



LINCOLN ELECTRIC SUBMERGED ARC ACCESSORIES

Torch Assemblies, Expendables and More



K113

HANDHELD SUBMERGED ARC WELDING GUN



- Robust and built to last
- Simple and compact design for durability and easy maintenance
- Comes ready to weld 5/64" or 3/32" diameter subarc wire

Recommended Wire Feeders

- FlexFeed 74 HT
- FlexFeed 84

EXPENDABLES PARTS

Description	Part Number
Contact Tip, .068, 5/16-18 Thread	KP2086-1B1
Contact Tip, 1/16, 5/16-18 Thread	KP2086-2B1
Contact Tip, 3/32, 5/16-18 Thread	KP2086-3B1
Contact Tip, 5/64, 5/16-18 Thread	KP2086-4B1

REPLACEMENT PARTS

Description	Part Number	K113-1	K113-2
Flux Cone Assembly, Manual Feed	K119-1	•	•
Cone Tip, Flux, 15/16	KP1968-3	•	•
Cone Tip, Flux, 3/4	KP1968-4	•	•
Cone Tip, Flux, 5/8	KP1968-5	•	•
Nozzle Tube Assembly	KP4417-1	•	
Nozzle Tube Assembly	KP4418-1		•
Ceramic Insert	KP2094-2	•	•

PRODUCT SPECIFICATIONS

Part Number	Description	Duty Cycle Rating	Wire Diameter in (mm)	Cable Length ft (m)
K113-1	Handheld Submerged Arc Welding Gun	100% @ 600A	5/64	15 (4.5)
K113-2			3/32	



K114

HANDHELD SAW GUN DESIGNED FOR MECHANIZED APPLICATIONS

Recommended Wire Feeders

- FlexFeed 74 HT
- FlexFeed 84



EXPENDABLES PARTS

Description	Part Number
Contact Tip, 3/32, 3/8-16 Thread	KP2088-2B1
Contact Tip, 5/64, 3/8-16 Thread	KP2088-3B1
Contact Tip, 7/64, 3/8-16 Thread	KP2088-4B1

REPLACEMENT PARTS

Description	Part Number
Nozzle Flux Cone 13/16 in. Opening	KP1968-2
Nozzle Flux Cone 5/8 in. Opening	KP1968-5
Nozzle Flux Cone 3/4 in. Opening	KP1968-4
Nozzle Flux Cone 15/16 in. Opening	KP1968-3
Contact Tip [3/32 in.]	KP2088-2B1
Contact Tip [5/64 in.]	KP2088-3B1

PRODUCT SPECIFICATIONS

Part Number	Description	Duty Cycle Rating	Wire Diameter in (mm)	Cable Length ft (m)
K114	Hand Mechanized Submerged Arc Welding Gun	100% @ 600A	5/64 - 3/32	15 (4.5)



K231

SUBMERGED ARC CONTACT NOZZLE ASSEMBLY

K231 contact assemblies are robust SAW accessories able to perform at high levels in a wide range of subarc welding applications.

Recommended Equipment

- LT-7 Tractor
- Cruiser Tractor, Tandem Cruiser Tractor
- NA-3, NA-4, NA-5 Controls & Feedheads
- MAXsa Controls & Feedheads

REPLACEMENT PARTS

Description	Part Number
Flux Cone	KP2085-1
Flux Cone, 15/16"	KP2085-2
Adapter (5/16-18 Female Thread) for 0.035-3/32 KP2100 Tips	KP1992-1
Nozzle Insert for 5/64 in. Wire (For LAF-[] & LT-34)	KP2121-2



FLUX BODIES

K231 Contact Assemblies come standard with Concentric flux bodies that direct flux to the arc, ensuring that the puddle is covered without wasting flux. Additional flux bodies are available for tandem-arc SAW and are designed to provide optimal flux coverage of two welding arcs.

REPLACEMENT PARTS

Part Number	Description	Amperage Rating	Compatible SAW Torch
K4984-1	Tandem Flux Body	600 A	K231-1
K4984-2	HD Tandem Flux Body	1200 A	K231-2

PRODUCT SPECIFICATIONS

Part Number	Description	Max Current	Duty Cycle	Wire Diameter in (mm)
K231-1	Submerged Arc Contact Nozzle Assembly	600 A	100% @ 600A	1/16 7/32 (1.5-5.5)
K231-2	HD Submerged Arc Contact Nozzle Assembly	1200 A	100% @ 1200A	



K231 EXPENDABLES

Contact Tips



Extended Life vs. Severe Duty

Lincoln Electric SAW contact tips use copper alloys designed to withstand extreme heats. **Extended Life** tips are a chrome zirconium alloy, and **Severe Duty** tips are made of a beryllium-copper alloy to increase hardness, making these our most wear resistant tips.



Standard vs Tapered

Standard contact tips are best for multi-purpose SAW and can withstand higher amperages than tapered tips. **Tapered tips'** smaller profile makes them favorable in applications with tighter joints

Wire Diameter	Extended Life	Severe Duty - Standard	Severe Duty - Tapered
1/16	KP3162-6B1	KP1962-6B1	KP5162-116
5/64	KP3162-7B1	KP1962-7B1	KP5162-564
3/32	KP3162-3B1	KP1962-3B1	KP5162-332
1/8	KP3162-1B1	KP1962-1B1	KP5162-18
5/32	KP3162-4B1	KP1962-4B1	KP5162-532
3/16	KP3162-2B1	KP1962-2B1	KP5162-316
7/32	KP3162-5B1	KP1962-5B1	-

Nozzle Extensions

Nozzle extensions improve accessibility, which is important when using tandem setups to fit multiple feed heads and make sure electrodes feed at the right angle. Nozzle Extensions can also improve accessibility with more-confined joint designs.

Heavy duty and standard nozzle extensions are compatible with both K231 contact assemblies.



Nozzle Extension Type	Standard	Heavy Duty
3 in.	KP2721-3	KP4985-3
5 in.	KP2721-1	KP4985-1
9 in.	KP2721-9	KP4985-9
12 Degrees	KP5165-12	KP5166-12
30 Degrees	KP5165-30	KP5166-30
45 Degrees	KP2721-2	KP5166-45



K148

SAW POSITIVE CONTACT NOZZLE ASSEMBLY

- Positive contact spring ensures constant contact between wire and contact tip.
- A K148 Contact Assembly is required for extended stickout applications

Recommended Equipment

- LT-7 Tractor
- Cruiser Tractor, Tandem Cruiser Tractor
- NA-3, NA-4, NA-5 Controls & Feedheads
- MAXsa Controls & Feedheads



REPLACEMENT PARTS

Description	Part Number
Guide Tube Assembly, 3/32-1/8 in. Wire	KP1974-1
Guide Tube Assembly, 5/32-3/16 in. Wire	KP1974-2
Guide Tube Assembly, .068-5/64 in. Wire	KP1974-3
Nozzle Tip [3/32-3/16]	KP1973-1
Nozzle Tip [.068-5/64]	KP1991-1
Inner Guide	KP1980-1

EXPENDABLES PARTS

Description	Part Number
Nozzle Tip [3/32-3/16"]	KP1973-1
Nozzle Tip [.068-5/64"]	KP1991-1

PRODUCT SPECIFICATIONS

Part Number	Description	Max Current	Duty Cycle	Wire Diameter in (mm)
K148A	Positive Contact Assembly	1100 A	100% @ 1100 A	3/32-1/8 [2.3-3.1]
K148B				5/32-3/16 [3.9-4.7]



EXTENDED STICK OUT OPTIONS

ESO and Deposition Rates

Long stick-out has 50% higher deposition rates than standard stick-out

- Very low additional investment
- Low heat input
- Flux-wire ratio reduction

K149-5/32

- Extended Stick Out (ESO) Extension
- Compatible with K148 single wire contact assemblies
- Excellent durability



INCLUDED PARTS

Description	Part Number
Extension Tube - 2 in. Long	KP1975-2
Extension Tube End (2 3/4 Electrical Stickout)	KP1976-3
Extension Tube End (2 1/4 Electrical Stickout)	KP1990-1
Extension Tube End	KP1976-1
Extension Tube End	KP1976-4
Extension Tube End	KP1976-2

K5428-1

- Long Stick Out (LSO) Extension
- Compatible with K148 single wire contact assemblies
- Flux delivery system is screwed onto extension to ensure proper alignment.
- Extension and flux nozzle widths are minimized for superior accessibility

REPLACEMENT PARTS

Description	Part Number
Long Stick out Nozzle	KP5542-1
Flux-Feeding Nozzle	KP5429-3
Flux-Nozzle Holder	KP5429-4
Replacement Screw Kit	KP5429-5





TWIN-ARC ASSEMBLIES

K129

TINY TWINARC

Upgrading a SAW cell from a single-electrode configuration to a Tiny-Twinarc two-wire configuration is a low cost option for increasing productivity. Using the same power source, feeder, and controller, the two wires are simultaneously fed through a twinarc assembly into one puddle



REPLACEMENT PARTS

Description	Part Number
Guide Tube	KP2092-2
Contact Tip .052 Wire	KP1979-2
Contact Tip 1/16 Wire	KP2100-2B1
Contact Tip 5/64 Wire	KP2100-4B1
Contact Tip 3/32 Wire	KP2100-3B1
Tip Holder -1/16, 5/64 & 3/32 Wire	KP1988-1
Nozzle Insert	KP2094-4
Tip Holder	KP2171-1
Drive Roll - .045 & .052 Wire	KP1888-1
Drive Roll - 1/16 & 5/64 Wire	KP1888-2
Drive Roll - 3/32 Wire	KP1889-1
Wire Guides - .045 & .052 Wire	KP1970-1
Wire Guides - 5/64 & 3/32 Wire	KP1970-3
Incoming Wire Guide Assembly	KP2122-1

TINY TWINARC WIRE KITS

Description	Part Number
.045 in. Wire Kit	KP1901-1
1/16 in. Wire Kit	KP1901-2
3/32 in. Wire Kit	KP1901-3
5/64 in. Wire Kit	KP1901-4

Tiny Twinarc kits come with the parts needed to weld with a specific wire size. KP1901 wire kits come with the drive rolls, wire guides, and contact tips needed to change wire sizes.

PRODUCT SPECIFICATIONS

Part Number	Description	Max Current	Duty Cycle	Wire Diameter in (mm)
K129-1/16	Tiny Twinarc Nozzle	1500 A	80% @ 1000 A	1/16 (1.5)
K129-3/32				3/32 (2.3)
K129-5/64				5/64 (1.9)



TWIN-ARC ASSEMBLIES

K225

LARGE WIRE TWIN ARC CONTACT JAW

Like Tiny-Twinarc SAW, large wire twinarc configurations increase deposition rates for higher productivity with minimal cost investments. The K225 twinarc contact jaw assembly is designed for wire diameters 5/64-1/8 in.

REPLACEMENT PARTS

Description	Part Number
Electrode Guide Tube	KP2084-1
Outer Drive Rolls	KP1889-1
Wire Guide Tubes - Upper & Lower	KP1982-1



K225 Contact assemblies are compatible with standard subarc wire sizes and have two spring-loaded jaws for consistent electrical contact and stickout, so no additional contact tips are needed

PRODUCT SPECIFICATIONS

Part Number	Description	Max Current	Duty Cycle	Wire Diameter in (mm)
K225	Large Wire Twinarc Nozzle	1000A	80% @ 1000 A	5/64-1/8 (1.9-3.1)

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