

Idealarc[®] DC-1000

Processes

MIG, Flux-Cored, Submerged Arc,
Gouging

Product Number

K1386-3
K1386-4
K1387-3
K1387-6
K1387-11

See back for complete specs

Input Power (Voltage/Phase/Hertz)

K1386-3: 230/460/3/60
K1386-4: 575/3/60
K1387-3: 220/380/440/3/50/60
K1387-6: 415/3/50/60
K1387-11 380/440/3/50/60

Input Current at Rated Output

220/230V: 193A
380V: 112A
415V: 102A
440/460V: 96.5A

575V: 77.2A

Rated Output

1000A/44V/100%

Output Range

150-1300A, 16-46V

Weight/Dimensions (H x W x D)

821 lbs. (372 kg)
30.7 x 22.25 x 39.0 in.
(781 x 565 x 991 mm)

Industrial DC Multi-Process Welder

The DC-1000 offers 1300 amps of smooth DC output, combining pure welding power with multi-process flexibility for semiautomatic and automatic welding.

FEATURES

- ▶ **500 amp output connections** - provide enhanced arc characteristics for low amperage submerged arc and MIG welding procedures.
- ▶ **Single range control** - for precise output control and easy operation.
- ▶ **Terminal strip and output studs** - for remote connections and cable.
- ▶ **Low profile case** - allows installation under a workbench and for stacking up to 2 machines to conserve floor space.
- ▶ **Removable side panels** - for easy access to internal parts.
- ▶ **Internal components** - including windings, rectifiers and circuit boards, are coated to protect against the effects of moisture and corrosion.
- ▶ **Seven-year warranty** - on power rectifier.

APPLICATIONS

- ▶ Fabrication
- ▶ Heavy Equipment
- ▶ Pressure Vessel
- ▶ Shipbuilding
- ▶ Transportation
- ▶ Construction



WHAT'S INCLUDED

K1386-3 Includes:

- ▶ Analog ammeter and voltmeter.
- ▶ Fuse protected 115V wire feeder auxiliary power.

Recommended Wire Feeders:

- ▶ LT-7
- ▶ NA-3
- ▶ NA-5

INPUT



(1) K1387-3 and K1387-6 only

OUTPUT



Two Year Extended
Warranty Available in
the U.S.A. and Canada.



KEY CONTROLS

1. Ammeter/Voltmeter
2. Weld Terminals On or Remotely Controlled
3. Output Control
4. Welding Mode Switch
5. Local/Remote Switch
6. On/Off Pushbutton
7. Power Source Pilot Light



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Paralleling Kit
Permits paralleling of two power sources.
Order K1897-1



Remote Output Control
For remote output of welding current or voltage. Consists of control box with 25 or 100 ft. (7.6 or 30 m) of four conductor cable and 6 pin MS-type connector. Requires K843 adapter.
Order K857 for 25 ft. (7.6 m)
Order K857-1 for 100 ft. (30 m)



Control Cable Adapter Kit-6 Pin
Adapts 6-pin MS-type plug connection to terminal strip on power source.
Order K843



Control Cable Adapter Kit-14 Pin
Adapts 14-pin MS-type plug connection to terminal strip on power source.
Order K1798



Factory Undercarriage
For moving by hand on smooth surface floors. Heavy-duty, puncture-resistant (inner tube and sealant) tires and front caster. Convenient steering handle.
Order K1770-3 - Flat-Free Tires
Order K1770-2 - Pneumatic Tires



All-Terrain Undercarriage
For moving by hand at construction sites. Maneuvers over obstacles. Heavy-duty puncture-resistant (inner tube and sealant) tires.
Order K1737-3 - Flat-Free Tires
Order K1737-4 - Pneumatic Tires



Weld Fume Control Solutions
Lincoln Electric offers a wide variety of weld fume control solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.
Request Publication MC08-70

WIRE FEEDER OPTIONS



LT-7 Tractors
Self-propelled mechanized wire feeder, designed for the submerged arc process with track system capabilities.
Order K227-1 Standard Model
Order K395-1 Track Model



Flex Feed 74 HT
Four drive-roll, high-torque, industrial semiautomatic wire feeder for general/structural fabrication
See Publication E8.203



Flex Feed 84 Single Bench
Four drive roll feeder with heavy duty wire reel stand for general/structural fabrication
See Publication E8.205



NA-3 and NA-5 Automatic Wire Feeders
These automatic drive heads and controls are designed for hard automation applications with FCAW-S, GMAW or SAW processes.
Request Publication E9.10

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC-1000	K1386-3	230/460/3/60	1000A/44V/100%	193/96.5A	16-46V 150-1300A	30.7 x 22.25 x 39.0 (781 x 565 x 991)	821 (372)
	K1386-4	575/3/60		77.2A			
	K1387-3	220/380/440/3/50/60		193/112/96.5A			
	K1387-6	415/3/50/60		102A			
	K1387-11	380/440/3/50/60		112/96.5A			

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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