

MAGNUM[®] PRO BARREL HDE[™] GUNS

Heavy Duty. Ergonomic.



KEY FEATURES

The Magnum PRO Barrel HDE guns join the HDE family to offer premium performance and improved efficiency. Designed for rugged welding environments, the Magnum PRO Barrel HDE guns with Magnum PRO expendables are built to last.

- **100% Duty Cycle with Mixed Gas** – The Magnum PRO Barrel HDE guns have the highest duty cycle rating in their class, making them ideal for rugged environments and high heat applications.
- **Premium Expendable Performance** – Lincoln Electric's patented Magnum PRO expendables are designed with both performance and productivity in mind. The premium performance helps extend the service life of the expendables, reducing downtime and total costs.
- **Tool-less Rotatable Gun Tube** – The bolt of the gun tube can be loosened without the need for tools and rotated 360°, so it is easy to position into a comfortable spot for welding.
- **Versatile Gun Configuration** – By turning the gun tube 180 degrees, the straight barrel handle can be used as a trigger on top welding gun

Process »
MIG, Pulsed MIG, Flux-Cored

Output »



Input »



Product Number »

See Magnum PRO HDE Guns table for details

What's Included »

- » Gooseneck
- » Insulator
- » Diffuser
- » Contact tip
- » Nozzle

(see next page for details)

WHAT'S INCLUDED:

MAGNUM PRO BARREL HDE 250A (K4856-X):

- Gooseneck (KP4693-60)
- Insulator (KP2773-2)
- Diffuser (KP2746-1)
- Contact Tip (KP2744-035)
- Nozzle (KP2742-1-62R)

MAGNUM PRO BARREL HDE 350A (K4857-X):

- Gooseneck (KP4694-60)
- Insulator (KP2773-1)
- Diffuser (KP2747-1)
- Contact Tip (KP2745-045)
- Nozzle (KP2743-1-62R)

MAGNUM PRO BARREL HDE 450A (K4858-X):

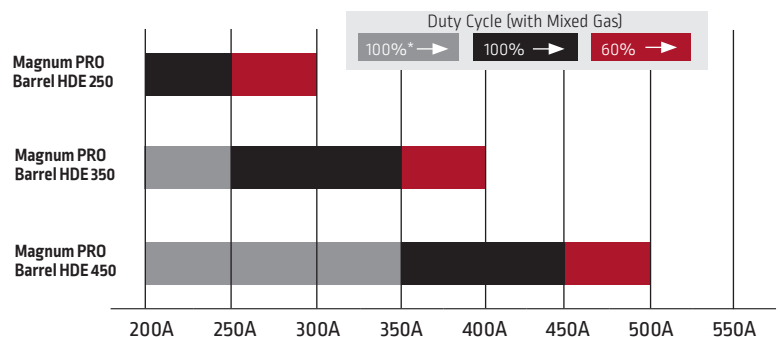
- Gooseneck (KP4695-60)
- Insulator (KP2773-1)
- Diffuser (KP2747-1)
- Contact Tip (KP2745-045)
- Nozzle (KP2743-1-62R)

HOW TO CONFIGURE A GUN

It is important to select the right product for each application. Use the following steps to select the correct components for your need.

- 1. Select Your Gun** – Three important elements to consider when choosing a gun are amperage, duty cycle, and gas blend. Gun selection should be based off of the amperage and duty cycle of the application, not the amperage rating of the machine the gun is being connected to. The Magnum PRO Barrel HDE guns are rated at 100% duty cycle with mixed gas, a unique performance advantage over competitive guns.

Magnum PRO Barrel HDE Performance Chart



*Note: We recommend selecting a lower amperage Magnum PRO Barrel HDE model

- 2. Select Your Liner** – Select your liner based off of the wire diameter that is being run.
- 3. Select Your Gun Connector Kit** – Choose the correct connector that matches the wire feeder model.
- 4. Choose Your Expendables** – Based off of the application, choose either 350A expendables (for light or medium duty applications) or 550A expendables (for medium or heavy duty applications). Multiple expendable types are available to cater to the type of wire used, the joint configuration, and the welding process.

1. SELECT YOUR GUN

MAGNUM PRO BARREL HDE GUNS

Product Name	Product Number	Amperage Rating 100% Duty Cycle Mixed Gas	Wire Diameter Range in (mm)	Cable Length ft (m)	Gun Tube	Gun Connector	Gun Liner	
Magnum PRO Barrel HDE 250	K4856-1	250	0.025 - 0.045 [0.6-1.2]	10 [3.0]	KP4693-60	Order Separately	Order Separately	
	K4856-2			15 [4.5]				
	K4856-3			20 [6.1]				
	K4856-4			25 [7.6]				
Magnum PRO Barrel HDE 350	K4857-1	350	0.035 - 5/64 [0.9-2.0]	10 [3.0]	KP4694-60			
	K4857-2			15 [4.5]				
	K4857-3			20 [6.1]				
	K4857-4			25 [7.6]				
Magnum PRO Barrel HDE 350 Dual Schedule	K5306-2	350	0.035 - 5/64 [0.9-2.0]	15 [4.5]	KP4694-60			
	K5306-4			25 [7.6]				
Magnum PRO Barrel HDE 450	K4858-1	450	0.035 - 5/64 [0.9-2.0]	10 [3.0]	KP4695-60			
	K4858-2			15 [4.5]				
	K4858-3			20 [6.1]				
	K4858-4			25 [7.6]				
Magnum PRO Barrel HDE 450 Dual Schedule	K5308-2	450	0.035 - 5/64 [0.9-2.0]	15 [4.5]	KP4695-60			
	K5308-4			25 [7.6]				
Magnum PRO Barrel HDE 250 Ready Pak	K4856-2-1-45	250	0.025 - 0.045 [0.6-1.2]	15 [4.5]	KP4693-60	K466-1	KP42-4045-15	
	K4856-2-10-45					K466-10	KP42-4045-15	
	K4856-2-3-45					K466-3	KP42-4045-15	
	K4856-2-FM-45					Fast Mate	KP42-4045-15	
	K4856-4-FM-45					Fast Mate	KP42-4045-25	
Magnum PRO Barrel HDE 350 Ready Pak	K4857-2-1-116	350	0.035 - 5/64 [0.9-2.0]	15 [4.5]	KP4694-60	K466-1	KP44-116-15	
	K4957-2-10-116					K466-10	KP44-116-15	
	K4857-2-3-116					K466-3	KP44-116-15	
	K4857-2-FM-45					Fast Mate	KP44-3545-15	
	K4857-4-1-116			25 [7.6]		K466-1	KP44-116-25	
	K4857-4-10-116					K466-10	KP44-116-25	
	K4857-4-3-116					K466-3	KP44-116-25	
	K4857-4-FM-45					Fast Mate	KP44-3545-25	
Magnum PRO Barrel HDE 450 Ready Pak	K4858-2-1-564	450	0.035 - 5/64 [0.9-2.0]	15 [4.5]	KP4695-60	K466-1	KP45-564-15	
	K4858-2-10-564					K466-10	KP45-564-15	
	K4858-2-3-564					K466-3	KP45-564-15	



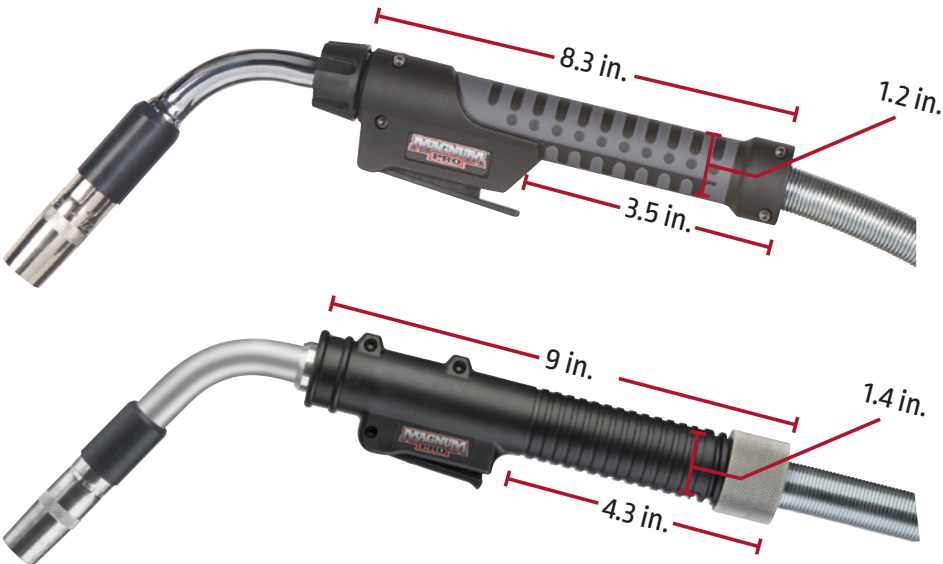
MAGNUM PRO CURVE HDE GUNS VS. MAGNUM PRO BARREL HDE GUNS:

The choice between the Curve style or Barrel style handle comes down to operator preference. Since both styles come with the same premium HDE features, you can experience increased operator comfort, productivity, and quality with whichever Magnum PRO HDE welding gun you choose.

	Magnum PRO Curve HDE	Magnum PRO Barrel HDE
100% Mixed Gas Duty Cycle	✓	✓
Amperage Classes	250/350/450/550	250/350/450
Tool-less Rotatable Gun Tube	✓	✓
Magnum PRO Expendables	✓	✓
Trigger Style	Standard	Paddle
Trigger On Top	—	✓
Over Molded Handle	✓	✓

IMPROVED PRODUCTIVITY AND OPERATOR COMFORT

The new Magnum PRO Barrel HDE welding guns are smaller and lighter than the Magnum PRO Barrel guns making them easier to control.



**20%
SMALLER
HANDLE**

100%
MIXED GAS
DUTY CYCLE
MAGNUM PRO
BARREL HDE

100%
CO₂
DUTY CYCLE
MAGNUM PRO
BARREL

2. SELECT YOUR LINER

KP44 SERIES LINERS

ft (m)	0.035-.045 in (0.9-1.2 mm)	0.052-1/16 in (1.3-1.6 mm)	1/16-5/64 in (1.6-2.0 mm)
15 (4.5)	KP44-3545-15	KP44-116-15	KP44-564-15
25 (7.6)	KP44-3545-25	KP44-116-25	KP44-564-25

KP42 SERIES LINERS

ft (m)	.025-.030 (0.6-0.8 mm)	.030-.035 (0.8-0.9 mm)	.035-.045 (0.9-1.2 mm)
15 (4.5)	KP42-25-15	KP42-3035-15	KP42-4045-15
25 (7.6)	KP42-25-25	KP42-3035-25	KP42-4045-25

* 250A guns are used with KP42 series liners, the 350A and 450A guns are used with KP44 series liners, and the 550A guns are used with KP45 series liners.
**The 450A gun can be adapted to run up to 1/8 in. wire by using a KP45 series liner, a K613 series backend, and a 550A or 550A short gooseneck. The original 450A gooseneck cannot be used on wire larger than 5/64 in.

KP45 SERIES LINERS

ft (m)	0.035-.045 in (0.9-1.2 mm)	0.052-1/16 in (1.3-1.6 mm)	5/64-3/32 in (2.0-2.4 mm)	7/64-1/8 in (2.8-3.2 mm)
15 (4.5)	KP45-3545-15	KP45-116-15	KP45H-332-15	KP45-18-15
25 (7.6)	KP45-3545-25	KP45-116-25	KP45H-332-25	KP45-18-25

3. SELECT YOUR GUN CONNECTOR KIT

GUN CONNECTOR KITS

Manufacturer	Wire Feeder Model	K466 Connector Kits (accepts KP42 & KP44 series liners)	K613 Connector Kits (accepts KP45 series liners)
Lincoln Electric®	LF-72™, LF-74™ Series, Flex Feed® 74 HT, Flex Feed 84, LN-25 PRO™, LN-25X®, Activ8®, Activ8X® Power Feed® 10, 10M, 25M, and 84 PIPEFAB™	K466-10	K613-7
	LN-7™ Series, LN-8™, LN-9™, LN-25® (up to 0.052 in./1.4 mm wire), LN-23P™	K466-1	K613-1
	POWER MIG® Series and Power Wave® 300C	K466-6	N/A
	LN-8, LN-9 Series, LN-25 (1/16 in./1.6 mm and larger), LN-23P	K466-8	K613-6
Tweco® Adapted	No. 2, No. 3, No. 4 Guns	K466-2	K613-2
Miller®	Intellimatic®, Sidekick, D-51A, Porto-MIG™ Millermatic® 130, 200, MM-35, S-42GL, S-52A, Swingarc™-Dual, Swingarc™-Single, S-32S, 52D, 54D, 54E, 60 Series, 70 Series	K466-3	K613-3

4. CHOOSE YOUR EXPENDABLES

All Magnum PRO HDE gun tubes will fit on any Magnum PRO HDE gun. However, the 250A, 350A, and 450A gun tubes may restrict wire diameter sizes. Please reference the chart below.

GUN TUBES

45° Gun Tube	Length in (mm)	60° Gun Tube	Length in (mm)	Wire Diameter Range in (mm)
KP4693-45	5.0 [127]	KP4693-60 ⁽¹⁾	4.6 [117]	0.035-5/64 [0.9-2.0]
KP4694-45	6.3 [160]	KP4694-60 ⁽²⁾	5.8 [147]	0.035-5/64 [0.9-2.0]
KP4695-45	7.8 [198]	KP4695-60 ⁽³⁾	7.4 [188]	0.035-5/64 [0.9-2.0]
KP4696-45	8.6 [218]	KP4696-60	8.0 [203]	0.035-1/8 [0.9-3.2]
KP4696-45SN	7.8 [198]	KP4696-60SN	7.3 [185]	0.035-1/8 [0.9- 3.2]

(1) Comes standard on the 250A gun.
(2) Comes standard on the 350A gun.
(3) Comes standard on the 450A gun.
(Note) The 450A gun can be adapted to run up to 1/8 in. wire by using a KP45 series liner, a K613 series backend, and a 550A or 550A short gooseneck. The original 450A gooseneck cannot be used on wire larger than 5/64 in.

ADDITIONAL GUN TUBE OPTIONS

Need something a little more customizable? The Magnum PRO HDE flexible gun tube and gun tube extensions offer many more gun tube configurations to fit any application.



MAGNUM PRO HDE 350 FLEXIBLE GUN TUBE
Order KP5707-2

MAGNUM PRO HDE 450 FLEXIBLE GUN TUBE
Order KP5707-3

MAGNUM PRO HDE 550 FLEXIBLE GUN TUBE
Order KP5707-4

Three flexible gun tube options depending on gun amperage rating. The Magnum Pro HDE Flexible Gun Tubes can be used when traditional fixed gun tube angles are not enough for hard to reach work areas.



3 in. Gun Tube Extension
Order KP5147-1

The Magnum PRO HDE Gun Tube Extensions can be used to add length to the front of the gun for those hard to reach weld joints. These extensions can be used in series to create custom lengths.



9 in. Gun Tube Extension
Order KP5148-1

Note: The use of a 350A insulator (KP2773-2) is required between each threaded connection.

CHOOSING THE RIGHT EXPENDABLES

350A OR 550A EXPENDABLES?

Both 350A and 550A expendable parts fit on 250A, 350A, 450A, and 550A guns. The 250A and 350A guns come standard with 350A expendables, and the 450A and 550A guns come standard with the 550A expendables. While the amperage of the expendables does not affect the overall amperage rating of the gun, the 350A expendables should be used in light or medium duty applications and the 550A expendables should be used in medium or heavy duty applications.

STANDARD, TAPERED, OR EXTENDED LIFE CONTACT TIPS?



Standard

Best for multi-purpose welding. Lasts longer than tapered tips.



Tapered

Best for welding in tight joints. Use with 3/8 in. or 1/2 in. ID nozzles.



Extended Life

Best for heavy-duty or robotic applications. Chrome zirconium copper alloy minimizes annealing and wear.

NOZZLE ID AND STICKOUT?



3/8 in. & 1/2 in. ID Nozzles
Best for welding in tight joints. Use with tapered contact tips.



5/8 in. & 3/4 in. ID Nozzles
Best for welds that require larger gas coverage.

Recess

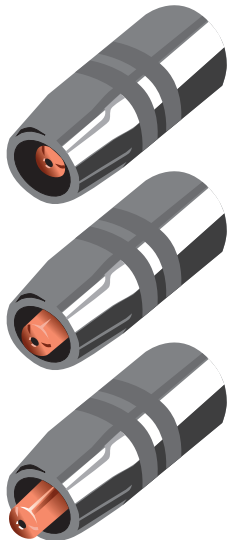
Used in most spray and pulse applications

Flush

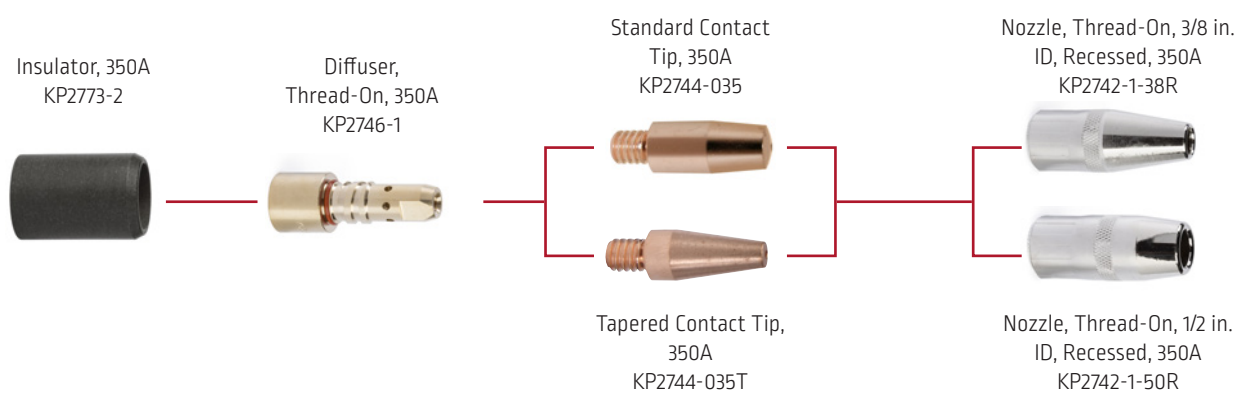
Used in short circuit and STT applications.

Stickout

Used in short circuit and STT applications, or in particularly tight joints for better access.



350A EXPENDABLES



CONTACT TIPS, 350A

Wire Diameter in (mm)	Standard Qty 10	Standard Qty 100	Tapered Qty 10	Tapered Qty 100
0.025 [0.6]	KP2744-025	KP2744-025-B100	KP2744-025T	KP2744-025T-B100
0.030 [0.8]	KP2744-030	KP2744-030-B100	KP2744-030T	KP2744-030T-B100
0.035 [0.9]	KP2744-035	KP2744-035-B100	KP2744-035T	KP2744-035T-B100
0.040 [1.0]	KP2744-040	KP2744-040-B100	KP2744-040T	KP2744-040T-B100
0.045 [1.2]	KP2744-045	KP2744-045-B100	KP2744-045T	KP2744-045T-B100
0.052 [1.3]	KP2744-052	KP2744-052-B100	KP2744-052T	KP2744-052T-B100
1/16 [1.6]	KP2744-116	KP2744-116-B100	KP2744-116T	KP2744-116T-B100
5/64 [2.0]	KP2744-564	KP2744-564-B100	KP2744-564T	KP2744-564T-B100

GAS DIFFUSERS, 350A

Qty	Thread-On	Thread-On, Extended Reach	Slip-On
1	KP2746-1	KP3360-1	KP2746-2
25	KP2746-1-B25	KP3360-1-B25	KP2746-2-B25

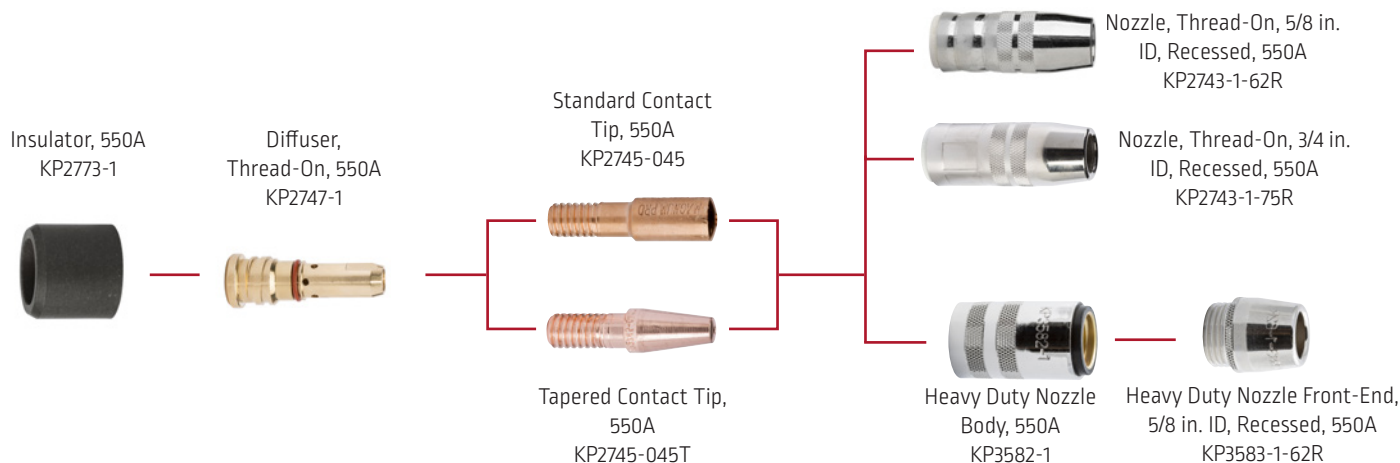
INSULATORS, 350A

Qty	Part Number
1	KP2773-2
25	KP2773-2-B25

GAS NOZZLES, 350A

Thread Type	Nozzle Type in (mm)	Qty	3/8 in ID, Standard	1/2 in ID, Standard	1/2 in ID, Extended Reach	1/2 in ID, Narrow Gap	1/2 in ID, Bottleneck	5/8 in ID, Standard
Thread-On	1/8 [3.2] Recess	1	KP2742-1-38R	KP2742-1-50R	KP3359-1-50R	KP3617-1-50R	KP3160-1-50R	KP2742-1-62R
		25	KP2742-1-38R-B25	KP2742-1-50R-B25	KP3359-1-50R-B25	KP3617-1-50R-B25	KP3160-1-50R-B25	KP2742-1-62R-B25
	Flush	1	KP2742-1-38F	KP2742-1-50F	KP3359-1-50F	KP3617-1-50F	KP3160-1-50F	KP2742-1-62F
		25	KP2742-1-38F-B25	KP2742-1-50F-B25	KP3359-1-50F-B25	KP3617-1-50F-B25	KP3160-1-50F-B25	KP2742-1-62F-B25
	1/8 [3.2] Stickout	1	KP2742-1-38S	KP2742-1-50S	KP3359-1-50S	KP3617-1-50S	KP3160-1-50S	KP2742-1-62S
		25	KP2742-1-38S-B25	KP2742-1-50S-B25	KP3359-1-50S-B25	KP3617-1-50S-B25	KP3160-1-50S-B25	KP2742-1-62S-B25
Slip-On	1/8 [3.2] Recess	1	—	KP2742-2-50R	—	—	—	KP2742-2-62R
		25	—	KP2742-2-50R-B25	—	—	—	KP2742-2-62R-B25
	Flush	1	—	KP2742-2-50F	—	—	—	KP2742-2-62F
		25	—	KP2742-2-50F-B25	—	—	—	KP2742-2-62F-B25
	1/8 [3.2] Stickout	1	—	KP2742-2-50S	—	—	—	KP2742-2-62S
		25	—	KP2742-2-50S-B25	—	—	—	KP2742-2-62S-B25

550A EXPENDABLES



CONTACT TIPS, 550A

Wire Diameter in (mm)	Standard Qty 10	Standard Qty 100	Tapered Qty 10	Tapered Qty 100	Extended Life Qty 10	Extended Life Qty 100
0.035 [0.9]	KP2745-035	KP2745-035-B100	KP2745-035T	KP2745-035T-B100	KP2745-035R	KP2745-035R-B100
0.040 [1.0]	KP2745-040	KP2745-040-B100	KP2745-040T	KP2745-040T-B100	KP2745-040R	KP2745-040R-B100
0.045 [1.2]	KP2745-045	KP2745-045-B100	KP2745-045T	KP2745-045T-B100	KP2745-045R	KP2745-045R-B100
0.052 [1.3]	KP2745-052	KP2745-052-B100	KP2745-052T	KP2745-052T-B100	KP2745-052R	KP2745-052R-B100
1/16 [1.6]	KP2745-116	KP2745-116-B100	KP2745-116T	KP2745-116T-B100	KP2745-116R	KP2745-116R-B100
0.068-0.072 [1.7-1.8]	KP2745-072	KP2745-072-B100	—	—	KP2745-072R	KP2745-072R-B100
5/64 [2.0]	KP2745-564	KP2745-564-B100	—	—	KP2745-564R	KP2745-564R-B100
3/32 [2.4]	KP2745-332	KP2745-332-B100	—	—	KP2745-332R	KP2745-332R-B100
7/64 [2.8]	KP2745-764	KP2745-764-B100	—	—	KP2745-764R	KP2745-764R-B100
1/8 [3.2]	KP2745-18	KP2745-18-B100	—	—	—	—

GAS DIFFUSERS, 550A

Material	Qty	Thread-On	Thread-on 1/4 in. Recess	Thread-On, Extended Reach*	Slip-On
Brass	1	KP2747-1	KP3155-1	KP4781-1	KP5129-2
	25	KP2747-1-B25	KP3155-1-B25	KP4781-1-B25	KP5129-2-B25
Copper	1	KP4766-1	—	—	KP4766-2
	25	KP4766-1-B25	—	—	KP4766-2-B25

* 550A Extended Reach Diffusers are compatible with KP3359-1-50X Nozzles and KP2745-XX 550A Contact Tips

INSULATORS, 550A

Qty	Part Number
1	KP2773-1
25	KP2773-1-B25

GAS NOZZLES, 550A

Thread Type	Nozzle Type in (mm)	Qty	3/8 in ID, Standard	1/2 in ID, Standard	5/8 in ID, Standard	5/8 in ID, Bottleneck	3/4 in ID, Standard
Thread-On	1/8 [3.2] Recess	1	KP2743-1-38R	KP2743-1-50R	KP2743-1-62R	KP3161-1-62R	KP2743-1-75R
		25	KP2743-1-38R-B25	KP2743-1-50R-B25	KP2743-1-62R-B25	KP3161-1-62R-B25	KP2743-1-75R-B25
	Flush	1	KP2743-1-38F	KP2743-1-50F	KP2743-1-62F	KP3161-1-62F	KP2743-1-75F
		25	—	—	KP2743-1-62F-B25	KP3161-1-62F-B25	KP2743-1-75F-B25
	1/8 [3.2] Stickout	1	KP2743-1-38S	KP2743-1-50S	KP2743-1-62S	KP3161-1-62S	KP2743-1-75S
		25	—	—	KP2743-1-62S-B25	KP3161-1-62S-B25	KP2743-1-75S-B25
Slip-On	1/8 [3.2] Recess	1	—	KP5130-2-50R	KP5130-2-62R	—	KP5130-2-75R
		25	—	KP5130-2-50R-B25	KP5130-2-62R-B25	—	KP5130-2-75R-B25
	Flush	1	—	KP5130-2-50F	KP5130-2-62F	—	KP5130-2-75F
		25	—	KP5130-2-50F-B25	KP5130-2-62F-B25	—	KP5130-2-75F-B25
	1/8 [3.2] Stickout	1	—	KP5130-2-50S	KP5130-2-62S	—	KP5130-2-75S
		25	—	KP5130-2-50S-B25	KP5130-2-62S-B25	—	KP5130-2-75S-B25

For high amperage applications, two-piece heavy duty nozzles may be used instead of standard 550A nozzles.

Both a nozzle body and a nozzle front end are required for use.

HEAVY DUTY GAS NOZZLE FRONT-ENDS, 550A

Thread Type	Nozzle Type in (mm)	Qty	5/8 in ID, Heavy Duty	3/4 in ID, Heavy Duty
Thread-On	1/8 [3.2] Recess	1	KP3583-1-62R	KP3583-1-75R
		25	KP3583-1-62R-B25	KP3583-1-75R-B25
	Flush	1	KP3583-1-62F	KP3583-1-75F
		25	KP3583-1-62F-B25	KP3583-1-75F-B25

HEAVY DUTY GAS NOZZLE BODIES, 550A

Qty	Part Number
1	KP3582-1
25	KP3582-1-B25

CUSTOMER ASSISTANCE POLICY

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