

# Lincoln Electric Submerged Arc Welding Guide

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## THE SUBMERGED ARC WELDING PROCESS 10 SUBMERGED ARC WELDING

www.lincolnelectric.eu ELECTRICAL STICK OUT Electrical Stick Out setting: The electrical stick out or CTWD (contact tip to work distance) is the distance set between the contact tip end and the work piece. The stick out needs to be kept constant along the weld if

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It is a type of welding that uses a welding power supply to create an electric arc between a metal stick ("electrode") and the base material to melt the metals at the point of contact. Submerged Arc Flux and

wire combinations for single- and multiple-pass welding in automatic and semi-automatic applications.

SubArcTractor Submerged Arc Welding Quick Specs Miller Electric Mfg. Co. An ITW Welding Company 1635 West Spencer Street P.O. Box 1079 Appleton, WI 54912-1079 USA Equipment Sales US and Canada MillerWelds.com Phone: 866-931-9730 FAX: 800-637-2315 International Phone: 920-735-4554 International FAX: 920-735-4125 Digital weld controller package ...

MULTI-PROCESS WELDERS Processes Stick, TIG, MIG, Flux-Cored, Submerged Arc, Gouging Industrial DC Multi-Process Welders Rated Output 600A/44V/100% 680A/44V/60% Output Range CV: 70A/13V - 780A/44V CC: 90A/24V - 780A/44V Weight/Dimensions (H x W x D) 522 lbs. (237 kg) 30.75 x 22.25 x 39.0 in. (781 x 567 x 988 mm) Rugged construction, simple controls and a 100% duty cycle output rating ...

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semiautomatic DC constant voltage (wire) welder, 2) a DC manual (stick) welder, or 3) an AC welder with reduced open-circuit volt-age. In most situations, use of a DC, constant voltage wire welder is recommended. And, do not work alone! Disconnect input power or stop engine before installing or servicing this equipment.

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