

*Bryan Fuller -
host of TWO GUYS GARAGE
and avid welder.*

I CHOOSE LINCOLN.™

2009 Product Catalog

www.lincolnelectric.com

LINCOLN®
ELECTRIC
THE WELDING EXPERTS®



The Lincoln Electric Company® ***The Welding Experts®***

Welding is everywhere, and Lincoln Electric has been there since the beginning.

Lincoln Electric has always been a leader and innovator in the design and production of arc welding equipment and consumables. Headquartered in Cleveland Ohio, we are also a worldwide leader in robotic arc welding systems as well as plasma and oxyfuel cutting equipment. The catalog you hold in your hands contains some of the best performing, most well made and tested Welders and Consumables on the market today.

We are committed to your success. At Lincoln Electric, we have a global team of professionally trained Technical Sales Representatives, Application Engineers, and Customer Service Representatives ready to help you improve quality and productivity, while reducing costs. And with more than 2,000 Authorized Distributor partners, no other company is better able to serve your welding and cutting needs.

Who We Are

The people of the Lincoln Electric Company strive to meet the goals set forth by our founders John and James Lincoln.

- Make a product you can take pride in, so the customer can too.
- Listen to the people that use your products, and always look for ways to make it better.
- Lead by design and innovation, and never accept that it can't be improved.
- Be The Best.

We're proud to say that for over 114 years, people have chosen Lincoln Electric products. No matter where you work; from a coal mine to a skyscraper, an oil derrick to your garage, there's a Lincoln Electric welder and consumable that can help you make it the best.

Thank you for Choosing Lincoln Electric!

Please note that products offered in this catalog are subject to change and availability at any time without notice.



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Content

- 1 Catalog Section**
Identifies catalog section for easy-to-find products.
- 2 Product Name**
Official Lincoln product name.
- 3 Product Description**
Brief description of the product.
- 4 Opening Paragraph**
This is a general description of the product. It may include features and applications of the product.
- 5 Key Features**
This section highlights the key features and benefits of the product.
- 6 Product Picture**
Detailed photo of Lincoln product.
- 7 Processes**
Recommended arc welding processes for the product.
- 8 Input & Output Icons**
See below for descriptions.
- 9 Unit Includes/Key Options**
These sections list options that are included or are the most popular options requested for each product.
- 10 Literature Number**
Order number to request more information.
- 11 Technical Specifications**
Common specifications, ratings, dimensions and weight for the product.

ENGINE DRIVES: INDUSTRIAL/CONSTRUCTION

NEW! Vantage® 500 (Compact Case)

3 Compact Design!
Get a 500 amp welder in a compact case! The same size as the Vantage® 300 and Vantage® 400! Also, less weight than traditional 500 amp welders makes the Vantage® 500 a great choice for installation on truck beds where available space and weight capacity are limited.

- Compact Case.** One of the most compact 500 amp machines available. Suitable for many pickup and service trucks.
- Stainless steel enclosure** for corrosion-resistant protection and durability.
- Multi-Process Welding.** 500 amps at 100% duty cycle for CC-stick, pipe, CV-wire, DC Touch-Start® TIG and arc gouging.
- VRD™ Voltage Reduction Device™** for reduced OCV in the CC-Stick weld mode.
- Plenty of AC Generator Power:**
- 22 kW peak (20 kW continuous) 3-Phase 240V AC
- 13 kW peak (12 kW continuous) 1-Phase 120/240V AC
- Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output

Input

Ready-Pak® Package Includes

- Vantage® 500
- Road Trailer with Duo-Hitch™
- Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Electrode Cable 3/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft. (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K2656-1 Medium Two-Wheel Road Trailer with Duo-Hitch™
- Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Control, 100 ft.
- More options at end of section

Literature: E6.214

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Vantage® 500	K2686-1	500A/40V/100% 500A/60V/60%	30-525A DC 40-300A Pipe 20-250A DC TIG 14-40V CV	Perkins® 404D-271 Turbo Diesel EPA Tier 4i	4	49 @ 1,850	35.9 x 25.3 x 60.0 (913 x 642 x 1524)	1,445 (655)

Air Vantage® 500

It's Three in One—Welder, Generator and Air Compressor

When you need it all, consider the rugged Air Vantage 500 for railroad, mining, heavy duty construction, and rental fleet use. A direct gear-driven compressor pumps plenty of air for arc gouging with up to 3/8" carbons, plasma cutting or other air tools. A powerful 500 amps @ 100% duty cycle is enough for almost any stick, TIG, MIG or flux-cored welding project.

- Rotary screw compressor** rated at 60 CFM, 100 PSI, 100% duty cycle.
- Multi-process powerhouse**—500 amps at 100% duty cycle, or 575 amps at 50%.
- Plenty of AC Generator Power**
- 20 kW continuous 3-phase 240V AC
- 12 kW continuous 1-phase 120/240V AC
- Stainless steel corrosion-resistant enclosure.**
- Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Air Vantage® 500	K2625-2	500A/40V/100% 550A/60V/60%	30-575A DC 40-300A Pipe 20-250A DC TIG 14-40V CV	Kubota® V360D-1 Turbo Diesel EPA Tier 4i	4	58 @ 1,850	49.0 x 32.7 x 63.1 (1245 x 831 x 1593)	1,730 (785)

www.lincolnelectric.com/engine-drives

Icons

Output Icons

	For constant current stick and TIG processes		Alternating current welding output		Peak auxiliary power output		2-Roll Wire feeder
	For constant voltage MIG, flux-cored and subarc processes		Direct current welding output		Surge auxiliary power output		4-Roll Wire feeder
	For multiprocess constant current or constant voltage applications		Alternating or direct current welding output		Continuous auxiliary power output		

Input Icons

	Single phase input power		115 Volt AC Wire feeder input power		50 Hertz input power		Engine Driven – Gas, Diesel or LPG
	Three phase input power		42 Volt AC Wire feeder input power		60 Hertz input power		
	Single or three phase input power		40 Volt DC Wire feeder input power		50/60 Hertz input power		

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4

STICK WELDERS

Versatile Stick Welders for Shop or Field

- Weld a Wide Range of Materials and Thicknesses
- Conventional or Inverter Models



	MODEL	OUTPUT		PROCESS					INPUT		FEATURES								
		Mode	Polarity	Current Range (Amps)		Stick	TIG Scratch	TIG Touch-Start®	TIG Hi-Freq™	Arc Gouge	Phase	Hertz	Compact	115/230 Volt Auto-Sensing	Hot Start	Arc Force Meters	7-Yr. Warranty (on Power Rectifier)	Polarity Switch	Voltmeter/Ammeter
1-Phase Transformer	AC-225	CC	AC	40-225 AC		●					1	50,60							
	AC/DC 225/125	CC	AC/DC	30-125 DC	40-225 AC	●	●				1	50,60							
	Idealarc® 250	CC	AC/DC	40-250 DC	35-300 AC	●	●	○	●		1	60							
Inverter	Invertec® V155-S	CC	DC	5-155 DC		●		●			1	50,60	●	●	●	●			
	Invertec® V275-S	CC	DC	5-275 DC		●		●		●	1/3	50/60	●		●	●			
3-Phase Transformer	Idealarc® R3R-400	CC	DC	60-500 DC		●	●	○	●		3	60				●	●	●	●
	Idealarc® R3R-500	CC	DC	75-625 DC		●	●	○	●		3	60				●	●	●	●

KEY: ● Excellent ● Good ○ Optional

AC-225

AC General Purpose Welding

Use our popular AC-225 to stick weld mild steel, low alloy and stainless steels as well as cast iron for common repair and hobby projects.

- **40-225 amps AC stepped output control** is enough for 3/16" (4.8 mm) diameter mild steel general purpose stick electrodes and select 5/32" (4.0 mm) diameter electrodes.
- **Weld 16 gauge sheet metal to heavy plate** on mild steel, low alloy stainless, cast iron and hardfacing applications.
- **Included Helmet and Sample Electrodes** allow you to start welding right away.
- **Three-year warranty** on parts and labor.



Shown:
K1170 AC-225

Processes

- Stick

Output **Input**

Unit Includes

- Insulated electrode holder and cable
- Lightweight helmet with lenses
- Heavy duty work clamp and cable
- Sample pack of electrodes
- Helpful Welder's Guide
- Input Cable with integrated plug
- K1170-4 also includes Wheel Kit and Gloves

Key Options

- K761 Wheel Kit
- *More options at end of section*

Literature

E2.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
AC-225	K1170 K1170-4	230/1/60	225A/25V/20% ⁽¹⁾	50A	40-225 Amps Max. OCV: 79V	24 x 17.25 x 12 (610 x 438 x 305)	109 (49.5)
	K1290	220/1/50	225A/25V/15%	63A	50-250 Amps Max. OCV: 76V		108 (49.0)

⁽¹⁾ Except 75 amp setting which can be used continuously for 1 hour.

AC/DC 225/125

Tackle More Tasks with AC/DC

Select DC polarity for extremely stable arc action or out-of-position welding with Lincoln Fleetweld® 5P+. Choose AC polarity for welding on heavier plate, greater deposition or faster travel speeds with Lincoln® Fleetweld® 35. Great choice for stick welding on mild steel, low alloy and stainless steels as well as cast iron and hardfacing for maintenance, repair and light fabrication projects.

- **40-225 amps AC and 30-125 amps DC stepped output control** is enough for 3/16" (4.8 mm) mild steel general purpose electrode diameters and select 5/32" (4.0 mm) diameter electrodes.
- **Weld 16 gauge sheet metal to heavy plate** on mild steel, low alloy stainless, cast iron and hardfacing applications.
- **Includes integrated input power cable with plug and receptacle** for wall-mounting.
- **Three-year warranty** on parts and labor.



Shown:
K1297 AC/DC 225/125

Processes

- Stick
- TIG

Output **Input**

Unit Includes

- Insulated electrode holder and cable
- Heavy duty work clamp and cable
- Helpful Welder's Guide
- Input Cable with integrated plug and receptacle

Key Options

- K761 Wheel Kit
- *More options at end of section*

Literature

E2.60

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
AC/DC 225/125	K1297	230/1/60	AC: 225A/25V/20% DC: 125A/25V/20%	AC: 50A DC: 36A	40-225 Amps AC Max. OCV: 79V 30-125 Amps DC Max. OCV: 73V	24 x 17.25 x 12 (610 x 438 x 305)	124 (56.3)
AC/DC 225/125	K1299	220/1/50	AC: 225A/25V/15% DC: 125A/25V/15%	AC: 55A DC: 41A	50-250 Amps AC Max. OCV: 76V 35-135 Amps DC Max. OCV: 69V		123 (55.8)

Idealarc® 250

Basic Industrial Stick Welding

The Idealarc® 250 delivers up to 300 amps AC (250 amps DC) for stick welding in vocational education, industrial production, maintenance and repair or farm shop environments.

- **Plenty of output**—300 amps AC and 250 amps DC is enough for up to 1/4" (6.4 mm) diameter of some stick electrode types.
- **Run every type of stick electrode**, including cellulosic and low hydrogen, and those for stainless steel, hardfacing and cast iron applications.
- **Easy to use full range continous control** provides precise command of heat input in the weld.
- **Stackable case design** can be stacked up to three high to save valuable floor space.
- **Three-year warranty** on parts and labor.



Shown: K1053-7 Idealarc® 250

Processes

- Stick
- TIG
- Gouging

Output **Input**

Key Options

- K1894-1 Power Factor Capacitor Kit (60 Hz)
- K866 Undercarriage
- K704 Accessory Kit, 400 Amp
- K930-2 TIG Module
- *More options at end of section*

Literature

E2.70

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® 250	K1053-7	208/230/460/1/60	AC: 250A/30V/30% DC: 250A/30V/30%	95/86/43A	35-300 Amps AC Max. OCV: 72V 40-250 Amps DC Max. OCV: 70V	27 x 19 x 21.5 (686 x 483 x 546)	350 (159)
	K1053-9 (w/PFC)			75/68/34A			
	K1053-8	230/460/575/1/60		86/43/34A			

Invertec® V155-S

Portable. Professional. Rugged. Affordable.

The NEW Invertec® V155-S offers much more than you would expect from a welder this size. Weighing in at just under 15 lbs. (6.8 kg) the Invertec® V155-S is no lightweight contender. It packs the full punch of a heavyweight professional that you can take to the most demanding job sites. It features 120/230V auto reconnect operation and can operate from a portable generator. It can also plug into a 200 ft. (61 m) 230V extension cord so you can weld just about anywhere.

- **Two stick modes**, SOFT and CRISP, provide the right arc characteristics for different types of electrodes.
- **Fan-As-Needed™ (F.A.N.™)** reduces noise and dust inside the machine.
- **Auto-Adaptive Arc Force™** minimizes electrode sticking in the puddle without compromising arc stability or increased spatter.
- **Automatic Hot-Start™** boosts the current during starting to make striking an arc easier.
- **Touch Start TIG® mode** – it's like getting a TIG welder for free!
- **Three-year warranty** on parts and labor.



Shown: K2605-1 Base Unit with Stick Accessories

Processes

- Stick
- DC TIG

Output **Input**

Base Unit Includes

- Invertec® V155-S (K2605-1).
- Stick electrode holder, cable and Twist-Mate™ plug.
- Work cable and clamp with Twist-Mate™ plug.
- Fully adjustable shoulder strap.
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug.
- Extra 120V 20 Amp plug.

Key Options

- K2275-1 Welding Cart
- K852-25 Twist-Mate™ Cable Plug Kit
- TIG Ready-Pak® (K2606-1) (see TIG Section for details).
- *More options at end of section*

Literature

E2.141

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V155-S	K2605-1 and K2606-1	120V/1/50/60	75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG	24.0A 33.8A 21.5A 28.8A	5-155 Amps DC Max. OCV: 75V	11.3 x 6.2 x 15.4 (288 x 158 x 392)	14.7 (6.7)
		230V/1/50/60	100A/24.0V/100% Stick 145A/25.8V/30% Stick 100A/14.0V/100% TIG 155A/16.2V/30% TIG	21.0A 31.0A 14.1A 22.8A			

⁽¹⁾ Input amps on 60 Hz input.

Invertec® V275-S

Weather-Resistant Stick and TIG Welder

The V275-S Stick and TIG power source is ideal for outdoor construction sites—it's IP23S rated and equipped with weather resistant features. Up to 275 amps of output gives you access to a greater number of stick electrodes, including outstanding E6010 performance.

- **Outstanding E6010 and E7018 performance** using up to 7/32" (5.6 mm) diameter electrode.
- **Touch Start TIG® DC** allows the welding arc to be established without high frequency starting.
- **Air Carbon Arc Cutting and Gouging** with up to 3/16" (4.8 mm) diameter carbon electrode.
- **Selectable Hot Start**—Turn it off for thin material or flip it on for thick, rusty or dirty material.
- **Variable Arc Force**—Dial in the "soft" or "crisp" arc you want.
- **All-in-one machine**—208/220/415/575 input volt settings—no single phase de-rating.
- **Three-year warranty** on parts and labor.



Shown: K2269-1 Invertec V275-S

Processes

- Stick
- TIG
- Gouging

Output Input

Key Options

- K852-70 Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable
- K1759-70 Twist-Mate™ Receptacle for 1/0-2/0, 50-70mm² cable
- K2394-1 Stick Electrode Holder, Work Clamp, Cable and Twist-Mate™ Set
- K857 Remote Output Control, 25 ft (7.6 m)
- K2265-1 TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled)
- *More options at end of section*

Literature

E2.161

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V275-S	K2269-1	208/230/460/ 575/3/60	275A/31V/35% 250A/30V/60% 200A/28V/100%	38/37/19/16A 34/33/17/14A 27/25/13/11A	5-275A	13.6 x 9.0 x 20.25 (345 x 229 x 514)	54.5 (24.7)
or NEW! Invertec® V275-S (Tweco®)(1)	or K2269-3	208/230/460/ 575/1/60	275A/29-31V/35% 250A/30V/60% 200A/28V/100%	68/67/38/31A 63/62/33/27A 49/48/26/21A			
		220/380/400/ 415/440/3/50	250A/30V/35% 200A/28V/100%	32/20/19/18/17A 25/15/15/14/13A			
		220/380/400/ 415/440/1/50		63/42/40/38/36A 48/32/30/29/27A			

(Tweco® is a registered trademark of Thermadyne.)

Idealarc® R3R-400 & R3R-500

Heavy Duty Stick Welding and Arc Gouging

Look to the R3R-400 and R3R-500 for your heavy-duty stick welding needs. Whether you are using cellulosic, low hydrogen, stainless steel or hardfacing electrodes, the Idealarc® R3R-400 and R3R-500 produce a smooth, quality arc for consistent results day-in and day-out.

- **Substantial amperage ranges** include the R3R-400 at 60-500 amps and the R3R-500 at 72-625 amps.
- **Easy to operate**—Calibrated current control knob makes procedure setting simple and easy.
- **Polarity switch, voltmeter and ammeter** are standard.
- **Arc gouge** with the R3R-400 using up to 5/16" (7.9 mm) diameter carbon electrode and the R3R-500 using up to 3/8" (9.5 mm) diameter carbon electrode.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on the power rectifier.



Shown: K1285-16 Idealarc® R3R-400

Shown: K1286-16 Idealarc® R3R-500

Processes

- Stick
- TIG
- Gouging

Output Input

Key Options

- K841 Undercarriage – Hand moving
- K2149-1 Work Lead Package
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- *More options at end of section*

Literature

E2.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® R3R-400	K1285-16	230/460/3/60	400A/36V/60%	74/37A	60-500A Max. OCV: 67V	27.5 x 22.3 x 32 (699 x 566 x 813)	402 (183)
Idealarc® R3R-500	K1286-16		500A/40V/60%	88/44A	72-625A Max. OCV: 67V		446 (203)

NOTE: 50 Hertz models available.

Stick Options

See "Recommended General Options" pgs. 151-171 for descriptions.

AC-225*General Options*

K761	Wheel Kit
—	Fume Extraction System

AC/DC 225/125*General Options*

K761	Wheel Kit
—	Fume Extraction System

Idealarc® 250*General Options*

K1894-1	Power Factor Capacitor Kit (60 Hz)
K866	Undercarriage
—	Fume Extraction System

Stick Options

K875	Accessory Kit, 150 Amp
K704	Accessory Kit, 400 Amp

TIG Options

K930-2	TIG Module
K938-1	Contact Kit
K936-4	Control Cable (9-pin to 115V plug)

Invertec® V155-S*General Options*

K2275-1	Welding Cart (80 cu ft bottle capacity)
K852-25	Twist-Mate™ Cable Plug Kit
—	Fume Extraction System

TIG Options

K1781-7	PTA-9FV Flexible Head Gas Valve Torch (25 ft., 1 pc.)
K960-2	Small Twist-Mate™ Torch Adapter (with separate gas)
KP507	Parts Kit for PTA-9 Series Torches
K1782-13	PTA-17FV Flex Head Gas Valve TIG Torch w/Ultra-Flex™ Cable (12.5 ft., 1 pc.)
K960-2	Small Twist-Mate™ Torch Adapter (with separate gas)
KP508	Parts Kit for PTA-17 Series Torches
K586-1	Deluxe Adjustable Gas Regulator and Gas Hose Kit

Invertec® V275-S*General Options*

K852-70	Twist-Mate™ Cable Plug, for 1/0-2/0, 50-70 mm ² cable
K852-95	Twist-Mate™ Cable Plug, for 2/0-3/0, 70-95 mm ² cable
K1759-70	Twist-Mate™ Receptacle, for 1/0-2/0, 50-70 mm ² cable
K1759-95	Twist-Mate™ Receptacle, for 2/0-3/0, 70-95 mm ² cable
—	Fume Extraction System

Stick Options

K2394-1	Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set
K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)

TIG Options

K2265-1	TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled)
K960-1	Twist-Mate™ Torch Adapter (with separate gas)
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)

Idealarc® R3R-400 and R3R-500*General Options*

K841	Undercarriage – Hand moving
K2149-1	Work Lead Package
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)

TIG Options

K930-2	TIG Module
K939-1	Docking Kit
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K938-1	Contact Kit
K936-3	Control Cable (9-pin to 6-pin and 115V plug)
K937-45	Control Cable Extension, 45 ft.
K586-1	Deluxe Adjustable Gas Regulator and Hose Kit

TIG WELDERS



Chip Foote – World-renowned automotive designer, builder and welder.



Lincoln TIG Welders Give You the Power to Perform!™

- Precision Arc Control
- Code Quality Results
- Convenient High Value Features

MICRO START™ II
TECHNOLOGY

	MODEL	OUTPUT		Current Range (Amps)	Stick	TIG Touch-Start®	TIG Hi-Freq™	TIG Pulse	INPUT		FEATURES				
		Mode	Polarity						Phase	Hertz	Micro-Start™ II	Auto-Balance®	Auto-Reconnect™	Variable AC Frequency	Ready-Pak®
Conventional Rectifier	Precision TIG® 225	CC	AC/DC	5-230	●	●	●		1	50,60	●	●			●
	Precision TIG® 275	CC	AC/DC	2-340	●	●	●	○	1	50,60	●	●			●
	Precision TIG® 375	CC	AC/DC	2-420	●	●	●	●	1	50,60	●	●			●
Inverter	Inverter® V155-S	CC	DC	5-155	●	●			1	50,60			●		●
	Inverter® V160-T	CC	DC	5-160	●	●	●	●	1	50,60			●		
	Inverter® V205-T DC	CC	DC	6-200	●	●	●	●	1	50,60			●		●
	Inverter® V205-T AC/DC	CC	AC/DC	6-200	●	●	●	●	1	50,60			●	●	●
	Inverter® V310-T AC/DC	CC	AC/DC	5-310	●	●	●	●	1/3	50,60			●	●	●

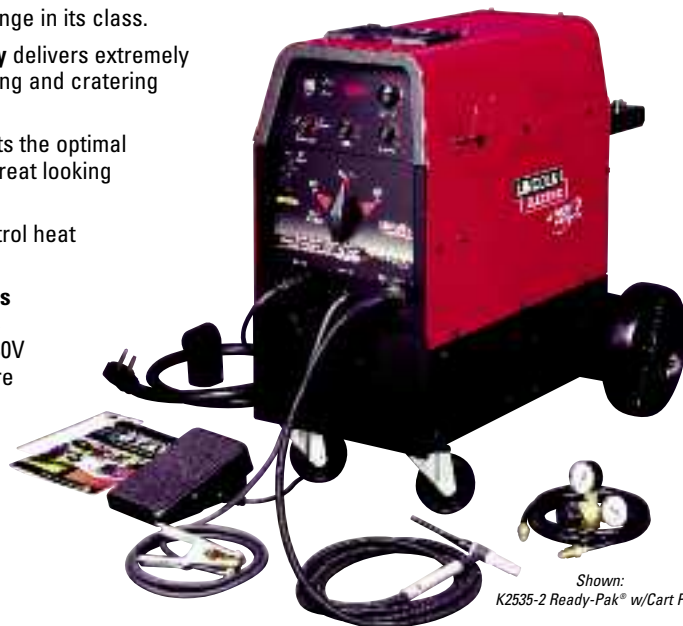
KEY: ● Excellent ● Good ● Optional

Precision TIG® 225

Great for Motorsports and Other Custom Fabricators

The Precision TIG® 225 gives you the "Power to PerformSM", for general fabrication, automotive/ motorsports, vocational schools or serious hobby work. Micro-Start™ II Technology delivers precision arc performance to improve arc starting, welding and weld cratering.

- **5-230 amps** is the widest welding range in its class.
- **Patented Micro-Start™ II Technology** delivers extremely stable low amperage starting, welding and cratering for AC and DC welding.
- **AC Auto-Balance®** automatically sets the optimal cleaning vs. penetration levels for great looking aluminum welds.
- **FREE! Built-in TIG pulser** helps control heat input in the weld.
- **115 volt auxiliary power receptacles** with 20 amp service reliably powers water coolers or other tools. (208/230V models only. 460/575V models feature 6 amp service).
- **Three-year warranty** on parts and labor.



Shown:
K2535-2 Ready-Pak® w/Cart Pkg.

Processes

- Stick
- TIG

Output **CC** **AC** **DC** Input **1** **60** **50**
Phase Hz Hz

Ready-Pak® Pkg. (K2535-1)

Includes

- Precision TIG® 225 (K2533-1)
- Removable Lift Eye
- 10 ft. (3.0 m) Work Cable & Clamp
- NEMA 6-50R Receptacle (208/230V models only)
- TIG Procedure Guide
- GTAW (TIG) Handbook
- PTA-17 One-Piece TIG Torch
- Gas Regulator/Hose
- Foot Amptrol®

Ready-Pak® w/Cart Pkg. (K2535-2)

Includes

- Everything Listed Above (K2535-1)
- Understorage Cart

One-Pak® w/POWER MIG® 140 (K2680-1)

- See below for what's included

Key Options

- K2266-1 TIG-Mate™ 17 Air-Cooled TIG Torch Starter Pack
- K870 Foot Amptrol®
- K963-3 Hand Amptrol®
- K2348-1 Understorage Cart
- Fume Extraction System
- *More options at end of section*

Literature

E3.37

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output ⁽¹⁾ Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽²⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Precision TIG® 225 Ready-Pak® Pkg.	K2535-1	208/230/1/60	90A/23.4V/100%	42/39A	5-230 Amps AC 5-230 Amps DC Max. OCV: 75V	20.7 x 14.5 x 25.6 (526 x 368 x 650)	212 (96)
Precision TIG® 225 Ready-Pak® w/Cart Pkg.	K2535-2					31.2 x 19.8 x 38 (794 x 503 x 966)	258 (117)
Precision TIG® 225 Base Model	K2533-1	208/230/1/60		42/39A		20.7 x 14.5 x 25.6 (526 x 368 x 650)	192 (87)
	K2533-2	460/575/1/60		18/15A			
	K2534-1	380/400-415/1/50/60		21/20-19A			

⁽¹⁾ Tested at 104°F (40°C). ⁽²⁾ Inputs and ratings are based on the 115 volt auxiliary receptacle being loaded to its full rating. 208/230V model feature a 20 amp rated auxiliary. 460/575V models feature a 6 amp auxiliary.

One Pak!

Precision TIG® 225 / POWER MIG® 140C

COMPLETE PACKAGE Includes:

Precision TIG® 225 (208/230/1/60) (K2535-1)

- 10 ft. (3.0 m) Work Cable & Clamp
- 9 ft. (2.7 m) Input Power Cord with Plug
- NEMA 6-50R Receptacle
- GTAW (TIG) Handbook
- PTA-17 12 ft. Ultra-Flex™ TIG Torch Package
- Gas Regulator with Hose
- Foot Amptrol® (K870)

Wire Feed Welder Mounting Bracket (K2616-1)

Dual Cylinder Cart (K2617-1)

Stick Electrode Holder & Cable (K2374-1)

POWER MIG® 140C (K2471-1)

- Magnum® 100L gun
- Contact Tips
- Gasless & Gas Nozzle
- .025"-.035" Wire Guide
- .025" & .035 Smooth Drive Rolls
- .030"-.045" Knurled Drive Roll
- Gas Regulator and Hose
- Spool of .025" SuperArc® L-56® Solid MIG wire
- Spool of .035" Innershield® NR®-211-MP® wire
- Spindle Adapter for 8" Diameter Spools
- Work Clamp and Cable
- How to Use DVD

Lincoln just combined the best small MIG and TIG Welder together into one easy to order package!

TIG MIG STICK

All for One-One for All

ORDERING INFORMATION: K2680-1

(Consult: Precision TIG® 225 sales bulletin E3.37 & POWER MIG® 140C sales bulletin E7.23)

Precision TIG® 275

Serious TIG Welding Performance

The Precision TIG® 275 gives you the “Power to Perform™”, for fabrication, aerospace, production, motorsports or vocational education.

- **Patented Micro-Start™ II Technology** delivers extremely stable low amperage starting, welding and cratering for AC and DC welding.
- **AC Auto-Balance®** automatically sets the optimal cleaning vs. penetration levels for great looking aluminum welds.
- **Widest Output Range** – 2-340 amps.
- **Highest duty cycle** – 275 amps @ 40%.
- **Optional TIG pulser** helps control heat input in the weld to reduce distortion and burnthrough on thin materials.
- **Neat/organized cable management** with integrated torch holster.
- **Built-in storage compartment** for torch consumables.
- **Fan-As-Needed™ (F.A.N.™)** prevents overheating. F.A.N.™ reduces power consumption, noise, motor wear and dust in the machine.
- **New set-up menu** gives more features.
- **Three-year warranty** on parts and labor.



Shown:
K2618-1 Ready-Pak® w/Cart Pkg.

Processes

- Stick
- TIG

Output **Input**

Water-Cooled Ready-Pak® w/Cart Includes

- K2619-1 Precision TIG® 275
- Under-Cooler Cart
- Foot Amptrol®
- Gas Regulator/Flowmeter/Hose
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- Parts Kit
- Water Hose (2 included)
- 15 ft. (4.5 m) 2/0 Work Cable/Clamp
- PTA-9 or -17 Torch Adapter

Key Options

- K2621-1 Advanced Control Panel
- K963-3 Hand Amptrol®
- K704 Stick Welding Accessory Kit
- *More options at end of section*

Literature

E3.42

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Precision TIG® 275 Ready-Pak® w/Cart Pkg.	K2618-1	208/230/460/1/60	275A/31V/40% [rated @ 104°F (40°C)]	80/72/36A with PFC 104/94/47A w/o PFC	DC: 2-340A AC: 2-340A Max. OCV: 75V	49.7 x 28 x 41 (1262 x 711 x 1041)	641 (291)
Precision TIG® 275	K2619-1	208/230/460/1/60		80/72/36A with PFC 104/94/47A w/o PFC			
	K2619-2	460/575/1/60		35/28A with PFC 47/38A w/o PFC			
	K2620-1	220-230/380-400/ 415/1/50/60		80/46/43A with PFC 95/55/50A w/o PFC		31 x 22 x 26 (787 x 559 x 660)	397 (180)

Precision TIG® 375

Precision Arc—Maximum Control

The Precision TIG® 375 delivers full featured welding sequencing, pulsing controls and power factor correction for serious code-level TIG welders.

- **Patented Micro-Start™ II Technology** delivers extremely stable low amperage starting, welding and cratering for AC and DC welding.
- **AC Auto-Balance®** automatically sets the optimal cleaning vs. penetration levels for great looking aluminum welds.
- **Widest Output Range** in its class – 2-420 amps.
- **Highest duty cycle** – 375 amps @ 40%.
- **FREE! Built-in TIG pulser** helps control heat input in the weld to reduce distortion and burnthrough on thin materials.
- **Neat/organized cable management** with integrated torch holster.
- **Built-in storage compartment** with removable tray for torch consumables.
- **Fan-As-Needed™ (F.A.N.™)** prevents overheating. F.A.N.™ reduces power consumption, noise, motor wear and dust in the machine.
- **New set-up menu** gives more features.
- **Three-year warranty** on parts and labor.



Shown:
K2624-1 Water-Cooled Ready-Pak® w/Cart Pkg.

Processes

- Stick
- TIG

Output **Input**

Water-Cooled Ready-Pak® w/Cart Includes

- K2622-1 Precision TIG® 375
- Under-Cooler Cart
- Foot Amptrol®
- Gas Regulator/Flowmeter/Hose
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- Parts Kit
- Water Hose (2 included)
- 15 ft., (4.5m) 2/0 Work Cable/Clamp
- PTA-9 or -17 Torch Adapter

Key Options

- K963-1 Hand Amptrol®
- K704 Stick Welding Accessory Kit
- *More options at end of section*

Literature

E3.51

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Precision TIG® 375 Ready-Pak® w/Cart Pkg.	K2624-1	208/230/460/1/60	375A/35V/40% [rated @ 104°F (40°C)]	102/92/46A with PFC	DC: 2-420A AC: 2-420A Max. OCV: 80V	49.7 x 28 x 41 (1262 x 711 x 1041)	751 (340)
Precision TIG® 375	K2622-1	208/230/460/1/60		102/51/41A with PFC			
	K2622-2	230/460/575/1/60		119/69/63A with PFC			
	K2623-1	220-230/380-400/ 415/1/50/60				31 x 22 x 26 (787 x 559 x 660)	507 (230)

Invertec® V155-S

Portable. Professional. Rugged. Affordable.

The Invertec® V155-S offers much more than you would expect from a welder this size. It packs the full punch of a heavyweight professional that you can take to the most demanding job sites. It features 120/230V auto reconnect operation and can operate from a portable generator. It can also plug into a 200 ft. (61 m) 230V extension cord so you can weld just about anywhere. The Invertec® V155-S is available in two models: a base unit with stick accessories or a complete Stick/TIG ready to weld package in an Easy-Store/Easy-Carry Suitcase.

- **Touch Start TIG® DC operation** allows you to strike the arc easily without high frequency or tungsten contamination.
- **Dent resistant case** is IP23 rated for outdoor use.
- **Fan-As-Needed™ (F.A.N.™)** reduces noise and dust inside the machine.
- **Two stick modes**, SOFT and CRISP, provide the right arc characteristics for different types of electrodes.
- **Auto-Adaptive Arc Force™** minimizes electrode sticking in the puddle without compromising arc stability or increased spatter.
- **Automatic Hot-Start™** boosts the current during starting to make striking an arc easier.
- **Three-year warranty** on parts and labor.



Processes

- Stick
- TIG

Output **Input**

TIG Ready-Pak® Welding Package (K2606-1) Includes

- Invertec® V155-S (K2605-1)
- Stick electrode holder & cable, 10 ft. (3.0 m) with Twist-Mate™ plug
- Work clamp and cable, 10 ft. (3.0 m) with Twist-Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord [6.6 ft. (2 m)] with a 120V 15 Amp plug
- Extra 120V 20 Amp plug
- Gas Regulator
- PTA-17V TIG torch with Ultra-Flex™ cable and Twist-Mate™ dapter
- PTA-17 TIG Accessory Kit (KP508)
- Easy-Store/Easy-Carry Suitcase

Key Options

- K2275-1 Welding Cart
- K852-25 Twist-Mate™ Cable Plug Kit
- K1782-13 PTA-17FV Flex Head Gas Valve Torch
- K1781-7 PTA-9FV Flex Head Gas Valve Torch
- *More options at end of section*

Literature: E2.141

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Invertec® V155-S	K2606-1 and K2605-1	120V/1/50/60	75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG	24.0A 33.8A 21.5A 28.8A	5-155 Amps DC Max. OCV: 75V	11.3 x 6.2 x 15.4 (288 x 158 x 392)	14.7 (6.7)
		230V/1/50/60	75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG	21.0A 31.0A 14.1A 22.8A			

⁽¹⁾ Input amps on 60 Hz input.

Invertec® V160-T

Serious DC TIG Arc—Extremely Small Package

The Invertec® V160-T is a full function DC TIG inverter intended for alloy fabrication or critical maintenance work.

- **Advanced inverter technology** delivers superior TIG performance.
- **Selectable Touch Start TIG®** starting or **high frequency** starting makes it easy to establish an arc under a variety of conditions.
- **Built-in pulsing functions** give you greater control over thin materials.
- **Auto-reconnect** between 115/230V 50/60Hz input power eliminates operator error.
- **Auto restore fuse** protects the machine from high input currents.
- **Integral gas and power connector** for simple torch connections and quick changes between TIG and stick welding.
- **Three-year warranty** on parts and labor.



Processes

- Stick
- TIG

Output **Input**

Unit Includes

- 115V Input Cord (10 ft.) & Plug (NEMA 5-15P).
- 20 Amp Plug (NEMA 5-20P).
- Twist-Mate™ Torch Adapter for PTA-9 or -17 one-piece torch.
- Adjustable Shoulder Strap.
- Work Clamp & Cable.

Key Options

- TIG-Mate™ 17 Air-Cooled TIG Torch Starter Pack (K2266-1)
- Foot Amptrol® (K870)
- Hand Amptrol® (K963-3)
- Fume Extraction System
- *More options at end of section*

Literature
E3.105

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Invertec® V160-T	K1845-1	115/1/50/60 20A Branch Circuit	90A/13.6V/100% TIG 60A/22.4V/100% Stick	20A	5-160 Amps DC Max OCV: 48V	13 x 8 x 17 (330 x 203 x 432)	24 (10.8)
		115/1/50/60 30A Branch Circuit	110A/14.4V/100% TIG 80A/23.2V/100% Stick	25A			
		230/1/50/60 30A Branch Circuit	130A/15.2V/100% TIG 130A/25.2V/100% Stick	25A			

⁽¹⁾ Input amps on 60 Hz input.

Invertec® V205-T DC

Code Quality DC TIG Welding

The Invertec® V205-T DC is a compact, TIG power source intended for critical DC TIG welding. From maintenance to production fabrication, to motorsports, aerospace, nuclear piping, and shipbuilding, this feature-packed inverter is flexible enough for almost any job!

- **Stick Crisp Mode** for exceptional Fleetweld® 5P & 5P+ (E6010) Performance.
- **Improved TIG starting** – Starts DC(-) to maintain a sharp tungsten.
- **Adjustable DC strike mode** – Allows adjustment of a hotter or colder start depending on the tungsten diameter.
- **Voltage Reduction Device™ (VRD™)** – Reduces the open circuit voltage in STICK mode for use in electrically hazardous conditions or when the use of a VRD™ is required.
- **200 amps @ 40% duty cycle** – highest output rating in this machine class.
- **Fan-As-Needed™ (F.A.N.™)** – Fan only operates when needed to reduce power consumption, noise and dust in machine.
- **Three-year Lincoln Warranty** on parts and labor.



Shown: K2629-1 Invertec® V205-T DC

Processes

- Stick
- TIG

Output Input

One-Pak® Pkg. (K2671-1) Includes

- K2629-1 Invertec® V205-T DC
- K2266-1 TIG-Mate™ 17 air-cooled TIG Torch Starter Pack
- K870 Foot Amptrol®

Key Options

- K2413-1 TIG Mate™ 9 Air-Cooled TIG Torch Starter Pack
- K870 Foot Amptrol®
- K963-3 Hand Amptrol®
- *More options at end of section*

Literature

E3.110.1

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V205-T DC	K2629-1	115/1/50/60	150A/16.0V/40% TIG 120A/14.8V/60% TIG 100A/14.0V/100% TIG	34.0A 25.0A 20.0A	6-200A DC Max OCV: 53.7V	15.0 x 8.5 x 19.0 (381 x 216 x 483)	38 (17.3)
		230/1/50/60 ⁽²⁾	200A/18.0V/40% TIG 170A/16.0V/60% TIG 140A/15.6V/100% TIG	30.0A 18.0A 15.0A			
		115/1/50/60	110A/24.4V/35% Stick 90A/23.6V/60% Stick 70A/22.8V/100% Stick	34.0A 28.0A 20.0A			
		230/1/50/60 ⁽²⁾	180A/27.2V/35% Stick 150A/26.0V/60% Stick 130A/25.2V/100% Stick	30.0A 23.0A 19.0A			

⁽¹⁾ Input current on 60 hertz input.

⁽²⁾ Also operates on 208V input.

Invertec® V205-T AC/DC

Code Quality AC/DC TIG Welding

The Invertec® V205-T AC/DC is a compact, TIG power source intended for critical AC or DC TIG welding. The V205-T AC/DC has many new features!

- **Added Stick Crisp Mode** for exceptional Fleetweld® 5P & 5P+ (E6010) Performance.
- **Improved TIG starting** – Now starts DC (-) to maintain a sharp tungsten.
- **Adjustable DC strike mode** – Allows adjustment of a hotter or colder start depending on the tungsten diameter.
- **Voltage Reduction Device™ (VRD™)** – Reduces the open circuit voltage in STICK mode for use in electrically hazardous conditions or when the use of a VRD™ is required.
- **200 amps @ 40% duty cycle** is the highest output rating in this machine class.
- **Fan-As-Needed™ (F.A.N.™)** – Fan only operates when needed to reduce power consumption, noise and dust in machine.
- **Three-year Lincoln Warranty** on parts and labor.



Shown: K1855-4 Invertec® V205-T AC/DC

Processes

- Stick
- TIG

Output Input

One-Pak® Pkg. (K2350-2) Includes

- K1855-4 V205-T AC/DC
- 230V Input Cord & Plug
- Adjustable Shoulder Strap
- K870 Foot Amptrol®
- K2266-1 TIG Mate™ 17 TIG Torch Starter Kit

Key Options

- K2266-1 TIG Mate™ 17 Air-Cooled TIG Torch Starter Pack
- K870 Foot Amptrol®
- K963-3 Hand Amptrol®
- Fume Extraction System
- *More options at end of section*

Literature

E3.110

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V205-T AC/DC	K1855-4	115/1/50/60	150A/16.0V/40% TIG 120A/14.8V/60% TIG 100A/14.0V/100% TIG	34.0A 25.0A 20.0A	6-200A AC/DC Max OCV: 53.7V	15.0 x 8.5 x 19.0 (381 x 216 x 483)	38 (17.3)
		230/1/50/60 ⁽²⁾	200A/18.0V/40% TIG 170A/16.0V/60% TIG 140A/15.6V/100% TIG	30.0A 18.0A 15.0A			
		115/1/50/60	110A/24.4V/35% Stick 90A/23.6V/60% Stick 70A/22.8V/100% Stick	34.0A 28.0A 20.0A			
		230/1/50/60 ⁽²⁾	180A/27.2V/35% Stick 150A/26.0V/60% Stick 130A/25.2V/100% Stick	30.0A 23.0A 19.0A			

⁽¹⁾ Input current on 60 hertz input.

⁽²⁾ Also operates on 208V input.

Invertec® V310-T AC/DC

Customize the Arc with Dynamic Display™

The Invertec® V310-T AC/DC is the most technologically advanced AC/DC TIG welder in its class. It fits the bill for serious fabrication, maintenance, and production work, yet it's compact, lightweight size makes it ideal for field applications like advanced motorsports, aerospace, shipbuilding, and construction.

- **LCD Dynamic Display™ (patent pending)** – Shows the effect of adjusting the various welding parameters making setup simple.
- **Adjustable AC Frequency and Selectable Waveshapes** – Allows you to customize the arc.
- **Soft, Crisp and AC Stick Modes** – Excellent welding performance with all electrodes, even E6010!
- **Optional Cool Arc® 35 "Smart" Water Cooler** – Digitally controls the speed of the water cooler's 3-phase pump motor based on coolant temperature for quiet operation and long dependable life. Powered directly by the Invertec® V310-T AC/DC.
- **208-460 1/3 Phase Auto-Reconnect** – Weld just about anywhere with minimal set up.
- **High Efficiency Inverter** – Yields extremely low input currents.
- **Three-year Lincoln Warranty** on parts and labor.



Shown:
K2228-1 Invertec® V310-T AC/DC
with K2630-1 Cool Arc® 35 Water Cooler

Processes

- Stick
- TIG

Output Input

One-Pak® Pkg. (K2695-1) Includes

- K2228-1 Invertec® V310-T AC/DC
- K2630-1 Cool Arc® 35 Water Cooler
- K2694-1 Inverter Cart
- K2267-1 TIG Mate™ 20 Torch Kit
- K870 Foot Amptrol®

Key Options

- K2630-1 Cool Arc® 35 Water Cooler
- K2694-1 Inverter Cart
- K2666-1 TIG Mate™ 17 Air Cooled TIG Torch Starter Pack
- K870 Foot Amptrol®
- K963-3 Hand Amptrol®
- *More options at end of section*

Literature

E3.115

Product Name	Product Number	Input Power Phase	Input Power Voltage/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V310-T AC/DC	K2228-1	3-Phase	460/50/60	210A/18.4V/100% 230A/19.2V/60% 310A/22.4V/40%	7.3 A 8.3 A 12.3 A	5-310A Max. OCV: 80V	17.3 x 10.6 x 24 (439 x 269 x 609)	75 (34)
			230/50/60	210A/18.4V/100% 230A/19.2V/60% 310A/22.4V/30%	13.9 A 15.8 A 24.6 A			
		1-Phase	460/50/60	200A/18.0V/100% 220A/18.8V/60% 310A/22.4V/35%	13.6 A 14.9 A 23.1 A			
			230/50/60	200A/18.0V/100% 220A/18.8V/60% 310A/22.4V/25%	21.9 A 24.6 A 41.5 A			
			208/50/60	200A/18.0V/100% 220A/18.8V/60%	24.2 A 27.7 A			
				310A/22.4V/25%	47.3 A			

⁽¹⁾ Input current on 60 hertz input.

I CHOOSE LINCOLN.™

LINCOLN ELECTRIC
The Official Welder of
EDWARDS

FOOSE

Chip Foose

CHIP FOOSE –
World-renowned automotive designer, builder and welder.

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TIG Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Precision TIG® 225

General Options

K2348-1	Understorage Cart
K2617-1	Dual Cylinder Cart
K2616-1	Small Wire Feeder Welder Mounting Bracket
K2378-1	Medium Canvas Cover
—	Fume Extraction System

Stick Options

K2374-1	Stick Electrode Holder and Cable
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TIG Options

K2266-1	TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
K2267-1	TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)
K2413-1	TIG-Mate™ 9 TIG Torch Starter Kit (air-cooled)
K1781-9	PTA-9F Flexible Head w/Ultra-Flex™ Cable Torch Package (12.5 ft., 1pc)
K1783-12	PTA-26 TIG Torch Package w/Ultra-Flex™ Cable (12.5 ft., 1pc)
KP2414-1	PTA-9/PTW-20 Gas Lens Parts Kit
KP508	Parts Kit For PTA-17 Series Torches
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
—	Cut Length Consumables

Precision TIG® 275

General Options

K2621-1	Advanced Control Panel
K1869-1	Undercarriage
K2150-1	Work Clamp and Cable Assembly
K1831-1	Power Factor Capacitor Kit
—	Fume Extraction System

Stick Options

K875	Accessory Kit, 150 Amp
K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)

TIG Options

—	Pro-Torch™ Air and Water-Cooled TIG Torches
K2166-3	PTA-9, -17 One Cable Torch Adapter
K2166-2	PTA-9, -17, -26 Two Cable Torch Adapter
K2166-1	PTA-26 One Cable Torch Adapter
K1828-1	Under-Cooler Cart Water Cooler
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
—	Cut Length Consumables

Precision TIG® 375

General Options

K1869-1	Undercarriage
K2150-1	Work Clamp and Cable Assembly
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)

TIG Options

—	Pro-Torch™ Air and Water-Cooled TIG Torches
K2166-3	PTA-9, -17 One Cable Torch Adapter
K2166-2	PTA-9, -17, -26 Two Cable Torch Adapter
K2166-1	PTA-26 One Cable Torch Adapter
K1828-1	Under-Cooler Cart Water Cooler
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
—	Cut Length Consumables

Invertec® V155-S

General Options

K2275-1	Welding Cart (80 cu ft bottle capacity)
K852-25	Twist-Mate™ Cable Plug Kit
—	Fume Extraction System

TIG Options

K1781-7	PTA-9FV Flexible Head Gas Valve Torch (25 ft., 1 pc.)
K960-2	Small Twist-Mate™ Torch Adapter (with separate gas)
KP507	Parts Kit for PTA-9 Series Torches
K1782-13	PTA-17FV Flex Head Gas Valve TIG Torch w/Ultra-Flex™ Cable (12.5 ft., 1 pc.)
K960-2	Small Twist-Mate™ Torch Adapter (with separate gas)
KP508	Parts Kit for PTA-17 Series Torches
K586-1	Deluxe Adjustable Gas Regulator and Gas Hose Kit

Invertec® V160-T

General Options

K2275-1	Welding Cart (80 cu ft. bottle capacity)
K520	Utility Cart (150 cu ft. bottle capacity)
K2377-1	Small Canvas Cover
—	Fume Extraction System

Stick Options

K2394-1	Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set
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TIG Options

K2413-1	TIG-Mate™ 9 TIG Torch Starter Kit (air-cooled)
K2266-1	TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
K2267-1	TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
—	Cut Length Consumables

TIG Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Invertec® V205-T AC/DC*General Options*

K2275-1	Welding Cart (80 cu ft. bottle capacity)
K520	Utility Cart (150 cu ft. bottle capacity)
K2377-1	Small Canvas Cover
—	Fume Extraction System

Stick Options

K2394-1	Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set
---------	---

TIG Options

K2413-1	TIG-Mate™ 9 TIG Torch Starter Kit (air-cooled)
K2266-1	TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
K2267-1	TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
K1781-1	PTA-9 TIG Torch (12.5 ft., 1 pc.)
K1622-1	Twist-Mate™ Torch Adapter, PTA-9, -17
K1783-1	PTA-26 TIG Torch (12.5 ft., 1 pc.)
K1622-3	Twist-Mate™ Torch Adapter, PTA-26
K1784-3	PTW-20 Braided TIG Torch (12.5 ft., 3 pc.)
K1622-4	Twist-Mate™ Torch Adapter, Water-Cooled
K1859-2	Water Hose Kit, 25 ft. (5/8 LH CGA to 5/8 LH CGA)
—	Cut Length Consumables

Invertec® V205-T DC*General Options*

K2275-1	Welding Cart (80 cu ft. bottle capacity)
K520	Utility Cart (150 cu ft. bottle capacity)
K2377-1	Small Canvas Cover
—	Fume Extraction System

Stick Options

K2394-1	Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set
---------	---

TIG Options

K2413-1	TIG-Mate™ 9 TIG Torch Starter Kit (air-cooled)
K2266-1	TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
K2267-1	TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
K1859-2	Water Hose Kit - 25 ft (5/8 LH CGA to 5/8 LH CGA)
K1781-1	PTA-9 TIG Torch (12.5ft 1pc)
K1622-1	Twist-Mate™ Torch Adapter - PTA-9, -17
K1782-1	PTA-17 TIG Torch (12.5ft 1pc)
K1622-1	Twist-Mate™ Torch Adapter - PTA-9, -17
K1783-1	PTA-26 TIG Torch (12.5ft 1pc)
K1622-3	Twist-Mate™ Torch Adapter - PTA-26
K1784-3	PTW-20 Braided TIG Torch (12.5ft 3pc)
K1622-4	Twist-Mate™ Torch Adapter - Water-Cooled
—	Cut Length Consumables

Invertec® V310-T AC/DC*General Options*

K2694-1	Inverter Cart
—	Fume Extraction System

Stick Options

K2394-1	Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set
---------	---

TIG Options

K2413-1	TIG-Mate™ 9 TIG Torch Starter Kit (air-cooled)
K2266-1	TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
K2267-1	TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)
3100211	Harris® Argon Flowmeter Regulator and Hose Kit
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch
K2630-1	Cool Arc® 35 Water Cooler
K1781-1	PTA-9 TIG Torch (12.5 ft., 1 pc.)
K1622-1	Twist-Mate™ Torch Adapter, PTA-9, -17
K1783-1	PTA-26 TIG Torch (12.5 ft., 1 pc.)
K1622-3	Twist-Mate™ Torch Adapter, PTA-26
K1784-3	PTW-20 Braided TIG Torch (12.5 ft., 3 pc.)
K1622-4	Twist-Mate™ Torch Adapter, Water-Cooled
—	Cut Length Consumables

MIG WIRE FEEDER / WELDERS



Jessi Combs – TV Host and Welder

POWER MIG® – The Professional's Choice!™

- Typical applications include – home, farm, autobody, maintenance or fabrication.
- Diamond Core® Technology delivers a superior arc.
- Professional Drive System.
- Spool Gun Ready.



- Great Arc Starts
- Low Spatter
- Excellent Out-of-Position Arc Action
- Enhanced Performance Stainless & Aluminum

	MODEL	OUTPUT				PROCESS					INPUT	FEATURES								
		Current Range (Amps)	Wire Feed Speed Range ipm (m/min)	Solid Wire Size Range in. (mm)	Cored Wire Size Range in. (mm)	MIG	MIG Pulsed	Flux-Cored	Stick	TIG Touch-Start®		Phase	Hertz	Compact	Spool Gun Capable	Locking Tool Storage	Meters	Synergic Control	Push-Pull Model	Diamond Core® Technology
120 Volt Input	SP-140T	30-140	50-500 (1.3-12.7)	.023-.035 (0.6-0.9)	.035 (0.9)	●	●				1	60	●	●						
	POWER MIG® 140C	30-140	50-500 (1.3-12.7)	.023-.035 (0.6-0.9)	.035 (0.9)	●	●				1	60	●	●					●	
208-230 Volt Input	SP-180T	30-180	50-500 (1.3-12.7)	.023-.035 (0.6-0.9)	.035-.045 (0.9-1.2)	●	●				1	60	●	●						
	POWER MIG® 180C	30-180	50-500 (1.3-12.7)	.023-.035 (0.6-0.9)	.035-.045 (0.9-1.2)	●	●				1	60	●	●					●	
	POWER MIG® 215XT	30-250	50-700 (1.3-17.7)	.023-.045 (0.6-1.2)	.035-.045 (0.9-1.2)	●	●				1	50/60	●	●					●	
	POWER MIG® 255XT	30-300	50-700 (1.3-17.7)	.023-.035 (0.6-0.9)	.035-.045 (0.9-1.2)	●	●				1	60	●	●	●				●	
	POWER MIG® 350MP	5-350	50-700 (1.3-17.7)	.023-.045 (0.6-1.2)	.035-.045 (0.9-1.2)	●	●	●	●	●	1	50/60	●	●	●	●	●	●	●	●

KEY: ● Excellent ● Good ● Optional

SP-140T

120 Volt AC Input Compact Wire Welder

Here's a great little welder for project and repair MIG welding on mild or stainless steel and flux-cored welding on mild steel.

- **Ready to Weld!** Includes mild steel MIG and flux-cored wire spools, regulator and basic handshield. Just add shielding gas (sold separately).
- **Easy to Set** – 5 position tap voltage control and continuous full-range wire feed speed control help you dial in your application.
- **Wide 30-140 amp welding output range.**
- **MIG weld 24 gauge up to 10 gauge (.135")** sheet metal in a single pass. Weld up to 5/16 in. steel using self-shielded Innershield® wire (FCAW-S).
- **Spool Gun Ready** – add the optional Magnum® 100SG spool gun for reliable aluminum wire feeding.
- **Three-year warranty** on parts and labor.



Processes

- MIG
- Flux-Cored

Output **Input**

Unit Includes

- Magnum® 100L gun 10 ft. (3.0 m)
- .025" (0.6 mm) Contact Tips (Qty. 3)
- .035" (0.9 mm) Contact Tips (Qty. 3)
- Gasless Nozzle for Innershield®
- Gas Nozzle for MIG
- Spindle Adapter, 8" (203 mm) Dia. Spools
- .025"-.030" (0.6-0.7 mm) MIG Drive Roll
- .035" (0.9 mm) MIG Drive Roll
- .030"-.045" (0.7-1.1 mm) Knurled Drive Roll
- Adjustable Gas Regulator & Hose
- 2 lb. (0.90 kg) Spool of SuperArc® L-56® MIG wire
- 1 lb. (0.45 kg) Spool NR®-211-MP
- Work Clamp & 10 ft. (3.0 m) Cable
- Handshield
- How to Use DVD

Key Options

- K2532-1 Magnum® 100SG Spool Gun
- *More options at end of section*

Literature

E7.62

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
SP-140T (Tapped Voltage Control)	K2688-1	120/1/60	90A/19.5V/20%	20A	30-140 Amps DC 50-500 ipm WFS (1.3-12.7 m/min) Max. OCV: 33	14 x 10.15 x 18.6 (357 x 258 x 472)	58 (26.3)

SP-180T

More Power for Thicker Material

Just plug this compact wire welder into a 208 or 230V outlet in your garage, barn or shop and start welding— up to 3/16" MIG wire welding and 1/2" with self-shielded flux-cored wire.

- **Ready to Weld!** Includes both mild steel MIG and flux-cored wire as well as an adjustable gas regulator. Just add shielding gas (sold separately).
- **Easy to Set** – 5 position tap voltage control and continuous full-range wire feed speed control help you dial in your application.
- **Wide 30-180 amp welding output range** – use .025" wire on thin sheet metal up to .045" flux-cored wire on thick plate.
- **MIG weld 24 gauge up to 3/16" sheet metal** in a single pass. Weld up to 1/2" steel using self-shielded Innershield® wire (FCAW-S).
- **Spool Gun Ready** – add the optional Magnum® 100SG spool gun for reliable aluminum wire feeding.
- **Three-year warranty** on parts and labor.



Processes

- MIG
- Flux-Cored

Output **Input**

Unit Includes

- Magnum® 100L gun 10 ft. (3.0 m)
- .025" (0.6 mm) Contact Tips (Qty. 3)
- .035" (0.9 mm) Contact Tips (Qty. 3)
- Gasless Nozzle for Innershield®
- Gas Nozzle for Innershield®
- Spindle Adapter, 8" (203 mm) Dia. Spools
- .025"-.030" (0.6-0.7 mm) MIG Drive Roll
- .035" (0.9 mm) MIG Drive Roll
- .030"-.045" (0.7-1.1 mm) Knurled Drive Roll
- Adjustable Gas Regulator & Hose
- 2 lb. (0.90 kg) Spool of SuperArc® L-56® MIG wire
- 1 lb. (0.45 kg) Spool NR®-211-MP
- Work Clamp & 10 ft. (3.0 m) Cable
- Handshield
- How to Use DVD

Key Options

- K2532-1 Magnum® 100SG Spool Gun
- *More options at end of section*

Literature

E7.63

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
SP-180T (Tapped Voltage Control)	K2689-1	208/230/1/60	208V: 130A/17V/30% 230V: 130A/20V/30%	20A	30-180 Amps DC 50-500 ipm WFS (1.3-12.7 m/min) Max. OCV: 33V	14 x 10.15 x 18.6 (357 x 258 x 472)	66 (30)

POWER MIG® 140C



Premium 120 Volt Input Wire Welder with Continuous Control

Home projects and repair, sheet metal and autobody work, farm and small shop welding—the POWER MIG® 140C designed for 120 volt household power does it all!

• **Exclusive Diamond Core® Technology** delivers an outstanding arc you'll notice immediately:

- Great arc starts.
- Wide voltage "sweet spot" gives you a very forgiving arc.

• **Wide 30-140 amp welding output range** is the highest output in the 120 volt input power welder class.

• **MIG weld 24 gauge up to 10 gauge (.135") sheet metal** in a single pass. Weld up to 5/16" steel using self-shielded Innershield® wires (FCAW-S).

• **Spool Gun Ready** – add the optional Magnum® 100SG spool gun for reliable aluminum wire feeding.

• **Three-year warranty** on parts and labor.

Spool Gun Ready



Light Duty



Shown:
K2471-1 POWER MIG® 140C

Processes

- MIG
- Flux-Cored

Output Input Hz

Unit Includes

- Magnum® 100L Gun, 10 ft. (3.0 m)
- Gas and Gasless Nozzles
- Cable Liner
- Contact Tips
- Work Cable and Clamp
- Adjustable Gas Regulator & Hose
- Spindle Adapter
- 2 lb. (0.90 kg) Spool of SuperArc® L-56® Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool NR®-211-MP Flux-Cored Wire
- Learn-To-Use DVD

Key Options

- K520 Utility Cart, 150 cu ft. bottle capacity
- K2377-1 Small Canvas Cover
- K2525-1 Spot Timer Kit
- K2532-1 Magnum® 100SG Spool Gun
- *More options at end of section*

Literature

E7.23

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
POWER MIG® 140C (Continuous Voltage Control)	K2471-1	120/1/60	90A/19.5V/20%	20A	30-140 Amps DC 50-500 ipm WFS (1.3-12.7 m/min) Max. OCV: 33V	14 x 10.15 x 18.6 (357 x 258 x 472)	58 (26.3)

POWER MIG® 180C



Premium 230 Volt Compact Wire Welder with Continuous Control

Whether you're a farmer or a fabricator, an autobody shop or a backyard mechanic, the POWER MIG® 180C helps you get the job done! It's a portable wire welder designed for use with industrial 230 volt input power.

• **Exclusive Diamond Core® Technology** delivers an outstanding arc you'll notice immediately:

- Great arc starts.
- Wide voltage "sweet spot" gives you a very forgiving arc.

• **Wide 30-180 amp welding output range** is the highest output in this welder class.

• **MIG weld 24 gauge up to 3/16" sheet metal** in a single pass. Weld up to 1/2" steel using self-shielded Innershield® wires (FCAW-S).

• **Spool Gun Ready** – add the optional Magnum® 100SG spool gun for reliable aluminum wire feeding.

• **Three-year warranty** on parts and labor.

Spool Gun Ready



Light Duty



Shown:
K2473-1 POWER MIG® 180C

Processes

- MIG
- Flux-Cored

Output Input Hz

Unit Includes

- Magnum® 100L Gun, 10 ft. (3.0 m)
- Gas and Gasless Nozzles
- Cable Liner
- Contact Tips
- Work Cable and Clamp
- Adjustable Gas Regulator & Hose
- Spindle Adapter
- 2 lb. (0.90 kg) Spool of SuperArc® L-56® Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool NR®-211-MP Flux-Cored Wire
- Learn-To-Use DVD

Key Options

- K520 Utility Cart, 150 cu ft. bottle capacity
- K2377-1 Small Canvas Cover
- K2525-1 Spot Timer Kit
- K2532-1 Magnum® 100SG Spool Gun
- *More options at end of section*

Literature

E7.24

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
POWER MIG® 180C (Continuous Voltage Control)	K2473-1	208/230/1/60	208V: 130A/17V/30% 230V: 130A/20V/30%	20A	30-180 Amps DC 50-500 ipm WFS (1.3-12.7 m/min) Max. OCV: 33V	14 x 10.15 x 18.6 (357 x 258 x 472)	66 (30)

POWER MIG® 215XT

Simple Control for Sheet Metal Welding

The POWER MIG® 215XT offers the autobody and sheet metal fabrication industries top welding performance and a host of professional features not often found at this price.

- **More Output**—rated at 215 amps/22 volts @ 30% duty cycle, with an amperage range of 30-250 amps DC – the highest rating and widest amperage range in its class.
- **Seven tapped voltage ranges** make it easy to select the right procedure for your application.
- **115 volt auxiliary power receptacle** for grinders and tool chargers.
- **Spool Gun Ready** – Add the optional Magnum® 100SG spool gun for reliable aluminum wire feeding.
- **Three-year warranty** on parts and labor. (90 days on gun.)

Spool Gun Ready



Light Duty

Spool Gun Capable



Medium Duty



Heavy Duty



Shown:
K2700-1 POWER MIG® 215XT



Processes

- MIG
- Flux-Cored

Output Input

Unit Includes

- Magnum® 250L Gun, 15 ft. (4.5 m)
- Work Cable and Clamp
- Contact Tips
- Cable Liner
- Drive Rolls
- Adjustable Gas Regulator & Hose

Key Options

- K2590-1 Magnum® 250 LX Spool Gun
- K2532-1 Magnum® 100SG Spool Gun
- K487-25 Magnum® SG Spool Gun
- K2703-1 Spool Gun Adapter (for K487-25 Magnum® SG and K2490-1 Magnum® 250LX Spool Guns)
- K2378-1 Medium Canvas Cover
- More options at end of section

Literature

E7.51

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
POWER MIG® 215XT	K2700-1	208/230/1/50/60	215A/22V ⁽¹⁾ /30% 190A/23V/40% 170A/24V/60%	45/41A 42/38A 39/35A	30-250 Amps DC 50-700 ipm WFS (1.3 -17.7 m/min) Max. OCV: 39V	31.8 x 18.9 x 38.8 (808 x 408 x 985)	198 (90)

⁽¹⁾ 21V on 220V 50 Hz input.

POWER MIG® 255XT

The Professional's Choice!™ for Job Shop Fabrication



The POWER MIG® 255XT sets the standard for MIG and flux-cored welding in industrial production, job shop fabrication, maintenance or repair work.

- **Timer Functions** – Adds 4-step interlock, spot mode, adjustable run-in speed for smoother arc starting and adjustable burn-back timer.
- **Digital meters display** – Preset wire feed speed and voltage, and actual amperage and voltage while welding.
- **Spool Gun Ready** – Electronics and second gas solenoid are built-in to drive either the Magnum® SG or Magnum® 250LX™ spool gun.
- **115V auxiliary receptacle** (208/230V model only) powers a grinder or other equipment.
- **Three-year warranty** on parts and labor. (90 days on gun.)

Spool Gun Capable



Medium Duty



Heavy Duty



Shown:
K2701-1 POWER MIG® 255XT

Processes

- MIG
- Flux-Cored

Output Input

One-Pak® Spool Gun Pkg. Includes

- POWER MIG® 255XT (K2701-1)
- Magnum® 250XL Spool Gun
- Spool Gun Holder
- Dual Cylinder Mounting Kit
- Adjustable Gas Regulator & Hose Kit

Unit Includes

- Magnum® 250L Gun
- Work Clamp and Cable, 10 ft. (3.0 m)
- 230V Input Power Cable w/Plug (208/230V model only)
- Drive Rolls & Guide for Steel
- Adjustable Gas Regulator & Hose

Key Options

- K1702-1 Dual Cylinder Kit
- K2378-1 Medium Canvas Cover
- K2490-1 Magnum® 250LX™ Spool Gun
- K487-25 Magnum® SG Spool Gun
- K2445-1 Power MIG SG Spool Gun Control Cable Adapter
- More options at end of section

Literature

E7.54

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
POWER MIG® 255XT	K2702-1	208/230/1/60	250A/26V/40%	56/52A	30-300 Amps 50-700 ipm WFS (1.3 -17.7 m/min) Max. OCV: 40V	—	—
One-Pak® w/Spool Gun	K2701-1	208/230/1/60		56/52A		31.8 x 18.9 x 38.8 (808 x 480 x 985)	240 (109) (with gun)
POWER MIG® 255XT	K2701-2	230/460/575/1/60		50/24/19A			

⁽¹⁾ Input current is at the rated output with the 115V auxiliary receptacle also drawing 15 amps.

POWER MIG® 350MP

The Professional's Choice!™



Processes

- Stick
- TIG
- MIG
- Pulsed
- Flux-Cored

Output **DC** **Input** **60 Hz**

Push-Pull One-Pak® Includes

- POWER MIG® 350MP (K2403-1)
- Python®-Plus Push-Pull Gun, 25 ft. (7.6 m)
- 3/64" Aluminum Drive Roll Kit
- Magnum® 300 Gun, 15 ft. (4.5m)
- Cable Liner
- Contact Tips
- Work Clamp and Cable
- Adjustable Gas Regulator & Hose

Unit Includes

- POWER MIG® 350MP
- Magnum® 300 Gun
- Work Clamp and Cable
- 230V Input Power Cable w/Plug (208/230V model only)
- Drive Rolls & Guide for Steel
- Adjustable Gas Regulator & Hose

Key Options

- K1702-1 Dual Cylinder Kit
- K2378-1 Medium Canvas Cover
- K2447-2 Python®-Plus Push-Pull Gun, 25 ft. (7.6 m)
- K2490-1 Magnum® 250LX Spool Gun
- *More options at end of section*

Literature
E7.57

When you want more than just a MIG machine, the POWER MIG® 350MP is the choice for you. Lincoln's Chopper Technology® delivers more welding processes: Stick, TIG, MIG, Flux-cored, and Advanced Processes such as Power Mode® and Pulse-On-Pulse®.

- **Pulse-on-Pulse®** – Improves cleaning action when welding aluminum and delivers a TIG-like appearance to the MIG weld beads.
- **Synergic control** of voltage and wire feed speed allows you to set weld procedures with one control.
- **Push-Pull or Spool Gun Ready** – A second gas solenoid and other electronics are built-in to drive either a spool gun or push-pull gun.
- **115V auxiliary receptacle** – Powers a grinder or other equipment.
- **Dual Procedure capable** – Select between either two welding procedures or two welding modes.
- **Three-year warranty** on parts and labor. (90 days on gun.)



Shown: K2403-1 POWER MIG® 350MP

Spool Gun Ready



Heavy Duty

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
POWER MIG® 350MP Push-Pull One-Pak®	K2451-2	208/230/460/575/1/50/60	300A/32V/60% ⁽¹⁾	72/62/31/25A	5-350 Amps DC 50-700 ipm WFS (1.3 -17.7 m/min) Max. OCV: 67V	—	—
POWER MIG® 350MP	K2403-1					31.8 x 18.9 x 38.8 (808 x 408 x 985)	255 (116)

⁽¹⁾ 40% on 208V input. Ratings based on 60 Hz operation.

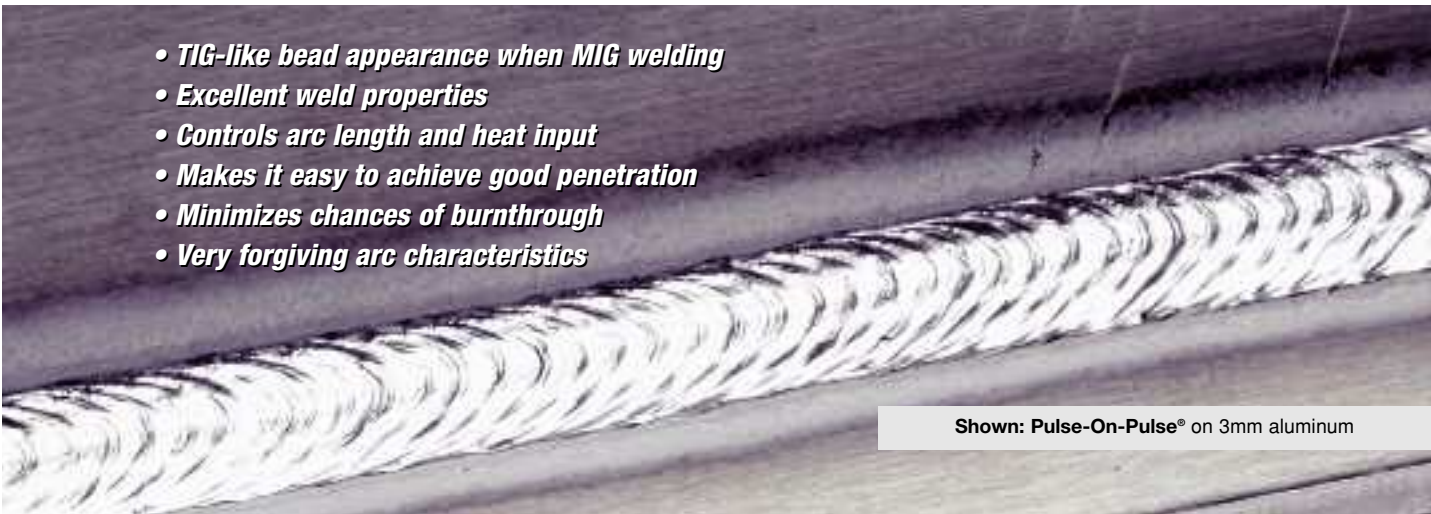
Take advantage of the advanced welding features of the POWER MIG® 350MP.



WAVEFORM CONTROL TECHNOLOGY®

Pulse-On-Pulse® takes the hassle out of aluminum welding

- TIG-like bead appearance when MIG welding
- Excellent weld properties
- Controls arc length and heat input
- Makes it easy to achieve good penetration
- Minimizes chances of burnthrough
- Very forgiving arc characteristics



Shown: Pulse-On-Pulse® on 3mm aluminum

MIG: Wire Feeder/Welders Options

See "Recommended General Options" pgs. 151-171 for descriptions.

SP-140T and SP-180T*General Options*

K2275-1	Welding Cart (80 cu. ft. bottle capacity)
K520	Utility Cart (150 cu. ft. bottle capacity)
K2377-1	Small Canvas Cover
K2525-1	Spot Timer Kit
—	Fume Extraction System

Wire Feeder Options

K2532-1	Magnum® 100SG Spool Gun
K2528-1	.045" Innershield® Welding Kit (POWER MIG® 180T only)
KP2529-1	Drive Roll, .025"-.030" Smooth
KP2529-2	Drive Roll, .035" Smooth
KP2529-3	Drive Roll, .030"-.045" Knurled

POWER MIG® 140C and POWER MIG® 180C*General Options*

K2275-1	Welding Cart (80 cu. ft. bottle capacity)
K520	Utility Cart (150 cu. ft. bottle capacity)
K2377-1	Small Canvas Cover
K2525-1	Spot Timer Kit
—	Fume Extraction System

Wire Feeder Options

K2532-1	Magnum® 100SG Spool Gun
K2528-1	.045" Innershield® Welding Kit (POWER MIG® 180C only)
KP2529-1	Drive Roll, .025"-.030" Smooth
KP2529-2	Drive Roll, .035" Smooth
KP2529-3	Drive Roll, .030"-.045" Knurled
KP2531-1	Inner Wire Guide, .025"-.035" Steel
KP2531-2	Inner Wire Guide, .045" Steel

POWER MIG® 215XT*General Options*

K2532-1	Magnum® 100SG Spool Gun
K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft
K2490-1	Magnum® 250LX Spool Gun
K2378-1	Medium Canvas Cover
K466-6	Connector Kit – POWER MIG®/Wire-Matic™
K2703-1	Adapter Kit for Magnum® SG or Magnum® 250LX Spool Gun
K1703-1	3/64" Aluminum Feeding Kit
K468	8" O.D. Spool Adapter
K1702-1	Dual Cylinder Mounting Kit
KP1696-030S	Drive Roll Kit, .023"-.030" Solid Wire
KP1696-035S	Drive Roll Kit, .035" Solid Wire
KP1696-1	Drive Roll Kit, .035" and .045" Solid Wire
KP1696-2	Drive Roll Kit, .040" Solid Wire
KP1696-045S	Drive Roll Kit, .045" Solid Wire
KP1697-035C	Drive Roll Kit, .030"-.035" Cored Wire
KP1697-045C	Drive Roll Kit, .040"-.045" Cored Wire
KP1695-3/64A	Drive Roll Kit, 3/64" Aluminum Wire
—	Fume Extraction System

POWER MIG® 255XT*General Options*

K1702-1	Dual Cylinder Mounting Kit
K1703-1	3/64" Aluminum Feeding Kit
K2378-1	Medium Canvas Cover
K466-6	Connector Kit – POWER MIG®/Wire-Matic™
K468	8" O.D. Spool Adapter
KP1696-030S	Drive Roll Kit, .023"-.030" Solid Wire
KP1696-035S	Drive Roll Kit, .035" Solid Wire
KP1696-1	Drive Roll Kit, .035" and .045" Solid Wire
KP1696-2	Drive Roll Kit, .040" Solid Wire

*POWER MIG® 255XT, con't.**General Options, con't.*

KP1696-045S	Drive Roll Kit, .045" Solid Wire
KP1697-035C	Drive Roll Kit, .030"-.035" Cored Wire
KP1697-045C	Drive Roll Kit, .040"-.045" Cored Wire
KP1695-3/64A	Drive Roll Kit, 3/64" Aluminum Wire
—	Fume Extraction System

Spool Gun Options

K2490-1	Magnum® 250LX Spool Gun
K2519-1	Control Cable Extension, 25 ft
K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft.
K2445-1	POWER MIG® 255XT/Magnum® SG Spool Gun Control Cable Adapter
K1738-1	Spool Gun Holder

POWER MIG® 350MP*General Options*

KP1696-030S	Drive Roll Kit, .023"-.030" Solid Wire
KP1696-035S	Drive Roll Kit, .035" Solid Wire
KP1696-1	Drive Roll Kit, .035" and .045" Solid Wire
KP1696-2	Drive Roll Kit, .040" Solid Wire
KP1696-045S	Drive Roll Kit, .045" Solid Wire
KP1697-035C	Drive Roll Kit, .030"-.035" Cored Wire
KP1697-045C	Drive Roll Kit, .040"-.045" Cored Wire
KP1695-035A	Drive Roll Kit, .035" Aluminum Wire
KP1695-3/64A	Drive Roll Kit, 3/64" Aluminum Wire
K1702-1	Dual Cylinder Mounting Kit
K2378-1	Medium Canvas Cover
—	Fume Extraction System

Stick Options

K875	Accessory Kit, 150 Amp
K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)

TIG Options

—	Pro-Torch™ TIG Torches
KP508	Parts Kit For PTA-17 Series Torches
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K814	Arc Start™ Switch

Wire Feeder Options

K489-8	Fast-Mate™ Adapter For POWER MIGs
K2447-1	Python®-Plus Push-Pull Gun, Air-Cooled, 15 ft.
K2447-2	Python®-Plus Push-Pull Gun, Air-Cooled, 25 ft.
K2447-3	Python®-Plus Push-Pull Gun, Air-Cooled, 50 ft.
K2296-2	Prince® XL Push-Pull Gun, Air-Cooled, 25 ft.
K2154-1	Push-Pull Gun Connection Kit
K468	8" O.D. Spool Adapter

Spool Gun Options

K2490-1	Magnum® 250LX Spool Gun
K2519-1	Control Cable Extension, 25 ft.
K1738-1	Spool Gun Holder

MIG: INDUSTRIAL WELDERS

- Recommended for industrial job shops and manufacturing applications.
- Optimized for CV processes.
- Designed for use with a variety of wire feeders.
- 100% Duty Cycle.



Scott Webster – Leroy Thompson Handcrafted Customs

MODEL	OUTPUT		Current Range Amps (A)	PROCESS				INPUT		FEATURES	
	Mode	Polarity		MIG	Flux-Cored	Submerged Arc	Arc Gouging	Phase	Hertz	Stackable	7-Yr. Warranty (on Power Rectifier)
CV-305	CV	DC	50-400 A	●	●			3	60	●	●
CV-400	CV	DC	60-500 A	●	●		●	3	60	●	●
CV-655	CV	DC	70-815 A	●	●	◐	●	3	50,60	●	●

KEY: ● Excellent ◐ Good ● Optional

CV-305

For All Day Long MIG Welding

When it comes to welding mild steel, stainless steel, aluminum and alloy materials, you won't find a more reliable power source than the CV-305.

- **Digital Ammeter/Voltmeter read-out** display allows you to view voltage presets for added convenience and accuracy.
- **Easy access Twist-Mate™ connections** on the front of the machine.
- **Two output connectors** allow you to optimally connect to high or low inductance for arc control. Use low inductance output connection when short-arc welding, and high inductance output connection with spray and globular transfer welding.
- **Stack them three-high** or purchase an affordable Ready-Pak® package that includes the LF-72 wire feeder, a Magnum® 400 MIG gun and more!
- **Compact unit is 20 lbs. (9.0 kg) lighter and significantly smaller** than competitive models—save your space!
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K2400-1 CV-305

Processes

- MIG
- Flux-Cored

Output Input

Ready-Pak® Package (K2395-1) Includes

- CV-305 Power Source
- LF-72 Bench Model (2-Roll) Wire Feeder w/Standard Duty Wire Reel Stand, 10 ft. Control Cable, and .035"-.045" solid Drive Roll & Guide Tube Kits
- Magnum® 400 Welding Gun, 15 ft. .035"-.045" wire
- Work and Wire Feeder Power Cables Package
- Harris® Flowmeter Regulator & Gas Hose

Key Options

- K857 Remote Output Control
- K857-1 Remote Output Control
- K852-70 Twist-Mate™ Welding Cable Connectors
- K852-95 Twist-Mate™ Welding Cable Connectors
- *More options at end of section*

Literature

E4.22

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
CV-305	K2400-1	208/230/460/3/60	315A/32.6V/100%	52/48/24A	50-400A 7-37V	24.6 x 19.5 x 27.0 (625 x 495 x 686)	330 (149)
	K2400-2	230/460/575/3/60		48/24/19A			
CV-305/LF-72 Ready-Pak® Pkg.	K2395-1	208/230/460/3/60		52/48/24A		47.7 x 25.5 x 33.0 (1212 x 648 x 838)	448 (203)

NOTE: 50 Hertz models available.

CV-400

Rugged, Proven Construction for Wire Welding

The rugged CV-400 is ready to tackle MIG and flux-cored wire welding for fabrication and production work in a variety of industries: transportation, heavy equipment, structural steel, railroad, furniture, appliances and sheet metal fabrication.

- **Connect wire feeders** via either 14-pin MS-type or terminal strip.
- **115V and 42V wire feeder auxiliary power** with circuit breaker protection.
- **Internal components, including windings, rectifiers and circuit boards,** are coated to protect against moisture and corrosion.
- **Electronic and thermostatic protection** from current overload and excessive temperatures. Indicator light lets you know when machine is reset.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1346-13 CV-400

Processes

- MIG
- Flux-Cored
- Gouging

Output Input

CV-400/LF-72 Ready-Pak® Package (K2439-1) Includes

- CV-400 Power Source
- LF-72 Wire Feeder (Bench Model)
- .035"-.045" Drive Rolls for Solid Wire
- Heavy Duty Wire Reel Stand
- Control Cable, 10 ft. (3.0 m)
- Weld Power Cable, 10 ft. (3.0 m)
- Work Cable & Clamp, 10 ft. (3.0 m)
- Magnum® 400 MIG Gun w/15 ft. (4.5 m) Cable
- Harris® Flowmeter Regulator & Gas Hose

Key Options

- K857 Remote Output Control
- K864 Remote Control Adapter
- K841 Undercarriage
- *More options at end of section*

Literature

E4.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
CV-400	K1346-22	230/460/575/3/60	400A/36V/100%	77/39/31A 80/40/32A	60-500A 12-42V	27.5 x 22.2 x 32 (699 x 564 x 813)	383 (174)
	K1346-13	230/460/3/60	450A/38V/60%	77/39A			
CV-400/LF-72 Ready-Pak® Pkg.	K2439-1			80/40A		22.5 x 36.5 x 53 (571 x 927 x 1346)	490 (222)
CV-400/LF-74 Ready-Pak® Pkg.	K2496-1					27.5 x 36.5 x 53 (699 x 927 x 1346)	490 (222)

NOTE: 50 Hertz models available.

CV-655

Dependable High Output MIG Welding

Energy efficiency, reliability and exceptional performance are what set the CV-655 apart from the rest. Designed primarily for heavy-duty applications, the CV-655 is an outstanding choice for MIG and flux-cored welding on mild steel, stainless steel, aluminum and alloys.

- **Calibrated output control** lets operator accurately regulate power levels.
- **Line voltage compensation** maintains weld consistency, even with line voltage changes of $\pm 10\%$.
- **115-volt duplex receptacle** provides 20 amps of auxiliary power.
- **Separate output studs** allow the operator to select high or low inductance.
- **Panel switches** allow operator to change settings at the power source or wire feeder.
- **Solid state circuitry** provides extra long life during repetitive applications.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1480-1 CV-655

Processes

- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output Input

Key Options

- K1482-1 Digital Meter Kit
- K1486-1 Air Filter Kit
- K1528-1 Dual Process Switch
- K857 Remote Output Control
- *More options at end of section*

Literature

E4.40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
CV-655	K1480-1	230/460/3/60	650A/44V/100% 815A/44V/60%	94/47A	70-815A 13-44V Max. OCV: 48V	27.5 x 22.2 x 38.0 (699 x 565 x 965)	652 (296)
	K1480-5	575/3/60		38A			
	K1481-1	230/400/3/50/60	94/54A				
	K1481-5	415/3/50/60	52A				

The Lincoln Electric Welding School

The Lincoln Electric Welding School hosts courses throughout the year on the various types of arc welding processes to educate and train students in arc welding safety, processes, techniques and Lincoln products as well as qualification and certification programs. Beginners, instructors, supervisors and those looking to improve their skills should call 216-383-2259 or visit:

<http://www.lincolnelectric.com/knowledge/training/weldschool/>



MIG: Industrial Welders Options

See "Recommended General Options" pgs.151-171 for descriptions.

CV-305*General Options*

K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K864	Remote Control Cable Adapter
K1803-1	Work and Wire Feeder 2/0 Weld Cable (10 ft.) Package
K852-70	Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm ² cable
K852-95	Twist-Mate™ Cable Plug for 2/0-3/0, 70-95 mm ² cable
K484	Jumper Plug Kit
K867	Universal Adapter Plug
K874	Undercarriage – Hand moving
—	Fume Extraction System

Wire Feeder Options

LF-72 and LF-74
LN™-25 PRO
Magnum® SG Spool Gun

CV-400*General Options*

K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K864	Remote Control Cable Adapter
K841	Undercarriage – Hand moving
K484	Jumper Plug Kit
K2149-1	Work Lead Package
—	Fume Extraction System

Wire Feeder Options

LF-72 and LF-74
LN™-8
LN™-9
LN™-10 and DH-10
LN™-15 and LN™-25 PRO
LN™-35

CV-655*General Options*

K1482-1	Digital Meter Kit
K1486-1	Air Filter Kit
K1528-1	Dual Process Switch
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K864	Remote Control Cable Adapter
K842	Undercarriage – Hand moving
K1737-1	All-Terrain Undercarriage
—	Fume Extraction System

Wire Feeder Options

LF-72 and LF-74
LN™-8
LN™-9
LN™-10 and DH-10
LN™-35
NA-3 and NA-5

MULTI-PROCESS WELDERS



- For Heavy Manufacturing and Fabrication
- One Machine For Stick, TIG, Wire Welding and Arc Gouging
- Ruggedly Built For Tough Environments



MODEL	OUTPUT		Current Range Amps (A)	PROCESS							INPUT		FEATURES		
	Mode	Polarity		Stick	TIG	MIG	MIG Pulsed	Flux-Cored	Submerged Arc	Arc Gouge	Phase	Hertz	Stackable	High Efficiency	7-Yr. Warranty on Power Rectifier
Invertec® V350-PRO	CC CV	DC	5-425 A	●	●	●	○	●		●	1/3	50/60		●	
Invertec® V450-PRO	CC CV	DC	5-570 A	●	●	●	○	●	●	●	3	50/60	●	●	
Idealarc® DC-400	CC CV	DC	60-500 A	●	●	●		●	●	●	3	50,60	●		●
Idealarc® DC-600	CC CV	DC	70-850 A	●	●	●		●	●	●	3	50/60	●		●
Idealarc® DC-655	CC CV	DC	50-815 A	●	●	●		●	●	●	3	50,60	●		●

KEY: ● Excellent ● Good ● Optional

Invertec® V350-PRO

Designed Smart. Built Tough.

The Invertec® V350-PRO is a versatile, multi-purpose, multi-process power source that's lightweight and portable. Available in four models: construction, factory, advanced process and factory rack.

- All input voltages and frequencies are both single and three phase rated—no phase derating necessary on single phase.
- 5-425 amp output range for all recommended processes from TIG to arc gouging.
- Input voltage from 208-575V—this one machine is capable of running on virtually any input power supply.
- 50 and 60 Hz operation—can be connected anywhere in the world.
- Touch Start TIG® for contamination-free starts.
- 87% efficiency—low power consumption for energy savings.
- Three-year warranty on parts and labor.



Shown: K1728-7 Invertec® V350-PRO (Advanced Process Model)

Processes

- Stick
- TIG
- MIG
- Pulsed (Advanced Process Panel only)
- Flux-Cored
- Gouging

Output Input

Ready-Pak® Package (K2437-1)

- Includes**
- V350-PRO Factory Model (K1728-6)
 - LF-72 Heavy Duty Wire Feeder (K2327-3)
 - Work & Wire Feeder 2/0 Welding Cable Package, 10 ft. (3.0 m)
 - Harris® Flowmeter/Regulator w/Adapter and Hose, 10 ft. (3.0 m)
 - Inverter and Wire Feeder Cart

Literature

E5.91

Product Name	Product Number	Model	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V350-PRO/LF-72 Ready-Pak® Pkg.	K2437-1	Factory	200-208/230/380-415/460/575/3/50/60	350A/34V/60%	3-ph: 50/42/28-26/23/18 1-ph: 94/85/54/42/37	5-425A Max OCV: 80V DC	55.2 x 28.5 x 55.5 (1403 x 724 x 1410)	370 (168)
	K2438-1	Advanced Process						
Invertec® V350-PRO	K1728-5	Construction	208/230/415/460/575/1/50/60	300A/32V/100%	3-ph: 41-39/36/23-22/19/16 1-ph: 76/69/41/36/31	80V DC	14.8 x 13.3 x 27.9 (376 x 338 x 709)	81 (36.7)
	K1728-6	Factory						
	K1728-7	Advanced Process	200-220/380-400/415-440/1/3/50/60	350A/34V/60% (3ph) 320A/33V/60% (1ph) 300A/32V/100% (3ph) 275A/31V/100% (1ph)	3-ph: 48/28-27/26-24 3-ph: 41-37/28-22/22-21	86.5 (37.4)		
	K1728-13	Factory (Tweco®)						
K1728-8	CE							

Invertec® V450-PRO

Substantial Output. Smart Performance. Rugged Reliability.

The Invertec® V450-PRO is targeted for shops commonly welding with .052" or larger diameter wires that also require plenty of power for arc gouging repair work with a 3/8" carbon.

- Features full remote and multi-process capability—Stick, Touch Start TIG®, MIG, Flux-cored and Arc Gouging.
- 5-570 amp output range for all recommended processes.
- 88% efficiency with a high 95% power factor.
- Standard Controls Include – Selectable Hot Start for stick welding and Variable Arc Control.
- Touch Start TIG® – Makes it easy to achieve great arc starts with minimal or no tungsten contamination.
- Stackable Case Design – Allows you to stack up to three units to save valuable shop floor space.
- Supports 24, 42 or 115 volt wire feeders.
- Easy access front panel – With 15 amp 115 volt AC auxiliary power receptacles with circuit breaker protection will power your lights, grinders or gun/torch water coolers.
- Three-year warranty on parts and labor.



Shown: K2420-1 Invertec® V450-PRO

Processes

- Stick
- TIG
- MIG
- Pulsed (Advanced Process Panel only)
- Flux-Cored
- Gouging

Output Input

Ready-Pak® Package (K2494-1)

- Includes**
- V450-PRO
 - LF-72 Heavy Duty Bench Model Wire Feeder (K2327-3)
 - Magnum® 400 Gun and Cable Assembly, 15 ft. (4.5 m)
 - .035-.045" (0.8-1.1 mm) Drive Rolls and Wire Guides
 - Work & Wire Feeder 2/0 Welding Cable Package, 10 ft. (3.0 m)
 - Harris® Flowmeter/Regulator w/Adapter and Hose, 10 ft. (3.0 m)

Literature

E5.94

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Invertec® V450-PRO/LF-72 Ready-Pak® Pkg.	K2494-1	208/230/460/575/3/50/60	60Hz: 450A/38V/100% (570A/43V/60%)	60Hz: 58/53/25/22A (82/78/37/31A) 50Hz: 49/45/23/18A (67/61/31/25A)	5-570A	47.5 x 24 x 38 (1207 x 610 x 965)	405 (184)
Invertec® V450-PRO/LF-74 Ready-Pak® Pkg.	K2495-1		50Hz: 400A/36V/100% (500A/40V/60%)				
Invertec® V450-PRO	K2420-1					26.1 x 19.9 x 32.9 (663 x 505 x 835)	293 (133)
Invertec® V450-PRO (CE)	K2421-1	380/415/3/50/60	400A/36V/100% (500A/40V/60%)	36/33A (48/44A)	5-500A		278 (126)

Idealarc® DC-400

DC Multi-Process Welding Power Source

This heavy-duty, industrial, three-phase multi-process power source from Lincoln Electric scores big in MIG, Flux-cored, Submerged Arc, Stick and DC TIG welding.

- **Large, conveniently located controls** make it easy to change between CC (Stick/TIG/arc gouging), CV (MIG/flux-cored) and CV Submerged Arc modes.
- **Arc force control** adjusts short circuit current for a soft arc or a forceful driving arc in the CC (Stick/TIG) mode.
- **Arc control adjustment** changes pinch effect of the arc to control spatter, fluidity, and bead shape in the MIG/Flux-Cored mode.
- **Solid state circuitry** provides extra long life for repetitive welding applications.
- **±10% input line voltage compensation** for maintaining weld consistency.
- **Low profile case** allows stacking machines up to three high to conserve floor space.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1308-12 Idealarc® DC-400

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output **DC** Input

Key Options

- K804-1 Multi-Process Switch
- K841 Undercarriage
- *More options at end of section*

Literature

E5.20

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC-400	K1308-11	230/460/3/60	400A/36V/100% (450A/38V/60%) (500A/40V/50%)	78/39A	60-500A 12-42V	27.5 x 22.3 x 33.1 (698 x 566 x 840)	473 (215)
	K1308-12 w/Multi-Process Switch						
	K1309-20	220/380/440/3/50/60		81/47/40A			
	K1309-17	230/400/3/50/60		77/45A			

Idealarc® DC-600

Rugged Multi-Process Power for Industrial Manufacturing

Rugged construction, simple controls and plenty of amperage for heavy duty applications on thick steel or other materials make this welder a sound investment.

- **115V, 15 amps, duplex auxiliary power receptacle** (60Hz models) makes it easy to power lights, grinders and other shop tools at your work station.
- **Full range output voltage control** for easy operation and precise control.
- **Standard analog ammeter and voltmeter.**
- **Mode switch** for selecting desired output characteristics.
- **Windings and rectifiers** protected against moisture and corrosive environments.
- **Flat-top case** with a small footprint can be placed under a workbench or stacked up to 3 high on top of each other.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1288-17 Idealarc® DC-600

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output **DC** Input

Key Options

- K804-1 Multi-Process Switch
- K1611-1 Paralleling Kit (for codes above 10500)
- K1897-1 Paralleling Kit (for codes below 10500)
- K842 Undercarriage
- *More options at end of section*

Literature

E5.40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC-600 w/Multi-Process Switch	K1288-18	230/460/3/60	600A/44V/100% 680A/44V/60%	108/54A	CV: 70-850A, 13-44V CC: 90-850A, 24-42V	30.7 x 22.2 x 38 (781 x 565 x 965)	522 (237)
	K1288-17						
Idealarc® DC-600	K1288-22	230/460/575/3/60		108/54/43.2A			

NOTE: 50 Hertz models available.

Idealarc® DC-655

Energy Efficient Multi-Process Welder

This 650-amp, 100% duty cycle CV/CC power source is ideal for construction and shop fabrication because of its excellent arc performance and many energy saving features.

- **CC Arc Force Control Knob** with built-in “Hot Start”.
- **“Idle Shut Down mode”** automatically shuts machine off when not in use to minimize power consumption.
- **Fan-As-Needed™**—solid state thermally controlled cooling fan operates only when required. Minimizes power consumption, operating noise and dust intake.
- **Separate output studs** let you choose low or high inductance.
- **Panel switches** are behind front latched panel, for remote or machine panel output control, and output “on” or remote “on” selection, and CC, CV Subarc or CV MIG mode selection.
- **Low profile case** allows stacking machines up to three high to conserve floor space.
- **Electronic and thermal protection** from current overload and excessive temperatures.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1609-2 Idealarc® DC-655

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output **DC** **Input**

Key Options

- K1482-1 Digital Meter Kit
- K1528-1 Dual Process Switch
- K1611-1 Paralleling Kit
- K842 Undercarriage
- *More options at end of section*

Literature

E5.46

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Idealarc® DC-655	K1609-2	230/460/575/3/60	650A/44V/100% (815A/44V/60%)	122/61/49A	13-44V 50-815A Max. OCV: 46V (CV) 68V (CC)	27.5 x 22.2 x 38 (699 x 564 x 965)	720 (327)
	K1610-1	230/400/3/50/60		122/70A			

Multi-Process Welders Options

See “Recommended General Options” pgs. 151-171 for descriptions.

Invertec® V350-PRO

General Options

- K1763-1 Advanced Process Panel
- K586-1 Deluxe Adjustable Gas Regulator & Hose Kit
- K1803-1 Work and Wire Feeder 2/0 Weld Cable Package
- K852-70 Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable
- K852-95 Twist-Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable
- K1759-70 Twist-Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable
- K1759-95 Twist-Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable
- K2176-1 Twist-Mate™ to Lug Cable Adapter
- K1764-1 Inverter and Wire Feeder Cart
- K1702-1 Dual Cylinder Mounting Kit
- K1838-1 Undercarriage – Valet Style
- K867 Universal Adapter Plug
- Fume Extraction System

Stick Options

- K704 Accessory Kit, 400 Amp
- K857 Remote Output Control, 25 ft. (7.6m)
- K857-1 Remote Output Control, 100 ft. (30m)
- K864 Remote Control Cable Adapter

TIG Options

- K930-2 TIG Module
- K936-1 Control Cable (9-pin to 14-pin)
- K936-4 Control Cable (9-pin to 115V plug)
- K963-3 Hand Amptrol® (Rotary Track Style)
- K870 Foot Amptrol®
- K814 Arc Start™ Switch
- K1762-2 Invertec® TIG Solenoid Kit

Invertec® V350-PRO, con’t.

TIG Options, con’t.

- K1622-1 Twist-Mate™ Torch Adapter, PTA-9, -17
- K1622-3 Twist-Mate™ Torch Adapter, PTA-26
- K1622-4 Twist-Mate™ Torch Adapter, Water-Cooled
- K960-1 Twist-Mate™ Torch Adapter (with separate gas)
- K2265-1 TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled)
- K2266-1 TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)
- K2267-1 TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)

Wire Feeder Options

- LF-72 and LF-74
- LN™-10 and DH-10
- LN™-15 and LN™-25 PRO

Invertec® V450-PRO

General Options

- K1763-1 Advanced Process Panel
- K586-1 Deluxe Adjustable Gas Regulator & Hose Kit
- K1813-1 Cool-Arc 40 Water Cooler 115/1/50/60
- K1570-1 Dual Cylinder Platform Undercarriage
- K2149-1 Work Lead Package
- Fume Extraction System

Stick Options

- K704 Accessory Kit, 400 Amp
- K857 Remote Output Control, 25 ft. (7.6 m)
- K857-1 Remote Output Control, 100 ft. (30 m)

Multi-Process Welders Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Invertec® V450-PRO, con't.

TIG Options

K1783-7	PTA-26V TIG Torch (12.5 ft., 2 pc)
K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
K1782-7	PTA-17V TIG Torch (12.5 ft., 2 pc)
K1782-9	PTA-17V TIG Torch (25 ft., 2 pc)
K930-2	TIG Module
K939-1	Docking Kit
K936-1	Control Cable (9-pin to 14-pin)
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K814	Arc Start™ Switch

Wire Feeder Options

LF-72 and LF-74
LN™-8
LN™-10 and DH-10
LN™-15 and LN™-25 PRO

Idealarc® DC-400

General Options

K804-1	Multi-Process Switch
K841	Undercarriage – Hand moving
K2149-1	Work Lead Package
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6m)
K857-1	Remote Output Control, 100 ft. (30m)
K864	Remote Control Cable Adapter

TIG Options

K930-2	TIG Module
K936-1	Control Cable (9-pin to 14-pin)
K1798	Adapter Cable – Male 14-pin Control Cable to Terminal Strip
K937-45	Control Cable Extension, 45 ft.
K939-1	Docking Kit
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K864	Remote Control Cable Adapter
K843	Amptrol® Adapter Kit
K586-1	Deluxe Adjustable Gas Regulator & Hose Kit

Wire Feeder Options

LF-72 and LF-74
LN™-8
LN™-9
LN™-10 and DH-10
LN™-15 and LN™-25 PRO
LN™-23P
LN™-35
LT-7

Idealarc® DC-600

General Options

K804-1	Multi-Process Switch
K842	Undercarriage – Hand moving
K1737-1	All-Terrain Undercarriage
K1611-1	Paralleling Kit (codes above 10500)
K1897-1	Paralleling Kit (codes below 10500)
—	Fume Extraction System

Idealarc® DC-600, con't.

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K864	Remote Control Cable Adapter

TIG Options

K930-2	TIG Module
K936-1	Control Cable (9-pin to 14-pin)
K1798	Adapter Cable – Male 14-pin Control Cable to Terminal Strip
K937-45	Control Cable Extension, 45 ft.
K939-1	Docking Kit
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K843	Amptrol® Adapter Kit
K586-1	Deluxe Adjustable Gas Regulator & Hose Kit

Wire Feeder Options

LF-72 and LF-74
LN™-8, LN™-9
LN™-10 and DH-10
LN™-15 and LN™-25 PRO
LN™-23P
LN™-35
NA-3 and NA-5
LT-7

Idealarc® DC-655

General Options

K1482-1	Digital Meter Kit
K1486-1	Air Filter Kit
K1528-1	Dual Process Switch
K1611-1	Paralleling Kit
K842	Undercarriage – Hand moving
K1737-1	All-Terrain Undercarriage
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K864	Remote Control Cable Adapter

TIG Options

K930-2	TIG Module
K936-1	Control Cable (9-pin to 14-pin)
K1798	Adapter Cable – Male 14-pin Control Cable to Terminal Strip
K937-45	Control Cable Extension, 45 ft.
K939-1	Docking Kit
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K864	Remote Control Cable Adapter
K843	Amptrol® Adapter Kit
K586-1	Deluxe Adjustable Gas Regulator & Hose Kit

Wire Feeder Options

LF-72 and LF-74
LN™-8
LN™-9
LN™-10 and DH-10
LN™-15 and LN™-25 PRO
LN™-23P
LN™-35
NA-3 and NA-5
LT-7

ADVANCED PROCESS WELDERS



NEXTWELD®

- A Wide Variety of Welding Waveforms for Every Application
- Fast, Reliable Digital Communication
- Expand or Update With Lincoln's Latest Welding Processes
- Multi-Process Welding On A Variety Of Materials



MODEL	OUTPUT		PROCESS							INPUT		FEATURES			
	Mode	Polarity	Current Range Amps (A)	Stick	TIG	MIG	MIG/STT®	Pulsed	Flux-Cored	Arc Gouge	Phase	Hertz	Waveform Control Technology®	ArLink® Digital Communication	Inverter Efficiency
Invertec® STT® II	STT®	DC	0-450 A PEAK 0-125 A BKGRND				●				3	50,60	●		●
Power Wave® C300	CC CV	DC	5-300 A	●	●	●		●	●	●	1,3	50,60	●	●	●
Power Wave® 355M	CC CV	DC	5-425 A	●	●	●		●	●	●	1,3	50,60	●	●	●
Power Wave® 455M	CC CV	DC	5-570 A	●	●	●		●	●	●	3	50,60	●	●	●
Power Wave® 455M/STT®	CC CV	DC	5-570 A	●	●	●	●	●	●	●	3	50,60	●	●	●

KEY: ● Excellent ● Good ● Optional

Invertec® STT® II

Featuring Surface Tension Transfer® Process



The Invertec® STT® II power source combines high frequency inverter technology with advanced Waveform Control Technology® to provide a better welding solution than traditional short arc MIG.

- **Controlled penetration and outstanding heat input control**—Ideal for welding joints with open root, gaps, or on thin material with no burnthrough.
- **Reduced spatter and fumes**—Current is controlled to achieve optimal metal transfer.
- **Various shielding gases**—STT® may be used with various gas blends including 100% CO₂ and Argon or Helium blends. Larger diameter wires can typically be used.
- **Good bead control and faster travel speeds**—Can replace TIG (GTAW) in many applications without sacrificing appearance or quality.
- **Background and Tailout Current**—accurately control fine and coarse heat input for reduced distortion and burnthrough as well as proper penetration.
- **Adjustable Hot Start** controls the heat at the start of the weld.



Shown: K1525-1 Invertec® STT II

Processes

- MIG-STT®

Output **Input**

Unit Includes

- Twist-Mate™ Cable Plugs (qty.2)
- STT® II Sense Lead Kit, 25 ft. (7.6 m)

Key Options

- K1560-2 STT® 10 Wire Feeder
- K1759-70 Twist-Mate™ Female Plug
- K2593-100 Coaxial Power #1 Cable, 100 ft.
- K1758-L Input Cable Assembly
- K852-xx Twist-Mate™ Welding Cable Connectors
- *More options at end of section*

Literature

E4.52

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Invertec® STT® II	K1525-1	208/230/460/3/60	225A/29V/60%	32/30/16A	Peak Current: 0-450A Background Current: 0-125A Max. OCV: 85V	23.2 x 13.2 x 24.4 (589 x 336 x 620)	117 (53)
	K1526-1	200-208/220-230/380-415/440-460/3/50/60	200A/28V/100%	33/30/15/17/16A			
	K1526-2	200/208/380/400/415/3/50/60		36/34/20/19/18A			
Invertec® STT® II CE	K1527-1	200/220/380/415/440/3/50/60		33/30/18/17/16A			
	K1527-2	200/208/380/400/415/3/50/60		36/34/20/19/18A			

NEW! Power Wave® C300



Portable. Powerful. Compact. One Machine Does it All!

The Power Wave® C300 is a portable multi-process power source with high-end functionality. Ideal for welding a wide variety of materials including aluminum, stainless, and nickel materials – where arc performance is critical. The Power Wave® C300 is well suited for production welding, construction, aerospace, automotive repair, general fabrication and training facilities.

- **PowerConnect™ Technology (patent pending)** – Allows you to automatically switch from 200-600V, 50 or 60 Hz, single or three phase, with no manual reconnect.
- **Tribrid™ Power Module** – Industry leading 88% efficiency at 250 amps and power factor of 0.97 for low operating costs.
- **Durable and Rugged Case** – IP23 rated and designed with harsh environments in mind.
- **Advanced User Interface** – Allows the machine to be customized for multiple operators, processes, and settings.
- **High Speed iARC™ Digital Controls** – More than 90 times faster than the previous generation and Ethernet is standard.
- **Waveform Control Technology®** – Provides industry leading arc performance focused on high quality and increased productivity.
- **Production Monitoring™ 2** – Standard feature that enables weld data to be monitored and stored.
- **Three-year warranty** on parts and labor.



Shown: K2774-1 Power Wave® C300 Ready-Pak® Pkg.

Processes

- Stick
- DC TIG
- Pulsed DC TIG
- Pulsed MIG
- MIG
- Flux-Cored

Output **Input**

Ready-Pak® Package (K2774-1) Includes

- Power Wave® C300 (K2675-1)
- Power Wave® C300 Undercarriage
- Magnum® 300 Gun Package
- Harris® Flowmeter
- Hose

Unit Includes

- Drive Roll Kit, .035"/.045" (0.9/1.2 mm)
- Input Cord, 10 ft. (3.0 mm)
- Work Lead & Clamp, 10 ft. (3.0 m)

Key Options

- Pro-Torch® TIG Torches
- K870 Foot Amptrol®
- K963-3 Hand Amptrol®
- *More options at end of section*

Literature

E5.100

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Wire Feed Speed Range ipm (m/min)	Wire Size Range inches (mm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Wave® C300	K2675-1	208/230/400/460/575 VAC 1/3 Phase	300A/29V/40% 250A/27V/100%	53/48/29/25/20A (1-phase) 30/28/16/14/11A (3-phase)	50-700 (1.27-17.8)	Solid: .023-.045 (0.6-1.2) Cored: .035-.045 (0.9-1.2)	20.4 x 14 x 24 (518 x 356 x 609)	91 (41.4)
Power Wave® C300 Ready-Pak® Pkg.	K2774-1	50/60 Hz					40.2 x 24 45.2 (1021 x 609 x 1148)	180 (81.6)

Power Wave® 355M

**Superior Arc Performance.
Revolutionary Communication.**



Processes

- Stick
- TIG
- MIG
- Pulsed
- Flux-Cored
- Gouging

Output **Input**

Ready-Pak® Package for Steel (K2372-1) Includes

- Power Wave® 355M (K2368-1)
- Power Feed™ 10M Bench Model (K2230-1)
- .035" (0.9 mm) and .045" (1.1 mm) Drive Roll & Spilt Wire Guide Kit
- Magnum® 400 Gun Pkg., 15 ft. (4.5 m)
- Work & Wire Feeder Power Cable Package
- Harris® Flowmeter/Regulator w/Adapter and Hose, 10 ft. (3.0 m)
- Inverter and Wire Feeder Cart
- 10 ft. (3.0 m) Power Input Cord

Key Options

- K586-1 Deluxe Adjustable Gas Regulator and Hose Kit
- K1764-1 Inverter and Wire Feeder Cart
- K1803-1 Work and Feeder Cables Package
- K2436-1 Ethernet/DeviceNet™ Communication Interface
- *More options at end of section*

Wire Feeders

Power Feed™ 10M, Power Feed™ 25M

Literature

E5.146

The Power Wave® 355M features some of Lincoln's® best performance technologies and processes all rolled into one highly efficient inverter power source designed for high-end semiautomatic welding.

- **Waveform Control Technology®** gives you the ability to select the right waveform for each application—that means the arc has been optimized for each wire type and size for exceptionally smooth arc performance.
- **Utilizes ArcLink®**—the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration with the wire feeder.
- **Push-pull capability** for ultimate aluminum welding with the Power Feed™ 10M or Power Feed™ 25M wire feeder.
- **Pulse-On-Pulse®** welding mode improves cleaning action when welding aluminum and delivers a TIG-like bead appearance.
- **Power Mode®** maintains a stable, smooth arc for short arc welding on thin materials.
- **State-of-the-art inverter technology** provides high power efficiency, excellent welding performance and a lightweight, compact design.
- **Rigorous environmental**, mechanical and weld testing ensures ruggedness and reliability.
- **Three-year warranty** on parts and labor.



Shown: K2368-1 Power Wave® 355M

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Wave® 355M/ Power Feed™ 10M Ready-Pak® Pkg.	K2372-1 (for steel)	3 ph: 200/208-230/380-400/ 415-460/575/3/50/60	350A/34V/60% (300A/32V/100%)	3 ph: 50/50-42/28-27/26-23/18A 1 ph: 94-85/64-42/37A	5-425A	—	250 (113)
	K2373-1 (for aluminum)	1 ph: 208-230/415-460/575/ 1/50/60	350A/34V/60% (300A/32V/100%)			—	250 (113)
	Power Wave® 355M	K2368-1				14.8 x 13.3 x 27.9 (376 x 338 x 709)	81.5 (37)

Take advantage of the advanced welding features powered by Nextweld® Technologies such as RapidArc® .



RapidArc® - High Speed GMAW Welding



Traditional pulse welding



- **Faster travel speeds**
- **Lower spatter**
- **Lower heat input**
- **Excellent bead profile**
- **Excellent arc stability**

Shown: RapidArc® Pulse Welding

Power Wave® 455M & Power Wave® 455M/STT®



Superior Arc Performance. Revolutionary Communication.

- **Waveform Control Technology®** gives you the ability to select the right waveform for each application, enabling patented processes like Pulse-On-Pulse®, Power Mode® and RapidArc®.
- **Choose from over 60 standard welding waveform programs** that offer a broad range of electrode size, type and shielding gas combinations to give you optimal appearance, penetration, beadshape and travel speed for each application.
- **Optional communication modules** provide networking and process monitoring capabilities via DeviceNet™ or Ethernet.
- **Push-Pull capability** delivers ultimate aluminum welding with the Power Feed™ 10M and Power Feed™ 25M wire feeder.
- **Utilizes ArcLink®**—the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration with the wire feeder.
- **Three-year warranty** on parts and labor.



Shown: K2202-1 Power Wave® 455M

Processes

- Stick
- TIG
- MIG
- Pulsed
- STT® (455M/STT® only)
- Flux-Cored
- Gouging

Output **Input**

Ready-Pak® Package (K2375-1) Includes

- Power Wave® 455M (K2202-1)
- Power Feed™ 10M Bench Model (K2230-1)
- .040-.045" (1.0-1.1 mm) Drive Roll & Guide Tube Kit
- Magnum® 400 Gun Pkg., 15 ft. (4.5 m)
- Work Lead Package
- Harris® Flowmeter/Regulator w/Adapter and Hose, 10 ft. (3.0 m)

Key Options

- K2149-1 Work Lead Package
- K2207-2 Ethernet/DeviceNet™ Interface Module
- K1570-1 Dual Cylinder Platform Undercarriage
- K1813-1 Cool Arc® 40 115/1/50/60

Wire Feeders

Power Feed™ 10M, Power Feed™ 25M

Literature

E5.161

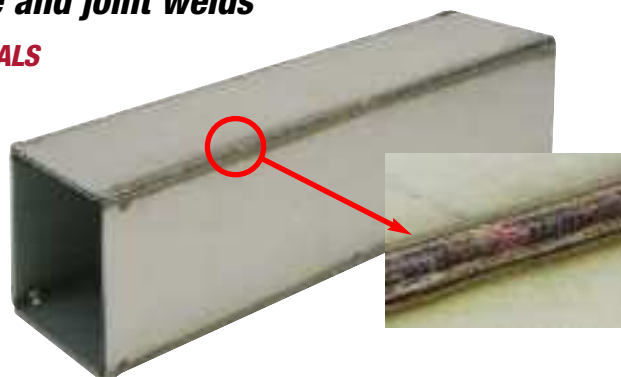
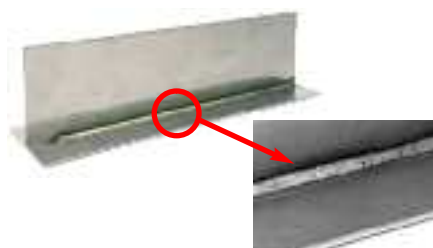
Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Power Wave® 455M	K2202-1	208/230/460/575/3/50/60	60Hz: 450A/38V/100% (570A/43V60%) 50Hz: 400A/36V/100% (500A/40V/60%)	60Hz: 58/53/25/22A (82/78/37/31A) 50Hz: 49/45/23/18A (67/61/31/25A)	5-570A	26.1 x 19.9 x 32.9 (663 x 505 x 835)	286 (130)
Power Wave® 455M/ Power Feed™ 10M Ready-Pak®	K2375-1						477 (216)
Power Wave® 455M/STT®	K2203-1						293 (133)
Power Wave® 455M CE	K2202-2	380/415/3/50/60					280 (127)
Power Wave® 455M/STT® CE	K2203-2						340 (154)

Take advantage of the advanced welding features powered by Nextweld® Technologies such as Power Mode® .



Power Mode® - Produces quality edge and joint welds

**PROVIDES STABLE ARC WELDING ON THIN MATERIALS
MAKES ALUMINUM WELDING MORE FORGING**



Advanced Process Welders Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Invertec® STT® II

General Options

K1764-1	Inverter and Wire Feeder Cart
K1702-1	Dual Cylinder Mounting Kit
K940-25	Sense Lead Kit, 25 ft.
K940-75	Sense Lead Kit, 75 ft.
K1796-25	Coaxial Weld Power Cable (350A), 25 ft.
K1796-50	Coaxial Weld Power Cable (350A), 50 ft.
K1796-75	Coaxial Weld Power Cable (325A), 75 ft.
K1796-100	Coaxial Weld Power Cable (300A), 100 ft.
K2593-25	Coaxial Weld Power Cable (#1, Lug to Lug), 25 ft.
K2593-50	Coaxial Weld Power Cable (#1, Lug to Lug), 50 ft.
K2593-100	Coaxial Weld Power Cable (#1, Lug to Lug), 100 ft.
K852-70	Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm ² cable
K852-95	Twist-Mate™ Cable Plug for 2/0-3/0, 70-95 mm ² cable
K1759-70	Twist-Mate™ Receptacle for 1/0-2/0, 50-70 mm ² cable
K1759-95	Twist-Mate™ Receptacle for 2/0-3/0, 70-95 mm ² cable
K2176-1	Twist-Mate™ to Lug Cable Adapter
—	Fume Extraction System

Wire Feeder Options

STT®-10, LN™-15 (Control Cable model)

Power Wave® C300

General Options

K2378-1	Canvas Cover
K2734-1	Understorage Cart
—	Fume Extracton System

Stick Options

K875	Accessory Kit, 150 amps
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30.5 m)

TIG Options

K1782-2	PTA-17, 150 Amp, Air-Cooled TIG Torch, 12.5 ft. (3.8 m) length, 2-cable
K1782-4	PTA-17, 150 Amp, Air-Cooled TIG Torch, 25 ft. (7.6 m) length, 2-cable
K1783-2	PTA-26, 200 Amp, Air-Cooled TIG Torch, 12.5 ft. (3.8 m) length, 2-cable
K1783-4	PTA-26, 200 Amp, Air-Cooled TIG Torch, 25 ft. (7.6 m) length, 2-cable
KP508	Parts Kits for PTA-17
KP509	Parts Kits for PTA-26
K870	Foot Amptrol®
K963-3	Hand Amptrol®
K814	Arc Start™ Switch

Wire Feeder Options

K2153-1	Aluminum Feeding Kit
K489-8	Fast-Mate™ Adapter
K2449-1	Dual Procedure Switch
K2490-1	Magnum® 250LX™ Spool Gun
K2519-1	Magnum® 250LX™ Spool Gun Control Cable Extension
K2447-1	Python®-Plus Push-Pull Gun, Air-Cooled, 15 ft. (4.5 m)
K2447-2	Python®-Plus Push-Pull Gun, Air-Cooled, 25 ft. (7.6 m)
K2447-3	Python®-Plus Push-Pull Gun, Air-Cooled, 50 ft. (15.2 m)
K2295-1	Magnum® 300 Gun Package
K2296-2	Prince® XL Push-Pull Gun, Air-Cooled, 25 ft. (7.6 m)
K2154-1	Push-Pull Gun Connection Kit

Power Wave® 355M

General Options

K586-1	Deluxe Adjustable Gas Regulator & Hose Kit
K1764-1	Inverter and Wire Feeder Cart
K1702-1	Dual Cylinder Mounting Kit
K1838-1	Undercarriage – Valet Style
K852-70	Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm cable
K852-95	Twist-Mate™ Cable Plug for 2/0-3/0, 70-95 mm cable
K1759-70	Twist-Mate™ Receptacle for 1/0-2/0, 50-70 mm cable
K1759-95	Twist-Mate™ Receptacle for 2/0-3/0, 70-95 mm cable
K2176-1	Twist-Mate™ to Lug Cable Adapter
K940-25	Sense Lead Kit, 25 ft.
K940-75	Sense Lead Kit, 75 ft.
K1811-50	Heavy Duty Process Sense Lead, 50 ft.
K1811-75	Heavy Duty Process Sense Lead, 75 ft.
K1811-100	Heavy Duty Process Sense Lead, 100 ft.
K1803-1	Work and Wire Feeder 2/0 Weld Cable Package
K2436-1	Ethernet/DeviceNet™ Communication Interface
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
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TIG Options

K2265-1	TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled)
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Wire Feeder Options

Power Feed™ 10M, Power Feed™ 25M

Power Wave® 455M & 455M/STT®

General Options

K2206-1	DeviceNet™ Interface Module
K2207-2	Ethernet/DeviceNet™ Interface Module
K1570-1	Dual Cylinder Platform Undercarriage
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
K2149-1	Work Lead Package
K1811-50	Heavy Duty Process Sense Lead, 50 ft.
K1811-75	Heavy Duty Process Sense Lead, 75 ft.
K1811-100	Heavy Duty Process Sense Lead, 100 ft.
—	Fume Extraction System

Stick Options

K704	Accessory Kit, 400 Amp
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TIG Options

K1782-7	PTA-17V TIG Torch (12.5 ft., 2 pc)
K1783-7	PTA-26V TIG Torch (12.5 ft., 2 pc)

Wire Feeder Options

Power Feed™ 10M
Power Feed™ 25M
Power Feed™ 10R

MULTI-OPERATOR WELDING SYSTEMS



- Great For Field or Shop Applications
- Multiple Arcs
- Simultaneous Welding with a Number of Operators

MODEL	OUTPUT		Current Range Amps (A)	PROCESS						INPUT		FEATURES		
	Mode	Polarity		Stick	TIG	MIG	Pulsed	Flux-Cored	Arc Gouge	Phase	Hertz	DC+ Welding Only	Touch-Start TIG®	One Disconnect Switch
Multi-Weld™ 350	CC CV	DC+ only	30-350 A	●	●	●		●	●	—	—	●		
Inverter Racks:														
Invertec® V275-S	CC	DC	5-275 A	●	●				●	1/3	50,60		●	●
Invertec® V350-PRO	CC CV	DC	5-425 A	●	●	●		●	●	1/3	50,60		●	●
Invertec® V450-PRO	CC CV	DC	5-570 A	●	●		●	●	●	3	50,60		●	●

KEY: ● Excellent ● Good ● Optional

Multi-Weld™ 350

Connect Several DC+ Welders to One Power Supply

The Multi-Weld™ 350 system offers a cleaner, safer job site, and allows operators to have high performance welding control right where they need it—at the arc.

- **Independent arcs.** Starting or stopping one Multi-Weld™ doesn't affect the welding of the others.
- **The Multi-Weld™ 350 is capable of continuous operation** at 350 amps in 122°F (50°C) air temperature.
- **No control cables are needed.** Single weld cable output from the power source to one or several Multi-Weld™ 350s.
- **Controls are located close to the operator** for quick access.
- **High efficiency design** uses less than half the power of other grid systems.
- **Lincoln® Chopper Technology®** for quality welds with instant control of the arc for superior welding results.
- **Additional stick welding controls** include hot start, arc force, and electrode type selection (E7018 & E6010).
- **Three-year warranty** on parts and labor.



Shown: K1735-1 Multi-Weld™ 350

Processes (DC+ only)

- Stick
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K1736-1 Distribution Box
- K852-70 Twist-Mate™ Welding Cable Connectors
- K1759-70 Twist-Mate™ Female Plug
- K857 Remote Output Control
- *More options at end of section*

Power Sources

Idealarc® DC-1500, SAE-400 (Perkins®), Idealarc® DC-1000, DC-655, Vantage® 500

Wire Feeders

LN™-15 Across-The-Arc , LN™-25 PRO

Literature

E5.302

Product Name	Product Number	Input Volts	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Multi-Weld™ 350	K1735-1	80V DC	350A/34V/100% (DC+ only output)	165A	15-40 Volts 30-350 Amps Max. OCV: 76V	11.6 x 10 x 21.5 (295 x 254 x 546)	59 (27)

Inverter Racks

Featuring Invertec® V350-PRO, V450-PRO or V275-S Power Sources with Tweco® Output Connectors

Ideal for grouping several inverter power sources in a portable industrial-grade package. These inverter racks are constructed of heavy gauge square tubular steel to ensure long life, yet maintain an extremely compact size.

- **One easy connection** allows power sources to be connected with one easy primary drop.
- **The power sources are factory installed** in the rack and wired to the main power distribution panel.
- **Entire system meets National Electrical Code (NEC).**
- **200 amp, 600 volt, 3 phase main disconnect switch.**
- **Individual fuses** provide overcurrent protection for each power source.
- **Standard length input cord** insures the power sources can be placed in any position on the rack.
- **Three-year warranty** on parts and labor.



Shown: K2667-2 V350-PRO Tweco® 6-Pack Rack

Processes:

Invertec® V450-PRO

- Stick
- TIG
- MIG
- Pulsed (Advanced Process Panel)
- Flux-Cored
- Gouging

Output Input

Invertec® V350-PRO

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Invertec® V275-S

- Stick
- TIG
- Gouging

Output Input

Literature

E5.92

Product Name	Product Number	Rack Input Power ⁽¹⁾	Rated Output Current/Voltage/Duty Cycle ⁽²⁾	Rated Input Current @ Rated Output	Output Range	H x W x D in. (mm)	Net Weight lbs. (kg)
NEW 4-Pack Rack V450-PRO	K2713-1	208/230/460/575/3/50/60	60Hz: 570A/43V/60% 50Hz: 500A/40V/60%	60Hz: 82/78/37/31A 50Hz: 67/61/31/25A	5-570A	72.5 x 41.5 x 63 (1842 x 1054 x 1600)	1644 (746)
4-Pack Rack V350-PRO	K2667-1	208/230/380-415/460/575/3/50/60	350A/34V/60%	200/230/380-415/ 460/575/3/50/60	5-425A	60.0 x 44.5 x 33.5 (1524 x 1130 x 851)	796 (361)
6-Pack Rack V350-PRO	K2667-2					60.0 x 59.0 x 33.5 (1524 x 1499 x 851)	1039 (471)
4-Pack Rack V275-S	K2666-1	208/230/460/575/3/60	275A/31V/35%	96/89/46/39A	5-275A	60.0 x 38.0 x 33.5 (1524 x 965 x 851)	483 (219)
8-Pack Rack V275-S	K2666-2	220/380/400/415/440/3/50	250A/30V/35%	89/53/53/50/46A		60.0 x 59.0 x 33.5 (1524 x 1499 x 851)	986 (447)

⁽¹⁾ Fused for 460/575/3/50/60 VAC operation. For 230 or 208 VAC operation, primary fuses must be changed. ⁽²⁾ Based on a 10 minute period. Output is for each individual machine.

Multi-Operator Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Multi-Weld™ 350

General Options

K1736-1	Distribution Box
K852-70	Twist-Mate™ Cable Plug for 1/0-2/0, 50-70 mm ² cable
K852-95	Twist-Mate™ Cable Plug for 2/0-3/0, 70-95 mm ² cable
K1759-70	Twist-Mate™ Receptacle for 1/0-2/0, 50-70 mm ² cable
K1759-95	Twist-Mate™ Receptacle for 2/0-3/0, 70-95 mm ² cable
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K1838-1	Undercarriage – Valet Style
—	Fume Extraction System

Power Source Options

DC-655, DC-1000 & DC-1500
SAE-500, Vantage® 500

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder
K1870-1	LN™-15 Wire Feeder Across-the-Arc Model

Inverter Racks

Power Source Options

K2269-3	Invertec® V275-S
K1728-13	Invertec® V350-PRO
K2420-1	Invertec® V450-PRO

General Options

K2665-1	Caster Kit
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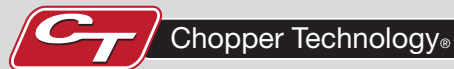


Inverter racks and the Multi-Weld™ 350 are an excellent choice for construction sites.

ENGINE DRIVES: COMMERCIAL



- Your Choice For Farm, Contractors, and Maintenance
- Outstanding Arc For Stick, TIG, Wire Welding
- Plenty Of AC Generator Power
- Rugged Reliability



	MODEL	OUTPUT			AC Generator Power (Watts) (C)=Continuous (P)=Peak (S)=Surge	PROCESS							FEATURES							
		Mode	Polarity	Current Range (Amps)		Stick Pipe	DC TIG Scratch Start	DC TIG Touch-Start®	AC TIG	MIG	Flux-Cored	Arc Gouge in. (mm)	Reactor Technology Chopper Technology®	Tube Frame	Enclosed Case	Electric Fuel Gauge	Remote Capable	Downhill Pipe Mode	Arc Force Control	Hot Start
Gasoline	Power Arc® 5500	CC	AC	70-125 AC	5,500(S)/4,000(C)	●						●	●							
	Weldanpower® 125	CC	DC	50-125 DC	5,500(P)/4,250(C)	●						●	●							
	Outback™ 185	CC	DC	50-185 DC	5,700(P)/5,200(C)	●						●	●							
	Ranger® 10,000 Plus	CC/CV	AC/DC	50-210 DC 50-225 AC	10,500(P)/9,000(C)	●	●	●	●	●	●	5/32 (4.0)	●							
	Ranger® 225 GXT	CC/CV	AC/DC	50-185 DC	10,500(P)/9,500(C)	●	●	●	●	●	●	5/32 (4.0)	●	●	●					
	Ranger® 250 GXT	CC/CV	AC/DC	50-250 DC 50-250 AC	11,000(P)/10,000(C)	●	●	●	●	●	●	3/16 (4.8)	●	●	●	●				
	Ranger® 3 Phase	CC/CV	AC/DC	50-210 DC 50-225 AC	3-Phase: 11,500(P)/10,500(C) 1-Phase: 10,500(P)/9,500(C)	●	●	●	●	●	●	5/32 (4.0)	●							
	Ranger® 250	CC/CV	DC	20-250 DC 40-250 DC Pipe 20-250 DC TIG	10,500(P)/9,500(C)	●	●	●	●	●	●	3/16 (4.8)	●	●	●	●	●	●	●	●
LPG	Ranger® 250 LPG	CC/CV	DC	20-250 DC 40-250 DC Pipe 20-250 DC TIG	10,000(P)/9,000(C)	●	●	●	●	●	3/16 (4.8)	●	●	●	●	●	●	●	●	
Diesel	Ranger® 305 G	CC/CV	DC	20-305 DC 40-300 DC Pipe 20-250 DC TIG	10,500(P)/9,500(C)	●	●	●	●	●	3/16 (4.8)	●	●	●	●	●	●	●	●	
	Ranger® 305 D	CC/CV	DC	20-305 DC 40-300 DC Pipe 20-250 DC TIG	10,000(P)/9,500(C)	●	●	●	●	●	3/16 (4.8)	●	●	●	●	●	●	●	●	

KEY: ● Excellent ● Good ● Optional

Power Arc® 5500

It's Two Tools in One!

The Power Arc® 5500 is ideal for home, farm, contractors, maintenance, or business power outage emergencies. You get two great tools in one for double the value—125 amps of AC welding output and maximum AC generator power in a lightweight package—that makes it easy to get auxiliary power where you need it – fast!

- 125 amps AC welding output is ideal for 3/32" (2.4 mm) and 1/8" (3.2 mm) diameter stick electrodes.
- Sizable 5500 watts surge (4000 watts continuous) single phase AC generator power keeps your lights, tools, heaters, sump pumps or appliances running during emergencies or for any project—any time, anywhere!
- Rugged tube frame roll cage adds protection and many lift handle points.
- 9 HP engine with cast iron sleeve for long engine life:
 - Subaru Robin® OHC (Overhead Cam)
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K1429-12
Power Arc® 5500

Processes

- Stick

Output Input

Key Options

- K875 Accessory Kit, 150 Amp
- K882-2 Hand Moving Undercarriage (2 wheels)

Literature

E6.21

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Arc® 5500 Subaru Robin®	K1429-12	125A/20V/30% 100A/25V/60%	70-125A AC 5,500 Watts Surge 4,000 Watts Continuous	Subaru Robin® EX 27 Gasoline	1	9 @ 3600	21 x 20 x 30 (530 x 508 x 762)	160 (72.5)

Weldanpower® 125

Versatile Welder and AC Power Generator for Year-Round Projects

Contractors and maintenance teams will appreciate the great arc and robust welding of the Weldanpower® 125. Step up to a DC welding machine to run smooth DC stick electrodes for welding projects on steel, stainless steel, cast iron or hardfacing. The handyman, farmer and small contractor will also value the 5500 watt AC generator power for lights, tools, pumps and emergency power.

- 125 amps DC welding output gives you access to steel, stainless steel, cast iron or hardfacing projects.
- Plenty of 120 or 240 volt AC generator power 5500 watts peak (4250 watts continuous) for lights, tools, pumps, or emergency power outage needs.
- Rugged tubular roll cage provides added protection and a host of handy lift handle points.
- The chain-driven OHC (Overhead Cam) Subaru Robin® 9 HP EX 27 engine is easy to start, delivers low noise and good fuel economy.
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K1444-4
Weldanpower® 125

Processes

- Stick

Output Input

Key Options

- K875 Accessory Kit, 150 Amp
- K882-2 Hand Moving Undercarriage (2 wheels)

Literature

E6.51

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Weldanpower® 125	K1444-4	125A DC/25V/30% 100A DC/25V/60%	50-125A DC 5,500 Watts Peak 4,250 Watts Continuous	Subaru Robin® EX 27 OHC Gasoline	1	9 @ 3600	21 x 20 x 30 (530 x 508 x 762)	180 (82)

NEW! Outback™ 185

Built For The Outdoors!

Great for service trucks, fence contractors, maintenance crews, farmers, ranchers and anyone who needs portable DC stick welding and AC generator power!

- **Low-Lift™ Grab Bars.** More leverage for lifting unit on and off truck beds! Extra protection against product damage.
- **All Engine Controls on Front Control Panel.** Easy access for starting, especially when mounted on truck beds. Includes electric start switch and choke control.
- **1-1/4" (32 mm) Diameter Rugged Tube Frame** for all-around sturdy protection.
- **6.8 Gallon (25.7 Liter) Fuel Tank** for extended run times.
- **Weld with up to 5/32" (4 mm) Stick Electrode.**
- **5,700 Watts Peak (5,200 Watts Continuous) AC Generator Power.**
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2706-1 Outback™ 185

Processes

- Stick

Output **Input**

Key Options

- K875 Accessory Kit, 150 Amp
- K2722-1 Undercarriage
- K2804-1 Canvas Cover

Literature

E6.70

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Outback™ 185	K2706-1	100A DC/25V/100% 130A DC/25V/60% 150A DC/25V/20%	50-185 DC	Kohler® CS 12.75	1	12.75 @ 3,600	25.5 x 21.1 x 31.5 (647 x 536 x 800)	310 (141)

PORTABLE ENGINE DRIVEN WELDER/GENERATOR

Built for the Outdoors

Outback 185

- ▶ 1 1/4" rugged tube frame - largest in its class.
- ▶ Low-Lift™ grab bar for lifting.
- ▶ Engine start switch and choke control on the front panel for ease of use - best in its class.
- ▶ Largest fuel tank in its class (6.8 gallon).
- ▶ Large fuel fill opening for easy re-fueling.
- ▶ Optional undercarriage.

Ranger® 10,000 Plus

Excellent Value AC/DC Stick Welding

It's the right choice for a general contractor, maintenance crew, farmer or rancher who needs a reliable and rugged general purpose AC/DC welder and AC generator. You can stick, TIG, MIG or flux-cored weld. You can also power lights and tools with up to 10,500 watts peak power (9,000 continuous) from the high capacity AC generator.

- **Smooth AC/DC welding output** for a broad range of Fleetweld® and Excalibur® stick electrodes. Also capable of MIG, Flux-Cored, and TIG welding.
- **Rated 225 amps/25 volts** for AC, 210 amps/25 volts for DC and 200 amps/20 volts for CV. All rated outputs at 100% duty cycle 104°F (40°C).
- **Expand to AC TIG welding** with optional TIG Module.
- **Arc Gouge** with up to 5/32" (4.0 mm) carbon electrode.
- **Up to 10,500 watts peak** (9,000 continuous) single-phase AC generator power for high capacity needs.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K14419-5
Ranger® 10,000 Plus

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K889-2 Hand Moving Undercarriage (2 wheels)
- K875 Accessory Kit, 150 Amp
- *More options at end of section*

Literature

E6.92

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP @ Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Ranger® 10,000 Plus	K1419-5	225A AC CC/25V/100% 210A DC CC/25V/100% 200A DC CV/20V/100%	50-225A AC 50-210A DC 15-25V CV 10,500/ 10,000 watts peak 9,000 watts continuous	Kohler OHV Command® CH23S	2	23 @ 3600	30.3 x 19.1 x 42.3 (770 x 485 x 1074)	502 (228)
	K2468-2			Subaru Robin® OHV EH65 Gasoline		22 @ 3600		528 (240)

NEW! Ranger® 225 GXT

Got It Covered!™

For construction contractors, maintenance crews, farmers or ranchers, the Ranger® 225 GXT does a variety of basic welding jobs. And with 10,500 watts of peak AC generator power, it handles a variety of other jobs: lights, grinder, Lincoln inverter, a Lincoln plasma cutter (separate air supply needed) or emergency power.

- **Totally Enclosed Case** for great Showroom Appearance.
- **Versatile AC/DC welding.** Smooth welding output for a broad range of stick electrodes, including Fleetweld® and Excalibur®. Also weld MIG, flux-cored, and TIG (with additional optional equipment). All outputs rated at 100% duty cycle 104°F (40° C)
- **10,500 Watts Peak Single-Phase AC Generator Power.** Use peak power for motor starting. 9,000 watts continuous power for high capacity needs such as a back-up generator, powering a Pro-Cut® plasma cutter, or an Invertec® inverter welder, as well as lights, grinders or other power tools.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2733-1
Ranger® 225 GXT

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K886-2 Canvas Cover
- K1737-1 All-Terrain Undercarriage
- K704 Accessory Kit, 400 Amp
- *More options at end of section*

Literature

E6.95

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Ranger® 225 GXT	K2733-1	225A/25V/100% 210A/25V/100% 200A/20V/100%	50-225A AC 50-210A DC 15-25V CV 10,500 watts peak 9,000 watts continuous	Kohler® OHV Command CH23S (Mechanical Fuel Pump)	2	23 @ 3600	36.2 x 21.5 x 42.3 (920 x 546 x 1073)	567 (257)

Ranger® 250 GXT

XTra Performance! XTra Power! XTra Protection!

The Ranger® 250 GXT has all of the Xtras you need for construction and maintenance work—250 amps for AC or DC stick and wire welding, 11,000 watts peak AC auxiliary power and Lincoln's® enclosed case.

- **XTra Performance!** Rated 250 amps/25 volts for AC, DC and CV. All rated outputs at 100% duty cycle 104°F (40°C).
- **Smooth AC/DC welding output** for Fleetweld® and Excalibur® stick electrodes.
- **Expand to AC TIG** welding with optional TIG Module and either a foot or hand Amptrol® for excellent aluminum and other alloy welding.
- **Arc gouge** with up to 3/16" (4.8 mm) carbon electrode.
- **XTra Power!** 11,000 watts peak (10,000 continuous) AC generator power for high capacity needs such as a back-up generator, or powering Pro-Cut® plasma cutters and Invertec® inverter welders, as well as lights, grinders and other power tools.
- **XTra Protection!** Engine doors provide protection and easy service access.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2382-3
Ranger® 250 GXT

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K886-2 Canvas Cover
- K930-2 TIG Module
- K1737-1 All-Terrain Undercarriage
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- *More options at end of section*

Literature

E6.96

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Ranger® 250 GXT	K2382-4	250A/25V/100%	50-250A AC 50-250A DC 14-28V CV 11,000 watts peak 10,000 watts continuous	Kohler® OHV Command CH23S (Electric Fuel Pump)	2	23 @ 3600	36.2 x 21.5 x 42.3 (920 x 546 x 1074)	602 (273)
	K2382-5 (Stainless Steel Roof, Case Sides & Engine Doors)			Kohler® OHV Command CH23S (Mechanical Fuel Pump)				

Ranger® 3 Phase

480V 3-Phase Portable Power for the Farm, Ranch or Job Site

Select the Ranger® 3 Phase for portable auxiliary power on the farm, ranch or construction sites. This rugged Ranger® delivers up to 11,500 watts peak three phase 480V power for farm irrigation circles, pumps and other power-hungry applications, or 10,500 watts peak single phase power for lights, grinders and farm, shop or home auxiliary power. You can also use the Ranger® 3 Phase for AC/DC stick welding and arc gouging, as well as TIG, MIG and flux-cored welding.

- **480V 3-Phase AC generator power** for irrigation circles or farm pumps.
- **10,500 watts peak single-phase power** to start single-phase motors.
- **Smooth AC/DC welding output** for a broad range of Fleetweld® and Excalibur® stick electrodes.
- **Arc Gouge** with up to 5/32" (4.0 mm) carbon electrode.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2337-2
Ranger® 3 Phase

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K886-1 Canvas Cover
- K2635-1 Small 2-Wheel Road Trailer w/Combination Ball/Eye Hitch
- K704 Accessory Kit, 400 Amp
- *More options at end of section*

Literature

E6.94

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Ranger® 3 Phase	K2337-2	225A AC CC/25V/100% 210A DC CC/25V/100% 200A DC CV/20V/100%	50-225A AC 50-210A DC 15-25V CV 1-Phase: 10,500 watts peak 9,500 watts continuous 3-Phase: 11,500 watts peak 10,500 watts continuous	Kohler OHV Command® CH23S	2	23 @ 3600	30.3 x 19.1 x 42.3 (770 x 485 x 1074)	538 (244)

Ranger® 250



250 Amp DC Gasoline Engine-Driven Welder/Generator

For contractors, construction and maintenance applications, this tough Lincoln® gasoline-driven welder/generator delivers 250 amps for welding at 100% duty cycle. You can weld with stick, Touch Start TIG® DC, flux-cored wire, MIG wire and arc gouging.

- Lincoln's® Chopper Technology® provides easy starts, a smooth arc, low spatter and excellent bead appearance.
- Arc Force control provides a soft or more forceful digging arc.
- Built-in "hot" start for easier starts and restrikes.
- Touch Start TIG® DC—Simply lift tungsten to start the arc.
- Arc gouging with up to 3/16" (4.8 mm) carbons.
- A portable powerhouse—Delivers 10,500 watts peak (9,500 watts continuous) of 120V/240V AC generator power.
- Fully enclosed case for equipment protection and low noise.
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K1725-12
Ranger® 250

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Key Options

- K886-2 Canvas Cover
- K2635-1 Small Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- More options at end of section

Literature

E6.103

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Ranger® 250	K1725-12	250A DC CC/28V/100% 250A DC CV/28V/100%	20-250A DC 40-250A Pipe	Subaru Robin® OHV EH65 Gas (Vacuum Fuel Pump)	2	22 @ 3600	36.2 x 21.5 x 42.3 (920 x 546 x 1074)	518 (235)
	K1725-11	275A DC CV/27V/60%	20-250A DC TIG 14-28V CV 10,500 watts peak 9,500 watts continuous	Kohler® OHV Command® CH23S Gas (Electric Fuel Pump)		23 @ 3600		500 227

Ranger® 250 LPG



250 Amp DC Liquid Propane Gas Engine-Driven Welder/Generator

For environments where gasoline and diesel emissions are unacceptable, this tough Lincoln® LPG fuel welder/generator delivers 250 amps for welding at 100% duty cycle. It's recommended for stick welding as well as Touch Start TIG® DC, flux-cored wire, MIG wire and arc gouging.

- Lincoln's® Chopper Technology® provides easy starts, a smooth arc, low spatter and excellent bead appearance.
- Arc Force control provides a soft or more forceful digging arc.
- Built-in "hot" start for easier starts and restrikes.
- Touch Start TIG® DC—Simply lift tungsten to start the arc.
- Arc gouging with up to 3/16" (4.8 mm) carbons.
- A portable powerhouse—Delivers 10,000 watts peak (9,000 watts continuous) watts of 120V/240V AC generator power.
- Fully enclosed case for equipment protection and low noise.
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2336-2
Ranger® 250 LPG

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

One-Pak® Package Includes

- K2336-2 Ranger® 250 LPG
- Factory Undercarriage
- Welding Gas Cylinder/LPG Tank Holder
- LPG Tank Strap
- K704 Accessory Kit, 400 Amp
- Six 10 lb. cans 1/8" dia. Excalibur® 7018 Stick Electrode

Key Options

- K886-2 Canvas Cover
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- More options at end of section

Literature

E6.104

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Ranger® 250 LPG	K2336-2	250A DC CC/28V/100% 250A DC CV/28V/100% 275A DC CV/27V/60%	20-250A DC 40-250A Pipe 20-250A DC TIG	Kohler® OHV Command® CH730 LPG	2	25 @ 3600	36.2 x 21.5 x 42.3 (920 x 546 x 1074)	482 (218)
Ranger® 250 LPG One-Pak® Package	K2371-2		14-28V CV 10,000 watts peak 9,000 watts continuous					

Ranger® 305 G

300 Amp DC Gasoline Engine-Driven Welder



For contractors with a gasoline fleet, here's a powerful stick, TIG, wire and pipe welding gasoline engine-driven welder that is ready for all day, everyday performance. Rugged and dependable, the Ranger® 305 G is built with a totally enclosed case for maximum protection. The 12 gallon (45 L) fuel tank will last the entire day.

- **Excellent DC multi-process welding** for general purpose stick, downhill pipe (stick), TIG, cored-wire, MIG (100% CO₂ and blended gas) and arc gouging with up to 3/16" (4.8 mm) carbons.
- **Lincoln's® Chopper Technology®** provides easy starts, a smooth arc, low spatter and excellent bead appearance.
- **A portable powerhouse**—Delivers 10,500 peak (9,500 continuous) watts of 120V/240V AC generator power.
- **Arc force** control provides a soft or more forceful digging arc.
- **Built-in "hot" start** for easier starts and restrikes.
- **Touch Start TIG® DC**—Lift tungsten to start the arc.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K1726-4 Ranger® 305 G

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

One-Pak® Package Includes

- K1726-4 Ranger® 305G
- K704 Accessory Kit, 400 Amp
- K2613-1 LN™-25 PRO Wire Feeder
- K126-2 Gun and Cable
- KP1697-068 Drive Roll Kit
- .072" NR®-232, 25 lb. Spool

Key Options

- K886-2 Canvas Cover
- K2635-1 Small 2-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- *More options at end of section*

Literature
E6.117

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Ranger® 305 G	K1726-5	305A DC CC/29V/100% 300A DC CV/29V/100%	20-305A DC 40-300A Pipe	Kohler® OHV Command® CH23S Gas Electrical Fuel Pump	2	23 @ 3600	36.2 x 21.5 x 42.3 (920 x 546 x 1074)	510 (231)
Ranger® 305 G One-Pak® Package	K2353-2		20-250A DC TIG 14-29V CV 10,500 watts peak 9,500 watts continuous	Kohler® OHV Command® CH23S Gas Mechanical Fuel Pump			—	—

Ranger® 305 D

300 Amp DC Diesel Engine-Driven Welder



For contractors with a diesel fleet, here's a powerful stick, TIG, wire and pipe welding diesel engine-driven welder. Rugged and dependable, the Ranger® 305 D is built with a totally enclosed case for maximum protection. The 12 gallon (45 L) fuel tank will last the entire day. Lincoln's® Ranger® 305 D . . . It's ready for a workout!

- **Excellent DC multi-process welding** for general purpose stick, downhill pipe (stick), TIG, cored-wire, MIG (100% CO₂ and blended gas) and arc gouging with up to 3/16" (4.8 mm) carbons.
- **Lincoln's® Chopper Technology®** provides easy starts, a smooth arc, low spatter and excellent bead appearance.
- **A portable powerhouse**—delivers 10,000 peak (9,500 continuous) watts of 120V/240V AC generator power.
- **Arc force** control provides a soft or more forceful digging arc.
- **Built-in "hot" start** for easier starts and restrikes.
- **Touch Start TIG® DC**—Lift tungsten to start the arc.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K1727-3 Ranger® 305 D

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

One-Pak® Package Includes

- K1727-3 Ranger® 305D
- K704 Accessory Kit, 400 Amp
- K2613-1 LN™-25 PRO Wire Feeder
- K126-2 Gun and Cable
- KP1697-068 Drive Roll Kit
- .072" NR®-232, 25 lb. Spool

Key Options

- K2635-1 Small 2-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Output Control, 100 ft. (30 m)
- *More options at end of section*

Literature
E6.118

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cyl.	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Ranger® 305 D	K1727-3	305A DC CC/29V/100% 300A DC CV/29V/100%	20-305A DC 40-300A Pipe	Kubota® D722 Diesel EPA Tier 4 Final	3	18.8 @ 3600	35.8 x 21.5 x 52.3 (909 x 546 x 1327)	698 (317)
Ranger® 305 D One-Pak® Package	K2352-1		20-250A DC TIG 14-29V CV 10,000 watts peak (9,500 watts continuous)				—	—

Engine Drives: Commercial/Small Contractor Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Power Arc® 5500

General Options

K875	Accessory Kit, 150 Amp
K882-2	Hand Moving Undercarriage (2 wheels)

Weldanpower® 125

General Options

K875	Accessory Kit, 150 Amp
K882-2	Hand Moving Undercarriage (2 wheels)

Outback™ 185

General Options

K875	Accessory Kit, 150 Amp
K2793-1	Spark Arrestor Kit
K2722-1	Undercarriage
K2804-1	Canvas Cover
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K2471-1	POWER MIG® 140C
K2473-1	POWER MIG® 180C
K2532-1	Magnum® 100SG Spool Gun

Ranger® 10,000 Plus and Ranger® 10,000

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K894-1	Spark Arrestor Kit
K886-1	Canvas Cover
K889-2	Hand Moving Undercarriage (2 wheels, inner-tube and sealant tires)
K889-3	Hand Moving Undercarriage (2 wheels, foam-filled tires)
K1737-1	All-Terrain Undercarriage
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K2635-1	Small 2-Wheel Road Trailer and Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K1788-1	Roll Cage

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit for PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-4	Control Cable (9-pin to 115V plug)
K937-45	Control Cable Extension, 45 ft.
K814	Arc Start™ Switch
K938-1	Contact Kit
K939-1	Docking Kit
K2535-1	Precision TIG® 225 Ready-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Ranger® 10,000 Plus and Ranger® 10,000, cont'd.

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062-3/32
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Ranger® 225 GXT

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K1898-1	Spark Arrestor Kit
K886-2	Canvas Cover
K1737-1	All-Terrain Undercarriage
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K2635-1	Small 2-Wheel Road Trailer and Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K1788-1	Roll Cage

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit for PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-4	Control Cable (9-pin to 115V plug)
K937-45	Control Cable Extension, 45 ft.
K814	Arc Start™ Switch
K938-1	Contact Kit
K939-1	Docking Kit
K2535-1	Precision TIG® 225 Ready-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062-3/32
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

**Engine Drives:
Commercial/Small Contractor Options, con't.**

See "Recommended General Options" pgs. 151-171 for descriptions.

Ranger® 250 GXT

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K1898-1	Spark Arrestor Kit
K886-2	Canvas Cover
K1737-1	All-Terrain Undercarriage
K1788-1	Roll Cage
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K1739-1	Cable Carrier Kit
K1788-1	Roll Cage
K2635-1	Small 2-Wheel Road Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-4	Pro-Torch™ TIG Torch PTA-26 (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-3	Control Cable (9-pin to 6-pin and 115V plug)
K937-45	Control Cable Extension, 45 ft.
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K938-1	Contacting Kit
K939-1	Docking Kit

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Ranger® 3 Phase

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K894-1	Spark Arrestor Kit
K886-1	Canvas Cover
K889-2	Hand Moving Undercarriage (2 wheels)
K889-3	Hand Moving Undercarriage (2 wheels, no-flat puncture proof tires)
K1737-1	All-Terrain Undercarriage
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K1788-1	Roll Cage
K2635-1	Small 2-Wheel Road Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-4	Control Cable (9-pin to 115V plug)
K814	Arc Start™ Switch
K939-1	Docking Kit
K938-1	Contacting Kit
K937-45	Control Cable Extension, 45 ft.
K2535-1	Precision TIG® 225 Ready-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

**Engine Drives:
Commercial/Small Contractor Options, con't.**

See "Recommended General Options" pgs. 151-171 for descriptions.

Ranger® 250*General Options*

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K1898-1	Spark Arrestor Kit
K886-2	Canvas Cover
K1737-1	All-Terrain Undercarriage
K1739-1	Cable Carrier Kit
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K1739-1	Cable Carrier Kit
K1788-1	Roll Cage
K2635-1	Small 2-Wheel Road Trailer and Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K2535-1	Precision TIG® 225 Ready-Pak®
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun, 10 ft., .068"-5/64"
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft.
K488	SG Control Module
K691-10	Control Module Input Cable – 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Ranger® 250 LPG*General Options*

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1898-1	Spark Arrestor Kit
K886-2	Canvas Cover
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K2361-1	LPG Tank Strap (requires K1745-1)
K1739-1	Cable Carrier Kit
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K2535-1	Precision TIG® 225 Ready-Pak®
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft.
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Engine Drives: Commercial/Small Contractor Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Ranger® 305 G

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K1898-1	Spark Arrestor Kit
K886-2	Canvas Cover
K1737-1	All-Terrain Undercarriage
K1739-1	Cable Carrier Kit
K1788-1	Roll Cage
K1770-1	Factory Undercarriage
K1745-1	Welding Gas Cylinder/LPG Tank Holder
K1739-1	Cable Carrier Kit
K1788-1	Roll Cage
K2635-1	Small 2-Wheel Road Trailer and Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K2535-1	Precision TIG® 225 Ready-Pak
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun, 10 ft., .068"-5/64"
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft.
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Ranger® 305D

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp (2 required)
K1898-1	Spark Arrestor Kit
K2174-1	Cold Weather Operation Kit
K1788-1	Roll Cage
K2635-1	Small 2-Wheel Road Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 100 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K963-3	Hand Amptrol® (Rotary Track Style)
K870	Foot Amptrol®
K2535-1	Precision TIG® 225 Ready-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder with Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun, 10 ft., .068"-5/64"
K2473-1	POWER MIG® 180C
K1816-1	Full KVA Adapter Kit (required)
K2532-1	Magnum® 100SG Spool Gun

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft.
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

ENGINE DRIVES: INDUSTRIAL



- World's Most Respected Among Pipe Welders
- Built Tough for Extreme Environments
- More Amperage for Thicker Materials
- Strong Arc Gouging Capability

	MODEL	OUTPUT			PROCESS							FEATURES								
		Mode	Polarity	Current Range (Amps)	AC Generator Power (Watts) (C)=Continuous (P)=Peak	Stick	Pipe	DC TIG Scratch Start	DC TIG Touch-Start™	AC TIG	MIG	Flux-Cored	Arc Gouge in. (mm)	Pure DC Generator	Chopper Technology®	Stainless Steel Case	Corrosive Environments	Digital Meters	Voltage Reduction Device (VRD)	Air Compressor
Diesel Engine	Pipelinor® 200D	CC	DC	40-300 DC	1-Phase: 1,750 DC	●	●					○	● 5/32 (4.0)	●						
	Classic® 300D	CC	DC	40-350 DC	1-Phase: 3,000 (C)	●	●	●				○	○	● 3/16 (4.8)	●					
	Vantage® 300	CC/CV	DC	30-400 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 12,500(P)/11,000(C) 1-Phase: 11,000(P)/10,000(C)	●	●		●	○	●	●	● 1/4 (6.3)	●	●			●		
	Vantage® 400	CC/CV	DC	30-500 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 19,000(P)/17,000(C) 1-Phase: 12,000(P)/11,000(C)	●	●		●	○	●	●	● 5/16 (8.0)	●	●			●	●	
	SAE-500	CC	DC	80-575 DC	1-Phase: 3,000 (C)	●	●	●					○	● 3/8 (10)	●					
	SAE-500 Severe Duty	CC	DC	80-575 DC	1-Phase: 3,000 (C)	●	●						● 3/8 (10)	●			●			
	Vantage® 500	CC/CV	DC	30-575 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 20,000(C) 1-Phase: 12,000(C)	●	●		●	○	●	●	● 3/8 (10)	●	●			●		
	Vantage® 500 (Compact Case)	CC/CV	DC	30-575 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 20,000(C) 1-Phase: 12,000(C)	●	●		●	○	●	●	● 3/8 (10)	●	●			●		
	Air Vantage® 500	CC/CV	DC	30-575 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 20,000(C) 1-Phase: 12,000(C)	●	●		●	○	●	●	● 3/8 (10)	●	●			●		●

KEY: ● Excellent ● Good ● Optional

Pipeliner® 200D

Rich Heritage – 200 Amp DC Diesel Engine

The Pipeliner® 200D is a direct descendant of Lincoln's® industry-respected 200 amp pure DC generator welders the cross-country pipeline welding. It features a DC exciter and runs slower than the common 1800 RPM, as requested by the most discriminating cross-country pipeline operators.

- All copper windings enhance arc stability.
- 200 amps DC @ 60% duty cycle. Weld up to 7/32" (5.6 mm) low hydrogen electrode. Gouge with up to 5/32" (4.0 mm) carbons.
- Five overlapping current ranges with fine-tuning within each range for precise control.
- Custom Arc™ 150 RPM high idle (OCV) adjustment range—enhanced fine tuning for pipe.
- Local/Remote switch and receptacle are factory installed.
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown: K6090-11 Pipeliner® 200D

Processes

- Stick
- Flux-Cored⁽¹⁾
- Gouging

Output **CC** **CV**⁽¹⁾ **DC** **1.75** **kw** Input

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K924-5 Remote Control Kit, 100 ft. (for use w/o Wire Feed Module)
- K623-1 Wire Feed Module
- More options at end of section

Literature

E6.132

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Pipeliner® 200D	K6090-11	200A/40V/60%	40-300A DC 1,750 watts DC Auxiliary Power	Kubota® V2203M Diesel EPA Tier 4i	4	27.8 @ 1600	45.5 x 24.0 x 68.0 (1156 x 610 x 1727)	1,302 (590)

⁽¹⁾ With Wire Feed Module. Rated at 200 amps, 35 volts at 60% duty cycle. 250 amps, 30 volts at 35% duty cycle.

Classic® 300D

Excellent for Pipeline, Construction and Maintenance

The Classic® 300D, with proven, rugged construction, is recommended for pipeline, construction and maintenance welding. It features Lincoln's® pure DC generator design for outstanding performance on pipe. Choose Perkins® or Kubota® 4-cylinder, water-cooled industrial diesel engines and add CV wire welding with the optional Wire Feed Module.

- 300 amps @ 60% duty cycle. Welds with up to 7/32" (5.6 mm) Fleetweld® 5P+ cellulosic and Excalibur® low hydrogen electrode.
- 3,000 watts of AC auxiliary power.
- All copper windings enhance arc stability for an extremely smooth arc.
- Five current ranges with overlap and fine-tuning within each range.
- Local/Remote switch and receptacle are factory installed.
- Three-year warranty on welder. (Engine is warranted separately by the manufacturer.)



Shown: K1643-7 Pipeliner® 300D

Processes

- Stick
- Flux-Cored⁽¹⁾
- TIG
- Gouging
- MIG⁽¹⁾

Output **CC** **CV**⁽¹⁾ **DC** **3** **kw** Input

Ready-Pak® Package Includes

- Classic 300D
- Road Trailer & Combination Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- Cable Connectors (qty. 2)
- Electrode Cable 2/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 2/0, 10 ft. (3 m)
- Work Cable 2/0, 50 ft. (15.3 m)
- 300A Electrode Holder
- 300A Work Clamp

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K924-5 Remote Control Kit, 100 ft. (for use w/o Wire Feed Module)
- More options at end of section

Literature

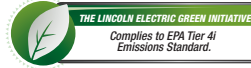
E6.155

⁽¹⁾ With Wire Feed Module. Rated at 300 amps, 35 volts at 60% duty cycle.

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Classic® 300D	K1643-7	250A/30V/100%	40-350A DC	Perkins® 404C-22 Diesel EPA Tier 4i	4	32.7 @ 1800	45.5 x 24.0 x 65.0 (1156 x 610 x 1651)	1354 (614)
Classic® 300D w/Wire Feed Module	K1643-8	300A/32V/60%	3000 watts AC Power					1389 (630)
Classic® 300D One-Pak®	K1864-3							—
Classic® 300D Ready-Pak®	K2242-3							—
Classic® 300D	K1643-9			Kubota® V2203M Diesel EPA Tier 4i		35.5 @ 1800	45.5 x 24.0 x 66.5 (1156 x 610 x 1727)	1320 (599)
Classic® 300D w/Wire Feed Module	K1643-10							1355 (615)
Classic® 300D One-Pak®	K2386-3							—
Classic® 300D Ready-Pak®	K2387-3							—

Vantage® 300

Compact, Multi-Process, Excellent Value



The Vantage® 300 is an ideal choice for construction teams, pipe rig owners and rental fleet managers. Housed in a compact, corrosion-resistant stainless steel case, this rugged welder/generator features Lincoln® Chopper Technology® to deliver great arc starts and a smooth arc for stick, TIG or wire welding.

- **Compact Case** with stainless steel enclosure.
- **Multi-Process Welding**—Four process modes, including CC-Stick (up to 3/16"), Downhill Pipe (for stick), Touch Start TIG® DC or CV-Wire (up to 5/64").
- **Plenty of AC Generator Power**
 - 12.5 kW peak (11 kW continuous) 3-phase 240V AC
 - 11.5 kW peak (10 kW continuous) 1-phase 120/240 AC
- **Arc Gouging**—with up to 1/4" carbons.
- **Reliable Engines**—4 cylinder 1800 RPM Kubota® or Deutz® diesel engines run smooth and quiet.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K2409-3 Vantage® 300

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output Input

Ready-Pak® Package Includes

- Vantage® 300
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Cable Connectors (qty. 2)
- Electrode Cable 2/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 2/0, 10 ft. (3 m)
- Work Cable 2/0, 50 ft. (15.3 m)
- 300A Electrode Holder
- 300A Work Clamp

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K2627-2 Remote Output Control w/120V AC, 100 ft., 20A capacity
- *More options at end of section*

Literature: E6.206

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Vantage® 300	K2409-3	300A/32V/100% 350A/28V/100%	30-400A DC 40-300A Pipe 20-250A DC TIG 14-32V CV	Kubota® V1505 Diesel EPA Tier 4i	4	22 @ 1800	35.9 x 25.3 x 60.0 (913 x 642 x 1524)	1,035 (469)
Vantage® 300 One-Pak®	K2452-3						—	—
Vantage® 300 Ready-Pak®	K2453-3						—	—
Vantage® 300	K2499-3		3-Phase AC Power: 12.5 kW Peak , 11 kW Continuous 1-Phase AC Power: 11.5 kW Peak , 10 kW Continuous	Deutz® D2008L4 Diesel EPA Tier 4i		24 @ 1800	35.9 x 25.3 x 60.0 (913 x 642 x 1524)	1,150 (522)
Vantage® 300 One-Pak®	K2506-3						—	—
Vantage® 300 Ready-Pak®	K2507-3						—	—

Vantage® 400

Compact, Multi-Process, Excellent Value



The Vantage® 400 is one of the most compact 400 amp engine-driven welder/generators in the construction, pipe or rental fleet market today. It's also one of the most quiet, with a smooth running 4-cylinder Perkins® diesel engine. Use this multi-process welder for arc gouging with up to 5/16" carbons, stick welding with up to 1/4" electrodes and CV wire welding with up to 3/32" wire.

- **Standard stainless steel roof**, side panels and engine-access door.
- **Plenty of AC Generator Power**
 - 19 kW peak (17 kW continuous) 3-phase 240V AC.
 - 12 kW peak (11 kW continuous) 1-phase 120/240V AC.
- **Low Noise**—99.1 dBA Lwa sound power (74.8 dB at 23 ft./7 m).
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K2410-3 Vantage® 400

Processes

- Stick
- TIG
- MIG
- Gouging
- Flux-Cored

Output Input

Ready-Pak® Package Includes

- Vantage® 400
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Cable Connectors (qty. 2)
- Electrode Cable 3/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft. (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K2627-2 Remote Output Control w/120V AC, 100 ft., 20A capacity
- *More options at end of section*

Literature: E6.210

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Vantage® 400	K2410-3	400A/36V/100% 450A/32V/100%	30-500A DC 40-300A Pipe 20-250A DC TIG 14-36V CV	Perkins® 404D-22 Diesel EPA Tier 4i	4	32.7 @ 1800	35.9 x 25.3 x 60 (913 x 642 x 1524)	1,230 (559)
Vantage® 400 One-Pak®	K2508-3						—	—
Vantage® 400 Ready-Pak®	K2509-3						—	—
Vantage® 400	K2711-1		3-Phase AC Power: 19 kW Peak , 17 kW Continuous 1-Phase AC Power: 12 kW Peak , 11 kW Continuous	Kubota® V2403M EPA Tier 4i		35.5 @ 1800	35.9 x 25.3 x 60 (913 x 642 x 1524)	1,245 (565)
Vantage® 400 One-Pak®	K2717-3						—	—
Vantage® 400 Ready-Pak®	K2718-3						—	—

NEW! SAE-500 Severe Duty

Great for Off-Shore Salt Spray and Other Corrosive Environments

For offshore and other corrosive environments the SAE-500 Severe Duty (The "Silver Bullet") is the preferred choice—featuring great arc performance, design simplicity, high reliability and extreme ruggedness!

- **Stainless steel and hot-dip galvanized case and internal sheet metal parts.**
 - Stainless steel brushholder assemblies.
 - All copper coils.
 - Coated radiator, fuel tank, laminations and wire connections.
 - Sealed switches.
- **Rugged Construction**—Heavy steel gauge case withstands rough field handling.
- **Spark arrestor and engine air intake shutdown** per Mineral Management Services Code.
- **Large diameter stick welding and arc gouging** with up to 3/8" (10 mm) carbons.
- **Dual Continuous Control**—both current and open circuit voltage for precise control.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K1278-12 SAE-500 Severe Duty

Processes

- Stick
- Gouging

Output

Input

Key Options

- K2637-1 Large Two-Wheeled Road Trailer with Duo-Hitch™. Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- More options at end of section

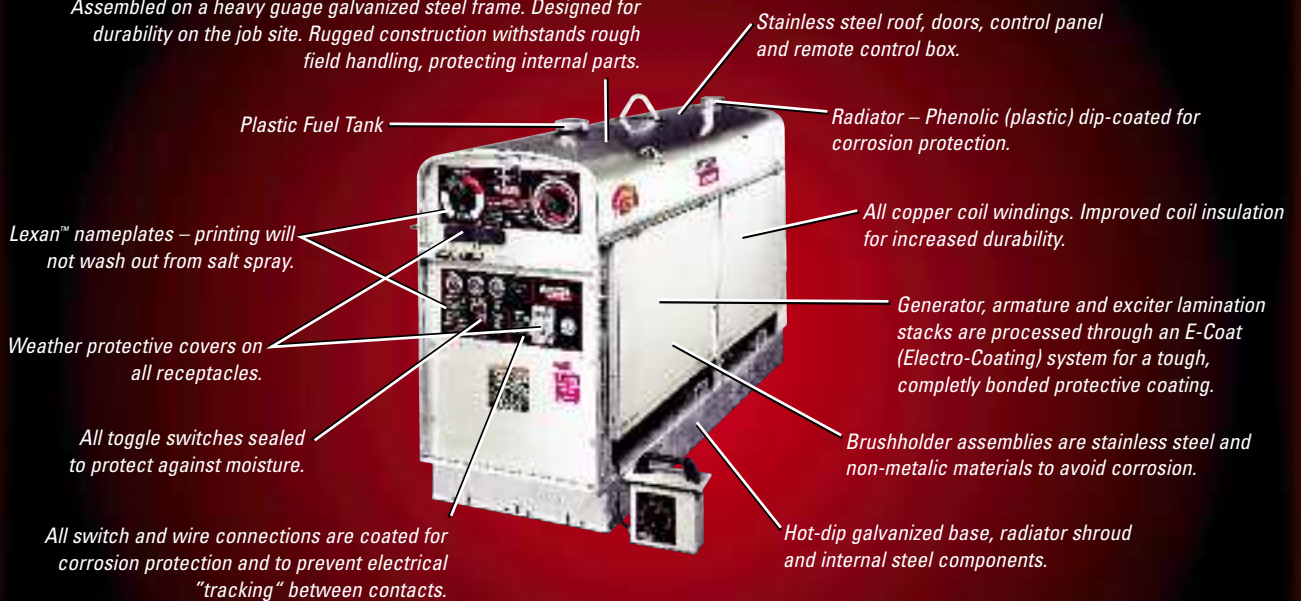
Literature

E6.184

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
SAE-500 Severe Duty	K1278-12	400A/40V/100% 500A/40V/60%	80-575A DC 3,000 watts Power	Kubota® V3600-T Turbo Diesel EPA Tier 4i	4	57.8 @ 1800	50.13 x 28 x 83 (1273 x 711 x 2109)	2,084 (945)

SAE-500 Severe Duty - Corrosion Resistance

Assembled on a heavy gauge galvanized steel frame. Designed for durability on the job site. Rugged construction withstands rough field handling, protecting internal parts.



Designed and Built for the Off-Shore Salt Spray and Other Corrosive Environments

NEW! SAE-500

Heavy Duty Industrial Pipe and Construction Stick Welder



For high amperage stick applications in demanding environments, the SAE-500 delivers 500 amps for DC stick welding and 3,000 watts of AC power. Designed especially for pipeliners and field welders, the SAE-500 is powered by a heavy duty Kubota® industrial turbo-charged diesel engine, offering low maintenance and a long service life.

- **Rugged Construction**—Withstands rough field handling, protecting internal parts.
- **High Welding Output**—60% duty cycle at 500 amps for demanding applications.
- **Dual Continuous Output Control**—Select either a soft “buttery” arc or snappy “digging” arc.
- **Multiple Arcs**—Robust DC weld output makes the SAE-500 the #1 choice for the multi-arc Multi-Weld™ 350 system.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K1278-11
SAE-500

(1) With CV Adapter. Rated at 400 amps, 35 volts at 60% duty cycle.

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
SAE-500	K1278-11	400A/40V/100% 500A/40V/60%	80-575A DC 3,000 watts AC Power	Kubota® V3600-T Turbo Diesel EPA Tier 4i	4	57.8 @ 1800	50.1 x 28 x 83 (1273 x 711 x 2109)	2,048 (928)
SAE-500 One-Pak®	K2726-3						—	—
SAE-500 Ready-Pak®	K2730-3						—	—

Processes

- Stick
- Flux-Cored⁽¹⁾
- TIG
- Gouging

Output **CC** **CV**⁽¹⁾ **DC** **3 kW** Input

Ready-Pak® Package Includes

- SAE-500
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Cable Connectors (qty. 2)
- Electrode Cable 3/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft. (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K924-5 Remote Control Kit, 10 ft. (3.0 m)
- K2637-1 Large Two-Wheeled Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K385-2 CV Adapter
- More options at end of section

Literature

E6.182

Vantage® 500

500 Amps @ 100 Duty Cycle, 20,000 Watts AC Generator Power!



If you're looking for a rugged welder for demanding construction, rental fleet or repair applications, take a close look at the Vantage® 500. Standard stainless steel panels, simple controls and Chopper Technology® deliver the low maintenance, long service life, easy operation and great arc performance every owner appreciates.

- **Corrosion-resistant stainless steel case.**
- **Multi-process powerhouse**—500 amps at 100% duty cycle, or 575 amps at 50%.
- **Plenty of AC Generator Power**
 - 20 kW continuous 3-phase 240V AC
 - 12 kW continuous 1-phase 120/240V AC
- **Digital Weld Meters** and Fuel, Oil Pressure and Engine Temperature gauges.
- **48 HP** oil/air-cooled Deutz® engine.
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown:
K2405-2
Vantage® 500

Processes

- Stick
- Flux-Cored
- TIG
- Gouging
- MIG

Output **CC** **CV** **DC** **20 kW** Input

Ready-Pak® Package Includes

- Vantage® 500
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Electrode Cable 3/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Control, 100 ft.
- More options at end of section

Literature: E6.216

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Vantage® 500	K2405-2	500A/40V/100% 550A/36V/60% 575A/35V/50%	30-575A DC 40-300A Pipe 20-250A DC TIG 14-40V CV	Deutz® D2011 L4i EPA Tier 4i	4	48 @ 1800	50.8 x 31.5 x 63.1 (1290 x 800 x 1603)	1,532 (695)
Vantage® 500 One-Pak®	K2288-3						—	—
Vantage® 500 Ready-Pak®	K2290-3						—	—

3-Phase AC Power:
20 kW Continuous
1-Phase AC Power:
12 kW Continuous

NEW! Vantage® 500 (Compact Case)

Compact Design!



Get a 500 amp welder in a compact case! The same size as the Vantage® 300 and Vantage® 400! A turbo-charged diesel engine with Lincoln's **CT Chopper Technology®** makes this a reality! Also, less weight than traditional 500 amp welders makes the Vantage® 500 compact design a great choice for installation on truck beds where available space and weight capacity are limited.

- **NEW! Compact Case.** One of the most compact 500 amp machines available. Suitable for many pickup and service trucks.
- **Stainless steel enclosure** for corrosion-resistant protection and durability.
- **Multi-Process Welding.** 500 amps at 100% duty cycle for CC-stick, pipe, CV-wire, DC Touch-Start® TIG and arc gouging.
- **NEW! VRD™ Voltage Reduction Device™** for reduced OCV in the CC-Stick weld mode.
- **Plenty of AC Generator Power:**
 - 22 kW peak (20 kW continuous) 3-Phase 240V AC
 - 13 kW peak (12 kW continuous) 1-phase 120/240V AC
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K2686-1 Vantage® 500 (Compact Case)

Processes

- Stick
- Flux-Cored
- TIG
- Gouging
- MIG

Output Input

Ready-Pak® Package Includes

- Vantage® 500
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Electrode Cable 3/0, two 50 ft. (15.3 m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Control, 100 ft.
- *More options at end of section*

Literature: E6.214

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
NEW! Vantage® 500	K2686-1	500A/40V/100% 525A/38V/60%	30-525A DC 40-300A Pipe 20-250A DC TIG 14-40V CV 3-Phase AC Power: 20 kW Continuous 1-Phase AC Power: 12 kW Continuous	Perkins® 404D-22T Turbo Diesel NEW! EPA Tier 4i	4	49 @ 1,850	35.9 x 25.3 x 60.0 (913 x 642 x 1524)	1,445 (655)
NEW! Vantage® 500 One-Pak®	K2724-3						—	—
NEW! Vantage® 500 Ready-Pak®	K2728-3						—	—

Air Vantage® 500

It's Three in One—Welder, Generator and Air Compressor



When you need it all, consider the rugged Air Vantage 500 for railroad, mining, heavy duty construction, and rental fleet use. A direct gear-driven compressor pumps plenty of air for arc gouging with up to 3/8" carbons, plasma cutting or other air tools. A powerful 500 amps @ 100% duty cycle is enough for almost any stick, TIG, MIG or flux-cored welding project.

- **Rotary screw compressor** rated at 60 CFM, 100 PSI, 100% duty cycle.
- **Multi-process powerhouse**—500 amps at 100% duty cycle, or 575 amps at 50%.
- **Plenty of AC Generator Power**
 - 20 kW continuous 3-phase 240V AC
 - 12 kW continuous 1-phase 120/240V AC
- **Stainless steel corrosion-resistant enclosure.**
- **Three-year warranty** on welder. (Engine is warranted separately by the manufacturer.)



Shown: K2325-2 Air Vantage® 500 (Compact Case)

Processes

- Stick
- Flux-Cored
- TIG
- Gouging
- MIG

Output Input

Ready-Pak® Package Includes

- Air Vantage® 500
- Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- Fender and Light Kit
- Cable Rack
- Cable Connectors (qty. 2)
- Electrode Cable 3/0, two 50 ft. (15.3m) lengths
- Electrode Cable 3/0, 10 ft. (3 m)
- Work Cable 3/0, 50 ft (15.3 m)
- 400A Electrode Holder
- 500A Work Clamp

Key Options

- K2636-1 Medium Two-Wheel Road Trailer with Duo-Hitch™: Ball/Eye Hitch Combo
- K704 Accessory Kit, 400 Amp
- K857-1 Remote Control, 100 ft.
- *More options at end of section*

Literature E6.217

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Type of Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Air Vantage® 500	K2325-2	500A/40V/100% 550A/36V/60% 575A/35V/50%	30-575A DC 40-300A Pipe 20-250A DC TIG 14-40V CV 3-Phase AC Power: 20 kW Continuous 1-Phase AC Power: 12 kW Continuous Compressor: 60 CFM, 100 PSI	Kubota® V3600-T Turbo Diesel EPA Tier 4i	4	58 @ 1,850	49.0 x 32.7 x 63.1 (1245 x 831 x 1603)	1,730 (785)
Air Vantage® 500 One-Pak®	K2725-3						—	—
Air Vantage® 500 Ready-Pak®	K2729-3						—	—

Engine Drives: Industrial/Construction Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Pipeliner® 200D*General Options*

K903-1	Spark Arrestor Kit
K2636-1	Medium Two-Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K1858-1	Service Indicator Kit
K2423-1	Stainless Steel Sheet Metal Kit

Stick Options

K704	Accessory Kit, 400 Amp
K875	Accessory Kit, 150 Amp
K924-5	Remote Control Kit, 100 ft.

Wire Feeder Options

K623-1	Wire Feed Module
K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K2464-1	Remote Control Kit, 100 ft.

Classic® 300D (Perkins® and Kubota®)*General Options*

K802D	Power Plug Kit
K903-1	Spark Arrestor Kit
K2636-1	Medium Two-Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K1858-1	Service Indicator Kit
K2423-1	Stainless Steel Sheet Metal Kit

Stick Options

K704	Accessory Kit, 400 Amp
K924-5	Remote Control Kit, 100 ft.

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-4	Control Cable (9-pin to 115V plug)
K937-45	Control Cable Extension, 45 ft.
K814	Arc Start™ Switch
K938-1	Contactor Kit

Wire Feeder Options

K623-1	Wire Feed Module
K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun 10 ft. (3.0 m), .068"-5/64"
K2464-1	Remote Control Kit, 100 ft. (30 m)

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Vantage® 300 (Kubota® and Deutz®)*General Options*

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full KVA Power Plug (1-Phase)
T12153-10	Full KVA Power Plug (3-Phase)
K2636-1	Medium Two-Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-2	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch
K1898-1	Spark Arrestor Kit
K2467-1	Digital Weld Meters Kit (for K2409-1 and K2499-1)
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6m)
K857-1	Remote Output Control, 100 ft. (30m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft. 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K2535-1	Precision TIG® 225 Ready-Pak® Package
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft., .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft., .035"-045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun 10 ft., .068"-5/64"

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Engine Drives: Industrial/Construction Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

SAE-500

General Options

K802D	Power Plug Kit
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp
K2637-1	Large Two-Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-1	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch
K1858-1	Service Indicator Kit
K1735-1	Multi-Weld™ 350 (See Bulletin E5.302)

Stick Options

K704	Accessory Kit, 400 Amp
K924-5	Remote Control Kit

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit for PTW-18 and PTA-26 Series Torches
K930-2	TIG Module
K936-4	Control Cable (9-pin to 115V plug)
K937-45	Control Cable Extension, 45 ft.
K814	Arc Start™ Switch
K938-1	Contacting Kit

Wire Feeder Options

K385-2	CV Adapter (with MS-Type connection, local/remote switch)
K316L-2	LN™-23P Wire Feeder
K2379-1	SAE-400 & SAE-500/LN™-23P Interface Kit
K385-1	CV Adapter (w/o MS-Type connection, local/remote switch)
K316L-1	LN™-23P Wire Feeder
K345-10	350A FCAW-SS Gun 10 ft. (3.0 m), .068"-5/64
K350	LN™-23P Adapter Kit, for Terminal Strip Connection
K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft. (4.5 m), .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-0.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft. (4.5 m), .035"-0.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid

SAE-500 Severe Duty

General Options

K802D	Power Plug Kit
K1690-1	GFCI Receptacle Kit, 120V, 20 Amp
K2637-1	Large Two Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-1	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch

Stick Options

K704	Accessory Kit, 400 Amp
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Vantage® 400 (Perkins® and Kubota®)

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full-KVA Power Plug (1-Phase)
T12153-10	Full-KVA Power Plug (3-Phase)
K2636-1	Medium Two-Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-2	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch
K903-1	Spark Arrestor Kit
K1858-1	Service Indicator Kit
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit
K2679-1	Cold Weather Heater and Tarp Kit (Perkins®)
K2679-2	Cold Weather Heater and Tarp Kit (Kubota®)

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit For PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K2535-1	Precision® TIG 225 Ready-Pak® Package
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun 15 ft. (4.5 m), .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-0.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun Package, 15 ft. (4.5 m), .035"-0.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun 10 ft. (3.0 m), .068"-5/64"

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1580-1	Pro-Cut® 55 with 25 ft. Torch
K1816-1	Full-KVA Adapter Kit (1-phase)

Engine Drives: Industrial/Construction Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Vantage® 500 (Deutz® and Perkins®)

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full-KVA Power Plug (1-Phase)
T12153-10	Full-KVA Power Plug (3-Phase)
K2636-1	Medium Two Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-2	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch
K887-1	Ether Start Kit (Deutz)
K899-1	Spark Arrestor Kit (Deutz)
K903-1	Spark Arrestor Kit (Perkins)
K1858-1	Service Indicator Kit (Perkins)
K2356-1	Control Panel Cover Kit (Deutz)
K2340-1	Lockable Fuel Cap/Flash Arrestor Kit (Deutz)
K2679-1	Cold Weather Heater & Tarp Kit (Perkins)
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit for PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K2535-1	Precision® TIG 225 Ready-Pak® Package
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft. (4.5 m), .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-0.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft. (4.5 m), .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun 10 ft. (3.0 m), .068"-5/64"

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1581-1	Pro-Cut® 80 with 25 ft. Torch
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Air Vantage® 500

General Options

K802N	Power Plug Kit, 20 amp
K802R	Power Plug Kit, 15 amp
T12153-9	Full-KVA Power Plug (1-Phase)
T12153-10	Full-KVA Power Plug (3-Phase)
K2636-1	Medium Two Wheel Trailer & Duo-Hitch™ Ball/Eye Hitch
K2639-1	Fender and Light Kit
K2640-1	Cable Rack
K2641-2	Four-Wheel Yard Trailer with Duo-Hitch™ Ball/Eye Hitch
K2354-2	Air Dryer Kit (Kubota®)
K2356-1	Control Panel Cover Kit
K2340-1	Lockable Fuel Cap/Flash Arrestor Kit
K2359-2	Cold Weather Heater and Tarp Kit (Kubota®)
K2642-1	Polarity/Multi-Process Switch
K2663-1	Docking Kit

Stick Options

K704	Accessory Kit, 400 Amp
K857	Remote Output Control, 25 ft. (7.6 m)
K857-1	Remote Output Control, 100 ft. (30 m)
K2627-2	Remote Output Control with 120V AC, 100 ft. (30 m), 20 amp capacity

TIG Options

K1783-9	Pro-Torch™ TIG Torch PTA-26V (25 ft., 2 pc)
KP509	Parts Kit for PTW-18 and PTA-26 Series Torches
K870	Foot Amptrol®
K963-3	Hand Amptrol® (Rotary Track Style)
K2535-1	Precision TIG® 225 Ready-Pak® Package
K1816-1	Full-KVA Adapter Kit (1-phase)
K2350-2	Invertec® V205-T AC/DC One-Pak®
K1816-1	Full-KVA Adapter Kit (1-phase)

Wire Feeder Options

K2613-1	LN™-25 PRO Wire Feeder w/Internal Contactor & Gas Solenoid
K126-2	350A FCAW-SS Gun, 15 ft. (4.5 m), .062"-3/32"
KP1697-068	Drive Roll Kit, .068"-0.072" Cored/Solid
KP1697-5/64	Drive Roll Kit, 5/64" Cored/Solid
K1802-1	Magnum® 300 Gun and Cable Assembly, 15 ft. (4.5 m), .035"-.045"
KP1696-1	Drive Roll Kit, .035" and .045" Solid
K316L-2	LN™-23P Wire Feeder
K2393-1	Input Cable Assembly for LN™-23P, 25 ft. (7.6 m)
K2393-2	Input Cable Assembly for LN™-23P, 75 ft. (22.9 m)
K345-10	350A FCAW-SS Gun, 10 ft. (3.0 m), .068"-5/64"

Spool Gun Options

K487-25	Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)
K488	SG Control Module
K691-10	Control Module Input Cable, 14-pin MS-type & Lug, 10 ft.

Plasma Cutting Options

K1581-1	Pro-Cut® 80 with 25 ft. Torch
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SEMI-AUTOMATIC WIRE FEEDERS



- Designed for MIG or Flux-Cored Processes
- Models for Shop Fabrication or Field Construction

	MODEL	PROCESS					WIRE FEED SPEED RANGE ipm (m/min) High Speed Low Speed	WIRE SIZE RANGE in. (mm)		MAXTRAC Wire Drive System	FEATURES		
		MIG	Pulsed MIG	MIG-STT®	Flux-Cored	Submerged Arc		High Speed Solid Low Speed Solid	High Speed Cored Low Speed Cored		ArtLink®	2-Roll Drive	4-Roll Drive
Digital	Power Feed™ 25M	●	●	●	●		50-800 (1.3-20.3) 30-400 (0.76-10.1)	.023-1/16 (0.6-1.6)	.030-3/32 (0.8-2.4) .030-5/64 (0.8-2.0)	✓	●	●	
	Power Feed™ 10M	●	●	●	●		75-1200 (2.0-30.5) 50-800 (1.27-20.3)	.025-1/16 (0.6-1.6) .025-3/32 (0.6-2.4)	.035-5/64 (0.9-2.0) .035-1/20 (0.9-3.0)		●	●	
	Power Feed™ 10M Dual	●	●	●	●		75-1200 (2.0-30.5) 50-800 (1.27-20.3)	.025-1/16 (0.6-1.6) .025-3/32 (0.6-2.4)	.035-5/64 (0.9-2.0) .035-1/20 (0.9-3.0)		●	●	
Analog	LF-72	●	●		●		50-800 (1.3-20.3)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	✓		●	
	LF-74	●	●		●		100-800 (2.5-20.3)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	✓		●	
	LF-74 Extra Torque	●	●		●		50-400 (1.3-10.1)	.023-1/16 (0.6-1.6)	.030-3/32 (0.8-2.4)	✓		●	
	LN™-10	●			●	●	55-1250 (1.3-31.7) 35-750 (0.8-19.0)	.023-1/16 (0.6-1.6) .023-5/64 (0.6-2.4)	.035-5/64 (0.9-2.0) .035-1/8 (0.9-3.2)			●	
	DH-10	●			●	●	55-1250 (1.3-31.7) 35-750 (0.8-19.0)	.023-1/16 (0.6-1.6) .023-3/32 (0.6-3.0)	.035-5/64 (0.9-3.0) .030-1/8 (0.8-3.2)			●	
	STT®-10			●			35-500 (0.8-12.7)	.023-.052 (0.6-1.4)	—			●	
Field	LN™-15	●	●	●	●		50-700 (1.3-17.8)	—	.035-1/16 (0.9-1.6)	✓	●	●	
	LN™-23P				●		30-170 (0.76-4.3)	.023-.052 (0.6-1.3)	.068-5/64 (1.7-2.0)			●	
	LN™-25 Pro	●	●		●		50-700 (1.3-17.7)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	✓		●	
	LN™-25 Pro Extra Torque	●	●		●		30-400 (0.8-10.1)	.023-1/16 (0.6-1.6)	.030-3/32 (0.8-2.4)	✓		●	
	LN™-25 Pro Dual Power	●	●		●		50-700 (1.3-17.7)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	✓		●	
	LN™-35				●		50-600 (1.3-12.8)	—	.035-7/64 (0.9-2.8)			●	
	Cobramatic®	●	●				0-800 (0-20.3)	.030-1/16 (0.8-1.6)	.030-1/16 (0.8-1.6)			●	

KEY: ● Excellent ● Good ● Optional

Power Feed™ 25M

Premium Welding Solution with a Portable Design!



Lincoln offers this full featured design in a robust package that can meet industry challenges. The lightweight construction, durable case, as well as the patented design of the MAXTRAC® wire drive system delivers the results you need.

- **Push-Pull Capability** is a standard function that delivers premier aluminum performance by offering uniform feeding, as well as a flexible system for extending the gun.
- **Hardened and Construction Ready.** Built tough for rough environments. From construction to shipbuilding, this design will meet your expectations. Packaged standard with either a durable aluminum or plastic case.
- **Internal Lighting.** High intensity LEDs illuminate the wire drive.
- **Internal heating** maintains control of humidity on your consumable by keeping the package warmed and protected in an enclosed case.
- **Mode Select Panel (MSP4)** allows easy access to the Power Wave® library of waveforms. Advanced controls and set-up options are only a fingertip away!
- **Dual Procedure and Memory Buttons** allow you to set-up an A and B procedure to simplify “on-the-fly” switching.
- **Three-year warranty** on parts and labor.



Shown: K2536-2 Power Feed™ 25M (Aluminum Case)

Processes

- MIG
- Pulsed
- STT®
- Flux-Cored
- Stick
- TIG
- Gouging

Output

Input

Unit Includes

- Electrode Pigtail
- MSP4 Panel
- Dual Procedure/Memory Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

Key Options

- Magnum® Gun & Cable Assemblies
- Self-Shielded Gun & Cable Assemblies
- K2447-2 Python®-Plus Push-Pull Gun
- K1543-25 ArcLink®/Linc-Net™ Control Cables
- K1733-4 MicroWire Straightener
- More options at end of section

Literature

E8.271

Product Name	Product Number	Input Power	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range – Solid in. (mm)	Wire Size Range – Cored in. (mm)	H x W x D in. (mm)	Net Weight lbs. (kg)
Power Feed™ 25M	K2536-2 (Aluminum Case)	40 VDC	Standard Speed (factory setting)	Solid: 50-800 (2.5-20.3) Cored: 50-800 (2.5-20.3)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	14.5 x 8.5 x 23.5 (368 x 216 x 597)	35 (15.9)
	NEW! K2536-3 (Plastic Case)		Extra Torque	Solid: 30-400 (1.3-10.4) Cored: 30-400 (1.3-10.4)				

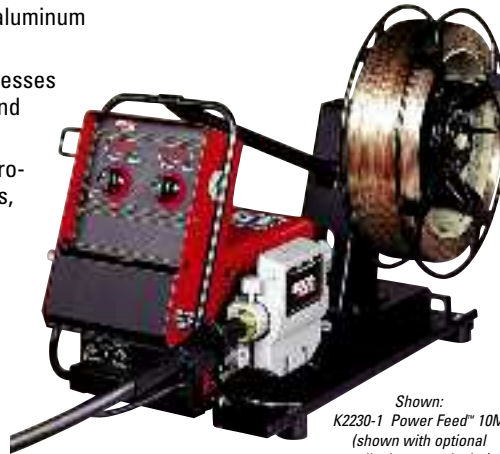
Power Feed™ 10M

Single and Dual Bench Wire Feeders



When you need a versatile, multi-process industrial wire feeder for welding virtually any material, you need the Power Feed™ 10M. Choose the Power Feed™ 10M for automotive manufacturing, shipbuilding, pressure vessels/heavy plate, oil, gas and pipeline construction, particularly when code-quality work is required.

- **World-class arc performance** on steel, stainless steel, aluminum and other materials.
- **Waveform Control Technology®** featuring patented processes like Pulse-On-Pulse®, for a TIG-like bead appearance, and Power Mode®, for a stable arc at low current levels.
- **Utilizes ArcLink®**—the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration with the power source.
- **Pulsed MIG process**—great for low spatter, low heat input and out-of-position applications—makes virtually any operator a better welder!
- **Easy-to-understand user interface panel** with large numeric displays make it easy to set weld parameters.
- **Features push-pull capability** for great performance on aluminum.
- **Three-year warranty** on parts and labor.



Shown: K2230-1 Power Feed™ 10M (shown with optional coil adapter and wire)

Processes

- MIG
- Pulsed
- STT®
- Flux-Cored
- Stick
- TIG
- Gouging

Output

Input

Dual Bench Model Includes

- Wire Reel Stand
- MSP4 Panel
- Dual Procedure/Memory Panel
- ArcLink®/Linc-Net™ Control Cable
- Weld Power Cable, 8 ft.
- High Speed Pinion Gear
- Power Wave® Utilities CD-ROM with Weld Manager®

Key Options

- K1543-XX ArcLink®/Linc-Net™ Control Cable
- K1733-1 Wire Straightener
- K2593-XX Coaxial Weld Power Cable
- More options at end of section

Literature

E8.266

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range in/min (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs. (kg)
Power Feed™ 10M Single Bench Model	K2230-1	40 VDC	600A/60% 500A/100%	High Speed: 75-1200 (2.0-30.5) Low Speed: 50-800 (1.27-20.3)	High Speed: Solid: .025-1/16 (0.6-1.6) Cored: .035-5/64 (0.9-2.0) Low Speed: Solid: .025-3/32 (0.6-2.4) Cored: .035-.120 (0.9-3.0)	18.5 x 13.5 x 30.5 (470 x 343 x 775)	62 (28.1)
Power Feed™ 10M Dual Bench Model	K2234-1			20.0 x 20.0 x 30.7 (508 x 508 x 781)	90 (40.8)		

Power Feed™ 10M

Single and Dual Boom Wire Feeders



- Processes**
- Flux-Cored
 - MIG
 - Pulsed
 - STT®
 - Stick
 - TIG
 - Gouging

Output **Input**

Dual Boom Model Includes

- MSP4 Panel
- Dual Procedure/Memory Panel
- Gun Trigger Cable
- ArcLink®/Linc-Net™ Control Cables, 8 ft. (2.4 m) & 25 ft. (7.6 m)
- Hardware Kit (high speed pinion gear, mounting hardware)
- Power Wave® Utilities CD-ROM with Weld Manager®

Key Options

- Magnum® Gun & Cable Assemblies
- K1733-1 Wire Straightner
- K2593-100 Coaxial Weld Power #1 Cable, 100 ft.
- KP1505-030S Drive Roll Kit – .023-.030" (0.6-0.8 mm) Solid Wire

Literature
E8.267

The Power Feed™ 10M single or dual industrial wire feeders are recommended for multi-process wire welding in the automotive manufacturing, pressure vessels/heavy plate, or job shop fabrication industries, particularly when code quality work is required.

- **Waveform Control Technology®** featuring patented processes like Pulse-On-Pulse®, for a TIG-like bead appearance, and Power Mode®, for a stable arc at low current levels.
- **ArcLink® capability** for networking welding equipment.
- **Pulsed MIG process**—great for low spatter, low heat input and out-of-position applications—makes virtually any operator a better welder!
- **Easy-to-understand user interface panel** with large numeric displays so it's easy to set weld parameters.
- **Weld Manager® software**, for wireless remote access to system configuration, allowing you to manage one or many welding systems from the palm of your hand.
- **Three-year warranty** on parts and labor.



Shown:
K2314-1 Power Feed™ 10M
Single Boom Model

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs. (kg)
Power Feed™ 10M Single Boom Model	K2314-1	40 VDC	600A/60% 500A/100%	High Speed: 75-1200 (2.0-30.5) Low Speed: 50-800 (1.27-20.3)	High Speed: Solid: .025-1/16 (0.6-1.6) Cored: .035-5/64 (0.9-2.0) Low Speed: Solid: .025-3/32 (0.6-2.4) Cored: .035-.120 (0.9-3.0)	Control: 13.0 x 8.5 x 4.0 (330 x 215 x 105)	8.5 (3.8)
						Wire Drive: 7.6 x 12.9 x 13.7 (195 x 325 x 345)	30 (13.6)
Power Feed™ 10M Dual Boom Model	K2316-1					Control: 13.0 x 8.5 x 4.0 (330 x 215 x 105)	8.5 (3.8)
						Wire Drive: 9.0 x 19.0 x 15.5 (228 x 483 x 394)	50 (22.7)

LF-72

2-Roll Heavy Duty Industrial Feeder



- Processes**
- MIG
 - Pulsed
 - Flux-Cored

Output **Input**

Base Model (K2327-4) Includes
• .035/.045" Drive Rolls and Guide

Required Options
Weld Power Cable

Key Options

- K2330-1 Postflow and Burnback Timer Kit
- K2329-1 Remote Voltage Control Kit
- K1546-1 Incoming Bushing for Lincoln Conduit
- *More options at end of section*

Literature
E8.11

Designed for MIG and cored wire welding in job shop and manufacturing environments, the rugged LF-72 is built to deliver reliable performance day after day.

- **Patented MAXTRAC® heavy-duty cast aluminum wire drive system** provides reliable feeding and durability.
- **Brass-to-brass gun connections** for better electrical conductivity that results in better arc performance.
- **Totally tool-less drive rolls and wire guide installation.** Two gear-driven wire drive rolls slide on and off easily!
- **Calibrated wire feed speed dial** for precise and accurate settings.
- **In addition to great mild steel performance,** these feeders deliver positive arc starting and feeding with stainless steel, aluminum and flux-cored wires!
- **Control cable connector with a Spin-Nut™** makes connecting the control cable a simple twist-of-the-wrist.
- **Three-year warranty** on parts and labor.



Shown:
K2327-2 LF-72 Bench Model
Standard Duty
(shown with optional wire.)

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)	H x W x D in. (mm)	Net Weight lbs. (kg)
LF-72 Base Model (no gun, no cable)	K2327-4	24-42 VAC 50/60 Hz 9 Amps	500A/60% 400A/100%	50-800 (1.3-20.3)	Solid: .023-1/16 (0.6-1.6) Cored: .030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	27 (12)
LF-72 Bench Model Standard Duty ⁽¹⁾	K2327-2					12.6 x 10.9 x 22.5 (320 x 277 x 574)	53 (24)
LF-72 Bench Model Heavy Duty	K2327-3					15.3 x 13.0 x 27.7 (389 x 330 x 704)	68 (31)

⁽¹⁾44 lbs. (19.9 kg) spool, max.

LF-74

4-Roll Heavy Duty Industrial Feeder



Designed for MIG and cored wire welding in job shop and manufacturing environments, the rugged LF-74 wire feeders are built to deliver reliable performance day after day. Select the LF-74 for large diameter wires, longer gun cables or long boom conduit or hard automation applications.

- Patented MAXTRAC® heavy-duty cast aluminum wire drive system provides reliable feeding and durability.
- Brass-to-brass gun connections for better electrical conductivity that results in better arc performance.
- Totally tool-less drive rolls and wire guide installation. Four gear-driven wire drive rolls slide on and off easily!
- Calibrated wire feed speed dial for precise and accurate settings.
- In addition to great mild steel performance, these feeders deliver positive arc starting and feeding with stainless steel, aluminum and flux-cored wires!
- Control cable connector with a Spin-Nut™ makes connecting the control cable a simple twist-of-the-wrist.
- Three-year warranty on parts and labor.



Shown:
K2426-3
LF-74 Bench Model
Heavy Duty, Extra Torque

Processes

- MIG
- Pulsed
- Flux-Cored

Output Input 24-42 VAC 60/50 Hz

Base Model Includes

- Control Cable, 15 ft. (4.5 m)
- .035/.045" Drive Rolls and Guide

Required Options

- Weld Power Cable

Key Options

- K2330-1 Postflow and Burnback Timer Kit
- K2329-1 Remote Voltage Control Kit
- K1546-1 Incoming Bushing for Lincoln® Conduit
- K162-1 Spindle Adapter For Readi-Reels and Spools
- *More options at end of section*

Literature

E8.11

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
LF-74 Base Model	K2426-1	24-42 VAC 50/60 Hz 9 Amps	600A/60% 500A/100%	100-800 (2.5-20.3)	Solid: .023-1/16 (0.6-1.6) Cored: .030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	46 (21)
LF-74 Bench Model Heavy Duty	K2426-2					15.3 x 13.0 x 27.7 (389 x 330 x 704)	71 (32)
LF-74 Bench Model Heavy Duty, Extra Torque	K2426-3			50-400 (1.3-10.1)	Solid: .023-1/16 (0.6-1.6) Cored: .030-3/32 (0.8-2.4)		71 (32)

LN™-10

Single Header Wire Feeder

The LN™-10 semiautomatic wire feeder features the revolutionary split wire guide which precisely aligns and supports the wire through the entire feeding system. The system also features a rugged 4 driven roll design for positive wire feeding. The LN™-10's modular design provides for many mounting options, including boom mounting.

- Standard dual procedure allows operator to set different voltage and wire feed speeds and switch between the two.
- Selectable trigger control for standard 2-step, interlocking 4-step, spot weld and cold feed trigger control.
- Digital Display standard.
- Preflow/Postflow/Burnback and Spot Timer standard.
- Three-year warranty on parts and labor.



Shown:
K1559-3
LN™-10 Bench Model
(standard speed)

Processes

- MIG
- Pulsed
- Flux-Cored

Output Input 42 VAC 60/50 Hz

Bench Model (Standard Speed) Includes

- Control Cable, 10 ft. (3.0 m)

Required Options

- Drive Roll Kit
- Weld Power Cable

Key Options

- K1501-10 Control Cable
- K1798 Terminal Strip Adapter Cable
- K1785-12 Control Cable (Heavy Duty), 12 ft. (3.6 m)
- K1785-16 Control Cable (Heavy Duty), 16 ft. (4.8 m)
- *More options at end of section*

Literature

E8.200

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
LN™-10 Bench Model (Standard Speed)	K1559-3	42 VAC 50/60 Hz 6 amps	600A/60% 500A/100%	Low Gear: 35-750 (0.8 19.0)	Solid: .023-3/32 (0.6-2.4) Cored: .035-1/8 (0.9-3.2)	16 x 15 x 31 (406 x 381 x 787)	65 (29.5)
LN™-10 Generic Boom Package	K1564-4						

NOTE: All units include 10 ft. (3.0 m) control cable. Boom packages also include a 25 ft (7.6 m) control cable/welding cable (3/0) assembly.

DH-10

Double Header Wire Feeder

Precision times two! This DH-10 dual wire feeder utilizes Lincoln's® revolutionary split wire guide system to precisely align and feed wire, and its dual wire feeder system allows you to weld with two different wires, with two different welding procedures using one power source.

- Each side of the DH-10 wire drive system is driven by its own motor and gear box for confidence that the feeder won't go down.
- Split wire guide and 4 driven rolls for positive wire feeding.
- Presetable voltage and wire feed speed for extra control.
- Standard dual procedure allows operator to set different voltage and wire feed speeds and switch between the two.
- Selectable trigger control for standard 2-step, interlocking 4-step, spot weld and cold feed trigger control.
- Digital Display standard.
- Preflow/Postflow/Burnback & Spot Timer standard.
- Three-year warranty on parts and labor.



Processes

- MIG
- Pulsed
- Flux-Cored

Output Input

Bench Model (Std./Std. Speed) Includes

- Control Cable, 10 ft. (3.0 m)

Required Options

- Drive Roll Kit
- Weld Power Cable

Key Options

- K1501-10 Control Cable
- K1798 Terminal Strip Adapter Cable
- K1785-12 Control Cable (Heavy Duty), 12 ft. (3.6 m)
- K1785-16 Control Cable (Heavy Duty), 16 ft. (4.8 m)
- Fume Extraction System
- More options at end of section

Literature
E8.200

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
DH-10	K1499-3	42 VAC 50/60 Hz 6 Amps	600A/60% 500A/100%	35-750 (0.8-19.0)	Solid: .023-3/32 (0.6-2.4) Cored: .035-1/8 (0.9-3.2)	21 x 20 x 32 (533 x 508 x 813)	98 (44.4)
DH-10 Generic Boom Package	K1521-7						
DH-10 (Std./High Speed)	K1499-4			Std: 35-750 (0.8-19.0) High: (55-1250 (1.3-31.7)	Solid: .023-3/32 (0.6-2.4) Cored: .030-1/8 (0.8-3.2) Solid: .023-1/16 (0.6-1.6) Cored: .035-5/64 (0.9-2.0)		

NOTE: All units include 10 ft. (3.0 m) control cable. Boom packages also include a 25 ft (7.6 m) control cable/welding cable (3/0) assembly.

STT®-10

Semiautomatic Wire Feeder

The sophisticated STT®-10 Process Controller was designed specifically to work with the revolutionary STT® II power source. Its microprocessor controls make the STT®-10 easy to develop optimal procedures and set the range of operator adjustments.

- Presetable background and peak current settings for optimum starting performance.
- Split wire guide and four drive rolls for positive feeding.
- Modular design for many mounting options.
- Range control keeps procedures in the "sweet spot".
- Four step trigger for "cruise control" on long welds and hard automation.
- Three-year warranty on parts and labor.



Processes

- MIG-STT®

Output Input

Required Options

- Drive Roll Kit

Key Options

- K1758-50 Control Cable, 50 ft. (15.2 m).
- K940-25 Sense Lead Kit, 25 ft. (7.6 m)
- More options at end of section

Literature
E4.52

Product Name	Product Number	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
STT®-10	K1560-2	35-500 (0.8-12.7)	Solid: .023-.052 (0.6-1.4)	16 x 15 x 31 (406 x 381 x 787)	65 (29.5)

LN™-15

Portable, Semiautomatic Wire Feeder



The LN™-15 is one of the smallest and most maneuverable wire feeders for the construction, shipbuilding and pipeline industries available on the market today. The LN™-15 is available in both Across-The-Arc and Control Cable versions. Both offer outstanding welding performance, including pulse welding, on a wide variety of steel, stainless steel, aluminum and alloy materials.

- **Designed for MIG, Pulsed MIG, Flux-Cored, and Metal-Cored welding processes** using light weight 8" (203 mm) diameter spools.
- **Illuminated digital meters** are easy to read in adverse lighting conditions.
- **Fully enclosed molded case** is heat, spatter and impact resistant.
- **Double latch case seals tight** to protect drive system and wire from dirt, dust and rain.
- **Full body aluminum roll cage** provides sturdy impact protection and all-around handles for easy portability.
- **Adjustable carrying strap** makes it easy to carry and hang.
- **Compact unit** fits easily through 14" diameter manhole/manway.
- **Three-year warranty** on parts and labor.



Shown:
K1870-1 LN™-15
Across-The-Arc

Shown:
K1871-1 LN™-15
Control Cable

- Processes**
- MIG
 - Pulsed
 - MIG-STT® (Control Cable Model only)
 - Flux-Cored

Output

- Unit Includes**
- K1500-2 Gun Receiver Bushing
 - Carrying Strap
 - Spindle Adapter for 8" O.D. Spools
 - Standard Contactor (Across-The-Arc Model)

- Required Options**
- Drive Roll Kit

- Key Options**
- K1500-1 Gun Receiver Bushing
 - K1500-2 Gun Receiver Bushing
 - K1797-25 Control Extension Cable, 25 ft. (7.6 m)
 - K1797-50 Control Extension Cable, 50 ft. (15.2 m)
 - *More options at end of section*

Literature
E8.60

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
LN™-15 Across-The-Arc	K1870-1	15-110 VDC	300A/60%	50-700 (1.3-17.8)	Solid: .023-.052 (0.6-1.3) Cored: .035-1/16 (0.9-1.6)	12.7 x 8.7 x 23 (356 x 188 x 533)	30 (15.4)
LN™-15 Control Cable	K1871-1	42 VAC	500A/60%				28 (12.7)

LN™-23P

Semiautomatic Wire Feeder

The LN™-23P semiautomatic wire feeder is able to handle the toughest work sites and is an excellent choice for field erection and pipe welding applications. It is portable, easy to set-up, and ideal for reaching difficult locations.

- **Weighs less than 50 lbs. (22.7 kg)** including optional Innershield® gun and 14 lb (6.3 kg) coil of electrode.
- **Continuous wire feed speed control**, voltage control and analog voltmeter are standard.
- **Completely enclosed wire reel** keeps the wire free of contaminants.
- **Equipped with trigger interlock circuit** to reduce operator fatigue.
- **Gun-mounted two-position switch** allows on-the-fly change to 83% of the preset wire feed speed.
- **Electrode and control cable quickly connect** to power source.
- **One or two LN™-23P wire feeders can be directly connected** to recommended Lincoln® power sources, but only one can be used at a time.
- **Three-year warranty** on parts and labor.



Shown:
K316L-1 LN™-23P
(shown with options)

- Processes**
- Innershield

Output

- Unit Includes**
- 25 ft. (7.6m) Control Cable
 - 25 ft. (7.6m) 1/0 Electrode Cable
 - 3/32" Drive Rolls and Guide Tubes

- Required Options**
- Adapter Kit
 - FCAW-SS 90° Nozzle
 - *More options at end of section*

Literature
E8.90

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
LN™-23P	K316L-1 K316L-2 ⁽¹⁾	14-50V DC (90V DC Max. OCV)	350A/60%	30-170 (0.76-4.3)	.068-5/64 (1.7-2.0)	20.5 x 9 x 19 (520 x 230 x 480)	27 (12.3)

⁽¹⁾ See Engine Drive Section for compatible equipment.

LN™-25 PRO

Portable Industrial Wire Feeder



The LN™-25 PRO is designed to be simple, reliable and easy to service. The LN™-25 PRO is ideal for field construction and fabrication, shipyards, and rental companies.

- The LN™-25 PRO is available in 3 models: Standard, Extra Torque, and Dual Power.
- The Extra Torque model features additional torque gearing for reliable feeding of large diameter flux-cored wires.
- The Dual Power model features a voltage control knob for superior arc control, digital meters for increased monitoring, MIG-STT® capability, and can be powered by either a control cable or across the arc.
- Non-linear wire feed speed gives single range control, yet maintains sensitivity with low wire feed speed.
- Lightweight, impact and flame resistant polycarbonate case design keeps the internal components protected.
- Potted and trayed PC board protects against moisture and corrosion.
- Case can be replaced in less than 5 minutes – eliminates downtime.
- Timer Kit available – includes preflow, postflow and burnback.



Processes

- MIG
- Pulsed
- Flux-Cored

Output



Input



LN™-25 PRO Includes

- Internal Contactor
- Gas Solenoid
- Flowmeter
- Arc Sensing Lead & Clip, 15 ft. (4.5m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

Required Options

- Drive Roll and Guide Kit

Key Options

- More options at end of section

Power Sources

All electric or engine drive welders with CV capability.

Literature

E8.105

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Gas Solenoid & Flow Meter	Wire Feed Speed Range ipm (m/min)	Wire Size Range - in. (mm)			H x W x D in. (mm)	Net Weight lbs.(kg)
						Solid	Cored	Aluminum		
LN™-25 PRO Standard	K2613-1	15-110V DC	325A/100% 450A/60%	YES	50-700 (1.3-17.7)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	.035-1/16 (0.9-1.6)	15 x 8 x 22 (381 x 203 x 558)	37 (16)
LN™-25 PRO Extra Torque	K2613-2				30-400 (0.8-10.1)		.030-3/32 (0.8-2.4)			
NEW! LN™-25 PRO Dual Power	K2614-1	15-110V DC or 24-42V AC			50-700 (1.3-17.7)		.030-5/64 (0.8-2.0)			

Introducing the

NEW! LN™-25 PRO Dual Power



FEED THE NEED

The Best Just Got Better!

The dual power model features a voltage control knob for remote arc control as well as digital meters to monitor voltage and wire feed speed. This model can be powered by control cable OR across-the-arc. (Patent pending).



LN™-35

Rugged, Portable Wire Feeder

The LN™-35 is an across-the-arc, semiautomatic wire feeder for hardfacing and fabrication applications using self-shielded, flux-cored welding electrodes.

- The LN™-35 is designed to feed .035-7/64" (0.9-2.8 mm) flux-cored electrodes.
- Enhanced starting control for smooth arc starting in CV mode.
- Electronic circuits protect wire feeder from overload.
- Adjustable wire feed speed for settings of 50-500 ipm (1.3-12.8 m/min).
- Three-year warranty on parts and labor.



Shown:
K2281-1
LN™-35 Across-The-Arc

Processes

- Flux-Cored (Self-Shielded Wires only)

Output

Unit Includes

- Wire Reel Stand
- Coil Adapter and Case

Key Options

- K1840-10 Weld Power Cable – Twist-Mate™-to-Lug, 10 ft. (3.0 m)
- K1842-10 Weld Power Cable – Lug-to-Lug, 10 ft. (3.0 m)
- K1842-35 Weld Power Cable – Lug-to-Lug, 35 ft. (10.6 m)
- K1842-60 Weld Power Cable – Lug-to-Lug, 60 ft. (9.1 m)
- More options at end of section

Literature

E8.110

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
LN™-35 Across-The-Arc	K2281-1	15-40V DC (Max. OCV: 110V DC)	500A/60%	50-500 (1.3-12.8)	Cored: .035-7/64 (0.9-2.8)	27.0 x 10.0 x 30.0 (686 x 254 x 762)	82 (37)

NOTE: A constant voltage (CV) power source is recommended for self-shielded, flux-cored arc welding (FCAW-S). The LN™-35 may be used with a constant current (CC) power source for non-critical applications where weld quality and deposition properties are not critical.

Cobramatic®

Push-Pull Cabinet

The Cobramatic® incorporates a push-pull drive system that virtually eliminates the problems associated with wire feeding. Cobramatic® is a great MIG welding choice for all wire types.

- Push-pull wire drive system yields reliable, consistent, trouble-free wire feeding up to 50 ft. (15.2 m) from the cabinet.
- Compatible with complete line of Lincoln® push-pull guns.
- Feeds aluminum wire diameters .030-1/16" (0.8-1.6 mm) with only a contact tip change.
- Patented paddle holds wire straight and level during feeding to minimize damage to the wire.
- Patented clutch/brake system keeps wire from over running on shut-off.
- Tool-less spool brake adjustment knob allows for easy tension adjustment.
- Simplified wire tension adjustment using two position steel/aluminum selector for foolproof operation.
- Three-year warranty on parts and labor.



Shown:
K2259-1
Cobramatic

Processes

- MIG
- Pulsed

Output

Input

Unit Includes

- 14-Pin Control Cable, 8 ft. (5.4 m)
- Gas Purge/Trigger Latch Kit

Required Options

- Python® Push-Pull Gun
- CobraMAX™ Push-Pull Gun

Key Options

- K1520-1 42 Volt Transformer Kit
- K1679-1 Control Cable for Power Wave® 450 ONE
- More options at end of section

Literature

E8.300

NOTE: Cobramatic®, CobraMAX™, Prince® XL and Python® are registered trademarks of MK Products, Inc.

Product Name	Product Number	Input Power	Output Capacity ⁽¹⁾ Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs.(kg)
Cobramatic®	K2259-1	42 VAC	400A/100%	0-800 Max. (0-20.3)	Solid: .030-1/16 (0.8-1.6) Cored: .030-1/16 (0.8-1.6)	14.8 x 9.5 x 19.3 (376 x 241 x 490)	47 (21)

⁽¹⁾ With appropriate gun.

Semiautomatic Wire Feeders Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Power Feed™ 25M Wire Feeder

General Options

Push-Pull Guns

See Push-Pull Guns chart in the "Recommended General Options" section.

- K590-6 Water Connection Kit
- K2339-1 Push-Pull Gun adapter Kit
- K586-1 Deluxe Adjustable Gas Regulator & Hose Kit

ArcLink®/Linc-Net™ Control Cables

See ArcLink®/Linc-Net™ Control Cables chart in the "Recommended General Options" section.

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

- K1796-25 Coaxial Weld Power Cable (350A), 25 ft.
- K1796-50 Coaxial Weld Power Cable (350A), 50 ft.
- K1796-75 Coaxial Weld Power Cable (325A), 75 ft.
- K1796-100 Coaxial Weld Power Cable (300A), 100 ft.
- K2593-25 Coaxial Weld Power Cable (#1, Lug to Lug), 25 ft.
- K2593-50 Coaxial Weld Power Cable (#1, Lug to Lug), 50 ft.
- K2593-100 Coaxial Weld Power Cable (#1, Lug to Lug), 100 ft.

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

- K1500-1 Gun Receiver Bushing
- K1500-2 Gun Receiver Bushing
- K1500-3 Magnum® 550 Gun Adapter
- K1500-4 Miller® Gun Receiver Bushing
- K1500-5 OXO Gun Receiver Bushing
- K489-7 Dual Schedule Fast-Mate™ Adapter 10 Series
- K1733-4 Micro Wire Straightner
- K2429-1 ArcLink® "T" Cable Connector
- K2596-1 Replacement Case (Aluminum)
- K2596-2 Replacement Case (Polycarbonate)
- Fume Extraction System

Power Source Options

- Power Wave® 355M, 455M, 455M/STT®

Power Feed™ 10M and Power Feed™ 10M Dual Wire Feeders

General Options

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

ArcLink®/Linc-Net™ Control Cables

See ArcLink®/Linc-Net™ Control Cables chart in the "Recommended General Options" section.

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

- K1796-25 Coaxial Weld Power Cable (350A), 25 ft.
- K1796-50 Coaxial Weld Power Cable (350A), 50 ft.
- K1796-75 Coaxial Weld Power Cable (325A), 75 ft.
- K1796-100 Coaxial Weld Power Cable (300A), 100 ft.
- K2593-25 Coaxial Weld Power Cable (#1, Lug to Lug), 25 ft.
- K2593-50 Coaxial Weld Power Cable (#1, Lug to Lug), 50 ft.
- K2593-100 Coaxial Weld Power Cable (#1, Lug to Lug), 100 ft.
- K1500-1 Gun Receiver Bushing
- K1500-2 Gun Receiver Bushing
- K1500-3 Magnum® 550 Gun Adapter
- K1500-4 Miller® Gun Receiver Bushing
- K1500-5 OXO Gun Receiver Bushing
- K489-7 Dual Schedule Fast-Mate™ Adapter 10 Series
- K683-3 Dual Procedure Switch (5 pin)
- K2429-1 ArcLink® "T" Cable Connector

Power Feed™ 10M and Power Feed™ 10M Dual Wire Feeders, con't.

General Options, con't.

- K1733-1 Wire Straightener
- K1733-4 Micro Wire Straightener
- K435 14 lb. Innershield® Coil Adapter
- K468 8" O.D. Spool Adapter
- K363P 22-30 lb. Readi-Reel® Adapter
- K438 50-60 lb. Readi-Reel® Adapter
- K1634-1 Plastic Wire Cover, 30-40 lbs
- K1634-2 Plastic Wire Cover, up to 60 lbs
- K1504-1 50-60 lb Coil Adapter (2 inch spindle)
- K1546-1 Incoming Bushing for Lincoln® Conduit (.025"-1/16" wire)
- K1546-2 Incoming Bushing for Lincoln® Conduit (1/16"-1/8" wire)
- K590-6 Water Connection Kit
- K1536-1 Flow Sensor
- K283 Portable Digital Wire Feed Speed Meter
- Fume Extraction System

For Single Bench and Dual Bench Models only:

- K2339-1 Push-Pull Gun Adapter Kit
- K1556-1 Light Duty Caster Kit
- K2320-1 Foot Amptrol® Connector Kit

For Single Bench and Single Boom Models only:

- K2360-1 Dual Procedure/Memory Panel

For Single Bench Model only:

- K1557-1 Swivel Platform
- K1555-1 Insulated Lift Bail

Power Source Options

- Power Wave® 355M, 455M and 455M/STT®
- Power Wave® 655 Robotic

LF-72 and LF-74 Wire Feeders

Required Options

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

General Options

- K1500-1 Gun Receiver Bushing
- K1500-2 Gun Receiver Bushing
- K1500-3 Magnum® 550 Gun Adapter
- K1500-4 Miller Gun Receiver Bushing
- K1500-5 OXO Gun Receiver Bushing
- K489-7 Dual Schedule Fast-Mate™ Adapter 10 Series
- Fume Extraction System

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

- K2330-1 Postflow and Burnback Timer Kit
- K2329-1 Remote Voltage Control Kit
- K1546-1 Incoming Bushing for Lincoln® Conduit (.025"-1/16" wire)
- K1546-2 Incoming Bushing for Lincoln® Conduit (1/16"-1/8" wire)
- K162-1 Spindle Kit, 2 Inch Hub
- K586-1 Deluxe Adjustable Gas Regulator & Hose Kit
- 3100211 Harris® Argon Flowmeter Regulator and Hose Kit
- K2335-1 Adapter for Competitive Power Sources
- K1798 Adapter Cable, Male 14-pin Control Cable to Terminal Strip
- K1520-1 42 Volt Transformer Kit

Additional Options For Base Model

- K2328-1 Standard Duty Wire Reel Stand (44 lbs. spools, max.)
- K1524-3 Heavy Duty Wire Reel Stand (60 lbs. spools, max.)

Semiautomatic Wire Feeders Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

LF-72 and LF-74 Wire Feeders, con't.

Additional Options For Feeders Equipped With Standard Duty Wire Reel Stand (44 lbs. spools, max.)

K2331-1	Lift Bail Kit
K2332-1	Lightweight Swivel Kit
K163	Undercarriage
K435	14 lb. Innershield® Coil Adapter
K468	8" O.D. Spool Adapter
K363P	22-30 lb. Readi-Reel® Adapter
K1634-1	Plastic Wire Cover, 30-40 lbs.

Additional Options For Feeders Equipped With Heavy Duty Wire Reel Stand

K1555-1	Insulated Lift Bail (60 lbs. spools, max.)
K1556-1	Light Duty Caster Kit
K1557-1	Swivel Platform
K163	Undercarriage
K435	14 lb. Innershield® Coil Adapter
K468	8" O.D. Spool Adapter
K363P	22-30 lb. Readi-Reel® Adapter
K1634-1	Plastic Wire Cover, 30-40 lbs.
K438	50-60 lb. Readi-Reel® Adapter
K1504-1	50-60 lb. Coil Adapter (2 inch spindle)
K1634-2	Plastic Wire Cover, up to 60 lbs.

Power Source Options

MIG Welders (CV)
Multi-Process Welders (CC/CV)

LN™-10 and DH-10 Wire Feeders

Required Options

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

General Options

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

K1500-1	Gun Receiver Bushing
K1500-2	Gun Receiver Bushing
K1500-3	Magnum® 550 Gun Adapter
K1500-4	Miller® Gun Receiver Bushing
K1500-5	OXO Gun Receiver Bushing
K489-7	Dual Schedule Fast-Mate™ Adapter 10 Series
K1546-1	Incoming Bushing for Lincoln® Conduit (.025"-1/16" wire)
K1546-2	Incoming Bushing for Lincoln® Conduit (1/16"-1/8" wire)
K1733-1	Wire Straightener
K1733-4	Micro Wire Straightener
K162-1	Spindle Kit, 2 Inch Hub
K435	14 lb. Innershield® Coil Adapter
K468	8" O.D. Spool Adapter
K363P	22-30 lb. Readi-Reel® Adapter
K438	50-60 lb. Readi-Reel® Adapter
K1504-1	50-60 lb. Coil Adapter (2 inch spindle)
K1634-1	Plastic Wire Cover, 30-40 lbs
K1634-2	Plastic Wire Cover, up to 60 lbs
K590-6	Water Connection Kit
K683-3	Dual Procedure Switch (5-pin)
K1520-1	42 Volt Transformer Kit
K283	Portable Digital Wire Feed Speed Meter
—	Fume Extraction System

LN™-10 and DH-10 Wire Feeders, con't.

For LN™-10 only:

K1557-1	Swivel Platform
K1556-1	Light Duty Caster Kit
K1555-1	Insulated Lift Bail

Recommended Power Source Options

MIG Welders (CV)
Multi-Process Welders (CC/CV)

STT®-10 Wire Feeder

Required Options

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

General Options

K1567-16	Head to Control, 16 ft.
K1567-20	Head to Control, 20 ft.
K1567-25	Head to Control, 25 ft.
K1758-10	Control / Weld Cable, 10 ft.
K1758-25	Control / Weld Cable, 25 ft.
K1758-50	Control / Weld Cable, 50 ft.
K2147-75	Control Cable w/Coaxial Power Cable, 14-pin MS-Type, 75 ft.
K1500-1	Gun Receiver Bushing
K1500-2	Gun Receiver Bushing
K1500-3	Magnum® 550 Gun Adapter
K1500-4	Miller® Gun Receiver Bushing
K489-7	Dual Schedule Fast-Mate™ Adapter 10 Series
K940-25	Sense Lead Kit, 25 ft.
K940-75	Sense Lead Kit, 25 ft.
K1561-1	Robotic Interface Module
K468	8" O.D. Spool Adapter
K363P	22-30 lb. Readi-Reel® Adapter
K438	50-60 lb. Readi-Reel® Adapter
K1504-1	50-60 lb. Coil Adapter (2 inch spindle)
K1634-1	Plastic Wire Cover, 30-40 lbs.
K1634-2	Plastic Wire Cover, up to 60 lbs.
K683-3	Dual Procedure Switch (5-pin)
K1556-1	Light Duty Caster Kit
K1555-1	Insulated Lift Bail

Power Source Options

Invertec® STT® II

Semiautomatic Wire Feeders Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

LN™-15 Wire Feeder

Required Options

Drive Roll and Wire Guide Kits

See Drive Roll and Wire Guide Kits chart in the "Recommended General Options" section.

General Options

- K1733-4 Micro Wire Straightener
- K1500-1 Gun Receiver Bushing
- K1500-2 Gun Receiver Bushing
- K1500-3 Magnum® 550 Gun Adapter

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

- K484 Jumper Plug Kit
- K468 8" O.D. Spool Adapter

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

- K283 Portable Digital Wire Feed Speed Meter
- Fume Extraction System

Power Source Options

- CV-400, CV-655, Invertec® STT® II
- Engine Driven Welders

LN™-23P Wire Feeder

Required Options

- K345-10 350A FCAW-SS Gun, 10 ft., .068"-5/64"

Options for K316L-1 only

- K350 LN™-23P Adapter Kit, For Terminal Strip Connection
- K350-1 LN™-23P Adapter Kit, For 14 pin Connection

Options for K316L-2 only

- K2393-1 Control/Weld Power Cable, 25 ft.
- K2393-2 Control/Weld Power Cable, 75 ft.
- K2379-1 SAE-400/LN™-23P Interface Kit

General Options

- Fume Extraction System

Power Source Options

- MIG Welders (CV)
- Multi-Process Welders (CC/CV)
- Engine Driven Welders

LN™-25 PRO Wire Feeder

(includes Dual Power and Extra Torque models)

Required Options

Drive Roll and Wire Guide Kits

See chart in "Recommended General Options" section.

- K852-70 Twist-Mate™ Cable Plug, for 1/0-2/0, 50-70 mm² cable
- K852-95 Twist-Mate™ Cable Plug, for 2/0-3/0, 70-95 mm² cable
- S1119-14 Cable Lugs, Unattached, for 1, 1/0 and 2/0 cable

General Options

- K2330-2 Preflow, Postflow and Burnback Time Kit
- K484 Jumper Plug Kit
- K363P 22-30 lb. Readi-Reel™ Adapter
- K435 14 lb. Innershield® Coil Adapter
- K468 8" O.D. Spool Adapter
- K2596-1 Aluminum Case Replacement Kit
- K2596-2 Plastic Case Replacement Kit
- K1733-4 Mico Wire Straightener

LN™-35

Required Options

Drive Roll and Guide Tube Kits

See chart in "Recommended General Options" section.

Weld Power Cables

See chart in "Recommended General Options" section.

General Options

- K1504-1 50-60 lb. Coil Adapter, 2 inch spindle
- K283 Portable Digital Wire Feed Speed Meter
- K1803-1 Work and Wire Feeder 2/0 Weld Cable Package
- Fume Extraction System

Cobramatic® Wire Feeder

Expendable Parts

- KP2073-1 Incoming Guide Tube
- KP2073-2 Outgoing Guide Tube

General Options

- K1520-1 42 Volt Transformer Kit
- Fume Extraction System

SUBMERGED ARC & AUTOMATIC EQUIPMENT



	WIRE FEEDER MODEL	OUTPUT				PROCESS			INPUT Power	FEATURES	
		Power Source Required	Wire Feed Speed Range ipm (m/min)	Solid Wire Size Range in. (mm)	Cored Wire Size Range in. (mm)	MIG	Flux-Cored	Submerged Arc		Waveform Control Technology®	Digital Display
Semi-automatic (Hand-held)	LN™-8 Feeder	DC-600, DC-655	50-600 (1.3-15.2)	.040-3/32 (1.0-2.4)	.045-.120 (1.2-3.0)	●	●	●	115 VAC		
	LN™-9 Feeder	DC-600, DC-655	50-600 (1.3-15.2)	.040-3/32 (1.0-2.4)	.045-.120 (1.2-3.0)	●	●	●	115 VAC		
Mechanized (Tractors)	LT-7 Tractor	DC-600, DC-655, DC-1000	100-400 (2.5-10.2)	3/32-3/16 (2.4-4.8)	—			●	115 VAC		
	NEW! Cruiser™ Tractor	Power Wave® AC/DC 1000®	15-200 (0.4-5.0)	1/16-7/32 (1.6-5.6)	—			●	40 VDC	●	●
Automatic	NA-3 Control & Heads	DC-600, DC-655, DC-1000, DC-1500	25-600 (0.6-15.2)	1/16-7/32 (0.8-5.6)	.045-5/32 (1.2-4.0)	●	●	●	115 VAC		
	NA-4 Control & Heads	AC-1200	Subject to arc voltage used	1/16-7/32 (0.8-5.6)	—			●	115 VAC		
	NA-5 Control & Heads	DC-600, DC-655, DC-1000, DC-1500	25-775 (0.6-19.7)	.035-7/32 (0.9-5.6)	.045-5/32 (1.2-4.0)	●	●	●	115 VAC		●
	Power Feed™ 10A Control & Head	Power Wave® AC/DC 1000®	10-300 (0.25-7.62)	1/8-7/32 (3.2-5.6)	—			●	40 VDC	●	●

	WELDER MODEL	OUTPUT			PROCESS					INPUT Phase Hertz	FEATURES						
		Mode	Polarity	Current Range Amps (A)	Stick	TIG	MIG	Pulsed	Flux-Cored		Submerged Arc	Arc Gauge	Waveform Control Technology®	Digital Communication	Production Monitoring	Stackable	7-Yr. Warranty on Power Rectifier
Analog	Idealarc® DC-600	CC CV	DC	70-680 A	●	●			●	●	●	3 50/60				●	●
	Idealarc® DC-655	CC CV	DC	50-815 A	●	●			●	●	●	3 50,60					●
	Idealarc® DC-1000	CC CV	DC	150-1300 A			●		●	●	●	3 50,60				●	●
	Idealarc® DC-1500	CC CV	DC	200-1500 A					●	●	●	3 50,60					●
	Idealarc® AC-1200	CC CV	AC	200-1500 A						●		1 50,60					●
Digital	Power Wave® AC/DC 1000®	CC CV	AC	100-1000 A						●		3 50/60	●	●	●		

KEY: ● Excellent ● Good ● Optional ■ Analog ■ Digital

LNTM-8 and LNTM-9

Semiautomatic Wire Feeders

The LN-8 and LN-9 are semiautomatic wire feeders providing dependable performance and reliable operation, making them ideal for shop or field operations. For precise wire feeding and quality welds, the LN-8 and LN-9 feature controlled wire feed speed and voltage during starting for clean, positive starts and reduced stubbing, skipping and spatter.

- **Completely enclosed case** protects the heavy duty wire drive mechanism from damage, yet allows easy access to drive rolls.
- **Rugged and durable design** recognized throughout the industry for its long life and years of trouble-free wire feeding.
- **Solid state control** compensates for wire drag and input line variations to maintain accurate wire feed speed.
- **Standard digital meter** can be set to read volts, inches or meters/minute on the LN-9.
- **Control of wire feed speed and voltage** at the wire feeder eliminates the need to return to the power source to adjust procedures.
- **Three-year warranty** on parts and labor. Two-year extended warranty available in the U.S.



Shown: K357-1 LN-9

Shown: K297 LN-8

(K297 LN-8 and K357-1 LN-9 shown with options.)

Processes

- Flux-Cored
- Submerged Arc

Output



Input



Required Options

- Drive Roll Kit
- Control Cable
- Terminal Strip Adapter Cable
- Control Extension Cable
- Weld Power Cable

Key Options

- K1524-3 Heavy Duty Wire Reel Stand
- K1555-1 Insulated Lift Bail
- K1556-1 Light Duty Caster Kit
- K1557-1 Swivel Platform
- *More options at end of section*

Literature

E8.30

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)	H x W x D in. (mm)	Net Weight lbs. (kg)
LN TM -8	K297	115 VAC 50/60 Hz	600A/60%	50-600 (1.3-15.2)	Solid: .040-3/32 (1.0-2.4) Cored: .045-.120 (1.2-3.0) Hardfacing: 7/64 (2.8)	10.9 x 9.8 x 9.6 (277 x 248 x 244)	36 (16.2)
LN TM -9	K357-1					11.5 x 11.3 x 11.5 (292 x 287 x 292)	42 (19)

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.

- **Feeds 3/32"-3/16" (2.4-4.8 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"-70" per minute (0.12-1.8 m/min).
- **Vertical head lift adjuster** for adjusting electrical stick-out from 1/2"-5" (12.7-127.0 mm).
- **Weld angle is up to 50° from vertical** on either side; drag angle is up to 30° from vertical.
- **Control box can be mounted either left or right**, eliminating the need to return to the power source for routine procedure changes.
- **Welds butts, horizontal fillet and lap joints** to the left or right side of the tractor frame for convenience.
- **Three-year warranty** on parts and labor.



Shown: K395-1 LT-7 Track Model

Processes

- Submerged Arc

Output



Input



Unit Includes

- Control Cable, 25 ft. (7.6 m)

Required Options

- Nozzle Assembly
- Control Cable
- Weld Power Cable

Key Options

- *More options at end of section*

Literature

E9.70

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range Solid - in. (mm)	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 Model	K395-1						130 (59)

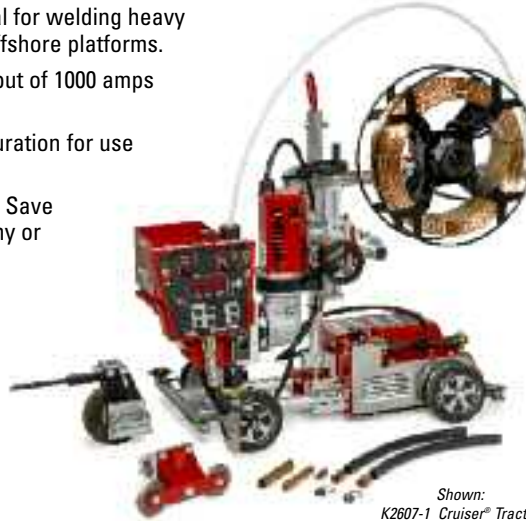
NEW! Cruiser™ Tractor

Submerged Arc Welding Tractor



Bring the productivity of the Power Wave® AC/DC 1000® to field applications. The Cruiser™ is an automatic wire feeder tractor for use with the Power Wave® AC/DC 1000®.

- **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 60 lbs./hr.** – Rated output of 1000 amps at 100% duty cycle.
- **Versatile travel capabilities** – 3 or 4 wheel configuration for use with or without a 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 heavy duty cross slides for any torch angle and feeds up to 7/32" diameter wire.
- **Three-year warranty** on parts and labor.



Shown:
K2607-1 Cruiser™ Tractor

Processes

- Submerged Arc

Output

Input 40 VDC

Cruiser™ Unit (K2607-1) Includes

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

Key Options

- K396 Track Section
- K1543-XX ArcLink® Control Cable
- KP2721-1 Nozzle Extension
- *More options at end of section*

Power Source

- K2344-2 Power Wave® AC/DC 1000™ 380/400/460/500/575/3/50/60

Literature

E9.170

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gear Box	Wire Feed Speed ipm (m/min)	Wire Size Range Solid - inches (mm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Cruiser™ Tractor	K2607-1	40 VDC	100A/100%	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)

NA-3, NA-4 & NA-5 Control & Heads

Automatic Welding Systems

Improve productivity with the NA-3, NA-4, or NA-5 automatic wire feeders. These systems have been specially designed to deposit more weld metal at faster travel speeds which eliminates bottlenecks and cuts costs.

- **Solid state controls** allow for precise control of welding procedures, striking characteristics, as well as bead size and shape.
- **Easily adjusted** for a wide range of processes, feed speeds, and wire sizes.
- **Compact units with excellent flexibility** to fit into simple fixtures or the most complex automated production lines.
- **Rugged construction** minimizes downtime and maintenance costs.
- **Three-year warranty** on parts and labor.



Shown:
K356-2 NA-5

Processes

- MIG
- Flux-Cored
- Submerged Arc

Output

Input 115 VAC

Required Options

- Nozzle Assembly
- Control Cable
- Weld Power Cable

Key Options

- *More options at end of section*

Literature

E9.10 (NA-3, NA-4)
E9.30 (NA-5)

Product Name	Product Number	Wire Feed Speed Range ipm (m/min)	Wire Size Range - in. (mm)	
			Solid	Cored
NA-3	K210-2	25-650 (0.6-16.5)	1/16-7/32 (1.6-5.6)	.035-5/32 (0.9-4.0)
NA-4	K388-2	subject to arc voltage used	1/16-7/32 (1.6-5.6)	-
NA-5	K356-2	25-775 (0.6-16.5)	.035-7/32 (0.9-5.6)	.045-5/32 (1.2-4.0)

Power Feed™ 10A Controller & Head

ArcLink® Controller for Power Wave® AC/DC Systems



Processes
• Submerged Arc

Output **Input**

Unit Includes
• Power Feed™ 10A Control Box
• Remote Pendant
• Remote Pendant Cable, 10 ft. (3.0 m)

Key Options
• K2311-1 Power Feed™ 10SM
• K2370-1 Power Feed™ 10S Head
• K2312-1 Power Feed™ 10SF Head
• K1842-110 Weld Power Cable, Lug to Lug, 110 ft. (33.5 m)
• K2462-1 Power Feed™ 10A Mounting Bracket
• *More options at end of section*

Power Sources
• K2344-2 Power Wave® AC/DC 1000™ 380/400/460/500/575/3/50/60

Literature
E9.165

Designed for use with the Power Wave® AC/DC 1000™ power source, the Power Feed™ 10A eliminates the need for a separate AC and DC controller, making this powerful hard automation system controllable, adaptable and easy to use.

- **Versatile system set-up options for stand-alone or PLC configurations** help you customize the weld cell to make your operations as efficient as possible.
- **Lincoln's Waveform Control Technology®** gives you the ability to select the right waveform for each application.
- **The Power Feed™ 10A Controller** provides clear dual digital display of set-up and weld modes, six memories, AC controls, strike/start/end options, travel stop/start, and timers.
- **Controls can be adjusted on-the-fly** to change penetration and/or deposition rates with Variable Frequency, Variable Amplitude and Variable Balance.
- **Easy-to-use switch panel** can be removed and used as a Remote Control Pendant to create a versatile work station set-up.
- **The motor conversion kit** allows the use of existing NA-3, NA-4, and NA-5 feed head mounting hardware.
- **Three-year warranty** on parts and labor.



Shown:
K2362-1
Power Feed™ 10A
Controller

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gear Box	Wire Feed Speed ipm (m/min)	Wire Size Range Solid - inches (mm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Feed™ 10A Controller with Wire Drive	K2362-1	40 VDC	100A/100%	142:1 ⁽¹⁾	10-200 (0.25-5.08)	5/32-7/32 (4.0-5.6)	15 x 13 x 4 (381 x 259 x 102)	25 (11.3)
				95:1 ⁽¹⁾	10-300 (0.25-7.62)	1/8-5/32 (3.2-4.0)		

⁽¹⁾ 142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-1, K2312-1, K2311-1).



Submerged arc welding with Power Wave® AC/DC 1000® and Power Feed™ 10A Controller.

Idealarc® DC-600

Rugged Multi-Process Power for Industrial Manufacturing

Rugged construction, simple controls and plenty of amperage for heavy duty applications on thick steel or other materials make this welder a sound investment.

- **115V, 15 amps, duplex auxiliary power receptacle** (60Hz models) makes it easy to power lights, grinders and other shop tools at your work station.
- **Full range output voltage control** for easy operation and precise control.
- **Standard analog ammeter and voltmeter.**
- **Mode switch** for selecting desired output characteristics.
- **Windings and rectifiers** protected against moisture and corrosive environments.
- **Flat-top case** with a small footprint can be placed under a workbench or stacked up to 3 high on top of each other.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown: K1288-17 Idealarc® DC-600

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output **CC** **CV** **DC** Input **3** **60** **Hz**

Key Options

- K804-1 Multi-Process Switch
- K1611-1 Paralleling Kit
- K1897-1 Paralleling Kit
- K842 Undercarriage
- *More options at end of section*

Literature

E5.40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC-600 w/Multi-Process Switch	K1288-18	230/460/3/60	600A/44V/100% 680A/44V/60%	108/54A	CV: 70-850A, 13-44V CC: 90-850A, 24-42V	30.7 x 22.2 x 38 (781 x 565 x 965)	522 (237)
Idealarc® DC-600	K1288-17						
	K1288-22	230/460/575/3/60		108/54/43.2A			

NOTE: 50 Hertz models available.

Idealarc® DC-655

Energy Efficient Multi-Process Welder

This 650-amp, 100% duty cycle CV/CC power source is ideal for construction and shop fabrication because of its excellent arc performance and many energy saving features.

- **CC Arc Force Control Knob** with built-in "Hot Start".
- **"Idle Shut Down mode"** automatically shuts machine off when not in use to minimize power consumption.
- **Fan-As-Needed™**—solid state thermally controlled cooling fan operates only when required. Minimizes power consumption, operating noise and dust intake.
- **Separate output studs** let you choose low or high inductance.
- **Panel switches** are behind front latched panel, for remote or machine panel output control, and output "on" or remote "on" selection, and CC, CV Subarc or CV MIG mode selection.
- **Low profile case** allows stacking machines up to three high to conserve floor space.
- **Electronic and thermal protection** from current overload and excessive temperatures.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown: K1609-2 Idealarc® DC-655

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output **CC** **CV** **DC** Input **3** **60** **50** **Hz**

Key Options

- K1482-1 Digital Meter Kit
- K1528-1 Dual Process Switch
- K1611-1 Paralleling Kit
- K842 Undercarriage
- *More options at end of section*

Literature

E5.46

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® DC-655	K1609-2	230/460/575/3/60	650A/44V/100% (815A/44V/60%)	122/61/49A	13-44V 50-815A Max. OCV: 46V (CV) 68V (CC)	27.5 x 22.2 x 38 (699 x 564 x 965)	720 (327)
	K1610-1						

Idealarc® DC-1000

Multi-Process Welder

Designed for semiautomatic and automatic welding, the precise control of the DC-1000 delivers superior high amperage MIG, flux-cored, submerged arc welding and air carbon arc gouging with up to 5/8" (15.9 mm) diameter carbons.

- **500 amp output connections** provide enhanced arc characteristics for low amperage submerged arc and MIG welding procedures.
- **Single range control** for precise output control and easy operation.
- **Terminal strip and output studs** for remote connections and cable.
- **Low profile case** allows installation of the DC-1000 under a workbench and for stacking up to 2 machines to conserve floor space.
- **Removable side panels** for easy access to internal parts.
- **Line voltage compensation** maintains weld consistency, even with line voltage changes of ±10%.
- **Electronic and thermostatic protection** from current overload and excessive temperatures.
- **Internal components**, including windings, rectifiers and circuit boards, are coated to protect against the effects of moisture and corrosion.
- **Recessed front panel** protects operating controls.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown: K1386-3
Idealarc® DC-1000

Processes

- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output Input

Key Options

- K1897-1 Paralleling Kit
- K857 Remote Output Control
- K843 Amptrol® Adapter Kit
- K1798 Terminal Strip Adapter Cable
- *More options at end of section*

Literature

E5.50

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Idealarc® DC-1000	K1386-3	230/460/3/60	1000A/44V/100%	193/96.5A	16-46V 150-1300A	30.7 x 22.5 x 39 (781 x 572 x 991)	821 (372)
	K1387-3 (CE Model)	220/380/440/3/50/60		193/112/96.5A			
	K1387-6	415/3/50/60		102A			

Idealarc® DC-1500

Multi-Process DC Arc Welding Power Source

The precise output of the DC-1500 enhances productivity and quality control when used with Lincoln NA-3 and NA-5 automatic wire feeders, and the LT-7 tractors.

- **Full range output voltage control** for easy operation and precise output control.
- **Mode switch** used to select the desired output characteristics for the process being used.
- **Line voltage compensation** for maintaining weld consistency, even with line voltage changes of ±10%.
- **Fan cooled** with electronic and thermostatic protection from current overload and excessive temperatures.
- **Function lights** built into the printed circuit boards speed diagnostics.
- **Windings and rectifiers** protected against moisture and corrosive environments.
- **Removable side panels** for easy access to internal parts.
- **Recessed front panel** protects operating controls.
- **Terminal strip and output studs** for remote connections and cable.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown: K1275
Idealarc® DC-1500

Processes

- Flux-Cored
- Submerged Arc

Output Input

Key Options

- K1900-1 Paralleling Kit
- K857 Remote Output Control, 25 ft. (7.6 m)
- K857-1 Remote Output Control, 100 ft. (30.5 m)
- K843 Amptrol® Adapter Kit
- *More options at end of section*

Literature

E5.60

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Idealarc® DC-1500	K1275	460/3/60	1500A/44V/100%	184A	20-60V	57.2 x 22.3 x 38 (1453 x 566 x 965)	1420 (644)
	K1383-4	380/440/3/50/60	1500A/60V/100%	216A/187A	200-1500A		

Idealarc® AC-1200

Automatic Submerged Arc Welding Power Source

The AC-1200 is the industry's leading power source for submerged arc welding specifically designed for operation with Lincoln's® NA-4 automatic wire feeder. It is a power source that you can count on day-in and day-out to provide proven performance.

- **Scott® connection taps** standard for two AC welding heads operated in tandem.
- **Rheostat** adjusts the output settings while welding or at idle.
- **Three output studs** with overlapping ranges.
- **±10% input line voltage compensation** for maintaining weld consistency.
- **Thermostatic protection** from current overload and excessive temperatures.
- **Terminal strip** for remote control and wire connections and output studs for welding cables.
- **Removable side panels** for easy access to internal parts.
- **Windings and rectifiers** protected against moisture and corrosive environments.
- **Three-year warranty** on parts and labor.
- **Seven-year warranty** on power rectifier.



Shown:
K1276
Idealarc® AC-1200

Processes
• Submerged Arc

Output **Input**

Key Options
• Fume Extraction System
• *More options at end of section*

Literature
E5.70

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Idealarc® AC-1200	K1276	460/1/60	1200A/44V/100%	182A	60Hz:	57.2 x 22 x 38 (1453 x 560 x 970)	1570 (712)
	K1382	440/1/50/60		190A	200-1500A		
	K1382-5	380/1/50/60		220A	50Hz:		
	K1382-6	415/1/50/60		201A	240-1500A		

Power Wave® AC/DC 1000®

Increase Productivity, Quality and Flexibility

The Power Wave® AC/DC 1000™ is the first power source to introduce Waveform Control Technology® to submerged arc welding. An operator can increase weld speeds, yield higher quality welds and improve efficiencies in a single or multi-arc environment.

- **Eliminate downtime** with easy polarity switching—no hardware reconfiguration required.
- **Stable and independent arc controls** for multiple arc applications.
- **Improved efficiency and reliability** with cooler operation through patented Coaxial Transformer Technology®.
- **95% power factor correction** enables connection of more machines on the same plant infrastructure for lower installation costs compared to other machines.
- **Remote process monitoring and control** through ArcLink®, Ethernet, and DeviceNet™ communication.
- **Consistent operation over ± 10% input voltage variation** through built-in line voltage compensation and reliable input voltage connection.
- **Three-year warranty** on parts and labor.



Shown:
K2344-2
Power Wave® AC/DC 1000®

Processes
• Submerged Arc

Output **Input**

Key Options
• K2362-1 Power Feed™ 10A
• K2282-1 System Interface
• K1543-8 ArcLink®/Linc-Net Control Cable, 8 ft
• K1785-12 Control Cable (Heavy Duty), 12 ft.
• *More options at end of section*

Wire Feeders
Power Feed™ 10SF,
Power Feed™ 10S,
Power Feed™ 10SM

Literature
E10.96

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Power Wave® AC/DC 1000	K2344-2 ⁽¹⁾	380/400/460/500/ 575/3/50/60	1000A/44V/100%	82/79/69/62/55A	100-1000A	43.5 x 19.2 x 33 (1105 x 488 x 838)	650 (295)

⁽¹⁾External filter is required to meet CE conducted emission requirements. The K2444-1 CE Filter must be used with the K2344-2 Power Wave® AC/DC 1000®

Submerged Arc & Automatic Equipment Options

See "Recommended General Options" pgs. 151-171 for descriptions.

LN-8*Required Options**Drive Roll and Guide Tube Kits*

See Drive Roll and Guide Tube Kits chart in the "Recommended General Options" section.

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

General Options

K1524-3	Heavy Duty Wire Reel Stand
K1555-1	Insulated Lift Bail
K1556-1	Light Duty Caster Kit
K1557-1	Swivel Platform
K1504-1	50-60 lb Coil Adapter (2 inch spindle)
K1634-2	Plastic Wire Cover - up to 60 lbs
K261	Wire Feed Speed Meter Kit
K202	Burnback Kit
K58	Magnetic Flux Screen Separator
K310	Flux Screen with Air-Driven Vibrator
K305	Wire Reel and Flux Tank Assembly
K320	Continuous Flux Feeding Tank Assembly
K163	Undercarriage
K110	Mechanized Hand Travel Unit
K283	Portable Digital Wire Feed Speed Meter

LN-9*Required Options**Drive Roll and Guide Tube Kits*

See Drive Roll and Guide Tube Kits chart in the "Recommended General Options" section.

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

General Options

K1524-3	Heavy Duty Wire Reel Stand
K1555-1	Insulated Lift Bail
K1556-1	Light Duty Caster Kit
K1557-1	Swivel Platform
K1504-1	50-60 lb Coil Adapter (2 inch spindle)
K162-1	Spindle Kit - 2 Inch Hub
K1634-2	Plastic Wire Cover - up to 60 lbs
K202	Burnback Kit
K58	Magnetic Flux Screen Separator
K310	Flux Screen with Air-Driven Vibrator
K305	Wire Reel and Flux Tank Assembly
K320	Continuous Flux Feeding Tank Assembly
K163	Undercarriage
K110	Mechanized Hand Travel Unit
K283	Portable Digital Wire Feed Speed Meter
KP1998-6	Insulating Rings
KP2096-1	Contact Tip Coupler 3/8-16 Thread

LT-7 Tractor*Required Options**Weld Power Cables*

See Weld Power Cables chart in the "Recommended General Options" section.

K231-3/32	Contact Nozzle Assembly for 3/32" (2.4mm) Wire
K231-1/8	Contact Nozzle Assembly for 1/8" (3.2mm) Wire
K231-5/32	Contact Nozzle Assembly for 5/32" (4.0mm) Wire
K231-3/16	Contact Nozzle Assembly for 3/16" (4.8mm) Wire
K148A	Positive Contact Nozzle Assembly for 3/32"-1/8"(2.4-3.2mm) Wire
K148B	Positive Contact Nozzle Assembly for 5/32-3/16" (4.0-4.8mm) Wire

General Options

KP2268-1	LT-7 Drive Roll 052-1/16 (2 required)
KP2268-2	LT-7 Drive Roll 068-3/32 (2 required)
KP2268-3	LT-7 Drive Roll 3/32-3/16 (2 required)
KP2268-4	LT-7 Drive Roll 045-052 (2 required)
KP1890-1	Drive Roll Center 5/64-3/32 Tiny Twin
KP1890-2	Drive Roll Side 5/64-3/32 Tiny Twin
KP1984-1	Guide Tube Asbly 068-3/16 Incoming
KP1985-1	Guide Tube 3/32-3/16 Outgoing
KP1985-2	Guide Tube 5/64-3/32-068 Outgoing
KP1986-1	Guide Tube Outgoing Tiny Twinarc
KP2127-1	Guide Tube Incoming TinyTwin Tractor

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

K149-3/32	Nozzle Extension for 3/32" (2.4mm) Wire
K149-1/8	Nozzle Extension for 1/8" (3.2mm) Wire
K149-5/32	Nozzle Extension for 5/32" (4.0mm) Wire
K232	Horizontal Fillet and Lap Adapter Ki
K229	Flat Fillet Adapter Kit
K230	Butt Seam Guide Kit
K400	Track Conversion Kit
K277-1	Tiny Twinarc Adapter Kit for Butt Seams
K277-2	Tiny Twinarc Adapter Kit for Flat Fillets
K396	Track Section - 70 in (1.8m)
K58	Magnetic Flux Screen Separator
K285	Concentric Flux Cone Assembly

Submerged Arc & Automatic Equipment Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Cruiser™ Tractor

General Options

Control Cables and Adapters

See Control Cables and Adapters chart and Drive Roll and Wire Guide Kits Chart in the "Recommended General Options" section.

K1504-1	50-60 lb Coil Adapter (2 inch spindle)
K162-1	Spindle Kit - 2 Inch Hub
K281	Tiny Twinarc Solid Wire Straightener
K1733-5	Wire Straightener (Automatics)
K310	Flux Screen with Air-Driven Vibrator
K58	Magnetic Flux Screen Separator
K2684-1	Pendant
K2714-1	Cross Slide Assembly
K2716-1	Tube and Clamp Kit
K396	Track Section - 70 in (1.8m)
K231-5/64	Contact Nozzle Assembly for 5/64" (2.0mm) Wire
K231-3/32	Contact Nozzle Assembly for 3/32" (2.4mm) Wire
K231-1/8	Contact Nozzle Assembly for 1/8" (3.2mm) Wire
K231-5/32	Contact Nozzle Assembly for 5/32" (4.0mm) Wire
K231-3/16	Contact Nozzle Assembly for 3/16" (4.8mm) Wire
K231-7/32	Contact Nozzle Assembly for 7/32" (5.6mm) Wire
K148A	Positive Contact Nozzle Assembly for 3/32-1/8" (2.4-3.2mm) Wire
K148B	Positive Contact Nozzle Assembly for 5/32-3/16" (4.0-4.8mm) Wire
K149-3/32	Nozzle Extension for 3/32" (2.4mm) Wire
K149-1/8	Nozzle Extension for 1/8" (3.2mm) Wire
K149-5/32	Nozzle Extension for 5/32" (4.0mm) Wire
K285	Concentric Flux Cone Assembly
K129-1/16	Tiny Twinarc Assembly for 1/16" (1.6mm) Wire
K129-5/64	Tiny Twinarc Assembly for 5/64" (2.0mm) Wire
K129-3/32	Tiny Twinarc Assembly for 3/32" (2.4mm) Wire
KP1962-3B1	Nozzle Tip - 3/32" wire diameter
KP1962-1B1	Nozzle Tip - 1/8" wire diameter
KP1962-4B1	Nozzle Tip - 5/32" wire diameter
KP1962-2B1	Nozzle Tip - 3/16" wire diameter
KP1962-5B1	Nozzle Tip - 7/32" wire diameter
KP2719-1	Flux Tubing

NA-3 and NA-4

K208A	NA-3S/NA-4 Head (for solid wire diameters 3/32"-7/32" (142:1 gear ratio)
K208B	NA-3S/NA-4 Head (for solid wire diameters 1/16"-3/32" (95:1 gear ratio)
K209A	NA-3SF/NA-4F Head (for solid wire diameters 3/32"-7/32" (142:1 gear ratio)
K209B	NA-3SF/NA-4F Head (for solid wire diameters 1/16"-3/32" (95:1 gear ratio)

General Options

Control Cables and Adapters

See Control Cables and Adapters chart and Drive Roll and Wire Guide Kits Chart in the "Recommended General Options" section.

K2163-35	Weld Power Cable - Lug to Lug (4/0) - 35 ft
K2163-60	Weld Power Cable - Lug to Lug (4/0) - 60 ft
K1842-110	Weld Power Cable - Lug to Lug (4/0, 600A, 60%) - 110 ft
K234-26	Control to Head Cable Extension - 26 ft
K234-46	Control to Head Cable Extension - 46 ft
K235-5	Control to Head Cable Extension - 5 ft
K235-26	Control to Head Cable Extension - 26 ft
K235-46	Control to Head Cable Extension - 46 ft
K231-5/64	Contact Nozzle Assembly for 5/64" (2.0mm) Wire
K231-3/32	Contact Nozzle Assembly for 3/32" (2.4mm) Wire
K231-1/8	Contact Nozzle Assembly for 1/8" (3.2mm) Wire

NA-3 and NA-4, con't.

General Options, con't.

K231-5/32	Contact Nozzle Assembly for 5/32" (4.0mm) Wire
K231-3/16	Contact Nozzle Assembly for 3/16" (4.8mm) Wire
K231-7/32	Contact Nozzle Assembly for 7/32" (5.6mm) Wire
K226R	Contact Jaw Assembly for 1/8-7/32" (3.2-5.6mm) Wire
K148A	Positive Contact Nozzle Assembly for 3/32-1/8" (2.4-3.2mm) Wire
K148B	Positive Contact Nozzle Assembly for 5/32-3/16" (4.0-4.8mm) Wire
K149-3/32	Nozzle Extension for 3/32" (2.4mm) Wire
K149-1/8	Nozzle Extension for 1/8" (3.2mm) Wire
K149-5/32	Nozzle Extension for 5/32" (4.0mm) Wire
K386	Narrow Gap Deep Groove Nozzle
KP2095-15	Liner Spring .133 ID .240 OD 12.60 in
KP2108-1B1	Nozzle Tip
KP1966-1B1	Contact Tip, Pressure Shoe Type - .052" wire diameter
KP1966-2B1	Contact Tip, Pressure Shoe Type - 1/16" wire diameter
KP1966-3B1	Contact Tip, Pressure Shoe Type - 3/32" wire diameter
KP1966-4B1	Contact Tip, Pressure Shoe Type - 5/64" wire diameter
K285	Concentric Flux Cone Assembly
K225	Sub Arc Twinarc Nozzle for 5/64", 3/32" & 1/8" Wire
K129-1/16	Tiny Twinarc Assembly for 1/16" (1.6mm) Wire
K129-5/64	Tiny Twinarc Assembly for 5/64" (2.0mm) Wire
K129-3/32	Tiny Twinarc Assembly for 3/32" (2.4mm) Wire
K281	Tiny Twinarc Solid Wire Straightener
K223	Solenoid Kit
K221	Start Controls P.C. Board for Automatics
K245	Crater Fill Controls P.C. Board for Automatics
K325HCS	TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 5-75 ipm.
K325HCF	TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 15-270 ipm.
K299	Wire Reel Assembly for 50-60 lb Coils. (without high frequency insulation).
K162-1	Spindle Kit - 2 Inch Hub
K29	Vertical Lift Adjuster (4")
K96	Horizontal Adjuster (2")
K278-1	Spreadarc Oscillator
K310	Flux Screen with Air-Driven Vibrator
K58	Magnetic Flux Screen Separator
K1733-5	Wire Straightener (Automatics)

NA-5

K331B	NA-5N Head (for solid wire diameters 1/16"-3/32" (57:1 gear ratio, 760 ipm max wfs)
K346A	NA-5S Head (for solid wire diameters 1/16"-7/32" (142:1 gear ratio, 290 ipm max wfs)
K346B	NA-5S Head (for solid wire diameters 1/16"-3/32" (95:1 gear ratio, 456 ipm max wfs)
K347A	NA-5SF Head (for solid wire diameters 3/32"-7/32" (142:1 gear ratio, 290 ipm max wfs)
K346B	NA-5SF Head (for solid wire diameters 1/16"-3/32" (95:1 gear ratio, 456 ipm max wfs)

General Options

Control Cables and Adapters

See Control Cables and Adapters chart and Drive Roll and Wire Guide Kits Chart in the "Recommended General Options" section.

K2163-35	Weld Power Cable - Lug to Lug (4/0) - 35 ft
K2163-60	Weld Power Cable - Lug to Lug (4/0) - 60 ft
K1842-110	Weld Power Cable - Lug to Lug (4/0, 600A, 60%) - 110 ft

**Submerged Arc & Automatic Equipment
Options, con't.**

See "Recommended General Options" pgs. 151-171 for descriptions.

NA-5, con't.

General Options, con't.

- K338-5 Control to Head Cable Extension - 5 ft
- K338-11 Control to Head Cable Extension - 11 ft
- K338-26 Control to Head Cable Extension - 26 ft
- K338-46 Control to Head Cable Extension - 46 ft
- K335-26 Control to Head Cable Extension - 26 ft
- K231-5/64 Contact Nozzle Assembly for 5/64" (2.0mm) Wire
- K231-3/32 Contact Nozzle Assembly for 3/32" (2.4mm) Wire
- K231-1/8 Contact Nozzle Assembly for 1/8" (3.2mm) Wire
- K231-5/32 Contact Nozzle Assembly for 5/32" (4.0mm) Wire
- K231-3/16 Contact Nozzle Assembly for 3/16" (4.8mm) Wire
- K231-7/32 Contact Nozzle Assembly for 7/32" (5.6mm) Wire
- K226R Contact Jaw Assembly for 1/8"-7/32" (3.2-5.6mm) Wire
- K148A Positive Contact Nozzle Assembly for 3/32"-1/8" (2.4-3.2mm) Wire
- K148B Positive Contact Nozzle Assembly for 5/32"-3/16" (4.0-4.8mm) Wire
- K149-3/32 Nozzle Extension for 3/32" (2.4mm) Wire
- K149-1/8 Nozzle Extension for 1/8" (3.2mm) Wire
- K149-5/32 Nozzle Extension for 5/32" (4.0mm) Wire
- K386 Narrow Gap Deep Groove Nozzle
- KP2095-15 Liner Spring .133 ID .240 OD 12.60 i
- KP2108-1B1 Nozzle Tip
- KP1966-1B1 Contact Tip, Pressure Shoe Type - .052" wire diameter
- KP1966-2B1 Contact Tip, Pressure Shoe Type - 1/16" wire diameter
- KP1966-3B1 Contact Tip, Pressure Shoe Type - 3/32" wire diameter
- KP1966-4B1 Contact Tip, Pressure Shoe Type - 5/64" wire diameter
- K285 Concentric Flux Cone Assembly
- K225 Sub Arc Twinarc Nozzle for 5/64", 3/32" & 1/8" Wire
- K129-1/16 Tiny Twinarc Assembly for 1/16" (1.6mm) Wire
- K129-5/64 Tiny Twinarc Assembly for 5/64" (2.0mm) Wire
- K129-3/32 Tiny Twinarc Assembly for 3/32" (2.4mm) Wire
- K281 Tiny Twinarc Solid Wire Straightener
- K373 Analog Interface Procedure Control
- K349 Multi-Procedure Kit
- K223 Solenoid Kit
- K325HCS TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 5-75 ipm.
- K325HCF TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 15-270 ipm.
- K299 Wire Reel Assembly for 50-60 lb Coils. (without high frequency insulation).
- K162-1 Spindle Kit - 2 Inch Hub
- K29 Vertical Lift Adjuster (4")
- K96 Horizontal Adjuster (2")
- K278-1 Spreadarc Oscillator
- K334 Start or Crater Module
- K337-10 Weld Timer Module - maximum time 9.99 seconds
- K337-100 Weld Timer Module - maximum time 99.9 seconds
- K336 Remote Interface Module
- K219 Automatic Flux Hopper Assembly
- K58 Magnetic Flux Screen Separator
- K1733-5 Wire Straightener (Automatics)

Power Feed™ 10A

- K2370-1 Power Feed™ 10S Head
- K2312-1 Power Feed™ 10SF Head

Drive Roll and Guide Tube Kits

See Drive Roll and Guide Tube Kits chart in the "Recommended General Options" section.

General Options

- K2163-35 Weld Power Cable - Lug to Lug (4/0) - 35 ft
- K2163-60 Weld Power Cable - Lug to Lug (4/0) - 60 ft

Weld Power Cables

See Weld Power Cables chart in the "Recommended General Options" section.

- K2311-1 Power Feed™ 10SM Motor Conversion Kit
- K387 Tandem Arc Framework Assembly
- K390 Tandem Arc Wire Reels and Mountings
- K389 Flux Hopper Assembly
- K231-5/64 Contact Nozzle Assembly for 5/64" (2.0mm) Wire
- K231-3/32 Contact Nozzle Assembly for 3/32" (2.4mm) Wire
- K231-1/8 Contact Nozzle Assembly for 1/8" (3.2mm) Wire
- K231-5/32 Contact Nozzle Assembly for 5/32" (4.0mm) Wire
- K231-3/16 Contact Nozzle Assembly for 3/16" (4.8mm) Wire
- K231-7/32 Contact Nozzle Assembly for 7/32" (5.6mm) Wire
- K226R Contact Jaw Assembly for 1/8"-7/32" (3.2-5.6mm) Wire
- K148A Positive Contact Nozzle Assembly for 3/32"-1/8" (2.4-3.2mm) Wire
- K148B Positive Contact Nozzle Assembly for 5/32"-3/16" (4.0-4.8mm) Wire
- K149-3/32 Nozzle Extension for 3/32" (2.4mm) Wire
- K149-1/8 Nozzle Extension for 1/8" (3.2mm) Wire
- K149-5/32 Nozzle Extension for 5/32" (4.0mm) Wire
- K386 Narrow Gap Deep Groove Nozzle
- KP2095-15 Liner Spring .133 ID .240 OD 12.60 in
- KP2108-1B1 Nozzle Tip
- KP1966-1B1 Contact Tip, Pressure Shoe Type - .052" wire diameter
- KP1966-2B1 Contact Tip, Pressure Shoe Type - 1/16" wire diameter
- KP1966-3B1 Contact Tip, Pressure Shoe Type - 3/32" wire diameter
- KP1966-4B1 Contact Tip, Pressure Shoe Type - 5/64" wire diameter
- K285 Concentric Flux Cone Assembly
- K225 Sub Arc Twinarc Nozzle for 5/64", 3/32" & 1/8" Wire
- K129-1/16 Tiny Twinarc Assembly for 1/16" (1.6mm) Wire
- K129-5/64 Tiny Twinarc Assembly for 5/64" (2.0mm) Wire
- K129-3/32 Tiny Twinarc Assembly for 3/32" (2.4mm) Wire
- K281 Tiny Twinarc Solid Wire Straightener
- K325HCS TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 5-75 ipm.
- K325HCF TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 15-270 ipm.
- K299 Wire Reel Assembly for 50-60 lb Coils. (without high frequency insulation).
- K162-1 Spindle Kit - 2 Inch Hub
- K29 Vertical Lift Adjuster (4")
- K96 Horizontal Adjuster (2")
- K278-1 Spreadarc Oscillator
- K58 Magnetic Flux Screen Separator
- K2462-1 Power Feed™ 10A Mounting Bracket
- K1733-5 Wire Straightener (Automatics)

Submerged Arc & Automatic Equipment Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Idealarc® DC-600

General Options

K804-1	Multi-Process Switch
K842	Undercarriage - Hand moving
K1737-1	All-Terrain Undercarriage
K1611-1	Paralleling Kit
K1897-1	Paralleling Kit

Wire Feeder Options

LN™-8, LN™-9, LT-7, NA-3, NA-5

Idealarc® DC-655

General Options

K1482-1	Digital Meter Kit
K1486-1	Air Filter Kit
K1528-1	Dual Process Switch
K1611-1	Paralleling Kit
K842	Undercarriage - Hand moving
K1737-1	All-Terrain Undercarriage

Wire Feeder Options

LN™-8, LN™-9, LT-7, NA-3, NA-5

Idealarc® DC-1000

General Options

K1897-1	Paralleling Kit
K1520-1	42 Volt Transformer Kit
K857	Remote Output Control - 25 ft
K857-1	Remote Output Control - 100 ft
K843	Amptrol Adapter Kit
K1798	Adapter Cable - Male 14 pin Control Cable to Terminal Strip
K1770-1	Factory Undercarriage
K1737-1	All-Terrain Undercarriage

Wire Feeder Options

LN™-9, LT-7, NA-3, NA-5

Idealarc® DC-1500

General Options

K1900-1	Paralleling Kit
K857	Remote Output Control - 25 ft
K857-1	Remote Output Control - 100 ft
K843	Amptrol Adapter Kit

Wire Feeder Options

LT-7, NA-3, NA-5

Idealarc® AC-1200

General Options

— Fume Extraction System

Wire Feeder Options

NA-4

Power Wave® AC/DC 1000®

General Options

Control Cables and Adapters

See Control Cables and Adapters chart in the "Recommended General Options" section.

K2282-1	System Interface Used for Multiple Arcs
K1795-10	Control Cable - 10 ft
K1795-25	Control Cable - 25 ft
K1795-50	Control Cable - 50 ft
K1795-100	Control Cable - 100 ft
K1785-12	Control Cable (Heavy Duty) - 12 ft
K1785-16	Control Cable (Heavy Duty) - 16 ft
K1785-25	Control Cable (Heavy Duty) - 25 ft
K1785-50	Control Cable - 14-pin - 50 ft
K1785-100	Control Cable - 14-pin - 100 ft
K2444-2	CE Filter
K2626-1	Remote Feed Head Kit

Wire Feeder Options

Power Feed™ 10A, Cruiser™ Tractor

SUBMERGED ARC GUNS

Submerged Arc Gun

Rated 600 amps, 15 ft. (4.5 m) cable.

Order K113-1
for 5/64" (2.0 mm)

Order K113-2
for 3/32" (2.4 mm)



Mechanized SAW Gun

Rated 600 amps, for 5/64 and 3/32" (2.0 and 2.4 mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit or Squirtmobile®.

Order K114



SUBMERGED ARC ACCESSORIES

Flux Cone

Fits K112 and K113 submerged arc guns for welding without the Continuous Flux Feed Tank Assembly.

Order K119



Wire Reel and Flux Tank Assembly

Includes flux tank, undercarriage, wire reel and brake assembly in open shroud.

Order K305



Magnetic Flux Screen Separator

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

Order K58



PLASMA CUTTING SYSTEMS

Vortech™ Technology



- Cut Any Conductive Material
- Fast, Clean Cutting Compared to Oxy-Fuel
- Great for Hobby, Farm, Autobody or Industry



	MODEL	OUTPUT		CUTTING CAPABILITY			INPUT	FEATURES					
		Cutting Output Range (Amps)	Maximum Cutting Thickness in. (mm)	Cut	Gouge	Pierce		Recommended Generator Power for Maximum Output (1-Phase/230V)	Auto-Voltage Reconnect	Parts-In-Place™ Safety	Vortech™ Torch Consumables	Dual Winding™ Technology	Valet Style Undercarriage
1 Phase	Pro-Cut® 25	12-25 DC	3/8 (9.5)	●	◐	◐	8,700	●	●	●			
1 or 3 Phase	Pro-Cut® 55	25-60 DC	3/4 (19)	●	●	●	12,700		●	●	●	●	
	Pro-Cut® 80	35-85 DC	1-1/4 (32)	●	●	●	18,400		●	●	●	●	●

KEY: ● Excellent ◐ Good ● Optional

Pro-Cut® 25

Portable Cutting Power Up To 3/8"

The handy Pro-Cut® 25 is ideal for hobby, farm, HVAC, autobody shop or sheet metal fabrication. This professional-grade plasma cutting system lists a host of features that will make your metal cutting jobs safe, fast and easy!

- **25 amps of cutting power** from only a 29.5 lb. (13.4 kg) package (without cables) for competitive performance on materials up to 3/8" (9.5 mm) thick.
- **Patented PCT 20 torch with VORTECH™ technology** consumables for unmatched cutting speed, precision and long life.
- **Automatic re-connection between 115V and 230V** for easy power connection and flexibility.
- **Parts-in-Place™ safety indicator and lockout circuit** to safely protect both the operator and the system.
- **Can be powered by most Lincoln® engine driven welders** for ultimate portability.
- **Two-year warranty** on parts and labor. (1-year warranty on plasma torch).



Shown: K1756-1 Pro-Cut® 25

Processes

- Air Plasma Cutting
- Gouging

Output **Input**

Unit Includes

- PCT 20 Hand Torch, 15 ft. (4.5 m)
- Work lead and clamp
- Spare consumables
- Built-in air pressure regulator with gauge
- Input Cord with 115V, 15 amp plug (NEMA 5-15P)
- 115V, 20 amp plug

Key Options

- K1572-1 Spare Parts Kit for PCT-20 Torches
- K2275-1 Welding Cart (80 cu ft. bottle capacity)
- K520 Utility Cart (150 cu ft. bottle capacity)
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- *More options at end of section*

Literature
E11.51

Product Name	Product Number	Torch Length ft. (m)	Input Power Voltage/Phase/Hertz	Rated Output Current/Duty Cycle	Input Current @ Rated Output	Pilot Current	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in. (mm)	Net Weight (w/Torch) lbs.(kg)
Pro-Cut® 25	K1756-1	15 (4.5)	115/1/50/60	25A/35% ⁽¹⁾ 20A/60%	37.7A 26.7A	12A	12-25A	65 PSI	240 SCFH	10.2 x 6.3 x 16.1 (260 x 160 x 410)	29.5 (13.4)
			230/1/50/60	25A/60% 20A/100%	19A 15A						

⁽¹⁾ Full-output current requires use of 25 amp branch circuit and plug (supplied).

Pro-Cut® 55

Rugged Industrial System Cuts Up To 3/4"

The Pro-Cut® 55 is your top choice for industrial plasma cutting for medium plate fabrication metalworking applications. Packed with patented features, the compact Pro-Cut® 55 generates 60 amps of cutting power capable of cutting conductive materials up to 3/4" (19.0 mm) thick.

- **Patented PCT 80 torch and VORTECH™ technology** consumables for excellent cutting speed and performance.
- **Dual winding technology** for fast arc transfers and improved cut quality.
- **Parts-in-Place™ safety indicator and lockout circuit** to safely protect both the operator and the system.
- **"Valet Style" undercarriage** available for easy transport around the shop or site.
- **Three-year warranty** on parts and labor. (1-year warranty on plasma torch).



Shown: K1580-1 Pro-Cut® 55

Processes

- Air Plasma Cutting
- Gouging

Output **Input**

Unit Includes

- PCT 80 Torch
- Work lead and clamp
- Spare consumables
- Built-in air filter and adjustable pressure regulator with gauge

Key Options

- K1838-1 Undercarriage – Valet Style
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- *More options at end of section*

Literature
E11.60

Product Name	Product Number	Torch Length ft. (m)	Input Power Voltage/Phase/Hertz	Rated Output Current/Duty Cycle	Input Current @ Rated Output	Pilot Current	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in. (mm)	Net Weight (w/Torch) lbs.(kg)
Pro-Cut® 55	K1580-1	25 (7.6)	208/230/460/1/3/50/60	55A/50%	1-ph, 50%: 60/55/30A 1-ph, 100%: 44/40/23A 3-ph, 50%: 31/28/17A 3-ph, 100%: 23/21/15A	18A	25-60A	70 PSI	360 SCFH	12.6 x 11 x 26 (320 x 279 x 660)	55 (25)
	K1580-2	50 (15.2)		40A/100%							
	K1580-3	25 (7.6)	460/575/3/50/60	55A/50%	17/14A						
	K1580-4	50 (15.2)		40A/100%	15/12A						
	K1601-1	25 (7.6)	200/380-415/3/50/60	55A/50%	30/17-16A						
	K1601-2	50 (15.2)		40A/100%	21/12-11A						

Pro-Cut® 80

Lincoln's Best Plasma Cutting System Cuts Up To 1-1/4"

The Pro-Cut® 80 exhibits maximum cutting ability with a full 85 amps of power, slicing through metal up to 1-1/4" (32 mm) thick with ease! Using six patented technologies, the unit is perfect for maintenance, fabrication or other applications which require cutting of thicker metals.

- **Dual winding technology** for fast arc transfers and improved cut quality.
- **Patented PCT 80 torch and VORTECH™ technology** consumables for excellent cutting speed and performance.
- **Parts-In-Place™ safety indicator and lockout circuit** to protect both the operator and the system.
- **"Valet Style" undercarriage** available for easy transport around the shop or site.
- **CNC/Robotic Interface** is included as a standard feature.
- **Three-year warranty** on parts and labor. (1-year warranty on plasma torch).



Shown: K1581-1 Pro-Cut® 80

Processes

- Air Plasma Cutting
- Gouging

Output **CC** **DC** Input **1/3** **3** **50/60**

Unit Includes

- PCT 80 Torch
- Work lead and clamp
- Spare consumables
- Built-in air filter and pressure regulator with gauge

Key Options

- K1838-1 Undercarriage – Valet Style
- K1764-1 Inverter and Wire Feeder Cart
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- K1571-3 PCT 80 Machine Torch, 25 ft. (7.6 m)
- K1571-5 PCT 80 Robotic Torch, 25 ft. (7.6 m)
- *More options at end of section*

Literature

E11.70

Product Name	Product Number	Torch Length ft. (m)	Input Power Voltage/Phase/Hertz	Rated Output Current/Duty Cycle	Input Current @ Rated Output	Pilot Current	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in. (mm)	Net Weight (w/Torch) lbs.(kg)
Pro-Cut® 80	K1581-1	25 (7.6)	208/230/460/ 1/3/50/60	80A/60% 65A/100%	1-ph: 96/87/48A 3-ph: 47/44/25A	18A	35-85A	70 PSI	480 SCFH	13.7 x 16.5 x 29.5 (348 x 419 x 749)	98 (44.5)
	K1581-2	50 (15.2)									113 (51.4)
	K1581-3	25 (7.6)	460/575/3/50/60	3-ph: 28/20A						98 (44.5)	
	K1581-4	50 (15.2)								113 (51.4)	

Plasma Cutting Systems Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Pro-Cut® 25

Expendable Parts

- KP2063-1B1 Electrode, 5/pack
- KP2062-1B1 VORTECH™ Nozzle .028", 5/pack
- KP2064-1 Shield Cup, 1/pack

General Options

- K1615-1 PCT 20 Hand Torch, 15 ft
- K2275-1 Welding Cart (80 cu ft. bottle capacity)
- K520 Utility Cart (150 cu ft. bottle capacity)
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- K1626-1 Adapter Bushing

Pro-Cut® 55

Expendable Parts

- KP2063-1B1 Electrode, 5/pack
- KP2062-2B1 VORTECH™ Nozzle, .043", 5/pack
- KP2062-4B1 VORTECH™ Gouging Nozzle, .068", 5/pack
- KP2064-1 Shield Cup, 1/pack
- KP2065-1 Drag Cup, 1/pack

General Options

- K1838-1 Undercarriage, Valet Style
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- K1626-1 Adapter Bushing
- K1571-1 PCT 80 Hand Torch, 25 ft.

Pro-Cut® 55, con't.

General Options, con't.

- K1571-2 PCT 80 Hand Torch, 50 ft.
- K1571-3 PCT 80 Machine Torch, 25 ft.
- K1571-5 PCT 80 Robotic Torch, 25 ft.

Pro-Cut® 80

Expendable Parts

- KP2063-1B1 Electrode, 5/pack
- KP2062-2B1 VORTECH™ Nozzle, .043", 5/pack
- KP2062-3B1 VORTECH™ Nozzle, .053", 5/pack
- KP2062-5B1 VORTECH™ Gouging Nozzle, .082", 5/pack
- KP2064-1 Shield Cup, 1/pack
- KP2065-1 Drag Cup, 1/pack

General Options

- K1838-1 Undercarriage, Valet Style
- K1764-1 Inverter and Wire Feeder Cart
- K1625-1 Combination Circle Cutting Kit
- K1628-1 Suction Pivot
- K1626-1 Adapter Bushing
- K1571-1 PCT 80 Hand Torch, 25 ft.
- K1571-2 PCT 80 Hand Torch, 50 ft.
- K1571-3 PCT 80 Machine Torch, 25 ft.
- K1571-5 PCT 80 Robotic Torch, 25 ft.

ENVIRONMENTAL SYSTEMS



- Reduces Welding Fume and Dust in The Workplace.
- Engineering Solution to Help Meet OSHA Requirements.
- Portable, Wall Mounted or Shop-Wide Systems.
- Visit www.lincolnelectric.com/safety for more information.

	MODEL	PROCESS				FILTER		INPUT	FEATURES				
		Stick	MIG	TIG	Flux-Cored	System	Size		Mobile	Start/Stop Sensor	Filter Indicator Gauge	Single Arm System	Dual Arm System
Mobile	NEW! DownFlex™ 100-NF	●	●	●	●	Non-Filtration	—	Central System					
	NEW! DownFlex™ 200-M	◐	●	●	◐	Disposable	52 m ² (560 ft ²)	208/230/460/3/60	●		●		
	NEW! DownFlex™ 400-MS	●	●	●	●	Self-Cleaning	52 m ² (560 ft ²)	208/230/460/3/60	●	●	●		
	Miniflex®	◐	●	●	◐	Disposable	12 m ² (130 ft ²)	115V/1/60	●	●		●	
	Mobiflex® 100-NF	●	●	●	●	Non-Filtration	—	115V/1/60	●				
	Mobiflex® 200-M	◐	●	●	◐	Disposable	50 m ² (538 ft ²)	115V/1/60	●	●	●	●	
	Mobiflex® 400-MS	●	●	●	●	Self-Cleaning	30 m ² (325 ft ²)	115V/1/60	●	●	●	●	
Wall Mount	Statiflex® 200-M	◐	●	●	◐	Disposable	50 m ² (538 ft ²)	—		●	●	●	●
	Statiflex® 400-MS	●	●	●	●	Self-Cleaning	30 m ² (325 ft ²)	—		●	●	●	

KEY: ● Excellent ◐ Good ● Optional

NEW! DownFlex™ 100-NF, 200-M & 400-MS

Rugged Workbench and Extraction System

The NEW Lincoln DownFlex™ table is a rugged welding workbench and extraction system, all in one self-contained unit. Great for welding, plasma cutting, grinding and polishing.

- **Dual Role** – acts as a rugged work bench and fume extraction unit, all in one durable welding table
- **Innovation filter design** – unique oval shaped filters offer an impressive 560 ft² (52 m²) of filter media surface area, giving longer filter life, lower energy consumption and fewer cleaning cycles
- **3 Stage Spark Arrestor** – provides 3 distinct and effective stages of spark arrest protection.
- **Full Front Access** – front access for controls, filters, trays and spark arrestors makes it simple and easy to maintain.
- **Self Cleaning** – Available on the 400-MS model.
- **DownFlex™ 100-NF** – Available for customers who need a rugged downdraft table, but prefer a customized extraction system. (no filtration, fan or electrical controls supplied).



Shown:
K2751-3
DownFlex™ 400-MS

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Input  

Unit Includes

- Sturdy Welding Table
- Backdraft Panel
- Side Panels
- Filters & Controls

Key Options

- K2752-1 HEPA Filter Kit
- K2752-2 Plasma Cutting Grid
- K2752-3 Light Kit
- K2752-6 Wheel Kit
- *More options at end of section*

Literature

E13.50

⁽¹⁾ Not suitable for grinding Aluminum or Magnesium.

Product Name	Product Number	Filter Type/ Filter Size	Input Power Voltage/Phase/Hertz	Input Current	H x W x D in. (mm)	Net Weight lbs. (kg)
DownFlex™ 200-M	K2751-2	Cellulose/Polyester Fiber Filter (Qty 2)	208/230/460/3/60	11A/10A/5A	36 x 55 x 40 (920 x 1380 x 1005)	540 (245)
DownFlex™ 400-MS	K2751-3					562 (255)
DownFlex™ 100-NF	K2571	Non-Filtration	Central System	—	36 x 54 x 30 (1920 x 1366 x 750)	330 (150)

Miniflex®

Portable Welding Fume Extractor

Lincoln Electric's Miniflex® is a portable, high vacuum, low volume system specifically designed for the removal and filtration of welding fumes. With light duty welding process, the Miniflex® excels in performance, design and ease of handling. It can be used in locations that are not accessible with other welding fume extractors.

- **Well thought-out, user-friendly design.**
- **Five-stage filtration system** for higher efficiency.
- **LongLife-H™ filter technique** separates and retains small particles for maximum efficiency.
- **Final filter: HEPA H12 Class.**
- **Two powerful motors:** 1.2 hp each.
- **Multiple extraction capacity settings:**
 - Low: 94 CFM.
 - High: 135 CFM.
- **Cable sensor allows** automatic start/stop capability.
- **Low noise level:** 70dB(A) with nozzle extraction installed.
- **Standard wheels** and handle make it easy to roll the Miniflex® around the shop.
- **One-year warranty** on unit. (30 day warranty on all consumables such as filters, hoses, hose adapters.)



Shown:
K2376-1 Miniflex®

Processes

- Stick (light duty)
- TIG
- MIG
- Flux-Cored (light duty)

Input  

Unit Includes

- 9 ft. (3 m) cord (AWG 14) with 15 amp plug (NEMA 5-15).
- 8 ft. (2.5 m) length x 1-3/4 in. (45 mm) O.D. extraction hose.
- LongLife®-H main filter.
- HEPA filter.
- 2 spare sets of carbon brushes and seals for motors.

Key Options

- K2387-8 16 ft. Extraction Hose
- K2387-9 8 ft. Extraction Hose
- K2389-5 EN20 Extraction Nozzle
- K2389-6 EN40 Extraction Nozzle
- *More options at end of section*

Literature

E13.11

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current	H x W inches (mm)	Net Weight lbs. (kg)
Miniflex®	K2376-1	115V/1/60	15A	28-3/4 x 16-1/2 (730 x 420)	36 (16)

Mobiflex® 100-NF

Portable Welding Exhaust System

The Mobiflex® 100-NF is a portable, lightweight welding fume extraction unit that provides source capture exhaust only capability. Great for field construction sites, repair & maintenance operations and/or shop welding applications where removing welding fumes at the source is needed. No filtration.

- Lightweight and portable.
- Weighs only 37.5 lbs (17 kg).
- Handle and sturdy base included.
- Great for field or shop welding.
- Exhaust only capability, up to 735 CFM.
- Low noise operation (69dBA).



Shown:
Mobiflex® 100-NF with
K1668-1 Hose & Hood Set and
K1668-2 Extension Hose Kit

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input  

Unit Includes

- Exhaust Fan Unit
- Carrying Handle
- Sturdy Base/Stand

Required Options

- K1668-1 Hose & Hood Set, 16 ft.

Key Options

- K1668-2 Extension Hose Kit, 16 ft.
- More options at end of section

Literature

E13.42

Product Name	Product Number	Filter Type/ Filter Size	Input Power Voltage/Phase/Hertz	Input Current	H x W x D mm (in.)	Net Weight kg (lbs.)
Mobiflex® 100-NF	K1666-1	Non-Filtration Exhaust Only	115/1/60	12A	587 x 480 x 480 (23.2 x 19 x 19)	17 (37.5)

Mobiflex® 200-M

Mobile Welding Fume Extractor

Low vacuum/high volume disposable filtration system designed for light to medium duty extraction of welding fumes. Ideal for facilities that require welding fume extraction in multiple locations including maintenance departments, general fabrication and job shops, and industrial environments.

- Generous 735 CFM airflow with LFA 3.1/4.1 extraction arm.
- 50 m² (538 ft²) LongLife® filter with ExtraCoat® pretreatment.
- Filter status indicator gauges amount of particulate in filter cartridge, indicating system maintenance and filter replacement.
- Internal aluminum mesh spark arrestor.
- One-year warranty on equipment. (30 day warranty on filter cartridge.)



Shown:
Mobiflex® 200-M with
required Extraction Arm

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input  

Unit Includes

- Filter
- Plastic housing
- 8" (203 mm) Flexible Hose
- 6 m (19 ft.) 115 VAC Input Power Cord

Required Options

- Extraction Arm
 - K2633-1 LFA 3.1
 - K2633-2 LFA 3.1 w/Lamp & Arc Sensor
 - K2633-3 LFA 4.1
 - K2633-4 LFA 4.1 w/Lamp & Arc Sensor

Key Options

- More options at end of section

Literature

E13.12

Product Name	Product Number	Filter Type/ Filter Size	Input Power Voltage/Phase/Hertz	Input Current	H x W x D mm (in.)	Net Weight kg (lbs.)
Mobiflex® 200-M Base Unit	K1653-2	Pretreated Cellulose 50 m ² (538 ft ²)	115/1/60	12A	900 x 810 x 1210 (36 x 32 x 48)	111 (243)

Mobiflex® 400-MS

Portable Welding Fume Extractor

Low vacuum/high volume self-cleaning filtration system designed for heavy duty extraction of welding fumes. Ideal for facilities that require welding fume extraction in multiple locations including maintenance departments, general fabrication and job shops, and industrial environments.

- **Generous 735 CFM** airflow with LFA 3.1/4.1 extraction arm.
- **30 m² (325 ft²) LongLife® filter** with ExtraCoat® pretreatment.
- **Electronic filter pressure system** monitors internal static pressure and controls filter cleaning.
- **Indicator light** for saturated filter.
- **RotaPulse® automatic filter cleaning system.**
- **Internal aluminum mesh spark arrestor.**
- **One-year warranty** on unit. (30 day warranty on all consumables such as filters, hoses, hose adapters.)



Shown: Mobiflex® 400-MS with required Extraction Arm

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input 

Unit Includes

- Filter
- Plastic Housing
- 8" (203 mm) Flexible Hose
- 6 m (19 ft.) 115 VAC Input Power Cord

Required Options

- Extraction Arm
 - K2633-1 LFA 3.1
 - K2633-2 LFA 3.1 w/Lamp & Arc Sensor
 - K2633-3 LFA 4.1
 - K2633-4 LFA 4.1 w/Lamp & Arc Sensor

Key Options

- *More options at end of section*

Literature

E13.13

Product Name	Product Number	Filter Type/ Filter Size	Input Power Voltage/Phase/Hertz	Input Current	H x W x D mm (in.)	Net Weight kg (lbs.)
Mobiflex® 400-MS Base Unit	K1741-1	Pretreated Cellulose 30 m ² (325 ft ²)	115/1/60	12A	1020 x 810 x 1210 (40 x 32 x 48)	130 (286)

Statiflex® 200-M

Wall mounted low vacuum/high volume disposable filtration system designed for light to medium duty extraction of welding fumes.

Ideal for a variety of facilities in which floor space is a premium including maintenance departments, general fabrication and job shops, weld schools, and industrial environments.

- **Generous 735 CFM** airflow with LTA 2.0, LFA 2.0, LFA 3.1, LFA 4.1, LFA 4.1-LC extraction arms and SF 2400 fan.
- **50 m² (538 ft²) LongLife® filter** with ExtraCoat® pretreatment.
- **Filter status indicator** gauges amount of particulate in filter cartridge, indicating system maintenance and filter replacement.
- **Suitable for a single or dual arm** system configuration.
- **Internal aluminum mesh spark arrestor.**
- **One-year warranty** on equipment. (30 day warranty on filter cartridge.)



Shown: K1654-1 Statiflex® 200-M Single Arm Base Unit

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Required Options

- Extraction Arm(s)
- Stationary Fan
- Overload Switch
- Lamp Kit with Arc Sensor

Key Options

- *More options at end of section*

Literature

E13.14

Product Name	Product Number	Filter Type	Filter Surface m ² (ft ²)	H x W x D mm (in.)	Net Weight kg (lbs.)
Statiflex® 200-M Single Arm Base Unit	K1654-1	Pretreated Cellulose	50 (538)	900 x 810 x 730 (36 x 32 x 29)	30 (66)
Statiflex® 200-M Dual Arm Base Unit	K1654-2	Pretreated Cellulose	50 (538)	900 x 810 x 730 (36 x 32 x 29)	30 (66)

Statiflex® 400-MS

Wall mounted low vacuum/high volume self-cleaning filtration system designed for heavy duty extraction of welding fumes.

Ideal for a variety of facilities in which floor space is a premium including maintenance departments, general fabrication and job shops, weld schools, and industrial environments.

- Generous 735 CFM airflow with LTA 2.0, LFA 2.0, LFA 3.1, LFA 4.1, LFA 4.1-LC extraction arms and SF 2400 fan.
- 30 m² (325 ft²) LongLife® filter with ExtraCoat® pretreatment.
- RotaPulse® automatic filter cleaning system.
- Internal aluminum mesh spark arrestor.
- Electronic filter pressure system monitors internal static pressure and controls filter cleaning.
- One-year warranty on equipment. (30 day warranty on filter cartridge.)



Shown: Statiflex® 400-MS with required Extraction Arm

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Required Options

- Extraction Arm(s)
- Stationary Fan
- Lamp Kit with Arc Sensor

Key Options

- More options at end of section

Literature

E13.15

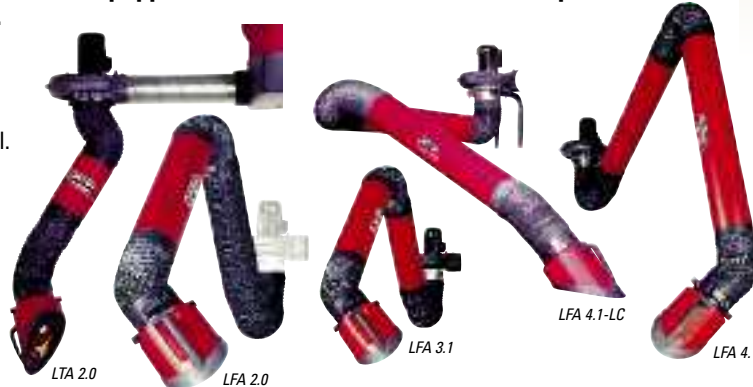
Product Name	Product Number	Filter Type	Filter Surface m ² (ft ²)	H x W x D mm (in.)	Net Weight kg (lbs.)
Statiflex® 400-MS Base Unit	K1742-1	Pretreated Cellulose	30 (325)	1040 x 670 x 660 (41 x 27 x 26)	85 (187)

Fume Extraction Arms

Low Vacuum Flexible Extraction Arms

These flexible extraction arms are built the Lincoln Electric way, rugged and reliable. Designed with the welder in mind, the arms come equipped with the 360° rotatable hood for optimal positioning to the welding point.

- Ultra-light positioning.
- Minimal maintenance.
- Dent and scratch resistant material.
- Unique spring-balanced internal mechanism: LFA 3.1/4.1/4.1-LC.
- Unique advanced friction internal mechanism: LTA 2.0/LFA 2.0.
- 360° rotatable hood.
- Airflow throttle valve.
- 1-year warranty.



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

E13.16

Product Name	Product Number	Arm Length m (ft.)	H x W mm (in.)	Net Weight kg (lb.)	CFM with SF 2400 Fan (with no filtration)	Use With:
LFA 3.1	K2633-1	3.1 (10)	208 x 3,000 (8 x 118)	15 (33)	760	Mobiflex®
	K1655-1					Statiflex®
LFA 3.1 (with Lamp & Arc Sensor)	K2633-2	3.1 (10)	208 x 3,000 (8 x 118)	15 (33)	760	Mobiflex®
LFA 4.1	K2633-3	4.1 (13)	208 x 4,000 (8 x 157)	17 (37.5)	760	Mobiflex®
	K1655-2					Statiflex®
LFA 4.1 (with Lamp & Arc Sensor)	K2633-4	4.1 (13)	208 x 4,000 (8 x 157)	17 (37.5)	760	Mobiflex®
LFA 4.1-LC (Low Ceiling)	K1655-6	4.1 (13)	208 x 4,000 (8 x 157)	17 (37.5)	760	Statiflex®
LFA 2.0	K1655-5	2 (6.5)	208 x 2,160 (8 x 85)	7 (15.4)	780	Statiflex®
LTA 2.0	K1655-3	Retracts from 1-1.5 (3-4.5)	208 x 1,000-1,400 (8 x 39.5-55)	7 (15.4)	780	Statiflex®

Fume Extraction Systems

Engineered solutions customized to meet your individual needs.

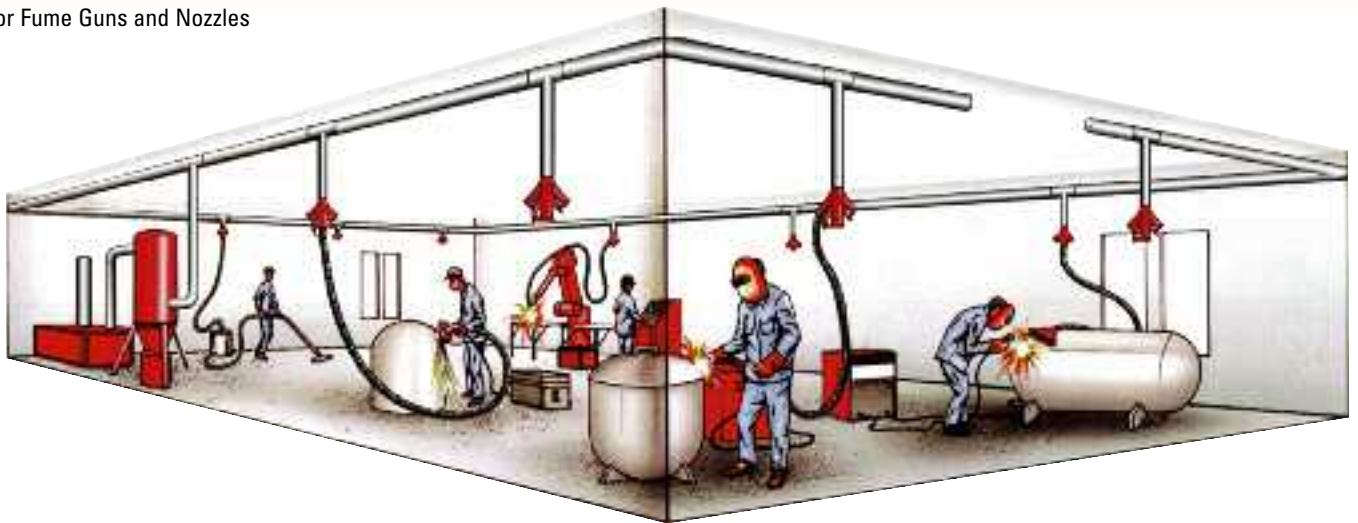
Hood and Filter Bank Systems

For Robotics, Hard Automation, Cutting Tables and Manual Welding Stations



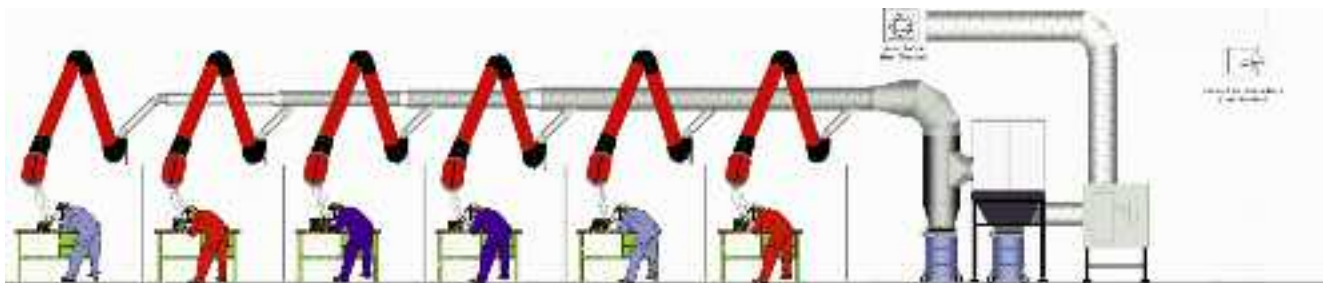
High Vacuum Central Systems

For Fume Guns and Nozzles



Low Vacuum Central Systems

For Industry and Schools



For further information, contact the Automation Team at: automation@lincolnelectric.com or call 216-383-2667

Environmental Systems Options

See "Recommended General Options" pgs. 151-171 for descriptions.

DownFlex™ 100-NF*General Options*

K2752-10	Central System Connection Kit
K2752-11	Dust Container
K2752-12	Spark Arrestor
K2572-2	Plasma Cutting Grid
K2572-3	Working Lamp Kit
K2572-8	Mounting Kit for Bench Vice

DownFlex™ 200-M and DownDraft™ 400-MS*General Options*

K2752-1	HEPA Filtraton Kit
K2752-2	Plasma Cutting Grid
K2752-3	Working Light Kit
K2752-4	Current Activated Start/Stop Sensor (400-MS only)
K2752-5	Motion Activated Start/Stop Sensor (400-MS only)
K2752-6	Wheel Kit
K2752-7	Silencer Outlet Duct
K2752-8	Bench Vice Mounting Bracket
K2752-9	Dust Tray Lid

Expendable Parts

K2752-13	LongLife® Filter FCC 52
K2752-14	HEPA Filter

Miniflex®*Expendable Parts*

KP2390-1	LongLife®-H Filter
KP2390-2	HEPA Filter
KP2390-3	Miniflex® Prefilter

General Options

K2389-5	EN 20 Nozzle
K2389-6	EN 40 Nozzle
K639-1	SHM-300 Suction Head for Manual Welding, 12"
K639-2	SHM-400 Suction Head for Manual Welding, 16"
K639-3	SHM-500 Suction Head for Manual Welding, 20"
K639-4	SHMS Low Noise Suction Nozzle
K639-5	SHFA Flat Suction Head with Flexible Arm
K639-6	UNM Suction Head for Heavy Smoke
K639-14	SHMT Round Suction Head with Flexible Arm
K2389-3	NKT Nozzle Kit, 1" x 8' Hose, 1-3/4" Hose Adapter
K2389-4	NKC Nozzle Kit, 1" x 8' Hose, 1-3/4" Hose Adapter
K2389-8	Extraction Hose, 1-3/4" x 16'
K2389-9	Extraction Hose, 1-3/4" x 8'
K2389-10	Hose-to-Hose Adapter, 1-3/4" x 1-3/4"
K2389-2	Hose Connection Outlet
K2389-1	Activated Carbon Filter
K2389-7	MBH Wall Mounting Bracket

Mobiflex® 100-NF*General Options*

K1668-1	Hose and Hood Set, 16 ft. (4.9 m)
K1668-2	Exhaust or Extension Hood Set, 16 ft. (4.9 m)

Mobiflex® 200-M*Hose/Hood Set or Extraction Arm*

K1668-1	Hose and Hood Set (requires S23267 Flange Adapter)
K2633-1	LFA 3.1 10 ft. Extraction Arm
K2633-2	LFA 3.1 10 ft. Extraction Arm with Lamp/Arc Sensor
K2633-3	LFA 4.1 13 ft. Extraction Arm
K2633-4	LFA 4.1 13 ft. Extraction Arm with Lamp/Arc Sensor

General Options

K1706-2	Work Lamp with Arc Sensor
K1494-3	Starter Overload Switch for 230V
K1673-1	LongLife® Filter (for 200-M)
K1852-1	Activated Carbon Filter

Mobiflex® 400-MS*Hose/Hood Set or Extraction Arm*

K1668-1	Hose and Hood Set (requires S23267 Flange Adapter)
K2633-1	LFA 3.1 10 ft. Extraction Arm
K2633-2	LFA 3.1 10 ft. Extraction Arm with Lamp/Arc Sensor
K2633-3	LFA 4.1 13 ft. Extraction Arm
K2633-4	LFA 4.1 13 ft. Extraction Arm with Lamp/Arc Sensor

General Options

K1706-2	Work Lamp with Arc Sensor
K1494-3	Starter Overload Switch for 230V
K1673-2	LongLife® Filter (for 400-MS)

Environmental Systems Options, con't.

See "Recommended General Options" pgs. 151-171 for descriptions.

Statiflex® 200-M Single and Dual Arm*Wall Mounted Filtration Units*

- K1654-1 Statiflex® 200-M Single Arm Base Unit
(includes LongLife® Filter, mounting bracket and one hose kit - 1m length)
- K1654-2 Statiflex® 200-M Dual Arm Base Unit
(includes LongLife® Filter, mounting bracket and two hose kits - 1m length each)

TO CREATE A SINGLE ARM PACKAGE, CHOOSE **ONE** ITEM FROM CATEGORY 2, AND **ONE** ITEM EACH FROM SYSTEMS 3A OR 3B

TO CREATE A DUAL ARM PACKAGE, CHOOSE **TWO** ITEMS FROM CATEGORY 2, AND **TWO** ITEMS EACH FROM SYSTEMS 3A OR 3B

Extraction Arms (Category 2)

- K1655-3 LTA 2.0 Telescopic Extraction Arm
- K1655-5 LFA 2.0 6.5 ft Extraction Arm
- K1655-1 LFA 3.1 10 ft Extraction Arm
- K1655-2 LFA 4.1 13 ft Extraction Arm
- K1655-6 LFA 4.1-LC Low Ceiling 13 ft Extraction Arm

Standard System (Category 3A) – requires fan, starting control and mounting brackets

- K1656-1 SF 2400 Stationary Fan (1 HP)
- K1494-2 Starter Overload Switch for 115V
- K1494-3 Starter Overload Switch for 230V
- K1669-4 Lamp Kit with Arc Sensor for Wall Mounted Arms
- K1657-1 SF 2400 Wall Mounting Bracket
- K1657-2 SF 2400 Wall Mounting Bracket

Extension Crane System (Category 3B) – requires fan, starting control and extension crane

- K1656-4 SF 4200 Stationary Fan (2 HP)
- K1494-10 Starter/Overload Switch for SF4200 Fan
- K1669-10 Lamp with Arc Sensor for SF4200 Fan
- K1671-1 EC 2 (7 ft) Extension Crane
- K1671-2 EC 4 (14 ft) Extension Crane
- K1672-1 Feeder Hanging Rail

General Options

- K1750-1 230V Conversion Kit for SF 2400 Fan
- K1673-1 LongLife® Filter (for 200-M)
- K1852-1 Activated Carbon Filter
- K1534-2 Air Exhaust Silencer
- K1743-2 Non-Return Valve

Statiflex™ 400-MS Single Arm*Wall Mounted Filtration Unit*

- K1742-1 Statiflex® 400-MS Base Unit
(includes LongLife® Filter, mounting bracket and one hose kit - 1m length)

TO CREATE A SINGLE ARM PACKAGE, CHOOSE **ONE** ITEM FROM CATEGORY 2, AND **ONE** ITEM EACH FROM CATEGORY 3A OR 3B
(Requires Lamp/Arc Sensor Kit to operate Statiflex® 400-MS Self-Cleaning Controls).

Extraction Arms (Category 2)

- K1655-3 LTA 2.0 Telescopic Extraction Arm
- K1655-5 LFA 2.0 6.5 ft Extraction Arm
- K1655-1 LFA 3.1 10 ft Extraction Arm
- K1655-2 LFA 4.1 13 ft Extraction Arm
- K1655-6 LFA 4.1-LC Low Ceiling 13 ft Extraction Arm

Standard System (Category 3A) – requires fan, starting control and mounting brackets

- K1656-1 SF 2400 Stationary Fan (1 HP)
- K1669-4 Lamp Kit with Arc Sensor for Wall Mounted Arms
- K1657-1 SF 2400 Wall Mounting Bracket
- K1657-2 SF 2400 Wall Mounting Bracket

Extension Crane System (Category 3B) – requires fan, starting control and extension crane

- K1656-4 SF 4200 Stationary Fan (2 HP)
- K1669-10 Lamp with Arc Sensor for SF4200 Fan
- K1671-1 EC 2 (7 ft) Extension Crane
- K1671-2 EC 4 (14 ft) Extension Crane
- K1672-1 Feeder Hanging Rail

General Options

- K1750-1 230V Conversion Kit for SF 2400 Fan
- K1673-2 LongLife® Filter (for 400-MS)
- K1534-2 Air Exhaust Silencer
- K1743-2 Non-Return Valve

(See page 171 for Fume Extraction Guns)

AUTOMATED SOLUTIONS



- Drop-In-Place Pre-Engineered Solutions
- Custom Systems Available for Unique Needs
- Resolve Quality, Productivity or Skilled Labor Issues
- Backed by Lincoln Automation Service, Support and Training

MODEL	OUTPUT			PROCESS				INPUT		FEATURES		
	Mode	Polarity	Amperage Range Amps (A)	MIG	Pulsed	Flux-Cored	STT®	Phase	Hertz	Waveform Control Technology®	ArcLink®	Production Monitoring
Power Wave® i400	CC CV	DC	5-420 A	●	●	●		3	50,60	●	●	●
Power Wave® 455M Robotic	CC CV	DC	5-570 A	●	●	●		3	50,60	●	●	●
Power Wave® 455M/STT® Robotic	CC CV	DC	5-570 A	●	●	●	●	3	50,60	●	●	●
Power Wave® 655 Robotic	CC CV	DC	20-880 A	●	●	●		3	60	●	●	●

KEY: ● Excellent ● Good ● Optional

Power Wave® i400

Intelligent Robotic Solution



The Power Wave® i400 & AutoDrive™ 4R90 (see below) solution delivers Lincoln's best performance technologies and welding processes all rolled into one highly efficient inverter power source paired with a compact, durable wire feeder designed for high-end robotic welding.

- **Flexible Design** – Designed for simple, seamless integration with the FANUC® Robotics R-30iA Controller, or use as a separated configuration to meet your weld cell requirements.
- **Quality and Consistent Welding Results** – Lincoln's Waveform Control Technology® gives you the ability to select the right waveform for each application.
- **High Performance Digital Communications** – High speed digital communication via ArcLink® protocol, a CAN connection or now the ArcLink XT™, the ArcLink® protocol can be communicated over an Ethernet cable.
- **Best in Class Power** – 5-420 amps output delivers the power you need for a wide range of processes and materials, with no derating for pulse waveforms.
- **Industry Leading Technology** – New high speed digital controls lead the industry in the performance of this welding package.
- **Ready to Perform** – Auxiliary outlet offers flexibility to add fume extraction, water cooler, computer or other accessories quickly and easily.



Shown:
Power Wave® i400 Power Source

Processes

- CV-MIG
- Pulsed-MIG
- Flux-Cored
- Metal-Cored
- Stainless
- Aluminum

Output Input

Key Options

- K1785-25 14-14 Control Cable
- K2670-1 CE Filter Kit
- K2677-1 Integration Kit
- K1543-25 ArkLink® Control Cable
- *More options at end of section*

Wire Feeders

- K2685-2 AutoDrive™ 4R90
- K1780-2 Power Feed™ 10R

Literature

E10.11

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Wave® i400	K2669-1	200/230/380-415/460/575/3/50/60	50/60Hz: 350A/34V/100% 400A/36V/60% 420A/37V/40%	50/60Hz: 350A/34V/100% 400A/36V/60% 420A/37V/40%	5-420A 10-37V	21 x 18.5 x 23.6 (533 x 470 x 600)	209 (95)

AutoDrive® 4R90

Industry Leading Design



- **Integrated Design** – Designed to “nest” in the upper arm of the FANUC® Robotics 100iC arm.
- **Durable and Rugged** – Patented MAXTRAC® wire drive is precision cast aluminum designed to provide reliable feed force.
- **Ease of Use** – Unlike competitive models, no tools are required for drive roll, wire guide or pressure arm adjustment.
- **High Performance** – Brass-to-brass gun connections provide more reliable electrical connectivity and more efficient energy transfer.
- **Best in Class Torque** – Results in faster acceleration and reliably pulls wire through conduit.
- **Precise Control** – Dual spring pressure arms offer clear-cut adjustment for optimizing pressure for different wire types.
- **Welding Results** – High resolution tachometer for accurate wire feed speed control.
- **Optimized Robotic Solution** – Compact, lighter weight packaging maximizes robot acceleration performance and through put.



Shown:
K2685-2
AutoDrive™ 4R90

Processes

- CV-MIG
- Pulsed MIG
- Flux-Cored
- Metal-Cored

Output Input

Unit Includes

- Outguide
- Incoming Bushing/Conduit Connector

Key Options

- K1505-035S Four-Roll Drive & Split Wire Guide Kit (Solid Steel Wire)
- K1505-045S Four-Roll Drive & Split Wire Guide Kit (Solid Steel Wire)
- *More options at end of section*

Literature

E10.11

Product Name	Product Number	Wire Feed Speed Range in/min (m/min)	Wire Size Range – Solid inches (mm)	Wire Size Range – Cored inches (mm)	H x W x D inches (mm)	Net Weight lbs.(kg)
AutoDrive® 4R90	K2685-2	30-800 (0.8-20.3)	.025-.045 (0.6-1.2)	.035-.045 (0.9-1.2)	9.1 x 7.5x 8.4 (231 x 141 x 213)	13.5 (6.1)

Power Wave® 455M Robotic

The Power Wave® 455M Robotic is a high performance, digitally controlled inverter power source designed for robotic, hard automation and semiautomatic applications.

- **Program your own waveform** or choose from over 60 standard welding waveform programs.
- **Optional communication modules** provide networking capabilities via DeviceNet™ or Ethernet.
- **Utilizes ArcLink®**—the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration to the power source and networked equipment.
- **Software based controls** can be upgraded as new features become available.
- **Process and production monitoring** with access to real time (500Hz) feedback.
- **A Power Wave® inverter operates at a high efficiency** (88-90%) with a 95% minimum power factor (at rated output) and is capable of operating from a universal input voltage (208 to 575 volts).



Shown:
K2262-1 Power Wave®
455M Robotic

Processes

- MIG
- Pulsed
- STT®
- Flux-Cored

Output **DC** **Input**

Key Options

- K2207-2 Ethernet/DeviceNet™ Interface Module
- K1570-1 Dual Cylinder Platform Undercarriage
- K1813-1 Cool-Arc™ 40 115/1/50/60
- *More options at end of section*

Wire Feeders

- K1780-2 Power Feed™ 10R
- K2685-2 AutoDrive 4R90

Literature

E10.90

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Power Wave® 455M Robotic	K2262-1	208/230/460/575/3/50/60	60Hz: 450A/38V/100% (570A/43V/60%) 50Hz: 400A/36V/100% (500A/40V/60%)	60Hz: 58/53/25/22A (82/78/37/31A) 50Hz: 49/45/23/18A (67/61/31/25A)	5-570A	26.1 x 19.9 x 32.9 (663 x 505 x 835)	286 (130)

Power Wave® 455M/STT® Robotic

The Power Wave® 455M/STT® Robotic is a high performance, digitally controlled inverter power source designed for robotic, hard automation and semiautomatic applications.

- **Program your own waveform** or choose from over 60 standard welding waveform programs.
- **Utilizes ArcLink®** – the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration to the power source and networked equipment.
- **Software based controls** can be upgraded as new features become available.
- **Process and Production Monitoring™** with access to real time (500Hz) feedback
- **A Power Wave® inverter operates at a high efficiency** (88-90%) with a 95% minimum power factor (at rated output) and is capable of operating from a universal input voltage (208 to 575 volts).
- **Features Lincoln's Surface Tension Transfer® (STT®) Process**, which controls heat input for great penetration and reduced spatter and fumes.



Shown:
K2263-1 Power Wave®
455/STT® Robotic

Processes

- MIG
- Pulsed
- STT®
- Flux-Cored

Output **DC** **Input**

Key Options

- K2207-2 Ethernet/DeviceNet™ Interface Module
- K1570-1 Dual Cylinder Platform Undercarriage
- K1813-1 Cool-Arc™ 40 115/1/50/60
- *More options at end of section*

Wire Feeders

- K1780-2 Power Feed™ 10R
- K2685-2 AutoDrive 4R90

Literature

E10.90

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
Power Wave® 455M/STT® Robotic	K2263-1	208/230/460/575/3/50/60	60Hz: 450A/38V/100% (570A/43V/60%) 50Hz: 400A/36V/100% (500A/40V/60%)	60Hz: 58/53/25/22A (82/78/37/31A) 50Hz: 49/45/23/18A (67/61/31/25A)	5-570A	26.1 x 19.9 x 32.9 (663 x 505 x 835)	286 (130)

Power Wave® 655 Robotic

For Tough Automation Jobs

The Power Wave® 655 Robotic is a high-performance, digitally controlled inverter power source capable of complex, high-speed waveform control. This Power Wave® connects seamlessly to robot controllers and hard automation PLCs to create a highly integrated and flexible welding cell.

- **Program your own waveform** or choose from over 60 standard welding waveform programs.
- **Utilizes ArcLink®**—the leading digital communication protocol for welding, making it the best choice for seamless, time-critical integration to the power source and networked equipment.
- **Software-based controls** can be upgraded as new features become available.
- **Process and Production Monitoring™** with access to real-time (500Hz) feedback.
- **A Power Wave® inverter operates at a high efficiency** (88-90%) with a 95% minimum power factor (at rated output) and is capable of operating from a universal input voltage (230 to 575 volts).
- **Excellent power source for heavy-duty Tandem MIG applications.**
- **Standard Ethernet/DeviceNet™** capabilities.



Shown: K1519-2 Power Wave® 655 Robotic

Processes

- MIG
- Pulsed
- Flux-Cored

Output **Input**

Key Options

- K1570-1 Dual Cylinder Platform Undercarriage
- K1813-1 Cool-Arc™ 40 115/1/50/60
- K2187-1 Cool-Arc™ 40 220-240/1/50/60
- *More options at end of section*

Wire Feeders

- K1780-2 Power Feed™ 10R
- K2685-2 AutoDrive™ 4R90

Literature

E10.95

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Wave® 655 Robotic	K1519-2	460/575/3/50/60 400/3/50/60	60Hz: 650A/44V/100% (815A/44V/60%)	60Hz: 41/33A (53/42A)	20-880A	26.1 x 19.9 x 32.9 (663 x 505 x 835)	306 (139)

Power Feed™ 10R

Compact Wire Drive System for Automation

The Power Feed™ 10R is a high performance, digitally controlled wire feeder designed to be part of a modular, multi-process welding system. It is specifically designed to mount to a robot arm or to use in hard automation applications.

- **Digitally controlled by the Power Wave® power source**, yielding the best performance in the industry.
- **Use with Lincoln power sources featuring ArcLink®**, the leading digital communications protocol for welding, making it the best choice for seamless integration with the power source and networked equipment.
- **Tachometer feedback** provides calibration and precise control of wire feed speed.
- **Feeder brakes from maximum speed to zero in milliseconds**, minimizing the chance of wire sticking in the puddle.
- **Select standard or high speed gears** for wide wire feed speed range.
- **Split wire guides** provide trouble-free feeding and offer fast, tool-less wire installation, changeover and maintenance.
- **Easy-to-read gauge** for accurate drive roll tension.
- **Brass-to-brass connections** for good connectivity between feeder and gun.
- **Self loading wire** feature for easy set-up.



Shown: K1780-2 Power Feed™ 10R mounted on FANUC Robot Arm.

Processes

- MIG
- Pulsed
- STT®
- Flux-Cored
- Metal-Cored

Output **Input**

Key Options

- K1785-25 Control Cable, Heavy Duty, 25 ft.
- K590-7 Water Connection Kit
- K1733-1 Wire Straightner
- K1546-1 Incoming Conduit Bushings, .025"-1/16"
- K1546-2 Incoming Conduit Bushings, 1/16"-3/32"
- K1500-2 Tweco® or Tregaskiss® Torch Bushings
- K1500-1 Lincoln or D&F® Torch Bushings
- K489-7 Binzel or Lincoln Fast-Mate™ Torch Bushings
- *More options at end of section*

Literature

E9.160

Product Name	Product Number	Wire Feed Speed Range inches (mm)	Wire Size Range – Solid inches (mm)	Wire Size Range – Cored inches (mm)	H x W x D inches (mm)	Net Weight lbs.(kg)
Power Feed™ 10R	K1780-2	50-800 (1.3-20.3) 75-1200 (2.0-30.5)	.025-3/32 (0.6-2.4) .025-1/16 (0.6-1.6)	.035-.120 (0.9-3.0) .035-5/64 (0.9-2.0)	8.9 x 10.3 x 8.1 (226 x 261 x 206)	22.4 (10.2)

Robotic Systems

Combine Lincoln Electric's industry leading welding and cutting expertise with the most recognized name in robotics, FANUC®, and you have a great robotics solution regardless of your application. We have the ability to seamlessly integrate all aspects of the automated welding/cutting process, from analysis to custom and pre-engineered cells, to software, service, and training.



Custom Robotic Solutions

From concept to design and build, Lincoln's automation engineers work closely with you to understand your manufacturing needs. Correct synergy, creative positioning design and production efficiency are all critical to producing repeatable, high quality, high volume solutions.



Shown: System 30 Custom Cell

Complete Single Source Robotic Solutions

- Welding applications evaluation
 - Robot feasibility testing
 - Sample part welding
 - Computer robot simulations
 - Return on investment calculations
- Complete system design and build
 - Pre-engineered systems
 - 24-hour hotline assistance
 - Operator training
 - Robot repair/rebuild
- In-the-field service support
 - In-plant start-up assistance
 - Emergency welder/robot part delivery
 - Long-term preventative maintenance programs

For further information, contact the Automation Team at: automation@lincolnelectric.com or call 216-383-2667

Automation Division

Regional Offices

Cleveland, OH
Phone: (888) 935-3878
Fax: (216) 383-8823

Detroit, MI
Phone: (248) 348-2575

Nashville, TN
Phone: (615) 291-9927
Fax: (615) 291-9928

Lincoln Electric's welding and automation experts are always as close as your phone – ready to provide fast, professional service and support.

Offering a variety of options:

- ▶ Preventive maintenance
- ▶ Repair services
- ▶ Upgrade services
- ▶ Redeployment capabilities

Equipment covered includes:

- ▶ Power Wave® 355M & F355i
- ▶ Power Wave® i400
- ▶ Power Wave® 450 & Synergic 7F
- ▶ Power Wave® 455R
- ▶ Power Wave® 455M & 455M/STT
- ▶ Power Wave® 655R
- ▶ Power Feed™ 10R
- ▶ AutoDrive™ 4R90



Robot Arm Selections

ARC Mate® 50iC/5L

- 5 kg (11.2 lbs) wrist loading capacity
- 6 axes controlled motion
- 892 mm (35.1 in.) reach

ARC Mate® 100iC

- 10 kg (22.4 lbs) wrist loading capacity
- 6 axes controlled motion
- 1420 mm (55.9 in.) reach

ARC Mate® 100iC/6L

- 6 kg (13.2 lbs) wrist loading capacity
- 6 axes controlled motion
- 1632 mm (64.2 in.) reach

ARC Mate® 120iC

- 20 kg (44.8 lbs) wrist loading capacity
- 20 kg (44.8 lbs) on J3 casting
- 6 axes controlled motion
- 1811 mm (71.3 in.) reach

ARC Mate® 120iC/10L

- 10 kg (22.4 lbs) wrist loading capacity
- 12 kg (26.5 lbs) on J3 casting
- 6 axes controlled motion
- 2009 mm (79.1 in.) reach

ARC Mate® R2000-165F

- 165 kg (360 lbs.) wrist loading capacity
- 6 axes controlled motion
- 2660 mm (104 in.) reach

ARC Mate® M710.C/20L

- 20 kg (44 lbs.) wrist loading capacity
- 6 axes controlled motion
- 3110 mm (122 in.) reach



Pre-Engineered Systems

Custom Integrated or Pre-Engineered Solutions



The ideal robotic welding system for your company may be one from our extensive menu of pre-engineered hardware and software configurations. Or, it may require the development of a custom cell that's designed and built specifically to meet your requirements. In either case, Lincoln's welding automation experts work with your team to identify the performance and quality characteristics that are most important to you, and then suggest appropriate robotic options for your review.

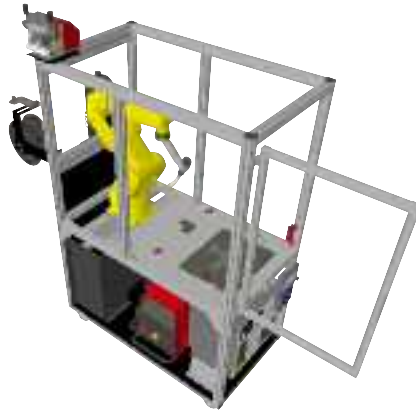
Lincoln offers a wide spectrum of pre-engineered systems to meet virtually any fabrication need.

EDUCATIONAL CELL

Product #: AD1222-36

Includes:

- FANUC ArcMate® 50iC/5L
- Power Wave® 355M
- 360 Amp Air Cooled Welding Torch
- Self-contained aluminum frame cart
- Robotic Software Package



SYSTEM 20

Product #: AD1222-29

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® i400
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

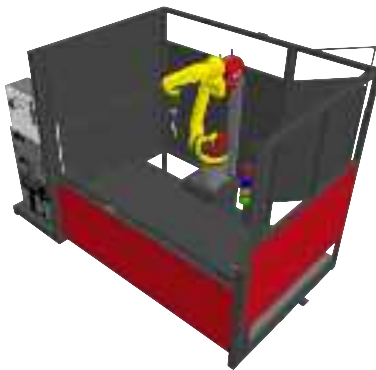


SYSTEM 5

Product #: AD1310-2

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

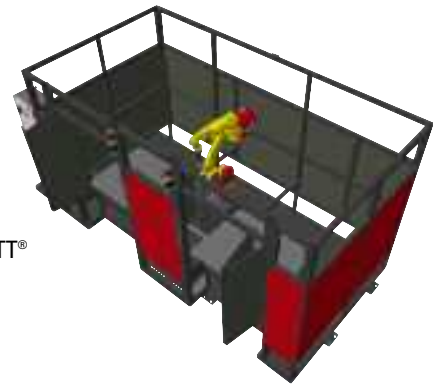


SYSTEM 30

Product #: AD1310-4

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

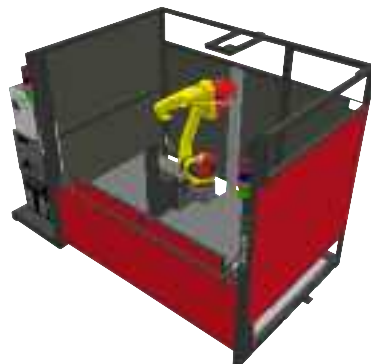


SYSTEM 10

Product #: AD1310-3

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

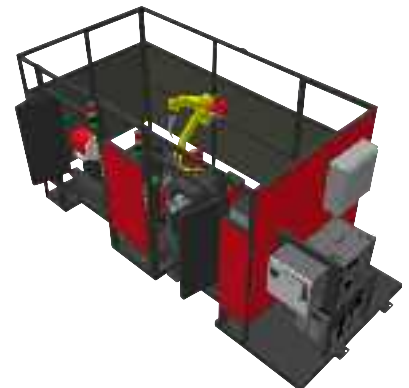


SYSTEM 30HS

Product #: AD1310-7

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center



Pre-Engineered Systems, con't.

Custom Integrated or Pre-Engineered Solutions



SYSTEM 35

Product #: AD1310-5

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center



SYSTEM 50HP

Product #: AD1310-8

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

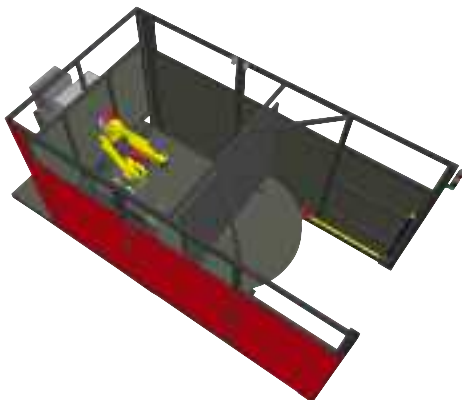


SYSTEM 40

Product #: AD1310-6

Includes:

- FANUC ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center

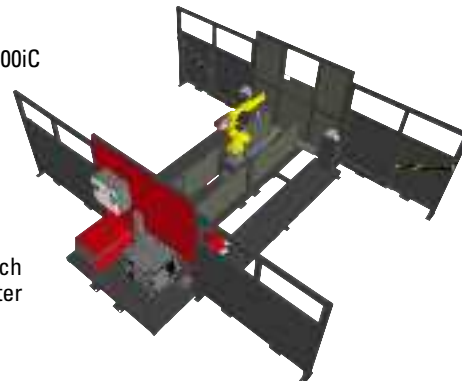


SYSTEM 55

Product #: AD1310-9

Includes:

- Fanuc ArcMate® 100iC
- LEA-500WC 8' 22
- Cool Arc® 40
- Power Wave® 455M/STT®
- Torch Guard/30iA
- Power REAM® Torch Maintenance Center



VERNON Tool

A Lincoln Electric Company



VERNON Abrasive Saw (VAS)



VERNON Pipe Cutting Machine (MPM)



VERNON Master Tube Plasma Profiler (MTC)

- ▶ *VERNON Tool Company, Ltd. is a manufacturer of computer-controlled pipe cutting equipment used for precision fabrication purposes based in San Diego, California.*
- ▶ *Founded in 1930, VERNON Tool Company provides solutions to difficult pipe fabrication and process flow issues in industrial construction, as well as heavy fabrication uses in the infrastructure and energy-related segments.*
- ▶ *Additional information can be found at www.VERNONTOOL.com.*



Automated Solutions Options

See "Recommended General Options" pgs. 151-171 for descriptions.

Power Wave® i400

General Options

K2673-1	Inverter Chasis
K2677-1	Integration Kit
K2670-1	CE Filter
K1543-25	ArcLink® Control Cable
K1785-2	Robotic Cable Adapter, 18 in.
K1785-12	Control Cable, 14 pin, Power Feed, external dress, 12 ft.
K1785-16	Control Cable, 14 pin, Power Feed, external dress, 16 ft.
K1785-25	Control Cable, 14 pin, Power Feed, external dress, 25 ft.
K1785-50	Control Cable, 14 pin, Power Feed, external dress, 50 ft.
K1785-100	Control Cable, 14 pin, Power Feed, external dress, 100 ft.
K940	STT® Sense Lead Kit, 25 ft.
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
—	Fume Extraction System

Wire Feeder Options

K2685-2	AutoDrive® 4R90
K1780-2	Power Feed™ 10R

AutoDrive™ 4R90

General Options

K590-7	Water Connection Kit
K2709-25	Control Cable, 14 pin, AutoDrive, external dress, 25 ft.
K2709-50	Control Cable, 14 pin, AutoDrive, external dress, 50 ft.
K2709-100	Control Cable, 14 pin, AutoDrive, external dress, 100 ft.
—	Fume Extraction System

Power Sources

—	Power Wave® 455M Robotic
—	Power Wave® 455M/STT® Robotic
—	Power Wave® 655 Robotic
—	Power Wave® i400

Power Wave® 455M Robotic & 455M/STT® Robotic

General Options

K2207-2	Ethernet/DeviceNet™ Interface Module
K1570-1	Dual Cylinder Platform Undercarriage
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
—	Fume Extraction System

Wire Feeder Options

K2685-2	AutoDrive® 4R90
K1780-2	Power Feed™ 10R

Power Wave® 655 Robotic

General Options

K1570-1	Dual Cylinder Platform Undercarriage
K2681-1	22-pin to 14-pin Adapter Cable Assembly
K1813-1	Cool Arc® 40 Water Cooler 115/1/50/60
K2444-2	CE Filter
—	Fume Extraction System

Wire Feeder Options

K2685-2	AutoDrive® 4R90
K1780-2	Power Feed™ 10R

Power Feed™ 10R

Drive Roll and Wire Guide Kits

See chart in "Recommended General Options" section.

General Options

K590-7	Water Connection Kit
K1785-2	Robotic Cable Adapter, 18 in.
K1785-12	Control Cable, 14 pin, Power Feed, external dress, 12 ft.
K1785-16	Control Cable, 14 pin, Power Feed, external dress, 16 ft.
K1785-25	Control Cable, 14 pin, Power Feed, external dress, 25 ft.
K1785-50	Control Cable, 14 pin, Power Feed, external dress, 50 ft.
K1785-100	Control Cable, 14 pin, Power Feed, external dress, 100 ft.
K1795-10	Control Cable, 10 ft.
K1795-25	Control Cable, 25 ft.
K1795-50	Control Cable, 50 ft.
K1795-100	Control Cable, 100 ft.
K1804-1	Robotic Cable Adapter, 22-pin to 14-pin, 10 ft.
K1804-2	Robotic Cable Adapter, 22-pin to 14-pin, 18 in.
K1805-1	Robotic Cable Adapter, 14-pin to 22-pin, 18 in.
—	Fume Extraction System

Power Sources

—	Power Wave® 455M Robotic
—	Power Wave® 455M/STT® Robotic
—	Power Wave® 655 Robotic
—	Power Wave® i400

Power REAM®

General Options

KP2435-1	Reaming Bit, 1/2" with Washer
KP2435-3	Reaming Bit, 5/8" with Washer
KP2435-5	Reaming Bit, 3/4" with Washer
KP2457-1	Anti-Spatter Fluid, 1 gallon
K2433-1	Power REAM® Robotic Cable, 20 ft.
K2434-1	Remote Power REAM® Reservoir Kit

CONSUMABLES

EXCALIBUR

SuperGlide

METALSHIELD

SuperGlaze

SuperArc

LINCORE
HARDFACING WIRE

BLUE MAX
MIG STAINLESS WIRE

INNERSHIELD





















WEARSHIELD
HARDFACING ELECTRODES

PIPELINER

ULTRACORE

Fleetweld®
Jetweld®
Lincolnweld®

Outershield®
Shield-Arc®

PACKAGE OPTIONS	PACKAGE OPTIONS
 Accu-Pak® Box (AP)	 Hermetically Sealed Pail (HS)
 Accu-Trak® Drum (AD)	 Plastic Bag (PLB)
 Accu-Trak® Reel (AR)	 Plastic Spool (SP)
 Bag (B)	 Sahara ReadyPak® (SRP)
 Bulk Bag (BB)	 Speed-Feed® Drum (D)
 Cardboard Carton (CT)	 Speed-Feed® Reel (R)
 Coil (C)	 Steel Spool (SSP)
 Easy Open Hermetic Can (EO)	 Tube (TB)
 Fiber Spool (FS)	 Vacuum Sealed Foil Bag (VFB)
 Foil Bag (FB)	 Vertical Reel (VR)



Premium Low Hydrogen Mild Steel Stick Electrode



Industry Tested. Operator Approved.

- ▶ **ENHANCED ARC PERFORMANCE** – Smooth arc and square coating burn-off increases puddle visibility and control, even in out-of-position welding.
- ▶ **EASY STRIKE AND RE-STRIKE CAPABILITY** – Minimize starting porosity.
- ▶ **EFFORTLESS SLAG REMOVAL** – Reduce post-weld clean-up and slag inclusions.
- ▶ **SAFETY FIRST PACKAGING** – Easy Open Pull Tab Lid for quick access with smooth edges to minimize risk of operator injury.

LINCOLN[®]
ELECTRIC
THE WELDING EXPERTS[®]

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Steel – Carbon & Low Alloy						
Fast Freeze, Out-of-Position, Mild Steel Stick Electrodes						
Fleetweld® 35	E6011	AC DC±	Operators consistently give this electrode high marks. This quality Lincoln product is a proven performer for sheet metal welding applications and AC pipe welding. Fleetweld 35 is a great electrode to use on jobs where the steel isn't clean.	3/32	30CT (10EO)	ED032567
				1/8	30CT (10EO)	ED032568
				5/32	30CT (10EO)	ED032569
				3/32	50CT	ED028152
				1/8	50CT	ED028153
				5/32	50CT	ED028154
				3/16	50CT	ED028155
				7/32	50CT	ED032301
				1/4	50CT	ED028157
Fleetweld® 35LS	E6011	AC DC±	Specifically designed for making tack welds under Innershield® deposits. Use Fleetweld® 35LS with confidence on plated, dirty, painted, or greasy steel. It's an outstanding stick choice for AC pipe welding, for applications that require deep penetration, and in jobs where x-ray quality welds are required.	1/8	50CT	ED028158
				5/32	50CT	ED028159
Fleetweld® 180	E6011	AC DC±	Got a small AC welder? Here's your electrode! Fleetweld® 180 offers excellent arc stability for excellent performance with power sources as low as 50V open-circuit voltage (OCV). A great stick electrode with the ability to start easily on low open circuit voltage welders.	3/32	6CT (1TB)	ED031152
				1/8	6CT (1TB)	ED031722
				3/32	20CT (5CT)	ED030562
				1/8	20CT (5CT)	ED030563
				5/32	20CT (5CT)	ED031724
				3/32	50EO	ED010110
1/8	50EO	ED010105				
5/32	50EO	ED010114				
Fleetweld® 22	E6022	DC+ AC	Developed specifically for floor decking and other applications where burn-through spot welding on sheet metal is required. Fleetweld® 22 is great for galvanized or plated sheet steel, as well as on steel that is painted or dirty.	1/8	50CT	ED021896
				5/32	50CT	ED021895

Fast-Fill, Fill-Freeze, High Deposition, Mild Steel Stick Electrode

Jetweld® 1	E7024-1	AC DC±	When the project involves large welds, you can't pick a more user-friendly electrode! Operators appreciate Jetweld® 1's smooth bead and high deposition rates. A great general purpose electrode for single or multi-pass applications.	1/8	50CT	ED010362
				5/32	50CT	ED010372
				3/16	50CT	ED010366
				7/32	50CT	ED010375
				1/4	50CT	ED010360
Jetweld® 2	E6027	AC DC±	When the job demands x-ray quality welds, high deposition rates, and excellent wash-in, reach for Jetweld® 2. We've designed Jetweld® 2 for peak performance on multiple pass welds, and fast-fill single pass welds.	5/32	50CT	ED010502
				3/16	50CT	ED010501
				1/4	50CT	ED010500

Fast-Fill, Fill-Freeze, High Speed, Mild Steel Stick Electrodes

Fleetweld® 37	E6013	AC DC±	Here's a terrific all-position electrode for low amperage welding on sheet metal—especially in applications where appearance is important. We've designed Fleetweld® 37 for excellent performance with smaller AC welders having low open-circuit voltages. It's an excellent choice for jobs involving irregular or short welds that require a change in position.	3/32	6CT (1TB)	ED031726
				1/8	6CT (1TB)	ED031727
				1/16	20CT (5CT)	ED030692
				5/64	20CT (5CT)	ED030691
				3/32	20CT (5CT)	ED030564
				1/8	20CT (5CT)	ED030565
				5/32	20CT (5CT)	ED031729
				3/32	30CT (10EO)	ED032573
				1/8	30CT (10EO)	ED032574
				5/64	50CT	ED010170
				3/32	50CT	ED010161
				1/8	50CT	ED010153
				5/32	50CT	ED010165
				3/16	50CT	ED010156
Fleetweld® 47	E7014	AC DC±	Fleetweld® 47 features high deposition rates for fast performance. Operators love this easy-to-use, all-position electrode! Choose Fleetweld® 47 for sheet metal lap joints and fillet welds, general purpose plate welding and maintenance jobs.	3/32	6CT (1TB)	ED031713
				1/8	6CT (1TB)	ED031153
				3/32	20CT (5CT)	ED030566
				1/8	20CT (5CT)	ED030567
				5/32	20CT (5CT)	ED031742
				3/32	50CT	ED010189
				1/8	50CT	ED010183
5/32	50CT	ED010193				
3/16	50CT	ED010186				

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can TB = Tube

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Steel – Carbon & Low Alloy, con't.						
Low Hydrogen, Mild Steel Stick Electrodes						
Excalibur® 7018 MR	E7018 H4R	DC+ AC	Excalibur® 7018 MR is a low hydrogen stick electrode designed for superior arc performance, weld appearance and operability. It is recommended for all position welding of mild steel with low diffusible hydrogen levels in weld deposits. For industry leading puddle control, strike-ability and slag removal, even in out-of-position welding—choose Excalibur® 7018 MR.	3/32	6CT (1TB)	ED032086
				1/8	6CT (1TB)	ED031468
				5/32	6CT (1TB)	ED032087
				3/32	30CT (10EO)	ED032588
				1/8	30CT (10EO)	ED032589
				5/32	30CT (10EO)	ED032590
				3/32	50EO	ED028280
				1/8	50EO	ED028281
				5/32	50EO	ED028282
				3/16	50EO	ED028283
7/32	50EO	ED028917				
1/4	50EO	ED028918				
Excalibur® 7018-1 MR	E7018-1 H4R	DC+ AC	When the job involves critical, out-of-position welding, reach for Lincoln Electric's® Excalibur® 7018-1. It offers a beautifully clean weld puddle, uniform slag follow, and superior wash-in with no undercutting. Also great for welding on steels with marginal weldability.	3/32	30CT (10EO)	ED032591
				1/8	30CT (10EO)	ED032592
				3/32	50EO	ED028700
				1/8	50EO	ED028702
				5/32	50EO	ED028704
				3/16	50EO	ED028706
				7/32	50EO	ED028919
				1/4	50EO	ED028920
Lincoln® 7018AC	E7018 H8	AC DC±	AC? DC? This electrode performs beautifully either way! Lincoln® 7018AC is a great choice for low open circuit voltage AC power sources. Cold restrikes are no problem with this versatile, all-position electrode.	3/32	6CT(1TB)	ED031714
				1/8	6CT(1TB)	ED031715
				3/32	20CT(5CT)	ED030568
				1/8	20CT(5CT)	ED030569
				5/32	20CT(5CT)	ED031736
				3/32	50EO	ED031732
1/8	50EO	ED031734				
5/32	50EO	ED031738				
Jetweld® LH-70	E7018 H4R	DC+ AC	A top-choice electrode for welding on thick sections and restrained joints when cracking is an issue. It's also a good call when the project involves hard-to-weld steels. Jetweld® LH-70 also offers high deposition rates.	3/32	50EO	ED010568
				1/8	50EO	ED010561
				5/32	50EO	ED010575
				3/16	50EO	ED010564
				7/32	50EO	ED010577
				1/4	50EO	ED010558
Jet-LH®-78 MR	E7018 H4R	DC+ AC	Great for jobs on mild steel and some high-strength low-alloy steels. It also tolerates high sulfur and high silicon steels. Jet-LH®-78 MR features higher tensile strength for stress-relieved properties.	3/32	40CT (5CT)	ED030174
				1/8	40CT (5CT)	ED030175
				5/32	40CT (5CT)	ED030176
				3/32	50EO	ED015161
				1/8	50EO	ED015198
				5/32	50EO	ED015141
				3/16	50EO	ED015186
				7/32	50EO	ED015258
				1/4	50EO	ED015383
Excalibur® 7028	E7028 H8	AC DC+	Excalibur® 7028 is a low hydrogen electrode designed for high-deposition welding applications in the flat and horizontal positions. Excalibur® is Lincoln Electric's premium line of low hydrogen electrodes featuring excellent slag release, arc stability, resistance to starting porosity, and puddle control.	5/32	50EO	ED032636
				3/16	50EO	ED032790
				7/32	50EO	ED032638

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can TB = Tube



Excalibur® low hydrogen stick electrodes are designed for superior arc performance, weld appearance and operability. They are recommended for all position welding of mild steel with low diffusible hydrogen levels in weld deposits. For industry leading puddle control, strike-ability and slag removal—choose Excalibur®.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Steel – Carbon & Low Alloy, con't.						
Low Hydrogen, Low Alloy Steel Stick Electrodes						
Excalibur® 7018-A1 MR	E7018-A1 H4R	DC+ AC	Excalibur® 7018-A1 MR low hydrogen electrode is an outstanding choice for all position welding of 0.50% molybdenum low alloy steels of 50 ksi (345 MPa) minimum yield strength.	3/32	30CT(10EO)	ED032593
				1/8	30CT(10EO)	ED032594
				5/32	30CT(10EO)	ED032595
				3/32	50EO	ED030862
				1/8	50EO	ED030863
				5/32	50EO	ED030864
Excalibur® 8018-C1 MR	E8018-C1 H4R	DC+ AC	Excalibur® 8018-C1 MR is the ideal moisture resistant electrode for welding on equipment and pipe that transport liquid ammonia, propane and other gases. An excellent all position electrode for applications requiring a nominal 2-1/4% nickel deposit.	3/32	30CT(10EO)	ED032596
				1/8	30CT(10EO)	ED032597
				5/32	30CT(10EO)	ED032598
				3/32	50EO	ED030876
				1/8	50EO	ED030877
				5/32	50EO	ED030878
				3/16	50EO	ED030879
				7/32	50EO	ED030881
1/4	50EO	ED030880				
Excalibur® 8018-C3 MR	E8018-C3 H4R	DC+ AC	Excalibur® 8018-C3 MR is a 1% nickel all position electrode for fabrication or repair of 1% nickel steels, as well as a wide variety of other low alloy and carbon steels.	3/32	30CT(10EO)	ED032599
				1/8	30CT(10EO)	ED032600
				5/32	30CT(10EO)	ED032601
				3/32	50EO	ED030892
				1/8	50EO	ED030893
				E5/32	50EO	ED030894
				3/16	50EO	ED030895
				7/32	50EO	ED030897
				1/4	50EO	ED030896
Excalibur® 9018M MR	E9018-M H4R	DC+	Excalibur® 9018M MR is intended for welding high strength steels of 90,000 psi (620 MPa) tensile strength and higher.	3/32	30CT(10EO)	ED032602
				1/8	30CT(10EO)	ED032603
				5/32	30CT(10EO)	ED032604
				3/16	30CT(10EO)	ED032605
				3/32	50EO	ED030868
				1/8	50EO	ED030869
				5/32	50EO	ED030870
				3/16	50EO	ED030871
Excalibur® 11018M MR™	E11018M-H4R	DC+	Excalibur® 11018M MR™ is designed primarily for joining high strength steel types in the as-welded or stress relieved conditions with excellent low temperature impact properties and robust welding procedures. All-position welding, except verticle down.	3/32	30CT(10EO)	ED032606
				1/8	30CT(10EO)	ED032607
				5/32	30CT(10EO)	ED032608
				3/32	50EO	ED031975
				1/8	50EO	ED031976
				5/32	50EO	ED031977
				3/16	50EO	ED031978
Blue Max® SL 9Cr (P91)	E9016-B9 H4	DC± AC	Blue Max® SL 9Cr (P91) is a basic, very low hydrogen stick electrode designed for 9% Cr, 1% Mo creep resistant and hydrogen-resistant steels commonly used in power plants and petrochemical industries. SL 9Cr weld deposits can be used at a maximum service temperature of 1200°F (650°C).	(2.5 mm)	3SRP	ED031235
				(3.2 mm)	4SRP	ED031236
				(4.0 mm)	3.3SRP	ED031237

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Steel – Carbon & Low Alloy, con't.						
Fill Freeze, Out-Of-Position Pipe Welding, Mild Steel & Low Alloy Steel Stick Electrodes						
Fleetweld® 5P	E6010	DC+	Fleetweld® 5P is a great choice for welding on dirty, rusty, greasy or painted steel – especially in vertical or overhead applications.	3/32	40CT(5CT)	ED030141
				1/8	40CT(5CT)	ED030142
				5/32	40CT(5CT)	ED030143
				3/32	30CT(10EO)	ED032561
				1/8	30CT(10EO)	ED032562
				5/32	30CT(10EO)	ED032563
				3/32	50EO	ED010211
				1/8	50EO	ED010203
				5/32	50EO	ED010216
				3/16	50EO	ED010207
7/32	50EO	ED010219				
1/4	50EO	ED010200				
Fleetweld® 5P+	E6010	DC+	Lincoln's® Fleetweld® 5P+ is ideal for steel that's less than clean. It's a first choice for pipe welding, and vertical-up and overhead plate welding. This electrode is a longtime favorite among operators who handle cross-country and in-plant pipe welding.	3/32	30CT(10EO)	ED032564
				1/8	30CT(10EO)	ED032565
				5/32	30CT(10EO)	ED032566
				3/32	50EO	ED010283
				1/8	50EO	ED010278
				5/32	50EO	ED010285
F3/16	50EO	ED010281				
Shield-Arc® 85	E7010-A1	DC+	Need a reliable, all-position stick electrode for high tensile steel pipe? Here's your electrode! Shield-Arc® 85 produces a 70,000 psi, 1/2% molybdenum weld deposit for use on 1/2% molybdenum pipe steels and API 5LX-42 through X-56 line pipe.	3/32	50EO	ED012893
				1/8	50EO	ED012885
				5/32	50EO	ED012896
				3/16	50EO	ED012889
Shield-Arc® HYP+	E7010-P1	DC+	Tendency for "fingernailing" and electrode sticking have been virtually eliminated! Designed for all passes of API 5LX-52 through X-65 high strength pipe. Shield-Arc® HYP+ provides the welder with a clean, visible weld puddle and superior puddle control. A true E7010-P1 electrode.	1/8	50EO	ED029511
				5/32	50EO	ED029513
				3/16	50EO	ED029509
Shield-Arc® 70+	E8010-G	DC+	Here's an electrode that makes short work of even the most challenging high silicon pipe applications! Shield Arc® 70+ is an outstanding choice for API 5LX-56 through X-70 grade pipe, as well as for a wide range of sheet metal welding assignments.	1/8	50EO	ED012841
				5/32	50EO	ED012849
				3/16	50EO	ED012845
Shield-Arc® 90	E9010-G	DC+	An all-position pipe electrode that's a great choice when the task is vertical down welding on API 5LX-70 through X-80 pipe. Shield-Arc® 90 also performs well in situations where low hydrogen processes are not practical, and when welding on dirty steels.	(3.2 mm)	50EO	EDS01693
				(4.0 mm)	50EO	EDS01694
				(5.0 mm)	50EO	EDS01695

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can TB = Tube

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
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Carbon Steel Gas Welding

Lincoln® R45	R45	General purpose oxyfuel rod for welding mild steels.	1/16	20CT(2TB)	ED025392
			3/32	20CT(2TB)	ED025395
			1/8	20CT(2TB)	ED025398
			1/16	10CT	ED025394
			3/32	10CT	ED025397
			1/8	10CT	ED025400
Lincoln® R60	R60	Oxyfuel rod for welding a variety of steels where additional strength and ductility are needed.	1/16	20CT(2TB)	ED025401
			3/32	20CT(2TB)	ED025404
			1/8	20CT(2TB)	ED025407
			1/16	10CT	ED025403
			3/32	10CT	ED025406
			1/8	10CT	ED025409

Carbon Steel TIG Welding

Lincoln® ER70S-2	ER70S-2	Triple deoxidized rod which produces x-ray quality welds over most surface conditions.	1/16	20CT(5TB)	ED025880
			3/32	20CT(5TB)	ED025881
			1/8	20CT(5TB)	ED025882
			1/16	10CT	ED025439
			3/32	10CT	ED025442
			1/8	10CT	ED025445
			1/16	50CT	ED026649
			3/32	50CT	ED026650
			1/8	50CT	ED026651
Lincoln® ER70S-6	ER70S-6	High quality rod with high levels of Mn and Si which produces sound welds with excellent wetting action.	1/16	20CT(5TB)	ED025877
			3/32	20CT(5TB)	ED025878
			1/8	20CT(5TB)	ED025879
			1/16	10CT	ED025448
			3/32	10CT	ED025451
			1/8	10CT	ED025454
			1/16	50CT	ED026652
			3/32	50CT	ED026653
			1/8	50CT	ED026654

Stainless Steel

Lincoln® ER308/308L	ER308, ER308L	For joining 304 and 304L and other "18-8" stainless steels.	1/16	10CT(1TB)	ED025410
			3/32	10CT(1TB)	ED025413
			1/8	10CT(1TB)	ED025416
			1/16	10CT	ED025412
			3/32	10CT	ED025415
			1/8	10CT	ED025418
			1/16	50CT	ED026655
			3/32	50CT	ED026656
			1/8	50CT	ED026657
Lincoln® ER309/309L	ER309, ER309L	For 309 stainless steels and joining carbon steels or low alloy steels to stainless steels.	1/16	10CT(1TB)	ED025419
			3/32	10CT(1TB)	ED025422
			1/8	10CT(1TB)	ED025425
			1/16	10CT	ED025421
			3/32	10CT	ED025424
			1/8	10CT	ED025427
			1/16	50CT	ED026658
			3/32	50CT	ED026659
			1/8	50CT	ED026660

(Please refer to page 124 for additional Stainless, Nickel and High Alloy TIG cut lengths.)

Package Code Key: CT = Cardboard Carton TB = Tube

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
Stainless Steel, con't.					
Lincoln® ER316/316L	ER316, ER316L	For joining 316L stainless steels.	1/16	10CT(1TB)	ED025428
			3/32	10CT(1TB)	ED025431
			1/8	10CT(1TB)	ED025434
			1/16	10CT	ED025430
			3/32	10CT	ED025433
			1/8	10CT	ED025436
			1/16	50CT	ED026661
			3/32	50CT	ED026662
			1/8	50CT	ED026663

Aluminum

SuperGlaze® 4043	ER4043	Aluminum-silicon alloy for use on many weldable cast and wrought aluminum alloys. The silicon addition improves puddle fluidity, making it a preferred alloy.	1/16	10CT	ED031111
			3/32	10CT	ED031112
			1/8	10CT	ED031113
			1/16	25CT	ED026664
			3/32	25CT	ED026665
			1/8	25CT	ED026666
SuperGlaze® 5356	ER5356	Aluminum-magnesium alloy for use on many weldable cast and wrought aluminum alloys. SuperGlaze® 5356 is generally chosen for its high shear strength.	1/16	10CT	ED031108
			3/32	10CT	ED031109
			1/8	10CT	ED031110
			1/16	25CT	ED026667
			3/32	25CT	ED026668
			1/8	25CT	ED026669



A fabricator from Bill Davis Racing® TIG welds a seat for a NASCAR® racecar using Lincoln® machines and consumables.

(Please refer to page 124 for additional Stainless, Nickel and High Alloy TIG cut lengths.)

Package Code Key: CT = Cardboard Carton TB = Tube

SuperArc®

Premium Copper Coated, Mild Steel MIG Wire



Top Performance and Reliability. Guaranteed.

- ▶ **SUPERIOR ARC PERFORMANCE AND FEEDABILITY** – MicroGuard® Ultra surface treatment on all SuperArc® wire maximizes arc performance and contact tip life, while minimizing spatter.
- ▶ **INDUSTRY-LEADING CONSISTENCY** – Lincoln Electric tests all incoming raw steel and finished product with more restrictive standards than are required by AWS to offer customers consistent arc action and wire stiffness.
- ▶ **WIDE RANGE OF DIAMETERS AND PACKAGING OFFERED** – All SuperArc MIG wires are available in a variety of diameters and alloys with a generous range of application specific packaging options from two-pound spools to 1000 lb. drums.
- ▶ **SATISFACTION GUARANTEED** – Lincoln is so confident that SuperArc is the best performing and most trouble-free MIG wire offered in the market that we offer a 100% satisfaction MIGuarantee.

LINCOLN®
ELECTRIC
THE WELDING EXPERTS®



Today, Lincoln's Super Arc® premium copper-coated MIG wire, and Super Glide® premium bare MIG wire, are the choice of welders and welding decision-makers everywhere because of their exceptional consistency, feedability, and arc performance.

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
Mild Steel Wire					
SuperArc® L-50	ER70S-3	Our most popular MIG wire, SuperArc® L-50, premium copper coated wire, is an excellent choice for 70,000 psi (482 MPa) tensile strength, carbon steel base materials. SuperArc® L-50 has moderate levels of silicon and manganese for deoxidation and cleaning action. Designed for use on clean, oil-free, and rust-free base material. SuperArc® L-50 also has an excellent reputation for feedability and trouble-free performance. Shielding gases include argon/carbon dioxide blends, argon/oxygen blends, or straight carbon dioxide.	.030	33SP	ED032923
			.035	33SP	ED032924
			.045	33SP	ED032925
			.030	33SSP	ED031407
			.035	33SSP	ED031408
			.045	33SSP	ED031409
			.035	44SSP	ED031914
			.045	44SSP	ED031915
			.052	44SSP	ED031916
			.035	44FS	ED021268
			.045	44FS	ED021270
			.035	60C	ED011301
			.045	60C	ED011306
			.052	60C	ED011311
			1/16	60C	ED011317
			.035	60FS	ED021269
			.045	60FS	ED021271
			.052	60FS	ED021273
			1/16	60FS	ED027274
			.030	500AD	ED029223
			.035	500AD	ED021052
			.040	500AD	ED028729
			.045	500AD	ED020526
			.052	500AD	ED020527
			.035	500AP	ED032899
			.045	500AP	ED032901
			.052	500AP	ED032902
			1/16	500AP	ED032903
			.035	1000R	ED011647
			.045	1000R	ED011648
			.052	1000R	ED011649
			1/16	1000R	ED011650
.035	1000AR	ED021361			
.045	1000AR	ED020524			
.052	1000AR	ED020525			
1/16	1000AR	ED029222			
.035	1000AD	ED028825			
.045	1000AD	ED028826			
.052	1000AD	ED029082			
1/16	1000AD	ED029083			
.035	900AP	ED032842			
.045	1000AP	ED032844			
.052	1000AP	ED032845			
1/16	1000AP	ED032846			
SuperGlide® S3	ER70S-3	SuperGlide® S3, our premium bare MIG wire, like our SuperArc® L-50, is an excellent choice for 70,000 psi (482 MPa) tensile strength, carbon steel base materials. SuperGlide® S3 has moderate silicon and manganese deoxidizer levels and has an excellent reputation for feedability and trouble-free performance. Designed for use on clean, oil-free, and rust-free base material. SuperGlide® S3 MIG wire is an excellent choice when a bare or non-copper coated ER70S-3 wire is preferred. Shielding gases include argon/carbon dioxide blends, argon/oxygen blends, or straight carbon dioxide.	.035	44FS	ED028621
			.045	44FS	ED028622
			.035	500AD	ED030772
			.045	500AD	ED030773
			.052	500AD	ED030774
			.045	1000R	ED028625
			1/16	1000R	ED028633
			.045	1000AD	ED029087

Package Code Key: AD = Accu-Trak® Drum AP = Accu-Pak® Box AR = Accu-Trak® Reel C = Coil CT = Cardboard Carton FS = Fiber Spool
 R = Speed Feed® Reel SP = Plastic Spool SSP = Steel Spool VR = Vertical Reel



Today, Lincoln's Super Arc® premium copper-coated MIG wire, and Super Glide® premium bare MIG wire, are the choice of welders and welding decision-makers everywhere because of their exceptional consistency, feedability, and arc performance.

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
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Mild Steel Wire, con't.

SuperArc® L-54	ER70S-4	SuperArc® L-54 premium copper coated MIG wire is your first choice when welding on metals with a light to medium presence of millscale. For best performance, use on clean, oil-free, and rust-free base material. Improved wetting at the toes of a weld when compared to welds made with ER70S-3 electrode. SuperArc® L-54 has higher silicon and manganese deoxidizer levels than AWS ER70S-3 electrodes to tolerate surface contaminants. Shielding gases include argon/carbon dioxide blends, argon/oxygen blends, or straight carbon dioxide.	.035	44SSP	ED031052
			.052	44SSP	ED031054
			.035	44FS	ED021117
			.035	500AD	ED031033
			.045	500AD	ED031034
			.052	500AD	ED031035
			.035	1000AD	ED031036
			.045	1000AD	ED031037
			.052	1000AD	ED031038
			1/16	1000AD	ED031039
SuperArc® L-56	ER70S-6	Lincoln's® premium copper coated MIG wire, SuperArc® L-56 is an excellent choice for welding on metals with a medium to high presence of millscale. For best performance, use on clean, oil-free, and rust-free base material. Best weld appearance and toe wetting when compared to ER70S-3 and ER70S-4 classifications. SuperArc® L-56 has high silicon and manganese deoxidizer levels. Superior feedability and excellent arc characteristics are trademarks of SuperArc® L-56. Shielding gases include argon/carbon dioxide blends, argon/oxygen blends, or straight carbon dioxide.	.025	10CT(2SP)	ED030583
			.030	10CT(2SP)	ED030631
			.035	10CT(2SP)	ED030632
			.025	12.5SP	ED015790
			.030	12.5SP	ED023334
			.035	12.5SP	ED028676
			.045	12.5SP	ED029042
			.030	33SP	ED032926
			.035	33SP	ED032927
			.045	33SP	ED032928
			.030	33SSP	ED031410
			.035	33SSP	ED031411
			.045	33SSP	ED031412
			.035	44SSP	ED025945
			.045	44SSP	ED025946
			.035	44FS	ED021274
			.040	44FS	ED027384
			.045	44FS	ED021276
			.052	44FS	ED021278
			.035	60C	ED011655
			.045	60C	ED011659
			.052	60C	ED011663
			1/16	60C	ED011666
			.035	60FS	ED021275
			.045	60FS	ED021277
.052	60FS	ED021279			
.035	250AD	ED029914			
.045	250AD	ED029915			
.052	250AD	ED029916			
.030	500AD	ED030771			
.035	500AD	ED021056			
.045	500AD	ED020532			
.052	500AD	ED020533			
1/16	500AD	ED029225			

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Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
Mild Steel Wire, con't.					
SuperArc® L-56, con't.			.035	500AP	ED032904
			.045	500AP	ED032905
			.052	500AP	ED032906
			1/16	500AP	ED032907
			.035	1000R	ED011734
			.045	1000R	ED011735
			.052	1000R	ED011736
			1/16	1000R	ED011737
			.035	1000AR	ED021362
			.045	1000AR	ED020530
			.052	1000AR	ED020531
			.035	1000AD	ED028827
			.040	1000AD	ED031032
			.045	1000AD	ED028828
			.052	1000AD	ED029084
			1/16	1000AD	ED029085
.035	900AP	ED032847			
.045	1000AP	ED032849			
.052	1000AP	ED032850			
1/16	1000AP	ED032851			
SuperGlide® S6	ER70S-6	Lincoln's® premium bare, mild steel MIG wire, SuperGlide® S6 is an excellent choice for welding on metals with a medium to high presence of millscale. For best performance use on clean, oil-free, and rust-free base material. S6 will tolerate higher levels of surface contaminants than ER70S-3 or S-4 electrodes. Best weld appearance and toe wetting when compared to ER70S-3 and ER70S-4 classifications. High silicon and manganese deoxidizer levels. SuperGlide® S6 MIG wire is the choice for you when a bare or non-copper coated ER70S-6 wire is preferred. Shielding gases include argon/carbon dioxide blends, argon/oxygen blends, or straight carbon dioxide.	.035	44FS	ED028635
			.045	44FS	ED028636
			.052	44FS	ED028637
			.035	500AD	ED030694
			.045	500AD	ED030695
			.052	500AD	ED030696
			.035	1000AR	ED028642
			.045	1000AR	ED028643
			.035	1000AD	ED029089
			.045	1000AD	ED029090
SuperArc® L-59™		SuperArc® L-59™ is a copper coated, mild steel, engineered alloy wire that leads the industry in arc performance, wire feedability, and consistency, as well as extended contact tip life. Improved arc deoxidizing and wetting action, enhanced silicon island management, and minimal spatter provide operators with reduced pre- and post-weld clean up time and higher deposition rates. SuperArc® L-59™ handles higher amounts of surface contaminants and is designed for all position welding.	.035	44SSP	ED032366
			.045	44SSP	ED032367
			.052	44SSP	ED032368
			.035	500AP	ED032894
			.045	500AP	ED032896
			.052	500AP	ED032897
			1/16	500AP	ED032898
			.035	900AP	ED032861
			.045	1000AP	ED032863
			.052	1000AP	ED032864
			1/16	1000AP	ED032865
			Low Alloy Wire		
SuperArc® LA-75	ER80S-Ni1	SuperArc® LA-75 is a premium copper coated, low alloy MIG wire certified to meet 80,000 psi (552 MPa) minimum tensile strength. Optimal mechanical properties are achieved with a 98-95% argon, 2-5% oxygen shielding gas blend. Can be welded with 90% argon, 10% carbon dioxide gas blend, as well as 75% argon, 25% carbon dioxide mixture. Charpy V-Notch impact testing meets or exceeds 20 ft. lbs. (27 J) at -50°F (-46°C). LA-75 delivers a weld deposit with outstanding corrosion resistance for use on ASTM A588 weathering steels.	.035	33SSP	ED031415
			.045	33SSP	ED031416
			.045	500AD	ED027345

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Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
Low Alloy Wire, con't.					
SuperArc® LA-90	ER80S-D2 ER90S-D2 (ER90S-G)	SuperArc® LA-90 is our premium copper coated, low alloy MIG wire manufactured to meet tensile strength requirements of 80,000 to 90,000 psi (552-620 MPa) minimum. The addition of 0.5% molybdenum provides strength after stress relief. Ideal selection when welding ASTM A182, A217, A234 and A335 high temperature pipe, fittings, flanges and valves and A336 pressure vessel forgings. Best mechanical properties are achieved with an 98-95% argon, 2-5% oxygen shielding gas blend.	.035	33SSP	ED031413
			.045	33SSP	ED031414
			.035	44SSP	EDS30775
			.045	44SSP	EDS30776
			.052	44SSP	EDS30777
			.035	60C	ED011088
			.045	60C	ED014779
			1/16	60C	ED013999
			.045	60FS	EDS01380
			.035	500AD	EDS01372
			.045	500AD	ED001378
			.052	500AD	ED026627
			.045	500AP	ED032919
			.052	500AP	ED032920
			.045	1000R	ED014828
			.052	1000R	EDS01383
.035	1000AR	EDS29593			
.045	1000AR	EDS29594			
.052	1000AR	EDS29595			
.035	1000AD	EDS29590			
.045	1000AD	ED029591			
.052	1000AD	EDS29592			
SuperArc® LA-100	ER100S-G ER110S-G MIL-100S-1 (Military)	SuperArc® LA-100, our premium copper coated, low alloy MIG wire is designed for use on 100,000 psi (690 MPa) tensile base material and those materials that require a minimum yield strength of 82,000 psi (565 MPa). Excellent for welding on ASTM A514, A543, A724 and A782 quenched and tempered plate or HY-80 base material. LA-100 provides excellent impact properties under higher heat input conditions. Best mechanical properties are achieved with an 98-95% argon, 2-5% oxygen shielding gas blend or 95% argon, 5% CO ₂ . Also meets MIL-E-23765/2C, /2D, /2E specifications as a MIL-100S-1 classification.	.045	33SSP	ED031417
			.035	44SSP	EDS30778
			.045	44SSP	EDS30779
			.052	44SSP	EDS30780
			.045	60C	ED010993
			1/16	60C	ED010996
			.035	500AD	ED031445
			.045	500AD	EDS01162

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SuperGlaze®

Premium Aluminum MIG Wire



More of What You Need.

- ▶ **CONTROLLING ALLOYS** - Alloy is carefully refined prior to casting to minimize hydrogen, alkaline metals, and inclusions.
- ▶ **CONTINUOUS CASTING** - Keeps the surface free from imperfections and impurities.
- ▶ **DRAWING THE WIRE** - Advanced wire drawing technology preserves surface integrity and internal soundness.
- ▶ **TESTING THE WIRE** - Continuous finished product inspection and surface quality evaluations must be passed.

LINCOLN®
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THE WELDING EXPERTS®



SuperGlaze® controls the problems usually associated with aluminum wire feeding such as birdnesting, tangling and burnback, by providing a pristine surface condition and feeding the wire with less force than typical competitive products.

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
SuperGlaze®					
SuperGlaze® 1100	ER1100	SuperGlaze® 1100 is highly resistant to chemical corrosion and has good crack resistance. Suitable for electrical and chemical applications utilizing aluminum base metal with little or no alloying elements. Like all 1XXX filler alloys, Lincoln's® SuperGlaze® 1100 is the softest aluminum MIG wire and requires extra care to ensure good feeding.	3/64	16SP	EDS28407
SuperGlaze® 4043	ER4043	SuperGlaze® 4043 is a great choice for the welding of heat-treatable base alloys and more specifically the 6XXX series alloys. It has a lower melting point and more fluidity than the 5XXX series filler alloys and is preferred by welders because of its favorable operating characteristics. ER4043 type wires are also less sensitive to weld cracking with the 6XXX series base alloys. SuperGlaze® 4043 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).	.030	20CT(1SP)	ED030307
			.035	20CT(1SP)	ED030308
			3/64	20CT(1SP)	ED030310
			.035	16SP	ED028395
			3/64	16SP	ED028397
			3/64	20SP	ED029234
1/16	20SP	ED030281			
SuperGlaze® 4047	ER4047	A lower melting point and higher fluidity are two advantages SuperGlaze® 4047 has over its cousin SuperGlaze® 4043. SuperGlaze® 4047 produces very clean weld deposits and possesses excellent operator appeal. It can be used as a substitute for an ER4043 type wire to increase silicon in the weld metal, minimize hot cracking, and produce higher fillet weld shear strength. SuperGlaze® 4047 is suitable for sustained elevated temperature service, i.e. above 150°F (65°C).	3/64	16SP	EDS28417
			1/16	16SP	EDS28418
SuperGlaze® 5183	ER5183	SuperGlaze® 5183 is designed to weld high magnesium alloys to meet higher tensile strength requirements. Use on 5083 and 5654 base materials when required tensile strengths are 40,000 psi (276 MPa) or greater. Typical applications are in the marine and cryogenic industries, and high strength structural aluminum fabrication.	3/64	16SP	EDS28437
			1/16	16SP	EDS28438
			3/64	300AP	ED031825
			1/16	300AP	ED031938
SuperGlaze® 5356	ER5356	SuperGlaze® 5356 is our most popular aluminum MIG wire. It is a great general purpose filler alloy designed for the welding of 5XXX series alloys when 40,000 psi (276 MPa) tensile strength is not required. 5356 is often chosen for its high shear strength.	.035	20CT(1SP)	ED030312
			3/64	20CT(1SP)	ED030314
			.035	16SP	ED028385
			3/64	16SP	ED028387
			3/64	20SP	ED030282
			1/16	20SP	ED030283
			3/64	300AP	ED031826
1/16	300AP	ED030985			
SuperGlaze® 5554	ER5554	SuperGlaze® 5554 is intended as a matching filler alloy when welding 5554 base alloys. This alloy is a lower magnesium content alloy and is often used for automotive wheels, over-the-road trailers, and rail tank cars where the weld filler metal chemistry must closely match the base material chemistry to maximize corrosion performance.	3/64	16SP	ED029573
			1/16	16SP	EDS29574
			3/64	300AP	ED031827
			1/16	300AP	ED031939
SuperGlaze® 5556	ER5556	SuperGlaze® 5556 weld deposits will provide matching tensile strengths for the 5XXX alloys, such as 5083 and 5654. Contains increased amounts of magnesium or manganese compared to SuperGlaze® 5356.	3/64	16SP	EDS29581
			1/16	16SP	EDS29582
			3/64	300AP	ED031828
			1/16	300AP	ED031940

ULTRACORE

Premium Flux-Cored Gas Shielded Wire



Ultra Performance. Ultra Dependability.

- ▶ **QUALITY** – UltraCore® features a stable arc, wide operating range and superior feedability to help increase productivity.
- ▶ **CONSISTENCY** – UltraCore® offers unparalleled consistency in hydrogen performance, weldability and mechanical properties.
- ▶ **RELIABILITY** – ProTech® Foil Bag Packaging protects UltraCore® wire from harmful moisture and contamination, ensuring reliable performance you can depend on.
- ▶ **ARC PERFORMANCE** – Smooth, consistent arc behavior results in extremely smooth bead appearance, even out-of-position.



LINCOLN[®]
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THE WELDING EXPERTS[®]





UltraCore®, Lincoln's premium gas-shielded flux cored wire product line, is a true performer for fillet, lap or butt welds – on single and multiple pass welding applications. UltraCore® wires feature unparalleled consistency in weldability and mechanical properties, superior arc action and bead shape, easy slag removal and exceptional puddle control.

Electrode Name	AWS Class	Recm'd Shielding Gas	General Description	Diameter inches	Package Weight Lbs.	Product Number
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Gas-Shielded Flux-Cored Wires

UltraCore® 71A85  	E71T-1M-D H8 E71T-9M-D H8	75-85% Argon with a balance of CO ₂	Designed specifically for use with high Argon mixed gas, UltraCore® 71A85 delivers Lincoln's best arc characteristics for gas-shielded flux cored welding. Shipbuilders and structural fabricators like it because it runs well — it's our best running E71T-1 for high Argon gas blends, and it delivers great arc stability and fast freezing slag for easy out-of-position welding, even with 1/16" diameter wire. This electrode is carefully protected from moisture contamination using the new ProTech® foil bag packaging system.	.045	60CT(15SP)	ED031885
				.052	60CT(15SP)	ED031886
				1/16	60CT(15SP)	ED031887
				.045	33SP(FB)	ED031663
				.052	33SP(FB)	ED031664
				1/16	33SP(FB)	ED031665
				.045	50FS(FB)	ED031847
				.052	50FS(FB)	ED031848
				1/16	50FS(FB)	ED031849
				.045	500AD (23" dia)	ED032047
.052	500AD (23" dia)	ED032048				
1/16	500AD (23" dia)	ED032049				

UltraCore® 71A75 Dual	E71T-1 H8 E71T-1M H8 E71T-9 H8 E71T-9M H8	75% Argon with a balance of CO ₂ or 100% CO ₂	UltraCore® 71A75 Dual is a general purpose wire that gives you the flexibility to use either straight CO ₂ or 75% Argon / 25% CO ₂ gas. It delivers a stable arc, low spatter, and a smooth bead appearance for general fabrication applications. The ProTech® foil bag packaging system protects the wire from atmospheric moisture while in shipping or storage.	.045	60CT(15SP)	ED031882
				.052	60CT(15SP)	ED031883
				1/16	60CT(15SP)	ED031884
				.045	33SP(FB)	ED031669
				.052	33SP(FB)	ED031670
				1/16	33SP(FB)	ED031671
				.045	50FS(FB)	ED031844
				.052	50FS(FB)	ED031845
				1/16	50FS(FB)	ED031846
				.045	500AD (23" dia)	ED032044
.052	500AD (23" dia)	ED032045				
1/16	500AD (23" dia)	ED032046				

UltraCore® 71C  	E71T-1-D H8 E71T-9-D H8	100% CO ₂	For those who prefer the economy of welding with 100% CO ₂ for seismic structural fabrication, railcar, shipbuilding and barge applications, UltraCore® 71C is a great choice that delivers superior arc characteristics for single and multiple pass welding. It's our best running E71T-1 for CO ₂ applications, and it delivers great arc stability and fast freezing slag for easy out-of-position welding, even with 1/16" diameter wire. The ProTech® foil bag packaging system protects wire form moisture contamination for consistent quality reel after reel.	.045	60CT(15SP)	ED031818
				.052	60CT(15SP)	ED031819
				1/16	60CT(15SP)	ED031820
				.045	33SP(FB)	ED031666
				.052	33SP(FB)	ED031667
				1/16	33SP(FB)	ED031668
				.045	50FS(FB)	ED031822
				.052	50FS(FB)	ED031823
				1/16	50FS(FB)	ED031824
				.045	500AD (23" dia)	ED031876
.052	500AD (23" dia)	ED031877				
1/16	500AD (23" dia)	ED031878				

UltraCore® 712A80	E71T-1MJ H8 E71T-9MJ H8 E71T-12MJ H8	75-80% Argon with a balance of CO ₂	UltraCore® 712A80 is Lincoln's best running E71T-12 product because of its superior arc characteristics in a variety of applications, including offshore, tank and pressure vessel fabrication. Robust impact toughness values — even with a notch offset of 2.5 mm from weld centerline — makes this a favorite for designers who need consistency weld after weld. Tensiles will not exceed 90 ksi to help reduce cracking tendency, and the new ProTech® foil bag packaging system protects the wire from harmful moisture contamination.	.045	60CT(15SP)	ED031888
				.052	60CT(15SP)	ED031889
				1/16	60CT(15SP)	ED031890
				.045	33SP(FB)	ED031675
				.052	33SP(FB)	ED031676
				1/16	33SP(FB)	ED031677
				.045	50FS(FB)	ED031850
				U.052	50FS(FB)	ED031851
				1/16	50FS(FB)	ED031852
				.045	500AD (23" dia)	ED032050
.052	500AD (23" dia)	ED032051				
1/16	500AD (23" dia)	ED032052				

UltraCore® 712A80-H	E71T-1MJ H4 E71T-9MJ H4 E71T-12MJ H4	75-80% Argon with a balance of CO ₂	UltraCore® 712A80-H, featuring ProTech® foil bag packaging, is designed to achieve low hydrogen levels for the toughest applications in heavy equipment, offshore, shipbuilding and pressure vessel fabrication. UltraCore® 712A80-H is ideal for all-position, single and multiple pass welding on heavy sections where hydrogen induced cracking may be a concern. UltraCore® 712A80-H potentially reduces the need for preheat, so prep-time can be virtually eliminated and efficiencies can be increased. For heavy duty reduced hydrogen applications, choose UltraCore® 712A80-H.	.045	60CT(15SP)	ED031891
				.052	60CT(15SP)	ED031892
				1/16	60CT(15SP)	ED031893
				.045	33SP(FB)	ED031678
				.052	33SP(FB)	ED031679
				1/16	33SP(FB)	ED031680
				.045	50FS(FB)	ED031841
				.052	50FS(FB)	ED031842
				1/16	50FS(FB)	ED031843

Package Code Key: AD = Accu-Trak® Drum CT = Cardboard Carton FB = Foil Bag FS = Fiber Spool SP = Plastic Spool



UltraCore®, Lincoln's premium our premium gas-shielded flux cored wire product line, is a true performer for fillet, lap or butt welds – on single and multiple pass welding applications. UltraCore® wires feature unparalleled consistency in weldability and mechanical properties, superior arc action and bead shape, easy slag removal and exceptional puddle control.

Electrode Name	AWS Class	Recm'd Shielding Gas	General Description	Diameter inches	Package Weight Lbs.	Product Number
Gas-Shielded Flux-Cored Wires, con't.						
UltraCore® 712C	E71T-1J H8 E71T-91J H8 E71T-12J H8	100% CO ₂	For tank and shipbuilding applications using 100% CO ₂ , UltraCore® 712C is a versatile E71T-12 choice — even with a notch offset of 2.5 mm from weld centerline. Tensiles will not exceed 90 ksi to help reduce cracking tendency. The ProTech® foil bag packaging system protects the wire from harmful moisture for consistent chemistry and performance. Use UltraCore® 712C to get high impacts when using straight CO ₂ for deep penetration profile and minimal gas costs.	.045	60CT(15SP)	ED031894
				.052	60CT(15SP)	ED031895
				1/16	60CT(15SP)	ED031896
	.045	33SP(FB)		ED031672		
	.052	33SP(FB)		ED031673		
	1/16	33SP(FB)		ED031674		
	.045	50FS(FB)		ED031838		
	.052	50FS(FB)		ED031839		
	1/16	50FS(FB)		ED031840		
	.045	500AD (23" dia)		ED031681		
.052	500AD (23" dia)	ED031879				
1/16	500AD (23" dia)	ED031799				

Low Alloys

UltraCore® 81Ni1A75-H	E81T1-Ni1MJ H4	75% Ar/CO ₂	An extension of our superior line of carbon steel UltraCore® products, 81Ni1A75-H is designed for high strength, low-alloy applications using 75% Argon / 25% CO ₂ . The use of mixed shielding gas stabilizes arc characteristics, reduces spatter levels, and washes out the weld bead for a flat appearance. These electrodes exhibit superior crack resistance, due to low diffusible hydrogen levels (4mL/100 grams of weld deposit max). This electrode is ideally suited to replace E8018-C3 stick electrodes for added efficiency and increased productivity in bridge fabrication, offshore work, or structural fabrication.	.045	33SP(VFB)	ED032206
				.052	33SP(VFB)	ED032279
				1/16	33SP(VFB)	ED032207
UltraCore® 81Ni1C-H	E81T1-Ni1CJ H4	100% CO ₂	An extension of our superior line of carbon steel UltraCore® products, 81Ni1C-H is designed for high strength, low-alloy applications using 100% CO ₂ . These electrodes exhibit robust impact properties, even with a notch offset of 2.5 mm from weld centerline, as well as superior crack resistance, due to low diffusible hydrogen levels (4mL/100 grams of weld deposit max). This electrode is ideally suited to replace E8018-C3 stick electrodes for added efficiency and increased productivity in bridge fabrication, offshore work, or structural fabrication.	.045	33SP(VFB)	ED032204
				.052	33SP(VFB)	ED032280
				1/16	33SP(VFB)	ED032205
UltraCore® 81Ni2A75-H	E81T1-Ni1MJ H4	75% Ar/CO ₂	Look to UltraCore® 81Ni2A75-H for high strength, low alloy applications where productivity and consistency are a must in 75% Argon / 25% CO ₂ applications. The mixed shielding gas stabilizes arc characteristics, reduces spatter levels, and washes out of the weld bead for a flat appearance. This welding wire exhibits superior crack resistance due to low diffusible hydrogen levels (4 mL/100 grams of weld deposit max). Even with a notch offset of 2.5 mm from weld centerline, this wire displays robust impact properties. Whether your application is mining, offshore, or fabrication, UltraCore® 81Ni2A75-H is the premier low alloy welding wire.	.045	33SP(VFB)	ED032217
				.052	33SP(VFB)	ED032277
				1/16	33SP(VFB)	ED032216
UltraCore® 81Ni2C-H	E81T1-Ni1CJ H4	100% CO ₂	To meet the most demanding requirements in high strength, low alloy applications, UltraCore® 81Ni2C-H is an outstanding performer. This 100% CO ₂ welding wire exhibit H4 diffusable hydrogen levels, even with a notch offset of 2.5 mm from weld centerline. Regardless of whether you are welding in mining, offshore, or fabrication applications, UltraCore® 81Ni2C-H is a preferred product for both consistency and productivity.	.045	33SP(VFB)	ED032215
				.052	33SP(VFB)	ED032278
				1/16	33SP(VFB)	ED032214



Metalshield®, Lincoln's metal-cored wire product portfolio, is the choice of welders all over the world who demand: quality, consistency, reliability, and performance. You will find that it's well-suited to a wide range of fabrication applications including, automotive, structural and offshore.

Electrode Name	AWS Class	Recm'd Shielding Gas	General Description	Diameter inches	Package Weight Lbs.	Product Number
Mild Steel Metal-Cored Wires						
Metalshield® MC-6®	E70C-6M H8	75-95% Argon with a balance of CO ₂	Metalshield® MC-6® is a mild steel, metal-cored wire designed for superior arc performance in fast-follow, high travel speed applications requiring minimal amounts of spatter. The wire tolerates moderate amounts of surface contaminants and produces welds with Charpy V-notch toughness down to -20°F (-30°C). All position welding.	.045	33SSP	ED030392
				.052	33SSP	ED030393
				1/16	33SSP	ED030394
				.045	50FS	ED030554
				.052	50FS	ED030556
				1/16	50FS	ED030555
				.045	60C	ED030549
				.052	60C	ED030550
				1/16	60C	ED030577
				.045	500AD (20" dia)	ED031011
.052	500AD (20" dia)	ED030946				
1/16	500AD (20" dia)	ED030947				
Metalshield® MC-706®	E70C-6M H8	75-95% Argon with a balance of CO ₂	Metalshield® MC-706™ is a mild steel, metal-cored wire designed for superior arc performance in high deposition, high travel speed applications requiring minimal amounts of spatter, improved arc wetting action, and enhanced silicon island management. The wire tolerates higher amounts of surface contaminants and produces welds with Charpy V-notch toughness down to -20°F (-30°C). All position welding.	.045	33SSP	ED031583
				.052	33SSP	ED031584
				1/16	33SSP	ED031585
				.045	50FS	ED031586
				.052	50FS	ED031587
				1/16	50FS	ED031588
				.045	50C	ED031589
				.052	50C	ED031590
				1/16	50C	ED031591
				.045	500AD (20" dia)	ED031592
.052	500AD (20" dia)	ED031593				
1/16	500AD (20" dia)	ED031594				
Metalshield® MC-710XL®	E70C-6M H16	75-95% Argon with a balance of CO ₂	Metalshield® MC-710XL™ is a mild steel, metal-cored wire designed for high deposition, high travel speed applications requiring minimal amounts of spatter. The wire tolerates moderate amounts of surface contaminants and produces welds with Charpy V-notch toughness down to -20°F (-30°C). All position welding.	.045	33SSP	ED030592
				.052	33SSP	ED030593
				1/16	33SSP	ED030594
				.045	60C	ED028526
				.052	60C	ED028527
				1/16	60C	ED028528
				.045	600AD (23" dia)	ED029524
				1/16	600AD (23" dia)	ED028450

Low Alloy Metal-Cored Wires

Metalshield® MC-900™	E90C-G H4	75-90% Argon with a balance of CO ₂	Metalshield® MC-900™ is a low alloy steel, metal-cored wire designed for high deposition, high travel speed applications requiring minimal amounts of spatter on high strength steels. The wire tolerates moderate amounts of surface contaminants and produces welds with Charpy V-notch toughness down to -60°F (-50°C). All position welding.	.045	33SP(FB)	ED032838
				.052	33SP(FB)	ED032839
				1/16	33SP(FB)	ED032840
Metalshield® MC-1100™	E110C-G H4	75-90% Argon with a balance of CO ₂	Metalshield® MC-1100™ is a low alloy steel, metal-cored wire designed for high deposition, high travel speed applications requiring minimal amounts of spatter on high strength steels. The wire tolerates moderate amounts of surface contaminants and produces welds with Charpy V-notch toughness down to -60°F (-50°C). All position welding.	.045	33SP(FB)	ED032841

Outershield®

Establishing a name for itself in the welding industry, Outershield® wire offers proven consistency, demonstrated performance, and a solution for any job's requirements. Outershield® wires also provide for a superb arc, high deposition rates, and exceptional puddle control in out-of-position welding.

Electrode Name	AWS Class	Recm'd Shielding Gas	General Description	Diameter inches	Package Weight Lbs.	Product Number
Outershield® 70	E70T-1C, E70T-9C	100% CO ₂	Outershield® 70 has a smooth stable arc that delivers beads with good tie-in. Outershield® 70 is able to weld over mild levels of mill scale, rust and other contaminants because of its high level of deoxidization.	1/16	50C	ED012782
				5/64	50C	ED012785
				3/32	50C	ED012784
				1/16	600R	ED014588
				3/32	600R	ED014120
3/32	600D	ED030262				
Outershield® 70-H	E70T-1C H8, E70T-9C H8	100% CO ₂	Outershield® 70-H has all the great qualities of Outershield® 70, but with lower diffusible hydrogen levels for extra crack resistance and potential reduced preheat temperatures.	3/32	50C	ED030419
Outershield® XLH70	E70T-1C H8, E70T-9C H8	100% CO ₂	Outershield® XLH70 has low diffusible hydrogen levels (8 ml/max per 100g of weld metal), and is capable of the best low temperature impact properties of any of our E70T-1 electrodes. It is an excellent choice for welding structures subject to seismic requirements.	3/32	50C(VFB)	ED030236
				3/32	500D	ED030360



Mild Steel Flux-Cored Wires — All Position

Outershield® 71	E71T-1C H8, E71T-9C H8	100% CO ₂	Outershield® 71 has excellent bead wetting action that produces great looking fillet welds. Provides easy handling in out-of-position welding, such as vertical up.	.045	33SSP	ED030589
				.045	50C	ED012797
				.052	50C	ED012799
				1/16	50C	ED012803
Outershield® 71 Elite	E71T-1C H8, E71T-9C H8, E71T-1M H8, E71T-9M H8	100% CO ₂ or 75-82% Argon with a balance of CO ₂	Smooth arc transfer, low spatter and good bead appearance make this a top quality electrode. Operators will enjoy the well directed arc with small ball transfer. The fast freezing slag system makes out-of-position welding easy.	.045	60CT(15SP)	ED029418
				.052	60CT(15SP)	ED029419
				.045	33SSP	ED029201
				.052	33SSP	ED029204
				1/16	33SSP	ED029206
				.045	60C	ED029202
				.052	60C	ED029205
				1/16	60C	ED029207
				.045	500AD (23" dia)	ED030290
				.052	500AD (23" dia)	ED030291
1/16	600AD (23" dia)	ED029387				



Outershield®

Establishing a name for itself in the welding industry, Outershield® wire offers proven consistency, demonstrated performance, and a solution for any job's requirements. Outershield® wires also provide for a superb arc, high deposition rates, and exceptional puddle control in out-of-position welding.

Electrode Name	AWS Class	Recm'd Shielding Gas	General Description	Diameter inches	Package Weight Lbs.	Product Number
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Mild Steel Flux-Cored Wires — All Position, con't.

Outershield® 71M	E71T-1C, E71T-9C, E71T-1M, E71T-9M	100% CO ₂ or 75-80% Argon with a balance of CO ₂	Outershield® 71M is an overall performer. From excellent feedability to good arc performance, welders enjoy using 71M. Outershield® 71M is extremely stiff because of the unique manufacturing process that we use to make this product. No side cutters are required to restart, just break the wire off in your hands — it's that easy.	.035	10SP	ED026804
				.045	10SP	ED020836
				.035	25SP	ED026805
				.045	25SP	ED022659
				.052	25SP	ED022660
				1/16	25SP	ED022661
				.045	33SSP	ED030007
				.052	33SSP	ED030008
				1/16	33SSP	ED030009
				.045	50C	ED020844
				.052	50C	ED020845
				1/16	50C	ED020846
				1/16	300R	ED020848
				1/16	600R	ED020851
				.045	500AD (23" dia)	ED027364
.052	500AD (23" dia)	ED029778				
1/16	500AD (23" dia)	ED029779				

Low Alloy Flux-Cored Wires

Outershield® 81K2-H	E81T1-K2M H8	75-82% Argon with a balance of CO ₂	Outershield® 81K2-H has excellent arc characteristics and weld metal properties. This electrode is a good choice for welding offshore platforms and components. The hydrogen control helps to potentially reduce preheat normally used in highly restrained joints and on crack sensitive steels.	.045	33SP	ED030942
Outershield® 91K2-H	E91T1-K2M H8	75-95% Argon with a balance of CO ₂	Operators will love this smooth, well-directed spray type arc. Outershield® 91K2-H offers superior puddle control in all positions, virtually effortless slag removal and excellent bead wetting. It can potentially reduce the level of preheat normally used on crack sensitive steels. Uses include welding HY-80 and ASTM A710 type steels.	.045	25SP(VFB)	ED030975
				.052	25SP(VFB)	ED030976
				1/16	25SP(VFB)	ED030977



Lincoln's Innershield® products are the worldwide leader in self-shielded flux-cored wire and offer the welding industry a more efficient welding method for crucial applications, including: structural, transportation, offshore and marine. For the portability of stick electrode and the productivity of wire electrode—welding fabricators choose Lincoln's Innershield® Flux-Cored Wire.

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
High Speed Single Pass Welding Wires					
Innershield® NR®-5	E70T-3	Innershield® NR®-5 is designed for high speed single pass welding applications. It is recommended for flat and horizontal positions with maximum steel thickness up to 3/16 in. (4.8 mm). For high productivity welding on thin gauge material—choose Innershield® NR®-5.	3/32	600R	ED012701
			.120	600R	ED012698
			3/32	600D	ED012699
Innershield® NR®-131	E70T-10	Innershield® NR®-131 is designed for high deposition rates at high speeds. It is recommended for single pass welding on material thicknesses of 0.110 in. (2.8 mm) or greater. For both single and twin arc welding applications and automatic roundabout positions—choose Innershield® NR®-131.	3/32	600R	ED012163
Innershield® NR®-152	E71T-14	Innershield® NR®-152 is designed for high speed welding of specialty coated steels. It is recommended for single pass welding on material thicknesses from 0.030 in. to 3/16 in. (0.8 to 4.8 mm). For excellent arc characteristics on galvanized and zinc or other coated steels—choose Innershield® NR®-152.	.045	25SP	EDS01702
			.062	50C	ED012185
			.068	50C	ED012186
			.062	500D	ED024301

Out-of-Position Welding Wires with No Impact Requirements

Innershield® NR®-211-MP	E71T-11	Innershield® NR®-211-MP is a versatile wire suitable for all-position welding of light gauge or thin plate. It is recommended for maximum plate thicknesses in the range of 5/16 in. (7.9 mm) to ½ in. (12.7 mm). For an easy to use general fabrication wire—choose Innershield® NR®-211-MP.	.030	5CT(1SP)	ED031448
			.035	10CT(1SP)	ED027641
			.035	10SP	ED016354
			.045	10SP	ED016363
			.068	56CT(14C)	ED012506
			5/64	56CT(14C)	ED012508
			.035	25SSP	ED030637
			.045	25SSP	ED030638
			.068	25SSP	ED030641
			5/64	25SSP	ED030645
			.068	50C	ED012507
5/64	50C	ED012509			
3/32	50C	ED013869			
Innershield® NR®-212	E71TG-G	Innershield® NR®-212 is designed with the same arc characteristics of NR®-211, but for use on a larger range of applications. It is recommended for single or multiple pass welding on up to ¾ in. (19 mm) thicknesses. For smooth arc performance on a wide variety of applications—choose Innershield® NR®-212.	.045	10SP	ED026090
			.068	56CT(14C)	ED027803
			5/64	56CT(14C)	ED027794
			.045	25SSP	ED030639
			.068	25SSP	ED030642
			5/64	25SSP	ED030646
			5/64	50C	ED026858

Out-of-Position Welding Wires with Impact Requirements

Innershield® NR®-203MP	E71T-8J	Innershield® NR®-203MP is designed to handle poor fit-up on heavy wall tubes and gaps up to 3/8 in. (9.5 mm) with ¼ in. (6.4 mm) offset. It is recommended for all position welding on unlimited plate thicknesses. For a FCAW-S electrode capable of producing impact values tested to -40° F (-40° C) and operability on materials with poor fit-up—choose Innershield® NR®-203MP.	5/64	56CT(14C)	ED021604
			.068	25SSP	ED030640
Innershield® NR®-203 Nickel (1%)	E71T8-Ni1	Innershield® NR®-203 Nickel (1%) is designed to produce a nickel bearing weld deposit with impact properties tested at -20° F (-29° C). It handles poor fit-up in the vertical up position and welds gaps up to 3/8 in. (9.5 mm). For nickel bearing weld deposits and color matching on weathering steels—choose Innershield® NR®-203 Nickel 1%.	5/64	56CT(14C)	ED012385
			5/64	50C	ED012386

NOTE: All Innershield® wires are recommended for use with constant voltage (CV) power sources.



Package Code Key: C = Coil CT = Cardboard Carton D = Speed Feed® Drum (wire) or Steel Drum (flux) HS = Hermetically Sealed Pail
R = Speed Feed® Reel SP = Plastic Spool SSP = Steel Spool VFB = Vacuum Sealed Foil Bag





Lincoln's Innershield® products are the worldwide leader in self-shielded flux-cored wire and offer the welding industry a more efficient welding method for crucial applications, including: structural, transportation, offshore and marine. For the portability of stick electrode and the productivity of wire electrode—welding fabricators choose Lincoln's Innershield® Flux-Cored Wire.



Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
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Out-of-Position Welding Wires with Impact Requirements, con't.

Innershield® NR®-232  	E71T-8	Innershield® NR®-232 is designed for high deposition, out-of-position welding for structural fabrication in seismic zones. It is recommended for single or multiple pass welding of 3/16 in. (4.8 mm) and heavier carbon steel. For a high deposition FCAW-S wire capable of producing Charpy V-notch impacts meeting the requirements in the AWS D1.8 when tested—choose Innershield® NR®-232.	.068	54CT(13.5C)	ED012518			
			.072	54CT(13.5C)	ED012522			
			5/64	54CT(13.5C)	ED012525			
			.068	25SSP	ED030643			
			.072	25SSP	ED030644			
			5/64	25SSP	ED030647			
			.068	50C	ED012519			
			.072	50C	ED012523			
			5/64	50C	ED012526			
			<i>Sealed Pkg:</i>			.068	54HS(13.5C)	ED032531
						.072	54HS(13.5C)	ED030232

Innershield® NR®-233  	E71T-8	Innershield® NR®-233 is a good choice for training or novice welders while also meeting the mechanical property requirements listed in AWS D1.8. It is recommended for vertical up and overhead fillet and groove welds. For a FCAW-S wire with easy out-of-position operability and capable of producing Charpy V-notch impact tested at -20° F (-29° C)—choose Innershield® NR®-233.	1/16	50CT(12.5SP)	ED030933			
			1/16	25SP	ED030934			
			.072	25SP	ED031030			
			<i>Sealed Pkg:</i>			1/16	25SP(VFB)	ED031576
						.072	25SP(VFB)	ED031577

In-Position Welding Wires with Impact Requirements

Innershield® NR®-305 ⁽¹⁾  	E70T-6	Innershield® NR®-305 is designed for in-position, high deposition welding on carbon steel. It is recommended in single or multiple pass, automatic and semiautomatic welding. For a FCAW-S wire capable of producing Charpy V-notch impact properties tested at -20° F (-29° C) and excellent operator appeal—choose Innershield® NR®-305.	5/64	25SSP	ED030648			
			3/32	50C	ED012593			
			<i>Sealed Pkg:</i>			3/32	25SP(VFB)	ED030971
						3/32	50C(VFB)	ED030005

Innershield® NR®-311 Ni  	E70T7-K2	Innershield® NR®-311 Ni is designed to provide a nominal 1.5% nickel weld deposit with high deposition rates and fast travel. It is recommended for flat and horizontal positions in single and multiple pass welding. For a FCAW-S wire capable of producing Charpy V-notch impact properties tested at -20° F (-29° C) required in AWS D1.8—choose Innershield® NR®-311 Ni.	5/64	25SSP	ED030650			
			3/32	50C	ED017822			
			7/64	50C	ED017824			
			<i>Sealed Pkg:</i>			3/32	50C(VFB)	ED032530

⁽¹⁾ Only 3/32" (2.4 mm) diameter is recommended for FEMA 353 and AWS D1.8 applications.
 NOTE: All Innershield® wires are recommended for use with constant voltage (CV) power sources.

Package Code Key: C = Coil CT = Cardboard Carton D = Speed Feed® Drum (wire) or Steel Drum (flux) HS = Hermetically Sealed Pail
 R = Speed Feed® Reel SP = Plastic Spool SSP = Steel Spool VFB = Vacuum Sealed Foil Bag



Lincoln's Innershield® products are the worldwide leader in self-shielded flux-cored wire and offer the welding industry a more efficient welding method for crucial applications, including: structural, transportation, offshore and marine. For the portability of stick electrode and the productivity of wire electrode—welding fabricators choose Lincoln's Innershield® Flux-Cored Wire.

Electrode Name	AWS Class	General Description	Diameter inches	Package Weight Lbs.	Product Number
In-Position Welding Wires with No Impact Requirements					
Innershield® NR®-311	E70T-7	Innershield® NR®-311 is designed for very high deposition rates and fast travel speeds. It is recommended for fillet, lap and butt welds on 1/8 in. (3.2 mm) and thicker steel, including some low alloy steels. For high deposition rates, easy slag removal and good bead shape—choose Innershield® NR®-311.	5/64	56CT(14C)	ED014464
			5/64	25SSP	ED030649
			5/64	50C	ED014459
			3/32	50C	ED012629
			7/64	50C	ED012632
			7/64	600R	ED012633
Innershield® NS-3M	E70T-4	Innershield® NS-3M is designed for high deposition rates and increased resistance to hydrogen cracking and porosity on sulfur steel or dirty plate. It is recommended for single or multiple pass welding on carbon steel and some low alloy steels in applications without impact strength requirements. For high deposition on less than ideal welding surfaces—choose Innershield® NS-3M.	5/64	56CT(14C)	ED012739
			5/64	50C	ED012740
			3/32	50C	ED012736
			.120	50C	ED012732
			3/32	600D	ED012735
			.120	600D	ED012731

Pipe Fabrication Welding Wires

Innershield® NR®-207	E71T8-K6	Innershield® NR®-207 is designed for vertical down, hot, fill and cap passes on standard cross-country pipelines and arctic grade pipe. It is recommended for API Pipe Grades X42 up to undermatching X70. For pipe welding up to X70 pipe—choose Innershield® NR®-207.	.088	56HS(14C)	ED016312
			5/64	56HS(14C)	ED012438
Innershield® NR®-208-H	E91T8-G	Innershield® NR®-208-H is designed to create high strength weld deposits with yield strength test results exceeding minimum AWS requirements. It is recommended for API Pipe Grade X80. For up to X80 pipe welding applications—choose Innershield® NR®-208-H.	5/64	14(HS)	ED023366

NOTE: All Innershield® wires are recommended for use with constant voltage (CV) power sources.

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 R = Speed Feed® Reel SP = Plastic Spool SSP = Steel Spool VFB = Vacuum Sealed Foil Bag

For everything you need to know about welding in seismic zones

To assist structural fabricators, erectors, inspectors and specifying engineers — Lincoln Electric created the D1.8 Resource Center with tools to understand seismic welding guidelines. The site offers links to Lincoln Electric consumables tested to meet the AWS D1.8 and FEMA 353 requirements. The development of Lincoln Electric's D1.8 Resource Center is just one more way Lincoln sets the standard for the welding industry, worldwide.

BLUE MAX®

Stainless, Nickel & High Alloy Consumables



Quality, Consistency and Variety in Stainless, Nickel and High Alloy Welding.

- ▶ **WIDE PRODUCT OFFERING** – Stick (SMAW), Flux-Cored Gas-Shielded (FCAW-G), MIG (GMAW), TIG (GTAW), and Submerged Arc (SAW) consumables to choose from.
- ▶ **INDUSTRY LEADING CONSISTENCY** – Every pound of incoming raw steel and flux is checked and re-checked before entering Lincoln's meticulously designed, diligently monitored, and technically advanced manufacturing process.
- ▶ **CONSISTENT CHEMICAL COMPOSITION** – Lincoln's incredibly tight tolerances means less adjusting, less waste, cleaner welds, and increased efficiency.
- ▶ **OUTSTANDING ARC STABILITY** – Blue Max® stainless steel and high alloy products deliver one of the most stable arcs on the market today.

LINCOLN®
ELECTRIC
THE WELDING EXPERTS®

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Red Baron® Stainless Steel Stick Electrode						
Red Baron® 308L MR	E308L-16	DC+ AC	Red Baron® 308L MR is a low carbon version of Red Baron® 308/308H MR, which gives it better resistance to intergranular corrosion than the higher carbon deposits. A good all-position stick electrode, except vertical down.	3/32	8EO	ED020388
				1/8	10EO	ED020389
				5/32	10EO	ED020390
				3/16	10EO	ED020391
Red Baron® 308/308L-V MR	E308-15, E308L-15	DC+	Slag control is second to none with this stick electrode. Designed specially for vertical down welding of 304 and 304L stainless steels. Can also be used on other common austenitic stainless steels referred to as "18-8" steels. Low heat input makes this stick electrode great for joining thin gauge materials and pipe.	3/32 1/8	8EO 8EO	ED025079 ED025080
Red Baron® 308/308H MR	E308-16, E308H-16	DC+ AC	Red Baron® 308/308H MR is intended for joining 304 and 304L stainless steels. Can also be used on other common austenitic stainless steels referred to as stainless. Improved high temperature strength and exceptional all-position "18-8" welding capability, except vertical down.	3/32	8EO	ED020397
				1/8	10EO	ED020398
				5/32	10EO	ED020399
				3/16	10EO	ED020400
Red Baron® 309/309L MR	E309-16, E309L-16	DC+ AC	This stick electrode is designed for joining stainless steels to carbon steels or stainless steels to low alloy steels. All-position electrode, except vertical down.	3/32	8EO	ED020401
				1/8	10EO	ED020402
				5/32	10EO	ED020403
				3/16	10EO	ED020404
Red Baron® 309/309L-V MR	E309-15, E309L-15	DC+	Slag control is second to none with this stick electrode, designed specially for vertical down welding of stainless steels to carbon steels or stainless steels to low alloy steels. Low heat input makes this stick electrode a great choice for joining thin gauge materials and pipe.	3/32 1/8	8EO 8EO	ED025081 ED025082
Red Baron® 310 MR	E310-16	DC+ AC	Red Baron® 310 MR electrode has a very high alloy content consisting of 25% chromium and 20% nickel. Ideal for joining types 310S and 310H wrought and type CK-20 castings in all welding positions, except vertical down.	3/32	8EO	ED020410
				1/8	10EO	ED020411
				5/32	10EO	ED020412
Red Baron® 316/316L MR	E316-16 E316L-16	DC+	Red Baron® 316/316L is designed for welding extra low carbon molybdenum bearing austenitic stainless steels, such as type 316 and 316L. Welds in all positions, except vertical down.	3/32	8EO	ED025083
				1/8	10EO	ED025084
				5/32	10EO	ED025085
				3/16	10EO	ED025086
Red Baron® 316/316L-V MR	E316-15, E316L-15	DC+	Red Baron® 316/316L-V MR is designed specially for vertical down welding of extra low carbon molybdenum bearing austenitic stainless steels, such as type 316 and 316L. The low heat input of this electrode makes it a great choice for joining thin gauge materials and pipe.	3/32 1/8	8EO 8EO	ED025087 ED025088

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can

STAINLESS, NICKEL & HIGH ALLOY STICK ELECTRODE



The Blue Max® AC-DC series of stainless steel electrodes is characterized by their distinctive blue coating and spray type metal transfer. These electrodes can be lightly dragged, if desired, on the surface of the base metal with no fear of freezing to the weld. The 3/16" diameter size is generally limited to flat and horizontal welding.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Stainless and High Alloy Stick Electrode						
Blue Max® Arosta 307	E307-16	DC+ AC	Blue Max® Arosta 307 is a stainless steel stick electrode designed for steels that are difficult to weld and dissimilar joints. Extra manganese is added to improve resistance to hot-cracking.	(2.5 mm)	5.7CT	ED031270
				(3.2 mm)	10.3CT	ED031271
Blue Max® 308/308L AC-DC	E308-17, E308L-17	DC+ AC	Blue Max® 308/308L stick electrode is ideally suited for joining 304 and 304L stainless steels. Can also be used on other common austenitic stainless steels referred to as "18-8". Designed for all-position welding, except vertical down.	1/8	6CT(1TB)	ED031472
				3/32	8EO	ED025089
				1/8	10EO	ED025090
				5/32	10EO	ED025091
				3/16	10EO	ED025092
Blue Max® 309/309L AC-DC	E309-17 E309L-17	DC+ AC	Blue Max® 309/309L stick electrode is ideally suited for joining carbon steels or low alloy steels to stainless steels. Designed for all-position welding, except vertical down.	3/32	8EO	ED025093
				1/8	10EO	ED025094
				5/32	10EO	ED025095
				3/16	10EO	ED025096
Blue Max® Arosta 309Mo	E309LMO-16	DC+ AC	Blue Max® Arosta 309Mo is a stainless steel stick electrode designed for welding mild steel to stainless steel and root runs in cladding applications. Maximum plate thickness in butt welds is 1/2" (12.7 mm). Suitable for repair welding in dissimilar metals and difficult to weld steels.	(2.5 mm)	5.7CT	ED031266
				(3.2 mm)	10.3CT	ED031267
				(4.0 mm)	10.5CT	ED031268
				(5.0 mm)	11.9CT	ED031269
Blue Max® 316/316L AC-DC	E316-17, E316L-17	DC+ AC	Blue Max® 316/316L stick electrode, with its distinctive blue coating, is for joining 316 and 316L stainless steels. Designed for all-position welding, except vertical down.	3/32	8EO	ED025097
				1/8	10EO	ED025098
				5/32	10EO	ED025099
				3/16	10EO	ED025100
Blue Max® 2100	—	DC+ AC	Blue Max® 2100 is designed for "hard-to-weld" applications. It provides high resistance to cracking, yet high strength when joining steels that are normally difficult to weld. Designed for all-position welding, except vertical down.	(2.5 mm)	6CT(1TB)	ED032296
				(3.2 mm)	6CT(1TB)	ED032297
				(2.5 mm)	10EO	ED032298
				(3.2 mm)	10EO	ED032299
Blue Max® Arosta 4462	E2209-16	DC± AC	Blue Max® Arosta 4462 is an all position stainless steel stick electrode designed for welding duplex stainless steels. For applications up to 480°F (250°C) and down to -40°F (-40°C). It has a high resistance to general corrosion, pitting and stress corrosion.	(2.5 mm)	3.3SRP	ED031244
				(3.2 mm)	4SRP	ED031245
				(4.0 mm)	3.5SRP	ED031246
Blue Max® Jungo 4462	E2209-15	DC± AC	Blue Max® Jungo 4462 is a stainless steel stick electrode designed for welding 22% chromium duplex stainless steels. Can be used in applications with service temperatures up to 480°F (250°C) and down to -58°F (-50°C). It has a high resistance to general corrosion, pitting and stress corrosion.	(2.5 mm)	3SRP	ED031251
				(3.2 mm)	4SRP	ED031252
				(4.0 mm)	3.3SRP	ED031253
Blue Max® Jungo Zeron 100X	E2553-15	DC+	Blue Max® Jungo Zeron 100X is a stainless steel stick electrode designed for welding 25% Chromium super duplex stainless steels. Core wire alloyed. Improved corrosion resistance, high strength and reliable impact toughness.	(3.2 mm)	4SRP	ED031257
				(4.0 mm)	1.75SRP	ED031259

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can SRP = Sahara Ready-Pak® TB = Tube



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Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Stainless and High Alloy Stick Electrode, con't.						
Blue Max® Jungo 4500	E385-16	DC+	Blue Max® Jungo 4500 is a stainless steel stick electrode designed for welding fully austenitic, 20% Cr, 25% Ni, 5% Mo stainless steels, such as AISI 904L. Blue Max® Jungo 4500 has excellent weldability, bead appearance, easy slag removal combined with excellent corrosion resistance.	(2.5 mm)	6.3CT	ED031276
				(3.2 mm)	12.5CT	ED031277
Blue Max® Nyloid 2	ENiCrMo-6	DC± AC	Blue Max® Nyloid 2 is a nickel-based stick electrode designed for welding low temperature steels. The deposition rate is very high—150% recovery. Especially developed for welding 9% nickel stainless steels.	(2.5 mm)	3.7SRP	ED031403
				(3.2 mm)	4.8SRP	ED031404
				(4.0 mm)	4SRP	ED031405
				(5.0 mm)	3.3SRP	ED031406
Blue Max® NiCro 60/20	ENiCrMo-3	DC+	Blue Max® NiCro 60/20 is designed for joining nickel-based alloys, such as Alloy 625, for applications with both high and low temperatures. Provides improved corrosion resistance. All-position welding, except vertical down.	(2.5 mm)	3.5CT	ED031287
				(3.2 mm)	3.7CT	ED031288
				(4.0 mm)	4.6CT	ED031289
Blue Max® NiCro 70/15Mn	ENiCrFe-3	DC+	Blue Max® NiCro 70/15Mn is a nickel-based stick electrode for welding nickel-base alloys, such as Alloy 600. Because of its composition, NiCro 70/15Mn is very suitable for welding dissimilar metals that require postweld heat treatment.	(2.5 mm)	3.5TB	ED031290
				(3.2 mm)	3.7TB	ED031291
				(4.0 mm)	4.1TB	ED031292

Cast Iron and Aluminum Stick Electrode

Softweld 55Ni	ENiFe-CI	DC+ AC	A versatile, all-purpose electrode for repairing and reclaiming gray cast iron. It is recommended for repairing heavy sections and phosphorous bearing castings. Welds made with this electrode are strong and ductile. Mult-pass welds are typically machinable. Operational characteristics are excellent.	(2.5 mm)	6CT (1TB)	ED031539
				(3.2 mm)	6CT (1TB)	ED031540
				(4.0 mm)	6CT (1TB)	ED031541
				(2.5 mm)	30CT (10EO)	ED032293
				(3.2 mm)	30CT (10EO)	ED032363
Softweld 99Ni	ENi-CI	DC+ AC	Description: A high nickel electrode specifically recommended for applications where machinability is important. Even single pass welds are machinable. It is recommended for surfacing applications and repairing small casting defects when the deposit will require machining.	(2.5 mm)	6CT (1TB)	ED032287
				(3.2 mm)	6CT (1TB)	ED032288
				(2.5 mm)	30CT (10EO)	ED032289
				(3.2 mm)	30CT (10EO)	ED032290
				(4.0 mm)	30CT (10EO)	ED032291
Ferroweld®	ESt	DC+ AC	A low cost steel electrode for repairing cast iron. It is recommended for repairing pits and small cracks in castings. The deposits are not machinable but may be finished by grinding.	1/8	10EO	ED010098
				1/8	1TB	ED031542
Aluminweld® 43	E4043	DC+	An extruded electrode for both metallic arc and carbon arc welding aluminum plate. The dense high strength welds can be polished leaving practically no discoloration. The molten flux retards oxidation and dissolves excess aluminum oxide to produce high quality deposits.	1/8	5EO	ED020453
				1/8	1TB	ED025114
				1/8	.5TB	ED031469

STAINLESS, NICKEL & HIGH ALLOY TIG CUT LENGTHS



The Blue Max® AC-DC series of stainless steel electrodes is characterized by their distinctive blue coating and spray type metal transfer. These electrodes can be lightly dragged, if desired, on the surface of the base metal with no fear of freezing to the weld. The 3/16" diameter size is generally limited to flat and horizontal welding.

Electrode Name	AWS Class	General Description	Diameter mm	Package Weight Lbs.	Product Number
Blue Max® LNT 9Cr (P91)	ER90S-B9	Blue Max® LNT 9Cr (P91) is a cut length consumable designed for welding on 9% Cr, 1% Mo creep resistant and hydrogen-resistant steels commonly used in power plants and petrochemical industries. Blue Max® LNT 9Cr (P91) weld deposits can be used at a maximum service temperature of 1200°F (650°C).	(2.4 mm)	11TB	ED031300
			(3.2 mm)	11TB	ED032201
Blue Max® LNT 347Si	ER347Si	Blue Max® LNT 347Si is an austenitic stainless steel consumable for welding Ti or Cb (Nb) stabilized CrNi steels. The resistance to intergranular corrosion and oxidizing environments is excellent.	(1.6 mm)	22TB	ED031357
			(2.4 mm)	22TB	ED031359
			(3.2 mm)	22TB	ED031360
Blue Max® LNT 4462	ER2209	Blue Max® LNT 4462 is a duplex stainless steel consumable for welding 2205 duplex stainless steel base materials. The high chromium and molybdenum content provides resistance against pitting and stress corrosion, as well as general corrosion.	(1.6 mm)	22CT	ED031309
			(2.0 mm)	22CT	ED031310
			(2.4 mm)	22CT	ED031311
			(3.2 mm)	22CT	ED031312
Blue Max® LNT Zeron 100X	ER2553	Blue Max® LNT Zeron 100X is a stainless steel TIG cut length consumable for welding 2507 superduplex base materials. Welds made with LNT Zeron 100X have high resistance against pitting and crevice corrosion.	(1.6 mm)	4.4TB	ED031319
			(2.4 mm)	4.4TB	ED031320
			(3.2 mm)	4.4TB	ED031749
LNT NiCro 60/20	ERNiCrMo-3	Blue Max® LNT is a nickel-based TIG cut length consumable. The chemical composition is similar to Alloy 625. It is suitable for both high and low temperature applications, as well as corrosive environment applications.	(1.6 mm)	30CT	ED032161
			(2.4 mm)	30CT	ED032162
			(3.2 mm)	30CT	ED032163
LNT NiCroMo 60/16	ERNiCrMo-4	LNT NiCroMo 60/16 GTAW wire designed for welding CrMoW-alloyed nickel alloys, such as C-276. Weld deposit is extremely resistant to corrosion environments containing sulphuric acid and chlorides and is also applicable for surfacing in high temperature applications (up to 1200°C)	(1.6 mm)	30CT	ED032155
			(2.4 mm)	30CT	ED032156
			(3.2 mm)	30CT	ED032157
Lincoln® ER308/308L	ER308, ER308L	For joining 304 and 304L and other "18-8" stainless steels.	1/16	10CT(1TB)	ED025410
			3/32	10CT(1TB)	ED025413
			1/8	10CT(1TB)	ED025416
			1/16	10CT	ED025412
			3/32	10CT	ED025415
			1/8	10CT	ED025418
			1/16	50CT	ED026655
			3/32	50CT	ED026656
			1/8	50CT	ED026657
Lincoln® ER309/309L	ER309, ER309L	For 309 stainless steels and joining carbon steels or low alloy steels to stainless steels.	1/16	10CT(1TB)	ED025419
			3/32	10CT(1TB)	ED025422
			1/8	10CT(1TB)	ED025425
			1/16	10CT	ED025421
			3/32	10CT	ED025424
			1/8	10CT	ED025427
			1/16	50CT	ED026658
			3/32	50CT	ED026659
			1/8	50CT	ED026660
Lincoln® ER316/316L	ER316, ER316L	For joining 316L stainless steels.	1/16	10CT(1TB)	ED025428
			3/32	10CT(1TB)	ED025431
			1/8	10CT(1TB)	ED025434
			1/16	10CT	ED025430
			3/32	10CT	ED025433
			1/8	10CT	ED025436
			1/16	50CT	ED026661
			3/32	50CT	ED026662
			1/8	50CT	ED026663

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The Blue Max® AC-DC series of stainless steel electrodes is characterized by their distinctive blue coating and spray type metal transfer. These electrodes can be lightly dragged, if desired, on the surface of the base metal with no fear of freezing to the weld. The 3/16" diameter size is generally limited to flat and horizontal welding.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Blue Max® Gas-Shielded, Flux-Cored Wires						
Blue Max® FC-308L	E308LT0-1, E308LT0-4, E308T0-1, E308T0-4	DC+	Blue Max® FC-308L wire is optimized for joining 304 and 304L stainless steels and other common "18-8" stainless steels in the downhand and horizontal positions. This wire provides attractive operation and a low carbon deposit.	.045 1/16	25SP 25SP	ED026991 ED026990
Blue Max® FC-309L	E309LT0-1, E309LT0-4, E309T0-1, E309T0-4	DC+	Blue Max® FC-309L is a great choice for joining carbon or low alloy steels to austenitic stainless steels in the downhand and horizontal positions. It has excellent operating characteristics and a low carbon weld deposit.	.045 1/16	25SP 25SP	ED026989 ED026988
Blue Max® FC-316L	E316LT0-1, E316LT0-4, E316T0-1, E316T0-4	DC+	Blue Max® FC-316L wire is designed for joining 316 and 316L wrought stainless steels in the downhand and horizontal welding positions. It has a low carbon weld deposit and excellent operating characteristics.	.045 1/16	25SP 25SP	ED026993 ED026992
Blue Max® FCP-309L	E309LT1-1, E309LT1-4, E309T1-1, E309T1-4	DC+	Blue Max® FCP-309L is designed for welding carbon and low alloy steels to austenitic stainless steels. Optimized for welding in out-of-position applications, especially vertical-up and overhead. Applications can be welded without procedure adjusting for each position change.	.045 1/16	25SP 25SP	ED027951 ED027952
Blue Max® FCP-316L	E316LT1-1, E316LT1-4, E316T1-1, E316T1-4	DC+	Blue Max® FCP-316L wire is designed for out-of-position joining of types 316 and 316L stainless steels, especially in the vertical-up and overhead positions. Excellent choice when the job calls for several position changes—no need to adjust procedures.	.045 1/16	25SP 25SP	ED027953 ED027954

Stainless Steel Gas-Shielded, Metal-Cored Wires

Outershield® MC®-409	EC409	DC+	Outershield® MC®-409 is designed for single pass welding of 409 stainless steel, used on exhaust systems in the automotive industry.	.045	33SSP	ED031419
				.045	400AD	ED023400
				.045	500AD (23" dia)	ED027361

Package Code Key: AD = Accu-Trak® Drum SP = Plastic Spool



Blue Max® stainless steel MIG wires can be used for all position welding. Globular and spray transfer are recommended for downhand and horizontal only. Short circuiting mode and pulsed arc can be used for out of position welding. Gas shielding mixtures recommended are either Argon and Oxygen blend for spray and pulsed transfer, or a Helium-rich blend for short circuiting and STT® welding.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Blue Max® LNM 307	ER307*	DC+	Blue Max® LNM 307 is a austenitic stainless steel MIG wire for steels that are difficult to weld and dissimilar metals. Extra manganese is added to improve hot-cracking resistance.	(1.0 mm)	33SSP	ED031325
				(1.2 mm)	33SSP	ED031326
Blue Max® MIG 308LSi	ER308Si, ER308LSi	DC+	Blue Max® MIG 308LSi is designed for joining type 304 and 304L stainless steels and other common austenitic stainless steels referred to as "18-8" steels. Optimized for chemistry, arc performance and feedability.	.030	25SP	ED023961
				.035	25SP	ED019292
				.045	25SP	ED019293
				1/16	25SP	ED019294
				.035	500AD	ED029768
				.045	500AD	ED029769
Blue Max® MIG 309LSi	ER309Si, ER309LSi	DC+	Blue Max® MIG 309LSi is designed for joining stainless steels to carbon steels or low alloy steels. Optimized for chemistry, arc performance and feedability.	.030	25SP	ED023962
				.035	25SP	ED019295
				.045	25SP	ED019296
				1/16	25SP	ED019297
				.035	500AD	ED029770
				.045	500AD	ED029771
Blue Max® MIG 316LSi	ER316Si, ER316LSi	DC+	Blue Max® MIG 316LSi is designed for joining extra low carbon molybdenum bearing austenitic stainless steels, such as type 316 and 316L. Optimized for chemistry, arc performance and feedability.	.030	25SP	ED023963
				.035	25SP	ED019298
				.045	25SP	ED019299
				1/16	25SP	ED019300
				.035	500AD	ED029772
				.045	500AD	ED029773
Blue Max® LNM 347Si	ER347Si	DC+	Blue Max® LNM 347Si is an austenitic stainless steel MIG wire consumable for welding Ti or Cb (Nb) stabilized CrNi steels. The resistance to intergranular corrosion and oxidizing environments is excellent.	(1.0 mm)	33SSP	ED031351
				(1.2 mm)	33SSP	ED031352
Blue Max® LNM 4462	ER2209	DC+	Blue Max® LNM 4462 is a duplex stainless steel MIG wire for welding 2205 duplex stainless steel base materials. The high chromium and molybdenum content provides resistance against pitting and stress corrosion, as well as general corrosion.	(1.2 mm)	11SP	ED031784
				(1.0 mm)	33SSP	ED031302
				(1.2 mm)	33SSP	ED031303
Blue Max® LNM Zeron 100X	ER2553	DC+	Blue Max® LNM Zeron 100X is a stainless steel MIG wire for welding 2507 super duplex base materials. Welds made with LNM Zeron 100X have high resistance against pitting and crevice corrosion.	(1.2 mm)	27.5SSP	ED031317
Blue Max® LNM 4500	ER385	DC+	Blue Max® LNM 4500 is a fully austenitic stainless steel MIG wire for welding 904L, or equivalent stainless steels. Welds have high corrosion resistance to phosphoric acid and sulfuric acid applications.	(1.2 mm)	33SSP	ED031329
LNM NiCro 60/20	ERNiCrMo-3	DC+	LNM NiCro 60/20 is a nickel-based MIG wire. Its chemical composition is similar to Alloy 625. It is suitable for both high and low temperature applications, as well as corrosive environment applications.	(0.9 mm)	33SSP	ED032158
				(1.0 mm)	33SSP	ED032159
				(1.2 mm)	33SSP	ED032160
LNM NiCroMo 60/16	ERNiCrMo-4	DC+	LNM NiCroMo 60/16 GMAW wire is designed for welding CrMoW-alloyed nickel alloys, such as C-276. Weld deposit is extremely resistant to corrosion environments containing sulphuric acid and chlorides and is also applicable for surfacing in high temperature applications (up to 1200°C)	(0.9 mm)	33SSP	ED032149
				(1.0 mm)	33SSP	ED032150
				(1.2 mm)	33SSP	ED032151
Blue Max® LNM NiCro 70/19	ERNiCr-3	DC+	Blue Max® LNM NiCro 70/19 is a nickel-based MIG wire for welding nickel-base alloys such as Alloys 600 and 601. The chemical composition gives it a high resistance against oxidation. Welds made with LNM NiCro 70/19 also have excellent impact toughness at low temperatures.	(1.0 mm)	33SSP	ED031379
				(1.2 mm)	33SSP	ED031380

* Nearest classification



Blue Max® stainless steel wires and flux are designed for use in submerged arc welding, both with chromium-compensating fluxes like ST-100, and with highly basic unalloyed fluxes like 880, 882, 801, 802 and Blue Max® 2000.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter inches	Package Weight Lbs.	Product Number
Blue Max® Submerged Arc Wire						
Blue Max® S308/308L	ER308, ER308L	DC+ DC-	Blue Max® S308/308L is designed primarily for submerged arc welding with basic fluxes. Balanced chromium and nickel levels provide enough ferrite in the weld metal for high resistance to hot cracking. Recommended Fluxes: Lincolnweld® 801, 802, 880, 880M, 882, ST-100, and Blue Max® 2000.	5/64	60C	ED021437
				3/32	60C	ED021438
				1/8	60C	ED021439
				5/32	60C	ED021440
Blue Max® S309/309L	ER309, ER309L	DC+ DC-	Blue Max® S309/309L wire is designed for submerged arc welding with basic fluxes that recover nearly all of the wire chromium in the deposit. Good resistance to hot cracking. Recommended Fluxes: Lincolnweld® 801, 802, 880, 880M, 882, ST-100, and Blue Max® 2000.	5/64	60C	ED021445
				3/32	60C	ED021446
				1/8	60C	ED021447
				5/32	60C	ED021448
Blue Max® S316/316L	ER316, ER316L	DC+ DC-	Blue Max® S316/316L is designed for submerged arc welding with basic fluxes that recover nearly all of the wire chromium in the deposit. Good resistance to hot cracking. Recommended Fluxes: Lincolnweld® 801, 802, 880, 880M, 882, ST-100, and Blue Max® 2000.	5/64	60C	ED021453
				3/32	60C	ED021454
				1/8	60C	ED021455
				5/32	60C	ED021456
Blue Max® LNS 4462	ER2209	DC+ AC	Blue Max® LNS 4462 is designed for joining duplex (ferritic-austenitic) stainless steel.	(2.4 mm)	55SSP	ED031313
				(3.2 mm)	55SSP	ED031314
LNS NiCro 60/20	ERNiCrMo-3	DC± AC	LNS NiCro is designed for joining nickel-based alloys. Depending on the application, it is also suitable for welding fully austenitic stainless steels, 9% Ni-steel and dissimilar joints.	(1.6 mm)	33FS	ED032189
				(1.6 mm)	55C	ED032164
				(2.4 mm)	55C	ED032165
				(3.2 mm)	55C	ED032166
LNS NiCro Mo 60/16	ERNiCrMo-4	DC+	LNS NiCroMo 60/16 is designed for welding CrMoW-alloyed nickel alloys, such as C-276. Weld deposits are extremely resistant to corrosion environments containing sulphuric acid and chlorides. Applicable for surfacing in high temperature applications up to 2192°F (1200°C).	(1.6 mm)	33FS	ED032188
				(1.6 mm)	55C	ED032152
				(2.4 mm)	55C	ED032153
				(3.2 mm)	55C	ED032154

Blue Max® Submerged Arc and Electroslag Fluxes

Blue Max® 2000	—	—	Blue Max® 2000 is a neutral basic flux designed for welding the more difficult stainless steels such as 347 and 2205 as well as nickel-based alloys. Maximum toughness and ductility with duplex stainless steels.	N/A	50PLB	ED031857
Blue Max® 3000	—	—	Blue Max® 3000 is a chromium alloyed flux for strip cladding where ferrite content of at least 4 FN is desired with 309L strip on carbon steel in one layer.	N/A	44HS	ED029474
Blue Max® 4000	—	—	Blue Max® 4000 is a neutral flux designed for cladding, using the electroslag welding process with stainless steel and nickel based strip electrodes.	N/A	44HS	ED025014
ST-100	—	—	Lincolnweld® ST-100 is an alloy flux for use with solid stainless steel wires. It is formulated to compensate for the chromium in the wire that is not recovered in the weld deposit.	N/A	60PLB	ED031856
				N/A	600D	ED012924

Package Code Key: C = Coil D = Speed Feed® Drum (wire) or Steel Drum (flux) F = Fiber Spool HS = Hermetically Sealed Pail PLB = Plastic Bag
SSP = Steel Spool

HARDFACING

Wearshield® and Lincore® Consumables



Don't Replace, Hardface.

- ▶ **GET NEW LIFE OUT OF OLD PARTS** – Hardfacing offers superior wear-resistance, hardness, and service life compared to the original material.
- ▶ **SUPERIOR WELDABILITY AND WEAR CHARACTERISTICS** – Lincoln hardfacing and build-up deposits go on smoothly and exhibit better wear characteristics than many competitive products intended for the same application.
- ▶ **WEARSHIELD STICK ELECTRODES** – Deliver maximum welding application flexibility in remote applications.
- ▶ **LINCORE® SELF-SHIELDED AND GAS-SHIELDED WIRE ELECTRODES AND SUBMERGED ARC WIRE ELECTRODES** – Many alloys, sizes and packages available for delivering the highest deposition rates and maximum productivity.
- ▶ **LINCOLNWELD® NEUTRAL AND ALLOY SUBMERGED ARC FLUXES** – Tailor the resulting wear characteristics for your hardfacing application with either neutral or alloy fluxes.

LINCOLN®
ELECTRIC
THE WELDING EXPERTS®



Select one of Lincoln's Wearshield electrodes for almost hardfacing job for maximum welding flexibility in remote locations.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Build-Up					
Wearshield® BU	23-28	For carbon and low alloy steels. Builds up worn steel parts to produce tough, forgeable, machinable surfaces of moderate hardness.	5/32	6CT(1TB)	ED031471
			5/32	40CT(10CT)	ED021991
			3/16	40CT(10CT)	ED021993
			1/4	50CT	ED021995
Wearshield® BU-30	31-38	Moderate hardness to resist shock. Used as final overlay on parts which must be machined or forged. For mild, medium carbon, low alloy and high tensile steels.	(3.2 mm)	40CT(10CT)	ED024943
			(4.0 mm)	40CT(10CT)	ED024944
Metal-To-Metal Wear					
Wearshield® MM	52-58	Martensitic deposit. Heat treatable weld metal. Can be tempered, annealed. Can be used on carbon and low alloy steels.	(3.2 mm)	40CT(10CT)	ED021986
			(4.0 mm)	40CT(10CT)	ED021988
			(3.2 mm)	50CT	ED021987
			(4.0 mm)	50CT	ED021989
			(5.0 mm)	50CT	ED021990
Wearshield® MI	50-58	Provides wear-resistant surface of martensite, with substantial retained austenite. Resists metal-to-metal wear, impact, mild abrasion. Can be used on carbon and low alloy steels.	1/8	40CT(10CT)	ED022003
			5/32	40CT(10CT)	ED022005
			3/16	40CT(10CT)	ED022007
			1/8	50CT	ED022004
			5/32	50CT	ED022006
			3/16	50CT	ED022008
			1/4	50CT	ED022009
Severe Abrasion					
Wearshield® 60	60-65	Excellent abrasion resistance. Fuses to carbon, low alloy, stainless, and manganese steel. Limit 2 layers. Use Wearshield® BU, Mangjet® or 15CrMn for preliminary layer(s).	1/8	40CT(10CT)	ED022010
			5/32	40CT(10CT)	ED022011
			3/16	40CT(10CT)	ED022012
Wearshield® 70	69	Resists very severe abrasion at temperatures up to 1400°F (760°C). Use with mild, low alloy, stainless and austenitic manganese steels. Limit 2 layers.	(3.2 mm)	40CT(10CT)	ED024951
			(4.0 mm)	40CT(10CT)	ED024952
			(5.0 mm)	40CT(10CT)	ED024953
Metal-To-Earth					
Wearshield® ME	49-59	Use on carbon and low alloy steels, cast iron, austenitic manganese and austenitic stainless steels. Use Wearshield® BU or 15CrMn for preliminary layer(s).	1/8	40CT(10CT)	ED023323
			5/32	40CT(10CT)	ED023324
			3/16	40CT(10CT)	ED023325
			1/8	50CT	ED023326
			5/32	50CT	ED023327
			3/16	50CT	ED023328

Package Code Key: CT = Cardboard Carton EO = Easy Open Hermetic Can TB = Tube



Select one of Lincoln's Wearshield electrodes for almost hardfacing job for maximum welding flexibility in remote locations.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Severe Impact					
Wearshield® Mangjet®	17-20	For building up austenitic manganese steel and cladding carbon steel. Pounding in service work hardens the deposit to develop maximum hardness and abrasion resistance (40-50 Rc).	5/32	40CT(10CT)	ED021975
			3/16	40CT(10CT)	ED021977
			5/32	50CT	ED021976
			3/16	50CT	ED021978
			1/4	50CT	ED021979
Wearshield® 15CrMn	17-20	For austenitic manganese steel to resist severe impact or gouging even in single layer over carbon steel, with excellent crack resistance. Joining of manganese steel to itself or carbon or low alloy steel. Work hardens to 40-50 Rc.	1/8	40CT(10CT)	ED021980
			5/32	40CT(10CT)	ED021982
			3/16	40CT(10CT)	ED021984
Wearshield® Frogmang®	20-23	Provides high alloy austenitic manganese steel buildup to resist severe impact. Specifically designed for rebuilding rail frogs and crossings. Work hardens to 44-55 Rc.	5/32	60CT(10EO)	ED026100
			3/16	60CT(10EO)	ED026101
			1/4	72CT(12EO)	ED031803

Abrasion Plus Impact

Wearshield® ABR	28-53	Versatile electrode producing good resistance to abrasion and moderate impact. Good hot-forging properties. Hardness will vary depending on cooling rate.	1/8	40CT(10CT)	ED021996
			5/32	40CT(10CT)	ED021998
			3/16	40CT(10CT)	ED022000
			1/4	50CT	ED022002
Wearshield® 44	42-48	Moderate hardness to resist abrasion under impact at temperatures up to 1100°F (593°C). Good spalling resistance on two or more layers.	1/8	6CT(1TB)	ED031470
			1/8	40CT(10CT)	ED024940
			5/32	40CT(10CT)	ED024941
			3/16	40CT(10CT)	ED024942



Lincore® wires for submerged arc hardfacing are designed for use with specific Lincoln® fluxes to provide optimum deposit composition, hardness and microstructure for a variety of applications.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Build-Up					
Lincore® BU	85-95 R _B	For rebuilding worn parts to near final size before applying final hardfacing layer(s), which is more wear resistant. Use on carbon, low alloy steels.	5/64	25SSP	ED031115
			5/64	50C	ED022064
			7/64	50C	ED022065
			7/64	125D	ED022069
Lincore® BU-G	20-35 R _C 30-42 ⁽¹⁾ R _C	Gas-shielded cored wire for build-up of mild steel and low alloy steel parts to bring them to final dimensions, or for metal-to-metal wear.	.045	25SP	ED029079
			1/16	25SP	ED029080
Lincore® 33	28-34 R _C	For build-up prior to hardfacing. Use on carbon and low alloy steels. Can be used under 802, 803, 880M flux.	5/64	56CT(14C)	ED011237
			.045	25SSP	ED031116
			1/16	25SSP	ED031117
			5/64	25SSP	ED031118
			5/64	50C	ED011238
			3/32	50C	EDS01197
			7/64	50C	ED011240
7/64	125D	ED011239			
Metal-To-Metal Wear					
Lincore® 40-0	40-45 ⁽¹⁾ R _C	Bridges the hardness gap between Lincore® 33 and Lincore® 55.	5/64	25SSP	ED031119
			5/64	50C	ED025907
			7/64	50C	ED025908
Lincore® 55	56-62 ⁽¹⁾ R _C	Hardfacing overlay to resist rolling, sliding, and metal-to-metal wear. For carbon, low alloy, and manganese steels. Can be used under 802, 803, 880M flux.	5/64	56CT(14C)	ED011277
			.045	25SSP	ED031120
			1/16	25SSP	ED031121
			5/64	25SSP	ED031122
			5/64	50C	ED011278
Lincore® 55-G	48-60 R _C	Gas-shielded cored wire. Martensitic low alloy steel deposit for resistance to metal-to-metal wear. Despite the high hardness, crack-free deposits can be obtained with proper preheat, interpass temperature control, and post-weld cooling.	1/16	25SP	ED028176
			.045	25SP	ED028177
			.045	500AD (20" dia)	ED031475
			1/16	500AD (20" dia)	ED031476
Lincore® T&D	48-65 R _C	For rebuilding tools and dies and for putting tool steel surface on carbon and low alloy steels.	1/16	25SSP	ED031134
			7/64	50C	ED022057
Severe Impact					
Lincore® Frogmang®	40-50 ⁽¹⁾ R _C	Self-shielded, cored wire. High alloy austenitic manganese composition for resistance to severe impact. Ideal for rebuilding worn manganese rail frogs, diamonds and switches.	1/16	25SP	ED026106
			5/64	25SP	ED026105
			3/32	25SP	ED026104
			7/64	25SP	ED026103
Lincore® M	40-48 ⁽¹⁾ R _C	Produces austenitic manganese steel deposit. Rebuild/join manganese steel. Limit interpass to 500°F.	.045	25SSP	ED031128
			1/16	25SSP	ED031129
			5/64	25SSP	ED031130
			5/64	50C	ED011160
			7/64	50C	ED011164
			7/64	125D	ED011163
			7/64	300D	ED011161
			7/64	600D	ED011162

⁽¹⁾ Hardness range given is work hardened. As-welded range would be significantly lower, typically around 22 R_C.

Package Code Key: AD = Accu-Trak® Drum C = Coil CT = Cardboard Carton D = Speed Feed® Drum (wire) or Steel Drum (flux)
 SP = Plastic Spool SSP = Steel Spool



Lincore® wires for submerged arc hardfacing are designed for use with specific Lincoln® fluxes to provide optimum deposit composition, hardness and microstructure for a variety of applications.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Severe Impact, con't.					
Lincore® 15CrMn	40-50 ^H R _C	Provides impact resistance on carbon, low alloy, austenitic manganese and stainless steels. Good for joining manganese steels. Limit interpass to 500° F.	5/64	25SSP	ED031126
			5/64	50C	ED022060
			7/64	50C	ED022061
			7/64	125D	ED022068
Lincore 15CrMn LS	40-50 ^H R _C	Lincore 15CrMn LS is a self-shielded, flux-cored wire with the same characteristics as Lincore 15CrMn but with lighter slag, that allows welding additional layer(s) without removing slag from the prior pass.	5/64	25SSP	ED031127
			7/64	50C	ED029064
			7/64	125D	ED029558

Severe Abrasion

Lincore® 60-O	55-60 R _C	Hardfacing carbon, low alloy, manganese, and stainless steels. Limit 2 layers.	.045	25SSP	ED031131
			1/16	25SSP	ED031132
			5/64	25SSP	ED031133
			5/64	50C	ED019887
			7/64	50C	ED019888
			.120	50C	ED020800
			5/64	125D	ED020803
Lincore® 65-O	60-65 R _C	Resists dilution better than 60-O. Check cracks are desired to relieve stress.	7/64	50C	ED026077
			7/64	125D	ED026079
			7/64	200D	ED026081
			1/8	200D	ED026080
			7/64	500D	ED026083
Lincore® 60-G	57-61 R _C	Gas-shielded, metal-cored wire for hardfacing carbon, low alloy, manganese and stainless steels.	.045	10SP	ED029937
			.045	25SP	ED029936

Abrasion Plus Impact

Lincore® 50	48-52 R _C	Use on low carbon, medium carbon, low alloy, manganese, and stainless steels.	.045	25SSP	ED031123
			1/16	25SSP	ED031124
			5/64	25SSP	ED031125
			.045	50C	ED020828
			1/16	50C	ED020829
			5/64	50C	ED017825
			7/64	50C	ED011275
			7/64	125D	ED011274

Package Code Key: AD = Accu-Trak® Drum C = Coil CT = Cardboard Carton D = Speed Feed® Drum (wire) or Steel Drum (flux)
 SP = Plastic Spool SSP = Steel Spool



Lincore® wires for submerged arc hardfacing are designed for use with specific Lincoln® fluxes to provide optimum deposit composition, hardness and microstructure for a variety of applications.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Build-Up					
Lincore® 20	22-28 R _C	For build-up on continuous caster rolls for the steel industry, with 801, 802 or 880 flux.	3/32	50C	EDS18565
			1/8	50C	EDS18566
			3/32	600D	EDS18568
			1/8	600D	ED018569
			5/32	600D	EDS18570
Lincore® 30-S	24-32 R _C	For build-up on tractor idler rolls, crane wheels, shafts, with 801, 802, 880 or 860 flux.	3/32	50C	ED011200
			1/8	50C	ED015889
			1/8	300D	ED015890
			3/32	600D	ED011199
			1/8	600D	ED015891
Lincore® 32-S	28-36 R _C	For two to three layer build-up on 4140 steel drill stems, with 802 or 803 flux.	3/32	50C	ED025655
			1/8	50C	ED025129
			3/32	300D	ED025656
			1/8	300D	ED025130
			1/8	600D	ED025131
Lincore® 35-S	34-42 R _C	For build-up on tractor idler rolls, crane wheels, shafts, with 801, 802 or 880 flux. Suitable for flame hardening.	3/32	50C	ED019880
			1/8	50C	ED019881
			5/32	50C	ED019882
			3/32	600D	ED019883
			1/8	600D	ED019884
			5/32	600D	ED019885
Lincore® 4130	18-24 R _C	For build-up for plate, rolls and sheaves, with 801, 802 or 880 flux. Suitable for flame hardening.	3/32	50C	ED015265
			1/8	50C	ED015266
			3/32	600D	ED015532
			1/8	600D	ED015405
Lincore® 8620	16-22 R _C	For build-up on continuous caster rolls for the steel industry, with 801, 802 or 880 flux.	3/32	50C	ED020787
			5/32	50C	EDS20789
			1/8	600D	ED020791
Metal-To-Metal Wear					
Lincore® 40-S	36-42 R _C	For hardfacing of tractor undercarriage parts and links with 801, 802 or 880 flux.	1/8	50C	ED015892
			1/8	300R	ED016262
			1/8	300D	ED015945
			1/8	600D	ED015909
Lincore® 42-S	38-44 R _C	For hardfacing of tractor undercarriage parts and links with 801 or 802 flux.	3/32	50C	EDS29162
			1/8	50C	ED029159
			3/32	300D	EDS29298
			1/8	300D	ED029264
			3/32	600D	EDS29164
Lincore® 96S	48-56 R _C	For hardfacing continuous caster and work rolls for steel mills with 801 or 802 flux. 12% Cr deposit also resists corrosion.	5/32	50C	EDS18573
			3/32	600D	ED018574
			1/8	600D	ED018575
			5/32	600D	ED018576
Lincore® 102W	48-56 R _C	For hardfacing work and transfer rolls for steel mill with 802 flux. Tool steel deposit resists softening in PWHT.	3/32	50C	ED018577
			1/8	50C	ED018578
			1/8	600D	ED018581
			5/32	600D	ED018582

Package Code Key: C = Coil D = Speed Feed® Drum (wire) or Steel Drum (flux)



Lincore® wires for submerged arc hardfacing are designed for use with specific Lincoln® fluxes to provide optimum deposit composition, hardness and microstructure for a variety of applications.

Electrode Name	Hardness Rockwell C	General Description	Diameter inches	Package Weight Lbs.	Product Number
Metal-To-Metal Wear, con't.					
Lincore® 102HC	53-60 R _C	For hardfacing work and transfer rolls for steel mill with 802 flux. Tool steel deposit resists softening in PWHT.	3/32	50C	ED026084
			1/8	50C	ED026085
			3/32	600D	ED026086
			1/8	600D	ED026087
Lincore® 410	28-36 R _C	For hardfacing continuous caster and work rolls for steel mills with 801 or 802 flux. 12% Cr deposit also resists corrosion.	3/32	50C	ED018583
			1/8	50C	ED018584
			3/32	600D	ED018586
			1/8	600D	EDS18587
			5/32	600D	ED018588
Lincore® 410NiMo	30-38 R _C	For hardfacing continuous caster and work rolls for steel mills with 801 or 802 flux. 12% Cr deposit also resists corrosion.	3/32	50C	ED018589
			1/8	50C	ED018590
			5/32	50C	EDS18591
			3/32	600D	EDS18592
			1/8	600D	ED018593
Lincore® 420	44-52 R _C	For hardfacing continuous caster and work rolls for steel mills with 801 or 802 flux. 12% Cr deposit also resists corrosion.	3/32	50C	ED015260
			1/8	50C	ED015262
			5/32	50C	EDS15263
			3/32	600D	ED015261
			1/8	600D	ED015268
5/32	600D	ED015264			
Lincore® 423L	41-47 R _C	For hardfacing continuous caster and work rolls for steel mills with 802 flux. 11.5% Cr deposit also resists corrosion. Contains vanadium for resistance to softening.	1/8	50C	ED018548
			3/32	600D	EDS18550
			1/8	600D	ED018551
Lincore® 423Cr	41-47 R _C	For hardfacing continuous caster and work rolls for steel mills with 802 flux. 13.5% Cr deposit also resists corrosion. Contains vanadium for resistance to softening.	3/32	50C	EDS18553
			1/8	50C	EDS18554
			3/32	600D	EDS18556
			1/8	600D	ED018557
			5/32	600D	ED018558
Lincore® 424A	37-43 R _C	For hardfacing continuous caster and work rolls for steel mills with 802 flux. 13% Cr deposit also resists corrosion.	3/32	50C	EDS18559
			1/8	50C	ED018560
			5/32	50C	EDS18561
			3/32	600D	EDS18562
			5/32	600D	EDS18564

Severe Abrasion

Lincore® 60-S	55-60 R _C	For hardfacing crusher rolls, ore chutes, and blast furnace bells and hoppers. Use with 803 flux.	5/32	50C	EDS16880
			5/32	600D	ED016884

Lincolnweld®

Lincoln defines **neutral fluxes** as those which will not produce any significant changes in the all weld metal composition as a result of a large change in the arc voltage, and thus the arc length. Lincoln defines **alloy fluxes** as those which are used with a plain carbon steel electrode to make alloy weld deposits. The alloys for the weld deposit are added as ingredients in the flux. Alloy fluxes are designed for use with Lincolnweld® L-60 mild steel wire.

Electrode Name	General Description	Package Weight Lbs.	Product Number
Hardfacing Fluxes - Neutral			
Lincolnweld® 801	Fast-freezing flux provides smooth beads and excellent slag removal. Use with Lincore® 20, 30-S, 35-S, 40-S, 42-S, 4130, 8620, 410, 410NiMo, 420 and 96S.	50B	ED019588
		450D	ED023403
		2700BB	EDS30786
Lincolnweld® 802	Excellent hot slag removal with wire containing columbium, vanadium or very high chrome levels. Use with Lincore® 102W, 423L, 423Cr and 102HC.	50B	ED019457
		550D	ED023365
		3000BB	EDS30787
Lincolnweld® 803	Specially designed for Lincore® 60-S on high speed welding applications, such as the resurfacing of coal crusher rolls and blast furnace bells and hoppers.	50B	ED019799
Lincolnweld® 880	Can be used in applications similar to 801 and 802 and may improve slag removal.	50B	ED027866
		550D	ED028322

Hardfacing Fluxes - Alloy

Lincolnweld® H-535	Produces a deposit with good abrasion resistance, allows some machinability. Low carbon martensitic deposit. Hardness range is 24-45 Rockwell C, depending upon the actual welding procedure used.	50B	ED027865
Lincolnweld® A-96-S	Modified Type 420 stainless deposit with a carbon content near the high side for as-welded hardness. Carbon will be about .23%, with about 13% chromium using proper procedures.	50FB	ED027863
Lincolnweld® H-560	High alloy flux depositing primary carbides in a martensitic matrix. Excellent material for severe abrasion applications. Resistance to abrasion is 50 to 60 times that of plain carbon steel.	100B	ED010345

NOTE: Deposit carbon, alloy content and hardness depend upon the ratio of flux melted to wire melted. High voltage promotes high carbon and alloy contents, while low voltage promotes lower carbon and alloy content.

Package Code Key: FB = Foil Bag B = Bag D = Speed Feed® Drum (wire) or Steel Drum (flux) BB = Bulk Bag

Submerged Arc

Wire and Flux for Mild and Low Alloy Steels



Over 100 Combinations to Choose From.

- ▶ **BETTER CHEMISTRY** – Incoming raw material checked for 19 elements, and chemistry is verified more than a dozen times during manufacturing ensuring consistent quality.
- ▶ **EXTENSIVE PRODUCT LINE** – Over 100 flux / wire combinations tested to meet your application requirements.
- ▶ **BETTER MANUFACTURING SYSTEMS** – ISO 9001 and 14001 certified and manufactured to standards for environmental and quality management systems.
- ▶ **WIDE VARIETY OF LINCOLNWELD® FLUXES** – Active, neutral and alloy fluxes available to give you more flexibility out of your submerged arc consumable solution.
- ▶ **LINCOLNWELD® SOLID AND CORED WIRE ELECTRODES** – Choose from mild or low alloy steel electrodes to increase your submerged arc welding performance and expand your capabilities.



LINCOLN®
ELECTRIC
THE WELDING EXPERTS®

Electrode Name	AWS Class	General Description	Diameter in	Package Weight Lbs.	Product Number			
Lincolnweld® Carbon Steel Solid Wire								
Lincolnweld® L-50	EM13K	Lincolnweld® L-50 is a low carbon, medium manganese, medium silicon wire. Team it up with Lincolnweld® 980 flux for the best flux/wire combination when semiautomatic subarc welding.	1/16	60C	ED011317			
			5/64	60C	ED011335			
			3/32	60C	ED011328			
			1/8	60C	ED011323			
			5/32	60C	ED011332			
			3/16	60C	ED015469			
			1/16	600D	ED011316			
			5/64	1000D	ED011334			
			3/32	1000D	ED011327			
			1/8	1000D	ED011322			
			5/32	1000D	ED011331			
			3/16	1000D	ED015352			
			1/16	1000AD	ED029083			
Lincolnweld® L-56	EH11K	Lincolnweld® L-56 is a low carbon, high manganese, very high silicon special purpose wire. It is primarily used with Lincolnweld® 880M flux on multiple pass welds requiring 70 ksi tensile strengths in stress relieved conditions.	1/16	60C	ED011666			
			5/64	60C	ED011678			
			3/32	60C	ED011674			
			1/8	60C	ED011671			
			5/32	60C	EDS11677			
			1/16	1000R	ED011737			
			5/64	1000R	EDS01631			
			5/64	60C	ED011762			
Lincolnweld® L-60	EL12	Lincolnweld® L-60 is a low carbon, low manganese, and low silicon general purpose electrode. It provides the lowest hardness and is best suited for use with the Lincolnweld® 700 series of active fluxes.	3/32	60C	ED011752			
			1/8	60C	ED011743			
			5/32	60C	ED011758			
			3/16	60C	ED011749			
			5/64	600D	EDS11760			
			1/8	600D	EDS11741			
			5/64	1000D	ED011761			
			3/32	1000D	ED011751			
			1/8	1000D	ED011742			
			5/32	1000D	ED011757			
			3/16	1000D	ED011748			
			Lincolnweld® L-61	EM12K	Lincolnweld® L-61 is a low carbon, medium manganese, low silicon general purpose subarc electrode. It is a good choice for a wide range of applications with single or multiple pass subarc welding.	1/16	60C	ED011803
						5/64	60C	ED011825
3/32	60C	ED011815						
1/8	60C	ED011807						
5/32	60C	ED011821						
3/16	60C	ED011812						
5/32	300D	ED030628						
5/64	600D	EDS11823						
3/32	600D	EDS11813						
1/8	600D	EDS11805						
5/32	600D	EDS11819						
5/64	1000D	ED011824						
3/32	1000D	ED011814						
1/8	1000D	ED011806						
5/32	1000D	ED011820						
3/16	1000D	ED011811						
Lincolnweld® LA-71	EM14K	Lincolnweld® LA-71 is a low carbon, medium manganese, medium silicon submerged arc electrode containing approximately 0.1% titanium. This small addition of titanium allows deposits to be stress-relieved with little loss of strength. It is also widely used with neutral basic fluxes where excellent CTOD's are required.	5/64	60C	EDS11054			
			3/32	60C	ED011052			
			1/8	60C	ED011051			
			1/8	1000D	EDS30781			
			5/32	1000D	EDS30782			

Package Code Key: AD = Accu-Trak® Drum C = Coil D = Speed Feed® Drum (wire) or Steel Drum (flux) R = Speed-Feed® Reel

Electrode Name	AWS Class	General Description	Diameter in	Package Weight Lbs.	Product Number
Lincolnweld® Carbon Steel Solid Wire, con't.					
Lincolnweld® L-S3	EH12K	Lincolnweld® L-S3 is a low carbon, high manganese, medium silicon electrode designed for use with the Lincolnweld® 800 series of neutral fluxes. It is capable of producing impact properties exceeding 20 ft•lbf (27 J) at -80° F (-62° C) when used with Lincolnweld® 882, 888™, 8500, or MIL800-H fluxes and is often used in the most demanding offshore applications.	1/8	60C	ED016767
			5/32	60C	ED016248
			5/32	300D	ED030567
			5/32	1000D	ED029226
			3/16	1000D	EDS01652

Lincolnweld® Low Alloy Steel Solid Wire

Lincolnweld® L-70	EA1	Lincolnweld® L-70 is a low carbon, medium manganese, low silicon, 0.5% molybdenum wire used for single or multiple pass welds. This electrode is a standard choice for pipe fabrication and other limited pass applications.	5/64	60C	ED012054
			1/8	60C	ED012051
			5/32	60C	ED012053
			3/16	60C	ED012052
			1/8	1000D	ED021192
Lincolnweld® LA-75	ENi1K	Lincolnweld® LA-75 is a low carbon, medium manganese, high silicon, nickel-bearing electrode designed for use with Lincoln's family of neutral fluxes. It is suitable for use where deposits with less than 1% Ni are required.	5/64	60C	ED011066
			3/32	60C	ED011064
			1/8	60C	ED011062
			5/32	60C	ED011065
			5/32	1000D	EDS21194
Lincolnweld® LA-81	EG	Lincolnweld® LA-81 is a low carbon, medium manganese, low silicon, 0.5% molybdenum wire containing small additions of titanium and boron for extremely high toughness. It is generally used in two pass applications for arctic grade line pipe or as a back bead on multiple pass welds. It can be used to weld up to API X90 grade pipe.	5/32	60C	ED023163
			5/32	1000D	EDS31060
Lincolnweld® LA-82	EF2	Lincolnweld® LA-82 is designed especially for high strength applications. This is primarily used when 100 ksi tensile strength is required.	3/32	60C	EDS30785
			1/8	60C	ED026958
			5/32	60C	ED026959
Lincolnweld® LA-84	EF3	Lincolnweld® LA-84 is a nickel-bearing electrode with 0.5% molybdenum. This electrode is used for higher strength weldments where impact properties exceeding 20 ft•lbf (27 Joules) at -80° F (-62° C) are needed. It can be used where less than 1% Ni is required.	3/32	60C	ED031871
			3/32	1000D	ED031872
Lincolnweld® LA-85	ENi5	Lincolnweld® LA-85 is a nickel-bearing wire with 0.2% molybdenum for use on weathering steels. When used with 8500 or MIL800-H flux, it can also be used for applications requiring impact properties which exceed 20 ft•lbf (27 Joules) at -80° F (-62° C).	3/32	60C	ED023166
			1/8	60C	ED023167
			5/32	60C	ED023168
			3/16	60C	ED023169
Lincolnweld® LA-90	EA3K	Lincolnweld® LA-90 is a low carbon, high manganese, high silicon, 0.50% molybdenum special purpose wire.	1/16	60C	ED013999
			5/64	60C	ED011086
			3/32	60C	ED011084
			1/8	60C	EDS11083
			5/32	60C	EDS11085
Lincolnweld® LA-92	EB2R	Lincolnweld® LA-92 is designed for the welding of 1-1/4% chromium, 1/2% molybdenum steels. These weld deposits are used for high temperature service applications such as pressure vessels or piping. The AWS R designator denotes ultra low residuals which will result in a low Bruscato factor.	5/32	1000D	EDS01152
			3/32	60C	EDS30783
			1/8	60C	EDS26960
			5/32	60C	EDS26961
			3/32	60C	EDS30784
Lincolnweld® LA-93	EB3R	Lincolnweld® LA-93 is designed for high temperature applications such as pressure vessels and piping for 2-1/4% chromium, 1% molybdenum steels. The AWS R designator denotes ultra low residuals which will result in a low Bruscato factor.	1/8	60C	EDS26962
			5/32	60C	EDS26963
			5/32	60C	EDS26963
Lincolnweld® LA-100	EM2	Lincolnweld® LA-100 is a low carbon, high manganese wire with nickel and molybdenum designed to weld high strength steels such as HY-80 and HSLA-80. It is also used for undermatching on HY-100 and HSLA-100 and is used extensively in critical high strength applications with MIL800-H flux.	1/16	60C	ED010996
			5/64	60C	ED011002
			3/32	60C	ED010999
			1/8	60C	ED010998
			5/32	60C	EDS11001

Package Code Key: C = Coil D = Speed Feed® Drum (wire) or Steel Drum (flux)

Electrode Name	AWS Class	General Description	Diameter in	Package Weight Lbs.	Product Number
Lincolnweld® Carbon Steel Cored Wire					
Lincolnweld® LC-72	EC1	Lincolnweld® LC-72 is a cored wire designed to increase deposition rates 10-30% when used with 980 flux. Good bead shape, penetration, and slag removal make LC-72 the only mild steel cored wire option needed.	5/64	50C	ED011099
			3/32	50C	ED011098
			3/32	300R	EDS01186
			3/32	600R	EDS01188
			3/32	600D	EDS01187

Lincolnweld Low Alloy Steel Cored Wires

Lincolnweld® LAC-B2	ECB2	Lincolnweld® LAC-B2 is a flux-cored wire designed to weld with either single or tandem arcs using a neutral flux. It is a cost effective choice when welding chrome-moly steels where Bruscato factor is not an issue.	3/32	60C	ED010954
			5/32	60C	ED010955
			3/32	600D	ED019581
			5/32	600D	ED019582
Lincolnweld® LAC-M2	ECM2	Lincolnweld® LAC-M2 flux-cored subarc wire delivers yield strengths around 100 ksi. Lincolnweld® LAC-M2 also delivers impact properties exceeding 20 ft•lbf (27 Joules) at -80° F (-62° C) when used with 888™ flux.	3/32	50C	ED010981
			5/32	50C	ED010982
Lincolnweld® LAC-Ni2	ECNi2	Lincolnweld® LAC-Ni2 is a 2% Ni flux-cored subarc wire which is used primarily for weathering steel applications. When used with 888™ flux, it can produce impact properties exceeding 20 ft•lbf (27 Joules) at -100° F (-73° C).	3/32	50C	ED010986

Package Code Key: C = Coil D = Speed Feed® Drum (wire) or Steel Drum (flux) R = Speed-Feed® Reel

Wire	AWS ASME Class	AWS Wire Composition Limits ⁽¹⁾												
		%C	%Mn	%Si	%Cr	%Ni	%Mo	%Ti	%Zr	%Al	%V	%S	%B	%P

Lincolnweld® Carbon Steel Electrodes (Chemistry)

Lincoln® Electrode Classifications per AWS A5.17-97

L-50	EM13K	.06-.16	.90-1.40	.35-.75	—	—	—	—	—	—	—	.030	—	.030	.35
L-56	EH11K	.06-.15	1.40-1.85	.80-1.15	—	—	—	—	—	—	—	.030	—	.030	.35
L-60	EL12	.04-.14	.25-.60	.10	—	—	—	—	—	—	—	.030	—	.030	.35
L-61	EM12K	.05-.15	.80-1.25	.10-.35	—	—	—	—	—	—	—	.030	—	.030	.35
LA-71	EM14K	.06-.19	.90-1.40	.35-.75	—	—	—	.03-.17	—	—	—	.025	—	.025	.35
LC-72 ^(2,3)	EC1	.15	1.80	.90	—	—	—	—	—	—	—	.035	—	.035	.35
L-S3	EH12K	.06-.15	1.50-2.0	.25-.65	—	—	—	—	—	—	—	.025	—	.025	.35

Lincolnweld® Low Alloy Electrodes (Chemistry)

Lincoln® Electrode Classifications per AWS A5.23-97

L-70	EA1	.05-.15	.65-1.00	.20	—	—	.45-.65	—	—	—	—	.025	—	.025	.35
LA-75	ENi1K	.12	.80-1.40	.40-.80	—	.75-1.25	—	—	—	—	—	.020	—	.020	.35
LA-81 ⁽⁴⁾	EG	.05	1.2	.2	—	—	.5	.1	—	—	—	—	.01	—	.20
LA-82	EF2	.10-.18	1.70-2.40	.2	—	.40-.80	.40-.65	—	—	—	—	.025	—	.025	.35
LA-84	EF3	.10-.18	1.75-2.20	.15-.25	—	.80-1.0	.45-.60	—	—	—	—	.010-.020	—	.010-.020	.05-.15
LA-85	ENi5	.12	1.20-1.60	.05-.30	—	.75-1.25	.10-.30	—	—	—	—	.020	—	.020	.35
LA-90	EA3K	.05-.15	1.60-2.10	.50-.80	—	—	.40-.60	—	—	—	—	.025	—	.025	.35
LA-92	EB2R	.07-.15	.45-1.00	.05-.30	1.00-1.75	—	.45-.65	—	—	—	—	.025	—	.025	.35
LA-93	EB3R	.05-.15	.40-.80	.05-.30	2.25-3.00	—	.90-1.10	—	—	—	—	.025	—	.025	.35
LA-100	EM2	.10	1.25-1.80	.20-.60	.30	1.40-2.10	.25-.55	.10	.10	.10	.05	.015	—	.010	.25

Electrode Name	General Description	Package Weight Lbs.	Product Number
Fluxes – Active			
760	Lincolnweld® 760 is highly active and designed to handle rust and mill scale. It is recommended for applications where porosity caused by arc blow is a challenge. For excellent bead appearance on flat fillet welds—choose Lincolnweld® 760.	50B	ED019584
761	Lincolnweld® 761 is a manganese alloying and carbon reducing flux designed to provide superior crack resistance. It is recommended for single pass welding with Lincolnweld® L-70 and LA-90 electrodes. For a flux which produces welds with good bead appearance and is capable of producing Charpy V-Notch results exceeding 20 ft•lbf (27 J) @ -20° F (-29° C) when welded in accordance to AWS A5.17 or AWS 5.23—choose Lincolnweld® 761.	50B	ED032765
780	Lincolnweld® 780 features fast freezing slag for easy removal and minimized spilling. When paired with Lincolnweld® L-61 it is recommended for a wide range of single and multi-pass welding applications. For low flash-through, excellent bead shape, and easy slag removal—choose Lincolnweld® 780.	50B 550D	ED019586 ED032007
781	Lincolnweld® 781 features fast follow characteristics needed to make uniform welds at high speed without undercut or voids. It is recommended for high speed, limited pass welds on clean plate and sheet steel. For good wetting action and uniform welds at high speeds—choose Lincolnweld® 781.	50B	ED019587

Fluxes – Neutral

The primary use for Neutral Fluxes is for multiple-pass welding applications.

860	Lincolnweld® 860 offers excellent operating characteristics and is tested to exceed the impact and tensile strength requirements of AASHTO Fracture Critical and FEMA seismic applications. When tested to applicable specifications, this flux is capable of producing Charpy V-Notch test results exceeding 20 ft•lbf (27 J) @ -20° F (-29° C). For a flux with the ability to meet the stringent fracture and tensile strength requirements of many applications—choose Lincolnweld® 860.	50B	ED019589
865	Lincolnweld® 865 is a general purpose flux designed to weld butt joints and flat and horizontal fillets. When used with Lincolnweld® L-50 or L-61, it produces 70 ksi tensile strength as welded or after short- or long-term stress relief. For fracture toughness exceeding minimum requirements, as well as resistance to rust porosity and pockmarking—choose Lincolnweld® 865.	50B	EDS27857
880	Lincolnweld® 880 is designed for use with solid low alloy steel electrodes with a minimum of 0.20% silicon to obtain increased de-oxidation and optimal bead appearance. It is also recommended for use with Lincolnweld® LAC series of low alloy flux-cored electrodes, and many Lincore® flux-cored hardfacing electrodes. For a smooth bead appearance on low alloy or hardfacing welding applications—choose Lincolnweld® 880.	50B 550D	ED027866 ED028322
880M	Lincolnweld® 880M features industry proven operating characteristics and mechanical properties tested to exceed the minimum specifications relevant to many applications. It is recommended for welding with solid carbon steel and low alloy steel electrodes, as well as Lincoln's LAC series of low alloy flux-cored electrodes. For the best single arc AC welding flux with the ability to meet Charpy V-Notch requirements—choose Lincolnweld® 880M.	50PLB	ED031853
882	Lincolnweld® 882 is designed for a variety of welding applications and is known for providing a good bead appearance. It is recommended for stainless steel welding and paired with both mild and low alloy steel electrodes. For a multi-purpose flux designed to accommodate a wide range of welding applications—choose Lincolnweld® 882.	50B	ED027859
888™	Lincolnweld® 888™ is a basic flux designed for use in critical applications requiring minimum Charpy V-Notch properties. It is recommended for joining mild steel and low alloy steels in as welded and stress relieved applications, typical of the off-shore, wind tower or structural fabrication industries. For a flux capable of low diffusible hydrogen levels and Charpy V-Notch test results exceeding 20 ft•lbf (27 J) @ -20° F (-29° C)—choose Lincolnweld® 888™.	50PLB	ED031596
MIL800-H	Lincolnweld® MIL800-H features very low diffusible hydrogen levels and is designed for low temperature applications where minimum Charpy V-Notch properties are required. It is recommended for both single and multiple arc welding of both butt welds and fillets. For Charpy V-Notch test results exceeding 20 ft•lbf (27 J) @ -60° F (-51° C)—choose Lincolnweld® MIL800-H.	50HS	ED020925
8500	Lincolnweld® 8500 is designed to resist nitrogen porosity and exceed minimum fracture toughness requirements. It is recommended for multi-pass welding with mild and low alloy steel electrodes in both single and multiple electrode welding. For a flux capable of producing Charpy V-Notch test results exceeding 20 ft•lbf (27 J) @ -40° F (-40° C) with L-61, L-S3 and LA-85 electrodes—choose Lincolnweld® 8500.	50PLB	ED031854

Package Code Key: B = Bag BB = Bulk Bag D = Speed Feed® Drum (wire) or Steel Drum (flux) FB = Foil Bag HS = Hermetically Sealed Pail
PLB = Plastic Bag

Electrode Name	General Description	Package Weight Lbs.	Product Number
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Fluxes – Special Purpose Neutral

960	Lincolnweld® 960 is a low cost, general purpose flux designed to weld butt joints and both single and multiple pass fillets. It is recommended for automatic and semiautomatic subarc welding. For a flux designed to meet the fracture toughness requirements in AASHTO Fracture Critical applications—choose Lincolnweld® 960.	50B	ED022412
980	Lincolnweld® 980 combines many of the features of the 700 and 800 series fluxes, making it an excellent choice for fabricators who desire one flux for both automatic and semiautomatic welding throughout the shop. It is primarily recommended for semiautomatic, multi-pass welding of mild steel. For exceptional resistance to flash-through and porosity caused by arc blow in a variety of applications—choose Lincolnweld® 980.	50B	ED027861

Fluxes – Fabrication of Line Pipe

995N	Lincolnweld® 995N is a nitrogen limiting flux designed for longitudinal and spiral seams on pipe. It is recommended for automatic single pass welding with single or multiple arcs. For pipe applications requiring a flux capable of producing Charpy V-Notch test results exceeding 20 ft•lbf (27 J) @ -20° F (-29° C)—choose Lincolnweld® 995N.	50PLB 2600BB	EDS01669 ED030657
761-Pipe	Lincolnweld® 761-Pipe features similar chemical composition to 761 with a particle size is optimized for seam welding. Weld deposits are usually low carbon, fairly high manganese and have superior resistance to cracks and pockmarking. For AC and multiple arc pipe welding applications—choose Lincolnweld® 761-Pipe.	50B	ED032797
P223	P223 is an industry standard for pipe welding on up to X80 grade pipe. It is recommended for many two-run welding applications, but can also be used in multiple pass welding because it is neutral. For fast freezing slag characteristics ideal for welding small diameter pipe—choose P223.	50B	EDS30636

Additional High Performance Fluxes

AXXX10	Lincolnweld® AXXX-10 is an alloy flux designed to produce a nickel bearing weld deposit. It is recommended for use on ASTM A533-Class 1 and A588 weathering steels when combined with Lincolnweld® L-61. For a low alloy deposit on weather steel welding applications—choose Lincolnweld® AXXX-10.	50B	ED027862
MIL800-HPNi	Lincolnweld® MIL800-HPNi is designed to be used with Lincolnweld® LA-85 (ENi5) electrode to increase the nickel content of a weld deposit from a nominal 1% to a minimum 1%. It is recommended for high performance steel applications, such as HPS70V, with minimum yield strengths of 70 ksi. For a flux capable of producing low diffusible hydrogen levels and high deposition rates on applications ranging from bridge girder manufacturing to those requiring 100 ksi yield strength—choose Lincolnweld® MIL800-HPNi.	50HS	ED028657

Package Code Key: B = Bag HS = Hermetically Sealed Pail PLB = Plastic Bag



World Class Performance. World Wide Support.



- ▶ **CUSTOM PIPELINE WELDING SOLUTIONS** – Choose from premium Stick (SMAW), MIG (GMAW), Flux-Cored Gas & Self-Shielded (FCAW-G/FCAW-S) consumables.
- ▶ **PROCESS CONTROL MANUFACTURING** – Tightly controlled worldwide manufacturing operations ensure pipe welding professionals around the world the highest quality and consistency.
- ▶ **LOT-CONTROLLED AND LOT-TESTED** – All Pipeliner® products carry a Q2 certification and have archived records of in-process and finished product testing and manufacturing.
- ▶ **HERMETICALLY SEALED PACKAGING** – Pipeliner® products are delivered in moisture resistant packaging to ensure the product's integrity in the harshest environments.
- ▶ **GLOBAL SUPPORT** – Lincoln Electric's global network of manufacturing and distribution facilities, pipe welding engineers, welding technicians, and technical experts are there to deliver.



Pipeliners® is Lincoln Electric's® family of premium SMAW (Stick), GMAW (MIG), FCAW-G (Gas Shielded Flux-Cored) and FCAW-S (Self Shielded Flux-Cored) consumables developed specifically to meet the rigorous demands of the global pipe welding industry.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter mm	Package Weight Lbs.	Product Number
Pipeliners® 6P+	E6010	DC±	Pipeliners® 6P+ sets the standard for root pass welding in the pipeline industry. It is recommended for root pass welding in either vertical up or vertical down welding positions of up to X80 grade pipe as well as hot, fill and cap pass welding of up to X60 grade pipe. For all-position pipe welding—choose Pipeliners® 6P+.	(2.5 mm)	30CT(10EO)	ED032609
				(3.2 mm)	30CT(10EO)	ED032610
				(4.0 mm)	30CT(10EO)	ED032611
				(3.2 mm)	50EO	ED030848
				(4.0 mm)	50EO	ED030849
Pipeliners® 7P+	E7010-P1	DC±	Pipeliners® 7P+ has high deposition rates which allow for fewer fill, cap and hot passes. It is capable of meeting stringent pipeline welding requirements when tested for low temperature impact toughness. It is recommended for root pass welding of up to X80 grade pipe, and hot, fill and cap pass welding of up to X65 grade pipe. For vertical down and out-of-position pipe welding—choose Pipeliners® 7P+.	(3.2 mm)	30CT(10EO)	ED032612
				(4.0 mm)	30CT(10EO)	ED032613
				(5.0 mm)	30CT(10EO)	ED032614
				(3.2 mm)	50EO	ED031611
				(4.0 mm)	50EO	ED031612
(5.0 mm)	50EO	ED031613				
Pipeliners® 8P+	E8010-P1	DC+	Pipeliners® 8P+ is the highest strength cellulosic electrode in the Lincoln Pipeliners® family. It is recommended for root pass welding of up to X80 grade pipe, and hot, fill and cap pass welding of up to X70 grade pipe. For vertical down and out-of-position pipe welding—choose Pipeliners® 8P+.	(3.2 mm)	30CT(10EO)	ED032615
				(4.0 mm)	30CT(10EO)	ED032616
				(5.0 mm)	30CT(10EO)	ED032617
				(3.2 mm)	50EO	ED030826
				(4.0 mm)	50EO	ED030827
(5.0 mm)	50EO	ED030828				

Low Hydrogen Stick (SMAW) Electrodes

Pipeliners® 16P	E7016 H4	DC+	Pipeliners® 16P has unique properties that enable low hydrogen SMAW root passes meeting strict pipe welding requirements. It is recommended for root pass welding of up to X100 grade pipe where a low hydrogen SMAW root pass is required. For vertical up pipe welding—choose Pipeliners® 16P.	(2.5 mm) (3.2 mm) (4.0 mm)	50EO 50EO 50EO	ED030916 ED030917 ED030918
Pipeliners® 17P	E7018-1 H4R	DC+	Pipeliners® 17P has high operator appeal, with smooth arc, square burn-off and excellent puddle control. It is recommended for fill and cap pass welding of up to X65 grade pipe. For vertical up pipe welding—choose Pipeliners® 17P.	(3.2 mm) (4.0 mm)	30CT(10EO) 30CT(10EO)	ED032618 ED032619
Pipeliners® 18P	E8018-G H4	DC+	Pipeliners® 18P has high operator appeal, with smooth arc, square burn-off and excellent puddle control. It is recommended for fill and cap pass welding of up to X70 grade pipe. For vertical up pipe welding—choose Pipeliners® 18P.	(3.2 mm) (4.0 mm)	30CT(10EO) 30CT(10EO)	ED032620 ED032621
Pipeliners® 19P	E10018-G H4R	DC+	Pipeliners® 19P has high operator appeal, with smooth arc, square burn-off and excellent puddle control. It is recommended for fill and cap pass welding of up to X80 grade pipe. For vertical up pipe welding—choose Pipeliners® 19P.	(3.2 mm) (4.0 mm)	30CT(10EO) 30CT(10EO)	ED032622 ED032623
Pipeliners® 20P	E12018-G H4R	DC+	Pipeliners® 20P has high operator appeal, with smooth arc, square burn-off and excellent puddle control. It is recommended for fill and cap pass vertical up welding of up to X100 grade pipe. For vertical up pipe welding—choose Pipeliners® 20P.	(3.2 mm) (4.0 mm)	30CT(10EO) 30CT(10EO)	ED032624 ED032625
Pipeliners® LH-D80	E8045-P2 H4R	DC+	Pipeliners® LH-D80 is a low hydrogen high deposition electrode specially designed for the vertical down welding of pipe. It is recommended for fill and cap pass welding of up to X70 pipe as well as pipe repair and hot tapping applications. For an electrode capable of low hydrogen levels, high productivity and operator appeal—choose Pipeliners® LH-D80.	(3.2 mm)	30CT(10EO)	ED032626
				(4.0 mm)	30CT(10EO)	ED032627
				(4.5 mm)	30CT(10EO)	ED032628
Pipeliners® LH-D90	E9045-P2 H4R	DC+	Pipeliners® LH-D90 is a low hydrogen high deposition electrode specially designed for the vertical down welding of pipe. It is recommended for fill and cap pass welding of up to X80 pipe as well as pipe repair and hot tapping applications. For an electrode capable of low hydrogen levels, high productivity and operator appeal—choose Pipeliners® LH-D90.	(3.2 mm)	30CT(10EO)	ED032629
				(4.0 mm)	30CT(10EO)	ED032630
				(4.5 mm)	30CT(10EO)	ED032631
Pipeliners® LH-D100	E10045-P2 H4R	DC+	Pipeliners® LH-D100 is a low hydrogen high deposition electrode specially designed for the vertical down welding of pipe. It is recommended for fill and cap pass welding of up to X90 pipe as well as pipe repair and hot tapping applications. For an electrode capable of low hydrogen levels, high productivity and operator appeal—choose Pipeliners® LH-D100.	(3.2 mm)	30CT(10EO)	ED032632
				(4.0 mm)	30CT(10EO)	ED032633
				(4.5 mm)	30CT(10EO)	ED032634

NOTE: Pipeliners® electrodes are manufactured under lot control. A Certificate of Test showing actual deposit chemistry and mechanical properties is available on www.lincolnelectric.com for every lot.

Package Code Key: C = Coil CT = Cardboard Carton EO = Easy Open Hermetic Can HS = Hermetically Sealed Pail SP = Plastic Spool
SSP = Steel Spool VFB = Vacuum Sealed Foil Bag



Pipeliners® is Lincoln Electric's® family of premium SMAW (Stick), GMAW (MIG), FCAW-G (Gas Shielded Flux-Cored) and FCAW-S (Self Shielded Flux-Cored) consumables developed specifically to meet the rigorous demands of the global pipe welding industry.

Electrode Name	AWS Class	Recm'd Polarity	General Description	Diameter in. (mm)	Package Weight Lbs.	Product Number
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MIG (GMAW) Wires

Pipeliners® 70S-G	ER70S-G		Pipeliners® 70S-G has a low silicon level for unblemished welds with less clean up required. Welds have good back bead shape for STT root passes. It is recommended for root pass welding of up to X100 grade pipe as well as hot, fill and cap pass welding of up to X70 grade pipe. For all-position welding—choose Pipeliners® 70S-G.	.045 (1.2)	10SP(VFB)	ED030904
				.045 (1.2)	30SP(VFB)	ED030905
Pipeliners® 80S-G	ER80S-G		Pipeliners® 80S-G is the highest strength MIG wire in Pipeliners® family. Recommended for root pass welding of up to X100 grade pipe as well as hot, fill and cap pass welding of up to X80 grade pipe. For all-position welding—choose Pipeliners® 80S-G.	.045 (1.2)	10SP(VFB)	ED031493
				.045 (1.2)	30SP(VFB)	ED031494

Self-Shielded Flux-Cored (FCAW-S) Wires

Pipeliners® NR®-207+	E71T8-K6	DC-	Pipeliners® NR®-207+ has the portability of stick electrode and the productivity of wire. It is recommended for hot, fill and cap pass welding of up to X70 grade pipe. For vertical down pipe welding—choose Pipeliners® NR®-207+.	5/64 (2.0)	56HS(14C)	ED030924
Pipeliners® NR®-208P	E81T8-6	DC-	Pipeliners® NR®-208P has the portability of stick electrode and the productivity of wire. It is capable of exceeding impact values of 29 Joules (20 ft•lbf) @ 0°C (32°F) when tested. It is recommended for hot, fill and cap pass welding of up to X70 grade pipe. For vertical down pipe welding—choose Pipeliners® NR®-208P.	5/64 (2.0)	56HS(14C)	ED031912
Pipeliners® NR®-208XP	E81T8-G	DC-	Pipeliners® NR®-208XP has been micro-alloyed to be capable of producing impact values of 29 J (20 ft•lbf) @ -20°C (-40°F). It is recommended for hot, fill and cap pass welding of up to X70 grade pipe. For vertical down pipe welding—choose Pipeliners® NR®-208XP.	5/64 (2.0)	56HS(14C)	ED031968

Gas-Shielded Flux-Cored (FCAW-G) Wires

Pipeliners® G70M	E71T-1MJH8 E71T-9MJH8	DC+ 75-80% Ar/ balance CO ₂	Pipeliners® G70M is designed for use with mechanized welding systems and has the best operator appeal in difficult welding positions. It is recommended for hot, fill and cap pass welding of up to X70 grade pipe. For vertical up pipe welding—choose Pipeliners® G70M.	.045 (1.2)	10SP(VFB)	ED030926
				.045 (1.2)	25SP(VFB)	ED030927
				.052 (1.3)	10SP(VFB)	ED030928
Pipeliners® G80M	E101T1-GM-H8	DC+ 75-80% Ar/ balance CO ₂	Pipeliners® G80M is higher strength than G70M, with slightly lower toughness. It is recommended for hot, fill and cap pass welding of up to X80 grade pipe. For vertical up pipe welding—choose Pipeliners® G80M.	.045 (1.2)	10SP(VFB)	ED031107
				.045 (1.2)	25SP(VFB)	ED031486
Pipeliners® G90M	E111T1-K3 MJ H4	DC+ 75-80% Ar/ balance CO ₂	Pipeliners® G90M is the highest strength FCAW-G wire capable of producing the lowest hydrogen level. It is recommended for hot, fill and cap pass welding of up to X80 grade pipe. For vertical up pipe welding—choose Pipeliners® G90M.	.045 (1.2)	10SP(VFB)	ED032860
				.052 (1.3)	10SP(VFB)	ED032664
				.045 (1.2)	33SP(VFB)	ED031931

NOTE: Pipeliners® electrodes are manufactured under lot control. A Certificate of Test showing actual deposit chemistry and mechanical properties are available on www.lincolnelectric.com for every lot.

Package Code Key: C = Coil HS = Hermetically Sealed Pail SP = Plastic Spool SSP = Steel Spool VFB = Vacuum Sealed Foil Bag

RECOMMENDED GENERAL OPTIONS



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Stick

ACCESSORY KITS

Accessory Kit, 400 Amp

For stick welding. Includes 35 ft. (10.7 m) #2/0 electrode cable with lug, 30 ft. (9.1 m) #2/0 work cable with lugs, headshield, filter plate, work clamp and electrode holder.

Order K704



Accessory Kit, 150 Amp

For stick welding. Includes 20 ft. (6.1 m) #6 electrode cable with lug, 15 ft. (4.6 m) #6 work cable with lugs, headshield, filter plate, work clamp, electrode holder and sample pack of mild steel electrode.

Order K875



Stick Electrode Holder & Cable

Includes 12.5 ft. (3.8 m) electrode cable with Twist-Mate™ connectors.

Order K2374-1 for Precision TIG® 225



Stick Electrode Holder, Work Clamp, Cable & Twist-Mate™ Set

Includes 200 amp stick holder, welding cable, work cable, work clamp and Twist-Mate™ connections.

Order K2394-1 for V275-S, V160-T, V205-T AC/DC, V205-T DC



REMOTE CONTROLS

Remote Output Control

For remote output of welding voltage. Consists of control box with 25 or 100 ft. (7.6 or 30 m) of four conductor cable and 6 pin MS-type connector. **Order K857** for 25 ft. (7.6 m) **Order K857-1** for 100 ft. (30 m)



Remote Output Control with 120V AC Receptacles

Remote weld output control box with two 120V AC receptacles having GFCI (Ground Fault Circuit Interrupter) protection. One cord for both remote and power. 100 ft. (30.5 m) long. Permits remote adjustment of weld output and power for tools 20 amp capacity.

Order K2627-2 for Ranger® 225 GXT, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



Remote Output Control

(Stick Welding) Contains remote control rheostat, and 100 ft. (30.5 m) long cable.

Order K924-5 for Pipeliner® 200D, Classic® 300D (Code 10911 and up), SAE-500



Remote Output Control

(Stick and Wire Welding) Contains rheostat for stick output, potentiometer for wire output, and 100 ft. (30.5 m) long control cable.

Order K2464-1 for Pipeliner® 200D, Classic® 300D (Code 10911 and up)



TIG MODULE



TIG Module

Portable, high frequency unit with gas valve for TIG welding. Rated at 300 amps/60% duty cycle.

Order K930-2

Control Cable

Connects TIG Module to power source.

Order K936-1 for 9-pin to 14-pin

Order K936-3 for 9-pin to 6-pin plus 115V

Order K936-4 for 9-pin to 115V



Control Cable Extension

Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. Available in 45 ft. (13.7 m) sections.

Order K937-45



Docking Kit

Allows you to "dock" the TIG Module on top of a flat-roofed power source, or any other flat surface measuring at least 10 x 15 in. (254 x 381 mm). Includes a latch and provisions for a user-supplied padlock to lock the TIG Module in place.

Order K939-1



Contact Kit

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.

Order K938-1



TIG REMOTE CONTROLS

Arc Start™ Switch

May be used in place of the foot or hand Amptrol®. Comes with a 25 ft. (7.6 m) cable and 6 pin plug connector.

Attaches to the TIG torch for convenient finger control to start and stop the weld cycle at the current set on the machine.

Order K814



Amptrol® Adapter Kit

Adapts Amptrol's 6-pin MS-type plug connection to terminal strip on power source.

Order K843



Foot Amptrol®

Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).

Order K870



Hand Amptrol®

Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6-pin plug connection). Velcro straps secure it to the torch.

Order K963-3 (One size fits all Pro-Torch™ TIG Torches.)

TIG WATER-COOLED OPTIONS

Cool Arc® 35 Water Cooler

Cooler plugs directly into the Invertec® V310-T AC/DC for digital communication and input power. This "smart cooler" monitors pressure and temperature and adjusts its speed accordingly.

Order K2630-1



Cool Arc® 40 Water Cooler

Reliable and affordable water cooler for water-cooled MIG, TIG, or plasma cutting applications.

Order K1813-1 for 115/1/50/60

Order K2187-1 for 220-240/1/50/60



Water Cooler Hoses (CGA to CGA)

For 5/8" LH CGA fitting applications at both cooler and wire feeder. Kit contains two 25 ft. hoses with 5/8" left hand CGA fittings on both ends of hose.

Order K1859-2 for Precision TIG® 275, Precision TIG® 375



TIG-MATE™ STARTER PACKS

TIG-Mate™ 9 Air-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-9 Ultra-Flex™ torch, gas lens parts kit, Harris® flowmeter/regulator, Twist-Mate™ adapter, gas hose, work clamp and cable.

Order K2413-1

Includes Ultra-Flex™ Torch!



TIG-Mate™ 17V Air-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17V Ultra-Flex™ torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, and work clamp and cable.

Order K2265-1

Includes Ultra-Flex™ Torch!



TIG-Mate™ 17 Air-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17 Ultra-Flex™ torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, Twist-Mate™ adapter, and work clamp and cable.

Order K2266-1

Includes Ultra-Flex™ Torch!



TIG-Mate™ 20 Water-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTW-20 torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, Twist-Mate™ adapter, work clamp and cable and 10 ft. (3.0 m) water hose.

Order K2267-1

Includes Ultra-Flex™ Torch!



TIG, con't.

PRO-TORCH™ TIG TORCHES

Light and easy to use, these torches feature flexible head models that give you the power of maximum versatility and maneuverability. A molded, knurled handle gives you a sure grip so you can focus on the weld. Available in either air-cooled or water-cooled designs.

Request publication E12.150 for details.

TIG Torches

Model	Rated Amperage	Tungsten Range in. (mm)	Length ft. (m)	Number of Cables	Product Number
Air-Cooled TIG Torches					
PTA-9	125	.020-1/8	12.5 (3.8)	1	K1781-1
	125		25.0 (7.6)	1	K1781-3
PTA-9F	125	.020-1/8 (0.8-3.2)	25.0 (7.6)	1	K1781-6
PTA-9FV	125	.020-1/8 (0.8-3.2)	25.0 (7.6)	1	K1781-7
PTA-9F Ultra-Flex™ ⁽¹⁾	125	.020-1/8 (0.8-3.2)	12.5 (3.8)	1	K1781-9
PTA-17	150	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1782-1
	150		12.5 (3.8)	2	K1782-2
	150		25.0 (7.6)	1	K1782-3
	150		25.0 (7.6)	2	K1782-4
PTA-17F	150	.020-5/32 (0.5-4.0)	25.0 (7.6)	1	K1782-10
PTA-17FV	150	.020-5/32 (0.5-4.0)	25.0 (7.6)	1	K1782-11
PTA-17V	150	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1782-6
	150		12.5 (3.8)	2	K1782-7
	150		25.0 (7.6)	1	K1782-8
	150		25.0 (7.6)	2	K1782-9
PTA-17 Ultra-Flex™	150	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1782-12
PTA-17FV Ultra-Flex™	150	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1782-13
PTA-26	200	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1783-1
	200		12.5 (3.8)	2	K1783-2
	200		25.0 (7.6)	1	K1783-3
	200		25.0 (7.6)	2	K1783-4
PTA-26F	200	.020-5/32 (0.5-4.0)	25.0 (7.6)	1	K1783-10
PTA-26FV	200	.020-5/32 (0.5-4.0)	25.0 (7.6)	1	K1783-11
	200		12.5 (3.8)	1	K1783-6
	200		12.5 (3.8)	2	K1783-7
	200		25.0 (7.6)	1	K1783-8
PTA-26V	200	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1783-6
	200		12.5 (3.8)	2	K1783-7
PTA-26V Ultra-Flex™ ⁽²⁾	200	.020-5/32 (0.5-4.0)	12.5 (3.8)	1	K1783-12
	200		12.5 (3.8)	2	K1783-9

Water-Cooled TIG Torches

PTW-18	350	.020-5/32 (0.5-4.0)	12.5 (3.8)	3	K1784-1
	350		25.0 (7.6)		K1784-2
PTW-20	250	.020-1/8 (0.5-3.2)	12.5 (3.8)	3	K1784-3
	250		25.0 (7.6)		K1784-4

Lincoln Adapters

Model	Product Number
<i>For Precision TIG® 275/375 Power Sources</i>	
PTA-26 (one-piece power cable)	K2166-1
PTA-9, -17 (one-piece power cable)	K2166-3
PTA-9, -17, -26 (two-piece power cable)	K2166-2
PTW-18, -20	No adapter required.
<i>For Invertec® V160-T, V205T AC/DC, V205T DC & Precision TIG® 225 Power Sources</i>	
PTA-9, -17	K1622-1
PTW-18, -20	K1622-4
PTA-26	K1622-3
<i>For TIG Module & Power Sources with 1/2" Stud Output Terminals</i>	
PTW-18, -20	K2505-2 and K1622-4
PTA-26, -26V	K2505-2 and K1622-3
PTA-9, -17	K2505-2 and K1622-1
PTA-9, -17, -26 (two-piece power cable)	No adapter required
<i>For Invertec® V160-S, V275-S, V350-PRO and Power Sources with Twist-Mate® Power and Separate Gas</i>	
PTA-9FV, -17V, -17FV	K2505-1 and K1622-1
<i>For Invertec® V100-S or V155-S Power Sources with small Twist-Mate® Power and Separate Gas</i>	
PTA-9FV, -17V, -17FV	K960-2

15 ft. (4.6 m) Torch Extension (right) for PTA-9, -17, and -26 torches



⁽¹⁾ Pre-configured package with K1622-1 Twist-Mate® adapter and 1/16" gas lens collet body, collet, and gas lens installed.

⁽²⁾ Pre-configured package with K1622-3 Twist-Mate® adapter, 1/8" collet, collet body, and gas lens installed.

Engine Drive

POWER PLUG KITS



120V

Power Plug Kit (20 amp)
Provides four 120V plugs rated at 20 amps each, and one dual voltage, full KVA plug rated at 120/240V, 50 amps. 120V plug may not be compatible with common household receptacles.

Order K802N for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



120V

Power Plug Kit (15 amp)
Provides four 120V plugs rated at 15 amps each, and one dual voltage, full KVA plug rated at 120/240V, 50 amps. 120V plug is compatible with common household receptacles.

Order K802R for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



115V

Power Plug Kit
Provides two 115V plugs rated at 20 amps each, and two 230V plugs rated at 15 amps each. 115V plugs may not be compatible with common household receptacles.

Order K802D for SAE-500, SAE-500 Severe Duty, Classic® 300D



GFCI Receptacle Kit
Includes one UL approved 120V ground fault circuit interrupter duplex type receptacle and installation instructions. Replaces the factory-installed 120V duplex receptacle. Each receptacle of the GFCI duplex is rated at 20 amps. Maximum total current from the GFCI duplex is limited to 20 amps. Two kits required for all 120V receptacles on Ranger® products.

Order K1690-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 250 GXT, Ranger® 250, Ranger® 305 G, SAE-500, SAE-500 Severe Duty



FULL KVA KITS

Full-KVA Adapter Kit (1-Phase)

Provides convenient connection of Lincoln Electric® equipment with NEMA 6-50P plug to Lincoln® engine driven welders having a full KVA receptacle.

Order K1816-1 for all engine driven welders with 120V/240V AC 1-Phase Receptacle



Full-KVA Power Plug (1-Phase)

One dual voltage plug rated at 120/240V, 50 amps. NEMA 14-50P.

Order T12153-9 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



Full-KVA Power Plug (3-Phase)

One plug rated at 240V, 50 amps. NEMA 15-50P.

Order T12153-10 for Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500

SERVICE KITS

Service Indicator Kit

Provides a GO/NO-GO visual indication of air cleaner element useful service life. Filter service based on restriction readings allows the longest life possible from the filter and best engine protection.

Order K1858-1 for Pipeliner® 200D, Classic® 300D, Vantage® 400, Vantage® 500 (Perkins®)

COLD WEATHER KITS

Cold Weather Operation Kit

For extreme cold conditions where engine glow plug starting is not sufficient. Includes oil pan heater, engine water heater and radiator grill tarp.

Order K2174-1 for Ranger® 305D (Kubota®)



Cold Weather Kit

For engine starting and operation in extreme cold weather conditions down to -40°F/-40°C (with the use of 0W40 synthetic oil and arctic diesel fuel). Includes 120V AC oil pan heater, 120V AC engine block heater, and radiator grill tarp.

Order K2679-1 for Vantage® 400 (Perkins®), Vantage® 500 (Perkins®)

Order K2679-2 for Vantage® 400 (Kubota®)



Cold Weather Heater and Tarp Kit

For extreme cold conditions where normal engine starting is not sufficient. Includes oil pan heater, battery heater, engine water heater and radiator grill tarp

Order K2359-2 for Air Vantage® 500



Ether Start Kit

Provides maximum cold weather starting assistance for frequent starting below 10°F (-12°C). Required ether tank is not provided with kit. (For Cummins® engine Ether Start Kit cannot be used simultaneously with service indicator kit).

Order K887-1 for Vantage® 500 (Deutz®)

SPARK ARRESTOR KITS

Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

Order K2793-1 for Outback™ 185



Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

Order K1898-1 for Ranger® 225 GXT, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300



Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

Order K899-1 for Vantage® 500 (Deutz)



Engine Drive, con't.

SPARK ARRESTOR KITS, CONT.



Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

Order K903-1 for Pipeliner® 200D (Kubota®), Classic® 300D, Vantage® 400, Vantage® 500 (Perkins®)



Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

Order K894-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 3 Phase



Lockable Fuel Cap/Flash Arrestor Kit

For use in locations where flash arrestor safety is required. Lockable fuel cap prevents tampering with fuel. Green cap color provides a visual reminder to use diesel when refueling.

Order K2340-1 for Vantage® 500 (Deutz®), Air Vantage® 500

WIRE FEEDER CAPABILITY



CV Adapter

Provides constant voltage output for semiautomatic wire welding. Includes 14-pin MS-Type connection and local/remote switch.

Order K385-2 for SAE-500



LN™-23P Interface Kit

Required for connecting LN™-23P to the K385-2 CV Adapter. Includes 50 ft. (15.2m) control cable.

Order K2379-1 for SAE-500



Wire Feed Module

Provides constant voltage (CV) output with improved arc stability for Innershield welding. Also excellent for MIG welding. Easy installation. The recommended wire feeder is the LN™-25 PRO.

Order K623-1 for Pipeliner® 200D, Classic® 300D

MISCELLANEOUS KITS



Control Panel Cover Kit

Clear Plexiglas cover to protect control panel from dirt and debris, and to visually monitor machine operation. Lockable to deter vandalism.

Order K2356-1 for Vantage® 500 (Deutz®), Air Vantage® 500



Air Dryer Kit

Minimizes water content in supply air. Avoids cold weather air hose ice up and water condensation in air tools during humid weather. Highly recommended for use with plasma cutter. Installs inside the machine for compact operation.

Order K2354-2 for Air Vantage® 500 (Kubota®)



Digital Weld Meters Kit

Easy-to-read digital meters for volts and amps. Easy to install.

Order K2467-1 for Vantage® 300. (K2409-1 and K2499-1)

Stainless Steel Sheet Metal Kit

Stainless steel roof and doors. Also includes decals (mounted), door latches, door hooks, bumpers and all required mounting hardware.

Order K2423-1 for Pipeliner® 200D, (K6090-9 thru -11), Classic® 300D (K1643-1 thru -10)



Polarity/Multi-Process Switch

For easy polarity switching. 6 and 14-pin remote connections can be made to this unit. For all Lincoln Chopper Technology® engine-driven welders. Mounts on roof with K2663-1 Docking Kit.

Order K2642-1 for Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



Docking Kit

Secures the K2642-1 Polarity/ Multi-Process Switch to the engine-driven welder roof. Release latch permits removal of K2642-1 Polarity/ Multi-Process Switch. Made from stainless steel for rust-free operation. For all Lincoln Chopper Technology® engine-driven welders.

Order K2663-1 for Ranger® 250, Ranger® 250 LPG, Ranger® 305 G, Ranger® 305 D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500.

UNDERCARRIAGES



Hand Moving Undercarriage

For moving by hand.

Order K882-2 for Power Arc® 5500, Weldonpower® 125



Undercarriage

Pneumatic tires for easy transport, fold down handles for easy storage when not needed, and convenient holders for wrapping welding output cables.

Order K2722-1 for Outback™ 185



Hand Moving Undercarriage

For moving by hand. Overall width 27" (0.7 m). Includes heavy-duty puncture-resistant tires.

Order K889-2 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 3 Phase



Hand Moving Undercarriage

Includes no-flat puncture proof tires. For moving by hand. Overall width 27" (0.7m).

Order K889-3 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 3 Phase



All-Terrain Undercarriage

For moving by hand at construction sites. Maneuvers over obstacles. Heavy-duty puncture-resistant tires.

Order K1737-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 305 G

Engine Drive, con't.

UNDERCARRIAGES, CON'T.

Factory Undercarriage

For moving by hand on smooth surface floors. Heavy-duty, puncture-resistant tires and front caster. Convenient steering handle.

Order K1770-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305G

Welding Gas Cylinder/LPG Tank Holder

Holds welding gas cylinder or LPG tank (for products with LPG engine). For LPG: Use first holder for LPG tank and second holder for welding gas cylinder. Both holders will attach to the K1770-1 Undercarriage.

Order K1745-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G

LPG Tank Strap

Mounts to K1745-1 gas cylinder holder to secure LPG tank.

Order K2361-1 for Ranger® 250 LPG

Cable Carrier Kit

Holds up to two 100 ft. (30m) lengths of #2/0 or smaller cable. Includes holder tray for electrodes or miscellaneous items. For use with K1737-1 or K1770-1 undercarriage.

Order K1739-1 for Ranger® 225 GXT, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305 G

Roll Cage

Improves damage protection and includes built-in cable rack. Attaches to K1737-1 or K1770-1 undercarriage. Can mount to K2635-1 trailer.

Order K1788-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 305G



Roll Cage

Improves damage protection and includes built-in cable rack. Attaches to K2635-1 trailer.

Order K1789-1 for Ranger® 305D

ROAD TRAILERS

Small Two Wheel Trailer

For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13" wheels. Stiff .120" welded rectangular steel tube frame construction is phosphate etched and powder coat painted for superior rust and corrosion resistance. Low sway suspension gives outstanding stability with manageable tongue weight. Wheels bearings packed with high viscosity, high pressure, low washout Lubriplate® grease. Includes a Duo-Hitch™ (2" Ball/Lunette Eye combination hitch). Overall width 60".

Order:
K2635-1 Trailer
K2639-1 Fender & Light Kit
K2640-1 Cable Rack for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 225 GXT, Ranger® 3 Phase, Ranger® 250 GXT, Ranger® 250, Ranger® 305G, Ranger® 305D



Medium Two Wheel Trailer

For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13" wheels. Stiff .120" welded rectangular steel tube frame construction is phosphate etched and powder coat painted for superior rust and corrosion resistance. Low sway suspension gives outstanding stability with manageable tongue weight. Wheels bearings packed with high viscosity, high pressure, low washout Lubriplate® grease. Includes a Duo-Hitch™ (2" Ball/Lunette Eye combination hitch). Overall width 60".

Order:
K2636-1 Trailer
K2639-1 Fender & Light Kit
K2640-1 Cable Rack for Pipeliner® 200D, Classic® 300D, Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



Large Two Wheel Trailer

For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 14" wheels. Stiff .120" welded rectangular steel tube frame construction is phosphate etched and powder coat painted for superior rust and corrosion resistance. Low sway suspension gives outstanding stability with manageable tongue weight. Wheels bearings packed with high viscosity, high pressure, low washout Lubriplate® grease. Includes a Duo-Hitch™ (2" Ball/Lunette Eye combination hitch). Overall width 60".

Order:
K2637-1 Trailer
K2639-1 Fender & Light Kit
K2640-1 Cable Rack for SAE 500, SAE 500 Severe Duty

Four-Wheeled Steerable Yard Trailer

For off-road, plant and yard use. Includes an automatically engaging drawbar lock when the drawbar is raised to the verticle position. 13" wheels. Wheel bearings are packed with high viscosity, high pressure, low washout Lubriplate® grease. Assembles directly to the base of the SAE-400 or SAE-400 Severe Duty welder. Also includes a Duo-Hitch™ – a 2" Ball/Lunette Eye combination hitch. Overall width: 55".

Order K2641-1 for SAE-500, SAE-500 Severe Duty



Four-Wheeled Steerable Yard Trailer

For off-road, plant and yard use. Includes an automatically engaging drawbar lock when the drawbar is raised to the verticle position. 13" wheels. Wheel bearings are packed with high viscosity, high pressure, low washout Lubriplate® grease. Stiff 3/16" welded rectangular steel frame construction is phosphate etched and powder-coat painted for superior rust and corrosion resistance. Also includes a Duo-Hitch™ – a 2" Ball/Lunette Eye combination hitch. Overall width: 55"

Order K2641-2 for Vantage® 300, Vantage® 400, Vantage® 500, Air Vantage® 500



Power Sources

UNDERCARRIAGES



Wheel Kit

Includes axle, two wheels, and assembly hardware. Can be installed in minutes.
Order K761 for AC-225, AC/DC-225/125



Understorage Cart

Adds easy shop mobility and provides shielding gas bottle platform, handy storage drawer and two filler rod holders.
Order K2348-1 for Precision TIG® 225



Dual Cylinder Kit

Permits side-by-side mounting of two full size gas cylinders, with easy loading. For use with K1764-1 cart and Power MIG® 215XT, Power MIG® 255XT, Power MIG® 350MP and Power Wave® 355M.
Order K1702-1



Undercarriage

For hand moving. Includes handle, axle, wheels, front bracket and mounting hardware.
Order K866 for Idealarc® 250



CARTS

Utility Cart

Heavy duty cart stores and transports welder, 150 cubic foot shielding gas cylinder, welding cables and accessories. Includes stable platforms for welder and gas bottle, lower tray for added storage capacity and adjustable height handle.
Order K520 for AC-225C, SP-140T, SP-180T, POWER MIG® 140C, Power MIG® 180C



Undercarriage

Platform undercarriage with mounting for two gas cylinders at rear of welder.
Order K841 for R3R-400, R3R-500, CV-400, DC-400
Order K842 for CV-655, DC-600, DC-655
Order K874 for CV-305



Dual Cylinder Platform Undercarriage

Platform undercarriage for mounting two gas cylinders at rear of welder
Order K1570-1 for Power Wave® 455M, Power Wave® 455M/STT®, Invertec® V450-PRO



Welding Cart

Lightweight cart stores and transports welder, 80 cubic foot shielding gas cylinder, welding cables and accessories. Includes an angled top shelf for easy access to controls, lower tray for added storage capacity, a sturdy fixed handle and convenient cable wrap hanger.
Order K2275-1 for Invertec® V160-S, Invertec® V160-T, Invertec® V205-T AC/DC, Invertec® V205-T DC, SP-140T, SP-180T, Power MIG® 140C, Power MIG® 180C, Pro-Cut® 25



Undercarriage

Includes a dual bottle rack with chain and front casters, rear wheels and a handle.
Order K1869-1 for Precision TIG® 275, Precision TIG® 375



CANVAS COVERS

Small Canvas Cover

Protect your machine when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent. Includes a convenient side pocket to hold welding torch or gun.
Order K2377-1 for SP-140T, SP-180T, Power MIG® 140C, Power MIG® 180C, Invertec® V160-T, Invertec® V205-T AC/DC, Invertec® V205-T DC



Under-Cooler Cart Water Cooler

Includes "cooler-in-a drawer" with hoses and a lockable storage drawer on a dual bottle undercarriage.
Order K1828-1 for Precision TIG® 275, Precision TIG® 375



Medium Canvas Cover

Protect your machine when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent.
Order K2378-1 for Power MIG® 215XT, Power MIG® 255XT, Power MIG® 350MP, Precision TIG® 185, Precision TIG® 225



Inverter and Wire Feeder Cart

Rear-wheeled cart includes front casters and no-lift gas bottle platform. Convenient handles allow for easy cable storage while full length side trays store parts and tools. Shipped fully assembled. Small footprint fits through 30 inch door.
Order K1764-1 for STT®-II, V350-PRO, Power Wave® 355M



Large Canvas Cover

Protect your machine when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent.
Order K886-1 for Ranger® 10,000 Plus, Ranger® 10,000, Ranger® 3 Phase
Order K886-2 for Ranger® 225 GXT, Ranger® 250 GXT, Ranger® 250, Ranger® 250 LPG, Ranger® 305G



Valet Style Undercarriage

Offers a unique pull-out handle. It provides cable storage and the ultimate in portability.
Order K1838-1 for V350-PRO, Multi-Weld™ 350, Power Wave® 355M, Pro-Cut® 55, Pro-Cut® 80

Power Sources

POWER SOURCE OPTIONS



Advanced Control Panel
Provides 2/4-step trigger with adjustable Pulser controls and Downslope timer for TIG welding. Also includes adjustable Hot Start and Arc Force internal panel controls for stick welding, and other user selectable features.

Order K2621-1 for Precision TIG® 275



Advanced Process Panel
Includes Pulsed MIG, Pulse-On-Pulse® and Power Mode® capabilities. Alpha-numeric display for accurate setting.

Order K1763-1 for V350-PRO Factory Model, V450-PRO



Air Filter Kit
Mounts on the front of the machine and uses cleanable, all metal air filters. Not compatible with dual process switch.

Order K1486-1 for CV-655 and DC-655



Digital Meter Kit
Accurately displays welding amps and volts.

Order K1482-1 for CV-655 and DC-655



Dual Process Switch
Mounts on front of machine and provides polarity change or electrical isolation. Great for arc gouging applications and where two separate feeders require different output polarity or inductance settings. Not compatible with air filter kit.

Order K1528-1 for CV-655 and DC-655



Multi-Process Switch
3-position switch allows quick and easy change from electrode positive or negative semiautomatic/automatic wire feed welding to stick or air carbon arc gouging.

Order K804-1 for DC-400, DC-600



Paralleling Kit
Permits paralleling of two power sources.

Order K1611-1 for DC-600 and DC-655

Order K1897-1 for DC-1000
Order K1900-1 for DC-1500



Power Factor Capacitor Kit
Used to reduce current draw and keep electricity costs to a minimum when machine is routinely operated at high outputs. Reduces input amps by approximately 20% at rated load.

Order K1894-1 for Idealarc® 250 (60 Hz models only)



Power Factor Capacitor Kit

Used to reduce current draw and keep electricity costs to a minimum when machine is routinely operated at high outputs.

Order K1831-1 for Precision TIG® 275



42 Volt Transformer Kit
Provides a way to use the LF-72, LF-74, LN™-742, LN™-10, DH-10 and Cobramatic® wire feeder on a DC-1000 that has 115V AC available on the terminal strip.

Order K1520-1 for DC-1000



DeviceNet™ Interface Module

This module provides networking capabilities for Output Control, Weld Settings, Weld Mode Selection and Data Logging.

Order K2206-1 for Power Wave® 455M, Power Wave® 455M/STT®



Ethernet/DeviceNet™ Interface Module

This module provides all DeviceNet functionality, networking capabilities for Weld Development, Data Logging, Systems Updates, Diagnostics, Weld Settings and Weld Mode Selection.

Order K2207-2 for Power Wave® 455M, Power Wave® 455M/STT®

MIG Wire Feeder/Welder

WELDING KITS

.035" Aluminum Welding Kit

Includes drive roll, non-metallic cable liner and contact tips (qty. 6) for feeding .035" (0.9 mm) aluminum MIG wire.

Also includes 1 lb. spool of SuperGlaze® 4043 aluminum MIG wire.

Order K664-2 for SP-135T, SP-175T

.035" Innershield® Welding Kit

Includes everything needed for Magnum® 100L gun and cable to use .035" (0.9 mm) diameter flux-cored wire.

Includes a contact tip, gasless nozzle, cable liner, and a 10 lb. (4.5 kg) spool of .035" (0.9 mm) Innershield® NR®-211-MP wire.

Order K549-1 for SP-135T, SP-175T

.045" Innershield® Welding Kit

Includes everything needed for Magnum® 100L gun and cable to use .045" (1.2 mm) diameter flux-cored wire.

Includes a .045" (1.2 mm) knurled drive roll, contact tip, gasless nozzle, cable liner, and a 10 lb. (4.5 kg) spool of .045" Innershield NR®-211-MP wire.

Order K549-2 for SP-175T

.045" Innershield® Welding Kit

Includes everything needed to weld with .045" (1.1 mm) Innershield® self-shielded flux-cored wire. Includes an .035"-.045" (0.9-1.1 mm) Magnum® 100L gun liner, a .045" (1.1 mm) contact tip, a gasless nozzle, knurled drive roll, .045" (1.1 mm) inner wire guide and 10 lb. (4.5 kg) spool of .045" (1.1 mm) Innershield® NR®-212 wire.

Order K2528-1 for Power MIG® 180C



3/64" Aluminum Feeding Kit

Conversion kit for welding with 3/64" (1.2mm) aluminum wire. Includes drive rolls, contact tips (qty. 2), non-metallic guides and cable liner.

Order K1703-1 for POWER MIG® 215, POWER MIG® 255C



3/64" Aluminum Feeding Kit

Conversion kit for welding with 3/64" (1.2 mm) aluminum wire. Includes drive rolls, contact tips (qty. 2), polished wire guides and cable liner.

Order K2153-1 for POWER MIG® 350MP

POWER MIG® SPOOL GUN SYSTEMS

POWER MIG® 255XT:



Magnum® SG Spool Gun

Lightweight, well-balanced, semiautomatic spool gun designed primarily for easy, accurate aluminum wire feeding.

Order K487-25



Magnum® SG Spool Gun Control Cable Adapter Plug

Allows K487-25 Magnum® spool gun's 6-pin control cable to plug into the POWER MIG® 255C's 7-pin spool gun control receptacle.

Order K2445-1

OR



Magnum® 250LX Spool Gun

300 amps, 60% duty cycle. Feeds .035-3/64" dia. aluminum wire on 2 lb. spools.

Order K2490-1

POWER MIG® 140C & 180C and SP-140T & SP-180T:



Magnum® 100SG Spool Gun

Designed to easily feed 4" (102 mm) diameter 1 lb. (0.45 kg) spools of .030" (0.8 mm) or .035" (0.9 mm) diameter SuperGlaze® aluminum MIG wire. Includes gun, adapter kit, .035" (0.9 mm) contact tips (qty. 3), gas nozzle, and a 1 lb. (0.45 kg) spool of SuperGlaze® 4043 .035" (0.9 mm) MIG wire. Packaged in a convenient carrying case.

Order K2532-1

POWER MIG® 215XT:

POWER MIG® 215XT Spool Gun Adapter

This kit is designed to allow the Magnum® SG or Magnum® 250LX spool gun to operate with the POWER MIG® 215XT. The kit includes the solenoid, gas lines, wiring harness and gun connection panel. The gun connection panel features a 6-pin MS-type connector for the Magnum® SG spool gun and a 7-pin MS-type connector for the Magnum® 250LX spool gun and a selector switch to choose which gun you are using.

Order K2703-1

(Note: The K2703-1 spool gun adapter disables the Magnum® 100SG capability.)

POWER MIG® 350MP:



Magnum® 250LX Spool Gun

300 amps, 60% duty cycle. Feeds .035-3/64" dia. aluminum wire on 2 lb. spools.

Order K2490-1



Spool Gun Holder

Provides neat storage of spool gun cable, and gas hose on power source.

Order K1738-1

POWER MIG® TIMER KIT

Timer Kit

Adds 4-step trigger interlock, spot mode, adjustable run-in speed for smoother arc starting, and adjustable burnback time to minimize wire sticking in puddle. Easy to install.

Order K1701-1 for POWER MIG® 255C



Spot Timer Kit

This timer allows you to set a fixed weld time of up to 10 seconds that is initiated when you pull the gun trigger. Ideal for making consistent spot welds on thin sheet metal.

Order K2525-1 for POWER MIG® 140C, POWER MIG® 180C



Wire Feeder

DUAL PROCEDURE KITS AND REMOTE PENDANTS



Dual Procedure/Memory Panel
User memories work by copying the weld procedure from one of the six memories into either the A or B procedure. Weld procedures are saved into the memory only when the operator chooses.
Order K2360-1 for Power Feed™ 10M



Dual Procedure Switch
Allows the use of two welding procedures with one Lincoln Magnum® gun. 15 ft. (4.5m).
Order K683-3 for LN™-10, DH-10, STT®-10, Power Feed™ 10M



STT® Remote Output Control
Remotely controls peak and background current. 10 pin remote control with 25 ft. (7.6m) of cable.
Order K942-1 for STT®-II



Foot Amptrol® Connector Kit
Provides 25 ft. (7.6m) of remote output control for TIG welding. (6 pin plug connection).
Order K2320-1 for Power Feed™ 10M



Dual Procedure Switch Kit
Easily mounts to gun using convenient velcro straps to allow welding operators to select between two preset welding procedures or modes. Plugs into the gun trigger connector on the wire feeder.
Order K2449-1 for POWER MIG® 350MP

GMA TIMER KITS, GAS SOLENOID AND BURN-BACK KITS

LF-72 and LF-74:



Postflow and Burnback Timer Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.
Order K2330-1 for LF-72, LF-74



Remote Voltage Control Kit
Allows arc voltage to be changed at the feeder.
Order K2329-1 for LF-72, LF-74

LN™-7, LN™-8, LN™-9, LN™-25 PRO, LN™-25 PRO Dual Power:



GMA Timer Kit
Provides delays for preflow and postflow gas, adjustable burnback, and a purge/cold inch switch.
Order K418 for LN™-7 GMA, LN™-9 GMA, LN™-9F GMA



Gas Solenoid Assembly
Includes solenoid valve and mounting bracket.
Order K494 for LN™-7



Gas Solenoid Kit
Includes solenoid valve and mounting bracket.
Order K425 for LN™-8, LN™-9



Burnback Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds. Includes a cold inch switch.
Order K419 for LN™-7, LN™-7 GMA, LN™-9 GMA
Order K202 for LN™-8, LN™-9



Preflow, Postflow and Burnback Timer Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.
Order K2330-2 for LN™-25 PRO, LN™-25 PRO Dual Power

REGULATORS AND WATER CONNECTION KITS



Deluxe Adjustable Gas Regulator & Hose Kit
Accommodates CO₂, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3m) gas hose.
Order K586-1



Harris® Argon Flowmeter Regulator
Deluxe flowmeter/regulator. Includes 10 ft. (3.0 m) hose.
Order 3100211



Water Connection Kit
Includes quick connect fittings on front and back of wire drive for use with water-cooled guns and coolers. Kit provides for one gun.
Order K590-6 for LN™-10, DH-10, Power Feed™ 10M, Power Feed™ 10M Dual, Power Feed™ 25M

Wire Feeder, con't.

CONTROL CABLES AND ADAPTERS

Description	Connection	Order No.
<i>Wire Feeder Control Cables</i>		
 Wire Feeder Control Cable	Male 6-pin to Female 14-pin	K1818-10 (for LN™-7)
Wire Feeder Control Cable	Female 8-pin to Male 14-Pin	K1819-10 (for LN™-742)
Wire Feeder Control Cable	Male 9-pin to Female 14-pin	K1820-10 (for LN™-8, LN™-9)
Wire Feeder Control Cable	Male 14-pin to Female 9-pin	K1501-10 (for LN™-10, DH-10)
Wire Feeder Control Cable	Male 14-pin to Female 8-pin	K2393-1, 25 ft. (for LN™-23P [K316L-2])
Wire Feeder Control Cable	Male 14-pin to Female 8-pin	K2393-2, 75 ft. (for LN™-23P [K316L-2])
<i>Extensions and Adapters</i>		
Wire Feeder Control Cable Extension (May require K1818-10, K1819-10, K1820-10 or K1501-10, depending on the feeder)	Male 14-pin to female 14-pin	K1797-10 for 10 ft. (3 m) K1797-25 for 25 ft. (7.6 m) K1797-50 for 50 ft. (15.2 m) K1797-100 for 100 ft. (30.4 m)
Adapter Cable for Control Cable to Terminal Strip of Power Source	Male 14-pin control cable to terminal strip	K1798
<i>ArcLink®/Linc-Net™ Control Cables</i>		
ArcLink®/Linc-Net™ Control Cables	For Power Wave®/Power Feed™ Systems	K1543-8 for 8 ft. (2.5 m) K1543-16 for 16 ft. (4.8 m) K1543-25 for 25 ft. (7.6 m) K1543-50 for 50 ft. (15.2 m) K1543-100 for 100 ft. (30.4 m)
Heavy Duty ArcLink®/Linc-Net™ Control Cables	For Cruiser™ Tractor and Power Wave® AC/DC 1000®	K2683-25 for 25 ft. (7.6 m) K2683-50 for 50 ft. (15.2 m) K2683-100 for 100 ft. (30.4 m)

CONTROL CABLES AND ADAPTERS

Remote Control Cable Adapter

Y connector adapter for connecting K857 Remote Output Control (6 pin plug connection) and wire feeder input cable (14-pin plug connection) to power source 14-pin receptacle.

Order K864 for CV-305, CV-400, CV-655, DC-400, DC-600, DC-655

Jumper Plug Kit

Required to close the contactor in the power source when the power source is used with a remote output contactor such as the contactor in across-the-arc wire feeders.

Order K484 for LN™-15, LN™-25 PRO, LN™-25 PRO Dual Power

Sense Lead Kit

Recommended for extended cable length. Application allows machine to sense voltage directly at the work piece for improved arc performance.

Order K940-25 for 25 ft. (7.6 m)

Order K940-75 for 75 ft. (23 m) for STT®-II, Power Wave® 355M, Power Wave® 455M/STT®

Universal Adapter Plug

The adapter plug allows user connection of any suitable accessory or wire feeder cable to the output contactor and auxiliary power circuitry of power source with 14-pin receptacle. Consists of a 14-pin MS-type (Amphenol) plug with 8" (203mm) stripped leads.

Order K867

ArcLink® "T" Connector Kit

For connecting multiple feeders to a single power source.

Order K2429-1

Adapter for Competitive Power Sources

Allows wire feeder to connect to select Miller Electric® power sources.

Order K2335-1 for LF-72, LF-74



Wire Feeder, con't.

WELD CABLES



Coaxial Weld Power Cables

Recommended for STT® and pulse welding when using long distances between feeder and power source.

- Order K1796-25**
25 ft. (7.6 m), 350 amps
- Order K1796-50**
50 ft. (15.2 m), 350 amps
- Order K1796-75**
75 ft. (22.8 m), 325 amps
- Order K1796-100**
100 ft. (30.4 m), 300 amps

Weld Power Cables

Connection	Description	Order No.
Twist-Mate™ to Lug	1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	Order K1840-10
Lug to Lug	3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)	Order K1842-10
	3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)	Order K1842-35
	3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)	Order K1842-60
	4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)	Order K1842-110
Twist-Mate™ to Twist-Mate™	1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	Order K1841-25
	2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	Order K1841-50

ADAPTERS AND PACKAGES



Twist-Mate™ to Lug Adapter

For connection of lugged cable to Twist-Mate™ connectors, 18" (457 mm) long.

- Order K2176-1** for V350-PRO, Power Wave® 355M



Work and Wire Feeder 2/0 Weld Cable Package

Includes Twist-Mate™ connectors, work clamp, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.

- Order K1803-1** for CV-305, V350-PRO, Power Wave® 355M



Work Lead Package

15 ft. (4.5 m) 4/0 cable with 1/2" (12.7 mm) stud lug and work clamp

- Order K2149-1**



Work Clamp and Cable Assembly

15 ft. 2/0 cable with 1/2" (12.7 mm) stud lug and work clamp.

- Order K2150-1**



Twist-Mate™ Cable Plug

For connecting welding cable to output terminal receptacles.

- Order K852-25** for #4-#6 cable (V155-S small Twist-Mate™).
- Order K852-50** for #1-#2 cable (V160-S).



Twist-Mate™ Cable Plug

For connecting welding cable to output terminal receptacles.

- Order K852-70** for 1/0-2/0 (50-70 mm²) cable
- Order K852-95** for 2/0-3/0 (70-95 mm²) cable.
- Order both** for V275-S, CV-305, STT®-II, V350-PRO, Power Wave® 355M



Twist-Mate™ Cable Receptacle

For connecting welding cable to Twist-Mate™ cable plug.

- Order K1759-70** for 1/0-2/0 (50-70 mm²) cable
- Order K1759-95** for 2/0-3/0 (70-95 mm²)

STANDS AND UNDERCARRIAGES



Heavy Duty Wire Reel Stand

For use with Lincoln® 10-60 lb. (4.5-27.2 kg) wire packages that use a 2" (51 mm) spindle. Hole in stand fits over lift bail.

- Order K1524-3** for LF-72, LF-74, LN™-7, LN™-8, LN™-9



Insulated Lift Bail

Allows the entire wire feeder to be hung from a crane or hook. Use with Heavy Duty Wire Reel Stand.

- Order K1555-1** for LF-72, LF-74, LN™-7, LN™-8, LN™-9, LN™-10, STT®-10, PF-10



Swivel Platform

Mounts to the lift bail on the power source and bottom of the Heavy Duty Wire Reel Stand. Wire feeder may be lifted off if needed.

Compatible with Light Duty



Caster Kit. Includes "lazy susan" parts tray.

- Order K1557-1** for LF-72, LF-74, LN™-7, LN™-8, LN™-9, LN™-10, STT®-10, PF-10

Caster Kit – Light Duty

Mounts to the Heavy Duty Wire Reel Stand. Allows for easy movement of wire feeder.

- Order K1556-1** for LF-72, LF-74, LN™-7, LN™-8, LN™-9, LN™-10, STT®-10, PF-10



Standard Duty Wire Reel Stand

For use with Lincoln 10-44 lb. (4.5-20 kg) wire packages that use a 2" (51 mm) spindle. Standard on K2327-2 LF-72 wire feeder.

- Order K2328-1** for LF-72, LF-74



Lift Bail Kit

Allows the entire wire feeder to be hung from a crane or hook. Use with Standard Duty Wire Reel Stand.

- Order K2331-1** for LF-72, LF-74



Lightweight Swivel Kit

Allows wire feeder to freely turn. For use with Standard Duty Wire Reel Stand.

- Order K2332-1** for LF-72, LF-74



Undercarriage

Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stand.

- Order K163** for LF-72, LF-74, LN™-7, LN™-8, LN™-9

Wire Feeder, con't.

WIRE ADAPTERS, COVERS AND STRAIGHTENERS



8" O.D. Spool Adapter
Permits 8" (200 mm) O.D. spools to be mounted on 2" (51 mm) O.D. spindles.
Order K468



Wire Straightener
Straightens wire for better, smoother feeding.
Order K1733-1 for LN™-10, DH-10, Power Feed™ 10M, Power Feed™ 10R



Portable Digital Wire Feed Speed Meter
When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute.
Order K283



Micro Wire Straightener
Straightens .035"-1/16" (0.9-1.6 mm) wire for use with portable feeders.
Order K1733-4 for Power Feed™ 25M and LN™-25 PRO



Accu-Trak® Drum Payoff Kit
A Payoff Kit must be used with Accu-Trak® Drums to ensure precise feeding. The fitting on the top of the Payoff Kit has a 1/2-14 NPT internal pipe thread to facilitate the connection of the conduit.
Order K884-5 for 500 lb. Accu-Trak® Drum
Order K884-6 for 250 lb. and 1,000 lb. Accu-Trak® Drums



Spindle Adapter for Readi-Reels® and Spools
2" (51 mm) O.D. spindle for mounting Readi-Reels® and 2" (51 mm) I.D. spools up to 60 lb. (27.2 kg) capacity to custom installations.
Order K162-1



14 lb. Innershield® Coil Adapter
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2" (51 mm) O.D. spindles.
Order K435



22-30 lb. Readi-Reel® Adapter
Adapts 22-30 lb. (10-14 kg) Lincoln Readi-Reels® of electrode to 2" (51 mm) spindle.
Order K363P



50-60 lb. Readi-Reel® Adapter
Adapts 60 lb. (27.2 kg) coils of Lincoln® electrode to 2" (51 mm) spindle.
Order K438



Incoming Bushings for Lincoln® Conduit
Connects directly to Lincoln plastic conduit (not included), for use in boom systems, long distances, or large payoff packages.
Order K1546-1 for .025-1/16"
Order K1546-2 for 1/16-1/8"



Accu-Pak® Box Payoff Kit
A Payoff Kit is necessary for our 100% recyclable Accu-Pak® Box to ensure precise feeding. The fitting on the top of the Payoff Kit has a 1/2-14 NPT internal pipe thread to facilitate the connection of the conduit.
Order K2175-1 for 500 lb. Accu-Pak® Box
Order K2175-2 for 1,000 lb. Accu-Pak® Box



50-60 lb. Coil Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln® electrode to 2" (51 mm) spindle.
Order K1504-1



Plastic Wire Cover
Plastic enclosure for 30-44 lbs. (13.6-19.9 kg) wire packages.
Order K1634-1



Shown: Aluminum Case for Power Feed™ 25M

Portable Feeder Case
Replace a damaged case without replacing the entire unit.
Order K2596-1 Aluminum, for Power Feed™ 25M (shown), LN™-25 PRO, LN™-25 PRO Dual Power



Plastic Wire Cover Kit
Plastic enclosure for up to 60 lb. (27.2 kg) wire packages.
Order K1634-2



Shown: Polycarbonate Case for LN™-25 PRO

Order K2596-2 Polycarbonate, for Power Feed™ 25M, LN™-25 PRO (shown), LN™-25 PRO Dual Power

Wire Feeder, con't.

DRIVE ROLL AND GUIDE TUBE KITS



**2-Roll
Wire
Drive
Systems**

**Power MIG® 215XT, 255XT, 350MP, LN™-15,
Power Feed™ 25M, LF-72, LN™-25 PRO, LN™-25
PRO Dual Power**

Description	Product Number
Solid Wire (includes stainless steel)	
.023-.030" (0.6-0.8mm)	KP1696-030S
.035" (0.9mm) solid	KP1696-035S
.035", .045" (0.9, 1.2mm)	KP1696-1 ⁽¹⁾
.040" (1.0mm)	KP1696-2 ⁽¹⁾
.045" (1.2mm)	KP1696-045S
.052" (1.4mm)	KP1696-052S
1/16" (1.6 mm)	KP1696-1/16S ⁽¹⁾
Cored Wire	
.030-.035" (0.8-0.9mm)	KP1697-035C
.040-.045" (1.0-1.2mm)	KP1697-045C
.052" (1.4mm)	KP1697-052C
1/16" (1.6mm)	KP1697-1/16C
.068-.072" (1.7-1.8mm)	KP1697-068
5/64" (2.0mm)	KP1697-5/64
3/32" (2.4mm)	KP1505-3/32 ⁽²⁾
Aluminum Wire	
.035" (0.9mm)	KP1695-035A
.040" (1.0mm)	KP1695-040A
3/64" (1.2mm)	KP1695-3/64A
1/16" (1.6mm)	KP1695-1/16A ⁽¹⁾



**4-Roll
Wire
Drive
Systems**

**LF-74, LN™-10, DH-10, Power Feed™ 10M,
Power Feed™ 10M Dual**

Description	Product Number
Solid Wire, Smooth V Groove	
.023-.030" (0.6-0.8mm)	KP1505-030S
.035" (0.9mm)	KP1505-035S
.040-.045" (1.0-1.2mm)	KP1505-045S
.052" (1.4mm)	KP1505-052S
1/16" (1.6mm)	KP1505-1/16S
Cored Steel Wire, Knurled V Groove	
.030-.035" (0.8-0.9mm)	KP1505-035C
.040-.045" (1.0-1.2mm)	KP1505-045C
.052" (1.4mm)	KP1505-052C
1/16" (1.6mm)	KP1505-1/16C
7/64" Hardfacing	KP1505-7/64H ⁽²⁾
(Knurled V Groove with matching Smooth U Groove)	
Cored or Solid Steel Wire, Knurled V Groove	
.068-.072" (1.8mm)	KP1505-068
5/64" (2.0mm)	KP1505-5/64
3/32" (2.4mm)	KP1505-3/32
7/64" (2.8mm)	KP1505-7/64 ⁽³⁾
.120" (3.2mm)	KP1505-120 ⁽³⁾
Aluminum Wire, Smooth U Groove	
.035" (0.9mm)	KP1507-035A
.040" (1.0mm)	KP1507-040A
3/64" (1.2mm)	KP1507-3/64A
1/16" (1.6mm)	KP1507-1/16A
3/32" (2.4mm)	KP1507-3/32A ⁽³⁾

⁽¹⁾ Not for use with the LN™-15.

⁽²⁾ Not for use with the LN™-15 or LF-72.

⁽³⁾ Not for use with the LF-74.

DRIVE ROLL AND WIRE GUIDE KITS



**2-Roll
Wire
Drive
Systems**

LN™-7 GMA, LN™-23P, LN™-25, LN™-35

Description	Product Number
Solid Wire	
.023"-.025" (0.6-0.9 mm)	KP653-025S
.030" (.8 mm)	KP653-030S
.035"-.040" (0.9-1.0 mm)	KP653-035S
.045"-.052" (1.2-1.4 mm)	KP653-052S
Cored Wire	
.035" (0.9 mm)	KP653-035C
.045"-.052" (1.2-1.4 mm)	KP653-052C
Solid or Cored Wire	
1/16" (1.6mm)	KP653-1/16
.068"-3/32" (1.7-2.4 mm)	KP653-3/32 ⁽²⁾
Hardfacing	
7/64" (2.8 mm)	KP653-7/64H ⁽¹⁾
LN™-8, LN™-9	
Solid Wire	
.030"-.035" (0.8-0.9 mm)	KP502-035
.040", .045"-.052" (1.0-1.4 mm)	KP502-052
1/16" (1.6 mm)	KP502-1/16
Cored Wire	
.045"-.052" (1.0-1.4 mm)	KP502-052C
1/16"-.062" (1.6 mm)	KP502-1/16C
7/64"-.120" (2.8-3.0 mm)	KP502-120
Solid or Cored Wire	
.068"-3/32" (1.7-2.4 mm)	KP502-3/32
Hardfacing	
7/64" (2.8 mm)	KP502-7/64H

⁽¹⁾ Not for use with the LN™-25 PRO and LN™-25 PRO Dual Power

⁽²⁾ For LN™-7 only.



**2-Roll
Wire
Drive
Systems**

**Cruiser™ Tractor, NA-3, NA-4, NA-5, Power
Feed™ 10A Controller**

Description	Product Number
Solid Wire	
3/32"-7/32"	KP1889-1
1/16" 5/64" 3/32"	KP1889-2
.035" .045" .052"	KP1889-3
Cored Wire	
.045"-.052"	KP1889-4
Knurled Wire	
3/32"-7/32"	KP1885-1
1/16"-3/32"	KP1886-1
.045"-.052"	KP1892-1
Smooth Wire	
3/32"-7/32"	KP1887-1
Outgoing	
3/32"-7/32"	KP1963-1
.052"	KP2097-1
3/32"	KP2097-2
Incoming	
.035"-.052"	KP1967-1
1/16"-3/32"	KP2116-1
3/32"-7/32"	KP2116-2

WELDING GUNS

MAGNUM®



Don't Be Undergunned!
Magnum® Guns Increase Your:

- Productivity
- Ease-Of-Use
- Peace-Of-Mind

	MODEL	OUTPUT			PROCESS				FEATURES				
		Current Range (Amps)	Duty Cycle	Wire Diameter Range in. (mm)	MIG	Aluminum MIG	Flux-Cored, Gas-Shielded	Flux-Cored, Self-Shielded	Submerged Arc	Dual Schedule	Dual Procedure	Water-Cooled	Fume Extraction
Gas-Shielded	Magnum® 100 Amp Gun	100	60%	.025-.045 (0.6-1.2)	●		●						
	Magnum® 200 Amp Gun	200	60%	.025-.045 (0.6-1.2)	●		●						
	Magnum® 250 Amp Gun	250	60%	.025-.045 (0.6-1.2)	●		●						
	Magnum® 300 Amp Gun	300	60%	.035-.045 (0.9-1.2)	●		●						
	Magnum® 400 Amp Gun	400	60%	.035-5/64 (0.9-2.0)	●		●			●	●		
	Magnum® 550 Amp Gun	550	60%	.035-1/8 (1.3-3.2)	●		●						
	Magnum® 450 Amp Gun	450	100%	.035-5/64 (0.9-2.0)	●		●					●	
	Magnum® Pro 250 Gun	250	100%	.025-.045 (0.6-1.2)	●		●			●	●		
	Magnum® Pro 350 Gun	350	100%	.035-5/64 (1.3-2.0)	●		●			●	●		
	Magnum® Pro 450 Gun	450	100%	.035-3/32 (1.3-2.4)	●		●			●	●		
	Magnum® Pro 550 Gun	550	100%	.052-1/8 (1.3-3.2)	●		●			●	●		
Self-Shielded	250 Amp Gun	250	60%	.062-3/32 (1.6-2.4)				●					
	350 Amp Gun	350	60%	.062-3/32 (1.6-2.4)				●					
	450 Amp Gun	450	60%	3/32-.120 (2.4-3.0)				●					
	600 Amp Gun	600	60%	7/64-.120 (2.8-3.0)				●					
Spool Guns	Magnum® 250LX Spool Gun	300	60%	.023-3/64 (0.6-1.2)	●	●							
	Magnum® SG Spool Gun	250	60%	.023-3/64 (0.6-1.2)	●	●							
	Magnum® 100SG Spool Gun	130	30%	.030-.035 (0.8-0.9)		●							
Sub Arc	600 Amp Gun	600	60%	5/64-3/32 (2.0-2.4)				●					
Fume Extraction	Magnum® 250 Amp Gun	250	60%	.035-.045 (0.9-1.2)	●		●					●	
	Magnum® 340 Amp Gun	340	60%	.035-.045 (0.9-1.2)	●		●					●	
	Magnum® Pro 350XA Gun	350	100%	.035-3/32 (0.9-2.4)	●		●			●	●	●	
	Magnum® Pro 550XA Gun	550	100%	.052-1/8 (1.3-3.2)	●		●			●	●	●	

KEY: ● Excellent ● Good ● Optional

Welding Guns

Magnum® Guns

MIG and Gas-Shielded Cored Wire Guns

Magnum® MIG and gas-shielded cored wire guns are engineered with the welder in mind. The handle grip design provides balance, reduces operator fatigue and offers a sure, confident grip. Magnum® gas-shielded welding guns have outstanding construction including a proprietary wound liner, a durable abrasion-resistant gun cable outer jacket and a gooseneck that's three-layer insulated. Gun nozzles, contact tips, gas diffusers and nozzle insulators are manufactured to tight tolerances and deliver consistent arc performance, improved electrical conductivity and wire feedability.

For more information on Magnum® MIG (GMAW) and gas-shielded cored welding guns, request publication E12.10.

Magnum® 100L (100 amps, 60% duty cycle, CO₂ shielding gas. Includes Gun Connector.)

Gun Type	Cable Length ft. (m)	Wire Diameter .025"-.030" (0.6-0.9 mm)	Wire Diameter .035"-.045" (0.9-1.2 mm)
Standard	10 (3.0)	K530-5 K530-6 ⁽¹⁾	K530-3 (FCAW-SS only)

Magnum® 200 (200 amps, 60% duty cycle, CO₂ shielding gas.)

Gun Type	Cable Length ft. (m)	Wire Diameter .025"-.030" (0.6-0.8 mm)			Wire Diameter .035"-.045" (0.9-1.2 mm)		
		Gun Connector			Gun Connector		
		Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package
Standard	10 (3.0)	—	—	—	—	K498-2	—
	12 (3.6)	—	—	—	K497-6	K498-6	—
	15 (4.5)	K497-3	—	—	K497-1	K498-1	K497-21 ⁽³⁾

Magnum® 250L (250 amps, 60% duty cycle, CO₂ shielding gas. Includes Gun Connector.)

Gun Type	Cable Length ft. (m)	Wire Diameter .035"-.045" (0.9-1.2 mm)
Standard	12 (3.6)	K533-7 (Fixed Gas Nozzle)
	15 (4.5)	K533-3 (Adjustable Gas Nozzle)

Magnum® 250SP (250 amps, 60% duty cycle, CO₂ shielding gas. Includes Gun Connector.)

Gun Type	Cable Length ft. (m)	Wire Diameter .035"-.045" (0.9-1.2 mm)
Standard	12.5 (3.8)	K524-5 (Fixed Gas Nozzle)

Magnum® 300 (300 amps, 60% duty cycle, CO₂ shielding gas.)

Gun Type	Cable Length ft. (m)	Wire Diameter .035"-.045" (0.9-1.2 mm)			Wire Diameter .052"-1/16" (1.3-1.6 mm)		Wire Diameter 1/16"-5/64" (1.6-2.0 mm)
		Gun Connector			Gun Connector		Gun Connector
		Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Open-End
Standard	10 (3.0)	K470-1	K478-1	—	—	K478-3	—
	12 (3.6)	—	—	—	—	—	—
	15 (4.5)	K470-2	K478-2	K1802-1 ⁽²⁾	K470-4	—	K470-6

Magnum® 400 (400 amps, 60% duty cycle, CO₂ shielding gas.)

Gun Type	Cable Length ft. (m)	Wire Diameter .035"-.045" (0.9-1.2 mm)			Wire Diameter .052"-1/16" (1.3-1.6 mm)			Wire Diameter 1/16"-5/64" (1.6-2.0 mm)		
		Gun Connector			Gun Connector			Gun Connector		
		Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package
Standard	10 (3.0)	K471-1	—	—	—	—	—	—	—	—
	12 (3.6)	K471-7	K479-7	—	K471-8	—	—	—	—	—
	15 (4.5)	K471-2	K479-2	K2286-1 ⁽²⁾ K471-21 ⁽³⁾	K471-4	K479-4	K471-22 ⁽³⁾	K471-6	K479-6	K471-23 ⁽³⁾
	20 (6.1)	K471-10	—	—	K471-11	—	—	—	—	—
	25 (7.6)	K471-13	—	—	K471-14	—	—	K471-15	—	—
Dual Schedule	15 (4.5)	K574-1	K575-1	—	K574-2	K575-2	—	—	—	—
	25 (7.6)	K574-4	—	—	—	—	—	—	—	—
Dual Procedure	10 (3.0)	—	K1723-1	—	—	—	—	—	—	—
	15 (4.5)	K1722-2	K1723-2	—	—	—	—	—	—	—
	25 (7.6)	K1722-3	—	—	—	—	—	—	—	—
Short Neck	10 (3.0)	K541-1	—	—	—	—	—	—	—	—
	15 (4.5)	K541-3	—	K541-23 ⁽²⁾	—	—	—	—	—	—



Magnum® 100L Gun



Magnum® 200 Gun



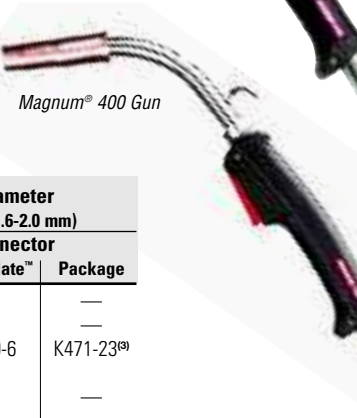
Magnum® 250L Gun



Magnum® 250SP Gun



Magnum® 300 Gun



Magnum® 400 Gun

- (1) Includes 4-pin MS-Type connection for trigger control
- (2) Includes K466-1 Connector Kit
- (3) Includes K466-10 Connector Kit

Welding Guns, con't.

Magnum® Guns

MIG and Gas-Shielded Cored Wire Guns, con't.



Magnum® 550 Gun

Magnum® 550 (550 amps, 60% duty cycle, CO₂ shielding gas.)

Gun Type	Cable Length ft. (m)	Wire Diameter	Wire Diameter		Wire Diameter	
		.035"-.045" (0.9-1.2 mm)	.052"-1/16" (1.3-1.6 mm)		5/64"-3/32 (2.0-2.4 mm)	
		Gun Connector	Gun Connector		Gun Connector	
		600A Open-End	600A Open-End	500A Open-End	600A Open-End	500A Open-End
Standard	10 (3.0)	—	K598-5	—	—	—
	12 (3.6)	—	K598-6	—	—	—
	15 (4.5)	—	K598-7	K598-16	K598-11	K598-17
	25 (7.6)	K598-4	—	—	—	—

Magnum® 450 Water-Cooled (450 amps, 100% duty cycle, CO₂ shielding gas.)

Gun Type	Cable Length ft. (m)	Wire Diameter .035"-.045" (0.9-1.2 mm)	Wire Diameter .052"-1/16" (1.3-1.6 mm)	Wire Diameter 1/16"-5/64" (1.6-2.0 mm)	Wire Diameter .035"-3/64" (0.9-1.2 mm)	Wire Diameter 1/16" (1.6 mm)
Standard	10 (3.0)	—	—	—	K684-17	K684-18 ⁽¹⁾
	15 (4.5)	K684-12	K684-14	K684-16	—	—

(1) Made to order.

Lincoln Adapters (for MIG and Gas-Shielded Cored Wire Guns)

Brand	Model	Order Number
Magnum® 200, 300 & 400 Guns		
Lincoln Electric	LN™-7 Series, LN™-25	K466-1
	LN™-8, LN™-9 (using smaller than 1/16" wire)	
	LN™-35	
	Wire-Matic Power MIG	K466-6
	LN™-8, LN™-9	K466-8
Lincoln Electric/ Tweco® Adapted	Small wire feed welders (e.g. SP-100T, SP-125 Plus)	K466-9
	Power Feed™ 10, LN™-10, LN™-15, LN™-72, LF-4, DH-10 & STT-10	K466-10

Magnum® 550 Gun

Lincoln Electric	LN™-7 Series, LN™-25 PRO, LN™-8, LN™-9 using smaller than 1/16" wire	K613-1
	LN™-8, LN™-9 Series (1/16" & larger wires)	K613-6
	10 Series Feeders	K613-7

Lincoln Electric Adapters (for 450WC Gun)

Brand	Model	Order Number
Magnum® 450WC Gun		
Lincoln	LN™-7, LN™-8, & LN™-9 Series	K489-1
	LN™-9 with K319 Dual Procedure Kit	K573-1
	LN™-25 PRO	K489-2
	Power Feed™ 10, 10 Series Feeder & LN™-15	K489-7
Tweco Adapted	Wire-Matic, Power MIG® Small wire feed	K489-8
	No. 2, No.3, or No. 4 Guns	K489-4

Self-Shielded Cored Wire Guns

Durable and reliable, Lincoln Electric semiautomatic flux-cored gun and cable assemblies have been proven tough in the field. These lightweight and maneuverable gun and cable assemblies are designed for welding with self-shielded, flux-cored arc welding (FCAW-S) continuous feed wires. Request publication E12.110.

Self-Shielded Cored Wire Guns

Gun Type	Amperage	Diameter in. (mm)	Length ft. (m)	Angle	Order Number
K126	350	.062-3/32 (1.6-2.4)	10 (3.0)	62°	K126-1
				62°	K126-2
K345	350	.068-5/64 (1.7-2.0)	10 (3.0)	62°	K345-10
K115	450	3/32 (2.4)	10 (3.0)	45°	K115-10
				82°	K115-3
				82°	K115-4
				82°	K115-1
				45°	K115-8
				82°	K115-2
K116	600	7/64 (2.8)	15 (4.5)	Straight	K116-2



K126 Gun

Lincoln Electric Adapters (for Self-Shielded Cored Wire Guns)

Model	Order Number
Feed Plate Gun Bushing	
10 Series, 15 Series & LF-72, LF-74	K1500-1

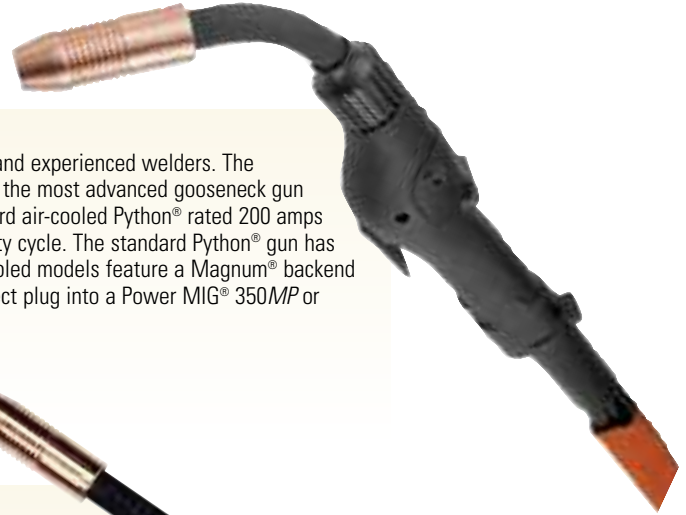
Welding Guns, con't.

Push-Pull Guns

Python® and Python®-Plus Push-Pull Guns

Hold the Python® in your hand and you'll know why this is a favorite among new and experienced welders. The ergonomic handle design, fingertip controls and foolproof set-up make the Python the most advanced gooseneck gun on the market. The Python® family offers several options, starting with the standard air-cooled Python® rated 200 amps at 100% duty cycle. The water-cooled version has a rating of 400 amps, 100% duty cycle. The standard Python® gun has a separate wire and conduit, power and gas connections. The Python®-Plus air-cooled models feature a Magnum® backend that integrates power, gas, and wire conduit into a single easy connection for direct plug into a Power MIG® 350MP or Power Feed™ 10M.

Request publication E12.13



Prince® XL Push-Pull Gun

The Prince® XL is one of the smallest, lightest pistol grip push-pull guns you can buy. It's a favorite among experienced welders who appreciate the versatility of the Prince® XL system. Choose the standard straight barrel or optional curved barrel with ratings up to 200 amps 100% duty cycle. The patented EZ-Lock system makes rotating or changing the barrel an easy no-tool "twist of the wrist." An ingenious 3-3/4 turn potentiometer is easily adjustable and conveniently hidden in the base of the handle for added protection. No matter what the situation demands, the Prince® XL delivers.

Request publication E12.11



PUSH-PULL GUN ACCESSORIES



Push-Pull Gun Connection Kit

For push-pull guns. Includes push-pull gun receiver bushing, fittings, modified gas-bypass valve, valve removal tool and control cable extension assembly.

Order K2339-1
for Power Feed™ 10M,
Power Feed™ 25M



Push-Pull Gun Connection Kit

Required for aluminum welding with the Prince® XL, Python® and CobraMax™ air or water-cooled push-pull guns. Includes power block, gun bushing, gas hose adapter, gun gas bypass valve (required for Prince® XL gun only), and wire reel brake limiter. Requires aluminum drive roll kit.

Order K2154-1
for Power MIG® 350MP, Prince® XL,
Python® (non Plus version).

Push-Pull Guns

Model	Diameter in. (mm)	Description	Length ft. (m)	Product Number	Machine	Adapter
Python®	.030-1/16 (0.8-1.6)	Air-Cooled	25 (7.6)	K2211-2	Power Feed™ 10M, Power Feed™ 25M, Power MIG® 350MP, Cobramatic®	K2339-1
		Water-Cooled	50 (15.2)	K2211-3		K2339-1
			25 (7.6)	K2212-2		K2154-1
Python®-Plus	.030-1/16 (0.8-1.6)	Air-Cooled	15 (4.5)	K2447-1	Power Feed™ 10M, Power Feed™ 25M, Power MIG® 350MP,	None
			25 (7.6)	K2447-2		None
			50 (15.2)	K2447-3		None
Prince® XL	.030-1/16 (0.8-1.6)	Air-Cooled	25 (7.6)	K2296-2	Power Feed™ 10M, Power Feed™ 25M, Power MIG® 350MP, Cobramatic®	K2339-1 K2339-1 K2154-1 None

NOTE: Prince® XL, Python® and Python®-Plus are registered trademarks of MK Products, Inc.

Welding Guns, con't.

Spool Guns

Magnum® 100SG Spool Gun

The Magnum® 100SG spool gun is the lowest cost way to add reliable and precise spool gun wire feeding performance for soft aluminum wire. It's easy to set up, does not require a bulky outboard adapter/power module and shares gun expendable parts with the standard MIG gun included with the Power MIG® models.

Request publication E12.21

Magnum® SG Spool Gun

The Magnum® SG – a lightweight, well balanced semiautomatic spool gun designed for easy and reliable aluminum wire feeding with a variety of CV power sources and engine-driven welders. Rated 250 amps @ 60%, the Magnum® SG features a generous 25 ft (7.5 m) gun cable and integrated wire feed speed control in the handle to cut your trips back to the power source.

Easy to set up, operate and maintain...the Magnum® SG is a great addition to your welding tool set.

Request publication E12.22

Magnum® 250LX™ Spool Gun

The Magnum® 250LX™ spool gun is a professional grade solution for feeding small spools of aluminum and steel wire. Featuring a 1-year warranty and a 280A 60% duty cycle rating, the Magnum® 250LX™ is a combination of durability and performance. The gun is well balanced and lightweight, and the unique oval shaped handle with finger ribs ensures both comfort and a sure grip. The Magnum® 250LX™ is an ideal complement to the Power MIG® 350MP and the Power MIG® 255XT.

Request publication E12.25



MAGNUM® SG SPOOL GUN ACCESSORIES



SG Control Module

Provides control of wire speed and gas flow. For use with CV power sources and CV Engine Drives with output contactor.

Order K488



Control Module Input Cable

Terminal Strip and Lug. Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® power sources having terminal strip and lug connections.

Order K492-10



Control Module Input Cable

14-pin MS-type & Lug. Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® engine driven power sources with 14-pin MS-type connection, separate 115V NEMA receptacles and lug power connections.

Order K691-10



Control Module Input Cable

14-pin MS-type and Twist-Mate™. Required for connection of control module to power source. Consists of control and electrode cables and gas line. 10 ft. (3.0 m). For Lincoln® power sources having 14-pin MS-type control connections and Twist-Mate™ power connections.

Order K493-10

Spool Guns

Model	Diameter in. (mm)	Description	Length ft. (m)	Product Number	Machine	Adapter
Magnum® 100SG	.030-.035 (0.8-0.9)	130A/30%	10 (3.0)	K2532-1	Power MIG® 215XT Power MIG® 180C Power MIG® 140C SP-180T, SP-140T	None
Magnum® SG	.025-3/64 (0.6-1.2)	250A/60%	25 (7.5)	K487-25	Power MIG® 215XT	K2703-1
Magnum® 250 LX™	.025-3/64 (0.6-1.2)	CO ₂ : 300A/60% Ar: 280A/60% Ar: 200A/100%	25 (7.5)	K2490-1	Power MIG® 350MP Power MIG® 255XT Power MIG® 215XT	None None K2703-1

Welding Guns, con't.

Fume Extraction & Submerged Arc Guns

FUME EXTRACTION GUNS



Magnum® Pro 350XA
350 amp capacity at 100% duty cycle (CO₂). Delivers superior fume extraction performance in severe GMAW and FCAW-GS applications.
Order K2649-1



Magnum® Pro 550XA
Rated 550 amps at 100% duty cycle (CO₂ shielding). Toughest smoke gun in the business for GMAW and FCAW-GS applications.
Order K2650-1



Magnum® 250FG
Lightweight and balanced Fume Extraction Gun for GMAW and FCAW-GS welding .035"-.045" wire. 250 amps at 60% duty cycle (CO₂) with a 45° Gooseneck. Includes a 15 ft. cable.
Order:
K2797-1 for Tweco® Adapter
K2797-2 for Power MIG®/ Lincoln style
K2797-4 for Miller® Feeders



Magnum® 340FG
Lightweight and balanced Fume Extraction Gun for GMAW and FCAW-GS welding .035"-.045" (0.9-1.1 mm) wire. 340 amps at 60% duty cycle (CO₂) with 45° Gooseneck. Includes a 15 ft. cable.
Order:
K2798-1 for Tweco® Adapter
K2798-2 for Power MIG®/ Lincoln old style
K2798-4 for Miller® Feeders



Order K206 500A Gun
For Innershield® or Lincore®. Rated 500 amps at 60% duty cycle. Use 5/64"-.120" (2.0-3.0 mm) diameter wires. select either 45° or 82° gun tube angle. Includes 15 ft. cable.
Order K289-1 for 82° angle
Order K289-4 for 45° angle



250A Gun
For Innershield® or Lincore®. Rated 250 amps at 60% duty cycle. Use .068"-3/32" (1.7-2.4 mm) diameter wires. 62° gun tube angle. Includes 15 ft. cable.
Order K309



350A Gun
For Innershield® or Lincore®. Rated 350 amps at 60% duty cycle. Use .062"-3/32" (1.6-2.4 mm) diameter wires. 62° gun tube angle. Includes 15 ft. cable.

FUME EXTRACTION ACCESSORIES



Magnum® Pro Spoiler™
This innovative attachment relieves hand fatigue by allowing a looser grip on the gun. Works with all Magnum® Pro models.
Order K2710-1

(See page 92, Environmental Section, for other Fume Extraction attachments and accessories)

SUBMERGED ARC GUNS



Submerged Arc Gun
Rated 600 amps, 15 ft. (4.5 m) cable.
Order K113-1 for 5/64" (2.0 mm)
Order K113-2 for 3/32" (2.4 mm)



Mechanized SAW Gun
Rated 600 amps, for 5/64 and 3/32" (2.0 and 2.4 mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit or Squirtmobile®.
Order K114

SUBMERGED ARC ACCESSORIES



Flux Cone
Fits K112 and K113 submerged arc guns for welding without the Continuous Flux Feed Tank Assembly.
Order K119



Magnetic Flux Screen Separator
For submerged arc welding. Removes foreign magnetic particles from reused flux.
Order K58



Wire Reel and Flux Tank Assembly
Includes flux tank, undercarriage, wire reel and brake assembly in open shroud.
Order K305

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