

# SubArc Tractor

**Submerged Arc Welding** 

## Quick Specs

### Heavy Industrial Applications

Storage tank construction  
Shipbuilding  
Bridge decks  
Beam construction  
Plate seams

### Processes

Submerged arc (SAW)

### Recommended Miller Power Supplies

SubArc DC 650/800 Digital  
SubArc DC 1000/1250 Digital  
SubArc AC/DC Digital

**Wire Feed Speed** 30–400 ipm (0.8–10.2 m/min.)

**Wire Size Range** 1/16–7/32 in. (1.6–5.6 mm)

**Travel Speed** 4–66 ipm (10–168 cm/min.)

**Net Weight** 162 lb. (73 kg) without flux or wire

**Designed and built to provide maximum reliability** in the toughest conditions. This simple to use self-propelled submerged arc welding tractor can easily connect to Miller SubArc DC or AC/DC Digital power supplies.

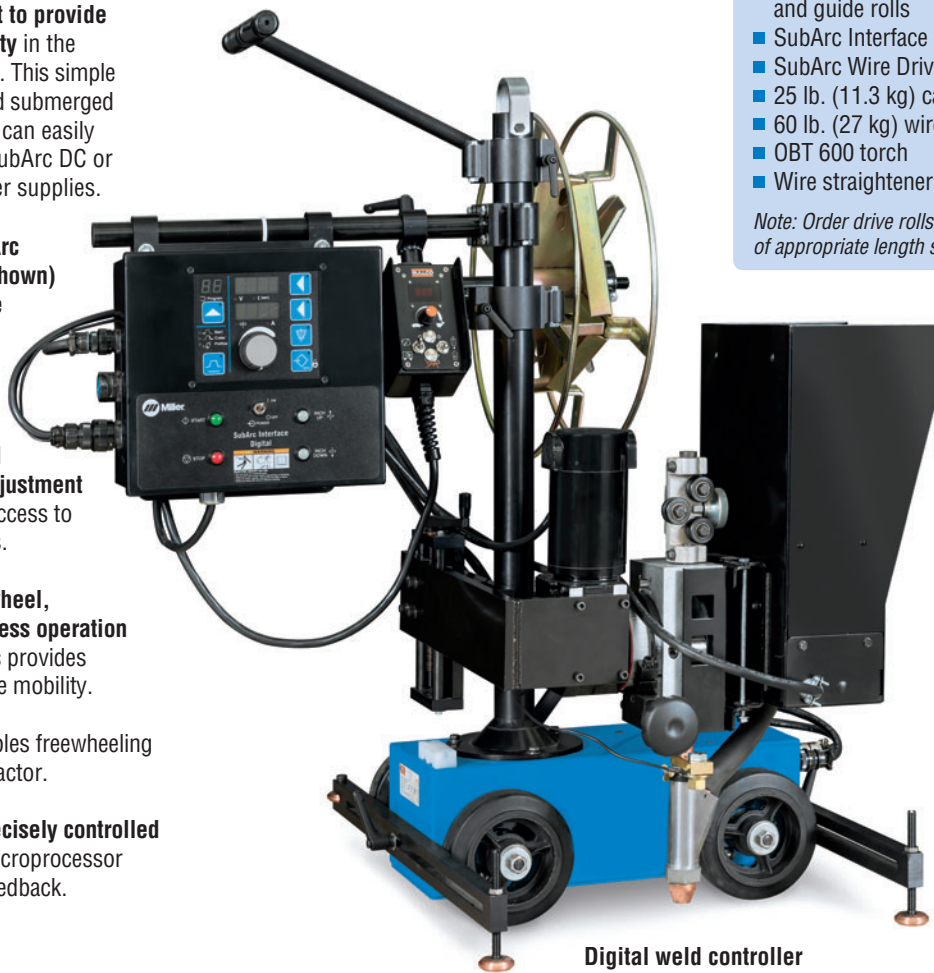
Available with **SubArc Interface Digital (shown)** or **SubArc Interface Analog** controller.

**Vertical, horizontal and rotary torch adjustment** allows for greater access to hard-to-reach spots.

**Heavy-duty, four-wheel, chain-driven trackless operation with rubber wheels** provides superior and reliable mobility.

**Manual clutch** enables freewheeling movement of the tractor.

**Travel speed is precisely controlled** by a closed-loop microprocessor control with tach feedback.



Digital weld controller package shown.

### Packages include:

- SubArc Tractor with remote start/stop control and guide rolls
- SubArc Interface weld controller
- SubArc Wire Drive 400 for Tractor
- 25 lb. (11.3 kg) capacity flux hopper with valve
- 60 lb. (27 kg) wire reel
- OBT 600 torch
- Wire straightener

*Note: Order drive rolls, contact tips, and control cables of appropriate length separately.*

**Easily accommodates a 60-pound (27 kg) wire reel** for fewer wire changeovers.

**All of the arms, support posts, etc. can be removed** with quick acting clamps enabling the carriage to be totally dismantled without tools and easily passed through an 24-inch (610 mm) manhole.

**Simple and easy change-over** from fillet to butt weld configuration.

**Miller recommends**



Tractor warranted for 1 year, parts and labor.



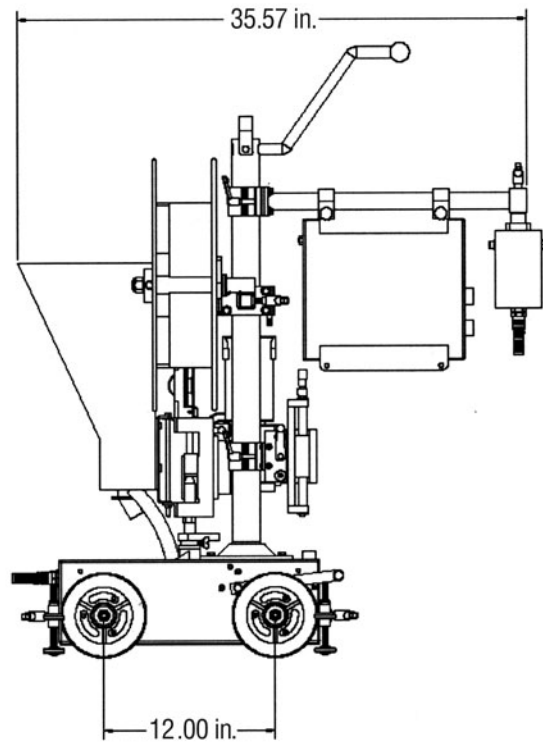
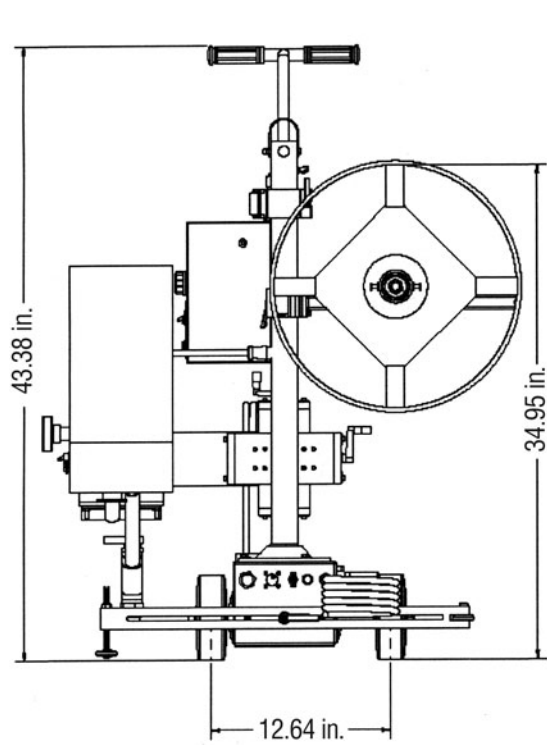
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**MillerWelds.com**



## SubArc Tractor

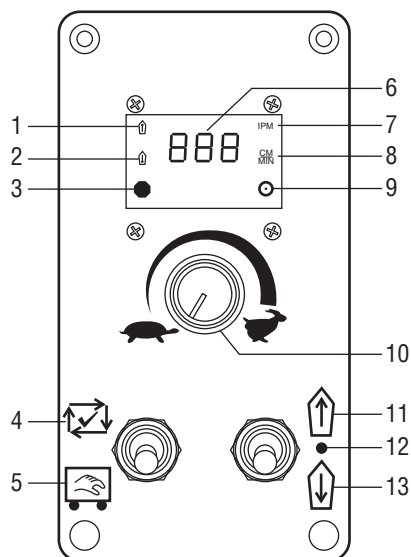


The SubArc Tractor is a highly flexible self-contained welding unit comprised of a travel system and a variety of quality engineered components designed to produce precision, high-quality submerged arc welds.

The SubArc Tractor comes complete with a main mounting mast and handle assembly, mounting arm for one wire reel, vertical and horizontal 4 x 4 inch slides, control support arm and one set of two adjustable guide roll arms.

The friction drive heavy-duty travel carriage utilizes a positive chain drive powering four rubber-tired wheels (operating temperature -30 to 125 degrees Fahrenheit [-34 to 51° C]) with a closed-loop tach feedback for accurate speed control. A manual clutch enables freewheeling movement of the carriage. Remote pendant control box houses forward/stop/reverse switch and infinitely variable four-turn speed potentiometer as well as LED display in ipm or cm/min. Available with either the SubArc Interface Digital or SubArc Interface Analog Controller. See literature AD/7.3.

## Speed Control Panel



1. Forward Motion Commanded Indicator
2. Reverse Motion Commanded Indicator
3. Hold (Stop) Mode Active Indicator
4. Auto Enable Mode
5. Manual Carriage Mode
6. Speed and Parameter Display
7. Speed Display Indicator  
(Calibrated in Inches per Minute)
8. Speed Display Indicator  
(Calibrated in Centimeters per Minute)
9. Programming Mode Indicator (Flashing)
10. Speed Adjustment
11. Command Forward Motion
12. Neutral
13. Command Reverse Motion

## Wire Drive Assembly Specifications (Subject to change without notice.)

| Input Power from Welding Power Source | Wire Feed Speed              | Wire Diameter Capacity     | Max. Incline                            | Gun Positioning Slides                   | Drive Motor                        | Max. Spool Size Capacity | Travel Speed              | Dimensions  | Net Weight                        |
|---------------------------------------|------------------------------|----------------------------|---|--|------------------------------------|--------------------------|---------------------------|---|-----------------------------------|
| 24 VAC, 1-phase, 50/60 Hz, 200 watts  | 30–400 ipm (0.8–10.2 m/min.) | 1/16–3/16 in. (1.6–4.8 mm) | 30° depending on mounting configuration | 4 in. (101.6 mm) vertical and horizontal | 24 VDC permanent magnet gear motor | 60 lb. (27 kg)           | 4–66 ipm (10–168 cm/min.) | H: 43.375 in. (1,102 mm)<br>W: Varies depending on system configuration<br>D: 35.5 in. (903 mm) | 162 lb. (73 kg) without flux/wire |

## Accessories

### Drive Rolls

V-knurled drive rolls for use with hard-shelled cored wires.

- 132955** 1/16 in. (1.6 mm)
- 132960** 5/64 in. (2.0 mm)
- 132961** 3/32 in. (2.4 mm)
- 132962** 7/64 in. (2.8 mm)
- 132963** 1/8 in. (3.2 mm)
- 193700** 5/32 in. (4.0 mm)
- 193701** 3/16 in. (4.8 mm)



### Contact Tips

#### OBT 600 Torch Contact Tips

- 192700** 1/16 in. (1.6 mm)
- 192701** 5/64 in. (2.0 mm)
- 192702** 3/32 in. (2.4 mm)
- 192703** 7/64 in. (2.8 mm)
- 192704** 1/8 in. (3.2 mm)
- 192705** 5/32 in. (4.0 mm)

### Cables



#### SubArc Control Cables

- 260622030** 30 ft. (9.1 m)
- 260622050** 50 ft. (15.2 m)
- 260622060** 60 ft. (18.3 m)
- 260622080** 80 ft. (24.4 m)
- 260622100** 100 ft. (30.5 m)
- 260622120** 120 ft. (36.6 m)
- 260622200** 200 ft. (61.0 m)

Cable between SubArc Interface and power source.

# Ordering Information

| Equipment and Options                       | Stock No. | Description  | Qty. | Price |
|---|-----------|--|------|-------|
| SubArc Tractor only                         | 300945    |  |      |       |
| SubArc Tractor Digital Weld Control Package | 951614    | With SubArc Interface Digital. See literature AD/7.3 |      |       |
| SubArc Tractor Analog Weld Control Package  | 951615    | With SubArc Interface Analog. See literature AD/7.3  |      |       |
| <b>Accessories</b>                          |           |  |      |       |
| Drive Rolls                                 |           | See page 3   |      |       |
| OBT 600 Torch Contact Tips                  |           | See page 3   |      |       |
| SubArc Control Cables                       |           | See page 3   |      |       |

Date:

Total Quoted Price:

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