ARC RUNNER

PORTABLE & PROGRAMMABLE WELDING CARRIAGE
REPEATS OPTIMUM WELD PROCEDURE

The **Steelmax® Arc Runner** is a portable, programmable welding carriage designed to produce consistent, high-quality welds. The powerful magnetic base and closed loop electronic speed control provide speed stabilization in all positions. The unit enables weld bead geometry that is exact to the required specifications, substantially reducing costly over welding and decreasing filler metal usage.

The **Arc Runner** can be programmed in continuous or stitch welding modes. Two easy-to-use function buttons enable programming of weld length, distance between welds, reverse fill, crater fill time and other required patterns and parameters. The **Arc Runner** travels at full speed between stitches, which saves valuable welding time.

An optional pendulum torch oscillator is available for the **Arc Runner** to produce weave welds. The oscillator allows for precise control of weave width, weave speed and left/right side wall dwell.

Arc Runner's microprocessor allows for development, storage and reproduction of up to 40 different welding programs for various joint configurations and multi-pass, multi-layer welds. Once an optimum weld procedure is developed, stored and programmed, **Arc Runner** will repeat it over and over again.

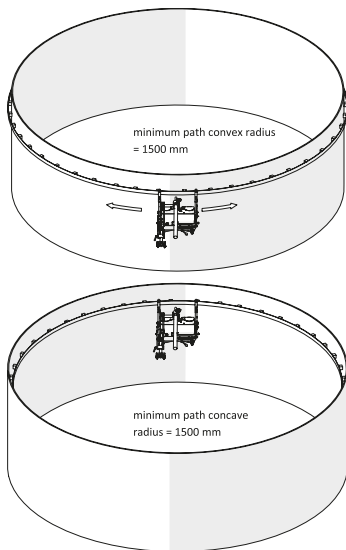**The Arc Runner can be used with the innovative Steelmax flexible guide rail system.**

The tools of innovation.

FEATURES

- Compact, lightweight design with durable cast aluminum housing
- Permanent magnet clamping system with on/off lever ensures positive magnetic traction
- Maintenance free, 4-wheel planetary gear drive system
- Standard torch holder for welding torches with diameters of 5/8" – 7/8" (16-22 mm); optional large holder for diameters up to 1-3/8" (35 mm)
- Precise cross-slide torch adjustment
- Multifunctional LED display and 2 function buttons for welding pattern programming
- Closed-loop speed control system stabilizes travel speed to reduce weld defects and costly repair work
- Consistent heat input reduces distortion
- Automatic ARC ON/OFF system initiates welding and travel, simultaneously
- Self-guiding roller arms eliminate the need for track
- Improves work environment – reduces fatigue and repetitive stress – removes operator from heat and fumes
- Capable of carrying and controlling 2 torches (without oscillation)
- Up to 40 complete programs may be stored in non-volatile memory

1. Drive unit with control panel
2. Main Supply Switch (0/I)
3. Cross slide assembly
4. Guide arm assembly with brass roller wheel
5. Quick release torch holder *(optional accessory)*
6. Power supply socket
7. Arc control cable socket
8. Magnetic adhesion release lever
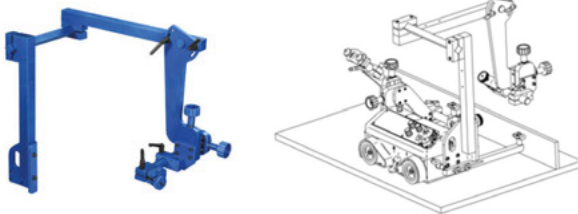9. Cable holder

OPTIONAL ACCESSORIES:

1. **Oscillator**

Oscillator Technical Specifications	
Oscillation type	Pendulum
Amplitude R-150 mm	0.08-1.2" (2-30 mm)
Frequency	12-115 cycles/min
Dwells	0-3 s.
Weight	5.5 lbs (2.5 kg)
Product Code	**SM-WC-AR-OSC**

2. **Dual Torch Mount**
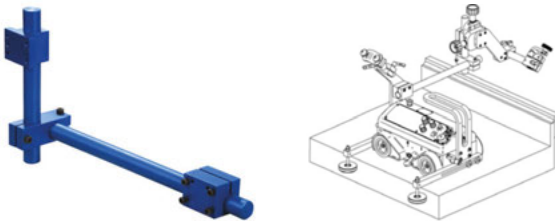   enables mounting of second torch for dual-sided fillet welding
   Product Code: SM-PDT-0466-40-00-00-0

3. **Torch Extension Arm**
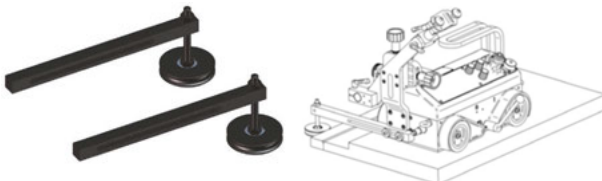   enables extended reach for torch placement
   Product Code: SM-PRD-0466-43-00-00-0

4. **Edge Following Guide Arms**
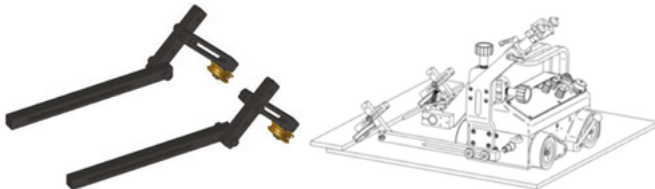   enables guiding off an outside edge
   Product Code: SM-PRW-0476-21-00-00-1
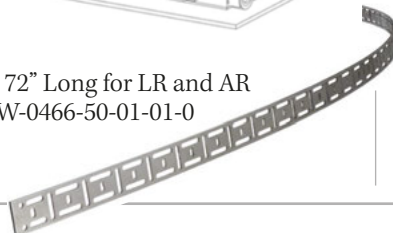
5. **Adjustable Guide Arms**
   enables guiding on lap joints and templates
   Product Code: SM-PRW-0476-22-00-00-1

6. **Flexible Guide Rail** 72" Long for LR and AR
   Product Code: SM-PRW-0466-50-01-01-0

7. **Flexible Guide Rail Alignment Tool**
   quickly aligns the flexible guide rail to the appropriate distance from the joint
   Product Code: SM-UST-0466-53-00-00-0
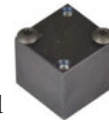
8. **Rail Guide Arms for Arc Runner**
   (set of 2)
   Product Code: SM-PRW-0476-50-01-00-1

9. **Magnet for Flex Rail**
   (LR and AR) - 10 required
   Product Code: SM-BLO-0466-50-01-10-0

10. **Quick Connect Torch Holder**
    quick connect/release torch holder
    Product Code: SM-ZRZ-0466-04-01-00-0

11. **Magnet Guide Arms for Arc Runner**
    (set of 2)
    enables guiding on overhead profiles and permits bi-directional movement
    Product Code: SM-PRW-0476-52-00-00-0

12. **Low Guide Arms for Arc Runner**
    (set of 2)
    enables guiding on short profiles and edges
    Product Code: SM-PRW-0476-54-00-00-1

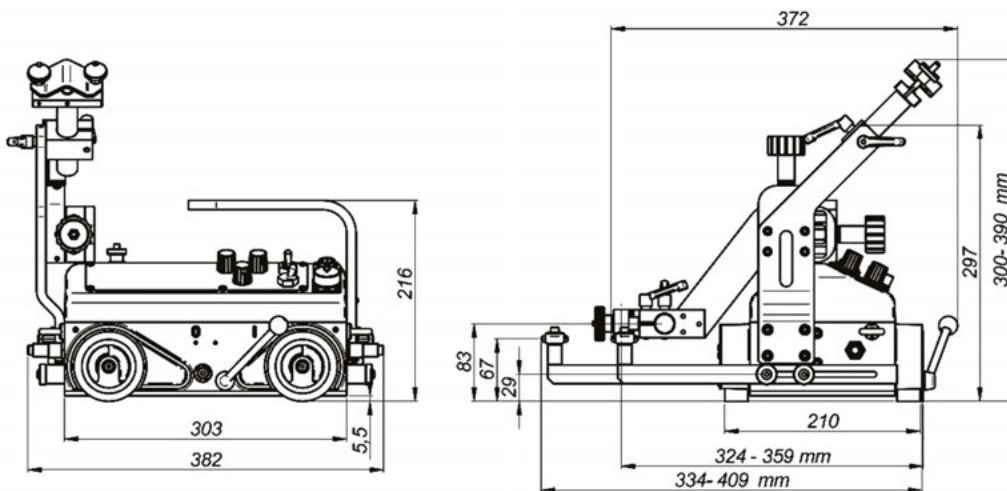13. **High Guide Arms for Arc Runner**
    (set of 2)
    enables guiding on plates and stiffeners with cut outs and holes
    Product Code: SM-PRW-0476-55-00-00-1

Arc Runner Technical Specifications

Part Number		**SM-WC-AR** or **SM-WC-AR-230**
Power supply		115-230 VAC / 50-60 Hz (separate units due to plug interface)
Welding positions		Vertical / Horizontal
Chassis to material clearance		3/16" (5 mm) minimum
Drive system		Friction drive with worm gear reduction
		Four wheel drive, heat resistant silicone wheels
Tracking method		2 roller guides in various configurations
Towing force		Vertical: 33.7 ft. lbs (150 Nm)
		Horizontal: 49.5 ft. lbs (220 Nm)
Torch adjustment	Up-Down	1-3/8" (35 mm)
	Left-Right	1-3/8" (35 mm)
Guide roller adjustment		3" (75 mm)
Control panel	Travel direction switch	program start, direction left / stop / program start, direction right
	Function button F1	Continuous welding, dash, crater fill, backweld
	Function button F2	Value change "+" or "-"
	Arc ignition switch	TEST / 0 / 1
	Speed knob	Horizontal speed: 0 – 47-1/4"/min (0-1200 mm/min)
		Vertical speed: 0 – 43-3/8"/min (0-1100 mm/min)
Automatic stop		Limit switches at both ends
Noise Level		< 70 dB
Dimensions (LxWxH)		15" x 14-5/8" x 15-3/8" (382 mm x 372 mm x 390 mm)
Weight		29.8 lbs (13.5 kg)

Steelmax.

The tools of innovation.