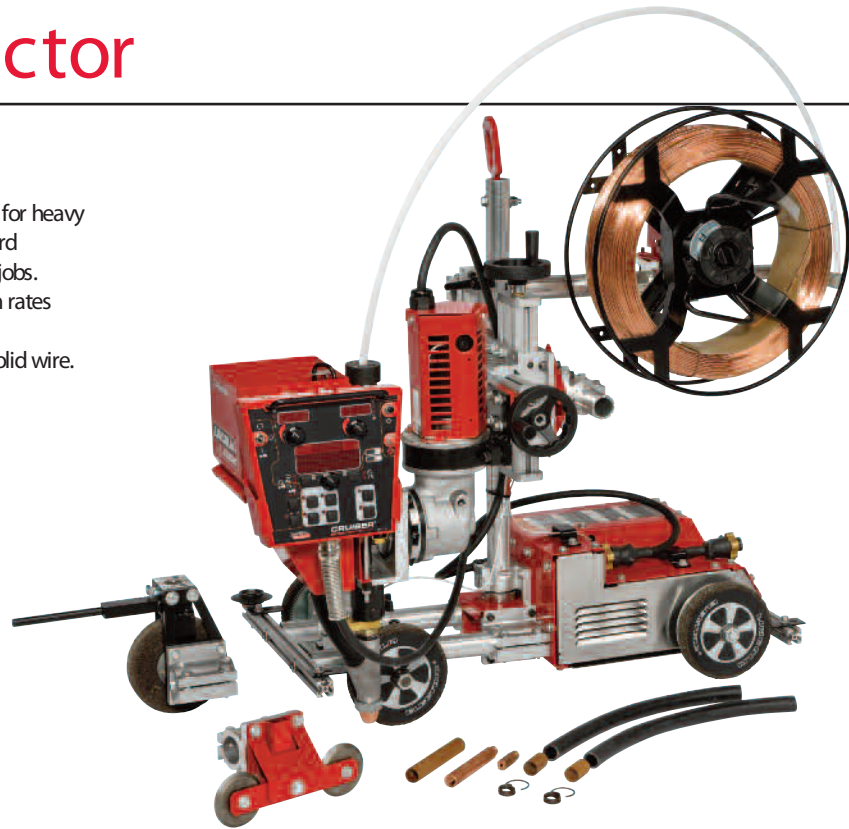


# Cruiser™ Tractor

## For The Long Haul

The Cruiser is a flexible wire feeding tractor for heavy plate submerged arc welding in field and yard applications. Designed for big joints on big jobs. Weld butt joints and fillet joints at deposition rates up to 30 lbs./hr. Comes ready to weld with joint tracking kits and drive rolls for 5/32" solid wire.

Processes  
Submerged Arc



Output



Input



### Key Features

- Designed for Welding Big Joints on Big Jobs – Ideal for welding heavy plate on barges, ships, large tanks, bridges, and offshore platforms.
- High Deposition rates up to 30 lbs./hr. – Rated output of 1000 amps at 100% duty cycle.
- Versatile Travel Capabilities – 3 or 4 wheel configuration for use with or without track.
- Lightweight Pendant Control with Digital Meters – Save procedures, apply procedure limits, and lockout any or all controls.
- Rugged Mast and Arm – Keeps the wire drive in a steady position and allows flexible adjustment.
- Proven Industrial Power Feed™ 10S Wire Drive Design – Rotates on two axis and is attached to heavy duty cross slides for any torch angle and feeds up to 7/32" diameter wire.

### K2607-1 Includes

- Pendant Control
- Butt, Fillet and Lap Joint Tracker
- 50-60 Lb. Coil Adapter
- Wire Straightener
- Drive Roll/Guide Tube Kit for 5/32 solid wire
- Contact Nozzle Assembly
- Nozzle Extension
- Contact Tip for 5/32 solid wire

### Technical Specifications

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Travel Speed in/min (m/min)	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm) Solid	Dimensions H x W x D in. (mm)	Net Weight lbs. (kg)
Cruiser™	K2607-1	40 VDC	1000A / 100%	10 - 100 (0.25 - 2.5)	142:1	15 - 200 (0.4 - 5.0)	1/16 - 7/32 (1.6 - 5.6)	29 x 23 x 36 (737 x 584 x 914)	140 (63.5)

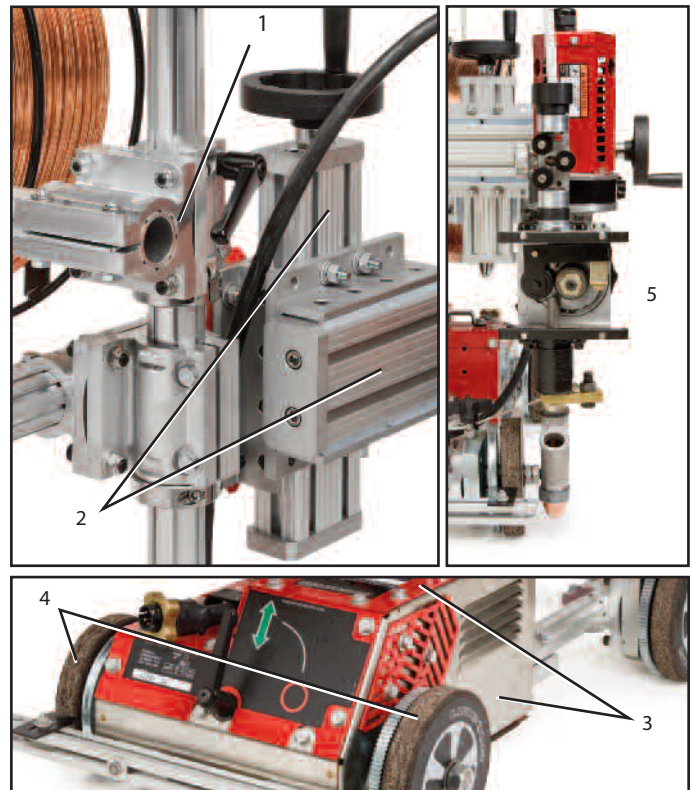
## KEY CONTROLS



- |  |  |  |   |
|--|--|--|---|
| <p>1. Digital Meters</p> <p>2. 3 Position Travel Toggle Switch</p> <ul style="list-style-type: none"> <li>• Auto</li> <li>• Off</li> <li>• Manual</li> </ul> | <p>3. Pushbutton Menu Options</p> <ul style="list-style-type: none"> <li>• Weld Mode Select</li> <li>• Frequency and Balance</li> <li>• Travel Options</li> </ul> <p>4. Travel Direction:</p> <ul style="list-style-type: none"> <li>• Forward</li> <li>• Reverse</li> </ul> | <p>5. Jog</p> <p>6. Start and Stop Pushbutton</p> <p>7. Arc Start and End Set-Up Options</p> <p>8. Inch/Inch Down Pushbuttons</p> <ul style="list-style-type: none"> <li>• Feed up and down</li> </ul> | <p>9. 4 Memory Buttons:</p> <ul style="list-style-type: none"> <li>• Save common procedures. (including travel)</li> <li>• Apply operator range or limits</li> <li>• Lockout changes for procedure control</li> </ul> |
|--|--|--|---|

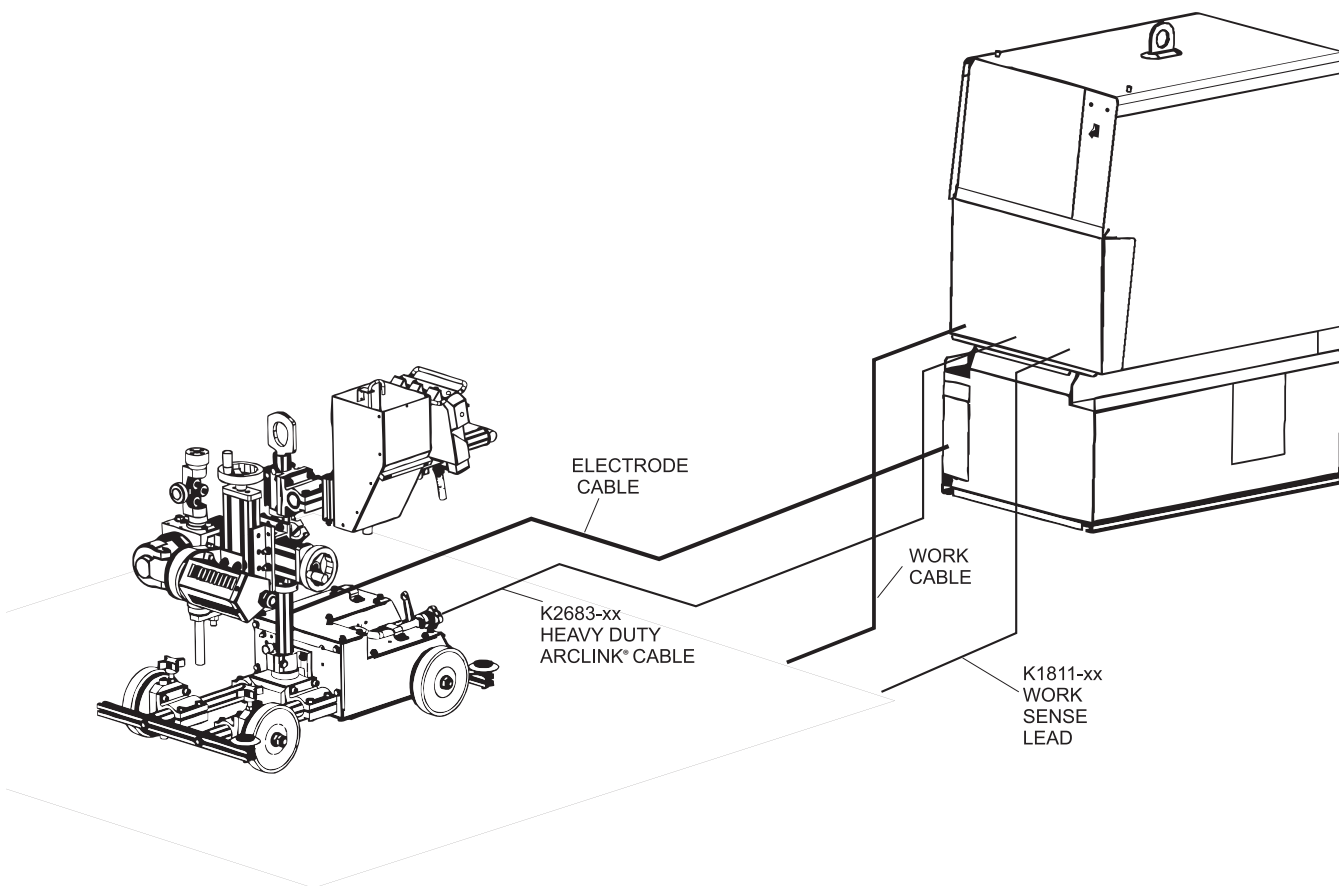
## RUGGED DESIGN & FLEXIBLE ADJUSTMENT FOR ANY CONFIGURATION

1. Mast and Frame
  - Heat treated aluminum alloy tubing
  - Creates a rigid frame for steady position
  - Mast and boom completely separates from the base for mobility
2. Heavy Duty Cross Slides
  - Easy adjustment of electrode stick-out and position
  - Accurate positioning of the electrode in joint
  - Easy adjustment and changes make the design efficient to use
3. Hardened Base Construction
  - Stainless steel to reduce corrosion
  - Heat shield to withstand preheated plate
  - Environmentally hardened (IP23 Rated)
4. Stable Travel and Tracking
  - 3 or 4 wheel configuration on same model
  - Easy to use clutch
  - Factory ready for use with or without track
  - Patent Pending wheel design that endures impacts, is high temperature resistant and excellent traction
5. Proven Industrial Wire Drive
  - Feeds wire up to 7/32" diameter
  - Changeable gears for a wide range of wire feed speed range
  - Rotation in two directions for any torch angle
  - 1000A, 100% Duty Cycle



RECOMMENDED EQUIPMENT

System Identifier	Product Number	Product Description	Qty. Required
Power Source	K2344-2	Power Wave <sup>®</sup> AC/DC 1000 <sup>®</sup>	1
Tractor	K2607-1	Cruiser <sup>™</sup>	1
Track	K396	Track Section	Optional
Nozzle	K231-xx	Submerged Arc Contact Nozzle Assembly	Included
Nozzle	K148A, K148B	Positive Contact Nozzle Assembly	Optional
Flux Cone	K285	Concentric Flux Cone Assemble	Optional
ArcLink <sup>®</sup> Digital Communication Cable	K2683-xx	Heavy Duty ArcLink <sup>®</sup> Cable	1
Sense Leads	K1811-xx	Work Sense Lead	1



RECOMMENDED ACCESSORIES AND OPTIONS

DRIVE ROLL KIT INFORMATION						
KP1899 Drive Roll Kit			Included with Kit			
Drive Roll Kit Number	Wire Sizes and Types		Drive Roll		Incoming Guide	Outgoing Guide
			Part Number	No. Required		
KP1899-1	3/32" - 7/32"	Wires	KP1885-1	2	KP2116-2	KP1963-1
KP1899-2	1/16" - 3/32"	Wires	KP1886-1	2	KP2116-1	KP2097-2
KP1899-3	.035" - .052"	Solid Wire	KP1887-1	1	KP1967-1	KP2097-1
KP1899-4	.045" - .052"	Cored Wire	KP1892-1	2	KP1967-1	KP2097-1



ArcLink®/LincNet® Cable (5-pin) Connects Power Feed™ to Power Wave®. Can be extended. Order K 1543-XX



System Interface External controller required for multi-arc applications provides arc-to-arc phase relationship.



Sense Lead Kit Required to accurately monitor voltage at the arc for heavy duty applications. Order K 1811-50 for 50 ft. (15.2 m) Order K 1811-75 for 75 ft. (23 m) Order K 1811-100 for 100 ft. (30 m)



Heavy-Duty ArcLink® Cable (5-pin) Connects Power Feed™ to Power Wave®. Can be extended. Order K 2683-xx



Order K 2282-1 CE Filter The K2444-2 Power Wave® AC/DC 1000® CE Module is a high power filter that enables the K2344-2 Power Wave® AC/DC 1000® CE "ready" machine to conform to the EMC standards of Europe and Australia. Electrically, the module is connected between the power line and the input of the K2344-2 machine. The filter provides high differential and common mode attenuation to reduce conducted emissions on the power line. Note: K2344-1 cannot be used with K2444-1 for CE conformance. Order K 2444-2

**POWER FEED® 10S HEADS**



TC-3 Self-Propelled Travel Carriage TC-3 high capacity travel carriage, multiple heads & controls, 5-75 ipm. Order K 325 HCS TC-3 high capacity travel carriage, multiple heads & controls, 15-270 ipm. Order K 325 HCF (made to order)



Feeder Control Cable (14-pin) Connects Power Wave® power source to wire feeder. Cannot be extended. Order K 1785-XX

**POWER WAVE® AC/DC 1000®**

Remote Wire Drive Module Designed for the Power Wave® AC/DC 1000® system, the Remote Wire Drive module enables you to remove and remotely locate your Wire Drive Module outside of the power source to support extended ArcLink® cable lengths. Recommended for applications where the Power Feed™ Head is installed at more than 25 ft (7.6 m) away from the power source. Order K 2626-1



Interface Control Cable (22-pin) Required to parallel multiple Power Wave® power sources — one per machine required. Can be extended. Order K 1795-XX

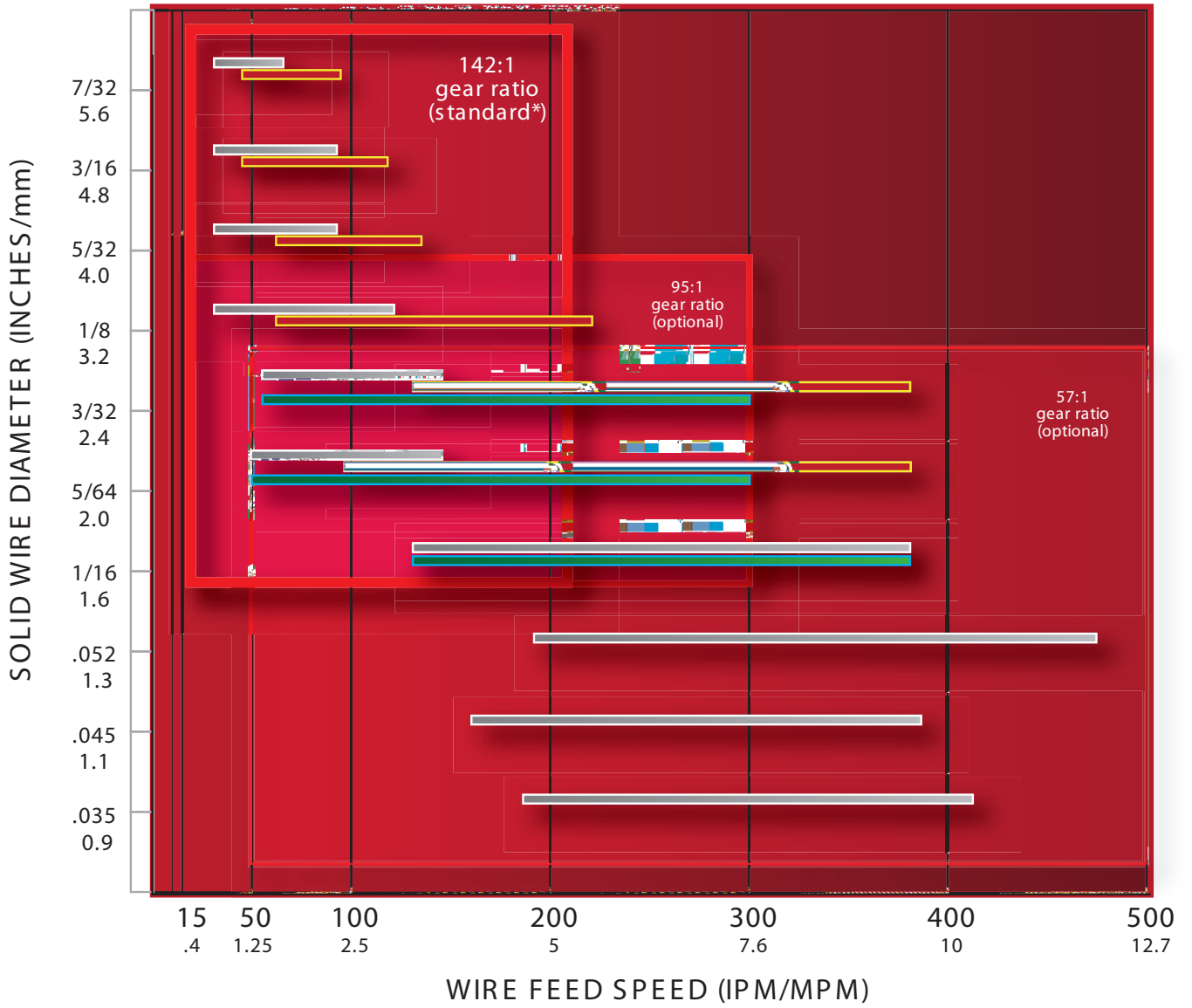


Large Wire Twinarc® Contact Assemblies Feeds two 5/64" (2.0 mm), 3/32" (2.4 mm) or 1/8" (3.2 mm) wires for submerged arc welding on "Fast-Fill" joints or hardfacing beads. Order K 225



Tiny Twinarc® Contact Assemblies Feeds two electrodes for high speed submerged arc welds. Includes contact nozzle, wire guides, drive rolls and guides, and a second wire reel and mounting bracket. Order K 129-xx

# Mild Steel SAW Wire Feeding Capability



\*On Power Feed™ 10A

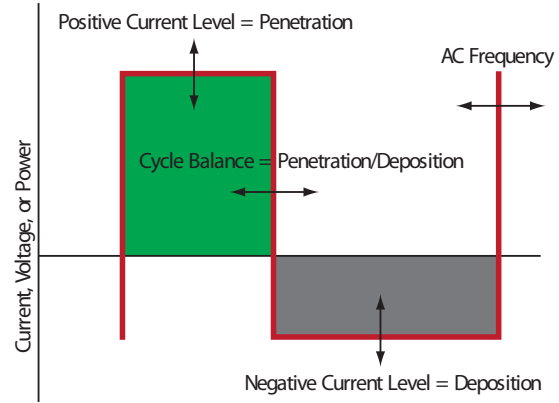
# Waveform Control Technology\*

The waveform may be varied to:

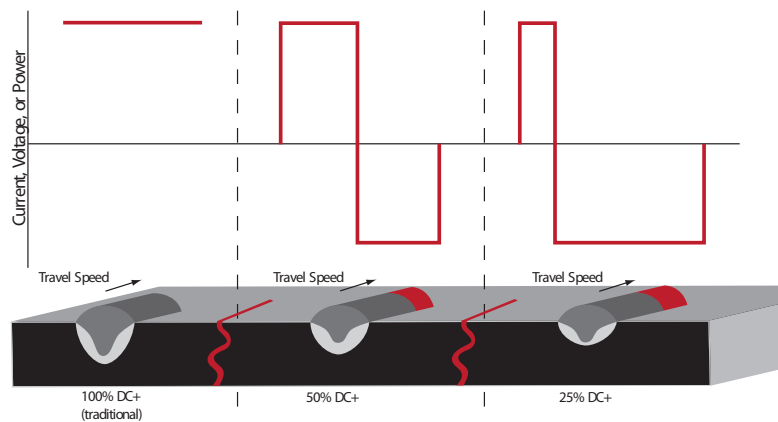
- Control Penetration
- Control Bead Shape
- Minimize arc interactions which can cause arc blow

Waveform Control Technology\* capability provides precise control over:

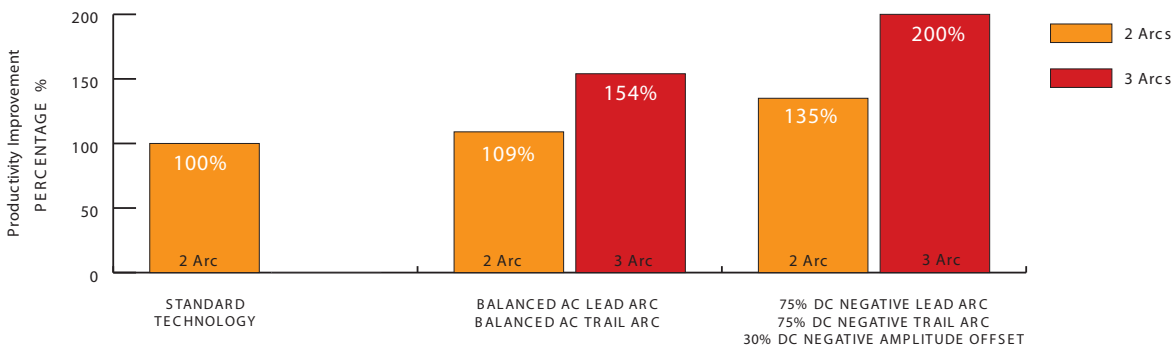
- AC Frequency
- Balance (Percentage of time in the positive polarity portion of one Cycle)
- Offset (Negative Amplitude)



## Effect on Penetration, Deposition Rate, and Travel Speed from Balance



## Multi-Arc Submerged Arc Welding Power Wave® AC/DC 1000®



### 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.

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.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.

**STARTUP** Máquinas e Equipamentos para Soldagem Ltda.  
 Rua dos Aliados, 11 Planalto Bela Vista - Ribeirão Pires - SP.  
 Tel/Fax: (11) 4823-7191 e-mail:contato@startupsoldas.com.br

