

SubArc 3-Wheel 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 1/16–5/32 in. (1.6–4.0 mm)

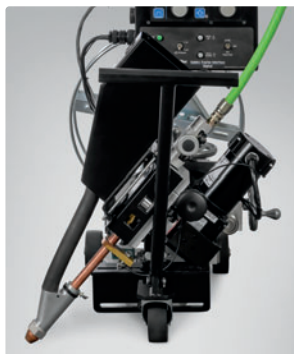
Travel Speed 5–70 ipm (0.13–1.75 m/min.)

Net Weight 120 lb. (54.4 kg) without flux and wire

The SubArc 3-Wheel Tractor is a compact size that makes it easy to configure, allowing greater flexibility and additional SAW setup options for shipbuilding, railcar and general fabrication. In addition, a new all-in-one interface lets welding operators control the tractor as well as the welding functions from the same panel, for improved ease of use.

Easy-to-use foot- or hand-operated clutch allows for easy engagement of tractor drive and disengagement to move tractor into position.

Flexible mast configuration allows torch to be positioned in multiple weld zones and adapts to your weld application.



Fillet weld configuration shown with 4 in. OBT Torch Body Extension (Sold separately. See page 3).



Package includes:

- SubArc 3-Wheel Tractor
- SubArc Tractor Interface Digital
- SubArc Wire Drive 400
- 10 lb. (4.5 kg) capacity flux hopper with manual 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.

SubArc Tractor Interface Digital provides easy-to-operate single control for power source and tractor operation.

Regulated travel speed ensures your actual and set travel speeds are consistent, improving weld quality.

Locking front wheel can be set in place to desired travel path.

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

Low-voltage operation and improved environmental protection. The new digital series accessories are powered with 24 VAC control voltage from the power source. All power sources, interface controls and wire drives are IP23 rated providing a high level of protection for harsh environments.



Tractor warranted for one year, parts and labor.

Miller recommends



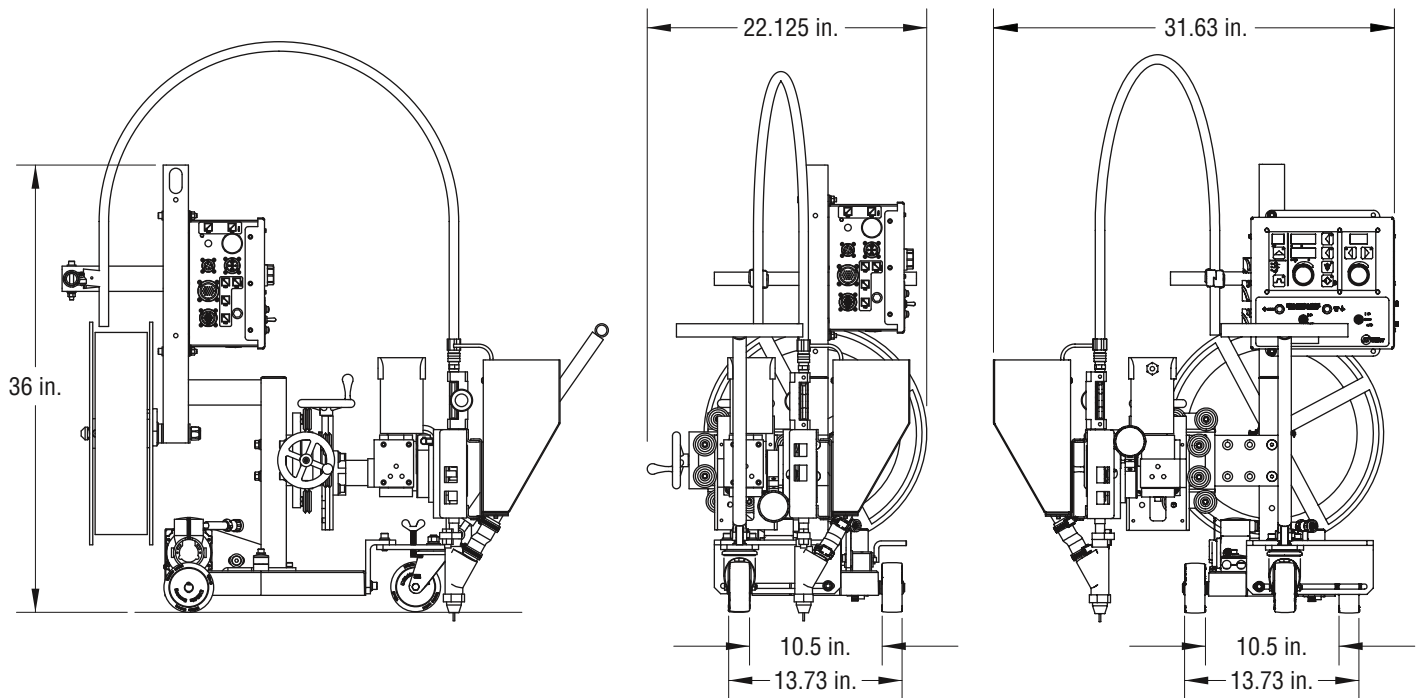
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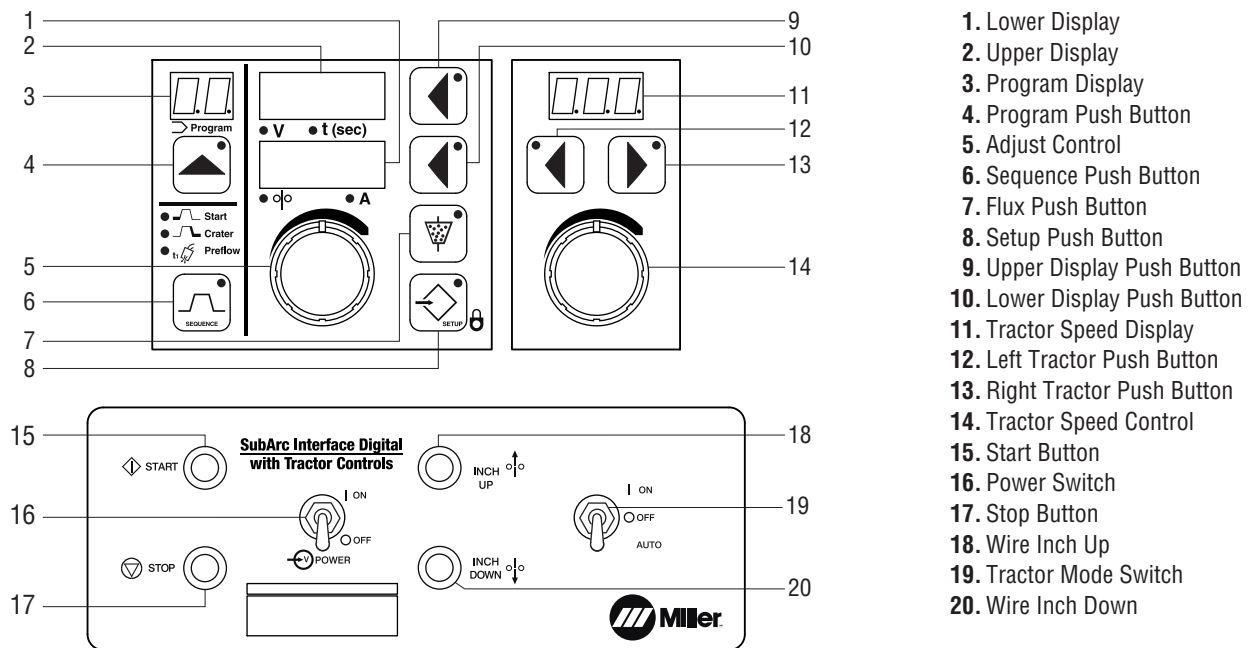
SubArc 3-Wheel Tractor



The SubArc 3-Wheel Tractor is a highly flexible self-contained welding unit comprised of a regulated travel system and a variety of quality engineered components designed to produce precise, high-quality submerged arc welds.

The SubArc 3-Wheel Tractor includes a cast aluminum base, main mounting mast, tractor drive motor, vertical and horizontal 3.5 x 3.5 inch slides and more.

SubArc Tractor Interface Digital Control Panel



Tractor Package Specifications (Subject to change without notice.)

Input Power from Welding Power Source	Wire Feed Speed	Wire Diameter Capacity	Gun Positioning Slides	Drive Motor	Max. Spool Size Capacity	Travel Speed	Dimensions	Net Weight
24 VAC, 1-phase, 50/60 Hz, 25 amps	30–400 ipm (0.8–10.2 m/min.)	1/16–5/32 in. (1.6–4.0 mm)	3.5 in. (88.9 mm)	38 VDC	60 lb. (27 kg)	5–70 ipm (0.13–1.75 m/min.)	H: 36 in. (914.4 mm) W: 43.25 in. (1,149.4 mm) D: 31.63 in. (803.4 mm)	120 lb. (54.4 kg) without flux/wire

Accessories

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)



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)

OBT 600 Torch Body Extensions

- 043967** 1 in. (25.4 mm)
- 043969** 2 in. (50.8 mm)
- 043973** 4 in. (101.6 mm)
- 043975** 6 in. (152.4 mm)



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 Tractor Interface and power source.



SubArc Flux Hopper Digital Low Voltage 300942

25-pound-capacity flux hopper with automatic flux valve. The opening is sized to allow hook-up of any flux-hopper-mounted recovery system. Includes slag screen and 11-foot (3.3 m) power cable.



Wire Reel 108008
For 60-pound (27 kg) coil of wire.

Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
SubArc 3-Wheel Tractor Digital Package	951755	24 VAC		
Power Sources				
SubArc DC 650 Digital	907622	230/460/575 V, 60 Hz		
SubArc DC 800 Digital (50 Hz) CE	907623	380/400/440 V, 50 Hz		
SubArc DC 1000 Digital	907624	230/460/575 V, 60 Hz		
SubArc DC 1250 Digital (50 Hz) CE	907625	380/400/440 V, 50 Hz		
SubArc AC/DC Digital	907620	460 V, 60 Hz		
SubArc AC/DC 1250 Digital (50 Hz) CE	907621	380/400 V, 50 Hz		
Accessories				
Drive Rolls	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)		
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)		
OBT 600 Torch Extensions	043967	1 in. (25.4 mm)		
	043969	2 in. (50.8 mm)		
	043973	4 in. (101.6 mm)		
	043975	6 in. (152.4 mm)		
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)			
SubArc Flux Hopper Digital Low Voltage	300942	25 lb. (11 kg) flux capacity		
Wire Reel	108008	For 60 lb. (27 kg) coil		

Date:

Total Quoted Price:

Distributed by:

