

Service Notice Number: 20200702-2

Date: July 2, 2020

To: Domestic and International Lincoln Authorized Service Facilities, Domestic and International Lincoln Electric Service Departments, Domestic and International Sales Offices

Potential Failure of Control Board

Products Covered:

Machine	Code #	Serial Range
LN-25, CONTACTOR, SOLENOID	11283	U1191200472-U1200500829
LN-25 IRONWORKER	11752	U1191201739-U1191200522
LN-25 PIPE	11693	U1191103359-U1200200044
LN-25 PRO DUAL POWER	11749	U1191101864-U1200400298
LN-25 PRO DUAL POWER EURO	11751	U1200204301-U1200409381
LN-25-PRO	11746	U1191103451-U1200509397
LN-25X EXTRA TORQUE NO FLOWMETER	12872	U1191103680-U1200503297
LN-25X NO FLOWMETER	12869	U1191106495-U1200508497
LN-25X W/ FLOWMETER	12870	U1191103036-U1200510584
LN-25X (RED-D-ARC) NO FLOWMETER	12873	U1191004561-U1200301417
LN-25X CE W/ FLOWMETER	12871	U1191100792-U1200409326
ACTIV8X	12759	U1191106684-U1200504503
ACTIV8X CE	12877	U1191105471-U1200507202
ACTIV8X (NASSCO)	SPLC81518	U1191103860-U1191103994

Symptoms:

The wire feeder may experience one or more of the following symptoms:

- The wire feeder appears to not turn on
- The motor runs wide open, feeding wire without the gun trigger being compressed
- Components on the control board are visibly damaged

Recommended Actions:

For products that fall within the serial number ranges listed above (“Covered Products”), and are experiencing one of the Symptoms listed above:

- First, check to see if the Covered Product has already been repaired by Lincoln Electric (a “Repaired Product”). A Repaired Product will have a yellow dot on the control box, and a blue dot on the G4784-1C2 or L12253-5J0 hardware label located in the corner of the control board.
- If the Covered Product is a Code 11283, check the hardware version on the Control PC Board. This notice only applies to hardware versions L12253-5H2 and L12253-5J0.
- For all other Covered Products, check the hardware version on the Flexible PC Board. This notice only applies to hardware version G4784-1C2.



LN-25 X/LN-25 Pro



Activ8X



LN-25 (K449)



- Submit a machine warranty claim on lincolnelectric.com or contact your local Lincoln Electric entity for assistance with claim processing. Replacement parts are listed by code in the table below.

Machine	Code #	Replacement
LN-25,CONTACTOR,SOLENOID	11283	9SL12253-5
LN-25 IRONWORKER	11752	9SS28442-4
LN-25 PIPE	11693	9SS28442-4
LN-25 PRO DUAL POWER	11749, 11751	9SS28442-4
LN-25-PRO	11746	9SS28662-4
LN-25X EXTRA TORQUE	12872	9SS33348-2
LN-25X	12869,12870, 12873, 12871	9SS33349-2
ACTIV8X	12759, 12877, SPLC81518	9SS32862-2

⚠ WARNING:

Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty.

Service and repair should only be performed by Lincoln Electric Factory Trained Personnel. If for any reason, you do not understand the test procedures or are unable to perform the test/repairs safely, contact the Lincoln Electric Service Department for electrical troubleshooting assistance before you proceed. If in the United States or Canada Call 1-888-935-3877 or email service@lincolnelectric.com. If you are located outside of the United States or Canada, please reach out to your local Lincoln Electric entity.

Repair Procedure: To locate the repair procedure, login to the service navigator (parts.lincolnelectric.com) and search for the relevant code number to find machine service manual. Click SERVICE MANUAL, followed by REMOVAL AND REPLACEMENT PROCEDURE, and then BOARD REMOVAL AND REPLACEMENT PROCEDURE.

Please contact Lincoln Electric with the subject line “SN 20200702-2” if you have any questions or need assistance. If in the United States or Canada email service@LincolnElectric.com. If you are located outside of the United States or Canada, please reach out to your local Lincoln Electric entity.

Jennifer Shafarenko
 Manager, Customer Service