

SP-180T

Processes

MIG, Flux-Cored

Product Number

K2689-2

See back for complete specs

Input Power

208/230/1/60

Input Current at Rated Output

20A

Rated Output Current/Voltage/Duty Cycle

208: 130A/17.6V/30%

230: 130A/20V/30%

Output Range

30-180 Amps DC

50-500 ipm WFS

(1.3-12.7 m/min)

Max. OCV: 34

Weight/Dimensions (H x W x D)

64 lbs. (29 kg)

13.65 x 10.38 x 18.16 in.

(347 x 264 x 461 mm)

208/230 Volt AC Input Compact Wire Welder

The SP-180T can help you get it done for farm, light fabrication, auto or home projects. Just plug it into a 208 or 230 volt outlet in your garage, barn or shop.

FEATURES

- ▶ **Superior Arc Performance** – Forgiving arc and simple tapped voltage control make dialing in your application easy. Smooth arc starts with minimal spatter. Wide 30-180 amp welding output range.
- ▶ **Precise Wire Drive** – Precision full adjustment drive system reduces chance of wire tangling and crushing. Brass-to-Brass gun connections for enhanced conductivity. Large industrial closed-design drive motor for improved torque and trouble-free performance.
- ▶ **No Hassle Tool-less Design** – for wire spool mounting, wire drive service and polarity changes.
- ▶ **Spool Gun Capable** – Add the economical Magnum® 100SG spool gun for enhanced aluminum wire feeding performance.
- ▶ **Toughest PC Board Protection in the industry** – 'Potted' to seal sensitive components from the environment, 'trayed' in a tough plastic tray to add rigidity and shock resistance.

APPLICATIONS

- ▶ **Metal Fabrication**
- ▶ **Maintenance and Repair**
- ▶ **Autobody/Farm**
- ▶ **Light Industrial**



Shown K2689-2

WHAT'S INCLUDED

K2689-2 Includes:

- ▶ Magnum® PRO 100L gun, 10 ft. (3.0 m)
- ▶ Gas and Gasless Nozzles
- ▶ Gas Diffuser
- ▶ Cable Liner
- ▶ .025 in. (0.6 mm) and .035 in. (0.9 mm) Contact Tips
- ▶ Work Cable and Clamp
- ▶ Adjustable Gas Regulator and Hose
- ▶ Spindle Adapter
- ▶ Full Size Spool of .025 in. (0.6 mm) SuperArc® L-56® Mild Steel MIG Wire
- ▶ Full Size Spool of .035 in. (0.9 mm) Innershield® NR-211-MP Flux-Cored Wire
- ▶ Learn-To-Use DVD
- ▶ .025 - .030 in. (0.6 - 0.7 mm) and .035 in. (0.9 mm) Smooth Drive Rolls for MIG
- ▶ .030 - .045 in. (0.7 - 1.1 mm) Knurled Drive Roll for FCAW

INPUT



OUTPUT



Two Year Extended
Warranty Available in
the U.S.A. and Canada



THE LINCOLN ELECTRIC COMPANY

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PERFORMANCE PLUS

SP-180T Welding Capabilities

Process	Wire Dia. (in.)	24ga.	22ga.	20ga.	18ga.	16ga.	14ga.	12ga.	10ga.	3/16"	1/4"	5/16"	3/8"	1/2"
Flux-Cored Welding – Steel	.030													
	.035													
	.045													
MIG Welding – Steel	.025													
	.030													
	.035													
MIG Welding – Aluminum	.035													

SP = Single Pass
MP = Multiple Pass

L12603-3



KP2529-2 Shown

DRIVE ROLL AND WIRE GUIDES		
Product Number	Wire Diameter in. (mm)	Type/Process
Drive Rolls		
KP2529-1	.025 - .030 (0.6 - 0.8)	Smooth/MIG
KP2529-2	.035 (0.9)	Smooth/MIG
KP2529-3	.030 - .045 (0.8 - 1.1)	Knurled/Flux-Cored

RECOMMENDED ACCESSORIES

GENERAL OPTIONS

Welding Cart

Full-featured cart is designed to store and transport a welder, 80 cubic foot gas cylinder, welding cables and accessories. Includes an angled top shelf for easy access to welder controls, a lower tray for added storage space, a sturdy handle also used as a convenient cable wrap hanger.

Order K2275-1

Utility Cart

Heavy duty cart stores and transports welder, 150 cubic foot shielding gas cylinder, welding cables and accessories. Includes stable platforms for welder and gas bottle platform, lower tray for added storage capacity and adjustable height handle.

Order K520

Small Canvas Cover

Protect your welder when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent. Includes a convenient side pocket to hold your welding torch or gun.

Order K2377-1

Spot Timer Kit

This timer allows you to set a fixed weld time of up to 10 seconds that is initiated when you pull the gun trigger. Ideal for making consistent spot welds on thin sheet metal.

Order K2525-1

WIRE FEEDER OPTIONS

Magnum® 100SG Spool Gun

Designed to easily feed 4 in. (102 mm) diameter 1 lb. (0.45 kg) spools of .030 in. (0.8 mm) or .035 in. (0.9 mm) diameter SuperGlaze® aluminum MIG wire. Includes gun, adapter kit, .035 in. (0.9 mm) contact tips (qty. 3), gas nozzle, and a 1 lb. (0.45 kg) spool of SuperGlaze® 4043 .035 in. (0.9 mm) MIG wire. Packaged in a convenient carrying case.

Order K2532-1

.045 Innershield® Welding Kit

Includes everything required to weld with .045 in. (1.1 mm) Innershield® self-shielded flux-cored wire. Includes an .035-.045 in. (0.9-1.1 mm) Magnum® 100L gun liner, a .045 in. (1.1 mm) contact tip, a gasless nozzle, knurled drive roll, .045 in. (1.1 mm) inner wire guide and a 10 lb. (4.5 kg) spool of .045 in. (1.1 mm) Innershield® NR®-212 wire.

Order K2528-1

Welding Fume Extractors

Lincoln Electric offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.

Request Publication E13.40

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
SP-180T	K2689-2	208/230/1/60	208: 130A/17.6V/30% 230: 130A/20V/30%	20A	30-180 Amps DC 50-500 ipm WFS (1.3-12.7 m/min) Max. OCV: 34V	13.65 x 10.38 x 18.16 (347 x 264 x 461)	64 (29)

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

CUSTOMER ASSISTANCE POLICY

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