

## Submerged Arc System



### Sub Arc AC/DC 1250 Submerged Arc Welding Power Source

#### Technology Increases SAW Deposition Rates

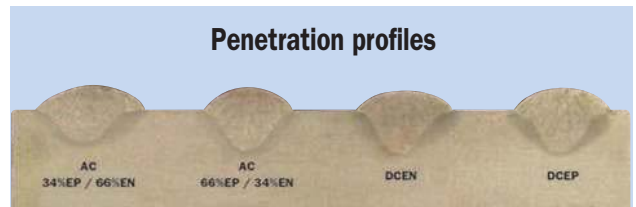
Variable balance AC squarewave Submerged Arc Welding (SAW) technology from Miller overcomes the traditional problems or limitations of SAW with all other processes including DC electrode positive(DCEP), DC electrode negative (DCEN) and traditional AC.

The new SUB ARC AC/DC 1250, that replaces the Summarc series, gives full control of the wave shape in frequency balance, and off-set:



- Increase deposition rate up to 59 % using the same welding parameters
- Smaller joint angles and lower filler metal volume
- Reduce heat input, minimize distortion and improve the mechanical properties
- Penetration control to minimize the risk of lack of fusion
- Minimize the magnetic arc blow
- Reduce arc interactions in multi-wire process
- Control of bead shape
- Excellent arc start
- Improved arc stability compared to traditional AC
- Substantially lower power consumption

The new SUB ARC AC/DC 1250 has a 12 balance and frequency use friendly set up for the most common applications. A total of 81 balance ratios gives excellent performance in all application segments.



Ø 4.0mm (0.156") Deposition rate

