Cruiser® and Tandem Cruiser® Tractors

Processes
Submerged Arc

Product Number
K3048-1 Cruiser® Tractor
K3083-1 Tandem Cruiser® Tractor

Input Power
40 VDC

Rated Output
1000A at 100% Duty Cycle

Travel Speed in/min (m/min)
10 - 100 (0.25 - 2.5)

Gearing
Standard: 142:1
Optional: 95:1, 57:1

Wire Feed Speed Range ipm (m/min)
142:1 – 15 - 200 (0.4 - 5.0)
95:1 – 15 - 300 (0.4 - 7.6)
57:1 – 50 - 500 (1.3 - 12.7)

Wire Dia. Range in. (mm) Solid
142:1 – 3/32 - 7/32 (2.4 - 5.6)
95:1 – 1/16 - 1/8 (1.6 - 3.2)
57:1 – 1/16 - 3/32 (1.6 - 2.4)

Weight / Dimensions
See Page 4 for details

Submerged Arc Welding Tractors
The self propelled, modular Cruiser® and Tandem Cruiser® travel carriages, used with the Power Wave® AC/DC 1000® SD power source, can deliver deposition rates up to 30 lbs. (13.61 kg) per arc, per hour for butt and fillet joints on lengthy plate welding applications common in bridge or barge decking, large tank fabrication or shipbuilding.

FEATURES

- Reliable Operation – Strong, rigid and stiff especially where you need it most.
  - Sturdy welded base frame.
  - Substantial steel mast stands up to daily construction site use.
  - Simple cast wheels – Equipped with high temperature and slip resistant rubber tires.
  - Robust tube and clamp design – Trouble-free feeding component mounting.
  - Adjustable extended length outriggers – Make it easy to guide tractor movement.

- Advanced Control Pendant – Removable, lightweight, impact resistant aluminum user interface can be used to save procedures, apply limits and lockouts for any or all controls.

- Common Expendable Parts – All drive rolls, nozzles, contact tips and wire straighteners are shared with the MAXsa® submerged arc wire drives.

- Multiple Configurations – Flexible system allows set-up with or without a track and three or four wheel operation. Tandem model not recommended for three wheel operation.

APPLICATIONS

- Bridge and Barge Decking
- Shipbuilding
- Offshore
- Large Tank Fabrication
- Heavy Manufacturing

WHAT’S INCLUDED

- Conduit Tubing – 5 feet (1.5 m)
- 5/32 in. (4.0 mm) 600 Amp Contact Nozzle Assembly
- 5/32 in. (4.0 mm) Contact Tip
- Nozzle Extension – 5 in. (127 mm)
- Nozzle Extension Insulator
- Wire Reel Assembly
- Wheels for Track Operation
- Cross Slide Assembly (2 for Tandem)
- Front and Rear Outriggers
- Enclosed Wire Reel (2 for Tandem)
- K1733-5 Wire Straightener (2 for Tandem)

Note: Control cable not included

RECOMMENDED POWER SOURCE

- Power Wave® AC/DC 1000® SD

THE LINCOLN ELECTRIC COMPANY
22801 St. Clair Avenue • Cleveland, OH 44117-1199 • U.S.A.
PH: +1.216-481-8100 • www.lincolnelectric.com
1. WFS LED
2. AMPS LED
3. Auto / OFF / Manual Travel Switch
4. Weld Mode Selection (Left Button)
5. Frequency and Balance (Left Button)
6. Travel Menu (Left Button)
7. Travel Direction
8. Jog
9. Memories
10. Mode Select Display and Control
11. Inch Down
12. Inch Up
13. Arc End Options (Right Button)
14. Arc Start Options (Right Button)
15. Set-Up Menu
16. Stop Pushbutton
17. Start Pushbutton
18. Volts LED
19. Voltage Display and Control
20. WFS/Amps Display and Control

**Item Product Number Description**

<table>
<thead>
<tr>
<th>Item</th>
<th>Product Number</th>
<th>Description</th>
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<tbody>
<tr>
<td>1</td>
<td>K1733-5</td>
<td>Wire Straightener</td>
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<tr>
<td></td>
<td>KP1899-2</td>
<td>Drive Roll/Guide Tube Kit - 1/16, 5/64, 3/32 in.</td>
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<td>KP1899-3</td>
<td>Drive Roll/Guide Tube Kit - .035, .045, .052 in.</td>
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<td>KP1899-4</td>
<td>Drive Roll/Guide Tube Kit - .045, .052 in. Cored</td>
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<td>3</td>
<td>K231-1</td>
<td>Contact Nozzle Assembly - 5/64-3/16 in. (2.0-4.8 mm) - Rated up to 600 amps</td>
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<td>4</td>
<td>KP2721-1</td>
<td>Nozzle Extension - 5 in.</td>
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<td>KP2721-2</td>
<td>Nozzle Extension - 45° Curved</td>
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<td>T12929</td>
<td>Flux Hose Clamp</td>
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<td></td>
<td>T11807</td>
<td>Nozzle Extension Insulator</td>
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<tr>
<td>5</td>
<td>KP1962-3B1</td>
<td>Severe Duty Contact Tip - 3/32 in. (2.4 mm)</td>
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<td>KP1962-1B1</td>
<td>Severe Duty Contact Tip - 1/8 in. (3.2 mm)</td>
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<td>KP1962-4B1</td>
<td>Severe Duty Contact Tip - 5/32 in. (4.0 mm)</td>
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<td>KP1962-2B1</td>
<td>Severe Duty Contact Tip - 3/16 in. (4.8 mm)</td>
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<td>KP1962-3B1</td>
<td>Severe Duty Contact Tip - 7/32 in. (5.6 mm)</td>
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<td>KP3162-3B1</td>
<td>Extended Life Contact Tips - 3/32 in. (2.4 mm)</td>
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<td>Extended Life Contact Tips - 1/8 in. (3.2 mm)</td>
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<td>KP3162-3B1</td>
<td>Extended Life Contact Tips - 7/32 in. (5.6 mm)</td>
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<td></td>
<td>K148A or K148B</td>
<td>Positive Contact Nozzle Assembly - Rated up to 1000 amps</td>
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<tr>
<td></td>
<td>K285</td>
<td>Concentric Flux Cone Assembly to use with K148A or K148B</td>
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1. **Improved Rigidity and Stiffness**
   - Base is fabricated from a single weldment.
   - Designed to carry weight and maintain a steady track.

2. **Heavy Duty Cross Slides**
   - Ceramic coated rails resist corrosion and wear.
   - Minimal deflection results in accurate electrode placement in the joint.

3. **New Rugged Wheels**
   - High temperature rubber wheels on cast aluminum core wheels – Rated to 500º F (260º C) continuous service.

4. **Modified Mast and Boom Clamping System**
   - Grade 8 bolts resist stripping.
   - Improved wrench clearance.

5. **Proven Industrial Wire Drive**
   - Feeds up to 7/32 in. (5.6 mm) diameter wire.
   - Change gear ratios to extend wire feed speed range.
   - Rotate in two directions to set up virtually any torch angle.
   - Rated for handling wire at up to 1000 amps at 100% duty cycle.

6. **Cable Rack**
   - Extended rear rack provides positive strain relief for feeder cables.

7. **Laser Pointer and Improved Steering**
   - Switch on and off to help locate joint during set up.
   - Extended outriggers with additional adjustment and guide wheel provide smooth tracking in wider range of applications.

8. **Tandem Cruiser®**
   - Carries two wire reels.
   - Allows placement of two wires in one arc for greater deposition.

Shown: K3083-1 Tandem Cruiser® Tractor
REQUIRED OPTIONS

ArcLink® Control Cables
Available in two forms:
- K1543-xx series for most indoor or factory installations.
- K2683-xx series for outdoor use or when the equipment is frequently moved.

PRODUCT SPECIFICATIONS

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<th>Rated Output</th>
<th>Gearing</th>
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<th>Wire Size Range</th>
<th>Dimensions</th>
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<td>3/32 - 7/32</td>
<td>36.5 x 45.5 x 41.5</td>
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