



SWSI

Southern Welding Systems International LLC

Welding | Industrial | Safety

International Wholesale Distribution

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SUB ARC



Miller offers an array of versatile Sub Arc components, including controllers, wire feed systems, tractors, torches and power sources. Our DC and new AC/DC systems optimized for Submerged Arc welding (SAW) can also be used for Air Carbon Arc cutting and gouging with 1/2-inch carbons. To learn more, visit MillerWelds.com/SubArc



MillerWelds.com/SubArc

Subarc Series



Subarc DC 650 and
NEW! Subarc AC/DC 1000 shown.



DC Series — See Literature No. DC/19.8
AC/DC Series — See Literature No. AD/7.2

Subarc DC Series power sources are known for stable, consistent arc output with a variety of electrode sizes, electrode types, and fluxes in single-arc system configurations.

NEW! Subarc AC/DC 1000 power sources work in single-arc or multi-arc configurations: AC + DC or AC + AC combined welding output. They feature:

- **Practical, easy-to-use operator interface** allows polarity/balance to be set at the front control panel.
- **Enhanced arc stability** from built-in digital arc control increases throughput.
- **More precise parallel operation** for multi-arc configurations with optional Parallel Control (#194 711).
- **Interchangeable accessories** (HDC controls, RAD wire drives, tractors, etc.) are fully compatible with DC or AC/DC systems.

Heavy Industrial  Subarc DC Series is DC only.

Processes

- Submerged Arc (SAW)
 - Air Carbon Arc Cutting and Gouging (CAC-A) (1/2-in. carbons)
 - Flux-Cored (FCAW)*
 - Stick (SMAW)*
- *Subarc DC Series only.

Most Popular Accessories

- Flux Hopper with Valve #194 775 (pg 86)
- Self-Propelled Tractor Pkgs (pg 87)
MT 1500 DX (Digital) #951 060
MT 1500 A (Analog) #951 061
- See additional Sub Arc Accessories on pages 86 and 87

Visit MillerWelds.com or your distributor for other Miller® options and accessories.

Model	Stock Number	Amperage Range	Voltage Range	Rated Output	Amps Input at Rated Output, 60 Hz					Max. Open-Circuit Voltage	Dimensions (Includes lift eye and strain relief.)	Net Weight
					230 V	460 V	575 V	KVA	KW			
Subarc DC 650	(#907 338) 230/460/575 V	50–815 A in CC Mode	10–65 V in CV Mode	650 A at 44 VDC, 100% Duty Cycle	126	63	50.4	50	34.8	72 VDC	H: 27.25 in. (692 mm) W: 22.25 in. (565 mm) D: 36 in. (914 mm)	545 lb. (247 kg)
Subarc DC 1000	(#907 342) 230/460/575 V	100–1250 A in CC Mode	10–60 V in CV Mode	1000 A at 44 VDC, 100% Duty Cycle	180	90	72	73	53	66 VDC in CC Mode, 38 VDC in CV Mode	H: 44 in. (1118 mm) W: 27.25 in. (692 mm) D: 46 in. (1168 mm)	644 lb. (292 kg)
Subarc AC/DC 1000	(#907 454) 460 V	350–1250 A in CC Mode	25–44 V in CV Mode	1000 A at 44 VDC, 100% Duty Cycle	—	122	—	98	53	71 VDC		1225 lb. (540 kg)

Automatic Weld Control



HDC 1500 DX



HDC 1500 A

HDC 1500 DX #300 438 With Digital Meters
HDC 1500 A #300 439 With Analog Meters

Reliable and flexible Miller weld controls work with AC or DC CC/CV power sources that have remote contactor and output control capabilities. Internal power strips allow interfacing with non-Miller power supplies. Run-in control ensures smoother arc starting and bumback control helps prevent wire sticking on weld termination. Crater time, speed, and output rates can also be controlled with HDCs. See Literature No. DC/19.8 or AD/7.2 for more details.

Wire Drive Assemblies



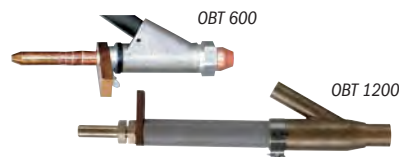
RAD wire drive assemblies include an adapter plate for mounting to 2.5-inch, 4.25-inch, and 4.625-inch bolt-hole patterns.

RAD-400 shown.

RAD-400 #195 265 Standard-speed, 20–400 IPM (0.5–10 MPM), for 1/8-inch or larger wire
RAD-780 #195 266 High-speed, 20–780 IPM (0.5–19.8 MPM), for 1/8-inch or larger wire
SAW4 #300 481 Standard-speed, 20–400 IPM (0.5–10 MPM), for smaller than 1/8-inch wire

Miller wire drive assemblies operate using 115-volt power and are available for a wide range of wire diameters. Right angle wire drives (RAD) are designed for larger diameter wires while the SAW4 is optimized for smaller diameters. Recommended drive rolls can be found on page 86.

Sub Arc Torches



OBT 600

OBT 1200

OBT 600 #043 923 600-amp, 100% duty cycle torch, for 1/16–7/32-inch (1.6–5.6 mm) wire
OBT 1200 #043 900 1200-amp, 100% duty cycle torch, for 1/16–7/32-inch (1.6–5.6 mm) wire

Miller offers a choice of torches for Submerged Arc welding: OBT 600 (600 amp maximum output) and OBT 1200 (1200 amp maximum output). Both feature a concentric flux flow nozzle and have optional body extensions available. OBT 1200 also has a replaceable breakaway adapter end to prevent costly damage should the torch run into an obstruction. Torch body extensions and contact tips can be found on page 87.