

POWER FEED® 25M

Advanced Wire Feeder



Advanced Process Control

This compact portable wire feeder comes packed with advanced capabilities and is built for both field and shop environments. Featuring our MAXTRAC® drive system, full controls and procedural memory presets, the Power Feed® 25M is ready for advanced process welding on almost any application.

- Comprehensive Control - Dual Procedure allows you to set an A and B procedure to simplify 'on-the-fly' switching. Memory presets allow the operator to easily recall up to 8 memories and specify the range of operation for the application.
- Push-Pull Functionality - Delivers Premium aluminum performance by offering uniform feeding, as well as the ability to extend gun to feeder distance
- Rugged, Portable Design - Compact case design ideal for tight, harsh environments.

Processes »

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

Output »



Input »



Applications »

Metal Fabrication
Construction
Shipbuilding

Product Number »

K2536-4 Red Aluminum Case
K2536-5 Plastic Case

FEATURES

- » **Internal Lighting** - Illuminates the wire drive to aid operators working in dark environments
- » **Internal Heating** - Maintains control of humidity by keeping consumables warm and protected within the enclosed case
- » **Advanced Process Control** – Easily access and control advanced weld process parameters and optimize arc characteristics
- » **ArcLink® Communication** – Industry-leading system communication for faster arc start detection time. Plug and play simplicity - no external hardware required

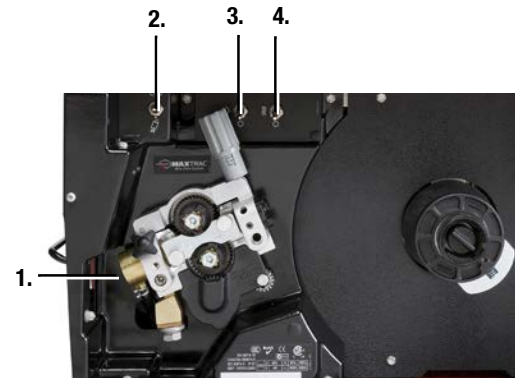
Recommended Power Sources

- » Power Wave® S350
- » Power Wave S500
- » Power Wave S700
- » Flextec® 350X
- » Flextec 500X
- » Flextec 650X

MAXTRAC® WIRE DRIVE SYSTEM

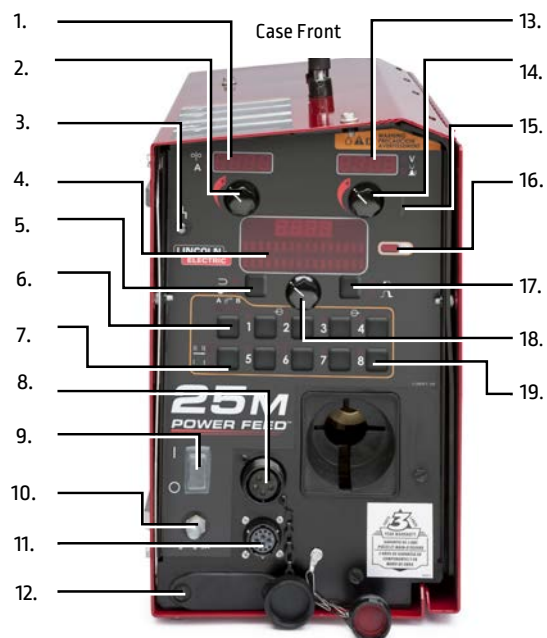


1. **Two Roll MAXTRAC® Wire Drive System**
 - Two gear driven rolls with patented groove design. No tools needed to remove rolls
 - Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
 - Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.
2. **Gas Purge/Cold Feed Switch** - Allows convenient purging of shielding gas and cold electrode feeding.
3. **Light Switch** - Turns on high intensity LED's to illuminate the inside of wire feeder.
4. **Heater Switch** - The built-in heater warms the inside air to protect consumables from moisture.



KEY CONTROLS

1. **Left Display** - Shows wire feed speed or amperage.
2. **WFS/Amperage Control** - Adjust WFS for MIG and flux-cored; adjust amps for stick or TIG.
3. **Status LED** - Shows a steady green when properly communicating to the power source.
4. **Main Display** - Shows detailed welding and diagnostic information.
5. **Arc Control** - Adjust arc characteristics to match individual preferences.
6. **Dual Procedure** - Toggle between two weld procedures while welding.
7. **2-Step/4-Step Control** - For trigger interlock capability.
8. **Gun Trigger Connector (5-pin)** - Connection for push-only guns.
9. **On/Off Power Switch** - Protected from the elements.
10. **3 Amp Circuit Breaker** - Protects the 12-pin accessories.
11. **12-pin Remote Connection** - For connecting remote output control or push-pull gun.
12. **Cover** - Covers location for optional water cooling line.
13. **Right Display** - Shows voltage or trim.
14. **Continuous Volts/Trim Control** - Adjust voltage for MIG and flux-cored; adjust arc length (trim) for Pulsed MIG.
15. **Thermal LED** - Lights when the drive overheats.
16. **Set-Up** - Lights when feeder is set-up.
17. **Advanced Process Options** - Control pre-weld and post-weld settings to optimize arc starts and stops.
18. **Weld Mode Search** - Search for an appropriate mode based on material, process, shielding gas and other parameters.
19. **Memory Presets** - Store up to 8 customized weld procedures.



ACCESSORIES

ARCLINK®/LINC-NET™ CONTROL EXTENSION CABLES

Length ft. (m)	Product Description	Order Number
8 (2.5)	ArcLink®/Linc-Net® Control Cable	K1543-8
25 (7.6)	ArcLink®/Linc-Net® Control Cable	K1543-25
50 (15.2)	ArcLink®/Linc-Net® Control Cable	K1543-50
100 (30.4)	ArcLink®/Linc-Net® Control Cable	K1543-100
25 (7.6)	Heavy duty ArcLink® Control Cable	K2683-25
50 (15.2)	Heavy duty ArcLink® Control Cable	K2683-50
100 (30.4)	Heavy duty ArcLink® Control Cable	K2683-100

WELD POWER CABLES

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
10 (3)	600	60%	3/0	K1842-10
35 (10.5)	600	60%	3/0	K1842-35
60 (18)	600	60%	3/0	K1842-60
110 (33.5)	600	60%	3/0	K1842-110

Note: All sizes are lug to lug connection type.

COAXIAL WELD POWER CABLES⁽¹⁾

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
25 (7.6)	350	60%	1/0	K1796-25
50 (15.2)	350	60%	1/0	K1796-50
75 (22.8)	300	60%	1/0	K1796-75
100 (30.4)	250 300	100% 60%	#1 1/0	K2593-100 K1796-100

⁽¹⁾ Recommended for STT® and pulse welding when using long distances between feeder and power source.

Note: All sizes are lug to lug connection type.

DRIVE ROLL & WIRE GUIDE KITS

Description in. (mm)	Order Number
Steel Wire Sizes (includes stainless steel):	
0.023-0.030 (0.6-0.8)	KP1696-030S
0.035 (0.9)	KP1696-035S
0.045 (1.2)	KP1696-045S
0.052 (1.4)	KP1696-052S
0.035, 0.045 (0.9, 1.2)	KP1696-1
0.040 (1.0)	KP1696-2
1/16 (1.6)KP1696-1/16S	
Cored Wire Sizes:	
0.030-0.035 (0.8-0.9)	KP1697-035C
0.040-0.045 (1.0-1.2)	KP1697-045C
0.052 (1.4)	KP1697-052C
1/16 (1.6)KP1697-1/16C	
Steel or Cored Wire Sizes:	
0.068-0.072 (1.8)	KP1697-068
5/64 (2.0)	KP1697-5/64
3/32 (2.4)	KP1697-3/32
Aluminum Wire Sizes:	
0.035 (0.9)	KP1695-035A
0.040 (1.0)	KP1695-040A
3/64 (1.2)	KP1695-3/64A
1/16 (1.6)KP1695-1/16A	

Gun Bushings / Feed Plate Gun Adapters

K1500-1 (Comes installed on feeder)	K1500-2	K1500-3	K1500-4	K1500-5	K489-7
Lincoln Electric Compatible gun connector kits K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4 Compatible gun connector kits K466-10 K466-2 K466-6	Tweco #5 Compatible gun connector kit K613-7 K613-2	Miller® guns Compatible gun connector kits K466-3 K613-3	OXO® guns	Magnum® PRO Fast-Mate™ / Euro Connector Compatible gun connector kits K489-1 K489-2 K489-7 K489-8
					

Tweco® is a registered trademark of Victor Technologies.
Miller® is a registered trademark of Miller Electric Mfg. Co.
Oxo® is a registered trademark of Miller Electric Mfg. Co.



Magnum® PRO Curve™

Choose for MIG or flux-cored welding. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum® PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.

See Publication E12.05



Magnum® PRO AL Pistol Grip

Pistol Grip models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

Order K3478-1 (15 ft),
K3478-2 (25 ft)
K3478-3 (35 ft)



Magnum® PRO AL

Models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

See Publication E12.14 for more options



Water Connection Kit

Includes fittings for use with water-cooled guns and Magnum® coolers. Kit provides for one gun.

Order K590-6



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. (1.3 m) gas hose.

Order K586-1



Portable Feeder Case-Plastic

Replace a damaged case without replacing the entire unit.

Order K2596-2



6-pin to 12-pin Adapter

Use for adapting existing 6-pin remote controls such as the K870, K857, and K963-3 to the new 12-pin connector.

Order K2909-1



7-pin to 12-pin Adapter

Use for connecting 7-pin push-pull guns such as the Magnum® Pro AL and Python® Plus to the new 12-pin connector.

Order K2910-1



Remote Output Control with 12-pin Universal Connector

Consists of a control box with choice of two cable lengths. Permits remote adjustment of output.

Order K857-225 ft. (7.6 m)
Order K857-3100 ft. (30.5 m)

TIG OPTIONS



PTA-17150 Amp

Air-Cooled TIG Torch

Order K1782-2 for 12.5 ft.

(3.8 m) length, 2-cable

Order K1782-4 for 25 ft.

(7.6 m) length, 2-cable



PTA-26200 Amp

Air-Cooled TIG Torch

Order K1783-2 for 12.5 ft.

(3.8 m) length, 2-cable

Order K1783-4 for 25 ft.

(7.6 m) length, 2-cable



Foot Amptrol™ with 12-pin Universal Connector

Provides 25 ft. (7.6 m) of remote current control for TIG welding.

Order K870-2



Hand Amptrol™ with 12-pin Universal Connector

Provides 25 ft. (7.6 m) of remote current control for TIG welding.

Order K963-4

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
						Solid	Cored		
Power Feed 25M Aluminum Case	K2536-4	40 VDC	500A/60%	Standard speed (factory setting)	GMAW: 50-800 [1.3 - 20.3] FCAW: 50-800 [1.3 - 20.3]	0.023-1/16 [0.6-1.6]	0.030-5/64 [0.8-2.0]	14.5 x 8.5 x 23.5 [368 x 216 x 597]	35 [15.9]
Power Feed 25M Plastic Case	K2536-5			Extra-torque	GMAW: 30-400 [0.8-10.2] FCAW: 30-400 [0.8-10.2]	0.023-1/16 [0.6-1.6]	0.030-3/32 [0.8-2.4]		

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

Manufactured at a facility with certified ISO Quality and Environmental Management Systems.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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