SubArc Portable Welding System is a ready-to-weld submerged arc system for pressure vessel, pipe and welding that requires positioning equipment which can adapt to your application.

Self-contained system houses column, boom and power source on a mobile platform, providing a compact, turnkey submerged arc welding solution.

Built-in fork pockets and castor wheels provide mobility options to move the welding system to your workpiece.

Ease of positioning the weld head through use of integrated motorized column, manual telescoping boom, cross slides and 360-degree column rotation.

Motorized column with pendant control provides 44 inches (1,117 mm) of vertical travel to accommodate workpieces of various heights.

Manual telescoping boom provides 31 inches (787 mm) of horizontal travel.

Manual cross slides provide 7.87 inches (200 mm) of fine vertical and horizontal torch adjustment.

Packages include:
- Portable column and boom
- SubArc Digital power source
- SubArc Interface Digital and control cable
- SubArc Wire Drive 400 Digital Low Voltage
- 25 lb. (11.3 kg) capacity flux hopper with valve
- 60 lb. (27 kg) wire reel and support assembly
- OBT 600 torch (650 system) or
- OBT 1200 torch (1000 system)
- Wire straightener
- Manual cross slides

Note: Drive rolls and contact tips are sold separately.
Portable Column and Boom Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Input Voltage</th>
<th>Column Stroke</th>
<th>Column Travel</th>
<th>Boom Stroke</th>
<th>Boom Travel</th>
<th>Base Rotation</th>
<th>Minimum Working Height</th>
<th>Maximum Working Height</th>
<th>Overall Height</th>
</tr>
</thead>
<tbody>
<tr>
<td>120 V, 1-phase, 60 Hz</td>
<td>44 in. (1,117 mm)</td>
<td>Constant speed</td>
<td>31 in. (787 mm)</td>
<td>Manual</td>
<td>360°</td>
<td>DC 650: 33.5 in. (851 mm)</td>
<td>DC 1000: 26.25 in. (667 mm)</td>
<td>102 in. (2,590 mm)</td>
</tr>
</tbody>
</table>

SubArc Digital Series Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Model</th>
<th>Torch Included with Welding System</th>
<th>Amperage/Voltage Ranges</th>
<th>Rated Output</th>
<th>IP Rating</th>
<th>Amps Input at Rated Load Output, 60 Hz</th>
<th>Maximum Open-Circuit Voltage DC**</th>
</tr>
</thead>
<tbody>
<tr>
<td>SubArc DC 650 Digital</td>
<td>OBT 600</td>
<td>50–815 A in CC mode 20–44 V in sub arc mode</td>
<td>650 A at 44 V, 100% duty cycle 815 A at 44 V, 60% duty cycle</td>
<td>IP23</td>
<td>126 63 50.4 50 34.8 3.8* 1.9* 1.4* 1.52* 0.76*</td>
<td>75 Vpk</td>
</tr>
<tr>
<td>SubArc DC 1000 Digital</td>
<td>OBT 1200</td>
<td>100–1,250 A in CC mode 20–44 V in sub arc mode</td>
<td>1,000 A at 44 V, 100% duty cycle 1,250 A at 44 V, 60% duty cycle</td>
<td>IP23</td>
<td>180 90 72 73 53 5.8* 2.9* 2.4* 3.2* 0.5*</td>
<td>68 Vpk</td>
</tr>
</tbody>
</table>

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

All SubArc Digital Series models are certified by Canadian Standards Association to both the Canadian and U.S. Standards.

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

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)

OBT Torch Contact Tips
192700 192701 192702 192703 192704 192705
192701 192702 192703 192704 192705
192141 192142 192143 192144

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).

Ordering Information

Equipment and Options | Stock No. | Description | Qty. | Price |
<table>
<thead>
<tr>
<th></th>
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<tr>
<td>SubArc DC 650 Digital Portable Welding System</td>
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<td>SubArc DC 650 Digital Portable Welding System</td>
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<tr>
<td>SubArc DC 1000 Digital Portable Welding System</td>
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<td>SubArc DC 1000 Digital Portable Welding System</td>
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<tr>
<td>Accessories</td>
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<tr>
<td>Drive Rolls</td>
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<td>See above. Order separately</td>
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<td>Contact Tips</td>
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<td>See above. Order separately</td>
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<tr>
<td>14-pin Insight Core™ Module</td>
<td>301072</td>
<td>Requires Insight Core to SubArc Digital Series Adapter (301295)</td>
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<td>Insight Core™ to SubArc Digital Series Adapter</td>
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<td>Date:</td>
<td>Total Quoted Price:</td>
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