

J. IRIZAR & COMPANY LTD

HEADQUARTERS:

3123 – 43 Ave, Edmonton
Alberta T6T 1C7 Canada
Phone & Fax : 1 780 450 6695
E mail: jirizar@jirizar.com
Website: www.jirizar.com

WAREHOUSE:

5720 – 48 Ave, Wetaskiwin Alberta Canada

MANUFACTURING PLANT

PROUDLY CANADIAN OWNED:
People's Republic of China

IRIZAR[®]

Design and Quality
IRIZAR of Canada

IRIZAR Magnetic Device for Lincoln Tractor LT7 Model MD-LT7

IRIZAR Magnetic Device Model MD- LT7 supports Lincoln Tractor LT-7 when it is welding the tank base while a tractor wheel is air-floating.

The magnetic guide allows the Lincoln Tractor LT7 to weld:

- a) On minimum 90 mm tank base plate flanges
- b) On minimum 4.80 meter tank outside diameter.

The magnetic guide allows the Lincoln Tractor LT7 to extend external angle welding by add in magnetism wheel device. It is mainly used in manufacturing and fitting of large tanks, vessels, blast furnace and shipbuilding.



The magnetic guide kit can roll over the top of vertical seam with crown 3 mm or less above the plate surface. A code quality weld should have the crown 2mm or less above the plate surface.

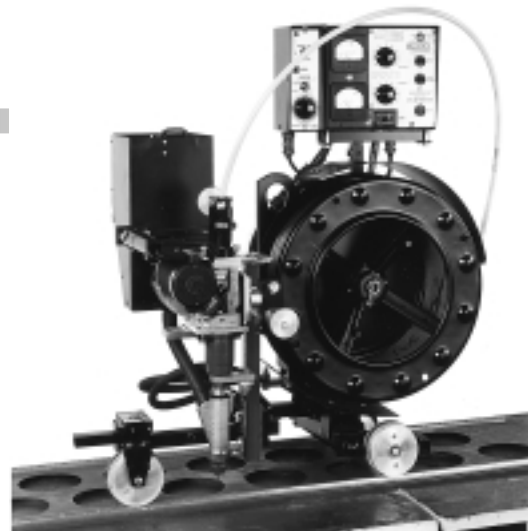
Magnetic Device Dimensions and Weight: 450 x 350 x 250mm, ~ 20kg per set.



LT-7 Tractor

Submerged Arc DC Wire Feeder

The LT-7 Tractor is a self-propelled mechanized wire feeder, designed for the submerged arc process with track system capabilities. It is self-guiding and easy to operate – only one operator is usually required. It is designed to be used with a variety of Lincoln DC constant voltage and constant current power sources. The rugged, lightweight unit permits quick movement to the next joint. Its compact size fits through small openings and confined spaces. Butt and fillet welds can be made on heavy plate or steel as light as 12 gauge (2.5mm). The LT-7 Tractor is ideal for the following applications: ship and barge building, storage tank erection, bridge deck installation, beam, girder or column fabrication, and long seams on heavy weldments.



Track Model Shown

Processes

Submerged Arc

Advantage Lincoln

- LT-7 Tractor feeds 3/32 to 3/16" (2.4 to 4.8 mm) solid wires, from 100 - 400 inches per minute (2.5 - 10.2 m/min) wire feed speed.
- Calibrated tractor drive adjusts travel speeds from 6 to 70 inches per minute (0.12 to 1.8 m/min).
- Vertical head lift adjuster for adjusting electrical stickout from 1/2 in. to 5 in. (12.7 to 127.0 mm).
- Weld angle is up to 50° from vertical on either side; drag angle is up to 30° from vertical.
- Control box is conveniently located on the tractor (can be mounted either left or right), eliminating the need to return to the power source for routine procedure changes.
- Exceptional tracking control and self-steering in most applications leave the operator free for quality control, joint cleaning and flux handling.
- Welds butts, horizontal fillet and lap joints to the left or right side of the tractor frame for convenience.
- Close mechanical alignment between wire and joint maximizes weld quality with no fixturing costs.
- Three-year warranty on parts and labor.

Description

Output  Input 

Required Options

Control Cable, Weld Power Cable, Contact Nozzle Assembly

Recommended General Options

Wire Feeder Control Cable Extensions, Adapter Cable, Linc-Fill™ Attachments, Horizontal Fillet and Lap Adapter Kit, Flat Fillet Adapter Kit, Butt Seam Guide Kit, Track Conversion Kit, Tiny Twinarc® Adapter Kit, Track Section, Flux Screen, Magnetic Flux Screen Separator, Concentric Flux Cone Assembly

Recommended Power Sources

CV-655, DC-600, DC-655, DC-1000, DC-1500

Order

K227-1 LT-7 Standard Model
K395-1 LT-7 Track Model

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range Solid in. (mm)	Dimensions H x W x D in. (mm)	Net Weight lbs. (kg)
LT-7 Standard	K227-1	115 VAC 50/60 Hz	600A/100% 1100A/100% (with water cooling)	100 - 400 (2.5 - 10.2)	3/32 - 3/16" (2.4 - 4.8)	27.5 x 33 x 14 (698 x 838 x 356)	120 (54)
LT-7 Track	K395-1						130 (59)

A CLOSER LOOK

PERFORMANCE

- Solid-state control system precisely regulates procedures for reliable starting and economical welding.
- Automatic compensation for input voltage and tractor loading variations.
- Function lights built into the solid-state printed circuit boards aid troubleshooting to minimize down time.

- Cross seam adjuster speeds setup and lets operator track irregular joints while welding. Adjustment range is 3-1/8 in. (79 mm) with clamp and 2-1/2 in. (63 mm) with handwheel.
- To perform a curved weld, the minimum diameter can be as small as 10 ft. (3.0m) for an inside weld and 13 ft. (3.9m) for an outside weld.
- To perform an inside circumferential weld, the minimum inside diameter that can be welded is approximately 5 ft. (1.5m).

FEATURES

- Quick, easy installation of optional guides for different joints.
- Reel holds 60 lb. (27.2 kg) solid wire coils.
- Flux hopper capacity of 15 lbs. (6.8 kg). Includes a manual flux flow rate control valve and can be mounted at four locations to the left or right.

- Continuous Vertical Adjustment: 1-1/2" (38 mm) handwheel variation for ESO (electrical stickout).
- Travel clutch operates from either side of the tractor.

QUALITY AND RELIABILITY

- Three-year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9001 requirements.

- Rugged and durable design recognized throughout the industry for its long life and years of trouble-free wire feeding.

REQUIRED OPTIONS

CONTROL CABLES

Description	Order No.
Wire Feeder Control Cable	K1822-25 - 25 ft. (7.6m)
Wire Feeder Control Cable Extensions	K1797-25 - 25 ft. (7.6m) K1797-50 - 50 ft. (15.2m)
Adapter Cable for Control Cable to Terminal Strip Power Sources	K1798

WELD POWER CABLES

Order No.	Description
K1842-10	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0m)
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6m)
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2m)
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5m)

CONTACT NOZZLE ASSEMBLIES

Description/Diameter Wire	Order No.
Submerged Arc: 3/32" (2.4 mm) 1/8" (3.2 mm) 5/32" (4.0 mm) 3/16" (4.8 mm)	K231-3/32 K231-1/8 K231-5/32 K231-3/16
Positive: 3/32 - 1/8" (2.4 - 3.2 mm) 3/32 - 3/16" (2.4 - 4.8 mm)	K148A K148B
Linc-Fill™ Attachments for Positive Contact Nozzle Assembly Extension for K148 3/32" (2.4 mm) 1/8" (3.2 mm) 5/32" (4.0 mm)	K149-3/32 K149-1/8 K149-5/32

GENERAL OPTIONS

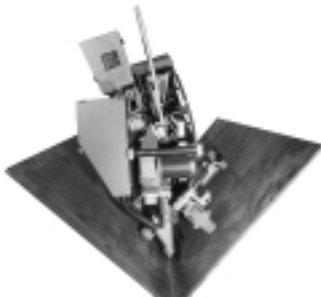
Horizontal Fillet and Lap Adapter Kit

Includes a rear guide wheel, head tension spring and front guide wheel assembly on an adjustable arm which rides in the joint to maintain alignment and electrode angle. Kit includes separate front guide wheel assemblies for fillet and lap joints. Welds to the left or right of the tractor's center line.
Order K232



Flat Fillet Adapter Kit

Includes front and rear guide wheels for operating the tractor in 30° or 45° flat fillet joints.
Order K229



Butt Seam Guide Kit

Mount in place of the standard front wheel to ride in a V-groove or open 1/8 - 3/8" (3.2 - 9.5 mm) butt joint, keeping the wire in required alignment.
Order K230



Track Conversion Kit

Converts the LT-7 standard model for track guidance. Shown with K396 track section.
Order K400



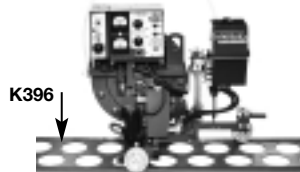
GENERAL OPTIONS

Tiny Twinarc Adapter Kit

Converts the LT-7 standard model to Tiny Twinarc using 5/64" (2.0 mm) electrode. These kits may also be used for horizontal fillets with the addition of the K232 Adapter Kit.
Order K277-1 for Butt Seams
Order K277-2 for Flat Fillets

Track Section

Each provides 70 in. (1.8m) of travel. To be used with the K395-1, LT-7 Track Model.
Order K396



Flux Screen

For submerged arc welding. Removes large particles from reused flux. Includes air-driven vibrator.
Order K310



Magnetic Flux Screen Separator

For submerged arc welding. Removes foreign magnetic particles from reused flux.
Order K58



Concentric Flux Cone Assembly

For use with the K148B, Positive Contact Nozzle Assembly. Gives concentric flux coverage around the electrode.
Order K285



LT-7 TRACTOR ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
LT-7 STANDARD MODEL	K227-1		
LT-7 TRACK MODEL	K395-1		
REQUIRED OPTIONS			
Control Cable	See Page 2		
Weld Power Cable	See Page 2		
Contact Nozzle Assembly	See Page 2		
RECOMMENDED GENERAL OPTIONS			
Wire Feeder Control Cable Extensions	See Page 2		
Adapter Cable	See Page 2		
Linc-Fill™ Attachments	See Page 2		
Horizontal Fillet and Lap Adapter Kit	K232		
Flat Fillet Adapter Kit	K229		
Butt Seam Guide Kit	K230		
Track Conversion Kit	K400		
Tiny Twinarc Adapter Kit, for Butt Seams	K277-1		
Tiny Twinarc Adapter Kit, for Flat Fillets	K277-2		
Track Section	K396		
Flux Screen	K310		
Magnetic Flux Screen Separator	K58		
Concentric Flux Cone Assembly	K285		
RECOMMENDED POWER SOURCES			
CV-655	see publication E4.40		
DC-600	see publication E5.40		
DC-655	see publication E5.46		
DC-1000	see publication E5.50		
DC-1500	see publication E5.60		
	TOTAL:		

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 customer's 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 been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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THE WELDING EXPERTS

THE LINCOLN ELECTRIC COMPANY

22801 St. Clair Ave., Cleveland, OH 44117-1199 • 216.481.8100 • www.lincolnelectric.com