

Operator's Manual

Magnum[®] PRO Water Cooled Mechanized Torch



For use with machines having Code Numbers:

K5333-3-10-564

K5333-5-10-564

K5333-8-10-564

K5333-10-10-564

K5333-15-10-564

K5333-25-10-564

K5333-10-FM-564

K5333-15-FM-564



Register your machine:

www.lincolnelectric.com/registration

Authorized Service and Distributor Locator:

www.lincolnelectric.com/locator

Save for future reference

Date Purchased

Code: (ex: 10859)

Serial: (ex: U1060512345)

THANK YOU FOR SELECTING A QUALITY PRODUCT BY LINCOLN ELECTRIC.

PLEASE EXAMINE CARTON AND EQUIPMENT FOR DAMAGE IMMEDIATELY

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

SAFETY DEPENDS ON YOU

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

WARNING

This statement appears where the information must be followed exactly to avoid serious personal injury or loss of life.

CAUTION

This statement appears where the information must be followed to avoid minor personal injury or damage to this equipment.



KEEP YOUR HEAD OUT OF THE FUMES.

DON'T get too close to the arc. Use corrective lenses if necessary to stay a reasonable distance away from the arc.

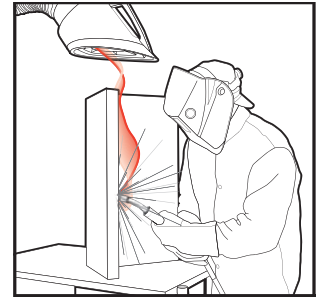
READ and obey the Safety Data Sheet (SDS) and the warning label that appears on all containers of welding materials.

USE ENOUGH VENTILATION or exhaust at the arc, or both, to keep the fumes and gases from your breathing zone and the general area.

IN A LARGE ROOM OR OUTDOORS, natural ventilation may be adequate if you keep your head out of the fumes (See below).

USE NATURAL DRAFTS or fans to keep the fumes away from your face.

If you develop unusual symptoms, see your supervisor. Perhaps the welding atmosphere and ventilation system should be checked.



WEAR CORRECT EYE, EAR & BODY PROTECTION

PROTECT your eyes and face with welding helmet properly fitted and with proper grade of filter plate (See ANSI Z49.1).

PROTECT your body from welding spatter and arc flash with protective clothing including woolen clothing, flame-proof apron and gloves, leather leggings, and high boots.

PROTECT others from splatter, flash, and glare with protective screens or barriers.

IN SOME AREAS, protection from noise may be appropriate.

BE SURE protective equipment is in good condition.

Also, wear safety glasses in work area **AT ALL TIMES.**



SPECIAL SITUATIONS

DO NOT WELD OR CUT containers or materials which previously had been in contact with hazardous substances unless they are properly cleaned. This is extremely dangerous.

DO NOT WELD OR CUT painted or plated parts unless special precautions with ventilation have been taken. They can release highly toxic fumes or gases.

Additional precautionary measures

PROTECT compressed gas cylinders from excessive heat, mechanical shocks, and arcs; fasten cylinders so they cannot fall.

BE SURE cylinders are never grounded or part of an electrical circuit.

REMOVE all potential fire hazards from welding area.

ALWAYS HAVE FIRE FIGHTING EQUIPMENT READY FOR IMMEDIATE USE AND KNOW HOW TO USE IT.



SECTION A: WARNINGS



CALIFORNIA PROPOSITION 65 WARNINGS



WARNING: Breathing diesel engine exhaust exposes you to chemicals known to the State of California to cause cancer and birth defects, or other reproductive harm.

- Always start and operate the engine in a well-ventilated area.
- If in an exposed area, vent the exhaust to the outside.
- Do not modify or tamper with the exhaust system.
- Do not idle the engine except as necessary.

For more information go to www.P65warnings.ca.gov/diesel

WARNING: This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code § 25249.5 *et seq.*)



WARNING: Cancer and Reproductive Harm
www.P65warnings.ca.gov

ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1" from the American Welding Society, P.O. Box 351040, Miami, Florida 33135 or CSA Standard W117.2. A Free copy of "Arc Welding Safety" booklet E205 is available from the Lincoln Electric Company, 22801 St. Clair Avenue, Cleveland, Ohio 44117-1199.

BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.



FOR ENGINE POWERED EQUIPMENT.

- Turn the engine off before troubleshooting and maintenance work unless the maintenance work requires it to be running.
- Operate engines in open, well-ventilated areas or vent the engine exhaust fumes outdoors.
- Do not add the fuel near an open flame welding arc or when the engine is running. Stop the engine and allow it to cool before refueling to prevent spilled fuel from vaporizing on contact



with hot engine parts and igniting. Do not spill fuel when filling tank. If fuel is spilled, wipe it up and do not start engine until fumes have been eliminated.

- Keep all equipment safety guards, covers and devices in position and in good repair. Keep hands, hair, clothing and tools away from V-belts, gears, fans and all other moving parts when starting, operating or repairing equipment.
- In some cases it may be necessary to remove safety guards to perform required maintenance. Remove guards only when necessary and replace them when the maintenance requiring their removal is complete. Always use the greatest care when working near moving parts.
- Do not put your hands near the engine fan. Do not attempt to override the governor or idler by pushing on the throttle control rods while the engine is running.
- To prevent accidentally starting gasoline engines while turning the engine or welding generator during maintenance work, disconnect the spark plug wires, distributor cap or magneto wire as appropriate.
- To avoid scalding, do not remove the radiator pressure cap when the engine is hot.
- Using a generator indoors CAN KILL YOU IN MINUTES.
- Generator exhaust contains carbon monoxide. This is a poison you cannot see or smell.
- NEVER use inside a home or garage, EVEN IF doors and windows are open.
- Only use OUTSIDE and far away from windows, doors and vents.
- Avoid other generator hazards. READ MANUAL BEFORE USE.



ELECTRIC AND MAGNETIC FIELDS MAY BE DANGEROUS



- Electric current flowing through any conductor causes localized Electric and Magnetic Fields (EMF). Welding current creates EMF fields around welding cables and welding machines
- EMF fields may interfere with some pacemakers, and welders having a pacemaker should consult their physician before welding.
- Exposure to EMF fields in welding may have other health effects which are now not known.
- All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:
 - Route the electrode and work cables together - Secure them with tape when possible.
 - Never coil the electrode lead around your body.
 - Do not place your body between the electrode and work cables. If the electrode cable is on your right side, the work cable should also be on your right side.
 - Connect the work cable to the workpiece as close as possible to the area being welded.
 - Do not work next to welding power source.



ELECTRIC SHOCK CAN KILL.



- 3.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.
- 3.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:

- Semiautomatic DC Constant Voltage (Wire) Welder.
 - DC Manual (Stick) Welder.
 - AC Welder with Reduced Voltage Control.
- 3.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semiautomatic welding gun are also electrically “hot”.
 - 3.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.
 - 3.e. Ground the work or metal to be welded to a good electrical (earth) ground.
 - 3.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.
 - 3.g. Never dip the electrode in water for cooling.
 - 3.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.
 - 3.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.
 - 3.j. Also see Items 6.c. and 8.



ARC RAYS CAN BURN.



- 4.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 4.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 4.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.



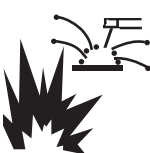
FUMES AND GASES CAN BE DANGEROUS.



- 5.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding hardfacing (see instructions on container or SDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and within applicable OSHA PEL and ACGIH TLV limits using local exhaust or mechanical ventilation unless exposure assessments indicate otherwise. In confined spaces or in some circumstances, outdoors, a respirator may also be required. Additional precautions are also required when welding on galvanized steel.**
- 5.b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 5.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 5.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 5.e. Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the Safety Data Sheet (SDS) and follow your employer's safety practices. SDS forms are available from your welding distributor or from the manufacturer.
- 5.f. Also see item 1.b.



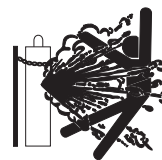
WELDING AND CUTTING SPARKS CAN CAUSE FIRE OR EXPLOSION.



- 6.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 6.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 6.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 6.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 6.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 6.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 6.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 6.h. Also see item 1.c.
- 6.i. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, MA 02269-9101.
- 6.j. Do not use a welding power source for pipe thawing.



CYLINDER MAY EXPLODE IF DAMAGED.



- 7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.
- 7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.
- 7.c. Cylinders should be located:
 - Away from areas where they may be struck or subjected to physical damage.
 - A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.
- 7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.
- 7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.
- 7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.
- 7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association, 14501 George Carter Way Chantilly, VA 20151.



FOR ELECTRICALLY POWERED EQUIPMENT.



- 8.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 8.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 8.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.

Refer to
<http://www.lincolnelectric.com/safety>
for additional safety information.

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 Parts Listparts.lincolnelectric.com
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GENERAL DESCRIPTION

The Magnum Pro Water Cooled Mechanized Torch and cable assemblies have been designed to meet IEC 60974-7 specification for welding with steel and flux cored electrode at 650A with a 100% duty cycle rating. This is designed to use a maximum of 3/32" single electrode. See Table A for the included components

GENERAL FUNCTIONAL DESCRIPTION

The Magnum Pro Water-Cooled Mechanized torch is rated for 650A with a 100% duty cycle rating. The torch and cable assemblies have been designed and tested per the IEC 60974-7 specification for welding with steel and flux cored electrode. The maximum electrode size for single wire applications is 3/32". The maximum electrode size for Hyperfill welding is .045".

CONNECTION TO WATER COOLERS.

The water cooler should be rated for .58 gallons per minute (2.2 liters per minute) at 60 psi (4.08 atm) or greater. The connectors on the gun water hoses have a male quick connect fitting that will mate to a Rectus® Series 21 Coupler. (Note: A KP1529-1 adapter is available to connect the male quick connect to a CGA 033 left hand male connection). When connecting the hoses to the water cooler, the WATER IN "BLUE HOSE" must be connected to the water out connector on the water cooler. The WATER OUT "RED HOSE" must be connected to the water in connector on the water cooler.

Do not operate the gun without having water flowing through the gun. **IRREPARABLE DAMAGE** to the gun will occur if incorrectly connected or if operated even for a short time without an adequate supply of cooling water. A flow sensor is recommended to protect the gun. A K1536-1 flow sensor is available.

CAUTION

Do not operate the gun without having water flowing through the gun. IRREPARABLE DAMAGE to the gun will occur if incorrectly connected or if operated even for a short time without an adequate supply of cooling water. A flow sensor is recommended to protect the gun. A K1536-1 flow sensor is available.

TABLE A.1 – REQUIRED CABLE CONNECTOR KITS (FOR FAST-MATE GUNS)

Product Number	Feeder Type
K489-1	Lincoln LN-7 Series, LN-8 or LN-9
K489-2	Lincoln LN-25
K489-7	Lincoln -10 Series wire feeders

LINER INSTALLATION AND TRIMMING INSTRUCTIONS

- Lay the gun and cable straight on a flat surface.
- Make sure that the set screw in the connector end is backed out so as not to damage liner or liner bushing. Remove and save the gas nozzle and gas diffuser from the end of the gun tube assembly.
- Insert a new untrimmed liner into the connector end of the cable. Be sure the liner bushing is stenciled appropriately for the wire size being used.
- Trim liner 1.25" from the end of the gun tube. When the diffuser is re-installed, the liner should meet flush with the diffuser.

CONTACT TIP AND GAS NOZZLE INSTALLATION

- Choose the correct size contact tip for the electrode being used (wire size is stenciled on the side of the contact tip) and screw it snugly into the gas diffuser.
- Install the appropriate gas nozzle into the diffuser. The proper nozzle should be selected based on the welding application.
- Choose the gas nozzle as appropriate for the GMAW process to be used. Typically, the contact tip end should be flush to .12" (3.1 mm) extended for the short-circuiting transfer process and .12" (3.1 mm) recessed for spray transfer. For the Outershield (FCAW) process, 1/8" (3 mm) recess is recommended.

FAST-MATE GUN INSTALLATION

The Magnum PRO 400A & 500A Water-Cooled Guns come in two varieties, Fast-Mate™ back end connections and K466-10 back end connections. The Fast-Mate versions of the guns

(K4521-2-FM-45 and K4522-2-FM-45) have fixed back ends that cannot be interchanged. These guns can be connected to wire feeders with a Lincoln Fast-Mate connection, a European style connection, or a wire feeder equipped with a Fast-Mate adapter kit. See table B.1 for the various Fast-Mate adapter kits available. To install a Fast-Mate gun, check that the feeder outgoing guide, as well as the drive rolls are appropriate for the electrode being used. When using a Fast-Mate Adapter Kit, be certain that the adapter guide tube is also correct.

Align and fully engage the brass connector end of the gun into the mating connector on the outgoing side of the feeder wire drive. Secure the cable connection by tightening the Fast-Mate™ connector collar nut.

K466 GUN INSTALLATION

The K4521-2-10-45 and K4522-2-10-45 guns come with a K466-10 back end connection. The K466-10 connection can be removed and replaced by other K466 connections. Please refer to table A.2 for a list of feeders and their appropriate connectors.

K466-1 and -8 Installation (For Lincoln Feeders)

- Remove brass cable connector and insulation tube from the K466-1 kit. Slide the insulation tube onto the connector from the threaded end and screw it onto the feeder end of the gun cable. Tighten the connection with the wrench provided.
- Remove the molded gas plug fitting on the side of the feeder end handle and replace it with the barbed brass fitting provided in the kit. The included wrench will fit both the gas plug and barbed fitting.
- Attach the round connector of the gun control cable provided to the trigger connector on the front of the Lincoln feeder. (NOTE: Both the plug and socket are keyed and must be properly oriented.)
- Place one tubing clamp onto each end of the flexible tubing provided, approximately 2" (51 mm) in from each end. Slide one end of the tubing onto the barbed connector on the feeder end cable handle (step b) and move the clamp down near the end of the tube to ensure a good gas seal.

NOTE: An optional K481 MAGNUM® Fast-Connect Gas Tube Kit is available to provide tool-less gas tube connection to Lincoln wire feeders. Install per the instructions sent with the kit.

K466-2 Installation (For Tweco Adapted Feeders)

- Remove brass cable connector from the K466-2 kit and screw it onto the feeder end of the gun cable. Tighten the connection with the wrench provided.
- Check that the molded gas plug fitting is sealing the gas fitting hole in the side of the feeder end handle.

K466-3 Installation (For Miller Feeders)

- Remove brass cable connector from the K466-3 kit and screw it onto the feeder end of the gun cable. Tighten the connection with the wrench provided.
- Check that the molded gas plug fitting is sealing the gas fitting hole in the side of the feeder end handle.
- Attach the round connector of the gun control cable provided to the trigger connector on the front of the Miller feeder.

TABLE A.2 - GUN CONNECTOR KITS FOR K5333 TORCHES

Manufacturer	Wire Feeder Model	Part Number
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 (Up to .052 in./1.4 mm wire, LN-23P)	K466-1
	LN-8, LN-9 Series, LN-25 (1/16 in./1.6 mm and larger), LN-23P	K466-8
	LF-72, LF-74 Series, Flex Feed 74 HT, Flex Feed 84, LN-25 PRO, LN-25X, Activ8, Activ8x	K466-10
	Power Feed™ 10, 10M, 25M, and 84	K466-10
	POWER MIG® Series and Power Wave® C300	K466-6
Tweco® Adapted	No. 2, No. 3, No. 4 Guns	K466-2
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, Swing Arc-Dual, Swing Arc-Single, S- 32S, 52D, 54D, 54E, 60 Series	K466-3

COMMON EQUIPMENT PACKAGES

The available torch package options are shown in Table A.3.

TABLE A.3

MAGNUM PRO WATER-COOLED MECHANIZED TORCH @ 100% DUTY CYCLE WITH MIXED 90 Ar/10 CO₂ GAS						
Product Number	Total Torch Length ft. (m)	Back End Connector	Contact Tip	Gas Diffuser Assembly	Gas Nozzle	Cable Liner
K5333-3-10-564	3 ft. (0.91m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-5-10-564	5 ft. (1.5m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-8-10-564	8 ft. (2.4m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-10-10-564	10 ft. (3m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-15-10-564	15 ft. (4.5m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-25-10-564	25 ft. (7.5m)	K466-10	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-25
K5333-10-FM-564	10 ft. (3m)	Fast-Mate	KP2745-564	KP4380-1	KP4120-1-75R	KP44-564-15
K5333-15-FM-564	15 ft. (4.5m)	Fast-Mate	KP2745-045	KP4380-1	KP4120-1-75R	KP44-564-15

TECHNICAL SPECIFICATIONS

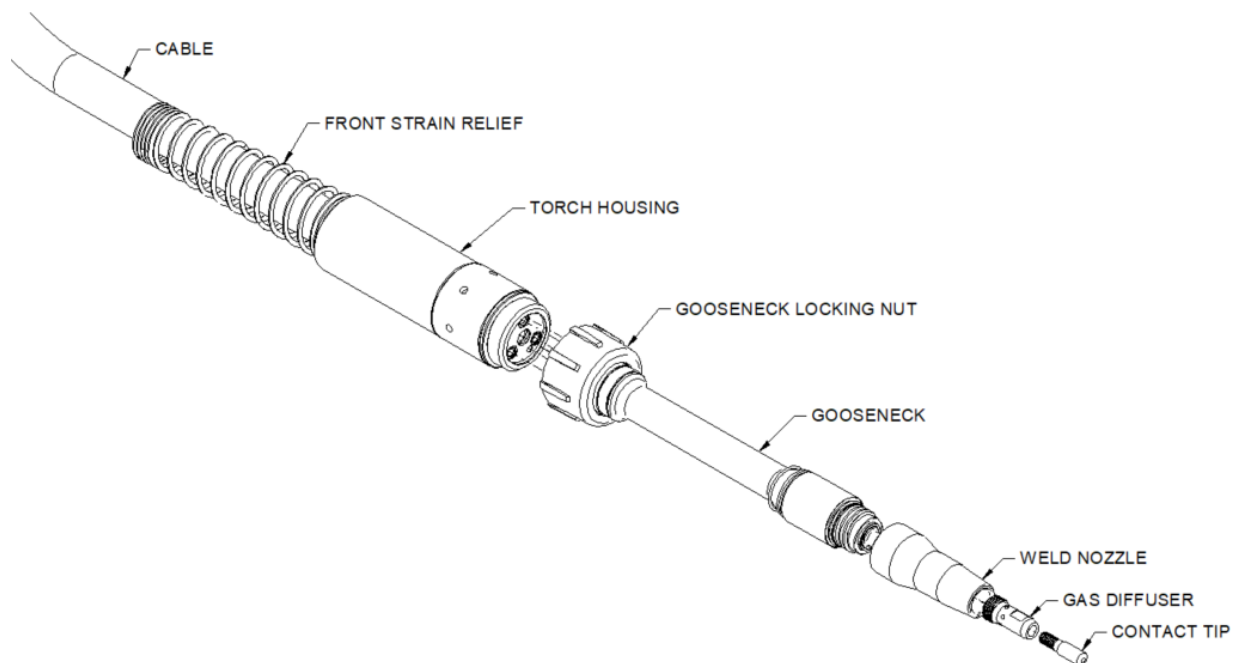
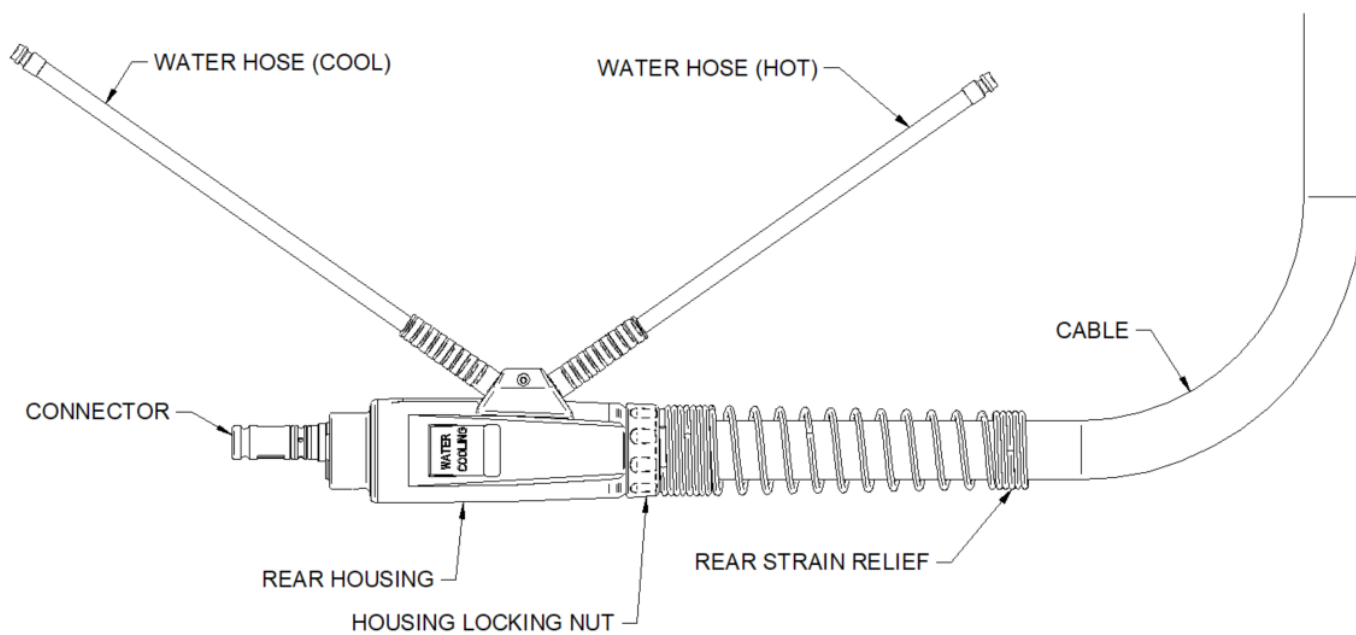
MAGNUM PRO WC MECHANIZED TORCH - 650 RATED OUTPUT IEC 60974-7	
DUTY CYCLE	AMPERES – MIXED GAS
100%	650

TEMPERATURE RANGES	
OPERATING TEMPERATURE	-4°F TO 104°F (-20°C TO 40°C)
STORAGE TEMPERATURE	-40°F TO 185°F (-40°C TO 85°C)

* This is not an IEC rating.

PHYSICAL DIMENSION OF CABLE		
PART NUMBER	LENGTH (IN)	WEIGHT (LBS)
K5333-3-10-564	25.1	10.25
K5333-5-10-564	49.1	11.75
K5333-8-10-564	85.1	14.0
K5333-10-10-564	109.1	15.5
K5333-15-10-564	169.1	19.25
K5333-25-10-564	289.1	26.75
K5333-10-FM-564	109.1	16.5
K5333-15-FM-564	169.1	20.25

WELDING PROCESSES			
PROCESS	ELECTRODE DIAMETER RANGE	OUTPUT RANGE (AMPERES)	WIRE FEED SPEED RANGE
GMAW-PULSED	.035" – 3/32" (0.8 – 2.4 MM)	650A @ 100%	SEE WIRE FEEDER LITERATURE
GMAW-STT	.035" – 3/32" (0.8 – 2.4 MM)	650A @ 100%	SEE WIRE FEEDER LITERATURE

TORCH COMPONENTS**FIGURE A.1****FIGURE A.2**

INSTALLATION

Read this entire installation section before you start installation.



WARNING

ELECTRIC SHOCK can kill.

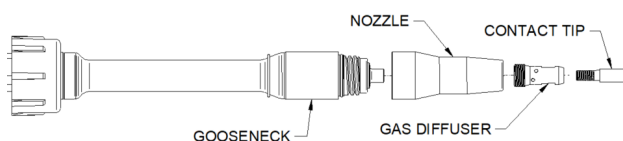
- Do not touch electrically live parts such as output terminals or internal wiring.
- Insulate yourself from the work and ground.
- Always wear dry insulating gloves.



Hardware parts breakdown included with hardware pack.

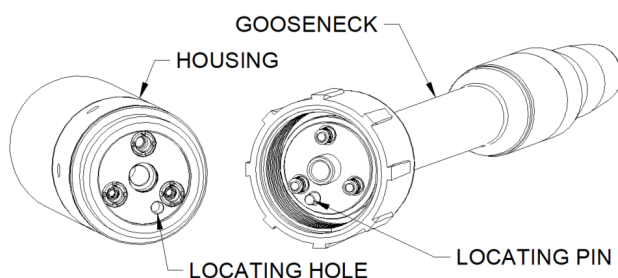
INSTALLING GOOSENECK ONTO TORCH

FIGURE B.1



1. Disassemble gas diffuser, contact tip, and nozzle from the gooseneck. (FIGURE B.1)

FIGURE B.2

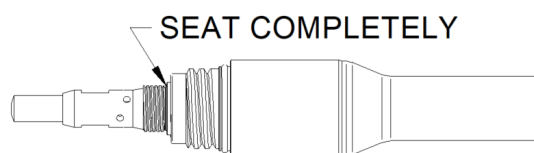


2. Align locating pin on the gooseneck with the locating hole in the housing.
3. Press gooseneck into housing completely. It is crucial to ensure that the gooseneck is completely and uniformly seated into the housing. If not properly seated, issues while welding could arise.
4. Use the gooseneck locking nut to tighten the gooseneck to the housing. This will ensure there is no wiggle while operating as well helping ensure the gooseneck is completely seated into the housing.

INSTALLING LINER AND EXPENDABLES

1. With the contact tip, gas diffuser, and nozzle removed from the end of the gooseneck, insert the appropriate liner into the back end connector pin.
2. Feed liner all the way through the torch until the liner extends out the front of the torch and gooseneck. Trim excess liner length so the liner protrudes no more than 0.2" from the end of the gooseneck threads.
3. Thread the gas diffuser onto the end of the gooseneck. Tighten the gas diffuser down until it is completely seated and flush with the shoulder on the gooseneck. (Figure B.3)

FIGURE B.3



CONNECTING TORCH AND FEEDER

(See Figure B.4)

Ensure the wire feeder has the correct adapter on the feed plate. Standard Lincoln bushing for K466-10 connector or Fast-Mate adapter for Fast-Mate torches.

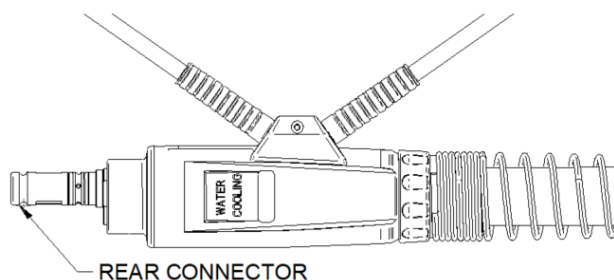
Push gooseneck into nose cone; torque to 35-40 ft. lb with KP4696-1 Gooseneck Nut Wrench (sold separately)

Trim liner to 5/8" stickout from front of gooseneck.

Install gas diffuser onto threads on gooseneck, and torque to 50- 60 in-lb (5.6-6.8 N-m.).

Install contact tip and tighten. Install gas nozzle handtight onto gooseneck until o-ring is engaged and nozzle is seated fully.

FIGURE B.4



ACCESSORIES

ELECTRODES AND EQUIPMENT

The (WC Mechanized Torch) has been designed for use with Lincoln Electric GMAW wire electrodes. Refer to the appropriate Lincoln Electric Process and Procedure Guidelines for the electrode used for information on recommended electrical and visible stickouts.

OPTIONAL KITS AND ACCESSORIES		
KP5397-22	22° GOOSENECK	INCLUDES: 1 GOOSENECK
KP5397-45	45° GOOSENECK	INCLUDES: 1 GOOSENECK
KP5397-60	60° GOOSENECK	INCLUDES: 1 GOOSENECK
KP5397-180	180° GOOSENECK	INCLUDES: 1 GOOSENECK

EXPENDABLE REPLACEMENT PARTS

Description	Part Number	Wire Diameter (In.)	Wire Diameter (mm)
CABLE LINER			
For Cables 15' (4.5 m) and less (Steel Wire)	KP44-3545-15	.035-.045"	0.9-1.2 mm
	KP44-116-15	.052-1/16"	1.3-1.6 mm
	KP44-564-15	1/16-5/64	1.6-2.0 mm
CONTACT TIPS - Pkg. Qty. - 10			
	KP2745-035	0.035"	.09 mm
	KP2745-040	0.040"	1.0 mm
	KP2745-045	0.045"	1.2 mm
	KP2745-052	0.052"	1.3 mm
	KP2745-116	1/16"	1.6 mm
	KP2745-072	0.068-0.072"	1.7-1.8 mm
	KP2745-564	5/64"	2.0 mm
GAS DIFFUSER	KP4380-1		
GAS NOZZLE - Thread-On			
1/8 Recessed, 1/2 ID	KP4523-1-50R		
1/8 Recessed, 3/4 ID	KP4523-1-75R		
1/8 Recessed, 5/8 ID	KP4523-1-62R		
Flush, 1/2 ID	KP4523-1-50F		
Flush, 3/4 ID	KP4523-1-75F		
Flush, 5/8 ID	KP4523-1-62F		
1/8 Stick Out, 1/2 ID	KP4523-1-50S		
1/8 Stick Out, 3/4 ID	KP4523-1-75S		
1/8 Stick Out, 5/8 ID	KP4523-1-62S		
GUN TUBE			
45 DEG. GUN TUBE - 500A	KP4526-45		
60 DEG. GUN TUBE - 500A	KP4526-60		
45 DEG. GUN TUBE - 400A	KP4527-45		
60 DEG. GUN TUBE - 400A	KP4527-60		

MAINTENANCE

REMOVAL, INSTALLATION AND TRIMMING INSTRUCTIONS FOR MAGNUM PRO LINERS

Refer to AutoDrive S Feeder literature for liner replacement.
For Wire Brake refer to Wire Brake Installation Section

GUN TUBES AND NOZZLES

(See Figure D-3)

1. Replace worn contact tips as required.
2. Remove spatter from contact tip, gas diffuser, and gun tube after 10 minutes of arc time or as required.
3. To remove gun tube from gun, loosen the gooseneck nut that is threaded to the torch housing assembly.
4. Pull gun tube out from housing assembly. To reinstall, insert the gun tube by aligning the locating dowel pin into the corresponding hole on the housing. Ensure the gun tube is sitting flat against the housing assembly and tighten the gooseneck nut until hand tight.

CABLE CLEANING

Clean cable liner after using approximately 150 (68 kg) pounds of electrode. Remove the cable from the wire feeder. Remove the contact tip from the gun. Using an air hose and only partial pressure, gently blow out the cable liner from the diffuser end.



CAUTION

- Excessive pressure at the start may cause the dirt to form a plug.

TROUBLESHOOTING



WARNING

Service and Repair should only be performed by Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed throughout this manual.

This Troubleshooting Guide is provided to help you locate and repair possible machine malfunctions. Simply follow the three-step procedure listed below.

Step 1. LOCATE PROBLEM (SYMPTOM).

Look under the column labeled "PROBLEM (SYMPTOMS)". This column describes possible symptoms that the machine may exhibit. Find the listing that best describes the symptom that the machine is exhibiting.

Step 2. POSSIBLE CAUSE.

The second column labeled "POSSIBLE CAUSE" lists the obvious external possibilities that may contribute to the machine symptom.

Step 3. RECOMMENDED COURSE OF ACTION

This column provides a course of action for the Possible Cause, generally it states to contact your local Lincoln Authorized Field Service Facility.

If you do not understand or are unable to perform the Recommended Course of Action safely, contact your local Lincoln Authorized Field Service Facility.



WARNING

- Turn the input power OFF at the welding power source before installation or changing drive rolls and/or guides.
- Do not touch electrically live parts.
- Welding power source must be connected to system ground per the National Electrical Code or any applicable local codes.
- Only qualified personnel should perform maintenance work.



Observe all additional Safety Guidelines detailed throughout this manual.



If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

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Observe all Safety Guidelines detailed throughout this manual

PROBLEM	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
NO WIRE FEED OCCURS.	OUT OF WIRE	INSTALL FULL SPOOL OF SPECIFIED WIRE.
	CONTACT TIP BURN BACK.	REPLACE CONTACT TIP.
	FULLY OR PARTIALLY BLOCKED GUN LINER.	REMOVE AND CLEAN OR REPLACE GUN LINER.
	BIRD NEST.	CUT OUT BIRD NEST, RELOAD WIRE, AND CHECK FOR PROPER WIRE ALIGNMENT.
	NO MOTOR VOLTAGE OR CURRENT FROM MACHINE	SEE TROUBLESHOOTING SECTION IN WELDING MACHINE'S OR WIRE FEEDER'S INSTRUCTION MANUAL.
	CONTACT TIP SIZE TOO SMALL FOR WIRE DIAMETER USED.	REPLACE CONTACT TIP WITH ONE THAT IS THE CORRECT SIZE.
SLUGGISH WIRE FEED.	DRIVE ROLL IS WORN OR GALLED	CLEAN DRIVE ROLL OR REPLACE DRIVE ROLL.
	MACHINE'S WIRE FEED SPEED SETTING IS TOO LOW.	INCREASE WIRE FEED SPEED.
	WIRE IS OBSTRUCTED SOMEWHERE ALONG THE WIRE FEED PATH IN THE GUN.	CHECK FOR OBSTRUCTIONS: REMOVE ANY WIRE SHAVINGS; REMOVE KINKED WIRE; REMOVE AND CLEAN OR REPLACE GUN LINER.
	LOW MOTOR VOLTAGE.	SEE TROUBLESHOOTING SECTION IN WELDING MACHINE'S INSTRUCTION MANUAL.
	GUN CABLE IS TWISTED.	REMOVE CABLE AND REINSTALL PER INSTALLATION INSTRUCTIONS.
	MECHANICAL RESISTANCE TO WIRE FEEDING IS TOO LARGE	REPOSITION ROBOT SO THAT CABLE IS LESS TWISTED OR BENT.
INTERMITTENT WIRE FEED.	DRIVE ROLL HAS BECOME GALLED.	REMOVE AND THEN CLEAN OR REPLACE DRIVE ROLL
	WIRE HAS BECOME KINKED ALONG ITS FEED PATH.	MANUALLY PULL WIRE SLOWLY THRU GUN UNTIL UNKINKED WIRE EMERGES
FREQUENT BIRDNESTING OR KINKING OF WIRE IN THE GUN CABLE.	WIRE SHAVINGS/LUBRICANT IS BUILDING UP IN THE CABLE.	CLEAN CABLE OR REPLACE CABLE LINER.
	CABLE LINER IS TOO LARGE FOR WIRE SIZE.	INSTALL THE SMALLEST POSSIBLE LINER WHICH IS SPECIFIED FOR THE WIRE BEING USED (I.E. USE A .052-1/16 LINER INSTEAD OF A 1/16-5/64 LINER WHEN WELDING WITH 1/16" DIAMETER WIRE.
WIRE BRAKE NOT FUNCTIONING.	AIR NOT BEING SUPPLIED.	ENSURE PROPER AIR SUPPLY
	WIRE BRAKE STUCK CLOSED.	REPAIR / REPLACE AS NEEDED



If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

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Observe all Safety Guidelines detailed throughout this manual

PROBLEM	POSSIBLE CAUSE	RECOMMENDED COURSE OF ACTION
FREQUENT OCCURRENCE OF CONTACT TIP BURNBACK.	IMPROPER WELDING PARAMETERS OR TECHNIQUE (EXAMPLE: ESO "ELECTRICAL STICK OUT" IS TOO SHORT).	SEE WELDING WIRE LITERATURE FOR PROPER SETTINGS.
	WIRE MAY BE FEEDING INTERMITTENTLY.	SEE SYMPTOMS ON INTERMITTENT OR SLUGGISH WIRE FEED.
POOR WELD BEAD APPEARANCE.	IMPROPER ELECTRODE POLARITY.	RECONNECT MACHINE'S WELDING OUTPUT TO PROPER ELECTRODE POLARITY.
	IMPROPER WELDING PARAMETERS OR TECHNIQUE.	SEE WELDING WIRE LITERATURE FOR PROPER SETTINGS.



If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your Lincoln Authorized Service Facility for technical troubleshooting assistance before you proceed.

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WARNING	<ul style="list-style-type: none"> Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground. 	<ul style="list-style-type: none"> Keep flammable materials away. 	<ul style="list-style-type: none"> Wear eye, ear and body protection.
Spanish AVISO DE PRECAUCION	<ul style="list-style-type: none"> No toque las partes o los electrodos bajo carga con la piel o ropa mojada. Aíslese del trabajo y de la tierra. 	<ul style="list-style-type: none"> Mantenga el material combustible fuera del área de trabajo. 	<ul style="list-style-type: none"> Protéjase los ojos, los oídos y el cuerpo.
French ATTENTION	<ul style="list-style-type: none"> Ne laissez ni la peau ni des vêtements mouillés entrer en contact avec des pièces sous tension. Isolez-vous du travail et de la terre. 	<ul style="list-style-type: none"> Gardez à l'écart de tout matériel inflammable. 	<ul style="list-style-type: none"> Protégez vos yeux, vos oreilles et votre corps.
German WARNUNG	<ul style="list-style-type: none"> Berühren Sie keine stromführenden Teile oder Elektroden mit Ihrem Körper oder feuchter Kleidung! Isolieren Sie sich von den Elektroden und dem Erdboden! 	<ul style="list-style-type: none"> Entfernen Sie brennbares Material! 	<ul style="list-style-type: none"> Tragen Sie Augen-, Ohren- und Körperschutz!
Portuguese ATENÇÃO	<ul style="list-style-type: none"> Não toque partes elétricas e electrodos com a pele ou roupa molhada. Isole-se da peça e terra. 	<ul style="list-style-type: none"> Mantenha inflamáveis bem guardados. 	<ul style="list-style-type: none"> Use proteção para a vista, ouvido e corpo.
Japanese 注意事項	<ul style="list-style-type: none"> 通電中の電気部品、又は溶材にヒフやぬれた布で触れないこと。 施工物やアースから身体が絶縁されている様にして下さい。 	<ul style="list-style-type: none"> 燃えやすいものの側での溶接作業は絶対にしてはなりません。 	<ul style="list-style-type: none"> 目、耳及び身体に保護具をして下さい。
Chinese 警告	<ul style="list-style-type: none"> 皮肤或湿衣物切勿接触带电部件及焊条。 使你自己与地面和工件绝缘。 	<ul style="list-style-type: none"> 把一切易燃物品移离工作场所。 	<ul style="list-style-type: none"> 佩戴眼、耳及身体劳动保护用具。
Korean 위험	<ul style="list-style-type: none"> 전도체나 용접봉을 젖은 형갑 또는 피부로 절대 접촉치 마십시오. 모재와 접지를 접촉치 마십시오. 	<ul style="list-style-type: none"> 인화성 물질을 접근시키지 마십시오. 	<ul style="list-style-type: none"> 눈, 귀와 몸에 보호장구를 착용하십시오.
Arabic تحذير	<ul style="list-style-type: none"> لا تلمس الاجزاء التي يسري فيها التيار الكهربائي أو الألكترود بجسد الجسم أو بالملابس المبللة بالماء. ضع عازلا على جسمك خلال العمل. 	<ul style="list-style-type: none"> ضع المواد القابلة للاشتعال في مكان بعيد. 	<ul style="list-style-type: none"> ضع أدوات وملابس واقية على عينيك وأذنيك وجسمك.

READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.

SE RECOMIENDA LEER Y ENTENDER LAS INSTRUCCIONES DEL FABRICANTE PARA EL USO DE ESTE EQUIPO Y LOS CONSUMIBLES QUE VA A UTILIZAR, SIGA LAS MEDIDAS DE SEGURIDAD DE SU SUPERVISOR.

LISEZ ET COMPRENEZ LES INSTRUCTIONS DU FABRICANT EN CE QUI REGARDE CET EQUIPMENT ET LES PRODUITS A ETRE EMPLOYES ET SUIVEZ LES PROCEDURES DE SECURITE DE VOTRE EMPLOYEUR.

LESEN SIE UND BEFOLGEN SIE DIE BETRIEBSANLEITUNG DER ANLAGE UND DEN ELEKTRODENEINSATZ DES HERSTELLERS. DIE UNFALLVERHÜTUNGSVORSCHRIFTEN DES ARBEITGEBERS SIND EBENFALLS ZU BEACHTEN.

			
<ul style="list-style-type: none"> ● Keep your head out of fumes. ● Use ventilation or exhaust to remove fumes from breathing zone. 	<ul style="list-style-type: none"> ● Turn power off before servicing. 	<ul style="list-style-type: none"> ● Do not operate with panel open or guards off. 	WARNING
<ul style="list-style-type: none"> ● Los humos fuera de la zona de respiración. ● Mantenga la cabeza fuera de los humos. Utilice ventilación o aspiración para gases. 	<ul style="list-style-type: none"> ● Desconectar el cable de alimentación de poder de la máquina antes de iniciar cualquier servicio. 	<ul style="list-style-type: none"> ● No operar con panel abierto o guardas quitadas. 	Spanish AVISO DE PRECAUCION
<ul style="list-style-type: none"> ● Gardez la tête à l'écart des fumées. ● Utilisez un ventilateur ou un aspirateur pour ôter les fumées des zones de travail. 	<ul style="list-style-type: none"> ● Débranchez le courant avant l'entretien. 	<ul style="list-style-type: none"> ● N'opérez pas avec les panneaux ouverts ou avec les dispositifs de protection enlevés. 	French ATTENTION
<ul style="list-style-type: none"> ● Vermeiden Sie das Einatmen von Schweißrauch! ● Sorgen Sie für gute Be- und Entlüftung des Arbeitsplatzes! 	<ul style="list-style-type: none"> ● Strom vor Wartungsarbeiten abschalten! (Netzstrom völlig öffnen; Maschine anhalten!) 	<ul style="list-style-type: none"> ● Anlage nie ohne Schutzgehäuse oder Innenschutzverkleidung in Betrieb setzen! 	German WARNUNG
<ul style="list-style-type: none"> ● Mantenha seu rosto da fumaça. ● Use ventilação e exaustão para remover fumo da zona respiratória. 	<ul style="list-style-type: none"> ● Não opere com as tampas removidas. ● Desligue a corrente antes de fazer serviço. ● Não toque as partes elétricas nuas. 	<ul style="list-style-type: none"> ● Mantenha-se afastado das partes moventes. ● Não opere com os painéis abertos ou guardas removidas. 	Portuguese ATENÇÃO
<ul style="list-style-type: none"> ● ヒュームから頭を離すようにして下さい。 ● 換気や排煙に十分留意して下さい。 	<ul style="list-style-type: none"> ● メンテナンス・サービスに取りかかる際には、まず電源スイッチを必ず切して下さい。 	<ul style="list-style-type: none"> ● パネルやカバーを取り外したままで機械操作をしないで下さい。 	Japanese 注意事項
<ul style="list-style-type: none"> ● 頭部遠離煙霧。 ● 在呼吸區使用通風或排風器除煙。 	<ul style="list-style-type: none"> ● 維修前切斷電源。 	<ul style="list-style-type: none"> ● 儀表板打開或沒有安全罩時不準作業。 	Chinese 警告
<ul style="list-style-type: none"> ● 얼굴로부터 용접가스를 멀리하십시오. ● 호흡지역으로부터 용접가스를 제거하기 위해 가스제거기나 통풍기를 사용하십시오. 	<ul style="list-style-type: none"> ● 보수전에 전원을 차단하십시오. 	<ul style="list-style-type: none"> ● 판넬이 열린 상태로 작동치 마십시오. 	Korean 위험
<ul style="list-style-type: none"> ● ابعد رأسك بعيداً عن الدخان. ● استعمل التهوية أو جهاز ضغط الدخان للخارج لكي تبعد الدخان عن المنطقة التي تتنفس فيها. 	<ul style="list-style-type: none"> ● اقطع التيار الكهربائي قبل القيام بأية صيانة. 	<ul style="list-style-type: none"> ● لا تشغيل هذا الجهاز اذا كانت الاغطية الحديدية الواقية ليست عليه. 	Arabic تحذير

LEIA E COMPREENDA AS INSTRUÇÕES DO FABRICANTE PARA ESTE EQUIPAMENTO E AS PARTES DE USO, E SIGA AS PRÁTICAS DE SEGURANÇA DO EMPREGADOR.

使う機械や溶材のメーカーの指示書をよく読み、まず理解して下さい。そして貴社の安全規定に従って下さい。

請詳細閱讀並理解製造廠提供的說明以及應該使用的銀焊材料，並請遵守貴方的有關勞動保護規定。

이 제품에 동봉된 작업지침서를 숙지하시고 귀사의 작업자 안전수칙을 준수하시기 바랍니다.

اقرأ بتمعن وافهم تعليمات المصنع المنتج لهذه المعدات والمواد قبل استعمالها واتبع تعليمات الوقاية لصاحب العمل.

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications 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, or to provide engineering advice in relation to a specific situation or application. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the definition of specifications, and the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

WELD FUME CONTROL EQUIPMENT

The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.



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