

LN-25 PRO WIRE FEEDERS

SEMIAUTOMATIC 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. These voltage-sensing feeders are compatible with any CV welding power source. 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[®], 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
K2613-7 PRO Extra Torque
K2614-6 PRO Dual Power
K2614-5 PIPE
K2614-9 Ironworker[®]
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.
- **Tachometer feedback** ensures accurate wire feed speed.
- **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** – Can be replaced in less than five minutes.
- **Potted PC Boards** – For moisture and corrosion protection.

CHOOSE THE RIGHT MODEL FOR YOUR APPLICATION

	LN-25 PRO STANDARD	LN-25 PRO EXTRA TORQUE	LN-25 PRO DUAL POWER	LN-25 PIPE	LN-25 IRONWORKER®	LN-25X w/CrossLinc™
Maxtrac® Wire Drive System	•	•	•	•	•	•
Trigger Interlock Switch	•	•	•	•	•	•
Replaceable, Flame Resistant Case	•	•	•	•	•	•
Internal Contactor	•	•	•	•	•	•
Gas Solenoid	•	•	•	•	•	•
Arc Sensing Lead and Clip, 15, ft. (4.5 m)	•	•	•	•	•	•
Two Gun Bushings (K1500-2 Tweco style installed; K1500-1 Lincoln style loose)	•	•	•	•	•	•
4/0 Input Power Cable w/Lug - 18.5 In.	•	•	•	•	•	•
Potted PC Boards for Moisture and Corrosion Protection	•	•	•	•	•	•
Dual Range Wire Feed Speed	•	•	•	•	•	
Flow Meter	•	•	•			•
Dual Digital Display for Wire Feed Speed/ Amperage and Voltage			•	•	•	•
CC/CV Switch	•	•	•			
Analog Voltage Meter	•	•				
5/64 in. (2.0 mm) cored wire drive rolls and guide kit (KP1697-5/64) included				•	•	
Extra Torque for up to 3/32 in. Diameter Wire Welding		•				
STT®-Ready With Remote Control Capabilities (Control cable compatible)			•			
14 lb. (6 kg) Innershield® Coil Adapter (K435) Included				•		
CrossLinc® Communication (Remote Voltage Control)						•

K2613-5
LN-25 PRO Standard



K2613-7
LN-25 PRO Extra Torque



K2614-6
LN-25 PRO Dual Power



K2614-5
LN-25 PIPE



K2614-9
LN-25 Ironworker®



K4267-1
LN-25X w/ CrossLinc™



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.
1/0 Cable	Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
	Twist Mate™ to Twist Mate™, 1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
2/0 Cable	Tweco®-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. (15.2 m)	K2485-2
	Tweco®-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K2484-2
	Twist Mate™ to Twist Mate™, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50
3/0 Cable	Tweco®-Style male plug and female receptacle 3/0, 600A, 60% duty cycle, 50 ft. (15.2 m)	K2485-3
	Tweco®-Style male plug and 0.53 lug, 3/0, 600A, 60% duty cycle, 50 ft. (15.2 m)	K2484-3
	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)	K1842-10
	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)	K1842-35
4/0 Cable	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)	K1842-60
	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)	K1842-110

CONTROL EXTENSION CABLES (FOR DUAL POWER MODEL ONLY)

Description	Order No.
Control Cable Extension, 10 ft. (3.0 m) - male 14 pin to female 14 pin	K1797-10
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
Control Cable Extension, 100 ft. (30.4 m) - male 14 pin to female 14 pin	K1797-100

CONTROLS

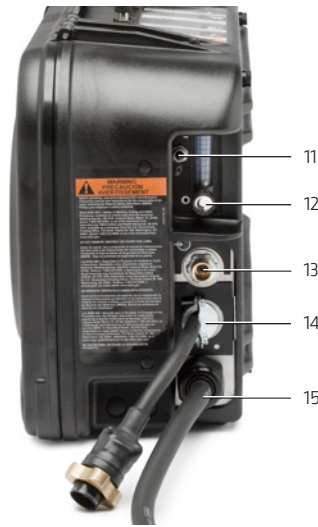
LN-25 PRO/LN-25 PRO Extra Torque



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

CONTROLS cont.

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-25 PIPE AND IRONWORKER



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 Sense Clip Connection
7. Thermal LED
8. Voltage Digital Display
9. Voltage LED
10. Gas Purge Button
11. Shielding Gas Inlet
12. Electrode Lead

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
- » 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 (15 ft/4.5 m, K613-6 Gun Connector)
Order K126-12 (15 ft/4.5 m, K466-10 Gun Connector)
See publication E12.111



Magnum® Self-Shielded Gun and Cable Assemblies
Available 250-600 amps.
See publication E12.110



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. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum® PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.
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



Work and Wire Feeder 2/0 Weld Cable Package
Includes Twist Mate™ connectors, work clamp, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.
Order K1803-1



Weld Cable Package Work & Power Lead 2/0 - Tweco® Male & GC500 / Tweco® Male & Lug - 10 ft (3 m)
Includes Tweco® style Cam-Lock connectors, work clamps, 10 ft. (3.0 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.
Order K1803-2



Weld Cable Package - Work Lead - TM & GC500 Ground Clamp (2/0, 350A, 60%) - 15 ft (4.5 m)
Includes Twist Mate™ (Dinse) connector, ground clamp, 15 ft. (4.5 m) 2/0 cable. Rated 350 amps, 60% duty cycle.
Order K1803-3



Work Clamp
Jaws open full 2-1/2 in. (63 mm). Welding cable lug bolts directly to the work clamp. 60% duty cycle. Select K910-1 for 300 Amp applications. K910-2 for 500 Amp.
Order K910-1 & K910-2



Tweco®-Style Plug Male, 1/0 through 2/0
Order K3416-70



Tweco®-Style Receptacle Female, 1/0 through 2/0
Order K3417-70



Tweco®-Style Plug Male, 3/0 through 4/0
Order K3416-90



Tweco®-Style Receptacle Female, 3/0 through 4/0
Order K3417-90



Deluxe Adjustable Gas Regulator
Deluxe Gas Regulator for Mixed Gases, Adapter for CO₂ and 10 ft. (3.0m) Hose.
Order K586-1



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 K852-95

FEED PLATE GUN ADAPTERS

K1500-1	K1500-2	K1500-3	K1500-4	K1500-5	K489-7
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	Fast-Mate™ / Euro Connector Compatible with weld guns with Fast-Mate™ or Euro connectors
					

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.

LN-25 ONE-PAK® PACKAGES

One-Pak® Ordering Information		One-Pak® Component Information	
Product Number	Description	Product Number	Description
K4100-1	 LN-25X Wire Feeder /Magnum® PRO Curve™300 Gun	K4267-1	LN-25X Wire Feeder with CrossLinc® Technology
		K2951-2-10-45	Magnum® PRO Curve™ 300 Welding Gun Ready-Pak® 15 ft
		KP1697-045C	Drive Roll Kit .040 - .045 in. (1.0 - 1.2 mm) Cored Wire
K4100-2	 LN-25X Wire Feeder / K126® PRO FCAW-S Gun	K4267-1	LN-25X Wire Feeder with CrossLinc® Technology
		K126-12	K126® PRO Innershield® 350A FCAW-SS Welding Gun 15 ft 1/16-5/64
		KP1697-5/64	Drive Roll Kit 5/64 in. (2.0 mm) Solid/Cored Wire
		KP1697-1/16C	Drive Roll Kit 1/16 in. (1.6 mm) Cored Wire
K4101-1	 LN-25 PRO Standard Wire Feeder / Magnum® PRO Curve™ 300 Gun	K2613-5	LN-25 PRO Wire Feeder Standard
		K2951-2-10-45	Magnum® PRO Curve™ 300 Welding Gun Ready-Pak® 15 ft
		KP1697-045C	Drive Roll Kit .040 - .045 in. (1.0 - 1.2 mm) Cored Wire
K4101-2	 LN-25 PRO Standard Wire Feeder / K126® PRO FCAW-S Gun	K2613-5	LN-25 PRO Wire Feeder Standard
		K126-12	K126® PRO Innershield® 350A FCAW-SS Welding Gun 15 ft 1/16-5/64
		KP1697-5/64	Drive Roll Kit 5/64 in. (2.0 mm) Solid/Cored Wire
		KP1697-1/16C	Drive Roll Kit 1/16 in. (1.6 mm) Cored Wire

PRODUCT SPECIFICATIONS

						Wire Size Range - in. (mm)				
Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Flow Meter	Wire Feed Speed Range ipm (m/min)	Solid	Cored	Aluminum	Dimensions H x W x D in (mm)	Net Weight lb (kg)
LN-25 PRO Standard	K2613-5	15-110 VDC	450A/60%	Yes	50-700 [1.3-17.7]	.023-1/16 [0.6-1.6]	.030-5/64 [0.8-2.0]	.035-1/16 [0.9-1.6]	15 x 8.7 x 23.2 [381 x 221 x 589]	Approx. 38 (17) Varies per model
LN-25 PRO Extra Torque	K2613-7				30-400 [0.8-10.1]		.030-3/32 [0.8-2.4]			
LN-25 PRO Dual Power	K2614-6	15-110 VDC or 24-42 VAC			No		50-700 [1.3-17.7]			
LN-25 PIPE	K2614-5	15-110 VDC								
LN-25 Ironworker®	K2614-9									
LN-25X w/ CrossLinc™	K4267-1			Yes						

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

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company® is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information 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. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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