Idealarc® DC400

Processes
Stick, TIG, MIG, Flux-Cored, Gouging

Product Number
K1308-12 230/460V w/meters and MPS
K1308-25 230/460/575V w/meters and GFCI
K1309-17 230/400V CE w/meters
K1309-20 220/380/440V w/meters

See back for complete specs

Input Power (Voltage/Phase/Hertz)
K1308-12: 230/460V/3/60
K1308-25: 230/460/575V/3/60
K1309-17: 230/400V/3/50/60
K1309-20: 220/380/440V/3/50/60

Input Current at Rated Output (100% Duty Cycle)
220V: 81A
230V: 78A
380V: 47A
400V: 45A
440V: 40A
460V: 39A
575V: 31A

Rated Output
400A/36V/100%
450A/38V/60%

Output Range
60-500A / 12-42V

Weight/Dimensions (H x W x D)
473 lbs. (215 kg)
27.5 x 22.3 x 33.1 in.
(698 x 566 x 840 mm)

Industrial DC Multi-Process Welders
Rugged construction, simple controls and a 100% duty cycle output rating make these machines a sound investment for heavy duty shop applications. Add the outstanding traditional SCR rectifier arc action delivering high quality, attractive welds and your operators will agree – it’s hard to go wrong with an Idealarc® DC400.

FEATURES
- Full range output voltage control for easy operation and precise control.
- Standard analog ammeter and voltmeter.
- Mode switch for selecting desired output characteristics.
- 115V, 15 amps, duplex auxiliary power receptacle makes it easy to power lights, grinders and other shop tools at your work station (K1308-25 only).
- Flat-top case with a small footprint can be placed under a workbench or stacked up to 3 high on top of each other.
- Windings and rectifiers are protected against moisture and corrosive environments.
- Seven-year warranty on power rectifier.

APPLICATIONS
- Metal Fabrication
- Maintenance and Repair
- Autobody/Farm
- Light Industrial

UL/CSA Approval on 60 Hz models.

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

1. Mode Switch
2. Arc Control Switch
3. Arc Force Control
4. Output Terminals On or Remote
5. Machine Output Local or Remote
6. 115 Volt Power Switch
7. Output Control
8. Power Source Pilot Light
9. Voltmeter Polarity Switch
10. Ammeter/Voltmeter
11. Circuit Breakers
12. Thermal Protection Light

Shown: K1308-12

RECOMMENDED ACCESSORIES

GENERAL OPTIONS

Multi-Process Switch
3-position switch allows quick and easy change from electrode positive or negative semiautomatic/automatic wire feed welding to stick or air carbon arc gouging.
Order K804-1

Undercarriage
Platform undercarriage with mountings for two gas cylinders at rear of welder.
Order K941

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

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
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 lug, headshield, filter plate, cover plate, work clamp and electrode holder. 400 amp capacity.
Order K704

PRODUCT SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Rated Output</th>
<th>Output Control</th>
<th>H x W x D</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Idealarc® DC400 w/Meters and Multi-Process Switch</td>
<td>K1308-12</td>
<td>230/460/3/60</td>
<td>400A/36V/100%</td>
<td>60-500A</td>
<td>27.5 x 22.3 x 33.1</td>
<td>473 lbs.</td>
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<tr>
<td>Idealarc® DC400 w/Meters and GFCI</td>
<td>K1308-25</td>
<td>230/460/5/75/3/60</td>
<td>450A/38V/60%</td>
<td>12-42V</td>
<td>698 x 566 x 840</td>
<td>(215)</td>
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<tr>
<td>Idealarc® DC400 CE w/Meters</td>
<td>K1308-17</td>
<td>230/400/3/50/80</td>
<td>500A/40V/50%</td>
<td>78/39A</td>
<td>81/47/41A</td>
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<tr>
<td>Idealarc® DC400 w/Meters</td>
<td>K1309-20</td>
<td>220/380/440/3/50/60</td>
<td>600A/415V/60%</td>
<td>87/45/4A</td>
<td>473 lbs.</td>
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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.

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