

# Subarc AC/DC 1250

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**Submerged Arc**  
**Welding Power Source**



## Quick Specs



### Heavy Industrial Applications

Railcar  
Shipbuilding  
Heavy Fabrication  
Pipe Manufacturing  
Pressure Vessel

### Process

Submerged Arc (SAW)  
Electroslag (ESW)  
Air Carbon Arc Cutting  
and Gouging (CAC-A)

**Input Power:** 380-400 VAC, 3-phase

**Rated Output:** 1000 A at 44 VDC  
100% Duty Cycle

**Weld Output Range:** 250 – 1250 A in CC modus  
25-44V in CV modus

**Weight:** 540 kg

## The Power of Blue.®

**Easier setup and operation.** The improved user interface of the Subarc AC/DC makes setting up and operating the power source relatively simple. The operator is presented only with the necessary functions to set process and control output.

**AC balance** is set using a rotary switch mounted on the front control panel. There is no need for a laptop PC connection to do complex wave shaping before operating. In multiple arc configurations, the power source interface control does the phase shifting for you.

**Easily change the amount of electrode positive and electrode negative polarity** from the front control panel of the power source.

**Greater control of deposition, penetration, and heat input.** Miller SAW solutions are designed to deposit large amounts of filler material and achieve deep penetration on thick or large surface area weldments.



### Enhanced distortion control.

The AC output of the Subarc AC/DC enhances user control of heat input into the weldment, minimizing distortion, and reducing structural or fit-up problems during or after final assembly.

**Multi-arc capable.** 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 combinations. Using multiple arcs further increases deposition rate, resulting in shorter welding cycles for very thick weldments without compromising quality.

**AC or DC operation** provides versatility and outstanding arc performance.

**Part of a customized system.** Miller power sources and system components enable users to implement a customized SAW solution that best fits their operations when combined with the travel and manipulation equipment they prefer.



Power source is warranted for 3 years, parts and labor.

**MADE IN USA**  
APPLETON, WI



Distribuito da:

**TECNOWELD**  
di ROBERTO GAMBERINI

MATERIALI E MACCHINE PER SALDATURA

Via dell'Artigianato, 4 - 60019 SENIGALLIA (AN)  
Tel. 071.7923031 (r.a.) - Fax 071.7927097  
<http://www.tecnoweld.it> E-mail: [info@tecnoweld.it](mailto:info@tecnoweld.it)

## Specifications



IP- Rating	Rated output	A/V Range	Max. Opencircuit Voltage	Dimensions	Weight
IP 21S	1000A 100% Duty Cycle	25 – 44 V 250 – 1250 A	71 V	H: 1118 mm W: 692 mm D: 1168 mm	540 kg

## Ordering Information

Power Source	Stock No.	Description
<b>Subarc AC/DC 1250</b>	<b>907 456</b>	400 V, 50/60Hz
<b>Accessories</b>		
HDC 1500 A	<b>300 439</b>	Analog controller
HDC 1500 DX	<b>300 438</b>	Digital controller
RAD - 100	<b>300 474</b>	Heavy-duty, right-angle drive motor for automated strip clad applications
RAD - 400	<b>195 265</b>	Standard-speed, right-angle drive assembly for 1/8 in or larger wires
RAD - 780	<b>195 266</b>	High-speed, right-angle drive assembly for 1/8 in or larger wires
OBT 600	<b>043 923</b>	600 amp, 100% duty cycle, air-cooled
OBT 1200	<b>043 900</b>	1200 amp, 100% duty cycle, air-cooled
Fluxhopper	<b>194 775</b>	25 lb capacity
Parallel Control Box	<b>194 711</b>	Must be used when paralleling two units
Wire Straightener	<b>199 733</b>	For RAD-400 and RAD-780
Spool Support Assembly	<b>119 438</b>	Support for 27 kg reels
Wire Reel	<b>108 008</b>	For 27 kg coil
Cable Kit for HDC 1500 Controllers	<b>195 308</b>	Includes 9 m 14-pin interconnect cable and 3 m motor cable



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