

LN-25 PRO WIRE FEEDERS

SEMI-AUTOMATIC WIRE FEEDERS



Shown:
LN-25X w/CrossLinc™ K4267-1

PORTABLE INDUSTRIAL WIRE FEEDERS

LN-25 PRO series wire feeders are designed to be simple, reliable and easy to service. Whether you are an ironworker, pipeline welder, or weld at a construction site, shipbuilding facility or metal fabrication shop, we have the right semiautomatic wire feeder for you.

Processes »

MIG, MIG-STT[®], Pulsed, Flux-Cored

Applications »

Pipe, Metal Fabrication, Construction, Shipbuilding, Rental Fleet

Output »



Input »



All Models
Across the Arc



K2614-6 Only
Control Cable

Product Numbers »

K2613-5 PRO Standard
K2614-6 PRO Dual Power
K4267-1 X w/ CrossLinc™

[®] STT™ capability only with K2614-6 Dual Power Model.

FEATURES

- **Maxtrac® Wire Drive System** – Heavy-duty cast aluminum wire drive system provides reliable feeding and durability.
- **Dual Range Wire Feed Speed** – Delivers greater precision at low end wire feed speeds.
- **Trigger Interlock Switch** – Provides operator comfort for long welds.
- **Replaceable and Flame Resistant Case** – Rugged and durable case can be replaced in less than five minutes.
- **Potted PC Boards** – For moisture and corrosion protection.

WHAT'S INCLUDED

STANDARD/DUAL POWER

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

X w/ CROSSLINC™

Features everything included with the LN-25 Pro. This also includes:

- CrossLinc™ communications with Flextec 350x power source, enabling voltage control at the feeder without a control cable

CHOOSE THE RIGHT MODEL FOR YOUR APPLICATION

	LN-25 PRO	LN-25X w/ CrossLinc™	LN-25 PRO DUAL POWER
Maxtrac® Wire Drive System	•	•	•
Dual Range Wire Feed Speed	•	•	•
CC/CV Switch	•		•
Trigger Interlock Switch	•	•	•
Replaceable, Flame Resistant Case	•	•	•
Potted PC Boards for Moisture and Corrosion Protection	•	•	•
Flow Meter	•	•	•
Extra Torque for up to 3/32 in. Diameter Wire Welding			
STT® Ready With Remote Control Capabilities			•
Digital Display for Amperage and Wire Feed Speed		•	•
14 lb. [6 kg] Innershield® Coil Adapter (K435)			
CrossLinc™ Communication		•	

K2613-5
LN-25 PRO Standard



K4267-1
LN-25X w/ CrossLinc™



K2614-6
LN-25 PRO Dual Power



REQUIRED ACCESSORIES

MAXTRAC® DRIVE ROLL & WIRE GUIDE KITS

Description	Order No.
Steel Wire Sizes (includes stainless steel):	
.023-.030 in (0.6-0.8 mm)	KP1696-030S
.035 in (0.9 mm)	KP1696-035S
.045 in (1.2 mm)	KP1696-045S
.052 in (1.4 mm)	KP1696-052S
.035, .045 in (0.9, 1.2 mm)	KP1696-1
.040 in (1.0 mm)	KP1696-2
1/16 in (1.6 mm)	KP1696-1/16S
Cored Wire Sizes:	
.030-.035 in (0.8-0.9 mm)	KP1697-035C
.040-.045 in (1.0-1.2 mm)	KP1697-045C
.052 in (1.4 mm)	KP1697-052C
1/16 in (1.6 mm)	KP1697-1/16C
Steel or Cored Wire Sizes:	
.068-.072 in (1.8 mm)	KP1697-068
5/64 in (2.0 mm)	KP1697-5/64
3/32 in (2.4 mm)	KP1697-3/32
Aluminum Wire Sizes:	
.035 in (0.9 mm)	KP1695-035A
.040 in (1.0 mm)	KP1695-040A
3/64 in (1.2 mm)	KP1695-3/64A
1/16 in (1.6 mm)	KP1695-1/16A

WELD POWER CABLES

Description	Order No.
Pigtail - mechconnector -hug	KA1452-12
Pigtail - mechconnector -Twistmate	K10377
Welding lead extension 10m	KA1452-4
Welding lead extension 20m	KA1452-13

CONTROL EXTENSION CABLES (LN-25 Pro Dual)

Description	Order No.
Control Cable Extension, 25 ft. (7.6 m) - male 14 pin to female 14 pin	K1797-25
Control Cable Extension, 50 ft. (15.2 m) - male 14 pin to female 14 pin	K1797-50

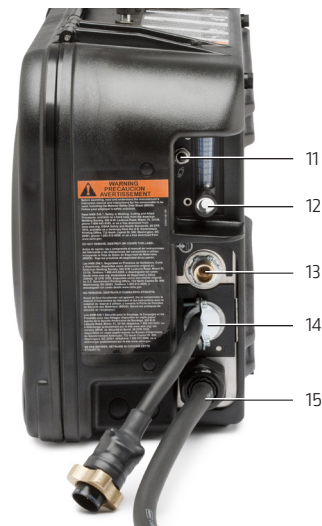
CONTROLS

LN-25 PRO



1. Analog Voltmeter
2. Wire Feed Speed Knob
3. Dual Range Speed Switch
4. 5-Pin Gun Trigger Connector
5. Work Sense Lead
6. Thermal Protection LED
7. Welding Polarity Indicator LED
8. Gas Purge Pushbutton
9. Flow Meter Valve
10. Shielding Gas Inlet
11. Electrode Lead

LN-25 PRO Dual Power



1. Wire Feed Speed/Amperage Digital Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connector
6. Work Sense Clip Connection
7. Thermal LED
8. Voltage Digital Display
9. Voltage LED
10. Remote Voltage Control Knob (not presettable)
11. Gas Purge Pushbutton
12. Flow Meter Valve
13. Shielding Gas Inlet
14. 14-Pin Control Cable Input
15. Electrode Lead

NOTE: In across-the-arc mode, voltage knob does not control voltage. Must be adjusted at power source.

LN-25X w/ CrossLinc™



1. Wire Feed Speed/Amperage Digital Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connection
6. Work Clip Connection
7. Thermal LED
8. Voltage Digital Display
9. Voltage LED
10. CrossLinc™ LED
11. Voltage Knob
12. Gas Purge Button
13. Flow Meter Valve
14. Shielding Gas Inlet
15. Electrode Lead

RECOMMENDED POWER SOURCES



Flextec® Family

- » Flextec® Family
- » Invertec® V350 PRO
- » Ranger® Engine Drive Welders
- » Vantage® Engine Driven Welders
- » CV Family
- » Idealarc DC Family

RECOMMENDED ACCESSORIES



K126 PRO Innershield® Gun
350 A, 60% duty cycle air-cooled gun for flux-cored self-shielded Innershield® welding. Magnum® PRO expendable parts.
Order K126-11 (4.5 m, K613-6 Gun Connector)
Order K126-12 (4.5 m, K466-10 Gun Connector)



Magnum® Self-Shielded Gun and Cable Assemblies
Available 250-600 amps.
Order K126-2



Magnum® PRO Gun and Cable Assemblies
250-550 amps, air-cooled, gas-shielded welding guns.
See publication E12.01



Magnum® PRO Curve™ Semiautomatic Guns
Magnum® PRO Curve™ guns for MIG or flux-cored, gas-shielded welding.
See publication E12.05



Prewflow, Postflow and Burnback Time Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.
Order K2330-2



Welding Lead Kit
Includes Twist Mate™ connectors, work clamp, 5 m work cable and 5.0 m electrode cable. Rated 300 amps, 60% duty cycle.
Order KIT-300A-50-5m

Pigtail Mechconnector to lug
Order KA1452-12

Mechconnector to Twistmate
Order K10377

Welding Lead
Welding lead extension male and female mechconnector fitted 10m.
Order K1842-10



Work Clamp
Welding cable lug bolts directly to the work clamp. 60% duty cycle.
Order KA1038 for 300 Amp applications
KA1039 for 500 Amp



Wire Feed Speed Meter
A wire feed speed meter with digital display.
Order K283

Jumper Plug Kit
For use with CV only power sources with 14 pin MS-type wire feeder connections and no contactor control switch. Jumper plug kit closes contactor for always hot welding output.
Order K484



14 Lb. Innershield® Coil Adapter
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. Wire not included.
Order K435



8 In. O.D. Spool Adapter
For small spools. Permits 8 in. (203 mm) O.D. spools to be mounted on 2 in. (51 mm) or 2.5 in. (64 mm) O.D. spindles. **Order K468**



Replacement Case Kit
Replace a damaged case without replacing the entire unit. **Order K2596-2 (plastic)**



Twist Mate™ Cable Plug
For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 90 mm²) cable.
Order LE20601

FEED PLATE GUN ADAPTERS

K1500-1	K1500-2	K1500-3	K1500-4	K1500-5	Magnum® PRO Fast-Mate™
Lincoln Electric Compatible gun connector kits: K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4 Compatible gun connector kits: K466-10 K466-2 K466-6	Tweco #5 Compatible gun connector kits: K613-7 K613-2	Miller® guns Compatible gun connector kits: K466-3 K613-3	OXO® guns	Compatible gun connector kits: K489-1 K489-2 K489-7 K489-8
					

Tweco® is a registered trademark of Victor Technologies. Miller® is a registered trademark of Miller Electric Mfg. Co. Oxo® is a registered trademark of Miller Electric Mfg. Co.

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Flow Meter	Wire Feed Speed Range ipm (m/min)	Wire Size Range - (mm)			Dimensions H x W x D in (mm)	Net Weight lb (kg)
						Solid	Cored	Aluminum		
LN-25 PRO C/W K126 Pro Gun	K2613-5A1	15-110 VDC	450A/60%	Yes	1.3-17.7		0.8-2.0		381 x 221 x 589	Approx. 16 Varies per model
LN-25 PRO C/W MAGNUM 400 GUN	K2613-5A2				0.6-1.6					
LN-25 PRO Dual Power	K2614-6	15-110 VDC or 24-42 VAC			1.3-17.7		0.8-2.0	0.9-1.6		
LN-25X w/ CrossLinc™	K4267-1	15-110 VDC		Yes						

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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