

DURAWELD® 350/500

NEW!

DURAWELD® 350/500 is a new and highly reliable CV DC power source provided by Lincoln Electric.

It can be used in various industries. Taking advantage of advanced control technology improves manufacturing process. It not only features superior performance but helps users set welding parameters precisely and weld more conveniently.

DURAWELD® 350/500 is produced strictly in accordance with IEC standard (IEC60974-1). IP23 ensures to be operated in harsh environment such as ship building, heavy steel structure.

DURAWELD® 350/500 is especially designed for GMAW including FCAW. It has excellent CV DC output features when used 100% CO₂ or mixed gas as protective gas.

Adjustable switch is placed on front panel including 2T/4T option, crater voltage and crater current. Independent DIP switch on main PC board can bring advanced feature and special function such as pre flow control, synergic operation control, arc start at low current, generator control, energy saving control, wire feeder option and so on, which improves flexibilities of usage greatly.

DURAWELD® can be matched with LWF®-22, LWF®-24 Plus and LWF®-4GS wire feeders of Lincoln electric.

Process

GMAW, FCAW

Description

Output   Input 

Wire Feeder Options

LWF®-22, LWF®-24 Plus, LWF®-4GS



Lincoln Advantage

- ★ Programmed welding output-the user can adjust welding current and voltage according to their application requirement.
- ★ Digital voltage and current display-easy to read.
- ★ Synergic adjustment of welding parameter – more convenient for welding parameters adjustment.
- ★ Self-adaptive burn back control-burn back mode can be adjusted based on actual welding standard to attain wire clipping function
- ★ Slow wire feeding before arc start-provide more reliable arc start, ensure cleaning and good appearance of weld bead around arc start.
- ★ Preset of crater voltage and current – convenient for burn back setting and easy for operation.
- ★ 2T/4T trigger mode-bring operator advanced welding control and make welding easier and more excellent.
- ★ Coated and sealed PC board-ensure long lifecycle of PC board usage in harsh environment.
- ★ Energy saving control-After activation of this function, DURAWELD® 350/500 can save more energy in idle state.
- ★ IP23-It can ensure the machine of higher reliability in harsh and rugged environment condition.
- ★ High reliability-Hclass design, higher reliability.

Technical Specifications

Product Name	Product Number	Input Power	Rated Output Current/Duty cycle	Input Power at Rated Output [KVA/KW]	Output Range	H*W*D (mm)	Net Weight (KG)
DURAWELD® 350	K60107-1	380V~415V [±10%] 3Ph/50HZ/60HZ	350A@60% 270A@100%	18.1/14.1@60%	50-350A 16.5-31.5V	755 x 500 x 590	116
DURAWELD® 500	K60096-1		500A@60% 390A@100%	30.6/25.3@60%	50-500A 16.5-39V		154

Feature



Front panel

1. ON/OFF Power switch
2. Wire selection
3. Gas selection
4. Voltage meter
5. Synergic state indicator
6. Crater adjustment indicator
7. Amperage meter
8. Crater current potential meter
9. Crater voltage potential meter
10. 2T/4T switch
11. Wire diameter selection
12. Protection door



Rear Panel

1. Input power protective box
2. Input cable holding bracket
3. Grounding cable connection
4. Wire feeder 8 fuse and fuse holder
5. Gas heating 2A fuse and fuse holder
6. Gas heating socket

"DIP"Switch



DURAWELD® machine offers two DIPs [S1 & S2] switch on the PC board, which allows the user to have additional features.

Number	Position	Function
S1		
1	ON	PREFLOW ON/OFF SWITCH
2	ON	SYNERGIC FUCNTION SWITCH
3	ON	Run in speed setting
4	OFF	Reserved
S2		
1	OFF	Generator Mode switch
2	OFF	ENERGY SAVING SWITCH
3	OFF	Wire Feeder Selection
4	OFF	Reserved
5	OFF	Parameter Polling
6	OFF	Parameter Setting
7	OFF	Calibration
8	OFF	

LWF® Wire Feeder

	Order No.	Name	Specification
LWF® Wire Feeder	K60084-2	LWF®-22	Two feed rolls, insulated hub, Asia gun connector
	K60086-2	LWF®-24 Plus	Four feed rolls, insulated hub, with carrying handle, rear wheels, skid shoes & gun holder, Asia gun connector
	K60120-1	LWF®-4GS	Four feed rolls, enclosed design, with wire cover, Euro gun connector
Euro gun adaptor	KP61108-2		Connection with Euro plug and Asia feeder



LWF®- 22



LWF®- 24 plus



Euro gun adaptor



LWF®- 4GS

Please refer to the LWF® wire feeder literature for the detail interconnection cable information

Recommended Options



Work cable with Clamp

Work cable with Clamp
Used to connect work piece
Order No.:
K60027-50-4M
Work cable with clamp, 50mm², 4M
K60027-70-4M
Work cable with clamp, 70mm², 4M



CO₂ Gas Regulator / Flow Meter

CO₂ Gas Regulator/Flow Meter [Inlet G5/8"-14, Outlet M16X1.5/Ø8]
Includes CO₂ flow meter and CO₂ heater
Order No.: K60012-4-220

RECOMMENDED OPTIONS

Product Name	Specification [Rated Current@Duty cycle]
LG351C Guns	350A@60% CO ₂ , 300A@60% Ar+CO ₂
LG501C Guns	500A@60% CO ₂ , 420A@60% Ar+CO ₂

Product Description	Order Number
LG 351, 350A MIG Gun 3M, Asia Adaptor	K60111-3
LG 351, 350A MIG Gun 4M, Asia Adaptor	K60111-4
LG 351, 350A MIG Gun 5M, Asia Adaptor	K60111-5
LG 501, 500A MIG Gun 3M, Asia Adaptor	K60110-3
LG 501, 500A MIG Gun 4M, Asia Adaptor	K60110-4
LG 501, 500A MIG Gun 5M, Asia Adaptor	K60110-5
LG 351, 350A MIG Gun 3M, Euro Adaptor	K60111-3E
LG 351, 350A MIG Gun 4M, Euro Adaptor	K60111-4E
LG 351, 350A MIG Gun 5M, Euro Adaptor	K60111-5E
LG 501, 500A MIG Gun 3M, Euro Adaptor	K60110-3E
LG 501, 500A MIG Gun 4M, Euro Adaptor	K60110-4E
LG 501, 500A MIG Gun 5M, Euro Adaptor	K60110-5E

Product Name	Specification [Rated Current@Duty cycle]
TBI511 Guns	Water cooled, 500A@60% CO ₂ , 450A@60% Ar+CO ₂

Product Description	Order Number
TBI 511 500A MIG Gun 3M, Euro Adaptor[Al]	K60124-3



LG351/501 Guns



TBI 511 Guns (Water cooled,)

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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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