



TM-262546H

2018-12

Processes



Submerged Arc (SAW) Welding

Description

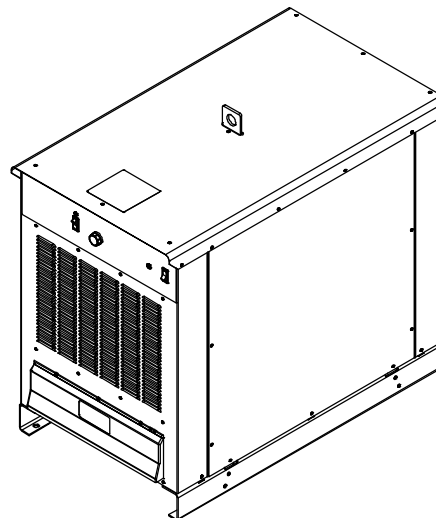


Arc Welding Power Source

SubArc AC/DC Digital, 1000 Amp SubArc AC/DC 1250 Digital CE And Non-CE Models

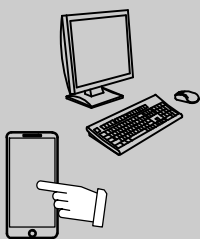
PARTS LIST

Eff w/Serial No. ME170053C And Following
For OM-265364 Revision A And Following



TECHNICAL MANUAL

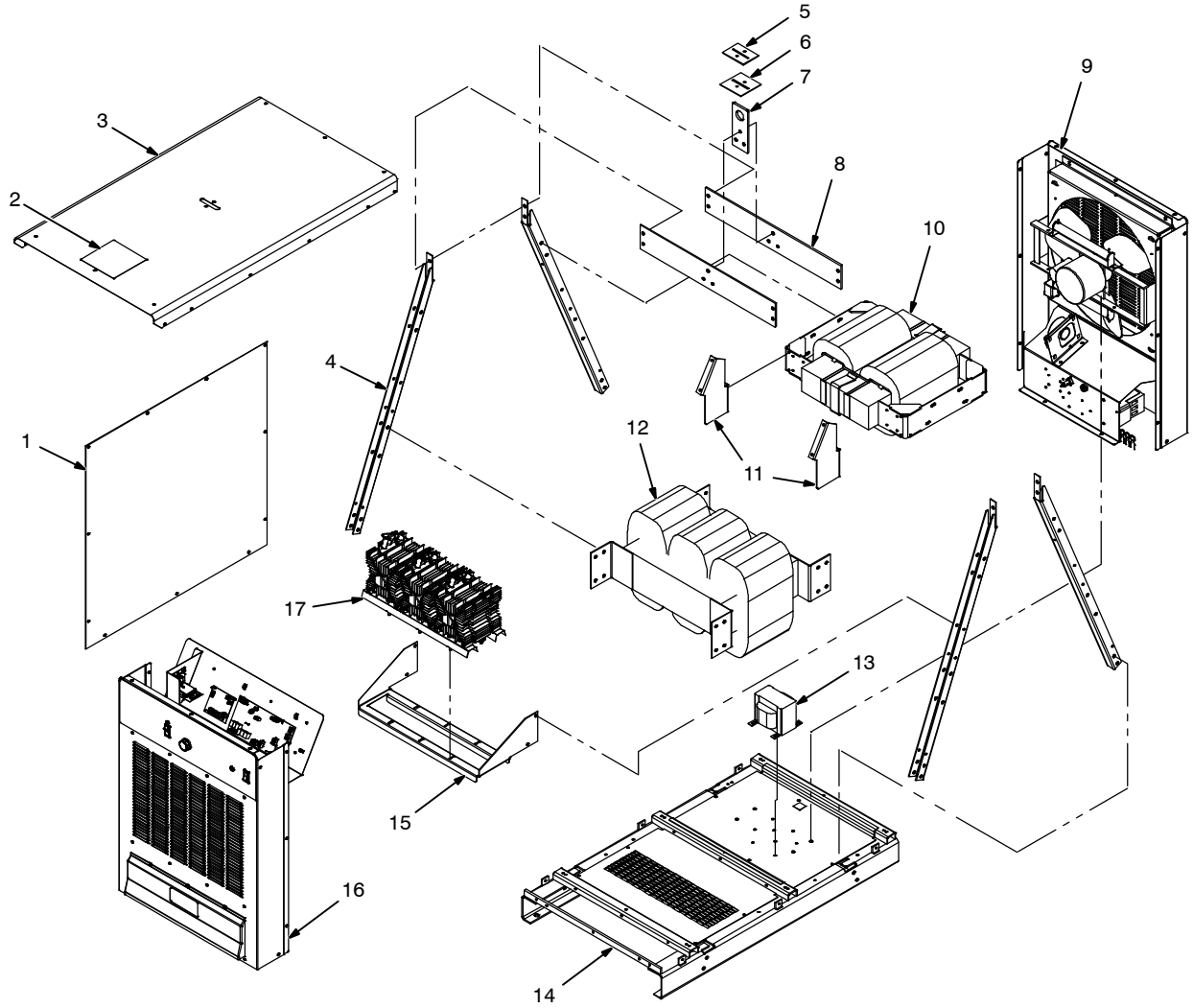
File: Submerged (SAW)




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Owner's Manual translations,
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SECTION 13 – PARTS LIST



Digital Model Illustrated

 Hardware is common and not available unless listed.

266222-D

Figure 13-1. Power Source Main Assembly

Eff w/Serial No. ME170053C And Following

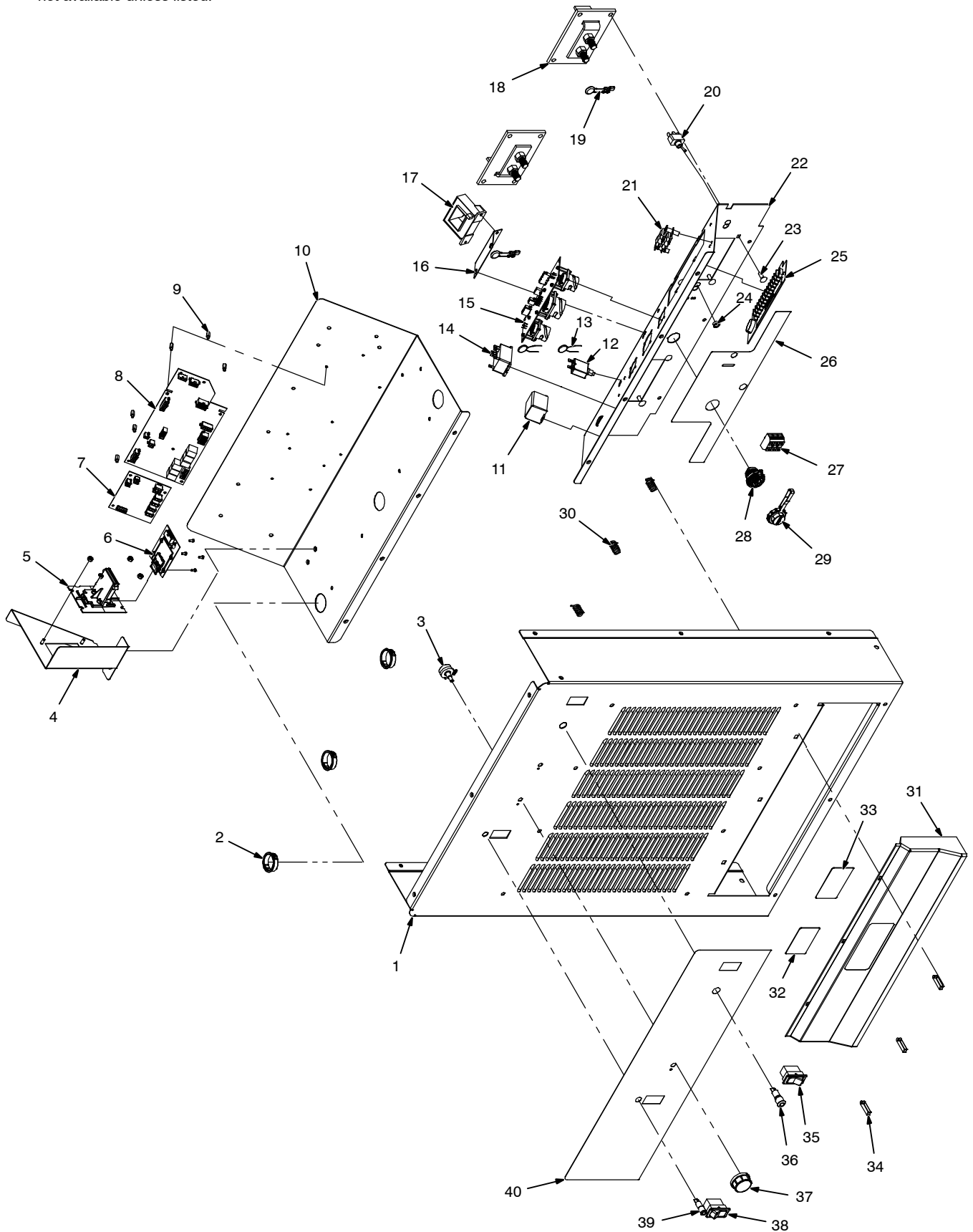
Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 13-1. Power Source Main Assembly				
.. 1		246960	.. Panel, Side	2
.. 2		274964	.. Label, Warning General Precautionary (Eng/Fr/Sp)	1
.. 3		+245938	.. Cover, Top	1
.. 4		184340	.. Channel, Upright	4
.. 5		026627	.. Gasket, Lift Eye	1
.. 6		184344	.. Stop, Cover	1
.. 7		184342	.. Lift Eye	1
.. 8		184341	.. Bar, Cross Lift Eye	2
.. 9		Fig.13-3	.. Panel, Rear	1
.. 10	.. Z1	184350	.. Stabilizer	1
.. 11		184359	.. Bracket, Mtg Terminal Assy	2
.. 12	.. T1	262547	.. XFMR Assy, Power Main 460 V (AC/DC Digital)	1
.. 12	.. T1	262548	.. XFMR Assy, Power Main 400 V (AC/DC 1250 Digital)	1
.. 13	.. T2	260738	.. XFMR, Control 600 VA 400/460 Pri	1
.. 14		246874	.. Base,	1
.. 15		184345	.. Bracket, Rectifier	1
.. 16		Fig. 13-2	.. Panel, Front	1
.. 17	.. SR1	264011	.. Rectifier, SCR Main	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Eff w/Serial No. ME170053C And Following

☞ Hardware is common and not available unless listed.



☞ Digital Model Illustrated

266294-D

Figure 13-2. Front Panel Assembly

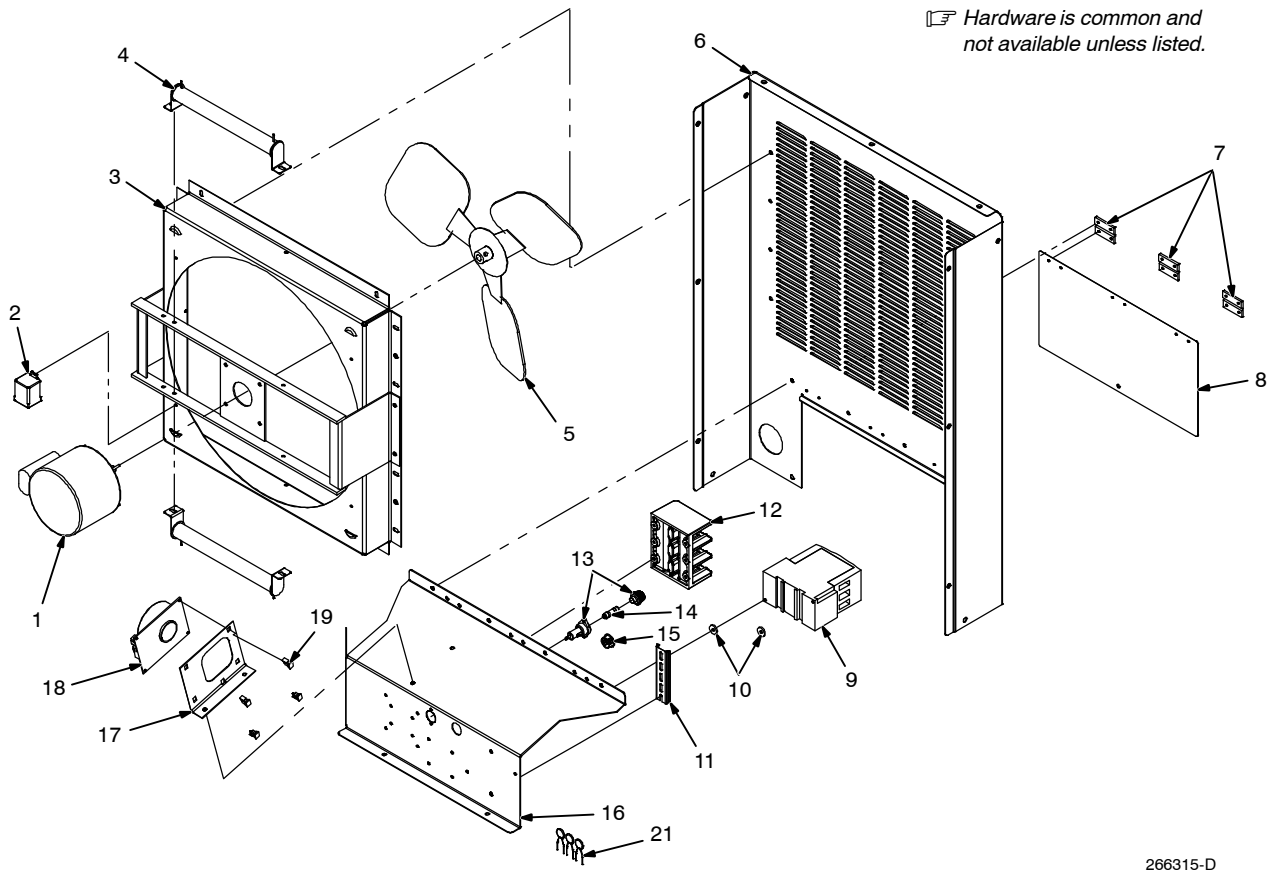
Eff w/Serial No. ME170053C And Following

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
Figure 13-2. Front Panel Assembly (Fig 13-1 Item 16)				
.. 1		264216	.. Panel, Front	1
.. 2		170647	.. Bushing, Snap-In Nyl 1.312 Id x 1.500 Mtg Hole	3
.. 3	R5	030109	.. Pot, Cp Std Slot 1t 2. W 5k Linear	1
.. 4		264302	.. Bracket, Mtg Memory Card Reader w/Pems	1
.. 5		234344	.. Bracket, SD Card Reader	1
.. 6	PC3	244477	.. Circuit Card Assy, SD Card	1
.. 7	PC4	264088	.. Circuit Card Assy, Automation w/Prgm	1
.. 8	PC1	264012	.. Circuit Card Assy, Control w/Prg SubArc Digital	1
	PLG11	163467	.. Housing Plug+Skts, (Service Kit)	1
	PLG12,13,15	152249	.. Housing Plug Pins+Skts, (Service Kit)	3
	PLG14	115094	.. Housing Plug+Skts, (Service Kit)	1
.. 9		098691	.. Stand-off, No 6-32 x .500 Lg .250 Hex Stl M&F	10
.. 10		264217	.. Baffle, Electronics	1
.. 11	CR1	000174	.. Relay, Encl 24VAC 3Pdt 10A/120VAC 11Pin Flange Mtg	1
.. 12	CB1-2	261011	.. Supplementary Pro, Man Reset 1p 25a 250VAC Frict	2
.. 13	C9, 10	246168	.. Capacitor Assy	2
.. 14	CR3	261010	.. Relay, Encl 24VDC Dpst 30A/24VAC 4pin Flange Mtg	1
.. 15	PC2	261384	.. Circuit Card Assy, SubArc AC/DC Digital Filter	1
.. 16		245940	.. Bracket, Mtg LEM	1
.. 17	HD2	244958	.. Transducer, Current 1000A Module Supply V +/- 15V	1
.. 18		263753	.. Terminal Assy, Power Output (Includes)	2
		601840	.. Nut, 500-13 .88hex .32h Brs	4
		191137	.. Bus Bar, Terminal Power Output	1
		191138	.. Terminal Board, Power Output	1
		601839	.. Nut, 500-13 .75Hex .44h Brs	2
		182495	.. Stud, Brs .500-13 x 2.750	2
		602247	.. Washer, Flat .531 Id x 1.062 Od x .095 T Stl Pld ANSI .500	2
		605787	.. Washer, Tooth .512 Id x 0.900 Od x .045 T Stl Pld Int .500 A	2
.. 19	C19, 20	249477	.. Capacitor Assy	2
.. 20	S3	011609	.. Switch, Tgl Spdt 15A 125VAC On-none-on Spd Term Chr	1
.. 21	R3,4	136076	.. Resistor, Ww Fxd 30W 200 Ohm Faston Te	2
.. 22		261712	.. Bracket, Mtg Output Term Assy	1
.. 23		005107	.. Bolt, Crg Stl .250-20 x .750 Gr5 Pld	8
.. 24		010546	.. Bushing, Snap-In Nyl .375 Id x .500 Mtg Hole	2
.. 25		262375	.. Assy,Terminal Block Sub Arc AC/DC Digital (Includes)	1
		162828	.. Panel, Mtg Rcpt/Terminal Strip	1
		159040	.. Block, Term 20 Amp 12 Pole Screw Term	1
		070371	.. Blank, Snap-In Nyl 1.093/1.125 MTG Hole Black	1
.. 26			.. Nameplate, Lower (Order By Model And Serial Number)	1
.. 27	TE2	246951	.. Block, Term 20 Amp 3 Pole Quick Conn 20-12Awg Wire Labeled	1
.. 28		264087	.. Conn, Circ Cpc Ethernet Skt Sealed 49.000 in. Cable	1
.. 29		244237	.. Dust Cap	1
.. 30		161303	.. Spring, Cprsn .600 Od x .072 Wire x 1.500 Pld	3
.. 31		+172587	.. Cover, Output Stud Generic	1
.. 32		217865	.. Label, Warning Electric Shock And Reduced Air (Fr)	1
.. 33		227980	.. Label, Notice Output Terminal Connection	1
.. 34		160935	.. Clip, Spring	3
.. 35	S1	261608	.. Switch, Rocker Spdt 10A 24VDC On-None-On Illum	1
.. 36	PL2	247090	.. LED Assy, Yellow w/Terminals	1
.. 37		171007	.. Knob, Pointer 1.670 Dia x .250 Id w/Set Screwplstc	1
.. 38	S2	248658	.. Switch, Rocker Spst 15/10A 125/250VAC On-None-On Spd Term Blk	1
.. 39	PL3	249340	.. LED Assy, Blue w/Terminals	1
.. 40			.. Nameplate, (Order By Model And Serial Number)	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

Eff w/Serial No. ME170053C And Following



266315-D

Figure 13-3. Rear Panel Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
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Figure 13-3. Rear Panel Assembly (Figure 13-1 Item 9)

.. 1	.. FM	.. 032605	.. Motor, Cap Perm SP 1/4 Hp 230VAC 1625 Rpm	.. 1
.. 2	.. CR2	.. 006393	.. Relay, Encl 24VAC Dpdt 10A/120VAC 8 Pin Flange Mtg	.. 1
.. 3		.. 222352	.. Windtunnel, 20 in.	.. 1
.. 4	.. R1,2	.. 097459	.. Resistor, Ww Fxd 375 W 20 Ohm	.. 2
.. 5		.. 222347	.. Blade, Fan 20.000 3Wg 13Deg .500 Bore Cw Al	.. 1
.. 6		.. +245936	.. Panel, Rear	.. 1
.. 7		.. 218280	.. Hinge, Cont Polyolefin Copolymer 2.000 L w/.125H	.. 3
.. 8		.. 245937	.. Door, Primary Access	.. 1
.. 9	.. W	.. 252348	.. Contactor, Size S3 3P AC 140 Amp 24V 50/60 Hz	.. 1
.. 10		.. 252264	.. Spacer	.. 2
.. 11		.. 252349	.. Rail, Din	.. 1
.. 12		.. 273782	.. Block, Power Splice/Dist 3P 255 Amp 600V AC/DC	.. 1
.. 13		.. 159034	.. Holder, Fuse Mintr 10.3mm x 33.3 To 38.1mm Panel Mt	.. 1
.. 14	.. F1	.. 260395	.. Fuse, Crtg 3 Amp 600V Time Delay	.. 1
.. 15		.. 030170	.. Bushing, Snap-in Nyl .750 Id x 1.000 Mtg Hole	.. 1
.. 16		.. 246208	.. Bracket, Mtg Contactor	.. 1
.. 17		.. 188403	.. Bracket, Mtg LEM	.. 1
.. 18	.. HD1	.. 270551	.. Circuit Card Assy, Current Transducer 1000A Module	.. 1
.. 19		.. 134201	.. Stand-Off Support, PC Card .312/.375 w/Post & Lock .43	.. 4
.. 21		.. 247239	.. Capacitor Assy	.. 3

+When ordering a component originally displaying a precautionary label, the label should also be ordered.
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Notes

DECIMAL EQUIVALENTS

	$\frac{1}{64}$.015625
	$\frac{1}{32}$.03125
	$\frac{3}{64}$.046875
$\frac{1}{16}$	$\frac{5}{64}$.0625
	$\frac{7}{64}$.078125
	$\frac{9}{32}$.09375
$\frac{1}{8}$	$\frac{11}{64}$.109375
	$\frac{13}{64}$.125
	$\frac{15}{32}$.140625
	$\frac{17}{64}$.15625
$\frac{3}{16}$	$\frac{19}{64}$.171875
	$\frac{21}{64}$.1875
	$\frac{23}{32}$.203125
	$\frac{25}{64}$.21875
$\frac{1}{4}$	$\frac{27}{64}$.234375
	$\frac{29}{64}$.25
	$\frac{31}{32}$.265625
	$\frac{33}{64}$.28125
$\frac{5}{16}$	$\frac{35}{64}$.296875
	$\frac{37}{64}$.3125
	$\frac{39}{32}$.328125
	$\frac{41}{64}$.34375
$\frac{3}{8}$	$\frac{43}{64}$.359375
	$\frac{45}{64}$.375
	$\frac{47}{32}$.390625
	$\frac{49}{64}$.40625
$\frac{7}{16}$	$\frac{51}{64}$.421875
	$\frac{53}{64}$.4375
	$\frac{55}{32}$.453125
	$\frac{57}{64}$.46875
$\frac{1}{2}$	$\frac{59}{64}$.484375
	$\frac{61}{64}$.5
	$\frac{63}{32}$.515625
	$\frac{65}{64}$.53125
$\frac{9}{16}$	$\frac{67}{64}$.546875
	$\frac{69}{64}$.5625
	$\frac{71}{32}$.578125
	$\frac{73}{64}$.59375
$\frac{5}{8}$	$\frac{75}{64}$.609375
	$\frac{77}{64}$.625
	$\frac{79}{32}$.640625
	$\frac{81}{64}$.65625
$\frac{11}{16}$	$\frac{83}{64}$.671875
	$\frac{85}{64}$.6875
	$\frac{87}{32}$.703125
	$\frac{89}{64}$.71875
$\frac{3}{4}$	$\frac{91}{64}$.734375
	$\frac{93}{64}$.75
	$\frac{95}{32}$.765625
	$\frac{97}{64}$.78125
$\frac{13}{16}$	$\frac{99}{64}$.796875
	$\frac{101}{64}$.8125
	$\frac{103}{32}$.828125
	$\frac{105}{64}$.84375
$\frac{7}{8}$	$\frac{107}{64}$.859375
	$\frac{109}{64}$.875
	$\frac{111}{32}$.890625
	$\frac{113}{64}$.90625
$\frac{15}{16}$	$\frac{115}{64}$.921875
	$\frac{117}{64}$.9375
	$\frac{119}{32}$.953125
	$\frac{121}{64}$.96875
$\frac{1}{1}$	$\frac{123}{64}$.984375
		1.

Miller Electric Mfg. LLC

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters-USA

USA Phone: 920-735-4505 Auto-Attended
USA & Canada FAX: 920-735-4134
International FAX: 920-735-4125

For International Locations Visit
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