230V / 1Ph	160A@20% / 160A@30% 100A@60% / 140A@60%	5-160 / 10-160		7	265 x 162 x 385	IP23
Invertec® 165SX	K14170-1							

INVERTEC® V270 S 2V

Powerful portability, robust reliability

- Smart switching 230 / 400V three phase.
- Excellent arc characteristics.
- Maximum output of 270 amps allows the use of electrodes up to 6,0 mm.
- Excellent rutile, basic and cellulosic stick welding performance.
- Adjustable "Arc Force" and "Hot Start" as standard.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, EL cellulosic, Lift TIG DC

Applications

- Pipeline
- Heavy fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry

Unit Includes
Input cable (2 m)
Carrying strap

THE LINCOLN ELECTRIC GREEN INITIATIVE
Inverter Technology reduces energy demand
www.lincolnelectric.com/green

INVERTEC® 270SX & 400SX

Professional welder built for tough working conditions

- Robust, built for heavy environmental conditions.
- Fully featured and user-friendly control panel with digital display allows precise setting of welding current.
- Soft and Crisp multiple arc modes for different electrode types.
- Auto Adaptive Arc force standard in Soft and Crisp modes: the automatic variable Arc Force operates when required.
- Adjustable Hot Start and Arc Force allow a smooth start / restart of the electrode and prevent sticking of the electrode in the weld pool.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, Lift TIG, Gouging (400SX)

Applications

- Heavy fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging (400SX)

Unit Includes
Input cable (2 m)

THE LINCOLN ELECTRIC GREEN INITIATIVE
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Product	Reference	Primary Voltage (50-60Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
Invertec® V270 S 2V	K12022-3	230 / 400V / 3Ph	270A / 30,8V@35% 200A / 28V@100%	5-270	35 / 20	13,5	385 x 215 x 480	IP23S / H
Invertec® 270SX	K12040-1	400V / 3Ph			20	22	389 x 247 x 502	IP23 / H
Invertec® 400SX	K12042-1		400A / 36V / 35% 300A / 32V / 100%	5-400	30	36	455 x 301 x 632	

COSNISTENCY – the same control of the entire range

	LINC-405S	LINC-405SA	LINC-406	LINC-635S	LINC-635SA	HOT ROD 500S
	K14002-2	K14002-1	K14104-1	K14038-2	K14038-1	K14038-2
Hot Start Control (Potentiometer)	preset	●	●	preset	●	preset
Arc Force Control (Potentiometer)	preset	●	●	preset	●	●
A meter	–	●	●	–	●	optional KIT
V meter	–	–	●	–	–	optional KIT
Local/Remote Switch	●	●	●	●	●	●
Desert duty	–	–	–	–	–	●
Output Current Control Range Switch	–	–	–	–	–	●

LINC® 405-S Control Panel

LINC® 635-S Control Panel

LINC® 406 Control Panel

LINC® 405-SA Control Panel

LINC® 635-SA Control Panel

HOT ROD 500S Control Panel

LINC® 405-S & SA

The rugged and distinguished workhorses

- Rugged, conventional rectifier with excellent arc characteristics.
- Capable of welding with Rutile, Basic and Cellulosic electrodes.
- Arc gouging capability.
- Easy-to-understand, graphic control panels.
- Ready to be moved. Equipped with wheels, pull bar and two lifting hooks.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, EL cellulosic, Gouging

Applications

- Pipeline construction
- Heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging

Unit Includes

Input cable (5 m)

LINC® 406

The rugged and distinguished workhorse

- Rugged, conventional welding rectifier with excellent arc characteristics.
- Capable of welding with Rutile, Basic and Cellulosic electrodes.
- Arc gouging capability.
- Hot Start supporting excellent arc starting.
- Arc Force to prevent sticking of the electrode in the welding pool.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, EL cellulosic, Gouging

Applications

- Pipeline construction
- Heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging

Unit Includes

Input cable (5 m)

Product	Reference	Primary Voltage (50-60Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
LINC® 405-S	K14002-2	230 / 400V / 3Ph	400A / 36V@35% 240A / 29V@100%	15-400	63 / 40	126	640 x 580 x 700	IP23 / H
LINC® 405-SA (with Display)	K14002-1							
LINC® 406	K14104-1	220 / 380 / 440V / 3Ph	400A / 36V@35% 240A / 29V@100%	40-400	63 / 40 / 32	135	650 x 580 x 690	

LINC® 635-S & SA

The rugged and distinguished workhorses

- Rugged, conventional welding rectifier with excellent arc characteristics.
- Capable of welding with Rutile, Basic and Cellulosic electrodes.
- Arc gouging capability.
- Easy-to-understand, graphic control panels.
- Ready to be moved. Equipped with wheels, pull bar and two lifting hooks.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, EL cellulosic, Gouging

Applications

- Pipeline construction
- Heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging

Unit Includes

Input cable (5 m)

HOT ROD 500S

The tough and powerful professional welder

- Excellent arc characteristics for a wide range of electrode types.
- Maximum output of 625A allows the use of electrodes up to 6,3 mm and air carbon gouging with 8mm electrodes.
- Desert rating operating temperature of up to 55°C.
- Stackable case design with built-in hook. Easy storage and handling.

Input

3 PHASE | 50/60 Hz

Output

CC | DC | GENERATOR READY

Processes

Stick, Gouging, TIG scratch, EL Cellulosic

Applications

- Pipeline construction
- Very heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Tough industrial applications
- Arc-Air gouging

Unit Includes

Input cable (5 m)

Product	Reference	Primary Voltage (50-60Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
LINC® 635-S	K14038-2	230 / 400V / 3Ph	670A / 44V@35% 400A / 36V@100%	15-670	100 / 63	150	670 x 580 x 700	IP23 / H
LINC® 635-SA (with Display)	K14038-1							
HOT ROD 500S	K14089-1	380 / 415V / 3Ph	600A / 44V@35% 375A / 35V@100%	50-625	63	203	795 x 566 x 813	

STICK ELECTRODES

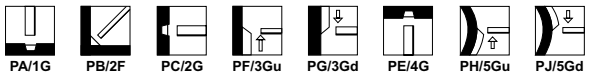
MILD STEEL STICK ELECTRODES

OMNIA®46

AWS A5.1: E6013
ISO 2560-A: E 38 0 R 1 1
AC / DC -

RUTILE (6013)

- Applicable for "clean" structural steel.
- Smaller dimentions – excellent for hobbyists.
- Very suitable for low open circuit voltage transformers (min. OCV 42 V).



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
OMNIA®46	2,0	300	400	4,2	609059
	2,5	350	253	4,8	609060
	3,2	350	181	5,3	609061
	3,2	450	154	6,2	609062
	4,0	350	111	5,0	609063
	4,0	450	97	5,9	609064
	5,0	450	58	5,8	609065

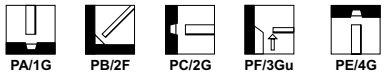
LINCOLN® 7016DR

AWS A5.1: E7016-H8
ISO 2560-A: E 38 3 B 1 2 H10
AC / DC +

BASIC (7016)

Double Coated Electrode

- Easy ignition, easy to restart – to restrike arc.
- Much easier vertical up vs basic electrode.
- Soft arc fusion, extremely good weldability.
- Few spatters, no need to rework, no sticking.
- Easier to weld especially with poor joint preparation.



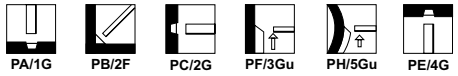
Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
LINCOLN® 7016 DR	2,5	350	600	3,90	829275
	3,2	350	375	4,10	829276
	3,2	450	375	5,30	829277
	4,0	450	240	5,20	829278

CONARC®49

AWS A5.1: E7018 H4
ISO 2560-A: E 46 3 B 42 H5
DC +

BASIC (7018)

- Universal basic electrode, most suitable for shipbuilding and light general construction work.
- Almost no spatter, nice wetting and full weld pool control.
- Perfect welding and 120% recovery contribute to high productivity.



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
CONARC®49	2,5	350	91	4,5	609266
	3,2	350	131	4,5	609267
	3,2	450	115	5,2	609309
	4,0	350	100	5,0	609268
	4,0	450	93	6,3	609269
	5,0	450	66	6,7	609270

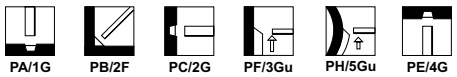
MILD STEEL STICK ELECTRODES

LINCOLN® 7018-1

AWS A5.1: E7018-1 H4R
ISO 2560-A: E 46 5 B 3 2 H5
AC / DC +

BASIC (7018-1)

- Excellent for general purpose welding.
- Good impact values: down to -50°C.



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
LINCOLN® 7018-1	2,5	350	172	4,0	619036
	3,2	350	110	4,0	619038
	3,2	450	116	5,5	619040
	4,0	350	76	4,0	619044
	4,0	450	81	5,5	619045

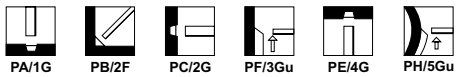
STAINLESS STEEL STICK ELECTRODES

LIMAROSTA® 304L

AWS A5.4: E308L-17
ISO 3581-A: E 19 9 L R 1 2
AC / DC + / -

304L / 308L

- Mirror-like bead appearance.
- Self-releasing slag.
- Good side wall fusion, no undercut.



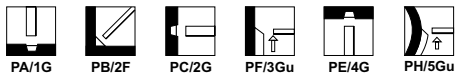
Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
LIMAROSTA® 304L	2,0	300	125	2,3	557312
	2,5	350	125	2,7	557329
	3,2	350	135	4,7	557367
	4,0	450	85	5,8	557398
	5,0	450	55	5,8	557404

LIMAROSTA® 316L

AWS A5.4: E316L-17
ISO 3581-A: E 19 12 3 L R 1 2
AC / DC + / -

316L

- Molybdenum level min. 2,7%.
- Mirror-like bead appearance.
- Self-releasing slag.
- Good side wall fusion, no undercut.



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
LIMAROSTA® 316L	2,0	300	200	2,3	557435
	2,5	350	125	2,7	557442
	3,2	350	135	4,8	557466
	4,0	450	85	5,9	557497
	5,0	450	55	5,9	557503

STAINLESS STEEL STICK ELECTRODES WITH LOW CR(VI) EMISSION RATE

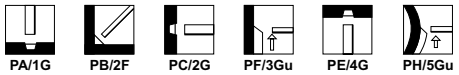
CLEAROSTA E 304L

AWS A5.4: E308L-17
ISO 3581-A: E 19 9 L R 22
DC+

304L / 308L

Double Coated Electrode

- High operator appeal and control due to the more stable and focused arc transfer.
- Reduced welding fumes (up to -40%) and lower hexavalent Cr content (up to -60%): improved working environment for all workers in the workshop.
- Suitable for root pass.
- Lower porosity, good striking and restriking, excellent slag removal.



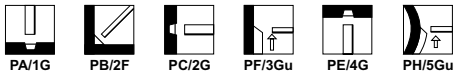
Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
CLEAROSTA E 304L	2,5	300	90	1,70	710001
	3,2	350	55	1,90	710002
	4	350	40	2,10	710003
	5	350	20	1,60	710004

CLEAROSTA E 316L

AWS A5.4: E316L-17
ISO 3581-A: E 19 12 3 L R 22
DC+

316L

Double Coated Electrode



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
CLEAROSTA E 316L	2,5	300	90	1,70	710009
	3,2	350	55	2,00	710010
	4	350	40	2,10	710011
	5	350	20	1,70	710012

STAINLESS STEEL STICK ELECTRODES FOR STEELS DIFFICULT TO WELD

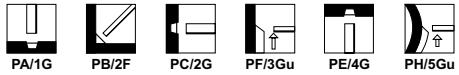
LIMAROSTA® 312

AWS A5.4: E312-17
ISO 3581-A: E 29 9 R 1 2
AC / DC +

312

- Excellent for repair welding.
- Especially developed for steels difficult to weld, such as armour plates, austenitic Mn-steels and high C-steels.
- Excellent weldability and self-releasing slag.

Also available in **Sahara ReadyPack®** – the best vacuum pack.



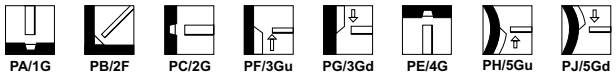
Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
LIMAROSTA® 312	2,0	300	175	2,2	539769
	2,5	350	125	2,6	557640
	3,2	350	150	5,0	557664
	4,0	350	100	5,0	557671

STICK ELECTRODES FOR REPAIR

REPTEC CAST 31

AWS A5.15: ENiFe-CI
ISO 1071: E C NiFe-CI 1
AC / DC -

- Electrode for repair welding of cast iron, malleable cast iron and cast iron to steel.
- The nickel-iron weld deposit is easily machinable.
- Particularly applicable for nodular cast iron.
- Hardness weld deposit ~ 180 HB.
- Excellent current-carrying capacity due to bi-metal core wire.



Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Item Number
REPTEC CAST 31	2,5	300	154	2,5	400915
	3,2	350	82	2,5	400922
	4,0	400	47	2,5	400939

GOUGING ELECTRODES

CARBONAIR

Pointed electrodes

Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Current Range (A)	Item Number
CARBONAIR	4,0	305	100	0,78	150-250	W000010645
	5,0	305	100	1,08	200-250	W000010443
	6,4	305	50	0,98	320-370	W000010444
	8,0	305	50	1,34	400-450	W000010445
	10,0	305	50	2,15	500-550	W000010446
	13,0	305	50	3,55	800-1000	W000010447

CARBONAIR PLUS

Jointed electrodes (no stub loss)

- This process requires a MMA direct current (DC) power source, a gouging torch and compressed air source.

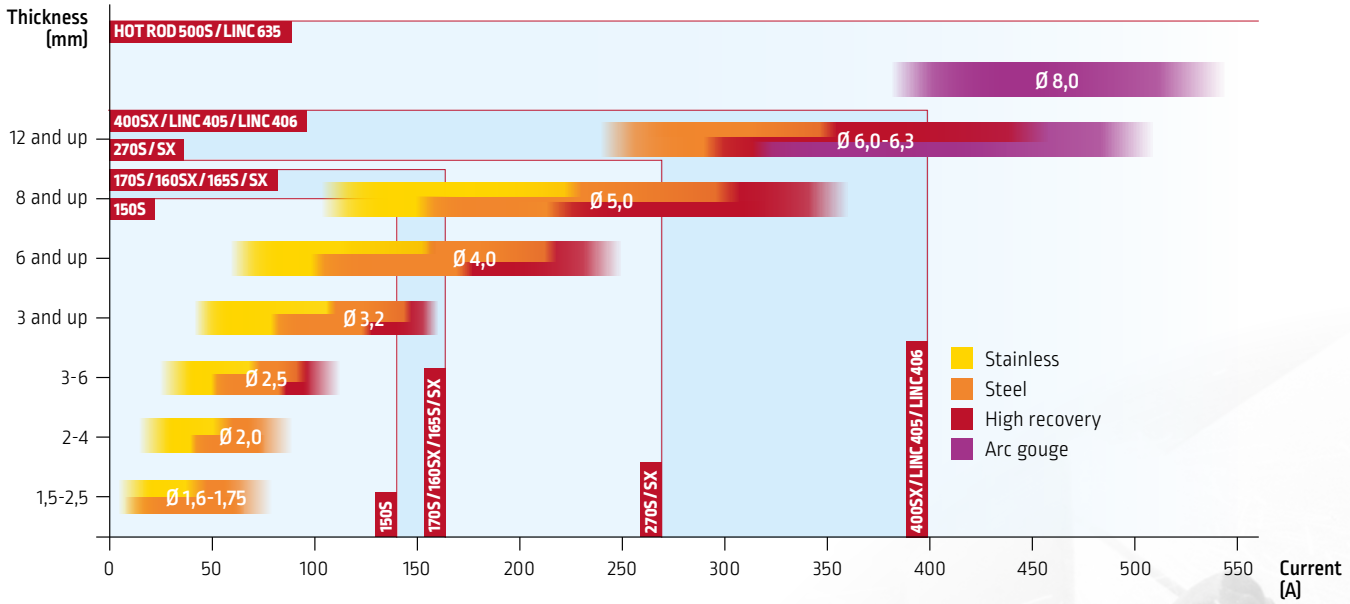
Product Name	Ø (mm)	Length (mm)	Quantity per pack	kg per pack	Current Range (A)	Item Number
CARBONAIR PLUS	8,0	355	50	1,80	500-550	W000010448
	10,0	430	50	3,22	600-650	W000010449
	13,4	430	50	4,97	800-1000	W000010450
	16,0	430	25	3,70	1000-1200	W000010451
	19,0	430	25	5,17	1200-1400	W000010452

CAUTION: before use, carefully read and understand the safety datasheet available on our websites.

ADVANTAGES OF ELECTRODE WELDING

- Easy to handle.
- Suitable to weld all types of metals.
- Universal – can be used anywhere, any time.
- The best choice for outdoor activities – welding with gas won't produce good results in windy conditions.
- Delivering quality welding and decent mechanical properties.
- Easy to learn.
- Relatively quiet.
- Inexpensive to procure.
- Insensible to contamination, such as rust, oil or grease.

PRODUCT APPLICATION CHART



HEAVY APPLICATIONS

Applications

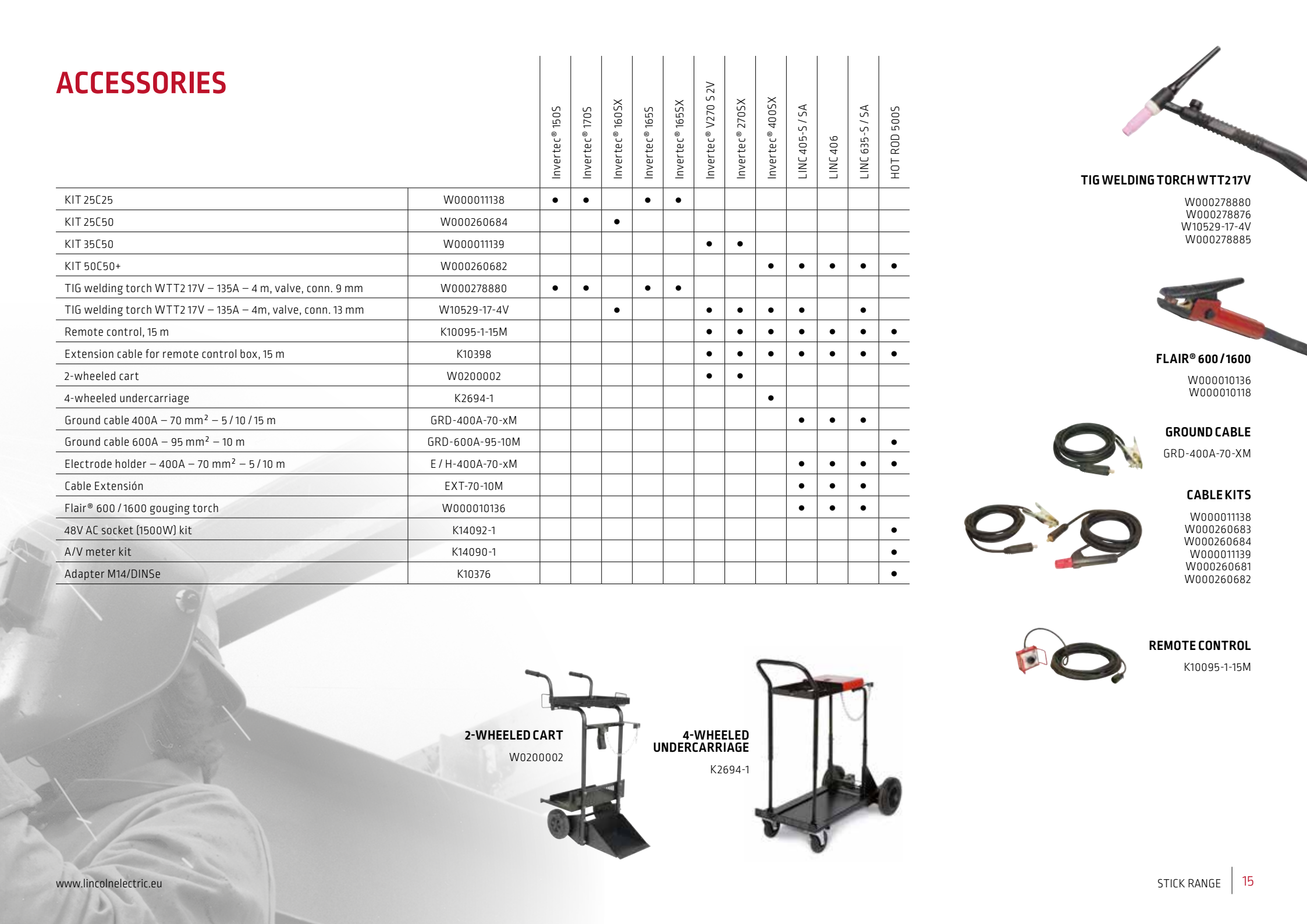
Pipeline
Shipbuilding
Heavy fabrication
Hardfacing
Plant construction
Process industry
Pressure vessels
Air-Arc gouging
Nuclear power station

Applied material

Steel
Stainless steel
Limited Aluminium
Large thickness plates

ACCESSORIES

		Invertec® 150S	Invertec® 170S	Invertec® 160SX	Invertec® 165S	Invertec® 165SX	Invertec® V270 S 2V	Invertec® 270SX	Invertec® 400SX	LINC 405-S / SA	LINC 406	LINC 635-S / SA	HOT ROD 500S
KIT 25C25	W000011138	●	●		●	●							
KIT 25C50	W000260684			●									
KIT 35C50	W000011139						●	●					
KIT 50C50+	W000260682								●	●	●	●	●
TIG welding torch WTT2 17V – 135A – 4 m, valve, conn. 9 mm	W000278880	●	●		●	●							
TIG welding torch WTT2 17V – 135A – 4m, valve, conn. 13 mm	W10529-17-4V			●			●	●	●	●		●	
Remote control, 15 m	K10095-1-15M						●	●	●	●	●	●	●
Extension cable for remote control box, 15 m	K10398						●	●	●	●	●	●	●
2-wheeled cart	W0200002						●	●					
4-wheeled undercarriage	K2694-1								●				
Ground cable 400A – 70 mm² – 5 / 10 / 15 m	GRD-400A-70-xM									●	●	●	
Ground cable 600A – 95 mm² – 10 m	GRD-600A-95-10M												●
Electrode holder – 400A – 70 mm² – 5 / 10 m	E / H-400A-70-xM									●	●	●	●
Cable Extensión	EXT-70-10M									●	●	●	
Flair® 600 / 1600 gouging torch	W000010136									●	●	●	
48V AC socket (1500W) kit	K14092-1												●
A/V meter kit	K14090-1												●
Adapter M14/DINSe	K10376												●



TIG WELDING TORCH WTT2 17V

W000278880
W000278876
W10529-17-4V
W000278885

FLAIR® 600 / 1600

W000010136
W000010118

GROUND CABLE

GRD-400A-70-XM

CABLE KITS

W000011138
W000260683
W000260684
W000011139
W000260681
W000260682

REMOTE CONTROL

K10095-1-15M

2-WHEELED CART

W0200002

4-WHEELED UNDERCARRIAGE

K2694-1

CUSTOMER ASSISTANCE POLICY

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www.lincolnelectriceurope.com

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