

# 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<sup>®</sup>, 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  
K2613-7 PRO Extra Torque  
K2614-6 PRO Dual Power  
K2614-5 PIPE  
K2614-9 Ironworker<sup>®</sup>  
K4267-1 X w/ CrossLinc™

<sup>®</sup> 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/EXTRA TORQUE/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)

### PIPE

Features everything included with Standard model, less the flowmeter. Also includes:

- 14 lb. Innershield® coil adapter (K435)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit (KP1697-5/64)
- Variable WFS range set at factory to Low (50-400 ipm)

### IRONWORKER®

Features everything included with Standard model. Also includes:

- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit (KP1697-5/64)
- Variable WFS range set at factory to High (50-700 ipm)

### X w/ CROSSLINC™

Features everything included with the Ironworker model, with the addition of a flowmeter. Also includes:

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

## CHOOSE THE RIGHT MODEL FOR YOUR APPLICATION

	LN-25 PRO STANDARD	LN-25 PRO EXTRA TORQUE	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			

	LN-25 PIPE	LN-25 IRONWORKER®	LN-25X w/ CrossLinc™
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



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.
<b>Steel Wire Sizes (includes stainless steel):</b>	
.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
<b>Cored Wire Sizes:</b>	
.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
<b>Steel or Cored Wire Sizes:</b>	
.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
<b>Aluminum Wire Sizes:</b>	
.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.
Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
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
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
Twist Mate™ to Twist Mate™, 1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
Twist Mate™ to Twist Mate™, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50

### CONTROL EXTENSION CABLES

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

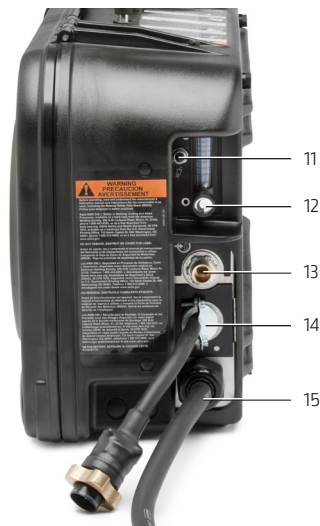
### LN-25 PRO/LN-25 PRO Extra Torque



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



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
- » 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 (15 ft/4.5 m, K613-6 Gun Connector)**  
**Order K126-12 (15 ft/4.5 m, K466-10 Gun Connector)**



**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**



**Adapter for Competitive Power Sources**  
Allows wire feeder to connect to select Miller Electric® power sources.  
**Order K2335-1**



**Preflow, 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**



**AWG 1/0 Co-Axial Power Cable**  
1/0 Coaxial weld cable of length "xx". Ends of the weld cable have lug connections. Use for Pulse welding.  
**Order K1796-xx**

**AWG #1 Co-Axial Power Cable**  
#1 Coaxial weld cable of length "xx". Ends of the weld cable have lug connections. Use for Pulse welding.  
**Order K2593-xx**

**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 Power Cable, Twist-Mate™ to Lug**  
Twist-Mate to Lug, 1/0 cable of length "xx". 1/0, 350A, 60% duty cycle.  
**Order K1840-xx**

**Weld Power Cable, Lug to Lug**  
Lug to Lug, 3/0 Cable of length "xx" for lengths up to 60 ft. [18.3m]. Lug to Lug, 4/0 cable of length "xx" for lengths greater than 60 ft. [18.3m].  
**Order K1842-10**



**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**



**Deluxe Adjustable Gas Regulator**  
Deluxe Gas Regulator for Mixed Gases, Adapter for CO<sub>2</sub> 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 mm<sup>2</sup>] cable.  
**Order K852-95**

### 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 - in. (mm)			Dimensions H x W x D in (mm)	Net Weight lb (kg)
						Solid	Cored	Aluminum		
LN-25 PRO Standard	K2613-5	15-110 VDC	450A/60%	Yes	50-700 (1.3-17.7)		.030-5/64 (0.8-2.0)	15 x 8.7 x 23.2 (381 x 221 x 589)	Approx. 37 (16) 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			.023-1/16 (0.6-1.6)		.035-1/16 (0.9-1.6)			
LN-25 PIPE	K2614-5	15-110 VDC		No	50-700 (1.3-17.7)		.030-5/64 (0.8-2.0)			
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](http://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](http://www.lincolnelectric.com) for any updated information.

**The Lincoln Electric Company**  
22801 St. Clair Avenue · Cleveland, OH · 44117-1199 · U.S.A.

[www.lincolnelectric.com](http://www.lincolnelectric.com)