

IDEALARC® R3R



R3R shown with optional meters and polarity switch.



The Idealarc R3R is one of Lincoln's premium stick welders. The R3R series consists of 400 amp, and 500 amp machines. These produce an extremely smooth and stable DC arc for welding a wide variety of materials including carbon, low alloy, and stainless steels, as well as, a forceful driving arc for gouging applications.

Applications include: field construction, shipbuilding, offshore oil platforms, water towers, storage tanks, pipeline welding, industrial shop fabrication and maintenance welding.

The R3R family is especially suited for critical welding applications using low hydrogen and stainless steel electrodes. They produce an arc with superior all position welding stability, which resists pop-outs, limits spatter and makes code quality welds and clear x-rays easier to attain.

The R3R Arc Force Control also adds to the operator appeal of these units. By simply adjusting the Arc Force Control, you can either create a soft welding arc for critical welding applications or a forceful driving arc for heavy duty welding applications.

ADVANTAGE LINCOLN

- Great operator appeal. Despite voltage or temperature changes, the R3R compensates to continue to produce a quality, low spatter, smooth arc without pop-outs.
- R3R's line voltage compensation holds the output constant with a $\pm 10\%$ input variation.
- Easy to operate. Calibrated current control knob makes procedure setting simple and easy.
- Traditional design provides long life and low cost operation.
- Smooth arc makes it easy to weld with different electrodes, including 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 safely be stacked three high to conserve floor space.
- All weather protection for field construction.
- Submersion dipped transformer assembly for added corrosion and moisture protection.
- Totally enclosed fan motor is permanently lubricated.
- Powder paint finish for increased durability.
- Fan-cooled for extra thermal protection.
- Designed to NEMA specifications.
- Manufactured under a quality system certified to ISO 9002 requirements.

TECHNICAL SPECIFICATIONS

Product Name	Rated DC Output Amps/Volts/Duty Cycle ⁽¹⁾	Output Range (continuous)	Weight (net)	Dimensions H x W x D
R3R-400	400A / 36V / 60% ⁽²⁾ Max. OCV 67	60-500	402 lbs. (183 kg)	27.5 x 22.3 x 30.1 in. (699 x 566 x 765 mm)
R3R-500	500A / 40V / 60% Max. OCV 67	75-625	446 lbs. (203 kg)	

⁽¹⁾ Based on a 10 minute period.

⁽²⁾ Also Lincoln plus rated at 400A/40V/60%.

ORDERING INFORMATION

Product Name Standard Voltage	Input Current at Rated DC Output	Product Number		
		Std. Machine	with Ammeter, Voltmeter & Polarity Switch	with Ammeter, Voltmeter, Polarity Switch & Pocket Amptrol
R3R-400 230/460/3/60	74/37	K1285-12	K1285-16	---
R3R-500 230/460/3/60	88/44	K1286-12	K1286-16	K1286-20

OPTIONS AVAILABLE

Remote Current Control - Portable current control provides the same dial range as the current control on the welder. Consists of a 6-pin Amphenol connector which plugs into the remote control Amphenol.

25 ft. cable - Order K857.

100 ft. cable - Order K857-1.

Accessory Kits (For R3R-400) -

Consists of electrode and work cables, headshield, electrode holder and work clamp. **Order K704.**

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

Undercarriage - A mounting frame with wheels for hand moving. **Order K817P.**

TIG WELDING OPTIONS

TIG Module - Portable, high frequency unit with gas valve for TIG welding. Rated at 300 amps/60% duty cycle.

Order K930-2.

Water Valve Kit - For use with a water-cooled TIG torch. Controlled by the preflow and afterflow timers. Installs inside the TIG Module. **Order K844-1.**

Amptrol™ - Provides 25 ft. (7.6m) of remote current control for TIG welding. (6 pin MS-type plug connection).

Foot Amptrol - Order K870.

Hand Amptrol:

For use with LA-9, LA-17, and LW-20 torches - Order K963-1.

For use with LA-26 and LW-18 torches - Order K963-2.

Contactor Kit - For use with the TIG Module. **Order K938-1.**

Docking Kit - Secures TIG Module on top of R3R machines, or any flat surface at least 10 in x 15 in (254mm x 381mm).

Mounts using strong grip adhesive pad or fasteners. Includes latch and provisions for a user-supplied padlock.

Order K939-1.

Control Cable - Connects the TIG Module to the R3R machine (9 to 6 plus 115V plug). **Order K936-3.**

Control Cable Extensions - Allows the TIG Module to be operated at distances up to 185 ft. (61m) from the power source.

Two lengths are available:

22.5 ft. - Order K937-22.5.

45 ft. - Order K937-45.



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