

LN-25 Wire Feeders

Processes

MIG, MIG-STT^{®(1)}, Pulsed, Flux-Cored

Product Number

K2613-5 PRO Standard
K2613-7 PRO Extra Torque
K2614-6 PRO Dual Power
K2614-5 PIPE
K2614-9 Ironworker[®]

See back for complete specs

Input Power

15-110 VDC (Standard/Extra Torque/
Pipe/Ironworker[®])
15-110 VDC or 24-42 VAC (Dual Power)

Output Capacity Current/Duty Cycle
450A/60%

Wire Size Range
See Back

Wire Feed Speed Range

See Back

Weight/Dimensions (H x W x D)

37 lbs. (16 kg)
15 x 8.7 x 23.2 in.
(381 x 221 x 589 mm)

Portable Industrial Wire Feeders

LN-25 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.

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.

APPLICATIONS

- ▶ Pipe
- ▶ Metal Fabrication
- ▶ Construction
- ▶ Shipbuilding
- ▶ Rental Fleet



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, less the flowmeter. 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)

OUTPUT



INPUT

All Models
Across the Arc



K2614-6 Only
Control Cable



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



Web Update 09/11

Publication E8.101 | Issue Date 03/11
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(1) STT[®] capability only with K2614-6 Dual Power Model.

THE LINCOLN ELECTRIC COMPANY

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LINCOLN[®]
ELECTRIC
THE WELDING EXPERTS[®]

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®**

Maxtrac® Wire Drive System	●	●	●	●	●
Dual Range Wire Feed Speed	●	●	●	●	●
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)				●	

REQUIRED OPTIONS

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

KEY 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 Ball
10. Flow Meter Valve
11. Shielding Gas Inlet
12. Electrode Lead

LN-25 PRO DUAL POWER



1. Wire Feed Speed/Amperage Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connector
6. Work Clip Connection
7. Thermal LED
8. Voltage Display
9. Voltage LED
10. Remote Voltage Control Knob (not presettable)

11. Gas Purge Pushbutton
12. Flow Meter Ball
13. Flow Meter Valve
14. Shielding Gas Inlet
15. 14-Pin Control Cable Input
16. Electrode Lead

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

LN-25 PIPE / IRONWORKER®









1. Wire Feed Speed/Amperage Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-pin Gun Trigger Connector
6. Work Clip Connection
7. Thermal LED
8. Voltage Display
9. Voltage LED

10. Gas purge button
11. Shielding Gas Inlet
12. Electrode Lead

RECOMMENDED POWER SOURCES

- ▶ CV-305
- ▶ CV-400
- ▶ CV-655
- ▶ DC-400
- ▶ DC-600
- ▶ DC-655
- ▶ Invertec® V350-PRO
- ▶ Flextec™ 450
- ▶ Ranger® Engine Driven Welders
- ▶ Vantage® Engine Driven Welders

FEED PLATE GUN RECEIVER BUSHINGS

K1500-1 Gun Receiver Bushing	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)	K1500-4 Gun Receiver Bushing (Optional)	K1500-5 Gun Receiver Bushing (Optional)	K489-7 Fast-Mate Gun Receiver Bushing (Optional)
<ul style="list-style-type: none"> Magnum® 200, 300 and 400 with K466-1 connector kit. Lincoln Innershield® Magnum® 550 with K613-1 connector kit. 	<ul style="list-style-type: none"> Magnum® 200 and 400 assembled guns (KC and KC). Magnum® 200, 300 and 400 w/K466-10. Guns with Tweco® #2, #3, and #4 connectors. 	<ul style="list-style-type: none"> Magnum® 550 with K613-7 connection. Guns with Tweco® #5 connectors. 	<ul style="list-style-type: none"> Magnum® 200, 300 and 400 with K466-3 connector kit. 	<ul style="list-style-type: none"> To adapt to OXO® guns. 	<ul style="list-style-type: none"> Magnum® with Fast-Mate connections. Handles single and dual procedure guns. 

RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES



K126 PRO Innershield® Gun
350A, 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)



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



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



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



Prewflow, Postflow and Burnback Timer 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



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



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



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



Twist Mate™ Cable Plug
For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 90 mm²) cable.
Order K852-95



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



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



Micro Wire Straightener
Straightens .035 - 1/16 in. (0.9 - 1.6 mm) wire for use with portable feeders.
Order K1733-4

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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 Lbs. (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)	37 (16)
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	50-700 (1.3-17.7)	.030-5/64 (0.8-2.0)			
LN 25 PIPE	K2614-5	15-110 VDC		No						
LN-25 Ironworker®	K2614-9									

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