



**FLEET 400**

**FLEET 500**

**FLEET 650**

ENGINE-DRIVEN WELDER/GENERATOR

**LINCOLN<sup>®</sup>**  
**ELECTRIC**

# Simple and Rugged Stick, TIG and Pipe/ Gouging Modes

Built for operation in remote locations, the FLEET™ 400, 500 and 650 are simple, rugged diesel engine-driven welders for stick welding, TIG, and arc gouging. The design features time-tested Chopper Technology,® and the popular Deutz® and Perkins® industrial diesel engines. This means high reliability in jungles, deserts and other extreme environments.



FLEET 400 K3427-1

FLEET 500 K4338-1

FLEET 650 K4339-1



## Easy to Set

A Weld Mode selector gives the operator the choice of Stick, Pipe/Gouge or TIG modes. In the Pipe/Gouge mode a rocker switch provides for a high and low range and in all modes the Output Control allows for fine adjustment within each range. The addition of an Arc Force control allows the operator to adjust for a soft buttery arc or a more forceful digging arc. Digital weld meters are available as an option providing supervision with an extra measure of quality control.

## Dependable

Lincoln's proven Chopper Technology delivers easy arc starting, smooth arc action, low spatter levels and excellent bead appearance.

## Plenty of Auxiliary Power

The FLEET 400 provides 10,350 watts of continuous single phase 230 volt power through three 3,450 watt Euro Plugs.

The FLEET 500 and FLEET 650 provide a maximum of 9600 watts of power across two 240V Euro receptacles (7200 watts total), a 120V Euro Receptacle (1800 watts total), and a 120V NEMA receptacle (2400 watts total).

## Remote - Auto Sense

It is no longer necessary to use a toggle switch to change the FLEET from local to remote control. As soon as a remote is attached, the FLEET automatically switches to remote control.

### Product Numbers

K3427-1 FLEET 400

K4338-1 FLEET 500

K4339-1 FLEET 650

### Processes »

Stick, TIG, Gouging

### Applications »

Maintenance and Repair,  
Construction, Pipeline

### Rated Output -

#### Current/Voltage/Duty Cycle

FLEET 400

At 40°C 400A/25V/100%

FLEET 500

At 40°C 500A/33V/100%

FLEET 650

At 40°C 650A/36V/60%

### Output »



### Input »



# FLEET 400

## Controls »

1. **OUTPUT CONTROL**
2. **PIPE/GOUGE CURRENT RANGE SELECTOR**
3. ENGINE OIL PRESSURE GAUGE
4. START PUSH BUTTON
5. RUN / STOP SWITCH
6. GLOW PLUG PUSH BUTTON
7. FUEL / HOUR GAUGE
8. BREAKER FOR 12V BATTERY CIRCUIT
9. RCD READY PORT COVER
10. POSITIVE TERMINAL
11. **230V AC EURO PLUGS**
12. NEGATIVE TERMINAL
13. 230V AC CIRCUIT BREAKERS FOR EURO PLUGS
14. ENGINE TEMPERATURE GAUGE
15. ENGINE PROTECTION LIGHT
16. BATTERY CHARGING LIGHT
17. **6-PIN REMOTE CONTROL CONNECTION WITH AUTO-REMOTE SENSOR**
18. WELD MODE SELECTOR
19. **ARC FORCE CONTROL**
20. **DIGITAL AMPERAGE & VOLTAGE METERS (OPTIONAL)**





## FLEET 500/650 Controls »

- 1. OUTPUT CONTROL**
- 2. PIPE/GOUGE CURRENT RANGE SELECTOR**
3. ENGINE OIL PRESSURE GAUGE
4. START PUSH BUTTON
5. RUN / STOP SWITCH
6. BREAKER FOR 12V BATTERY CIRCUIT
7. 240 AV CIRCUIT BREAKERS FOR EURO PLUGS
8. RCD READY PORT COVER
9. POSITIVE TERMINAL
- 10. 240V AC EURO PLUGS**
11. FUEL / HOUR GAUGE
12. 120V AC NEMA PLUGS
13. ENGINE TEMPERATURE GAUGE
14. 120V EURO PLUG
15. NEGATIVE TERMINAL
16. SEALED GFCI MODULE
17. ENGINE PROTECTION LIGHT
18. BATTERY CHARGING LIGHT
- 19. 6-PIN REMOTE CONTROL CONNECTION WITH AUTO-REMOTE SENSOR**
20. WELD MODE SELECTOR
- 21. ARC FORCE CONTROL**
22. THERMAL PROTECTION INDICATOR
- 23. DIGITAL AMPERAGE & VOLTAGE METERS [OPTIONAL]**





## MACHINE SPECIFICATIONS

Product Name	Product Number	Description	Rated DC	DC Current	Auxiliary Power	Dimensions HxWxD in (mm)	Net Weight lb (kg)
<b>FLEET™ 400</b>	K3427-1	400A DC Engineered DC Generator	At 40°C 400A/25V/100%	Pipe/Gouge High Range 250-400 Pipe/Gouge Low Range 30-300 Stick Mode 30-300 TIG Mode 20-250	Three 230V Euro Receptacles 10350 Watts Total	34 x 24 x 56 (863.6 x 609.6 x 1422.4) To top of exhaust tube 40 in. (1016)	1065 (483)
<b>FLEET™ 500</b>	K4338-1	500A DC Engineered DC Generator	At 40°C 500A/33V/100%	Pipe/Gouge High Range 250-500 Pipe/Gouge Low Range 30-380 Stick Mode 30-380 TIG Mode 20-250	Two 240V Euro Receptacles 7200 Watts Total  One Duplex 120V NEMA Receptacle 2400 Watts Total	36.9 x 28.3 x 65.1 (937 x 718 x 1654)	1410 (639)
<b>FLEET™ 650</b>	K4339-1	650A DC Engineered DC Generator	At 40°C 650A/36V/60%	Pipe/Gouge High Range 300-650 Pipe/Gouge Low Range 30-380 Stick Mode 30-380 TIG Mode 20-250	One 120V Euro Receptacle 1800 Watts Total  [9600 Watts Maximum Combined Total]	To top of exhaust tube 46.5 in. (1181)	1510 (685)



## ENGINE SPECIFICATIONS

Product Name	Engine Model	Description	Horsepower & Displacement	Capacities	Operation Load	Fuel Consumption
<b>FLEET™ 400</b>	Perkins® 403D-15	3 Cylinder Water-Cooled Diesel Engine With Dry Cartridge Air Filter	21.7 HP @ 1800 RPM 91 cu in. [1.49L]	FUEL: 16 Gals (60.5 liters)	No Load 200A @ 28V 100% 300A @ 32V 100% 400A @ 25V 100%	0.45 gals/hr - 1.70 L/hr 0.79 gals/hr - 2.98 L/hr 1.12 gals/hr - 4.23 L/hr 1.15 gals/hr - 4.36 L/hr
<b>FLEET™ 500</b>	Deutz® D2011 L 3i	3 Cylinder Oil/Air-Cooled Diesel Engine With Dry Cartridge Air Filter	32 HP @ 1800 RPM 142 cu in. [2.33L]	FUEL: 25 Gals (94.6 liters)	No Load 200A @ 28V 100% 400A @ 36V 100% 500A @ 33V 100%	0.50 gals/hr - 1.91 L/hr 0.82 gals/hr - 3.11 L/hr 1.39 gals/hr - 5.28 L/hr 1.68 gals/hr - 6.37 L/hr
<b>FLEET™ 650</b>	Deutz® F3L912	3 Cylinder Oil/Air-Cooled Diesel Engine With Dry Cartridge Air Filter	44 HP @1800 RPM 173 cu in. [2.8L]		No Load 200A @ 28V 100% 500A @ 40V 100% 650A @ 36V 60%	0.70 gals/hr - 2.64 L/hr 1.01 gals/hr - 3.83 L/hr 1.93 gals/hr - 7.32 L/hr 1.62 gals/hr - 5.74 L/hr



<b>Additional Accessories</b>	<b>Product Number</b>	<b>FLEET 400 K3427-1</b>	<b>FLEET 500 K4338-1</b>	<b>FLEET 650 K4339-1</b>
<b>GENERAL</b>				
Spark Arrestor Kit - Mounts to muffler exhaust tube. Virtually eliminates spark emissions	K903-1	.		
Spark Arrestor Kit - Mounts to muffler exhaust tube. Virtually eliminates spark emissions.	K2864-1		.	.
<b>Medium Two-Wheeled Welder Trailer with Duo-Hitch®</b> – For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13 in. (330 mm.) wheels. Overall width 60 in. (1524 mm.) Stiff .120 in. (3.0 mm.) welded rectangular steel tube frame construction is phosphate-etched and powder coat painted for superior rust and corrosion resistance. Features a Duo-Hitch 2 in. (51 mm.) Ball/Lunette Eye combination hitch.	K2636-1	.	.	.
<b>Fender &amp; Light Kit</b> - Allows use of trailer at night and as required by local regulations. Includes fenders, lights with guards, mounting brackets, wiring and hardware.	K2639-1	.	.	.
<b>Cable Storage Rack</b> – For storage of approximately 100 ft. (30.5 m.) of 2/0 (70 mm <sup>2</sup> ) welding cable per side.	K2640-1	.	.	.
<b>Polarity Switch</b> – Allows easy switching of weld output polarity. Factory installation available as special order.	Special	.	.	
<b>STICK</b>				
<b>Accessory Kit</b> – For stick welding. Includes 35 ft. (10.7m) 2/0 (70 mm <sup>2</sup> ) electrode cable with lug, 30 ft. (9.1m) 2/0 (70 mm <sup>2</sup> ) work cable with lugs, headshield, filter plate, work clamp and electrode holder.	K704	.	.	.
<b>Remote Output Control</b> - Includes control box, cable and 6-pin MS-Type connector.	K857 (25 ft.) K857-1 (100 ft.)	.	.	.
<b>Remote Output Control - 125 FT</b> – Customizable MIN/MAX range is easy to set up in seconds. Precisely set the range you need for the job at hand. Detachable control box can be stowed in your truck or job box to deter job site theft. Connects to 6-pin MS-type connector.	K4330-1	.	.	.
<b>Remote Output Control with 120V AC Receptacles - 125 FT</b> – Includes a 115V duplex receptacle that can be used to power lights, grinders and tools right where welding occurs. Customizable MIN/MAX range is easy to set up in seconds. Precisely set the range you need for the job at hand. Detachable control box can be stowed in your truck or job box to deter job site theft. Connects to 6-pin MS-type connector.	K4268-1		.	.

<b>Additional Accessories</b>	<b>Product Number</b>	<b>FLEET 400 K3427-1</b>	<b>FLEET 500 K4338-1</b>	<b>FLEET 650 K4339-1</b>
<b>TIG</b>				
<b>TIG Module (K938-1 Contactor Kit Required)</b> - Supplies high frequency for superior starting, contactor control, remote control capability and a gas valve for AC or DC TIG welding (polarity selection dependent on output characteristics of power source). Rated at 300 amps/60% duty cycle. Requires 115V, single phase input power.	K930-2		.	.
<b>Contactor Kit</b> - Installs in the K930-2 TIG Module for use with welders without a contactor. Makes the TIG torch electrode electrically 'cold' until the Amptrol® is activated.	K938-1		.	.
<b>Control Cable</b> - Control Cable for the TIG Module. Connects 9-pin socket on TIG Module to 115V plug.	K936-3		.	.
<b>Control Cable Extension</b> - Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source.	K937-45		.	.
<b>Pro-Torch™ PTA-26V TIG Torch</b> – “V” model torches have a convenient gas control valve on the torch to quickly and easily control the shielding gas flow when a gas solenoid valve is not “built-in” to the power source.	K1783-9	.	.	.
<b>Magnum® Parts Kit for PTA-26V TIG Torch</b> - Magnum Parts Kits provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box.	KP509	.	.	.
<b>Foot Amptrol™</b> - Depress pedal to increase current. Depressing pedal fully achieves maximum set current. Fully raising the pedal finishes the weld and starts the Afterflow cycle. Equipped with a 6 pin connector	K870	.	.	.
<b>Hand Amptrol™</b> - Provides 25 ft. (7.6 m) of remote current control for TIG welding. Compatible with power sources with 6-pin remote connection.	K963-3	.	.	.
<b>OPTIONS</b>				
<b>Digital Meter Kit</b> - Digital display of amps and volts.	K2467-1	.	.	.

#### 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.

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