

# SubArc Digital Series

Issued April 2019 • Index No. AD/7.3 UK

**Submerged Arc  
Welding Power Source**



## Quick Specs

### Heavy Industrial Applications

Railcar  
Shipbuilding  
Heavy fabrication  
Pipe manufacturing  
Pressure vessel

### Processes

Submerged arc (SAW)  
Electroslag (ESW)  
Air carbon arc cutting  
and gouging (CAC-A)

### Input Power

Requires 3-phase power

### Rated Output

**DC 650/800:** 650 A at 44 V, 100% duty cycle

**DC 1000/1250:** 1000 A at 44 V, 100% duty cycle

**AC/DC:** 1000 A at 44 V, 100% duty cycle

### SubArc Digital Series

- Choice of three power sources, two interface controls and a range of wire drive motors and accessories
- Digital process control technology
- Highly reliable thyristor power regulation
- Digital control and communication electronics improve weld performance and simplify the integration of the equipment in more advanced applications



SubArc DC 650/800 Digital

SubArc DC 1000/1250 Digital

SubArc AC/DC Digital

### Easy to integrate.

Our SubArc power sources are easy to integrate by using a standard Modbus® connection. Different levels of integration are possible, from simple remote operation to more complex automated systems.



### Two DC power source models and one AC/DC power source model.

Power sources have sufficient power capacity to cover applications from traditional DC single-arc to multi-wire tandem welding. In the case of electroslag welding or other high-current demand, two or more power sources can easily be paralleled (both DC and AC/DC machines).

### Easier setup and operation.

The SubArc Digital Series interface controls recognize the power source and wire drive connected, and automatically configure the system for proper operation. The easy-to-understand interface provides the operator with the necessary controls to set process parameters and control output. The power sources feature simplified parallel and tandem setups—just plug the cable into the appropriate connectors.

### Improved flux delivery system.

Our SubArc flux hopper utilizes a flux valve mechanism that assures continuous delivery of flux to the arc. The unique valve design provides a barrier between the flux and actuation device to help prevent jamming of the solenoid actuator due to dust and debris. A sight glass is provided on the front of the flux hopper allowing the weld operator to visually monitor the remaining flux in the hopper.

### Low-voltage accessory operation and improved environmental protection.

The digital series accessories are powered with 24 VAC control voltage from the power source. All power sources, interface controls and wire drives are IP23 rated providing a high level of protection for harsh environments.

**All power sources also feature thermal overload protection, line voltage compensation and Fan-On-Demand™.**



Power source is warranted for three years, parts and labor.  
Original main power rectifier parts are warranted for five years.



### International Headquarters Miller Electric Mfg. LLC

An Illinois Tool Works Company  
1635 W. Spencer Street  
Appleton, WI 54914 USA

MillerWelds.com

### ITW Welding Products BV

Edisonstraat 10  
P.O. Box 1551  
NL-3261 LD Oud-Beijerland  
The Netherlands  
Tel.: +31 186 641 444  
info@itw-welding.com  
ITWwelding.com

### UK sales office

Tel.: +44 1695 58 59 11

# SubArc DC Digital



**SubArc DC 650/800 Digital and DC 1000/1250 Digital** cover most single- and twin-wire applications. These traditional transformer/rectifier power sources combine high efficiency with the highest reliability. They also feature state-of-the-art digital-control electronics to provide best-in-class welding performance and repeatability.

## SubArc DC Digital Specifications (Subject to change without notice.)



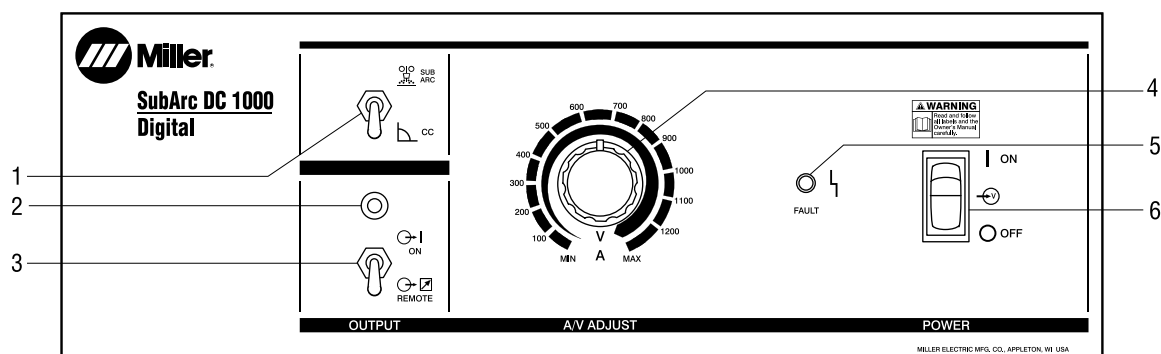
| Model                    | Amperage/<br>Voltage<br>Ranges | Rated Output                       | IP<br>Rating | Amps Input at Rated<br>Load Output, 60 Hz |            |              | Amps Input at Rated<br>Load Output, 50 Hz |             |             | KVA         | KW            | Maximum<br>Open-Circuit<br>Voltage DC** | Dimensions                                                                   | Net<br>Weight       |
|--------------------------|--------------------------------|------------------------------------|--------------|-------------------------------------------|------------|--------------|-------------------------------------------|-------------|-------------|-------------|---------------|-----------------------------------------|------------------------------------------------------------------------------|---------------------|
|                          |                                |                                    |              | 230 V                                     | 460 V      | 575 V        | 380 V                                     | 400 V       | 440 V       |             |               |                                         |                                                                              |                     |
| SubArc DC<br>650 Digital | 50–815 A<br>in CC mode         | 650 A at 44 V,<br>100% duty cycle  | IP23         | 126<br>3.8*                               | 63<br>1.9* | 50.4<br>1.4* | —                                         | —           | —           | 50<br>1.52* | 34.8<br>0.76* | 75 Vpk                                  | H: 30 in. (762 mm)<br>(including lift eye)                                   | 593 lb.<br>(269 kg) |
| SubArc DC<br>800 Digital | 20–44 V in<br>sub arc mode     | 815 A at 44 V,<br>60% duty cycle   |              | —                                         | —          | —            | 95<br>1.9*                                | 90<br>1.8*  | 83<br>1.6*  |             |               |                                         | W: 23 in. (584 mm)<br>D: 38 in. (965 mm)<br>(not including<br>strain relief) | 603 lb.<br>(273 kg) |
| SubArc DC<br>650 Digital | 100–1250 A<br>in CC mode       | 1000 A at 44 V,<br>100% duty cycle | IP23         | 180<br>5.8*                               | 90<br>2.9* | 72<br>2.4*   | —                                         | —           | —           | 73<br>3.2*  | 53<br>0.5*    | 68 Vpk                                  |                                                                              | 682 lb.<br>(309 kg) |
| SubArc DC<br>800 Digital | 20–44 V in<br>sub arc mode     | 1250 A at 44 V,<br>60% duty cycle  |              | —                                         | —          | —            | 135<br>5.2*                               | 128<br>5.0* | 117<br>4.5* |             |               |                                         |                                                                              | 681 lb.<br>(309 kg) |

\*While idling. \*\*Open-circuit voltages in CV mode are factory set at values less than indicated for CC.

SubArc DC 650 Digital and DC 1000 Digital models are certified by Canadian Standards Association to both the Canadian and U.S. Standards.

All SubArc DC Digital models are manufactured and certified in accordance with IEC-60974-1, -10.

## SubArc DC Digital Control Panel



1. Process Selector Switch
2. Output Indicator Light
3. Output Switch (Contactor)

4. Amperage/Voltage Adjustment Control
5. Fault Indicator
6. Power Switch

# SubArc AC/DC Digital



**SubArc AC/DC Digital and SubArc AC/DC 1250 Digital.** AC welding output enables the SubArc AC/DC to be used in tandem-arc welding systems with a DC lead arc and AC trailing arc, or with AC/ AC arc combinations. Using multiple arcs increases deposition rate, resulting in shorter welding cycles for very thick weldments without compromising quality. All AC balance control modes can be set on the SubArc Interface

Digital or the SubArc Remote Pendant Digital. These easy-to-understand interfaces include two DC modes and 12 best-practice AC balance settings. In multiple-arc configurations, the system automatically adjusts the phase shifting between power sources thereby eliminating arc interaction. There is no need to employ a laptop PC for complex wave shaping before operation.

## SubArc DC Digital Specifications (Subject to change without notice.)



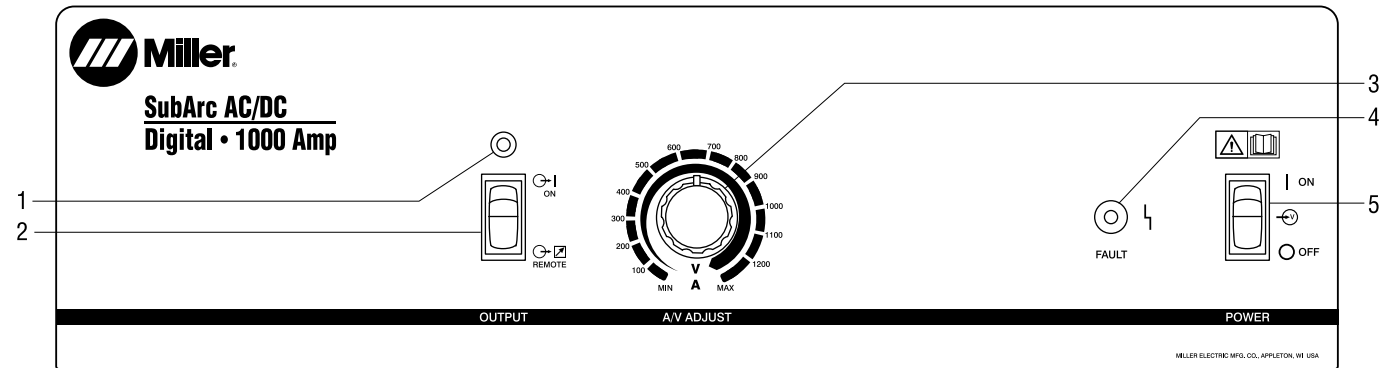
| Model                        | Amperage/<br>Voltage<br>Ranges | Rated Output                       | IP<br>Rating | Amps Input at Rated<br>Load Output |                  |                  | KVA          | KW          | Maximum<br>Open-Circuit<br>Voltage DC | Dimensions                                                                                                                | Net<br>Weight        |
|------------------------------|--------------------------------|------------------------------------|--------------|------------------------------------|------------------|------------------|--------------|-------------|---------------------------------------|---------------------------------------------------------------------------------------------------------------------------|----------------------|
|                              |                                |                                    |              | 460 V<br>(60 Hz)                   | 380 V<br>(50 Hz) | 400 V<br>(50 Hz) |              |             |                                       |                                                                                                                           |                      |
| SubArc AC/DC<br>Digital      | 300–1250 A<br>in CC mode       | 1000 A at 44 V,<br>100% duty cycle | IP23         | 122<br>3.0*                        | —                | —                | 98<br>2.37*  | 53<br>0.95* | 93 Vpk                                | H: 43 in. (1092 mm)<br>(including lift eye)<br>W: 28 in. (711 mm)<br>D: 48 in. (1219 mm)<br>(not including strain relief) | 1187 lb.<br>(538 kg) |
| SubArc AC/DC<br>1250 Digital | 20–44 V<br>in sub arc mode     | 1250 A at 44 V,<br>60% duty cycle  |              | —                                  | 179<br>3.0*      | 176<br>3.0*      | 122<br>2.37* | 67<br>0.95* |                                       |                                                                                                                           | 1260 lb.<br>(572 kg) |

\*While idling.

 SubArc AC/DC Digital is certified by Canadian Standards Association to both the Canadian and U.S. Standards.

 Both SubArc AC/DC Digital models are manufactured and certified in accordance with IEC-60974-1, -10.

## SubArc AC/DC Digital Control Panel



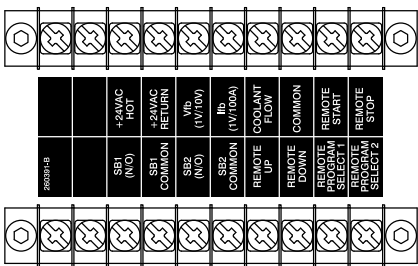
- 1. Output Indicator Light
- 2. Output Switch (Contactor)
- 3. Amperage/Voltage Adjustment Control

- 4. Fault Indicator
- 5. Power Switch

# SubArc Interface



SubArc Interface Digital



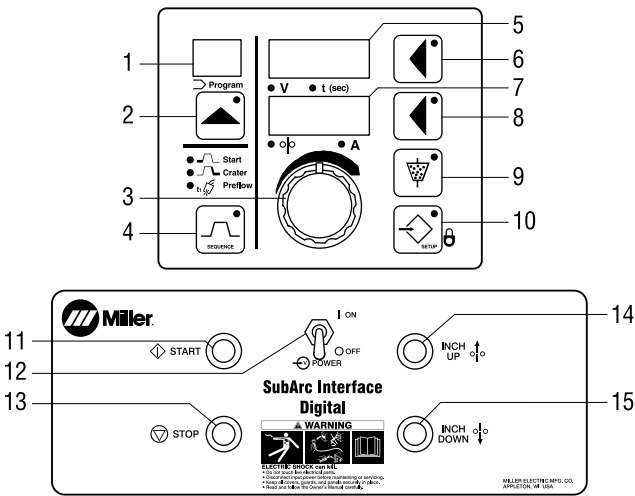
Internal terminal strip is able to integrate with positioners, sidebeams, turning rolls and other peripheral equipment.

## SubArc Interface Specifications (Subject to change without notice.)

| Model                    | Input Power from Welding Power Source | Welding Power Source Type                                                              | Weld Voltage and Amperage Capacity | Dimensions                                                      | Net Weight           |
|--------------------------|---------------------------------------|----------------------------------------------------------------------------------------|------------------------------------|-----------------------------------------------------------------|----------------------|
| SubArc Interface Digital | 24 VAC, single-phase, 25 A, 50/60 Hz  | Constant voltage (CV), AC or DC, with remote contactor and output control capabilities | 0–100 V<br>0–1500 A                | H: 11.5 in. (292 mm)<br>W: 12 in. (305 mm)<br>D: 7 in. (178 mm) | 15.8 lb.<br>(7.2 kg) |

 Certified by Canadian Standards Association to both the Canadian and U.S. Standards.  
 Manufactured according to the Standard IEC-60974-1, -5, -10.

## SubArc Interface Control Panel

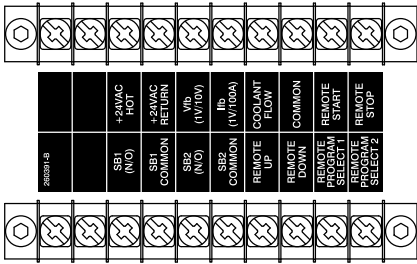


SubArc Interface Digital

# SubArc Remote Operator Interface



Motor Control Digital



Internal terminal strip inside Motor Control Digital is able to integrate with positioners, sidebeams, turning rolls and other peripheral equipment.



Remote Pendant Digital

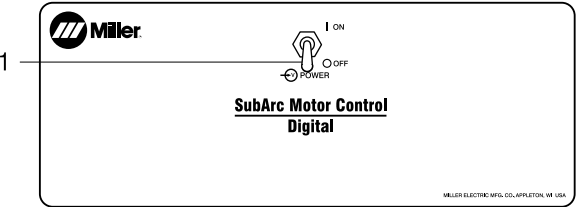
## SubArc Remote Operator Interface Specifications (Subject to change without notice.)

| Model                  | Input Power from Welding Power Source | Welding Power Source Type                                                              | Weld Voltage and Amperage Capacity | Dimensions                                                          | Net Weight           |
|------------------------|---------------------------------------|----------------------------------------------------------------------------------------|------------------------------------|---------------------------------------------------------------------|----------------------|
| Motor Control Digital  | 24 VAC, single-phase, 25 A, 50/60 Hz  | Constant voltage (CV), AC or DC, with remote contactor and output control capabilities | 0–100 V<br>0–1500 A                | H: 11.5 in. (292 mm)<br>W: 12 in. (305 mm)<br>D: 7 in. (178 mm)     | 15.8 lb.<br>(7.2 kg) |
| Remote Pendant Digital | 42 VDC, 1 A                           |                                                                                        |                                    | H: 11 in. (279 mm)<br>W: 10.63 in. (270 mm)<br>D: 3.125 in. (80 mm) | 3 lb.<br>(1.4 kg)    |

Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

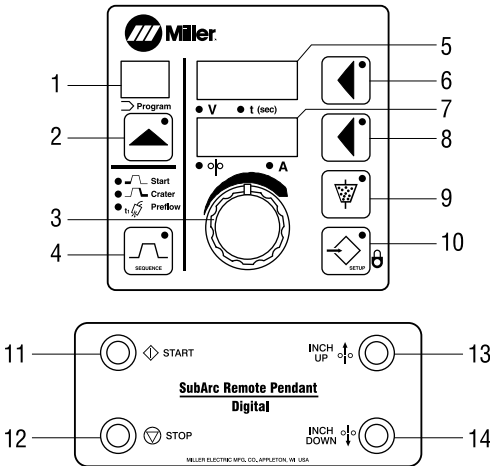
Manufactured according to the Standard IEC-60974-1, -5, -10.

## SubArc Remote Operator Interface Control Panels



Motor Control Digital

1. Power Switch

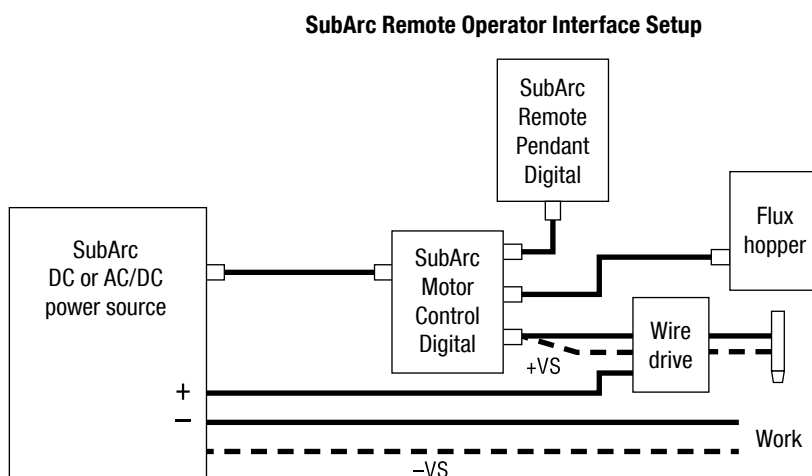
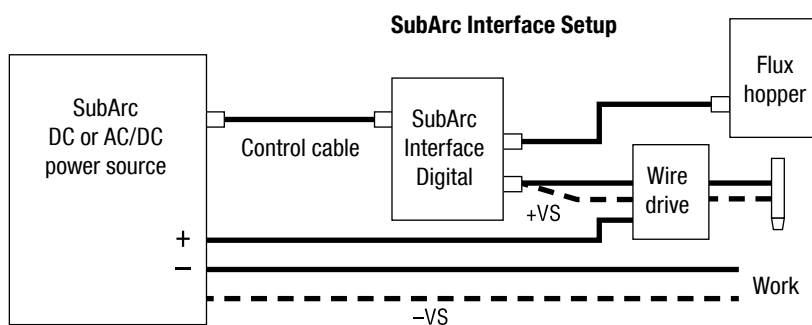


Remote Pendant Digital

1. Program Display
2. Program Push Button
3. Adjust Control
4. Sequence Push Button
5. Upper Display
6. Upper Display Push Button
7. Lower Display
8. Lower Display Push Button
9. Flux Push Button
10. Setup Push Button
11. Start Button
12. Stop Button
13. Wire Inch Up
14. Wire Inch Down

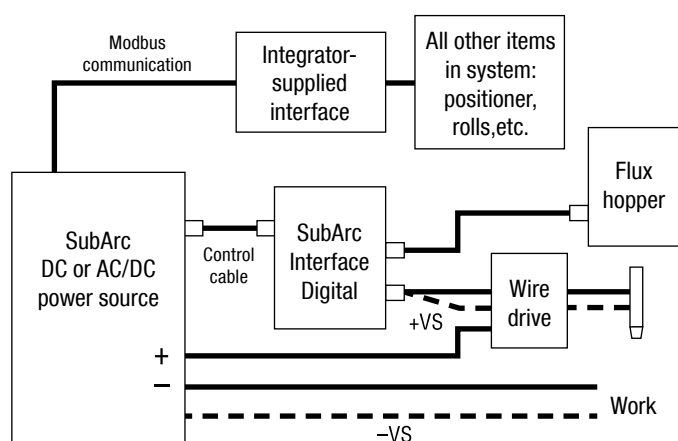
## SubArc Interface and Remote Operator Interface Setups

The positive sense lead is integrated in the wire feeder motor cable and control cable. A customer supplied negative sense lead is required for optimal performance.



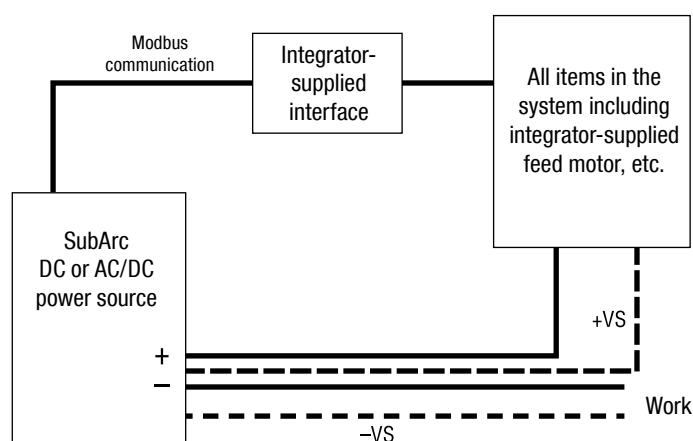
## SubArc Modbus® Setups

### Easy Method



**Easy method** of integrating standard components while controlling them over Modbus communication. Using the standard SubArc interface, wire feed motor and flux hopper, an integrator can remotely adjust settings and operation of the SubArc interface. A separate document with interfacing information is available.

### High-Level Method

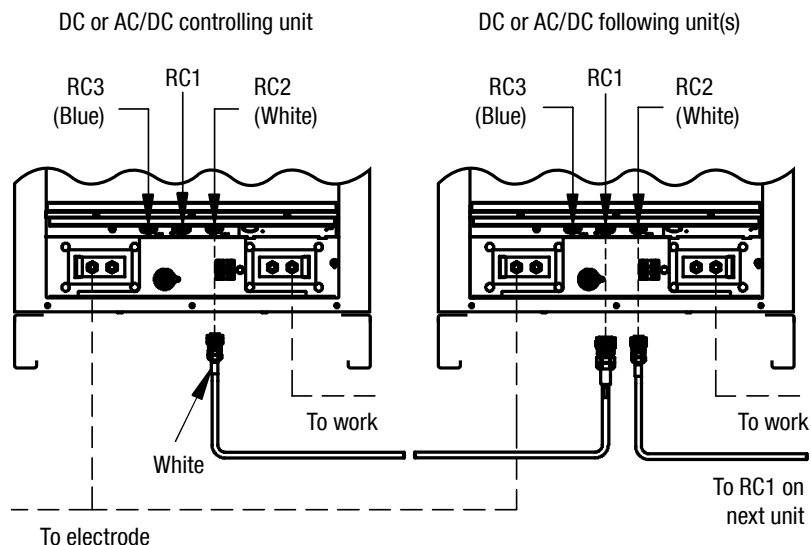


**High-level method** where the integrator solely uses the digital power sources and controls them over Modbus communication. Benefits from Miller technology-driven arc performance while integrating into a custom-made welding solution.

## SubArc System Parallel and Tandem Setups

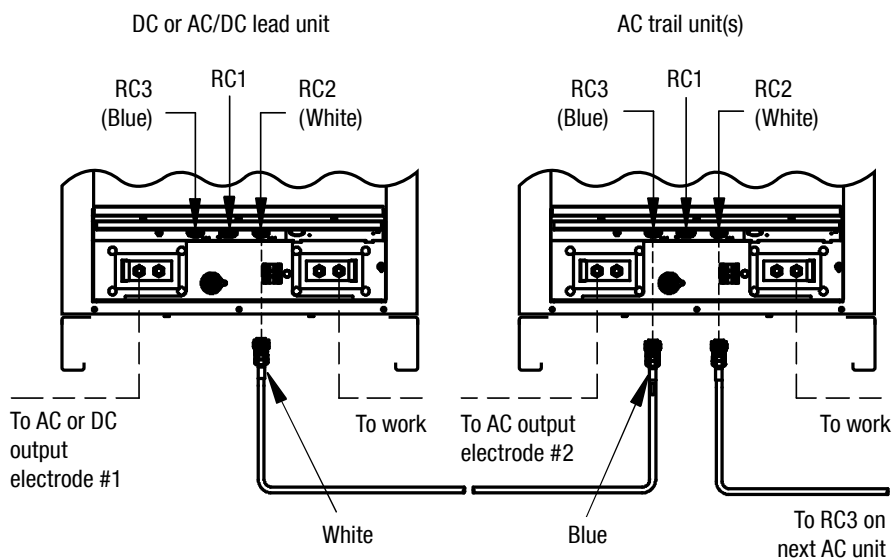
**Parallel setup.** Only like power sources can be paralleled. Paralleling of two machines to increase maximum welding current is simply done by connecting the paralleling cable from RC2 on the first unit to RC1 on the second unit. This works for both DC as well as AC/DC machines. Daisy chaining multiple machines to gain higher output is done in the same way. No special tools, laptop or software needed... plug and play.

### Parallel Connections



### Tandem Connections

**Tandem setup.** To use two or more AC arcs, the arc must be phase shifted to prevent arc to arc interaction. This is simply done by connecting the tandem cable from RC2 on the first unit to RC3 on the second unit. This automatically sets the optimum phase shift for AC welding. No special tools, laptop or software needed... plug and play.



# Wire Drive Assembly



**SubArc Wire Drive 400 Digital Low Voltage  
300938**  
Standard-speed, right-angle wire drive assembly.

## Wire Drive Assembly Specifications (Subject to change without notice.)

| Model                                        | Input Power | Input Power Cord | Rating         | Wire Feed Speed                 | Wire Diameter Capacity        | Net Weight       |
|----------------------------------------------|-------------|------------------|----------------|---------------------------------|-------------------------------|------------------|
| SubArc Wire Drive 400<br>Digital Low Voltage | 38 VDC      | 4 ft. (1.2 m)    | 1/5 hp, 85 rpm | 30–400 ipm<br>(0.8–10.2 m/min.) | 3/32–5/32 in.<br>(2.4–4.0 mm) | 26 lb. (11.8 kg) |

## Accessories

### Drive Rolls

**132955** 1/16 in. (1.6 mm)  
**132960** 5/64 in. (2.0 mm)  
**132961** 3/32 in. (2.4 mm)  
**132962** 7/64 in. (2.8 mm)  
**132963** 1/8 in. (3.2 mm)  
**193700** 5/32 in. (4.0 mm)

### Cables



#### SubArc Control Cables

**260622030** 30 ft. (9.1 m)  
**260622050** 50 ft. (15.2 m)  
**260622060** 60 ft. (18.3 m)  
**260622080** 80 ft. (24.4 m)  
**260622100** 100 ft. (30.5 m)  
**260622120** 120 ft. (36.6 m)  
**260622200** 200 ft. (61.0 m)

Cable between SubArc Interface or Motor Control and power source.



#### Flux Hopper Extension Cables

**260623010** 10 ft. (3 m)  
**260623025** 25 ft. (7.6 m)  
**260623065** 65 ft. (19.8 m)

Cable between SubArc Interface or Motor Control and flux hopper.



#### Motor Extension Cables

**254232005** 5 ft. (1.5 m)  
**254232010** 10 ft. (3 m)  
**254232025** 25 ft. (7.6 m)  
**254232065** 65 ft. (19.8 m)

Cable between SubArc Interface or Motor Control and drive motor.



#### Continuum Motor/Control Cables

**263368015** 15 ft. (4.6 m)  
**263368020** 20 ft. (6.1 m)  
**263368025** 25 ft. (7.6 m)  
**263368050** 50 ft. (15.2 m)  
**263368080** 80 ft. (24.4 m)  
**263368100** 100 ft. (30.5 m)

Cable between SubArc Motor Control and SubArc Remote Pendant



#### SubArc Parallel Cable

**260775015**  
 15 ft. (4.6 m)



#### SubArc Tandem Cable

**260878015**  
 15 ft. (4.6 m)

### Submerged Arc Torches



#### OBT 600 043923

600 amps at 100 percent duty cycle. For 1/16–5/32 inch (1.6–4.0 mm) wire. Torch has concentric flux flow nozzle.

#### OBT 600 Torch Body

##### Extensions

**043967** 1 in. (25.4 mm)  
**043969** 2 in. (50.8 mm)  
**043973** 4 in. (101.6 mm)  
**043975** 6 in. (152.4 mm)



#### OBT 1200 043900

1200 amps at 100 percent duty cycle. For 1/16–5/32 inch (1.6–4.0 mm) wire. Torch has concentric flux flow nozzle and features a replaceable breakaway adapter end to prevent costly damage should torch run into an obstruction.

#### OBT 1200 Torch Body Extension 043981

Overall length with extension is 9 inches (228.6 mm). Actual length of extension is 8.5 inches (215.9 mm).

#### OBT Torch Contact Tips

| OBT 600       | OBT 1200      | Wire Size         |
|---------------|---------------|-------------------|
| <b>192700</b> | <b>192141</b> | 1/16 in. (1.6 mm) |
| <b>192701</b> | <b>199026</b> | 5/64 in. (2.0 mm) |
| <b>192702</b> | <b>192142</b> | 3/32 in. (2.4 mm) |
| <b>192703</b> | <b>200771</b> | 7/64 in. (2.8 mm) |
| <b>192704</b> | <b>192143</b> | 1/8 in. (3.2 mm)  |
| <b>192705</b> | <b>192144</b> | 5/32 in. (4.0 mm) |



#### 1200-Amp Twin-Wire Torch

**301144** Long, 16.8 in. (427 mm)  
 1200 amps at 100 percent duty cycle.  
 For 3/64–3/32 inch (1.2–2.4 mm) wires.

#### 1200-Amp Twin-Wire Torch Contact Tips

**264595** 3/64 in. (1.2 mm)  
**264596** 1/16 in. (1.6 mm)  
**264597** 5/64 in. (2.0 mm)  
**264588** 3/32 in. (2.4 mm)

## Accessories (continued)



### Single-Wire Straightener 199733

For use with OBT 600 and OBT 1200 single-wire torches. For 1/16–5/32 inch (1.6–4.0 mm) wires.



### Twin-Wire Straightener 301160

Single adjustment for 1200-amp twin-wire torch only.



### SubArc Flux Hopper Digital Low Voltage 300942

25-pound-capacity flux hopper with automatic flux valve. The opening is sized to allow hook-up of any flux-hoppermounted recovery system. Includes slag screen and 11-foot (3.3 m) power cable.



### Wire Reel 108008

For 60-pound (27 kg) coil of wire. Requires Spool Support Assembly (119438)

### Spool Support Assembly 119438

For 60-pound (27 kg) wire reel.



### Manual Slide 301137

Manual slide for smooth and accurate movement of the welding head. Slide allows for 7.87 inch (200 mm) travel adjustment with load capacity of 220 pounds (100 kg) at 1.64 feet (500 mm).

**Not recommended for tandem.**



### SubArc Single Mounting Bracket 301134

Single mounting bracket configures single-arc welding head to mount to manual slide.



### SubArc Tandem Mounting Bracket 301135

Tandem mounting bracket is a predesigned welding head configuration for tandem applications. Independent adjustments of lead and trail torches adapt to most applications.



### SubArc Mounting Hinge 301136

Mounting hinge allows welding head to swivel 90 degrees with minimal effort. Ideal for changing from longitudinal to circumferential welds.



### SubArc 3-Wheel Tractor Digital Package 951755

Package includes SubArc 3-Wheel Tractor, SubArc Tractor Interface Digital, SubArc Wire Drive 400, 10-pound (4.5 kg) capacity flux hopper with manual valve, 60-pound (27 kg) wire reel, OBT 600 torch and wire straightener. See literature AD/7.7 for more information.



### SubArc Portable Welding System

**951675** With SubArc DC 650 Digital

**951676** With SubArc DC 1000 Digital

**951677** With SubArc AC/DC Digital

SubArc Portable Welding System is a ready-toweld submerged arc system for pressure vessel, pipe and welding that requires positioning equipment which can adapt to your application. See literature AD/7.6 for more information.

## Welding Intelligence™



### 14-pin Insight Core™ Module 301072

Insight Core is a simplified, internet-based industrial welding information management solution that monitors and reports welding activity for basic productivity and quality metrics. Requires Insight Core to SubArc Digital Series Adapter (301295). See Insight Core brochure (266011) for more information.

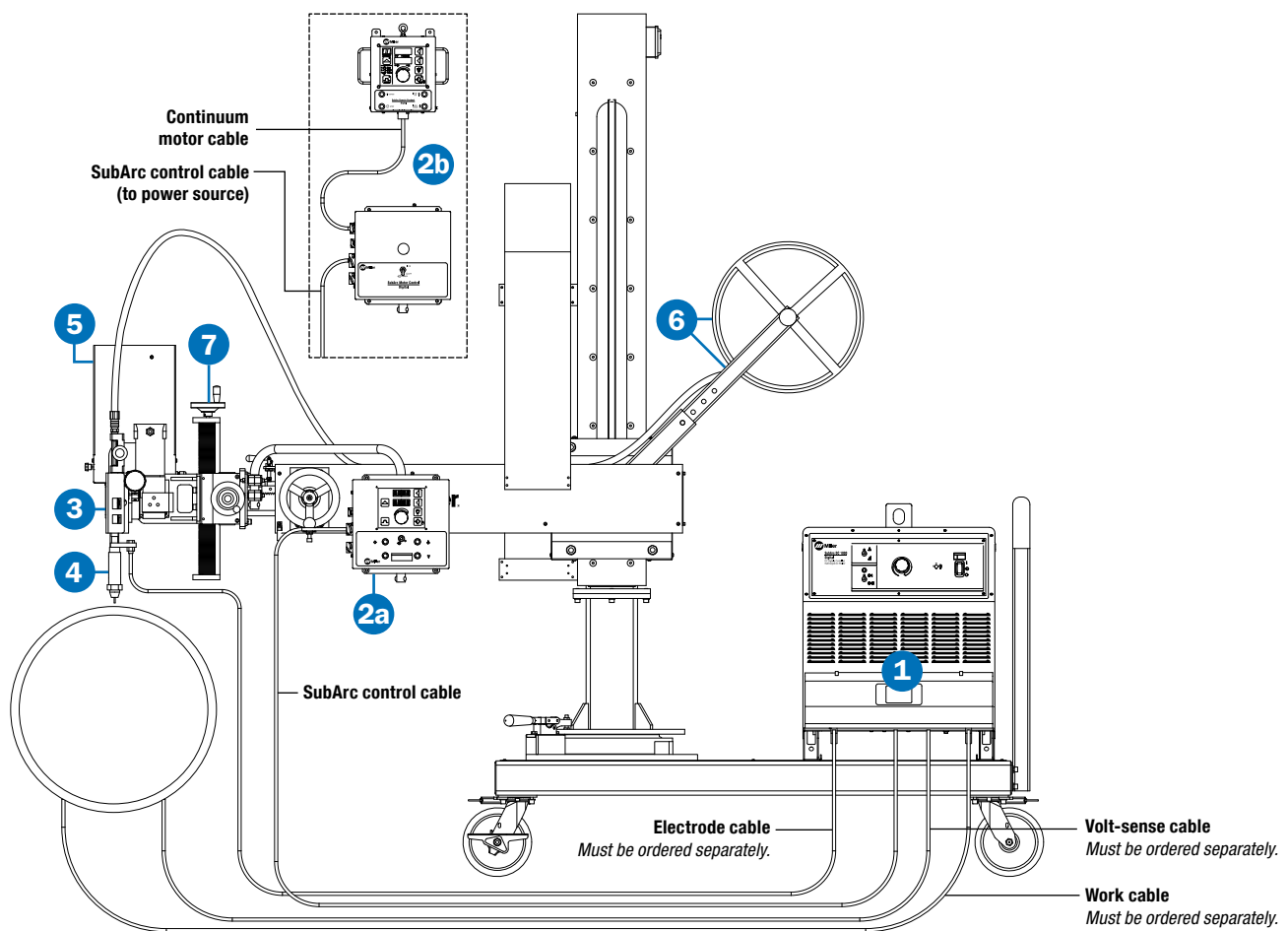


### Insight Core™ to SubArc Digital Series Adapter 301295

### ArcAgent™ Auto 301346

See literature WI/1.0 for more information.

## Typical Installations (SubArc Interface and Remote Operator Interface Setups.)



### 1 Power Source

See page 12 for available models.

### 2 Interface (choose one)

- a SubArc Interface Digital** — See page 12. Requires a SubArc control cable to connect power source to interface. See page 9 for available cable lengths.
- b SubArc Remote Operator Interface** — See page 12. Consists of SubArc Motor Control Digital and SubArc Remote Pendant Digital. Requires a Continuum motor cable and a SubArc control cable. See page 9 for available cable lengths.

### 3 Drive Motor

See page 12 for available models. Includes 4-foot (1.2 m) motor control cable. See page 9 for optional cable extension lengths and required drive rolls.

### 4 Torch (choose one)

- a Single-Wire** — See page 9 for single-wire torches, optional body extensions and required contact tips. See page 10 for optional wire straightener.
- b Twin-Wire** — See page 9 for twin-wire torch and required contact tips. See page 10 for optional wire straightener.

### 5 Flux Hopper

See page 10. Includes 11-foot (3.3 m) flux hopper cable. See page 9 for optional cable extension lengths.

### 6 Reel/Spool Assembly

See page 10. Wire reel requires spool support assembly.

### 7 Manual Slide

See page 10.

## Ordering Information

| Equipment and Options                                | Stock No.     | Description                                                                         | Qty. | Price |
|------------------------------------------------------|---------------|-------------------------------------------------------------------------------------|------|-------|
| <b>1 Power Source</b>                                |               |                                                                                     |      |       |
| SubArc DC 650 Digital                                | <b>907622</b> | 230/460/575 V, 60 Hz                                                                |      |       |
| SubArc DC 800 Digital (50 Hz) <b>CE</b>              | <b>907623</b> | 380/400/440 V, 50 Hz                                                                |      |       |
| SubArc DC 1000 Digital                               | <b>907624</b> | 230/460/575 V, 60 Hz                                                                |      |       |
| SubArc DC 1250 Digital (50 Hz) <b>CE</b>             | <b>907625</b> | 380/400/440 V, 50 Hz                                                                |      |       |
| SubArc AC/DC Digital                                 | <b>907620</b> | 460 V, 60 Hz                                                                        |      |       |
| SubArc AC/DC 1250 Digital (50 Hz) <b>CE</b>          | <b>907621</b> | 380/400 V, 50 Hz                                                                    |      |       |
| <b>2a Interface Controls and Cables</b>              |               |                                                                                     |      |       |
| SubArc Interface Digital                             | <b>300936</b> | CV, AC/DC digital control                                                           |      |       |
| SubArc Control Cables                                |               | See page 9                                                                          |      |       |
| <b>2b SubArc Motor Control Digital</b>               | <b>301425</b> | Motor control for Remote Pendant Digital                                            |      |       |
| SubArc Remote Pendant Digital                        | <b>301424</b> | CV, AC/DC digital control, requires <b>301425</b> and Continuum motor/control cable |      |       |
| Continuum Motor/Control Cables                       |               | See page 9                                                                          |      |       |
| SubArc Interface Digital                             |               | See page 9                                                                          |      |       |
| <b>3 Drive Motors, Extension Cables and Rolls</b>    |               |                                                                                     |      |       |
| SubArc Wire Drive 400 Digital Low Voltage            | <b>300938</b> | Standard-speed right-angle drive assembly                                           |      |       |
| Motor Extension Cables (if needed)                   |               | See page 9                                                                          |      |       |
| Drive Rolls                                          |               | See page 9                                                                          |      |       |
| <b>4a Single-Wire Torches, Straightener and Tips</b> |               |                                                                                     |      |       |
| OBT 600                                              | <b>043923</b> | 600 amps, 100% duty cycle, air cooled                                               |      |       |
| OBT 1200                                             | <b>043900</b> | 1200 amps, 100% duty cycle, air cooled                                              |      |       |
| OBT Torch Body Extensions (if needed)                |               | See page 9                                                                          |      |       |
| Single-Wire Straightener                             | <b>199733</b> | For single-wire torches                                                             |      |       |
| Contact Tips                                         |               | See page 9                                                                          |      |       |
| <b>4b Twin-Wire Torch, Straightener and Tips</b>     |               |                                                                                     |      |       |
| 1200-Amp Twin-Wire Torch                             | <b>301144</b> | Long, 16.8 in. (427 mm), 1200 amps, 100% duty cycle                                 |      |       |
| Twin-Wire Straightener                               | <b>301160</b> | Single adjustment for twin-wire torch only                                          |      |       |
| Contact Tips                                         |               | See page 9                                                                          |      |       |
| <b>5 Flux Hopper and Cables</b>                      |               |                                                                                     |      |       |
| SubArc Flux Hopper Digital Low Voltage               | <b>300942</b> | 25 lb. (11 kg) flux capacity                                                        |      |       |
| Flux Hopper Extension Cables (if needed)             |               | See page 9                                                                          |      |       |
| <b>6 Reel/Spool Assembly</b>                         |               |                                                                                     |      |       |
| Wire Reel                                            | <b>108008</b> | For 60 lb. (27 kg) coil, requires <b>119438</b>                                     |      |       |
| Spool Support Assembly                               | <b>119438</b> |                                                                                     |      |       |
| <b>7 Slide</b>                                       |               |                                                                                     |      |       |
| Single Manual Slide                                  | <b>301137</b> | 7.87 in. (200 mm) travel adjustment                                                 |      |       |
| <b>Accessories</b>                                   |               |                                                                                     |      |       |
| SubArc Parallel/Tandem Cables                        |               | See page 9                                                                          |      |       |
| SubArc Brackets/Hinge                                |               | See page 10                                                                         |      |       |
| SubArc 3-Wheel Tractor/Portable Welding System       |               | See page 10                                                                         |      |       |
| Welding Intelligence™                                |               | See page 10                                                                         |      |       |

Date:

Total Quoted Price:

Distributed by:

