

IDEALARC[®] 250



Lincoln Electric's Idealarc 250 is a single phase, constant current arc welding power source. It offers a broad welding amperage range of 35-300 amps AC and 40-250 amps DC welding. It is an extremely useful stick welding power source for maintenance repair, fabrication, construction, erecting and hardfacing applications.

The Idealarc 250 produces an extremely smooth arc for welding a variety of materials, including carbon, low alloy and stainless steels, as well as cast iron. Use the electrode polarity switch on the front of the machine to select a DC welding arc for use on thin materials where a low current, stable arc is necessary. Or select an

AC welding arc for large diameter, general purpose electrodes for welding heavier plate where higher deposition rates and travel speeds are desired.

Though designed for stick welding, the Idealarc 250 may also be used for TIG welding. For DC TIG welding, use the "scratch start" method. For AC welding, and higher quality DC work, use in conjunction with Lincoln's K799 Hi-Freq™ kit.

Combined with the Hi-Freq, the Idealarc 250 is a cost effective combination for occasional production or repair TIG welding of aluminum, magnesium, thin gauge stainless steel and many space-age metals.

ADVANTAGE LINCOLN

- Easy to install. Comes with input cable and attached plug.
- Easy to operate. Full range continuous current control dial with current indicator for exact heat required for each job.
- Settings are precise and will not "creep".
- Stackable case design allows machines to be stacked 3 high to save valuable floor space.
- Polarity switch saves time offering AC, DC+ or DC- with a twist of the wrist.
- 300 amps AC output for maximum productivity.
- 250 amps DC output for maximum quality with every type of electrode including low hydrogen, stainless steel, hardfacing, aluminum and bronze.
- Outstanding arc stability, transformer design and built-in stabilizer provides popout-resistant welding with all AC electrodes.
- Fan-cooled for extra thermal protection.
- NEMA rated (60 Hz only).
- UL listed (60 Hz only).
- 3-year warranty including parts and labor.
- Manufactured under a quality system certified to ISO 9002 requirements.

THE TOTAL SOLUTION

To obtain the best welding performance, Lincoln electrodes are strongly recommended. They are designed for easier arc striking and a more stable arc when used with the Idealarc 250.

STAINLESS APPLICATIONS

Lincoln's Red Baron® line of stainless steel electrodes offer outstanding quality and performance. The most popular and commonly used stainless electrodes are the Red Baron 308, 309, and 316 types.

MILD STEEL APPLICATIONS

Lincoln's Fleetweld® 37 is a general purpose electrode, primarily used for general fabrication and repair of mild steel parts or equipment. Lincoln's Fleetweld 180 electrode is used in applications where a driving, deep penetrating arc is required. Lincoln's Fleetweld 5P is recommended for DC+ welding and is your best choice for welding dirty, rusty, painted or plated steels.

LOW HYDROGEN APPLICATIONS

Lincoln's Jetweld® LH-70 is a general purpose DC welding electrode used mainly for welding carbon and low

alloy steels. The iron powder in the coating provides high deposit rates consistent for quality weldments required in the flat, vertical and overhead welding positions. LH-70 also has excellent mechanical properties. Lincoln 7018 AC or LH-73 are also recommended for AC welding applications where a high quality, low hydrogen weld deposit is required.

HARDFACING APPLICATIONS

The Wearshield® line of electrodes offers a variety of hardfacing combinations for buildup, abrasion, impact, metal to earth, and metal to metal wear.

TECHNICAL SPECIFICATIONS

Product Name	Rated Output Amps/Volts/Duty Cycle ⁽¹⁾		Output Range	Weight (net)	Dimensions H x W x D
	AC	DC			
Idealarc 250	300A 32V 20% 72 OCV	250A 30V 30% 70 OCV	35-300 AC 40-250 DC	350 lbs. (159 kgs)	27 x 19 x 21.5 in. (686x483x546mm)
Idealarc 250	250A 30V 30% 72 OCV	250A 30V 30% 70 OCV	35-250 AC 40-250 DC	350 lbs. (159 kgs)	27 x 19 x 21.5 in. (686x483x546mm)

⁽¹⁾ Based on a 10 minute period.

ORDERING INFORMATION

Standard Voltage	Rated Input Current at 230V		Product Number	
	w/o PFC	with PFC	Standard Idealarc 250	Idealarc 250 w/Power Factor Capacitors
208/230/460/1/60	86	68	K1053-7	K1053-9
230/460/575/1/60	86	68	K1053-8	K1053-10

RECOMMENDED OPTION

Power Factor Capacitors

Factory installed option. Reduces input amps by about 30% at rated load.

Undercarriage

For easy portability. Includes handle, axle, wheels, front bracket and mounting hardware. Overall width 24.56 in. (624mm). **Order K866.**

Hi-Freq

Converts Idealarc 250 into a TIG welder. See publication E3.200 for full details. **Order K799.**

Accessory Kit for Idealarc 250

Consists of electrode holder, work clamp, electrode and work cables, and headshield with lens and cover plate. **Order K710.**



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**Stick Welders
E2.70 2/99**

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