X-TRACTOR® 2 FUME GUN

FUMES DON'T STAND A CHANCE



Shown: X-Tractor 2 Fume Gun
K5271-1

Portable Welding Fume Extractor

The Lincoln Electric X-Tractor® 2 Fume Gun is a high vacuum extraction system designed for the removal and filtration of welding fume when connected to a welding nozzle, fume gun or robotic on torch application. This unit is a great choice for fume removal in medium to heavy duty welding applications typically used in heavy fabrication, ship building and maintenance shops due to the mobility and self cleaning filters. The X-Tractor 2 Fume Gun is designed for Industrial high production applications due to the high 180 SCFM with high static pressure and large 160 sq. ft. of self cleaning filter media.

- » High SCFM controlled at the unit (180 SCFM)
- » Large filter versus the competition
- » 160 sq. ft. of filter media
- » Long lasting, easy to change filter
- » Automatic self cleaning

Note: Customer supplied compressed air.

Processes »
Stick, TIG, MIG, Flux-Cored

Input »
3 PHASE 60 Hz

Product Number »
K5271-1 X-Tractor 2 Fume Gun 460/3/60
K5271-2 X-Tractor 2 Fume Gun 208-230/3/60
K5271-3 X-Tractor 2 Fume Gun 575/3/60

Publication E13.22 | Issue Date 10/26
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KEY FEATURES

- **Automatic self cleaning**
- **VFD controlled - 4 HP**
- **SCFM Control at the unit 180 max. SCFM or 150 SCFM when connected to two fume guns.**
- **Infinitely variable fan speed control knob** – Conveniently located on the front panel allowing control of SCFM to ensure shielding gas is not disturbed.

Unit

- **Particulate Tray** – Large, self-contained particulate tray for easy emptying
- **Mobile** – With two large rear wheels, the X-Tractor 2 Fume Gun is easy to move around
- **Minihelic Filter Gauge** – Differential pressure gauge measures the pressure drop across the filter to monitor filter life and order replacement filters.
- **Easy to Change Filters** – Easily change filters with a 3/8 in. hex driver in less than two minutes

WHAT'S INCLUDED

BASE UNIT INCLUDES

- (2) Inlet Spark Arrestors
- Inlet Plug
- MERV 16 (HE), NANO FILTER
- (2) Cable Management Brackets
- 20 ft. (6 m) Power Cable

RECOMMENDED ACCESSORIES

Extraction Hoses, 1-3/4 in. Diameter
Flexible high temperature hoses with spring steel reinforcement. Standard hose to connect the various extraction devices to the X-Tractor 2 base units.

Order K2389-8 16 ft. (4.8 m)
K2389-9 8 ft. (2.4 m)
K3492-4 1-3/4 in. to 2 in. adapter*

*Required for use with hose kits, 2 per hose.

KEY CONTROLS

1. Power On (Light)
2. Alarm (Light)
3. Fan Running (Light)
4. Reset Drive Alarm & Manual Clean
5. Start/Stop Fan
6. Fan Speed Adjustment Dial
7. Remote Start Inputs A
8. Remote Start Inputs B
9. Main Switch - Input Power
10. Filter Differential Pressure Gauge



High Vacuum Product Application

High vacuum welding fume extraction systems utilize high pressure of 70-90 inches of water column and low volume of 50-100 cu. ft./min with an air speed of 4000-5000 ft/min. The air handling configuration of high vacuum equipment allows the use of small diameter rigid duct and small diameter flexhose to easily reach extraction points. It is ideal for applications such as short welds when using fume suction nozzles or larger fixture welding using integrated fume extracting guns. This process is designed for close proximity source extraction from 2-4 in. to the welding source. The smaller size of hoses and suction nozzles than those of low vacuum systems, makes it easier to carry the fume gun, extraction nozzle and/ or flex hose into confined spaces – depending on the type of welding, base material, consumable used and arc time. The mobility of the suction devices allows the main filter unit to be kept at a central location.

IDEAL APPLICATIONS

The X-tractor 2 Fume Gun is a versatile source capture fume extractor that can be used in several applications in conjunction with our other products to create a low cost fume system. The X-Tractor 2 Fume Gun can be used with the following:

Fume Guns



On-Torch Robotic Systems



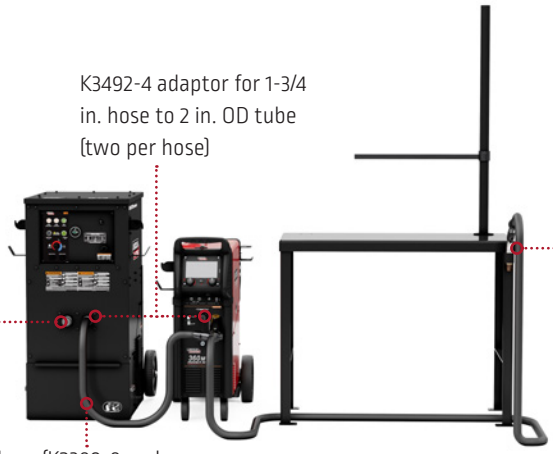
Fume Extraction Nozzles



FUME EXTRACTION GUNS

The X-Tractor 2 Fume Gun is designed to be used with up to two manual fume guns[1]. With an integrated automatic self-cleaning filter system, it is ideal for welding large parts at a high duty cycle. This can also be used for welding smaller parts on a table in an education environment. The Magnum® PRO Fume guns provide a premium fume welding gun experience by placing focus on not only welding performance but also operator comfort. The Infinite SCFM control allows for maximum air flow control to extract the fume without disruption to the shielding gas.





For K2389-8 and K2389-9 hose kits, remove the 1-3/4 in. hose to 1-34 in. tube adapters and replace with K3492-4 1-3/4 in. hose to 2 in. adapters

Note:
K2389-9 Hose Kit, 8 ft.
K2389-8 Hose Kit, 16 ft.

1 For Robotic applications, it is recommended that each setup has its own X-Tractor 2.

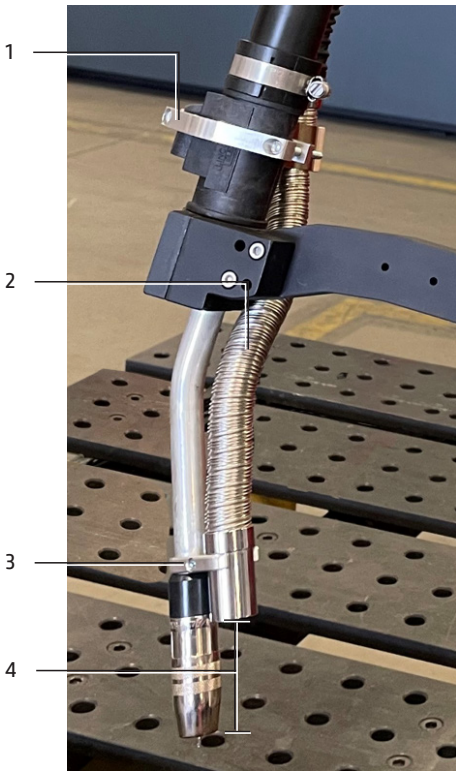
ON-TORCH ROBOTIC APPLICATIONS

KEY FEATURES

The X-Tractor 2 is an integral part of the On-Torch fume extraction system for robot and cobot applications. When coupled with one of our on-torch extraction kits, fume can be captured at the source. Easily control the SCFM on the front of the unit based on your needs to optimize fume extraction without disturbing the shielding gas. This product pairing creates a cost effective, easy-to-use fume system.

- **High Vacuum** - High local pressure where low volumes of air are being extracted.
- **Source Capture** - Capture up to 90% of the fume at the source without interrupting the shielding gases
- **Energy Efficient** - Uses a lower SCFM compared to robotic hoods
- **Simple to Install** - Kit includes the tools and parts you need for simple set up
- **Versatile** - Use with both air and water cooled torches

1. Torch body diameter
2. Suction nozzle set formed to the shape of the torch
3. Torch goose neck diameter
4. Target distance is 3 - 3.5 in. (75 - 90 mm)



Recommended Applications

- Low cost alternative that collects the majority of welding fume
- Some exotic materials may require redundant fume extraction where On-Torch can be paired with fume hood applications
- For robot hood Applications that require crane access to load the parts and would interfere with a fume hood



Note: For Robot and Cobot applications, it is recommended that each setup has its own X-Tractor 2. Attention needs to be paid to the mechanical envelope around the torch. In some cases, the torch tool path needs to be modified to allow for On-Torch part clearances.

ON-TORCH ROBOTIC KIT INCLUDES

- Suction Nozzle Set
- Torch Body Clamp
- Torch Neck Clamp
- Hose Clamp
- Cinch Clamp
- Reducer, 1 - 1.75 in. (25 - 45 mm)
- Adapter, 1.75 x 2 in. (44.5 x 50.8 mm)
- 50 ft. (15.2 m) 1.75 in. (45 mm) Hose for Robot and Cobot Applications.

FUME EXTRACTION NOZZLES

Nozzle applications work well with small production parts or educational welding plates that require a small fixed fume extraction area. There are several types of nozzles that can be pared with different part geometry.

GENERAL OPTIONS



EN 20 Extraction Nozzle
The EN 20 nozzle is designed for a wide array of welding applications. With its funnel extraction opening and magnetic mounting stand, the EN 20 gives the welder a greater amount of versatility.
Order K2389-5



SHM Aluminum Suction Nozzle
Includes S20591-7 adapter for 1 3/4 in. (45 mm) hose. Best capture distance:~ 1-1/2 in. (38 mm).
SHM-300 Nozzle - 12 in. (300 mm)
Order K639-1



UNM Suction Nozzle for Heavy Smoke
8 in. (200 mm) aluminum suction nozzle with magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: < 4 in. (100 mm)
Order K639-6



SHFA Flat Suction Nozzle
150 mm (6 in.) aluminum suction nozzle with 20 in. (500 mm) flexible steel hose and magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance: < 4 in. (100 mm).
Order K639-5



SHMS-400 Low Noise Nozzle
16 in. (400 mm) aluminum suction nozzle with magnetic mounting. Includes S20591-7 adapter for 1-3/4 in. (45 mm) hose. Best capture distance:~ 1-1/2 in. (38 mm).
Order K639-4



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



NOTE: Gun not included, sold separately

NKT Nozzle Kit for MIG Guns
The NKT Nozzle Kit provides extraction capacity to a standard MIG welding gun. Nickel plated brass nozzle slips over the gun's gas nozzle and secures with screw.
Kit includes:
1 – Nozzle
1 – Adapter, Hose to Tube, 1 to 1 in.
1 – Hose, 1 in. (ID), 8 ft. (2.4 m)
1 – Connector, Hose-to-Hose, 1 to 1-3/4 in. (25.4 - 45 mm)
Order K2389-3



Tapered Plug
For single fume gun use.
Order K5412-1



Spark Arrestor Kit for Fume Gun
Application Mounts to exhaust tube prevent captured sparks from entering the unit.
Order K1898-1



Current activated start/stop sensor
Order K2752-4



Undercarriage Kit
Undercarriage kit allows X-Tractor 2 Fume Gun System to be easily moved by hand.
Order K5540-1



Extraction hose 1-3/4 in. (45mm) I.D.
Order K2389-8 16 ft. (5 m) Long
K2389-9 8 ft. (2.5 m) Long

FILTER REPLACEMENTS



KP5178-1 FILTER, MERV 11, POLYESTER
Recommended for Steel Welding Applications



KP5178-4 FILTER MERV 11 Oil Resistant
Recommended for Oil Resistant / Welding on Stamped Parts



KP5178-2 FILTER, MERV 16, Cellulose/Nano
Recommended for Steel, Stainless Steel, and Galvanized Welding Applications



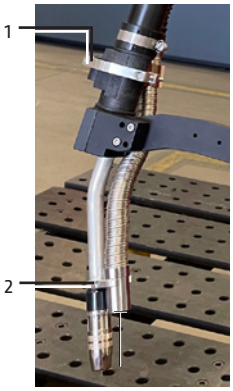
KP5178-3 FILTER, MERV 16, PTFE
Recommended primarily for cutting applications, and for some heavy fume welding



KP5178-5 FILTER MERV 16 Oil Resistant
Recommended for oil resistance, for welding on steel, stainless steel and galvanized stamped parts

ON-TORCH FUME EXTRACTION KITS

Product Number (50 ft Hose)	Torch Body Diameter in (mm)[1]	Torch Goose Neck Diameter in (mm)[2]	Lincoln Electric Robotic Torch Compatibility
K6041-1	1.97 - 3.94 (50 - 100)	0.71 - 0.91 (18 - 23)	K3359-XX, K5415-XX, K2647-XX, K5481-XX and K3593-XX



1. Torch body diameter shown as callout 1 in image.
2. Torch goose neck diameter shown as callout 2 in image.

FUME EXTRACTION GUNS

Product Number	Input Current
K4463-2	250A
K4464-2	350A

HOSES AND CONNECTORS

Product Number	Length ft (m)	Diameter in (mm)
K2389-8	16 (4.8)	1-3/4 (44.5)
K2389-9	8 (2.4)	1-3/4 (44.5)
K3492-4	—	1-3/4 - 2 in. (44.5 - 50.8) Adapter

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power Voltage / Phase / Hertz	Input Current	H x W x D in (mm)	Net Wt lbs (kg)
X-Tractor 2 Fume Gun Base Model	K5271-1	460/3/60	5.2 A	44.8 x 26.1 x 32.3 (1138 x 663 x 820)	335 (152)
	K5271-2	208-230/3/60	10.5 - 10.3 A		335 (152)
	K5271-3	575/3/60	3.8 A		

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.

Lincoln Electric Product Claim - Weld fume control products manufactured by The Lincoln Electric Company are designed to be utilized as an engineering safety control to aide in achieving adequate ventilation while conducting welding or it's allied processes. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, and the specific welding procedure and application involved. When the equipment is used as designed - and when properly installed, operated and maintained - it can be a valuable and effective tool to help employers maintain adequate ventilation in the workplace. Lincoln Electric defines adequate ventilation as that which is required to maintain occupational exposure levels below the applicable exposure limits when sound work practices are utilized. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.

Lincoln Electric, weld fume control, products are highly effective at decreasing the occurrence level of thermal events, however thermal events can still happen even if the system is operating as designed.

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, cutting equipment and EV charging systems. 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.

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