

# NA-3, NA-4 & NA-5 Control & Heads

## Automatic Welding Systems

Improve productivity with the NA-3S, NA-4, or NA-5 automatic wire feeders. These systems have been specially designed to deposit more weld metal at faster travel speeds which eliminates bottlenecks and cuts costs.

### Features

- Solid state controls allow precise control of welding procedures, striking characteristics, as well as bead size and shape.
- Easily adjusted for a wide range of processes, feed speeds and wire sizes.
- Compact units with excellent flexibility to fit into simple fixtures or the most complex automated production lines.
- Rugged construction minimizes downtime and maintenance costs.



### Technical Specifications

| Product           | Item Number | Input Power | Wire Feed Speed Range <sup>(1)</sup> (m/min) | Wire Size Range <sup>(1)</sup> Solid - mm | Gear Box <sup>(1)</sup> |
|-------------------|-------------|-------------|--|---|-------------------------|
| NA-3S Controller  | K210-2      | 115V AC     | 0.6 -16.5                                    | 0.9-5.6                                   | -                       |
| NA-4 Controller   | K388-2      |             | 0.6 -16.5*                                   |   | -                       |
| NA-5 Controller   | K356-2      |             | 0.6 -16.5                                    |   | -                       |
| NA-3S/NA-4 Head   | K208A       |             | 0.4-7.4*                                     | 2.4-5.6                                   | 142:1                   |
|                   | K208B       |             | 0.6-10.8*                                    | 0.9-2.4                                   | 95:1                    |
| NA-3SF/NA-4F Head | K209A       |             | 0.4-7.4*                                     | 2.4-5.6                                   | 142:1                   |
|                   | K209B       |             | 0.6-10.8*                                    | 0.9-2.4                                   | 95:1                    |
| NA-5S Head        | K346A       |             | 0.4-7.4                                      | 2.4-5.6                                   | 142:1                   |
|                   | K346B       |             | 0.6-10.8                                     | 1.6-2.4                                   | 95:1                    |
|                   | K347A       |             | 0.4-7.4                                      | 2.4-5.6                                   | 142:1                   |
| NA-5SF Head       | K347B       | 0.6-10.8    | 1.6-2.4                                      | 95:1                                      |                         |

**Processes**  
• Submerged arc



### Recommended Power Sources

- NA-3S / NA-5: Flextec 650, Idealarc® DC-1000, Idealarc® DC-1500
- NA-4: Idealarc® AC-1200

### Key Options

- K221 Start controls PC board
- K245 Crater fill control PC board
- K2163-60 Power Cable, 18 m [NA-5]
- K1842-110 Power Cable, 33 m [NA-5]
- K29 Vertical Adjuster, 100 mm
- K96 Horizontal Adjuster, 50 mm
- K219 Flux Hopper
- K278-1 Spreadarc Oscillator
- K231-1 Contact Nozzle [2.4, 3.2, 4.0 mm]
- K148A Positive Contact Nozzle [2.4-3.2 mm]
- K148B Positive Contact Nozzle [4.0-4.8 mm]
- KP2721-2 Nozzle Extension, 45°
- K285 Concentric Flux Cone
- K386 Narrow Gap Nozzle
- K149-5/32 Nozzle Extension [4.0 mm]
- K129-x Tiny Twinarc® [1.6/2.0/2.4 mm]
- K225 Twinarc® Nozzle [2.0-2.4 mm]
- K389 Flux Hopper
- K223 Solenoid Kit [NA-5]
- K162-1 Spindle Kit [NA-5]
- K334 Start/Crater Module [NA-5]
- K337-10 Weld Timer [NA-5]
- K336 Remote Interface [NA-5]



# LT-7 Tractor

## Submerged Arc DC Wire Feeder

The LT-7 Tractor is a self-propelled mechanized wire feeder, designed for the submerged arc process with track system capabilities. It is self-guiding and easy to operate – only one operator is usually required.

### Features

- Feeds 2.4-4.8 mm solid wires, from 2.5-10.2 m/min wire feed speed.
- Calibrated tractor drive adjusts travel speeds from 0.12-1.8 m/min.
- Vertical head lift adjuster for adjusting electrical stick-out from 12.7-1270 mm.
- Weld angle is up to 50° from vertical on either side; drag angle is up to 30° from vertical.
- Control box can be mounted either left or right, eliminating the need to return to the power source for routine procedure changes.
- Welds butts, horizontal fillet and lap joints to the left or right side of the tractor frame for convenience.



### Technical Specifications

| Product          | Item Number | Output Capacity | Wire Feed Speed Range <sup>(1)</sup> (m/min) | Wire Size Range <sup>(1)</sup> Solid - mm | Weight (kg) | Dimensions HxWxD (mm) |
|------------------|-------------|-----------------|--|---|-------------|-----------------------|
| LT-7 Track Model | K395-1      | 600A/100%       | 2.5 -10.2                                    | 2.4 - 4.8                                 | 59          | 698 X 838 X 356       |

**Processes**  
• Submerged arc



### Unit Includes

- Control cable 7.6 m

### Key Options

- K228-x Control cable
- K231-1 Contact Nozzle Assembly for 2.4, 3.2, 4.0 mm Wire
- K148A Positive Contact Nozzle Assembly for 2.4-3.2 mm Wire
- K148B Positive Contact Nozzle Assembly for 4.0-4.8 mm Wire
- K149-5/32 Nozzle Extension for 4.0 mm Wire
- KP2721-1 Nozzle Extension, 127 mm
- K232 Horizontal Fillet and Lap Adapter Kit
- K229 Flat Fillet Adapter Kit
- K230 Butt Seam Guide Kit
- K396 Track Section, 1.8 m
- K285 Concentric Flux Cone Assembly
- KP2268-x LT-7 Drive Roll range
- KP1890-1 Drive Roll Center 5/64-3/32 Tiny Twin
- KP1890-2 Drive Roll Side 5/64-3/32 Tiny Twin
- KP1984-1 Guide Tube Assembly 068-3/16 Incoming
- KP1985-1 Guide Tube 3/32-3/16 Outgoing
- KP1986-1 Guide Tube Outgoing Tiny Twinarc®
- KP2127-1 Guide Tube Incoming TinyTwin Tractor

