

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 »



15-110
VDC
All Models
Across the Arc



24-42
VAC
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.

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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.
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.
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

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 cross-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



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



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 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

FEEDPLATE 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
					

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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)	.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. 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		No	50-700 (1.3-17.7)		.030- 5/64 (0.8-2.0)			
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

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