

# Idealarc® R3R-400 & 500

## Processes

Stick, TIG, Gouging

## Product Number

K1285-16 R3R-400 230/460

K1286-16 R3R-500 230/460

K1286-25 R3R-500 230/460/575

See back for complete specs

## Input Power (Voltage/Phase/Hertz)

K1285-16/K1286-16: 230/460/3/60

K1286-25: 230/460/575/3/60

## Input Current at Rated Output

(60% Duty Cycle)

R3R-400: 74/37A

R3R-500: 88/44A

## Rated Output

R3R-400: 400A/36V/60% Duty Cycle

R3R-500: 500A/40V/60% Duty Cycle

## Output Range

R3R-400: 60-500A, Max. OCV: 67V

R3R-500: 72-625A, Max. OCV: 67V

## Weight/Dimensions (H x W x D)

R3R-400: 402 lbs. (183 kg)

R3R-500: 446 lbs. (203 kg)

27.5 x 22.3 x 32 in.

(699 x 566 x 813 mm)

## Heavy Duty Stick Welding and Arc Gouging

Look to the R3R-400 and R3R-500 for your heavy duty stick welding needs. Whether you are using cellulosic, low hydrogen, stainless steel or hardfacing electrodes, the Idealarc® R3R-400 and R3R-500 produce a smooth, quality arc for consistent results day-in and day-out.

### FEATURES

- ▶ **Substantial amperage ranges** include the R3R-400 at 60-500 amps and the R3R-500 at 72-625 amps.
- ▶ **Easy to operate** - Calibrated current control knob makes procedure setting simple and easy.
- ▶ **Polarity switch, voltmeter and ammeter are standard** on the K1285-16 R3R-400 and K1286-16 R3R-500.
- ▶ **Arc gouge** with the R3R-400 using up to 5/16 in. (7.9 mm) diameter carbon electrode and the R3R-500 using up to 3/8 in. (9.5 mm) diameter carbon electrode.
- ▶ **Smooth arc** - Makes it easy to weld with mild steel, low hydrogen, stainless steel and hardfacing electrodes.
- ▶ **Stackable case design** - With built-in lift hook allows for easy storage and handling. Machines can be safely stacked three high to conserve floor space.



- ▶ **Both the R3R-400 and R3R-500 can be used for limited DC TIG welding** – Simply add TIG accessories and shielding gas.
- ▶ **Seven-year warranty** on the power rectifier.

### INPUT



### OUTPUT



Two Year Extended  
Warranty Available in  
the U.S.A. and Canada.



## RECOMMENDED ACCESSORIES

### GENERAL OPTIONS



**Undercarriage**  
Platform undercarriage with mounting for two gas cylinders at rear of welder.  
**Order K841**



**Work Lead Package**  
15 ft. (4.5 m) 4/0 cable with 1/2 in. (12.7 mm) stud lug and work clamp.  
**Order K2149-1**



**Arc Tracker™**  
Connect the Arc Tracker™ between any DC welding power source and the work clamp to access a wide array of data monitoring information regarding your welding arc, including True Energy™ and Production Monitoring™.  
**Order K3019-1**



**Welding Fume Extractors**  
Lincoln Electric offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.  
**Request Publication MC08-70**



**Accessory Kit – 400 Amp**  
For stick welding. Includes 35 ft. (10.7 m) 2/0 electrode cable with lug, 30 ft. (9.1 m) 2/0 work cable with lugs, headshield, filter plate, work clamp and electrode holder.  
**Order K704**



**Remote Output Control**  
For remote output of welding voltage. Consists of control box with 25 or 100 ft. (7.6 or 30 m) of four conductor cable and 6 pin MS-type connector.  
**Order K857** for 25 ft. (7.6 m)  
**Order K857-1** for 100 ft. (30 m)



### TIG OPTIONS

**Pro-Torch™ TIG Torch**  
A full line of air-cooled and water-cooled torches available.  
**Request Lincoln Electric publication E12.150**



**TIG Module**  
Portable, high frequency unit with gas valve for TIG welding. Rated at 300 amps/60% duty cycle. Requires TIG Module Control Cable.  
**Order K930-2**



**Docking Kit**  
Provides a means to “dock” the TIG Module on top of a flat surface measuring at least 10 x 15 in. (254 x 381 mm). Includes a latch and provisions for a user-supplied padlock to lock the TIG Module in place.  
**Order K939-1**



**Hand Amptrol™**  
Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6-pin plug connection). Velcro straps secure torch.  
**Order K963-3** (One size fits all Pro-Torch™ TIG Torches.)



**Foot Amptrol™**  
Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).  
**Order K870**



**Contactor Kit**  
Installs in the K930-2 TIG Module for use with welders without a contactor. Makes the TIG torch electrode electrically “cold” until the Amptrol™ is activated.  
**Order K938-1**



**Control Cable**  
Connects TIG Module to power source.  
**Order K936-3** for 9-pin to 6-pin plus 115V.



**Control Cable Extension**  
Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. Available in 45 ft. (13.7 m) sections.  
**Order K937-45**



**Deluxe Adjustable Gas Regulator & Hose Kit**  
Accommodates CO<sub>2</sub>, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.  
**Order K586-1**

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® R3R-400	K1285-16	230/460/3/60	400A/36V/60%	74/37A	60-500A Max. OCV: 67V	27.5 x 22.3 x 32 (699 x 566 x 813)	402 (183)
Idealarc® R3R-500	K1286-16 K1286-25	230/460/3/60 230/460/575/3/60	500A/40V/60%	88/44A	72-625A Max. OCV: 67V		446 (203)

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables.  
Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

### CUSTOMER ASSISTANCE POLICY

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