

INVERTEC®400TP

OPERATOR'S MANUAL



ENGLISH



Lincoln Electric Bester Sp. z o.o.
ul. Jana III Sobieskiego 19A, 58-260 Bielawa, Poland
www.lincolnelectric.eu



THANK YOU! For choosing the QUALITY of the Lincoln Electric products.

- Please check packaging and equipment for damage. Claims for material damaged in shipment must be notified immediately to the dealer.
- For ease of use, please enter your product identification data in the table below. Model Name, Code & Serial Number can be found on the machine rating plate.

Model Name:	
.....	
Code & Serial number:	
.....	
Date & Where Purchased:	
.....	

ENGLISH INDEX

Technical Specifications.....	1
ECO design information	2
Electromagnetic Compatibility (EMC).....	4
Safety	5
Introduction	7
Installation and Operator Instructions.....	7
WEEE	13
Spare Parts	13
Authorized Service Shops Location	13
Electrical Schematic	13
Accessories.....	14
Connection Diagram	15
Dimension Diagram.....	16

Technical Specifications

NAME		INDEX		
INVERTEC®400TP		K14390-1		
INPUT				
	Input Voltage U_1	EMC Class		
INVERTEC®400TP	400V ± 15%, 3-phase	A		
	I_{eff}	I_{1max}		
INVERTEC®400TP	16,9A	24,9A		
	Input Power at Rated Cycle	Input Amperes I_{1max}	PF(400V)	
INVERTEC®400TP	4,0 kVA @100% (GTAW)	12,1A	0,89	
	11,1 kVA @60% (GTAW)	15,7A	0,91	
	12,9 kVA @40% (GTAW)	18,6A	0,92	
	11,9 kVA @100% (SMAW)	16,9A	0,91	
	15,1 kVA @60% (SMAW)	21,5A	0,92	
	17,4 kVA @40% (SMAW)	24,9A	0,93	
RATED OUTPUT				
	Process	Duty Cycle 40°C (based on a 10 min. period)	Output Current	Output Voltage
INVERTEC®400TP	GTAW	100%	300A	22V
		60%	360A	24,4V
		40%	400A	26V
	SMAW	100%	300A	32V
		60%	360A	34,4V
		40%	400A	36V
OUTPUT RANGE				
	GTAW	SMAW	Peak Open Circuit Voltage U_0	
INVERTEC®400TP	5 – 400A	5 – 400A	85V	
RECOMMENDED INPUT CABLE AND FUSE SIZES				
	Fuse Type gR or Circuit Breaker Type Z		Power Lead	
INVERTEC®400TP	25A, 400 Vac		4 Conductors, 4,0mm ²	
DIMENSION				
	Weight	Height	Width	Length
INVERTEC®400TP	31,5kg	509 mm	294 mm	624 mm
OTHERS				
	Protection Rating		Maximum Gas Pressure	
INVERTEC®400TP	IP23		0,5MPa (5 bar)	
	Operating Temperature		Storage Temperature	
INVERTEC®400TP	from -10°C to +40°C		from -25°C to 55°C	

ECO design information

The equipment has been designed in order to be compliant with the Directive 2009/125/EC and the Regulation 2019/1784/EU.

Efficiency and idle power consumption:

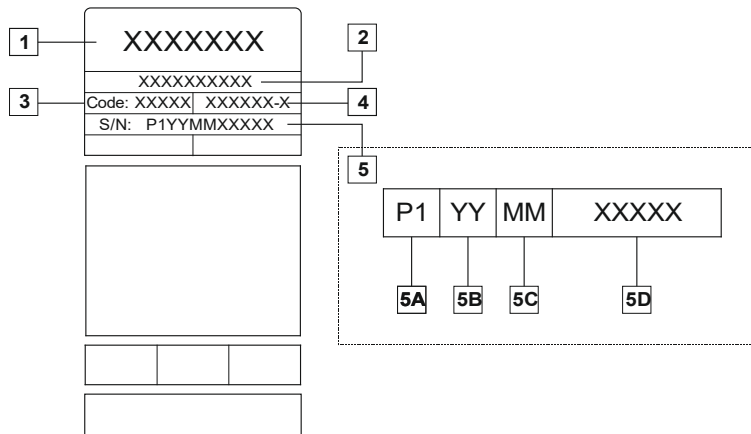
Index	Name	Efficiency when max power consumption / Idle power consumption	Equivalent model
K14390-1	INVERTEC®400TP	88% / 22W	No equivalent model

Idle state occurs under the condition specified in below table

IDLE STATE	
Condition	Presence
MIG mode	
TIG mode	X
STICK mode	
After 30 minutes of non-working	X
Fan off	X

The value of efficiency and consumption in idle state have been measured by method and conditions defined in the product standard EN 60974-1:20XX.

Manufacturer's name, product name, code number, product number, serial number and date of production can be read from rating plate.



Where:

- 1- Manufacturer name and address
- 2- Product name
- 3- Code number
- 4- Product number
- 5- Serial number
 - 5A- country of production
 - 5B- year of production
 - 5C- month of production
 - 5D- progressive number different for each machine

Typical gas usage for **MIG/MAG** equipment:

Material type	Wire diameter [mm]	DC electrode positive		Wire Feeding [m/min]	Shielding Gas	Gas flow [l/min]
		Current [A]	Voltage [V]			
Carbon, low alloy steel	0,9 ÷ 1,1	95 ÷ 200	18 ÷ 22	3,5 – 6,5	Ar 75%, CO ₂ 25%	12
Aluminium	0,8 ÷ 1,6	90 ÷ 240	18 ÷ 26	5,5 – 9,5	Argon	14 ÷ 19
Austenitic stainless steel	0,8 ÷ 1,6	85 ÷ 300	21 ÷ 28	3 - 7	Ar 98%, O ₂ 2% / He 90%, Ar 7,5% CO ₂ 2,5%	14 ÷ 16
Copper alloy	0,9 ÷ 1,6	175 ÷ 385	23 ÷ 26	6 - 11	Argon	12 ÷ 16
Magnesium	1,6 ÷ 2,4	70 ÷ 335	16 ÷ 26	4 - 15	Argon	24 ÷ 28

TIG Process:

In TIG welding process, gas usage depends on cross-sectional area of the nozzle. For commonly used torches:

Helium: 14-24 l/min
 Argon: 7-16 l/min

Notice: Excessive flow rates causes turbulence in the gas stream which may aspirate atmospheric contamination into the welding pool.

Notice: A cross wind or draft moving can disrupt the shielding gas coverage, in the interest of saving of protective gas use screen to block air flow.



End of life

At end of life of product, it has to be disposal for recycling in accordance with Directive 2012/19/EU (WEEE), information about the dismantling of product and Critical Raw Material (CRM) present in the product, can be found at <https://www.lincolnelectric.com/en-gb/support/Pages/operator-manuals-eu.aspx>

Electromagnetic Compatibility (EMC)

01/11

This machine has been designed in accordance with all relevant directives and standards. However, it may still generate electromagnetic disturbances that can affect other systems like telecommunications (telephone, radio, and television) or other safety systems. These disturbances can cause safety problems in the affected systems. Read and understand this section to eliminate or reduce the amount of electromagnetic disturbance generated by this machine.



This machine has been designed to operate in an industrial area. To operate in a domestic area it is necessary to observe particular precautions to eliminate possible electromagnetic disturbances. The operator must install and operate this equipment as described in this manual. If any electromagnetic disturbances are detected the operator must put in place corrective actions to eliminate these disturbances, if necessary with assistance from

Lincoln Electric.

WARNING

Provided that the public low voltage system impedance at the point of common coupling is lower than:

- 68 mΩ for the **INVERTEC®400TP**.

This equipment is compliant with IEC 61000-3-11 and IEC 61000-3-12 and can be connected to public low voltage systems. It is the responsibility of the installer or user of the equipment to ensure, by consultation with the distribution network operator if necessary, that the system impedance complies with the impedance restrictions.

Before installing the machine, the operator must check the work area for any devices that may malfunction because of electromagnetic disturbances. Consider the following.

- Input and output cables, control cables, and telephone cables that are in or adjacent to the work area and the machine.
- Radio and/or television transmitters and receivers. Computers or computer controlled equipment.
- Safety and control equipment for industrial processes. Equipment for calibration and measurement.
- Personal medical devices like pacemakers and hearing aids.
- Check the electromagnetic immunity for equipment operating in or near the work area. The operator must be sure that all equipment in the area is compatible. This may require additional protection measures.
- The dimensions of the work area to consider will depend on the construction of the area and other activities that are taking place.

Consider the following guidelines to reduce electromagnetic emissions from the machine.

- Connect the machine to the input supply according to this manual. If disturbances occur it may be necessary to take additional precautions such as filtering the input supply.
- The output cables should be as short as possible and positioned together as close as possible to each other. If possible connect the work piece to ground in order to reduce the electromagnetic emissions. The operator must check that connecting the work piece to ground does not cause problems or unsafe operating conditions for personnel and equipment.
- Shielding of cables in the work area can reduce electromagnetic emissions. This may be necessary for special applications.

WARNING

EMC classification of this product is class A in accordance with electromagnetic compatibility standard EN 60974-10 which means that the product is designed to be used in an industrial environment only.

WARNING










The Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility in those locations, due to conducted as well as radiated disturbances.











WARNING

This equipment have to be used by qualified personnel. Be sure that all installation, operation, maintenance and repair procedures are performed only by qualified person. Read and understand this manual before operating this equipment. Failure to follow the instructions in this manual could cause serious personal injury, loss of life, or equipment damage. Read and understand the following explanations of the warning symbols. Lincoln Electric is not responsible for damages caused by improper installation, improper care or abnormal operation.

	<p>WARNING: This symbol indicates that instructions must be followed to avoid serious personal injury, loss of life, or equipment damage. Protect yourself and others from possible serious injury or death.</p>
	<p>READ AND UNDERSTAND INSTRUCTIONS: Read and understand this manual before operating this equipment. Arc welding can be hazardous. Failure to follow the instructions in this manual could cause serious personal injury, loss of life, or equipment damage.</p>
	<p>ELECTRIC SHOCK CAN KILL: Welding equipment generates high voltages. Do not touch the electrode, work clamp, or connected work pieces when this equipment is turned on. Insulate yourself from the electrode, work clamp, and connected work pieces.</p>
	<p>ELECTRICALLY POWERED EQUIPMENT: Turn off the input power using the disconnect switch at the fuse box before working on this equipment. Ground this equipment in accordance with local electrical regulations.</p>
	<p>ELECTRICALLY POWERED EQUIPMENT: Regularly inspect the input, electrode, and work clamp cables. If any insulation damage exists replace the cable immediately. Do not place the electrode holder directly on the welding table or any other surface in contact with the work clamp to avoid the risk of accidental arc ignition.</p>
	<p>ELECTROMAGNETIC FIELD MAY BE DANGEROUS: Electric current flowing through any conductor creates electromagnetic field (EMF). EMF fields may interfere with some pacemakers, and welders having a pacemaker shall consult their physician before operating this equipment.</p>
	<p>CE COMPLIANCE: This equipment complies with the European Community Directives.</p>
 <p><small>Optical radiation emission Category 2 (EN 12185)</small></p>	<p>ARTIFICIAL OPTICAL RADIATION: According with the requirements in 2006/25/EC Directive and EN 12198 Standard, the equipment is a category 2. It makes mandatory the adoption of Personal Protective Equipment (PPE) having filter with a protection degree up to a maximum of 15, as required by EN169 Standard.</p>
	<p>FUMES AND GASES CAN BE DANGEROUS: Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. To avoid these dangers the operator must use enough ventilation or exhaust to keep fumes and gases away from the breathing zone.</p>
	<p>ARC RAYS CAN BURN: Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing. To protect the skin, use suitable clothing made of durable, fireproof material. Protect other nearby personnel with suitable, non-flammable screening and warn them not to watch the arc nor expose themselves to the arc.</p>

	<p>WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION: Remove fire hazards from the welding area and have a fire extinguisher easily accessible. Welding sparks and hot materials from the welding process can easily go through small cracks and openings to adjacent areas. Do not weld on any tanks, drums, containers, or material until the proper steps have been taken to insure that no flammable or toxic vapors will be present. Never use this equipment when flammable gases, vapors or flammable liquids are present.</p>
	<p>WELDED MATERIALS CAN BURN: Welding generates a large amount of heat. Hot surfaces and materials in work area can cause serious burns. Use gloves and pliers when touching or moving materials in the work area.</p>
	<p>CYLINDER MAY EXPLODE IF DAMAGED: Use only certificate, compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. Always keep cylinders in an upright position securely chained to a fixed support. Do not move or transport gas cylinders with the protection cap removed. Do not allow the electrode, electrode holder, work clamp or any other electrically live part to touch a gas cylinder. Gas cylinders must be located away from areas where they may be subjected to physical damage or the welding process including sparks and heat sources.</p>
	<p>MOVING PARTS ARE DANGEROUS: There are moving mechanical parts in this machine, which can cause serious injury. Keep your hands, body and clothing away from those parts during machine starting, operating and servicing.</p>
<p>HF</p>	<p>CAUTION: The high frequency used for contact-free ignition with TIG (GTAW) welding, can interfere with the operation of insufficiently shielded computer equipment, EDP centers and industrial robots, even causing complete system breakdown. TIG (GTAW) welding may interfere with electronic telephone networks and with radio and TV reception.</p>
	<p>HOT COOLANT CAN BURN SKIN: Always be sure coolant is NOT HOT before servicing the cooler.</p>
	<p>SAFETY MARK: This equipment is suitable for supplying power for welding operations carried out in an environment with increased risk of electric shock.</p>

The manufacturer reserves the right to make changes and/or improvements in design without upgrade at the same time the operator's manual.

Introduction

The welding machines **INVERTEC®400TP** enables welding:

- GTAW (TIG),
- SMAW (MMA),
- GOUGING (CAG).

The complete package contains:

- Work lead – 5m,
- Gas hose – 1,5m,
- Manual Instruction (USB).

Recommended equipment, which can be bought by user, was mentioned in the chapter "Accessories".

Installation and Operator Instructions

Read this entire section before installation or operation of the machine.

Location and Environment

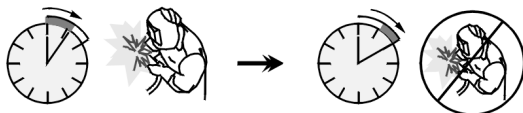
This machine will operate in harsh environments. However, it is important that simple preventative measures are followed to assure long life and reliable operation.

- Do not place or operate this machine on a surface with an incline greater than 15° from horizontal.
- Do not use this machine for pipe thawing.
- This machine must be located where there is free circulation of clean air without restrictions for air movement to and from the air vents. Do not cover the machine with paper, cloth or rags when switched on.
- Dirt and dust that can be drawn into the machine should be kept to a minimum.
- This machine has a protection rating of IP23. Keep it dry when possible and do not place it on wet ground or in puddles.
- Locate the machine away from radio controlled machinery. Normal operation may adversely affect the operation of nearby radio controlled machinery, which may result in injury or equipment damage. Read the section on electromagnetic compatibility in this manual.
- Do not operate in areas with an ambient temperature greater than 40°C.

Duty cycle and Overheating

The duty cycle of a welding machine is the percentage of time in a 10 minute cycle at which the welder can operate the machine at rated welding current.

Example: 60% duty cycle:



Cutting for 6 minutes.

Break for 4 minutes.

Excessive extension of the duty cycle will cause the thermal protection circuit to activate.



Minutes

or decrease
Duty Cycle

Input Supply Connection

WARNING

Only a qualified electrician can connect the welding machine to the supply network. Installation had to be made in accordance with the appropriate National Electrical Code and local regulations.

Check the input voltage, phase and frequency supplied to this machine before turning it on. Verify the connection of ground wires from the machine to the input source. The welding machine **INVERTEC®400TP** must be connected to a correctly installed plug-in socket with an earth pin. Input voltage is 400 Vac 50/60Hz. For more information about input supply refer to the technical specification section of this manual and to the rating plate of the machine.

Make sure that the amount of mains power available from the input supply is adequate for normal operation of the machine. The necessary delayed fuse or circuit breaker and cable sizes are indicated in the technical specification section of this manual.

WARNING

The welding machine can be supplied from a power generator of output power at least 30% larger than input power of the welding machine.

WARNING

When powering the machine from a generator be sure to turn off welder first, before generator is shut down, in order to prevent damage to welder!

Output Connections

Refer to points [3] and [7] of the Figures below.

Controls and Operational Features

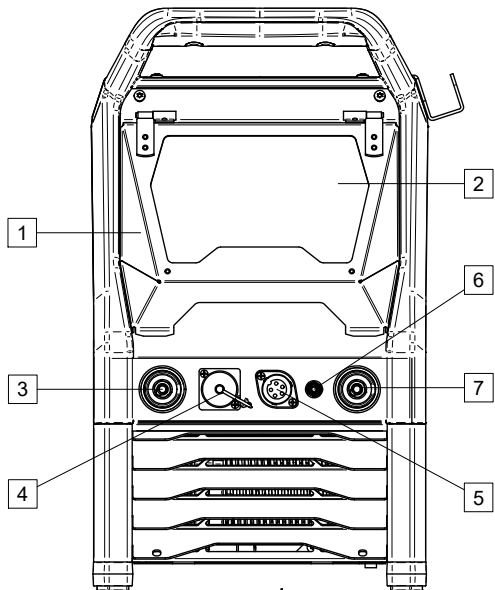











Figure 1

1. Display Cover. Display protection for User Interface.
2. User Interface: See User Interfaces chapter.
3. Positive Output Socket for the Welding Circuit: Depending on the process to connecting:

Process	Symbol	Description
GTAW		Work Lead
SMAW		Electrode Holder with lead / work lead depending on the require configuration
GAUGE		Gauging Torch / work lead depending on the require configuration

4. Remote Control Connector Plug: To install Remote Control Kit. This connector allows connection Remote Control. See "Accessories" chapter. 
5. TIG Control Connector: To connect TIG Torch Trigger or "Up and Down". 
6. Gas Connector: Connection TIG torch gas line. 

7. Negative Output Socket for the Welding Circuit: Depending on the process to connecting:

Process	Symbol	Description
GTAW		TIG Torch
SMAW		Electrode Holder with lead / work lead depending on the require configuration
GAUGE		Gauging Torch / work lead depending on the require configuration

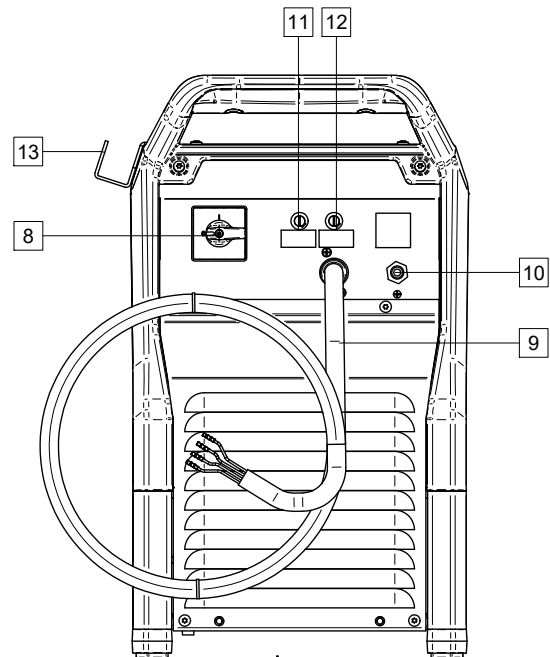



Figure 2

8. Power Switch ON/OFF (I/O): Controls the input power to the machine. Be sure the power source is connected to the mains supply before turning power on ("I").
9. Main Input Cord (5m): Connect the supply plug to the existing input cable that is rated for the machine as indicated in this manual, and conforms to all applicable standards. This connection shall be performed by a qualified person only.
10. Gas Quick Coupling Socket: For connecting a gas line. 

WARNING

The machine allows the use all suitable shielding gases with a maximum pressure of 5 bar.

11. Fuse F1: Use the 2A/400V (6,3x32mm) slow-blow fuse. See "Spare Parts" chapter.
12. Fuse F2: Use the 2A/400V (6,3x32mm) slow-blow fuse. See "Spare Parts" chapter.

13. TIG Torch Holder: Rotary TIG torch handle.

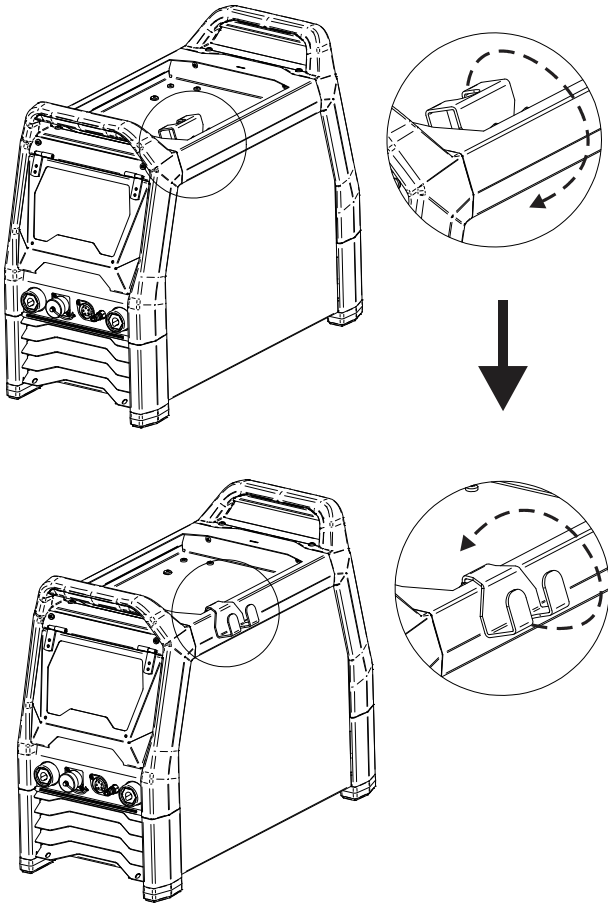


Figure 3

User Interface

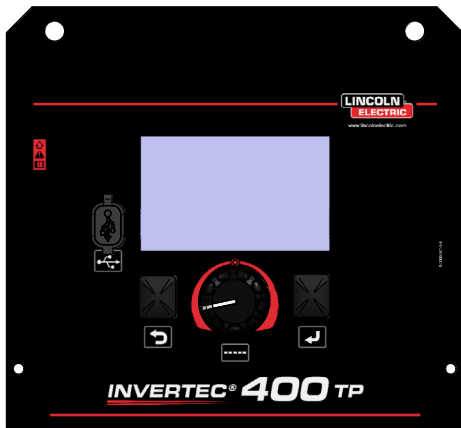


Figure 4

Detailed operation of Global User Interface can be found in the IM3187 user manual.

Welding GTAW Process

INVERTEC®400TP can be used to GTAW process with DC (-).

INVERTEC®400TP does not include the torch to GTAW welding, but the one can be purchased separately. See "Accessories" chapter.

Procedure of begin welding of GTAW process:

- First turn the machine off.
- Connect GTAW torch to [7] output socket.
- Connect the work lead to [3] output socket.
- Connect the work lead to the welding piece with the work clamp.
- Install the proper tungsten electrode in the GTAW torch.
- Turn the machine on.
- Set the welding parameters.

! WARNING

Detailed operation can be found in the IM3187 user manual.

- The welding machine is now ready to weld.
- By applying the principle of occupational health and safety at welding, welding can be begun.

Welding SMAW Process

INVERTEC®400TP does not include the electrode holder with lead necessary for SMAW welding, but the one can be purchased separately. See "Accessories" chapter.

Procedure of begin welding of SMAW process:

- First turn the machine off.
- Determine the electrode polarity for the electrode to be used. Consult the electrode data for this information.
- Depending on the polarity of using electrode, connect the work lead and the electrode holder with lead to output socket [3] or [7] and lock them. See the Table 1.

Table 1 Polarity

		Output Socket		
POLARITY	DC (+)	The electrode holder with lead to SMAW	[3]	+
		Work lead	[7]	-
POLARITY	DC (-)	The electrode holder with lead to SMAW	[7]	-
		Work lead	[3]	+

- Connect the work lead to the piece with the work clamp.
- Install the proper electrode in the electrode holder.
- Turn the machine on.
- Set the welding parameters.

! WARNING

Detailed operation can be found in the IM3187 user manual.

- The welding machine is now ready to weld.
- By applying the principle of occupational health and safety at welding, welding can be begun.

Gouging

INVERTEC® 400TP does not include the torch holder with lead necessary for gouging, but the one can be purchased separately. See "Accessories" chapter.

Procedure of begin of gouging process:

- First turn the machine off.
- Determine the electrode polarity for the electrode to be used. Consult the electrode data for this information.
- Depending on the polarity of using electrode, connect the work lead and the electrode holder with lead to output socket [3] or [7] and lock them. See the Table 2.

Table 2 Polarity

		Output Socket	
		[3]	[7]
POLARITY	DC (+)	Gouging Torch	+
	Work lead	[7]	—
DC (-)	Gouging Torch	[7]	—
	Work lead	[3]	+

- Connect the air connector of gouging holder to air source.
- Connect the work lead to the piece with the work clamp.
- Install the proper electrode in the electrode holder.
- Turn the machine on.
- Set the gouging parameters.

WARNING

Detailed operation can be found in the IM3187 user manual.

- The machine is now ready to gouging.
- By applying the principle of occupational health and safety at welding, welding can be begun.

Gas Connection



WARNING

- **CYLINDER** may explode if damaged.
- Always fix the gas cylinder securely in an upright position, against a cylinder wall rack or purpose-made cylinder cart.
- Keep cylinder away from areas where it may be damaged, heated or electrical circuits to prevent possible explosion or fire.
- Keep cylinder away from welding or other live electrical circuits.
- Never lift welder with cylinder attached.
- Never allow welding electrode to touch cylinder.
- Build up of shielding gas may harm health or kill. Use in a well-ventilated area to avoid gas accumulation.
- Close the gas cylinder valves thoroughly when not in use to avoid leaks.

WARNING

Welding machine supports all suitable shielding gases at a maximum pressure of 5,0 bar.

WARNING

Before use, make sure that the gas cylinder contains gas suitable for the intended purpose.

- Turn off input power at the welding power source.
- Install a proper gas flow regulator to the gas cylinder.
- Connect the gas hose to the regulator using the hose clamp.
- The other end of gas hose connect to the gas connector on the power source rear panel.
- Turn on input power at the welding power source.
- Open the gas cylinder valve.
- Adjust the shielding gas flow of the gas regulator.

Transport & Lifting



! WARNING

Falling equipment can cause injury and damage to unit.

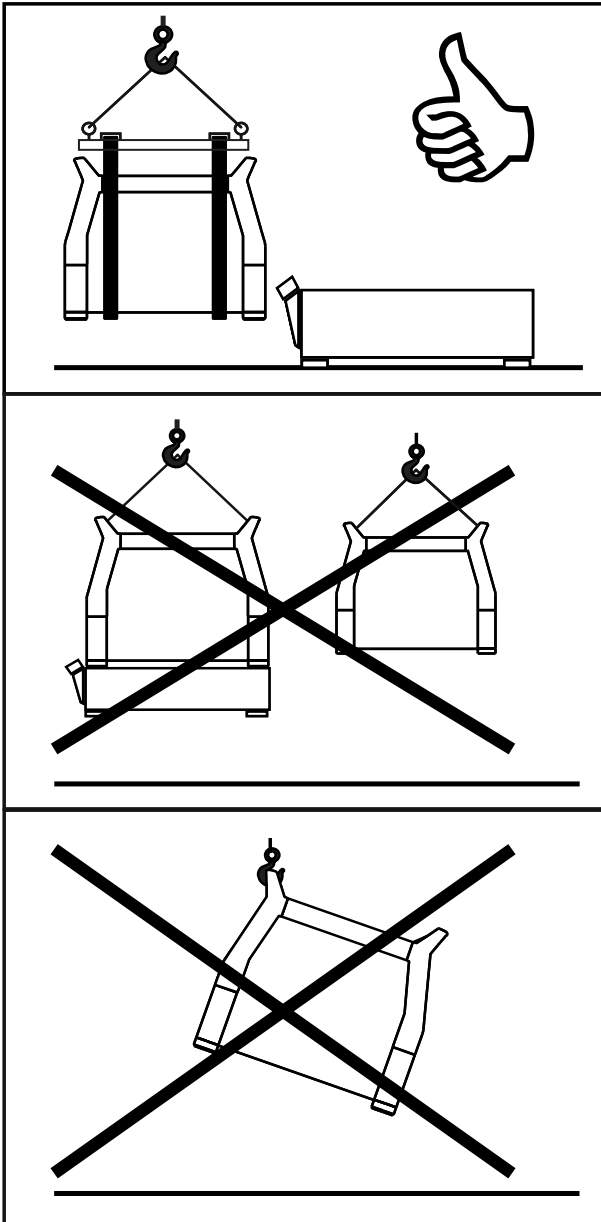


Figure 5

During transportation and lifting with a crane, adhere to the following rules:

- Power source does not include the eye bolt which can be used to transport or lifting the machine.
- To lift use of suitable lifting equipment capacity.
- To lifting and transport use a traverser and minimum two belts.
- Lift only power source without gas cylinder, cooler and wire feeder, or/and any other accessories.

Maintenance

! WARNING

For any repair operations, modifications or maintenances, it is recommended to contact the nearest Technical Service Center or Lincoln Electric. Repairs and modifications performed by unauthorized service or personnel will cause, that the manufacturer's warranty will be lost.

Any noticeable damage should be reported immediately and repaired.

Routine maintenance (everyday)

- Check condition of insulation and connections of the work leads and insulation of power lead. If any insulation damage exists replace the lead immediately.
- Remove the spatters from the welding gun nozzle. Spatters could interfere with the shielding gas flow to the arc.
- Check the welding gun condition: replace it, if necessary.
- Check condition and operation of the cooling fan. Keep clean its airflow slots.

Periodic maintenance (every 200 working hours but at least once a year)

Perform the routine maintenance and, in addition:

- Keep the machine clean. Using a dry (and low pressure) airflow, remove the dust from the external case and from the cabinet inside.
- If it is required, clean and tighten all weld terminals.

The frequency of the maintenance operations may vary in accordance with the working environment where the machine is placed.

! WARNING

Do not touch electrically live parts.

! WARNING

Before removed case, machine has to be turned off and the power lead has to be disconnected from mains socket.

! WARNING

Mains supply network must be disconnected from the machine before each maintenance and service. After each repair, perform proper tests to ensure safety.

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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

WEEE

07/06



Do not dispose of electrical equipment together with normal waste!

In observance of European Directive 2012/19/EC on Waste Electrical and Electronic Equipment (WEEE) and its implementation in accordance with national law, electrical equipment that has reached the end of its life must be collected separately and returned to an environmentally compatible recycling facility. As the owner of the equipment, you should get information on approved collection systems from our local representative.

By applying this European Directive you will protect the environment and human health!

Spare Parts

12/05

Part List reading instructions

- Do not use this part list for a machine if its code number is not listed. Contact the Lincoln Electric Service Department for any code number not listed.
- Use the illustration of assembly page and the table below to determine where the part is located for your particular code machine.
- Use only the parts marked "X" in the column under the heading number called for in the assembly page (# indicate a change in this printing).

First, read the Part List reading instructions above, then refer to the "Spare Part" manual supplied with the machine that contains a picture-descriptive part number cross-reference.

Authorized Service Shops Location

09/16

- The purchaser must contact a Lincoln Authorized Service Facility (LASF) about any defect claimed under Lincoln's warranty period.
- Contact your local Lincoln Sales Representative for assistance in locating a LASF or go to www.lincolnelectric.com/en-gb/Support/Locator.

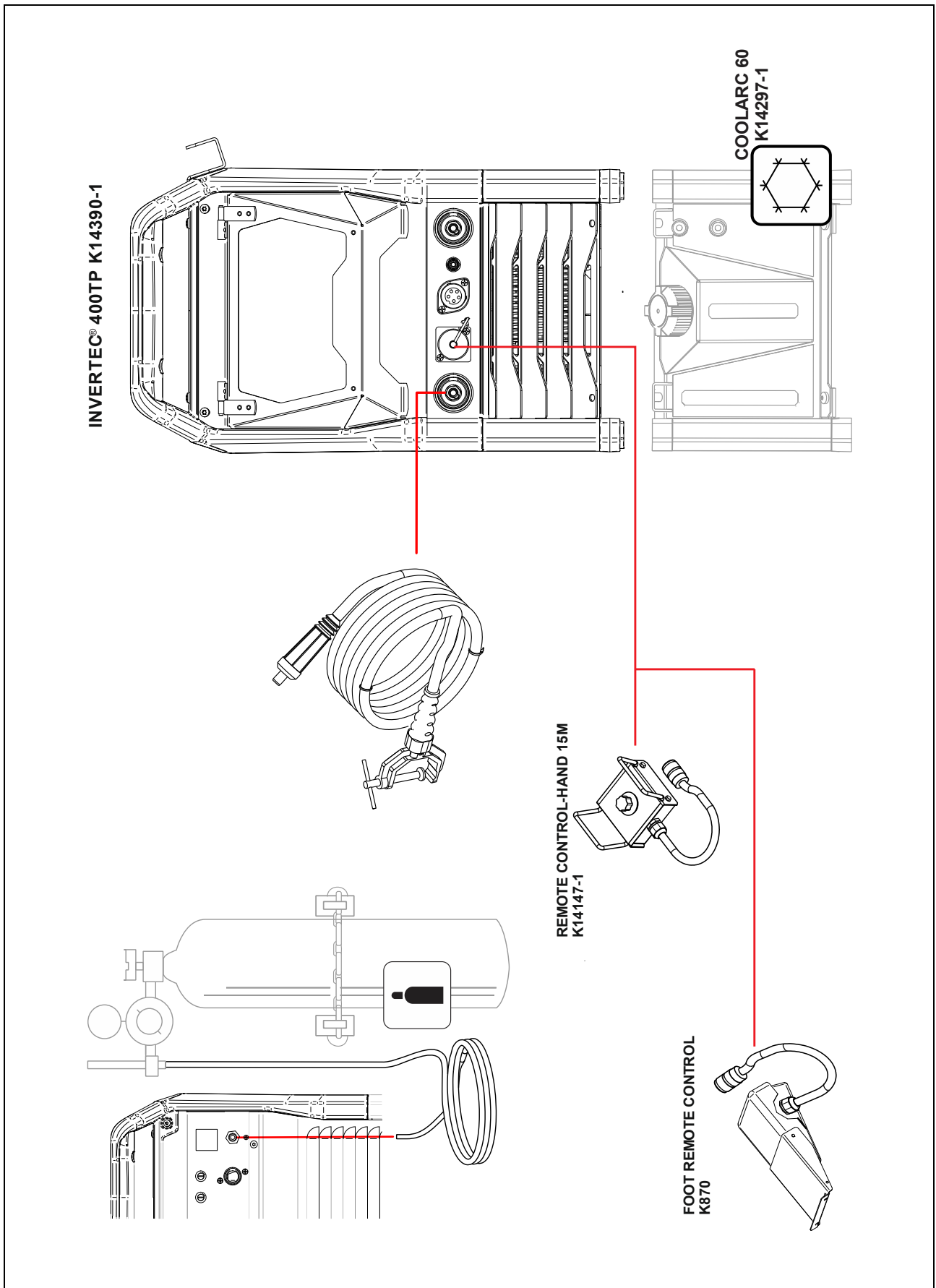
Electrical Schematic

Refer to the "Spare Part" manual supplied with the machine.

Accessories

TIG PREMIUM TORCHES AIR	5mt	8mt
PROTIG IIIS 10 RL	W000382715-2	W000382716-2
PROTIG IIIS 20 RL	W000382717-2	W000382718-2
PROTIG IIIS 30 RL	W000382719-2	W000382720-2
PROTIG IIIS 40 RL	W000382721-2	W000382722-2
PROTIG NGS 10 EB	W000278394-2	W000278395-2
PROTIG NGS 20 EB	W000278396-2	W000278397-2
PROTIG NGS 30 EB	W000278398-2	W000278399-2
PROTIG NGS 40 EB	W000278400-2	W000278401-2
TIG PREMIUM TORCHES WATER	5mt	8mt
PROTIG IIIS 35W RL	W000382725-2	W000382726-2
PROTIG IIIS 40W RL	W000382727-2	
PROTIG NGS 35W EB	W000278404-2	000278405-2
PROTIG NGS 40W EB	W000278406-2	W000278407-2
TIG TORCHES AIR	4mt	8mt
WTT2 9 RL	W000278879	W000278922
WTT2 9 EB	W000278875	
WTT2 17 RL	W000278884	W000278917
WTT2 17 EB	W000278882	W000278919
WTT2 26 RL	W000278890	W000278913
WTT2 26 EB	W000278887	W000278915
TIG TORCHES WATER	4mt	8mt
WTT2 18W RL	W000278898	W000278899
WTT2 18W EB	W000278896	W000278901
WTT2 20W RL	W000278894	W000278905
WTT2 20W EB	W000278892	W000278909
TORCHES ACCESSORIES		
HORIZONTAL POTENTIOMETER	WP10529-3	
VERTICAL POTENTIOMETER	WP10529-4	
UP AND DOWN BUTTONS	WP10529-2	
BLADE	W000279245	
REMOTE CONTROLS		
REMOTE CONTROL – HAND 15 M	K14147-1	
FOOT REMOTE CONTROL	K870	
OPTIONS		
COOLARC®60	K14297-1	
FREEZCOOL (9,6L COOLING LIQUID)	W000010167	
CART 4-WHEELS	K14298-1	
EXTENSION CORD 15M (*)	K14148-1	
CABLES		
KIT 50C50	W000260682	
GROUND CABLE 400A/70MM²; 5 m	GRD-400A-70-5M	
GROUND CABLE 400A – 70 MM² – 10m	GRD-400A-70-10M	
GROUND CABLE 400A/70MM²; 15 m	GRD-400A-70-15M	
ELECTRODE HOLDER 400A/70MM² - 5 m	E/H-400A-70-5M	
GOUGING TORCH		
FLAIR® 600GOUGING TORCH	W000010136	

Connection Diagram



Dimension Diagram

