



# LHF 400/630/800

## Heavy duty rectifiers

### Robust and powerful

The LHF 400/630/800 are sturdy and robust thyristor-controlled units intended for manual heavy duty MMA welding with covered electrodes with direct current.

The LHF range can be also used for TIG welding when TIG add-on units are applied.

The LHF 630 and LHF 800 are optimised for arc-air gouging as well.

The LHF 400/630/800 are recommended especially for the highest requirements and toughest areas of applications. The large wheels make them easy to move.

Well proven technology together with ESAB developed software provides high reliability and outstanding welding performance.

### Easy to use

The wide current and voltage range make it easy to optimise settings for a wide variety of filler materials.

It is possible to adjust parameters during welding process.

The LHF units are equipped with such functions as hot start and anti stick.



## Applications

- General fabrication and civil construction
- Repair and maintenance
- Power generation
- Pipelines
- Shipbuilding and offshore
- Process industry

### Flexibility

The units have vertical static characteristics which means that regardless of cable length and arc voltage, the current is constant.

The dynamic characteristics of the LHF range ensures stable, spatterfree arc and easily controlled molten pool.

Due to high power factor energy consumption is low as well as installation costs.

As an option the LHF range can be equipped with remote control units.

The units are switched off automatically in case of overheating.

- Outstanding welding characteristics- high efficiency and high quality welding.
- Wide current and voltage range- multiple purpose applications.
- Mains voltage compensation - stable welding controls
- Stepless voltage control - exact settings and giving remote control facilities
- Anti stick and hot start

## Technical data

	<b>LHF 400</b>	<b>LHF 630</b>	<b>LHF 800</b>
<b>Mains voltage</b>	400/415/500 V, 3-50 Hz 440-460/550 V, 3-60 Hz	400/415/500 V, 3-50 Hz 440-460/550 V, 3-60 Hz	400/415/500 V, 3-50 Hz 440-460/550 V, 3-60 Hz
<b>Permitted load at</b>			
35% duty cycle	400 A	630 A	800 A
60% duty cycle	315 A	500 A	630 A
100% duty cycle	250 A	400 A	500 A
<b>Setting range (DC)</b>	8 A/20V - 400 A/36V	8 A/20V - 630 A/44(49)V	8 A/20V - 800 A/44(50)V
<b>Open circuit voltage</b>	80-87 V	65-72 V	65-72 V
<b>Open circuit power</b>	340W	615W	640W
<b>Power factor</b> at maximum current	0,9	0,87	0,82
<b>Efficiency</b> at maximum current	74%	77%	78%
<b>Inductance outlets</b>	2	2	2
<b>Dimensions l x w x h</b>	1310x 765 x 705 mm	1310x 765 x 705 mm	1310 x 765 x 705 mm
<b>Weight</b>	195 kg	260 kg	295kg
<b>Operating temperature</b>	-10 till +40°C	-10 till +40°C	-10 till +40°C
<b>Enclosure class</b>	IP 23	IP 23	IP 23
<b>Application classification</b>	S	S	S

## Ordering information

LHF 400	0319 783 882
LHF 400 Stationary	0319 783 885
LHF 400 Offshore	0319 783 886
LHF 400 V/A meter, fan control	0468 680 880
LHF 630	0319 950 882
LHF 630 Stationary	0319 950 885
LHF 630 Offshore	0319 950 886
LHF 630 V/A meter, fan control	0468 680 881
LHF 800 Offshore	0319 951 884

### Accessories

MMA 1 Remote control, 10 m	0349 501 024
MMA 2 Remote control, 10 m	0349 501 025
AT1 Remote control	0459 491 896
AT1 CoarseFine Remote control	0459 491 897

Connection cable 5 m analogue 12 pole	0459 552 880
Connection cable 10 m analogue 12 pole	0459 552 881
Connection cable 15 m analogue 12 pole	0459 552 882
Connection cable 25 m analogue 12 pole	0459 552 883
Auxiliary transformer (for TIG or rod drier)	0320 003 880
Spacer bars (stationary)	0320 000 880
Pneumatic tyres	0320 001 880
4-wheel chassis	0320 002 880
Protective 2-wheel frame	0365 053 880



## Quality accessories for the quality welder

ESAB offers a wide range of accessories. The complete range, along with product information, is available at our local web-sites, look at [www.esab.com](http://www.esab.com) or contact your local ESAB dealer.

## Unrivalled service and support

Our commitment and ability to deliver the expected service and support starts immediately after the order is confirmed. We endeavour to offer our customers an After Sales service, which is second to none. A strong and skilful service organisation is prepared to offer service and maintenance, calibration, validation and upgrading of equipment and software.

The service organisation will offer standardised solutions for the reconditioning or modification of existing products.

Spare and wear parts are manufactured according to ESAB's quality plan. Exchange Printed Circuit Board (PCB), exchange modules and components are available for all our products in order to reduce downtime to an absolute minimum. ESAB is continuously upgrading authorised service partners for local service support. Customers who have their own service and maintenance personnel will always be offered a service-training package as part of a total ESAB offering. However, product and process training for end-users will form an additional part of the ESAB offering. Always ask your ESAB sales representative or distributor for a complete ESAB solution.

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