


For use with machines Code numbers:

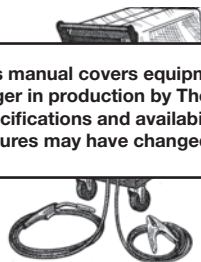
11519, 11520



## OPERATOR'S MANUAL



This manual covers equipment which is no longer in production by The Lincoln Electric Co. Specifications and availability of optional features may have changed.



### Safety Depends on You

Lincoln arc welding and cutting equipment is designed and built with safety in mind. However, your overall safety can be increased by proper installation ... and thoughtful operation on your part. **DO NOT INSTALL, OPERATE OR REPAIR THIS EQUIPMENT WITHOUT READING THIS MANUAL AND THE SAFETY PRECAUTIONS CONTAINED THROUGHOUT.** And, most importantly, think before you act and be careful.

#### **Please Examine Carton and Equipment For Damage Immediately**

When this equipment is shipped, title passes to the purchaser upon receipt by the carrier. Consequently, Claims for material damaged in shipment must be made by the purchaser against the transportation company at the time the shipment is received.

Please record your equipment identification information below for future reference. This information can be found on your machine nameplate.

Product \_\_\_\_\_

Model Number \_\_\_\_\_

Code Number or Date Code \_\_\_\_\_

Serial Number \_\_\_\_\_

Date Purchased \_\_\_\_\_

Where Purchased \_\_\_\_\_

Whenever you request replacement parts or information on this equipment, always supply the information you have recorded above. The code number is especially important when identifying the correct replacement parts.

# SAFETY



## WARNING

**ARC WELDING CAN BE HAZARDOUS. PROTECT YOURSELF AND OTHERS FROM POSSIBLE SERIOUS INJURY OR DEATH. KEEP CHILDREN AWAY. PACEMAKER WEARERS SHOULD CONSULT WITH THEIR DOCTOR BEFORE OPERATING.**

Read and understand the following safety highlights. For additional safety information, it is strongly recommended that you purchase a copy of "Safety in Welding & Cutting - ANSI Standard Z49.1"

**BE SURE THAT ALL INSTALLATION, OPERATION, MAINTENANCE AND REPAIR PROCEDURES ARE PERFORMED ONLY BY QUALIFIED INDIVIDUALS.**



### FOR ELECTRICALLY powered equipment.

- 1.a. Turn off input power using the disconnect switch at the fuse box before working on the equipment.
- 1.b. Install equipment in accordance with the U.S. National Electrical Code, all local codes and the manufacturer's recommendations.
- 1.c. Ground the equipment in accordance with the U.S. National Electrical Code and the manufacturer's recommendations.



### ARC RAYS can burn.

- 2.a. Use a shield with the proper filter and cover plates to protect your eyes from sparks and the rays of the arc when welding or observing open arc welding. Headshield and filter lens should conform to ANSI Z87.1 standards.
- 2.b. Use suitable clothing made from durable flame-resistant material to protect your skin and that of your helpers from the arc rays.
- 2.c. Protect other nearby personnel with suitable, non-flammable screening and/or warn them not to watch the arc nor expose themselves to the arc rays or to hot spatter or metal.

# SAFETY



## **WELDING SPARKS can cause fire or explosion.**

- 4.a. Remove fire hazards from the welding area. If this is not possible, cover them to prevent the welding sparks from starting a fire. Remember that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas. Avoid welding near hydraulic lines. Have a fire extinguisher readily available.
- 4.b. Where compressed gases are to be used at the job site, special precautions should be used to prevent hazardous situations. Refer to "Safety in Welding and Cutting" (ANSI Standard Z49.1) and the operating information for the equipment being used.
- 4.c. When not welding, make certain no part of the electrode circuit is touching the work or ground. Accidental contact can cause overheating and create a fire hazard.
- 4.d. Do not heat, cut or weld tanks, drums or containers until the proper steps have been taken to insure that such procedures will not cause flammable or toxic vapors from substances inside. They can cause an explosion even though they have been "cleaned". For information, purchase "Recommended Safe Practices for the Preparation for Welding and Cutting of Containers and Piping That Have Held Hazardous Substances", AWS F4.1 from the American Welding Society (see address above).
- 4.e. Vent hollow castings or containers before heating, cutting or welding. They may explode.
- 4.f. Sparks and spatter are thrown from the welding arc. Wear oil free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes and a cap over your hair. Wear ear plugs when welding out of position or in confined places. Always wear safety glasses with side shields when in a welding area.
- 4.g. Connect the work cable to the work as close to the welding area as practical. Work cables connected to the building framework or other locations away from the welding area increase the possibility of the welding current passing through lifting chains, crane cables or other alternate circuits. This can create fire hazards or overheat lifting chains or cables until they fail.
- 4.h. Read and follow NFPA 51B "Standard for Fire Prevention During Welding, Cutting and Other Hot Work", available from NFPA, 1 Batterymarch Park, PO box 9101, Quincy, Ma 022690-9101.
- 4.i. Do not use a welding power source for pipe thawing.

# SAFETY



## ELECTRIC SHOCK can kill.

5.a. The electrode and work (or ground) circuits are electrically “hot” when the welder is on. Do not touch these “hot” parts with your bare skin or wet clothing. Wear dry, hole-free gloves to insulate hands.

5.b. Insulate yourself from work and ground using dry insulation. Make certain the insulation is large enough to cover your full area of physical contact with work and ground.

**In addition to the normal safety precautions, if welding must be performed under electrically hazardous conditions (in damp locations or while wearing wet clothing; on metal structures such as floors, gratings or scaffolds; when in cramped positions such as sitting, kneeling or lying, if there is a high risk of unavoidable or accidental contact with the workpiece or ground) use the following equipment:**

- Semiautomatic DC Constant Voltage (Wire) Welder.
- DC Manual (Stick) Welder.
- AC Welder with Reduced Voltage Control.

5.c. In semiautomatic or automatic wire welding, the electrode, electrode reel, welding head, nozzle or semi-automatic welding gun are also electrically “hot”.

5.d. Always be sure the work cable makes a good electrical connection with the metal being welded. The connection should be as close as possible to the area being welded.

5.e. Ground the work or metal to be welded to a good electrical (earth) ground.

5.f. Maintain the electrode holder, work clamp, welding cable and welding machine in good, safe operating condition. Replace damaged insulation.

5.g. Never dip the electrode in water for cooling.

5.h. Never simultaneously touch electrically “hot” parts of electrode holders connected to two welders because voltage between the two can be the total of the open circuit voltage of both welders.

5.i. When working above floor level, use a safety belt to protect yourself from a fall should you get a shock.

5.j. Also see Items 4.c. and 1.

# SAFETY



## FUMES AND GASES can be dangerous.

6.a. Welding may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. When welding, keep your head out of the fume. Use enough ventilation and/or exhaust at the arc to keep fumes and gases away from the breathing zone. **When welding with electrodes which require special ventilation such as stainless or hard facing (see instructions on container or MSDS) or on lead or cadmium plated steel and other metals or coatings which produce highly toxic fumes, keep exposure as low as possible and below Threshold Limit Values (TLV) using local exhaust or mechanical ventilation. In confined spaces or in some circumstances, outdoors, a respirator may be required. Additional precautions are also required when welding on galvanized steel.**

6. b. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.
- 6.c. Do not weld in locations near chlorinated hydrocarbon vapors coming from degreasing, cleaning or spraying operations. The heat and rays of the arc can react with solvent vapors to form phosgene, a highly toxic gas, and other irritating products.
- 6.d. Shielding gases used for arc welding can displace air and cause injury or death. Always use enough ventilation, especially in confined areas, to insure breathing air is safe.
- 6.e. Read and understand the manufacturer's instructions for this equipment and the consumables to be used, including the material safety data sheet (MSDS) and follow your employer's safety practices. MSDS forms are available from your welding distributor or from the manufacturer.

# SAFETY



## **CYLINDER may explode if damaged.**

7.a. Use only compressed gas cylinders containing the correct shielding gas for the process used and properly operating regulators designed for the gas and pressure used. All hoses, fittings, etc. should be suitable for the application and maintained in good condition.

7.b. Always keep cylinders in an upright position securely chained to an undercarriage or fixed support.

7.c. Cylinders should be located:

- Away from areas where they may be struck or subjected to physical damage.
- A safe distance from arc welding or cutting operations and any other source of heat, sparks, or flame.

7.d. Never allow the electrode, electrode holder or any other electrically "hot" parts to touch a cylinder.

7.e. Keep your head and face away from the cylinder valve outlet when opening the cylinder valve.

7.f. Valve protection caps should always be in place and hand tight except when the cylinder is in use or connected for use.

7.g. Read and follow the instructions on compressed gas cylinders, associated equipment, and CGA publication P-1, "Precautions for Safe Handling of Compressed Gases in Cylinders," available from the Compressed Gas Association 1235 Jefferson Davis Highway, Arlington, VA 22202.



## **WARNING**

This statement appears where the information **must** be followed **exactly** to avoid **serious personal injury** or **loss of life**.



## **CAUTION**

This statement appears where the information **must** be followed to avoid **minor personal injury** or **damage to this equipment**.

# TABLE OF CONTENTS

	Page
<b>Installation .....Section A</b>	
Technical Specifications .....	A-1
Safety Precautions .....	A-2
Uncrating the POWER MIG® 255XT .....	A-2
Location .....	A-2
Input Power, Grounding and connection Diagrams.....	A-2/A-4
Output polarity Connections.....	A-5
Gun and Cable Installation.....	A-5
Shielding Gas .....	A-6,A-7
<b>Operation .....Section B</b>	
Safety Precautions .....	B-1
Product Description .....	B-2
Recommended Processes and Equipment.....	B-2
Welding Capability.....	B-3
Limitations .....	B-3
Description of Controls.....	B-3
Wire drive Roll.....	B-3
Wire Size Conversion Parts .....	B-4
Procedure for Changing Drive Roll .....	B-4
Wire Reel Loading .....	B-4,B-5
Mounting of 10 to 30 lbs. Spools .....	B-5
To Start the Welder .....	B-6
Feeding Electrode .....	B-6
Idle Roll Pressure Setting.....	B-7
Wire Drive Configuration .....	B-8, B-9
Setting Run-in Speed .....	B-10
Operating Instructions for Timer Setting.....	B-11, B-12
Making a Weld.....	B-13
Avoiding Wire Feeding Problems.....	B-14
Fan Controls.....	B-15
Input Line Voltage Protection .....	B-15
Wire Feed Overload Protection.....	B-15
Welding Thermal Overload Protection .....	B-16
Overcurrent Protection .....	B-16
Welding Procedure Information.....	B-16
<b>Accessories .....Section C</b>	
Drive Rolls Kits.....	C-1
Aluminium Feeding Kit .....	C-1
K363P Readi-Reel Adapter .....	C-1
Dual Cylinder Mounting Kit .....	C-1
Alternative Magnum GMAW Gun and Cable Assemblies.....	C-2
Magnum Gun Connection Kit .....	C-2
Spool Gun .....	C-3
Connecting the Spool Gun.....	C-3
Making a Weld with the Spool Gun Adapter Kit and Spool Gun Installed.....	C-4, C-5
Magnum SG Spool Gun.....	C-5, C-6
Magnum 250LX Push-Pull and Push-Pull Adapter .....	C-7, C-8, C-9

# TABLE OF CONTENTS

	Page
<b>Maintenance.....Section D</b>	
Safety Precautions .....	D-1
General Maintenance .....	D-1
Drive Rolls and Guide Tubes.....	D-1
Contact Tip and gas Nozzle Installation .....	D-1
Gun Tubes and Nozzles .....	D-2
Cable Cleaning .....	D-2
Liner removal and Replacement.....	D-3,D-4
Gun Handle Disassembly.....	D-5
<b>Troubleshooting.....Section E</b>	
How to Use Troubleshooting Guide.....	E-1
Troubleshooting Guide.....	E-2
Troubleshooting Guide.....	E-3
Troubleshooting Guide.....	E-4
<b>Diagrams.....Section F</b>	
<b>Parts Manual.....P Series</b>	
POWER MIG® 255XT.....	P-579 Series
Magnum 250L Gun.....	P202-H.2



# TECHNICAL SPECIFICATIONS

INPUT – SINGLE PHASE ONLY			
<u>Standard Voltage/Frequency</u> 208/230/60 Hz 230/460/575/60 Hz	<u>Input Current @ 200 Amp Rated Output</u> *47/44 Amps 41/20/16 Amps	<u>Input Current @ 250 Amp Rated Output</u> *56/52 50/24/19	
*With 115V receptacle loaded to 15A.			
RATED OUTPUT			
<u>Duty Cycle</u>	<u>Amps</u>	<u>Volts at rated Amperes</u>	
40%	250 Amps	26 Volts	
60%	200 Amps	28 Volts	
100%	145 Amps	26 Volts	
OUTPUT			
<u>Welding Current Range (Continuous)</u>	<u>Maximum Open Circuit Voltage</u>	<u>Welding Voltage Range</u>	
30 - 300 Amps	40 Volts	10-28 Volts	
RECOMMENDED INPUT WIRE AND FUSE SIZES			
<u>Input Voltage Frequency (Hz)</u>	<u>Fuse or breaker Size (Super Lag)</u>	<u>Input Ampere Rating On Nameplate</u>	
208/60	60	56	
230/60	60	52	
460/60	30	24	
575/60	25	19	
<u>75°C Copper Wire in Conduit AWG (IEC) Sizes (For lengths up to 100 ft.)</u>	<u>75°C Copper Wire in Conduit AWG (IEC) Sizes (For lengths exceeding 100 ft.)</u>		
8 (10 mm <sup>2</sup> )	6 (16 mm <sup>2</sup> )		
10 (6 mm <sup>2</sup> )	8 (10 mm <sup>2</sup> )		
14 (2.5 mm <sup>2</sup> )	12 (4 mm <sup>2</sup> )		
14 (2.5 mm <sup>2</sup> )	12 (4 mm <sup>2</sup> )		
PHYSICAL DIMENSIONS			
<u>Height</u>	<u>Width</u>	<u>Depth</u>	<u>Weight</u>
31.79 in 808 mm	18.88 in 480 mm	38.78 in 985 mm	220 lbs 100 kg
WIRE SPEED RANGE			
<u>Wire Speed</u>	50 - 700 IPM (1.27 - 17.8 m/min)		

# INSTALLATION

Read entire installation section before starting installation.

## SAFETY PRECAUTIONS

### WARNING



- **ELECTRIC SHOCK** can kill.
- Only qualified personnel should perform this installation.
- Only personnel that have read and understood the **POWER MIG® 255XT Operating Manual** should install and operate this equipment.
- Machine must be grounded per any national, local or other applicable electrical codes.
- The **POWER MIG** power switch is to be in the **OFF** position when installing work cable and gun and when connecting other equipment.

### UNCRATING THE POWER MIG® 255XT

Cut banding and lift off cardboard carton. Cut banding holding the machine to the skid. Remove foam and corrugated packing material. Untape accessories from Gas Bottle Platform. Unscrew the two wood screws (at the Gas Bottle Platform) holding the machine to the skid. Roll the machine off the skid assembly.

### LOCATION

Locate the welder in a dry location where there is free circulation of clean air into the louvers in the back and out the front. A location that minimizes the amount of smoke and dirt drawn into the rear louvers reduces the chance of dirt accumulation that can block air passages and cause overheating.

### INPUT POWER, GROUNDING AND CONNECTION DIAGRAMS

### WARNING



- **ELECTRIC SHOCK** can kill.
- Do not touch electrically live parts such as output terminals or internal wiring.
- All input power must be electrically disconnected before proceeding.

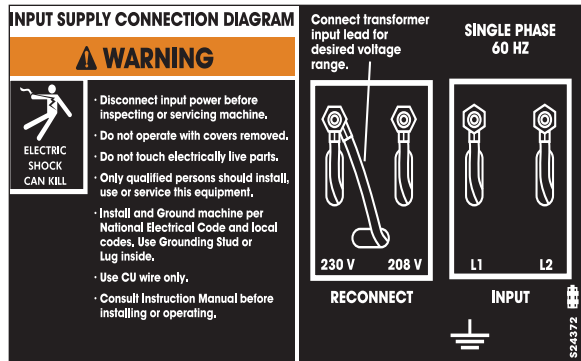
## INSTALLATION

1. Before starting the installation, check with the local power company if there is any question about whether your power supply is adequate for the voltage, amperes, phase, and frequency specified on the welder nameplate. Also be sure the planned installation will meet the U.S. National Electrical Code and local code requirements. This welder may be operated from a single phase line or from one phase of a three phase line.
2. Models that have multiple input voltages specified on the nameplate (e.g. 208/230) are shipped connected for the highest voltage. If the welder is to be operated on lower voltage, it must be reconnected according to the instructions in Figure A.1 for dual voltage machines and Figure A.2 for triple voltage machines.

### WARNING

**Make certain that the input power is electrically disconnected before removing the screw on the reconnect panel access cover.**

**FIGURE A.1 — Dual Voltage Machine Input Connections**



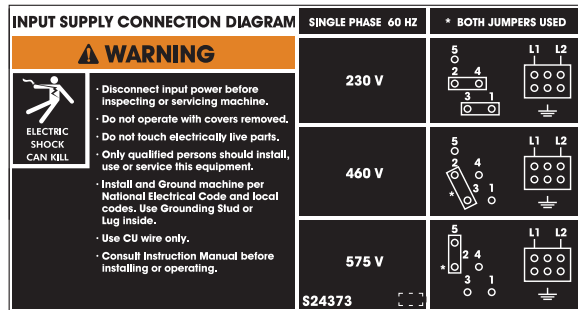
3. The 208/230 volt 60 Hz model POWER MIG is shipped with a 10 ft. input cable and plug connected to the welder. Obtain a receptacle and mount it in a suitable location. Be sure it can be reached by the plug on the input cable attached to the welder. Mount with the grounding terminal at the top to allow the power cable to hang down without bending.

The 230/460/575 volt 60 Hz model is not equipped with a plug, an input cable or a receptacle.

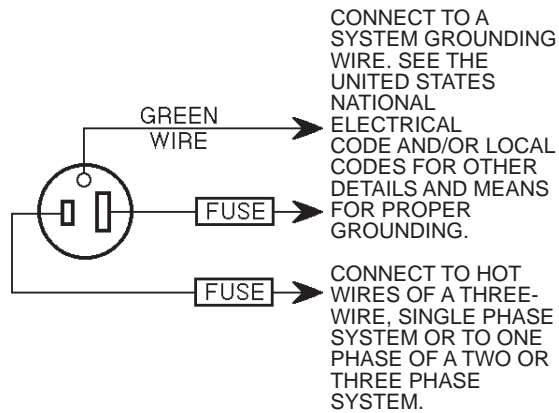
# INSTALLATION

- Using the instructions in Figure A.3, have a qualified electrician connect the receptacle or cable to the input power lines and the system ground per the U.S. National Electrical Code and any applicable local codes. See "Technical Specifications" at the beginning of this chapter for proper wire sizes. For long runs over 100 feet, larger copper wires should be used. Fuse the two hot lines with super lag type fuses as shown in the following diagram. The center contact in the receptacle is for the grounding connection. A green wire in the input cable connects this contact to the frame of the welder. This ensures proper grounding of the welder frame when the welder plug is inserted into the receptacle.

**FIGURE A.2 — Triple Voltage Machine Input Connections**



**FIGURE A.3 —Receptacle Diagram**



## INSTALLATION

### OUTPUT POLARITY CONNECTIONS

The welder, as shipped from the factory, is connected for electrode positive (+) polarity. This is the normal polarity for GMA welding.

If negative (-) polarity is required, interchange the connection of the two cables located in the wire drive compartment near the front panel. The electrode cable, which is attached to the wire drive, is to be connected to the negative (-) labeled terminal and the work lead, which is attached to the work clamp, is to be connected to the positive (+) labeled terminal.

### GUN AND CABLE INSTALLATION

The Magnum 250L gun and cable provided with the POWER MIG® 255XT is factory installed with a liner for .035-.045" (0.9-1.2 mm) electrode and an .035" (0.9 mm) contact tip. Install the .045" tip (also provided) if this wire size is being used.

### WARNING

**Turn the welder power switch off before installing gun and cable.**

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1. Lay the cable out straight.
2. Unscrew knurled screw on the drive unit front end (inside wire feed compartment) until tip of screw no longer protrudes into gun opening as seen from front of machine.
3. Insert the male end of gun cable into the female casting through opening in front panel. Make sure connector is fully inserted and tighten knurled-screw.
4. Connect the gun trigger connector from the gun and cable to the mating receptacle inside the compartment located above the gun connection made in item 3 above. Make sure that the keyways are aligned, insert and tighten retaining ring.

## INSTALLATION

### SHIELDING GAS

(For Gas Metal Arc Welding Processes)

Customer must provide cylinder of appropriate type shielding gas for the process being used.

A gas flow regulator, for CO<sub>2</sub> or Argon blend gas, and an inlet gas hose are factory provided with the POWER MIG® 255XT.

#### WARNING



**CYLINDER** may explode if damaged.

- Gas under pressure is explosive. Always Keep gas cylinders in an upright position and always keep chained to undercarriage or stationary support. See American National Standard Z-49.1, "Safety in Welding and Cutting" published by the American Welding Society.

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Install shielding gas supply as follows:

1. Set gas cylinder on rear platform of POWER MIG® 255XT. Hook chain in place to secure cylinder to rear of welder.
2. Remove the cylinder cap. Inspect the cylinder valves and regulator for damaged threads, dirt, dust, oil or grease. Remove dust and dirt with a clean cloth.  
DO NOT ATTACH THE REGULATOR IF OIL, GREASE OR DAMAGE IS PRESENT! Inform your gas supplier of this condition. Oil or grease in the presence of high pressure oxygen is explosive.
3. Stand to one side away from the outlet and open the cylinder valve for an instant. This blows away any dust or dirt which may have accumulated in the valve outlet.

#### WARNING

**Be sure to keep your face away from the valve outlet when "cracking" the valve.**

4. Attach the flow regulator to the cylinder valve and tighten the union nut(s) securely with a wrench.

## INSTALLATION

**NOTE:** If connecting to 100% CO<sub>2</sub> cylinder, insert regulator adapter between regulator and cylinder valve. If adapter is equipped with a plastic washer, be sure it is seated for connection to the CO<sub>2</sub> cylinder.

5. Attach one end of the inlet gas hose to the outlet fitting of the flow regulator, the other end to the POWER MIG® 255XT rear fitting, and tighten the union nuts securely with a wrench.
6. Before opening the cylinder valve, turn the regulator adjusting knob counterclockwise until the adjusting spring pressure is released.
7. Standing to one side, open the cylinder valve slowly a fraction of a turn. When the cylinder pressure gauge pointer stops moving, open the valve fully.

### **WARNING**

**Never stand directly in front of or behind the flow regulator when opening the cylinder valve.  
Always stand to one side.**

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8. The flow regulator is adjustable. Adjust it to the flow rate recommended for the procedure and process being used before making the weld.

### **AUXILIARY POWER RECEPTACLES**

(For 208/230V Models only)

This machine is equipped with 15Amp 120V receptacle with 15Amp Circuit Breaker. The receptacle is UL and CSA approved.

## OPERATION

Read entire Operation section before operating the POWER MIG® 255XT.

### WARNING



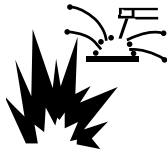
**ELECTRIC SHOCK** can kill.

- Do not touch electrically live parts or electrode with skin or wet clothing. Insulate yourself from work and ground.
- Always wear dry insulating gloves.



**FUMES AND GASES** can be dangerous.

- Keep your head out of fumes.
- Use ventilation or exhaust to remove fumes from breathing zone.



**WELDING SPARKS** can cause fire or explosion.

- Keep flammable material away.
- Do not weld on closed containers.



**ARC RAYS** can burn eyes and skin.

- Wear eye, ear and body protection.

Observe all safety information throughout this manual.



## OPERATION

### PRODUCT DESCRIPTION

The POWER MIG® 255XT is a complete semiautomatic constant voltage DC arc welding machine built to meet NEMA specifications. It combines a constant voltage power source and a constant speed wire feeder with a microcomputer-based controller to form a reliable high-performance welding system. A simple control scheme, consisting of continuous full range voltage and wire feed speed controls, provides versatility with ease of use and accuracy. The POWER MIG® 255XT is Spool Gun ready and includes a second Gas Solenoid for Spool Gun use. Refer to Accessories Section for Applicable Spool Guns.

Other features include a 2" (51 mm) O.D. wire reel spindle with adjustable brake, an integral gas cylinder mounting undercarriage, an adjustable CO<sub>2</sub> or Argon blend flow regulator with cylinder pressure gauge and inlet hose, a 15 ft. (4.6 m) Magnum 250L GMAW gun and cable with fixed (flush) nozzle, a 10 ft. (3.1 m) power cable with plug and a 10ft. (3.1 m) work cable with clamp.

The POWER MIG® 255XT features a Timer kit that provides variable burnback control, a spot function, a selectable 4-step trigger interlock and adjustable "Run In" for wire starting optimization is available. Optional features include a Dual Cylinder Mounting kit and an Aluminum Feeding Kit for push feeding with standard built in feeder.

### RECOMMENDED PROCESSES AND EQUIPMENT

The POWER MIG® 255XT is recommended for GMA welding processes using 10 to 44 lb (4.5 to 20 kg) 2"(51 mm) I.D. spools or Readi-Reel® coils (with optional adapter) of .025" through .045" (0.6 – 1.2 mm) solid steel, .035" (0.9 mm) stainless, 3/64" (1.2 mm) aluminum and .045" (1.2 mm) Outershield® and Ultracore® ; as well as .035" (0.9 mm) and .045" (1.2 mm) Innershield® self-shielding electrodes.

The POWER MIG® 255XT is factory equipped to feed .035" (0.9 mm) and .045(1.2mm) electrode. It also includes a 200A, 60% duty cycle (or 250A, 40% duty cycle) rated, 15 ft. (4.6 m) GMAW gun and cable assembly equipped for these wire sizes. Use of GMAW processes requires a supply of shielding gas.

## OPERATION

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### WELDING CAPABILITY

The POWER MIG® 255XT is rated at 250 amps @ 26 volts, at a 40% duty cycle based on a ten minute cycle time. It is capable of higher duty cycles at lower output currents and capable of up to 300 Amps at lower duty cycles.

### LIMITATIONS

The POWER MIG® 255XT **WILL NOT operate** satisfactorily if powered with a portable or in-plant generating system.

### DESCRIPTION OF CONTROLS

**Power ON/OFF Switch** — Place the lever in the "ON" position to energize the POWER MIG® 255XT. When the power is on, the red LED display lights illuminate.

**Voltage Control** — This is a continuous control that gives full range adjustment of power source output voltage. It can be adjusted while welding over its 10 to 28 volt range.

**Wire Speed Control** — This controls the wire feed speed from 50 – 700 inches per minute (1.2 – 17.8 m/min). The control can be preset on the dial to the setting specified on the Procedure Decal on the inside of the wire compartment door. Wire speed is not affected when changes are made in the voltage control.

### WIRE DRIVE ROLL

The drive rolls installed with the POWER MIG® 255XT have two grooves one for .035(0.9mm) wire Solid Steel electrode and the other for .045(1.2mm) wire. Drive roll size is stenciled on each side of the drive roll. If feeding problems occur, check to make sure that the wire size and the drive roll size matches. See "Procedure for Changing Drive Roll" in this section. This information also appears on the Procedure Decal on the door inside the wire compartment.

## OPERATION

### WIRE SIZE CONVERSION PARTS

The POWER MIG® 255XT is rated to feed .025 through .045" (0.6-1.2 mm) solid or cored electrode sizes.

The drive roll kits and Magnum 250L gun and cable parts are available to feed different sizes and types of electrodes. See Accessories section.

### PROCEDURE FOR CHANGING DRIVE AND IDLE ROLL SETS

1. Turn off the power source.
2. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position.
3. Remove the outside wire guide retaining plate by loosening the two large knurled screws.
4. Twist the drive roll retaining mechanism to the unlocked position as shown below and remove the drive roll. (See Figure B.1)

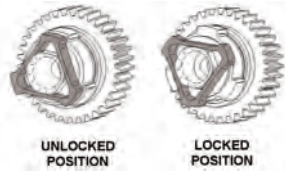


FIGURE B.1

5. Remove the inside wire guide plate.
6. Replace the drive and idle rolls and inside wire guide with a set marked for the new wire size. **NOTE:** Be sure that the gun liner and contact tip are also sized to match the selected wire size.
7. Manually feed the wire from the wire reel, over the drive roll groove and through the wire guide and then into the brass bushing of the gun and cable assembly.
8. Replace the outside wire guide retaining plate by tightening the two large knurled screws. Reposition the adjustable pressure arm to its original position to apply pressure. Adjust pressure as necessary.

### WIRE REEL LOADING - READING REELS, SPOOLS OR COILS

**To Mount a 30 Lb. (14 kg) Read-Reel Package (Using the Molded Plastic K363-P Read-Reel Adapter:)**

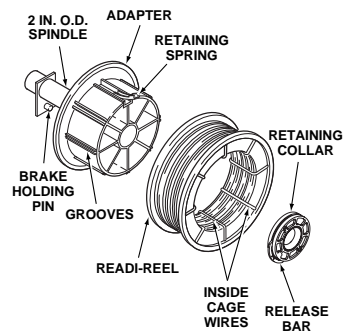
## OPERATION

1. Open the Wire Drive Compartment Door
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the Optional Adapter on the spindle
4. Re-install the Retaining Collar. Make sure that the Release Bar "pops up" and that the collar retainers fully engage the retaining ring groove on the spindle.
5. Rotate the spindle and adapter so the retaining spring is at the 12 o'clock position.
6. Position the Redi-Reel so that it will rotate in a direction when feeding so as to be de-reeled from top of the coil.
7. Set one of the Redi-Reel inside cage wires on the slot in the retaining spring tab.
8. Lower the Redi-Reel to depress the retaining spring and align the other inside cage wires with the grooves in the molded adapter.
9. Slide cage all the way onto the adapter until the retaining spring "pops up" fully.

### WARNING

**CHECK TO BE SURE THE RETAINING SPRING HAS FULLY RETURNED TO THE LOCKING POSITION AND HAS SECURELY LOCKED THE READI-REEL CAGE IN PLACE. RETAINING SPRING MUST REST ON THE CAGE, NOT THE WELDING ELECTRODE.**

10. To remove Redi-Reel from Adapter, depress retaining spring tab with thumb while pulling the Redi-Reel cage from the molded adapter with both hands. Do not remove adapter from spindle.



## OPERATION

### To Mount 10 to 44 Lb. (4.5-20 kg) Spools (12"/300 mm Diameter) or 14Lb.(6 Kg) Innershield Coils:

(For 13-14 lb. (6 Kg) Innershield coils, a K435 Coil Adapter must be used).

(For 10 lb.(4.5 Kg) 8 inch(203mm) diameter spools, a K468 spindle adapter must be used).

1. Open the Wire Drive Compartment Door
2. Depress the Release Bar on the Retaining Collar and remove it from the spindle.
3. Place the spool on the spindle making certain the spindle brake pin enters one of the holes in the back side of the spool (Note: an arrow mark on the spindle lines up with the brake holding pin to assist in lining up a hole). Be certain the wire comes off the reel in a direction so as to de-reel from the top of the coil.
4. Re-install the Retaining Collar. Make sure that the Release Bar "pops up" and that the collar retainers fully engage the retaining ring groove on the spindle.

### TO START THE WELDER

Turn the "Power Switch" switch to "ON". This lights the red LED display lights. With the desired voltage and wire speed selected, operate the gun trigger for welder output and to energize the wire feed motor.

### FEEDING WIRE ELECTRODE

#### **WARNING**

**When triggering, the electrode and drive mechanism are electrically "hot" relative to work and ground and remain "hot" several seconds after the gun trigger is released.**

-----  
**NOTE:** Check that drive rolls, guide plates and gun parts are proper for the wire size and type being used. Refer to Table C.1 in Accessories section.

1. Turn the Readi-Reel or spool until the free end of the electrode is accessible.
2. While securely holding the electrode, cut off the bent end and straighten the first six inches. (If the electrode is not properly straightened, it may not feed properly through the wire drive system).

## OPERATION

3. Release the pressure on the idle roll by swinging the adjustable pressure arm down toward the back of the machine. Lift the cast idle roll assembly and allow it to sit in an upright position. Leave the outer wire guide plate installed. Manually feed the wire through the incoming guide bushing and through the guide plates (over the drive roll groove). Push a sufficient wire length to assure that the wire has fed into the gun and cable assembly without restriction. Reposition the adjustable pressure arm to its original position to apply pressure to the wire.
4. Press gun trigger to feed the electrode wire through the gun.

### IDLE ROLL PRESSURE SETTING



#### WARNING

ELECTRIC SHOCK can kill.



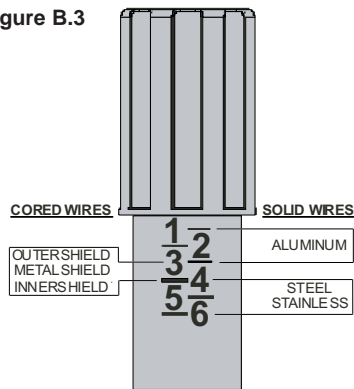
- Turn the input power OFF at the welding power source before installation or changing drive rolls and/or guides.
- Do not touch electrically live parts.
- When inching with the gun trigger, electrode and drive mechanism are "hot" to work and ground and could remain energized several seconds after the gun trigger is released.
- Only qualified personnel should perform maintenance work.

The pressure arm controls the amount of force the drive rolls exert on the wire. Proper adjustment of both pressure arm gives the best welding performance. For best results, set both pressure arms to the same value.

Set the pressure arm as follows (See Figure B.3):

Aluminum wires	between 1 and 3
Cored wires	between 3 and 4
Steel, Stainless wires	between 4 and 6

Figure B.3



## OPERATION

### WIRE DRIVE CONFIGURATION

(See Figure B.4)

#### Changing the Gun Receiver Bushing



### WARNING



**ELECTRIC SHOCK can kill.**

- Turn the input power OFF at the welding power source before installation or changing drive rolls and/or guides.
  - Do not touch electrically live parts.
- When inching with the gun trigger, electrode and drive mechanism are "hot" to work and ground and could remain energized several seconds after the gun trigger is released.
  - Only qualified personnel should perform maintenance work.

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Tools required:

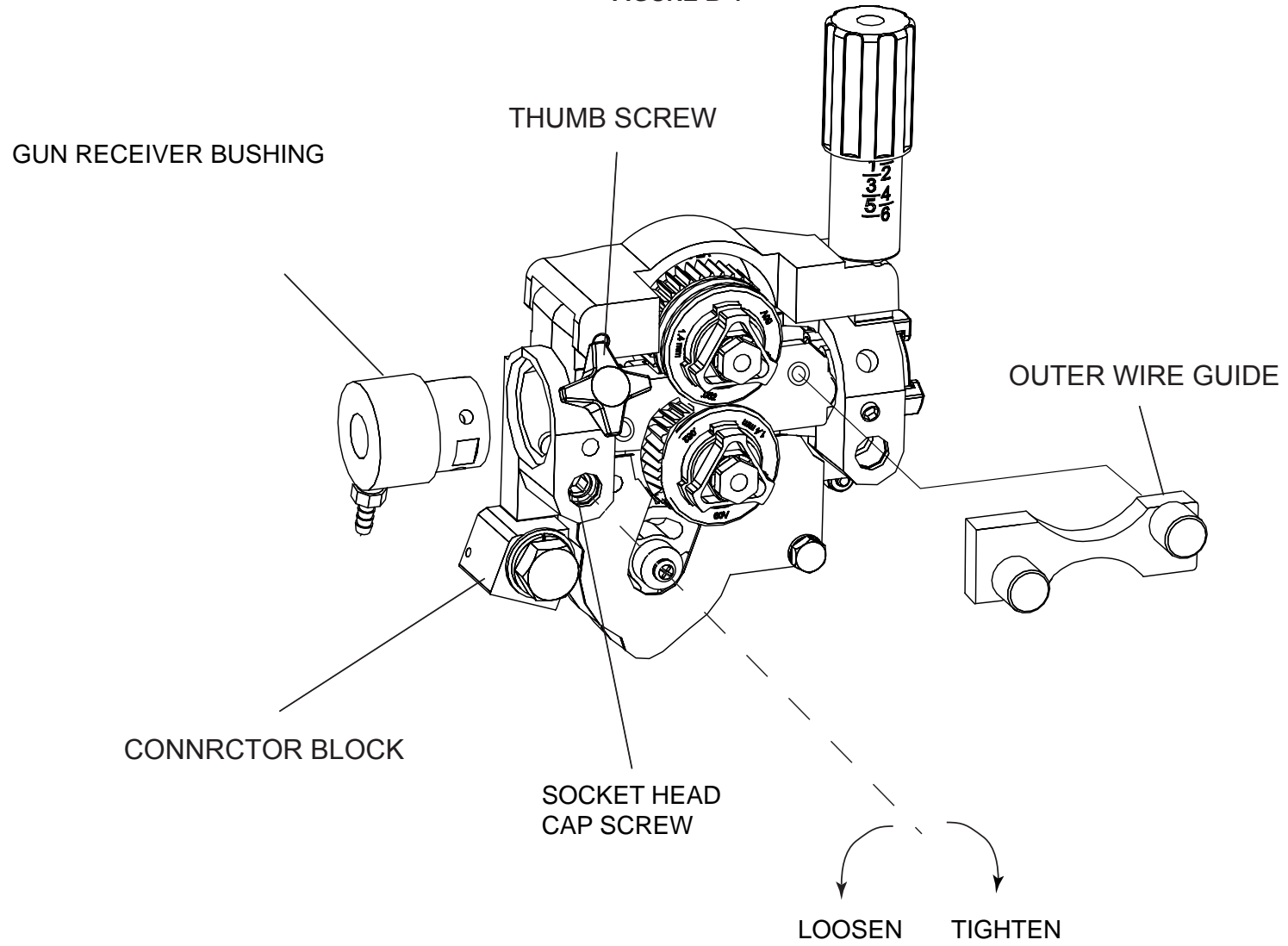
- 1/4" hex key wrench.

Note: Some gun bushings do not require the use of the thumb screw.

1. Turn power off at the welding power source.
2. Remove the welding wire from the wire drive.
3. Remove the thumb screw from the wire drive.
4. Remove the welding gun from the wire drive.
5. Loosen the socket head cap screw that holds the connector bar against the gun bushing.  
**Important: Do not attempt to completely remove the socket head cap screw.**
6. Remove the outer wire guide, and push the gun bushing out of the wire drive. Because of the precision fit, light tapping may be required to remove the gun bushing.
7. Disconnect the shielding gas hose from the gun bushing, if required.
8. Connect the shielding gas hose to the new gun bushing, if required.
9. Rotate the gun bushing until the thumb screw hole aligns with the thumb screw hole in the feed plate. Slide the gun receiver bushing into the wire drive and verify the thumb screw holes are aligned.
10. Tighten the socket head cap screw.
11. Insert the welding gun into the gun bushing and tighten the thumb screw.

OPERATION

FIGURE B-4





## OPERATION

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### SETTING RUN-IN SPEED ON STANDARD POWER MIG FEEDER

#### FAST OR SLOW RUN-IN MODE SELECTION, (When Timer Option is not installed)

The POWER MIG® 255XT is factory set for fast run-in mode where the wire feed will accelerate directly to the preset wire feed speed when the gun trigger is closed.

Slow run-in mode may also be selected, where it will initially feed wire at 50 IPM until output current is sensed or for 1.0 seconds, whichever occurs first. After which it will accelerate to the preset wire feed speed.

**Note:** See operating instructions for Timer Option Kit if it is installed, as it provides its own Run-in operation.

#### INSTRUCTIONS TO ENTER SLOW RUN-IN

1. Turn power OFF on front panel of POWER MIG® 255XT.
2. Turn the wire feed speed dial to minimum, fully counter-clockwise.
3. With the gun trigger closed, turn the power ON at the front panel of the POWER MIG® 255XT.
4. The display will read "SLO run".

#### INSTRUCTIONS TO ENTER FAST RUN-IN

1. Turn power OFF on front panel of POWER MIG® 255XT.
2. Turn the wire feed speed dial to maximum, fully clockwise.
3. With the gun trigger closed, turn the power ON at the front panel of the POWER MIG® 255XT.
4. The display will read "FAS run".

#### **NOTE:**

Arc starting characteristics may be effected when using the fast run-in mode since optimum starting processes are being overridden.

On the initial trigger closure at power up, no output power or wire feed will be available until the trigger is opened and reclosed, regardless of wire feed speed dial setting.

## OPERATION

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It is not necessary to repeat either of the above procedures each time the unit is powered up. The unit will remember the run-in mode from the previous power down and return you to that same state upon your next power up. Thus, you need only perform one of the above procedures when you want to change the run-in mode.

### OPERATING INSTRUCTIONS FOR TIMER SETTINGS

Select the desired mode with the selector switch:

- A. **Normal Welding mode** provides weld power only while the trigger switch is depressed.
- B. **4-Step Trigger interlock mode** eliminates the need to hold the gun trigger while welding. It operates in 4 steps:
  1. Close trigger and establish welding arc.
  2. Release trigger and continue welding.
  3. Reclose trigger near end of weld.
  4. Release trigger again to stop welding.

If the arc is broken while using this feature, the machine will reset to the "trigger off" condition automatically.

**Note:** 4 Step Trigger interlock mode does not function with a Spool Gun.

- C. **Spot Weld Mode** is used for tack welding parts into position or for spot plug welds to hold thin sheet metal together prior to manual stitch or continuous welding. To use this feature, adjust the On-Time (0-5 seconds) as appropriate to obtain the desired results. Closing the trigger initiates a single timed spot weld cycle.

Plug welds are made by using a punch to make a 3/16" (5 mm) diameter hole in the top sheet and arc welding through the hole into the back sheet.

## OPERATION

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To make spot plug welds, punch 3/16" (5 mm) holes in the top sheet. Set the Spot Time control to approximately 1.2 seconds and set the procedure for the metal thickness to be welded. Install spot weld nozzle (if available) on gun and press it against the top sheet so the top and bottom sheets are tight together. Close trigger and hold it closed until the arc goes out. If a spot weld nozzle is not used, smoother welds will result by moving the welding wire in a small circle during the weld.

- D. **Burnback Time** control provides manual adjustment of the burnback time (0-250 milliseconds) for any selected welding mode. this control should be set as low as possible without the wire "sticking" in the puddle after each weld. Too long of a burnback time may form a "ball" on the end of the wire, or may "flash back" to the gun tip.
- E. **Run-In Mode** is used to adjust the starting wire feed speed. Starting conditions for certain welding applications can be improved with adjustment to the Run-In speed. The control allows for initial starting speeds from 50 - 150 IPM. After the arc is started, the set point on the wire feed speed control will dominate. Note that the Run-in is not functional with the spool gun. Also note that if Run-in is set fully counter clockwise to "OFF", Run-in speed will equal the preset WFS on the machine.

## OPERATION

### MAKING A WELD

1. Check that the electrode polarity is correct for the process being used, then turn the power switch ON.
2. Set desired arc voltage and wire speed for the particular electrode wire, material type and thickness, and gas (for GMAW) being used. Use the Application Chart on the door inside the wire compartment as a quick reference for some common welding procedures.
3. Select the desired mode as described in "Operating Instructions for Timer Setting Section".
4. Press the trigger to feed the wire electrode through the gun and cable and then cut the electrode within approximately 3/8" (10 mm) of the end of the contact tip [3/4" (20 mm) Outershield<sup>®</sup>].

**NOTE:** If set for slow run-in when the trigger is pulled, the wire feeder feeds wire at low speed regardless of the set wire feed speed until the welding arc starts or 1 second has elapsed. This feature enhances starting and makes it easier to set the stickout. The 1 second limit permits high speed loading of the gun and cable. To change run-in mode, see "Setting Run-In Speed" in this section, if the Timer Kit is not installed, or Timer Kit Operation section if installed.

5. If welding gas is to be used, turn on the gas supply and set the required flow rate (typically 25-35 CFH; 12-16 liters/min).
6. When using Innershield electrode, the gas nozzle may be removed from the insulation on the end of the gun and replaced with the gasless nozzle. This will give improved visibility and eliminate the possibility of the gas nozzle overheating.
7. Connect work cable to metal to be welded. Work clamp must make good electrical contact to the work. The work must also be grounded as stated in "Arc Welding Safety Precautions".

## OPERATION

### WARNING

When using an open arc process, it is necessary to use correct eye, head, and body protection.

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8. Position electrode over joint. End of electrode may be lightly touching the work.
9. Lower welding helmet, close gun trigger, and begin welding. Hold the gun so the contact tip to work distance is about 3/8" (10 mm) [3/4" (20 mm) for Outershield].
10. To stop welding, release the gun trigger and then pull the gun away from the work after the arc goes out.
11. When no more welding is to be done, close valve on gas cylinder (if used), momentarily operate gun trigger to release gas pressure, and turn off POWER MIG® 255XT.

### AVOIDING WIRE FEEDING PROBLEMS

Wire feeding problems can be avoided by observing the following gun handling procedures:

- a. Do not kink or pull cable around sharp corners.
- b. Keep the gun cable as straight as possible when welding or loading electrode through cable.
- c. Do not allow dolly wheels or trucks to run over cables.
- d. Keep cable clean by following maintenance instructions.
- e. Use only clean, rust-free electrode. The Lincoln electrodes have proper surface lubrication.
- f. Replace contact tip when the arc starts to become unstable or the contact tip end is fused or deformed.

## OPERATION

---

- g. Keep wire reel spindle brake tension to minimum required to prevent excess reel over-travel which may cause wire "loop-offs" from coil.
- h. Use proper drive rolls and wire drive idle roll pressure for wire size and type being used.

### FAN CONTROL

The fan is designed to come on automatically when a weld arc is established. The fan will stay on for a minimum of 6 minutes after the weld arc is terminated. The fan will also stay on when the machine's welding and feeding are disabled during thermostatic over temperature protection. (See Welding Thermal Overload Protection)

### INPUT LINE VOLTAGE PROTECTION

**High Line Voltage** — If the line voltage exceeds 125% of rated input voltage, the output will be reduced to the lower level to protect voltage rating of the capacitor bank.

**Low Line Voltage** — You may not be able to get maximum output from the machine if the line voltage is less than rated input. The unit will continue to weld, but the output may be less than what is set.

### WIRE FEED OVERLOAD PROTECTION

The POWER MIG® 255XT has solid state overload protection of the wire drive motor. If the motor becomes overloaded, the protection circuitry turns off the wire feed speed weld output and gas solenoid. Check for proper size tip, liner, and drive rolls, for any obstructions or bends in the gun cable, and any other factors that would impede the wire feeding.

To resume welding, simply pull the trigger. There is no circuit breaker to reset, as the protection is done with reliable solid state electronics.

## OPERATION

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### **WELDING THERMAL OVERLOAD PROTECTION**

The POWER MIG® 255XT has built-in protective thermostats that respond to excessive temperature. They open the wire feed and welder output circuits if the machine exceeds the maximum safe operating temperature because of a frequent overload, or high ambient temperature plus overload. The thermostats automatically reset when the temperature reaches a safe operating level and welding and feeding are allowed again, when gun is retriggered.

### **OVERCURRENT PROTECTION**

The machine will automatically reduce the output if the load on the machine exceeds 300 to 320 amperes. This protects the welding power SCR's from excessive short circuit currents and from exceeding their temperature rating before the thermostats can react.

### **WELDING PROCEDURE INFORMATION**

**NOTE:** See inside cover of machine for additional, commonly used welding procedure.

## ACCESSORIES

### DRIVE ROLL KITS

Refer to Table C.1 for various drive roll kits that are available for the POWER MIG. All items in **Bold** are supplied standard with the POWER MIG.

TABLE C.1

Electrode Type	Wire Size	Drive Roll Kit
Solid Steel (Includes Stainless Steel)	.023"-.030" (0.6-0.8 mm)	KP1696-030S
	.035" (0.9 mm)	KP1696-035S
	.045" (1.2 mm)	KP1696-045S
	<b>.035-.045 (0.9-1.2mm)</b>	<b>KP1696-1</b>
	.040 (1.01)	KP1696-2
Cored	.035" (0.9 mm)	KP1697-035C
	.045" (1.2 mm)	KP1697-045C
Aluminum	3/64" (1.2 mm)	KP1695-3/64A
	.035" (0.9 mm)	KP1695-.035A*

\*For use with optional Push Pull Gun.

### 3/64" (1.2 mm) ALUMINUM FEEDING KIT (K1703-1)

This kit helps push feeding aluminum through standard machine feeder and gun. It provides gun and wire drive conversion parts to weld with 3/64" (1.2 mm) aluminum wire. 5356 alloy aluminum wire is recommended for best push feeding performance.

Kit includes drive rolls and wire guide plate for the wire drive, liner and two contact tips for the gun, along with installation instructions.

#### K2378-1 Canvas Cover

**K468 Spindle Adapter** - for 8" (203.2mm) O.D. spool.

#### K363P READI-REEL™ ADAPTER

The K363P Readi-Reel Adapter mounts to the 2" spindle. It is needed to mount the 22-30 lb. Readi-Reels.

#### DUAL CYLINDER MOUNTING KIT (K1702-1)

Permits stable side-by-side mounting of two full size (9" dia. x 5' high) gas cylinders with "no lift" loading. Simple installation and easy instructions provided. Includes upper and lower cylinder supports, wheel axles and mounting hardware.



## ACCESSORIES

### ALTERNATIVE MAGNUM GMAW GUN AND CABLE ASSEMBLIES

The following Magnum 250L gun and cable assemblies are separately available for use with the POWER MIG® 255XT. Each is rated 200 amps 60% duty cycle (or 250 amps 40% duty) and is equipped with the integrated connector, twist-lock trigger connector, fixed nozzle and insulator, and includes a liner, diffuser, and contact tips for the wire sizes

Length	Part No.	English Wire Size <sup>1</sup>	Metric Wire Size
12' (3.6 m)	K533-7	.035 – .045"	0.9 – 1.2 mm
15' (4.5 m)	K533-3		

specified:

<sup>1</sup> Optional liners for different wire diameters are sold separately, see table D.1.

### MAGNUM GUN CONNECTION KIT (Optional K466-6)

Using the optional K466-6 Magnum Connection kit for the POWER MIG permits use of standard Magnum 200, 300 or 400 gun and cable assemblies.

## ACCESSORIES

### SPOOL GUN

#### **WARNING**

Remove all input power to the POWER MIG® 255XT before proceeding.

---

The POWER MIG® 255XT provides direct connection and use of the Spool Gun (with remote speed control).

It also provides gun trigger switch transfer between the machine's use with its feeder gun or the spool gun for same polarity welding with different wire and gas processes.

<b>K2490-1</b>	Magnum® 250LX
<b>K487-25</b>	Magnum® SG Spool Gun (requires K2445-1 Cable Adapter)

#### **K2445-1 Magnum SG Spool gun Control Cable Adapter**

Allows the K487-25 Magnum SG spool gun's 6-pin control cable plug to connect to the POWER MIG® 255XT's 7-pin spool gun control cable receptacle.

#### **K1738-1 Spool Gun Hanger Accessory**

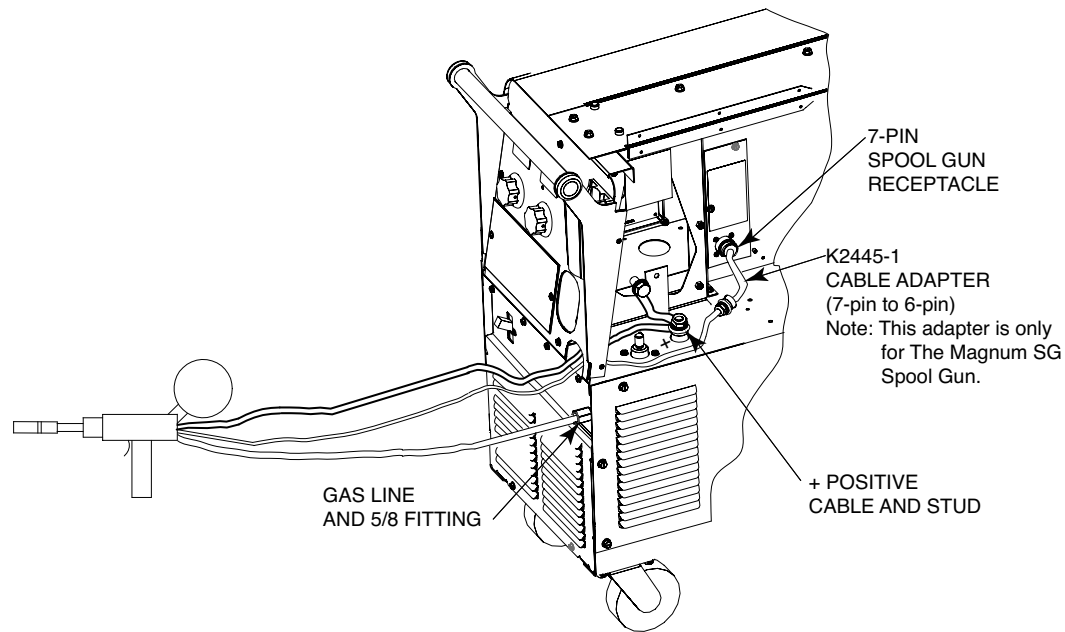
### CONNECTING THE SPOOL GUN TO THE POWER MIG® 255XT

(See Figure C.1)

1. Connect the Spool Gun control cable to the mating 7-pin receptacle in the Power MIG wire drive compartment. K487-25 Magnum SG Spool Gun requires K2445-1 cable 7-pin to 6-pin adapter.
2. Connect the Spool Gun electrode lead to the (+)positive stud with the Spool Gun electrode lead sandwiched between the (+)positive power source electrode lead and the (+)positive stud. Tighten and be careful not to strip the threads.
3. Attach the Spool Gun gas line to the 5/8 Gas fitting on the front of the machine.
4. Attach a Gas hose from the Gas supply to the rear inlet gas fitting on the POWER MIG® 255XT.

## ACCESSORIES

FIGURE C.1



### MAKING A WELD WITH THE SPOOL GUNS

The POWER MIG control circuitry is designed to sense either the spool gun or (built in) wire feeder trigger circuitry. The spool gun can easily be plugged in and will be ready to use.

#### **CAUTION**

Closing either gun trigger will cause the electrode of both guns to be electrically "HOT". Be sure unused gun is positioned so electrode or tip will not contact metal case or other metal common to work.

1. Pulling the trigger for the built-in feeder gun:
  - a. Disables spool gun operation.
  - b. Closing feeder gun trigger starts feeder gun welding and makes both electrodes electrically "HOT".

## ACCESSORIES

2. Pulling SPOOL GUN Trigger:
  - a. Disables built-in feeder gun operation.
  - b. Closing spool gun trigger starts spool gun welding and makes both electrodes electrically "HOT".
3. Operation with POWER MIG® 255XT:
  - a. Turn the POWER MIG® 255XT input power ON.
  - b. Adjusting the voltage control will increase or decrease your welding voltage.
  - c. Adjusting the wire speed control on the spool gun will increase or decrease the spool gun wire feed speed.
  - d. To aid in set-up, the POWER MIG® 255XT wire feed speed(WFS) meter will display the approximate WFS of the gun. Actual WFS at the gun may vary from the displayed value due to tension setting, liner condition or gun variation.
4. The following procedure settings for Aluminum 4043 can be used as initial settings for making test welds to determine final settings:

Wire Diameter In. (mm)	Wire Feed Speed Display	Arc voltage Setting
.030" (.8mm)	270	15V
.035" (.9mm)	250	16V
3/64" (1.2mm)	240	20V

5. To return to normal POWER MIG® 255XT welding, release the spool gun trigger and reset feeder gun voltage procedure setting if necessary.

## MAKING A WELD WITH THE MAGNUM SG SPOOL GUN

The POWER MIG® 255XT control circuitry is designed to sense either the spool gun or (built in) wire feeder trigger circuitry. The spool gun can easily be plugged in and will be ready to use.

## ACCESSORIES

### CAUTION

Closing either gun trigger will cause the electrode of both guns to be electrically "HOT". Be sure unused gun is positioned so electrode or tip will not contact metal case or other metal common to work.

1. Pulling the trigger for the built-in feeder gun:
  - a. Disables spool gun operation.
  - b. Closing feeder gun trigger starts feeder gun welding and makes both electrodes electrically "HOT".
2. Pulling SPOOL GUN Trigger:
  - a. Disables built-in feeder gun operation.
  - b. Closing spool gun trigger starts spool gun weld-ing and makes both electrodes electrically "HOT".
3. Operation with POWER MIG® 255XT:
  - a. Turn the POWER MIG® 255XT input power ON.
  - b. Adjusting the voltage control will increase or decrease your welding voltage.
  - c. Adjusting the wire speed control on the spool gun will increase or decrease the spool gun wire feed speed.
  - d. For the Magnum SG Spool Gun, the wire feed speed is controlled by combination of the wire feed speed displayed on the POWER MIG® 255XT and the wire speed control on the spool gun.

See the following procedure for setting the Wire Speed Feed using the Magnum SG Spool Gun:

Wire Feed Speed Display	SG Spool Gun Wire Feed Speed Approximate Range
50	50-200
300	200-400
700	300-600

To determine spool gun wire feed speed use a hand tachometer, or calculate the speed using the following equation:

$$\text{IPM} = \frac{\text{Length of wire fed (inches)} \times 60}{\text{Time fed (seconds)}}$$

4. To return to normal POWER MIG® 255XT welding, release the spool gun trigger and reset feeder gun welding procedures.

## INSTALLATION

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### **MAGNUM 250LX PUSH-PULL GUN AND PUSH PULL ADAPTER**

For heavier duty aluminum applications when use of large 16 pound aluminum spools of wire are desired the following push pull gun and adapter kit are available.

#### **Magnum 250LX Push Pull Gun (K2704-1)**

This pistol grip push pull gun is similar to the Magnum 250LX spool gun except it is designed to feed large spools of wire. The Magnum 250LX push pull features a 25 foot power, gas and control cable. It operates as an assist slave motor pulling the aluminum wire as the Power MIG drive motor acts as the master push motor.

#### **Magnum 250LX Push Pull Adapter (K2705-1)**

This adapter box is designed to drive the Magnum 250LX push pull gun when used on a non push ready Lincoln power source feeder such as the POWER MIG® 255XT. This box features a 115V cord and plug to power the box, a control cable with receptacle to connect the push pull gun's control cable to, and a 4 pin connector to connect to the Power MIG gun trigger receptacle.

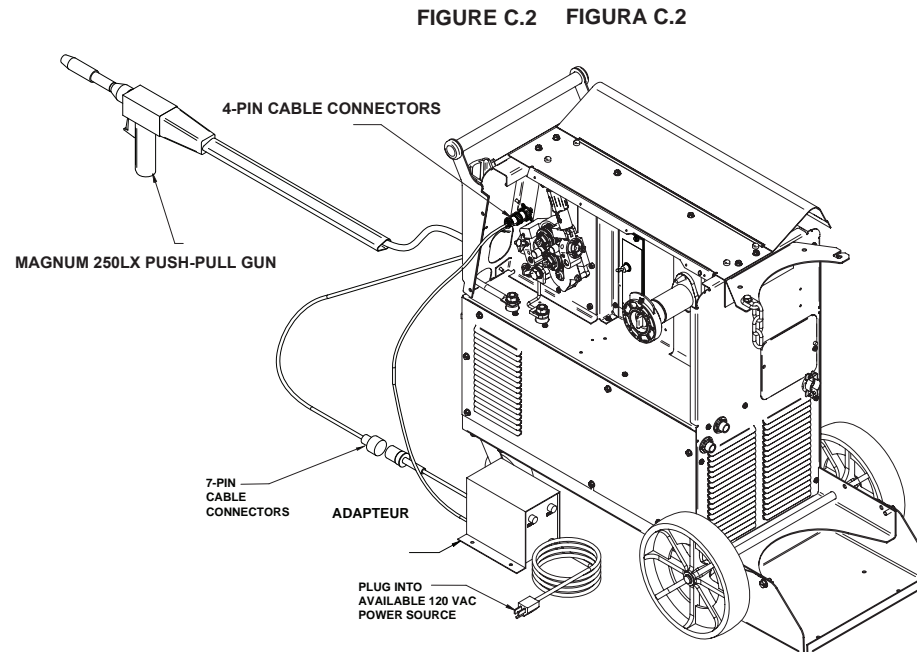
Note the Magnum 250LX push pull gun has a wire feed speed adjustment potentiometer. However this potentiometer only functions on push-pull ready machines like the Power MIG 350MP. When the Magnum 250LX is used on a non-push-pull machine with the K2705-1 adapter, the wire feed speed is set on the control panel of the machine.

## ACCESSORIES

### CONNECTING THE MAGNUM 250 LX PUSH-PULL GUN (K2704-1) AND MAGNUM 250LX PUSH-PULL GUN ADAPTER (K2705-1)

See Figure C.2

1. Plug the 115 VAC cable into available 115V AC receptacle. The POWER MIG® 255XT (K2701-1) furnishes the 15A 115V AC auxiliary supply. The receptacle is located at the back of the machine.
2. Connect the 4-pin connector cable of the Push-Pull Gun Adapter to the 4-pin trigger receptacle located in the front section of the wire drive compartment.
3. Connect the 7-pin connector cable of the Push-Pull Gun to the 7-pin receptacle cable from the adapter.
4. Connect the Push-Pull gas & power pin into the POWER MIG® 255XT wire feeder brass bushing.
5. Attach a gas hose from the Gas supply to the rear inlet gas fitting on the POWER MIG® 255XT.



## ACCESSORIES

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### MAKE A WELD WITH THE MAGNUM 250LX PUSH-PULL GUN

1. POWER MIG® 255XT
  - a. Set machine to non spool gun operation.
  - b. Turn the POWER MIG® 255XT input power ON adjusting the voltage control at the front panel.
  - c. Adjust the wire speed control on the front panel. Refer to the procedure decal mounted at the inside of the wire feeder compartment cover.
  
2. Magnum 250LX Push-Pull Gun:
  - a. Set machine to non spool gun operation.
  - b. Closing Push-Pull gun trigger starts the Push-Pull gun welding and makes all guns connected to the machine electrically "Hot".
  - c. The Push-Pull Adapter will provide power and control to the "Pull" motor of the Push-Pull gun and the POWER MIG® 255XT will control its wire drive.



## MAINTENANCE

### SAFETY PRECAUTIONS

#### **WARNING**



**ELECTRIC SHOCK can kill.**

- **Have an electrician install and service this equipment.**
- **Turn the input power off at the fuse box before working on equipment**
- **Do not touch electrically hot parts.**

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### GENERAL MAINTENANCE

In extremely dusty locations, dirt may clog the air passages causing the welder to run hot. Blow dirt out of the welder with low-pressure air at regular intervals to eliminate excessive dirt and dust build-up on internal parts.

The fan motors have sealed ball bearings which require no service.

### DRIVE ROLLS AND GUIDE PLATES

After every coil of wire, inspect the wire drive mechanism. Clean it as necessary by blowing with low pressure compressed air. Do not use solvents for cleaning the idle roll because it may wash the lubricant out of the bearing.

All drive rolls are stamped with the wire sizes they will feed. If a wire size other than that stamped on the roll is used, the drive roll must be changed.

For instructions on replacing or changing drive roll, see "Wire Drive Rolls" in Operation section.

### CONTACT TIP AND GAS NOZZLE INSTALLATION

- a. Choose the correct size contact tip for the electrode being used (wire size is stenciled on the side of the contact tip) and screw it snugly into the gas diffuser.

## MAINTENANCE

- b. Screw the appropriate fixed gas nozzle fully onto the diffuser. Either the standard .50" (12.7 mm) flush nozzle or other optional flush or recessed (spray arc) nozzle sizes may be used. (See Table D.2 in this section.)
- c. If using optional adjustable slip-on nozzles, see Table D.2 in this section.
  - 1. Be sure the nozzle insulator is fully screwed onto the gun tube and does not block the gas holes in the diffuser.
  - 2. Slip the appropriate gas nozzle onto the nozzle insulator. Either a standard .50" (12.7 mm) or optional .62" (15.9 mm) I.D. slip-on gas nozzle may be used and should be selected based on the welding application.

Adjust the gas nozzle as appropriate for the GMAW process to be used. Typically, the contact tip end should be flush to .12" (3.2 mm) extended for the short-circuiting transfer process and .12" (3.2 mm) recessed for spray transfer.

## GUN TUBES AND NOZZLES

- a. Replace worn contact tips as required.
- b. Remove spatter from inside of gas nozzle and from tip after each 10 minutes of arc time or as required.

## GUN CABLE CLEANING

To help prevent feeding problems, clean cable liner after using approximately 300 pounds (136 kg) of electrode. Remove the cable from the wire feeder and lay it out straight on the floor. Remove the contact tip from the gun. Using an air hose and only partial pressure, gently blow out the cable liner from the gas diffuser end.

### **WARNING**

**Excessive pressure at the start may cause the dirt to form a plug.**

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## MAINTENANCE

Flex the cable over its entire length and again blow out the cable. Repeat this procedure until no further dirt comes out. If this has been done and feed problems are experienced, try liner replacement, and refer to trouble shooting section on rough wire feeding.

### LINER REMOVAL AND REPLACEMENT

NOTE: Changing the liner for a **different** wire size requires replacement of the gas diffuser per Table D.1 to properly secure the different liner.

**TABLE D.1**

Diameter of Electrode Used	Replacement Line Part Number	Size Stencilled on End of liner Bushing	Fixed Nozzle Gas Diffuser Part No. (and stencil)	Adjustable nozzle Gas Diffuser Part No. (and Stencil)
.025-.030" Steel (0.6-0.8 mm)	KP1934-2	.030 (0.8 mm)	KP2026-3	KP2026-2
.035-.045" Steel (0.9-1.2 mm)	KP1934-1	.045 (1.2 mm)	KP2026-3	KP2026-1B1
3/64" Aluminum (1.2 mm)	KP1955-1	3/64" (1.2 mm)	KP2026-3	KP2026-1B1

### LINER REMOVAL, INSTALLATION AND TRIMMING INSTRUCTIONS FOR MAGNUM 250L

NOTE: The variation in cable lengths prevents the interchangeability of liners between guns. Once a liner has been cut for a particular gun, it should not be installed in another gun unless it can meet the liner cutoff length requirement. Liners are shipped with the jacket of the liner extended the proper amount.

1. Remove the gas nozzle and nozzle insulator, if used, to locate the set screw in the gas diffuser which is used to hold the old liner in place. Loosen the set screw with a 5/64" (2.0 mm) Allen wrench.
2. Remove the gas diffuser from the gun tube.
3. Lay the gun and cable out straight on a flat surface. Loosen the set screw located in the brass connector at the feeder end of the cable and pull the liner out of the cable.

## MAINTENANCE

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4. Insert a new untrimmed liner into the connector end of the cable. Be sure the liner bushing is stencilled appropriately for the wire size being used.

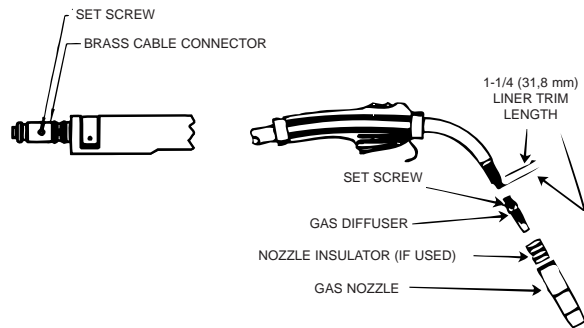
**Note: For liners KP1950-7, KP1950-8, KP1955-1 and KP1599-2**

Before fully seating the liner bushing, it will be necessary to trim the liner's inner tube flush with the liner bushing using a sharp blade. After trimming, remove any burrs from inner tube and insure that the opening is fully open.

5. Fully seat the liner bushing into the connector. Tighten the set screw on the brass cable connector. The gas diffuser, at this time, should not be installed onto the end of the gun tube.
6. With the gas diffuser still removed from the gun tube, be sure the cable is straight, and then trim the liner to the length shown in Figure D.1. Remove any burrs from the end of the liner.
7. Screw the gas diffuser onto the end of the gun tube and securely tighten. Be sure the gas diffuser is correct for the liner being used. (See table and diffuser stencil.)
8. Tighten the set screw in the side of the gas diffuser against the cable liner using a 5/64" (2.0 mm) Allen wrench.

# MAINTENANCE

FIGURE D.1



## **⚠ WARNING**

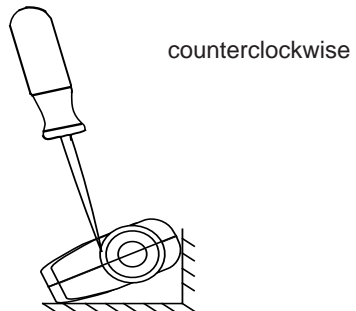
**This screw should only be gently tightened. Overtightening will split or collapse the liner and cause poor wire feeding.**

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## **GUN HANDLE DISASSEMBLY**

The internal parts of the gun handle may be inspected or serviced if necessary.

The gun handle consists of two halves that are held together with a collar on each end. To open up the handle, turn the collars approximately 60 degrees counterclockwise (the same direction as removing a right hand thread) until the collar reaches a stop. Then pull the collar off the gun handle. If the collars are difficult to turn, position the gun handle against a corner, place a screwdriver against the tab on the collar and give the screwdriver a sharp blow to turn the collar past an internal locking rib.



# MAINTENANCE

**TABLE D.2  
ACCESSORIES AND EXPENDABLE REPLACE-  
MENT PARTS FOR MAGNUM 250L GUN AND  
CABLE ASSEMBLIES**

Description	Part No.	English Size	Metric Size
CABLE LINER For 15' (4.5 m) or shorter cable	KP1934-2	.025 – .030"	0.6 – 0.8 mm
	KP1934-1	.035 – .045"	0.9 – 1.2 mm
	KP1955-1	3/64"	1.2 mm
		(Alum. wire)	(Alum. wire)
CONTACTS TIPS Standard Duty  Heavy Duty  Tapered  Notched (For Alum.)	KP2020-6B1	.025"	0.6 mm
	KP2020-7B1	.030"	0.8 mm
	KP2020-1B1*	.035"	0.9 mm
	KP2020-2B1*	.045"	1.2 mm
	KP2021-1B1	.035"	0.9 mm
	KP2021-2B1	.045"	1.2 mm
	KP2021-5B1	.025"	0.6 mm
	KP2021-6B1	.030"	0.8 mm
	KP2022-1B1	.035"	0.9 mm
	KP2022-2B1	.045"	1.2 mm
	KP2010-5B1	3/64"	1.2 mm
		(Alum. Wire)	(Alum. Wire.)
GAS NOZZLES Fixed (Flush)  (Recessed)  Requires: Gas Diffuser as'bly  Adjustable Slip On  Requires: Nozzle Insulator  Requires: Gas diffuser As'bly  Gasless nozzle (For Innershield)	KP1931-1	3/8"	9.5 mm
	KP1931-2*	1/2"	12.7 mm
	KP1931-3	5/8"	15.9 mm
	KP1930-1	3/8"	9.5 mm
	KP1930-2	1/2"	12.7 mm
	KP1930-3	5/8"	15.9 mm
	KP2026-3 *	.025 – .045"	0.6 – 1.2 mm
	KP1935-2	1/2"	12.7 mm
	KP1935-1	5/8"	15.9 mm
	KP2025-1		
	KP2026-2	.025 – .030"	0.6 – 0.8 mm
	KP2026-1	.035 – .045"	0.9 – 1.2 mm
	KP1947-1∅		
GUN TUBE ASSEMBLIES Standard (60°) 45°	KP2015-1 *		
	KP2041-1		

\*Included with POWER MIG® 255XT

Δ Requires KP2026-1 Gas Diffuser

## TROUBLESHOOTING

### HOW TO USE TROUBLESHOOTING GUIDE

#### WARNING

Service and Repair should only be performed by Lincoln Electric Factory Trained Personnel. Unauthorized repairs performed on this equipment may result in danger to the technician and machine operator and will invalidate your factory warranty. For your safety and to avoid Electrical Shock, please observe all safety notes and precautions detailed throughout this manual.

This Troubleshooting Guide is provided to help you locate and repair possible machine malfunctions.

If you do not understand or are unable to perform the Recommended Course of Action safely, contact your local Lincoln Authorized Field Service Facility.

#### CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **Local Lincoln Authorized Field Service Facility** for technical troubleshooting assistance before you proceed.

## TROUBLESHOOTING

### **Major physical or electrical damage is evident.**

1. Contact your Local Lincoln Authorized Field service facility.

### **There is no wire feed or open circuit voltage when the gun trigger is pulled. The machine displays are lit indicating input power to the POWER MIG® 255XT.**

- 1 The gun trigger or cable may be faulty. Check or replace gun assembly.
2. The thermal protection circuit may be activated. If this is the case, the display will show "too hot". "Too Hot" may also be an indication of a defective Gun (Trigger lead shorted to welding circuit). Allowing the machine to cool will clear the error condition.
3. Make sure input voltage is correct and matches nameplate rating and reconnect panel configuration.

### **Machine output is low. Welds are "cold", weld bead is rounded or bumped up demonstrating poor wetting into plate.**

1. Replace gun assembly. If problem is solved gun assembly is faulty. Repair or replace.
2. If problem persists with new gun then the problem is within the POWER MIG® 255XT.



### **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **LOCAL AUTHORIZED LINCOLN ELECTRIC FIELD SERVICE FACILITY** for assistance before you proceed.



## TROUBLESHOOTING

**Machine output is low. Welds are "cold", weld bead is rounded or bumped up demonstrating poor wetting into plate.**

1. Check input voltage. Make sure input voltage matches name-plate rating and reconnect panel configuration.
2. Make sure settings for wire feed speed and voltage are correct for process being used.
3. Make sure output polarity is correct for process being used.
4. Check welding cables and gun assembly for loose or faulty connections.

**Poor arc striking with electrode sticking or blasting off.**

1. Make sure settings for wire feed speed and voltage are correct for process being used.
2. The Run-In (Fast or Slow) speed may be wrong for process and technique being used. See Operation Section.
3. The gas shielding may be improper for process being used



### CAUTION

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **LOCAL AUTHORIZED LINCOLN ELECTRIC FIELD SERVICE FACILITY** for assistance before you proceed.

## TROUBLESHOOTING

### **Rough wire feeding or wire will not feed but drive rolls are turning.**

1. The gun cable may be kinked or twisted.
2. The wire may be jammed in the gun cable, or gun cable may be dirty.
3. Check drive roll tension and position of grooves.
4. Check for worn or loose drive rolls.
5. The electrode may be rusty or dirty.
6. Check for damaged or incorrect contact tip.
7. Check wire spindle for ease of rotation and adjust break tension knob if necessary.

### **The wire feed stops while welding. When trigger is released and pulled again the wire feed starts.**

1. Check the wire feed drive rolls and motor for smooth operation.
2. Check for restrictions in the wire feed path. Check the gun and cable for restrictions.
3. Make sure gun liner and tip are correct for wire size being used.
4. Make sure drive rolls and guide plates are clean and are the correct size.
5. Make sure the spot timer knob is set to off.
6. Check spindle for ease of rotation.

### **Gas does not flow when gun trigger is pulled.**

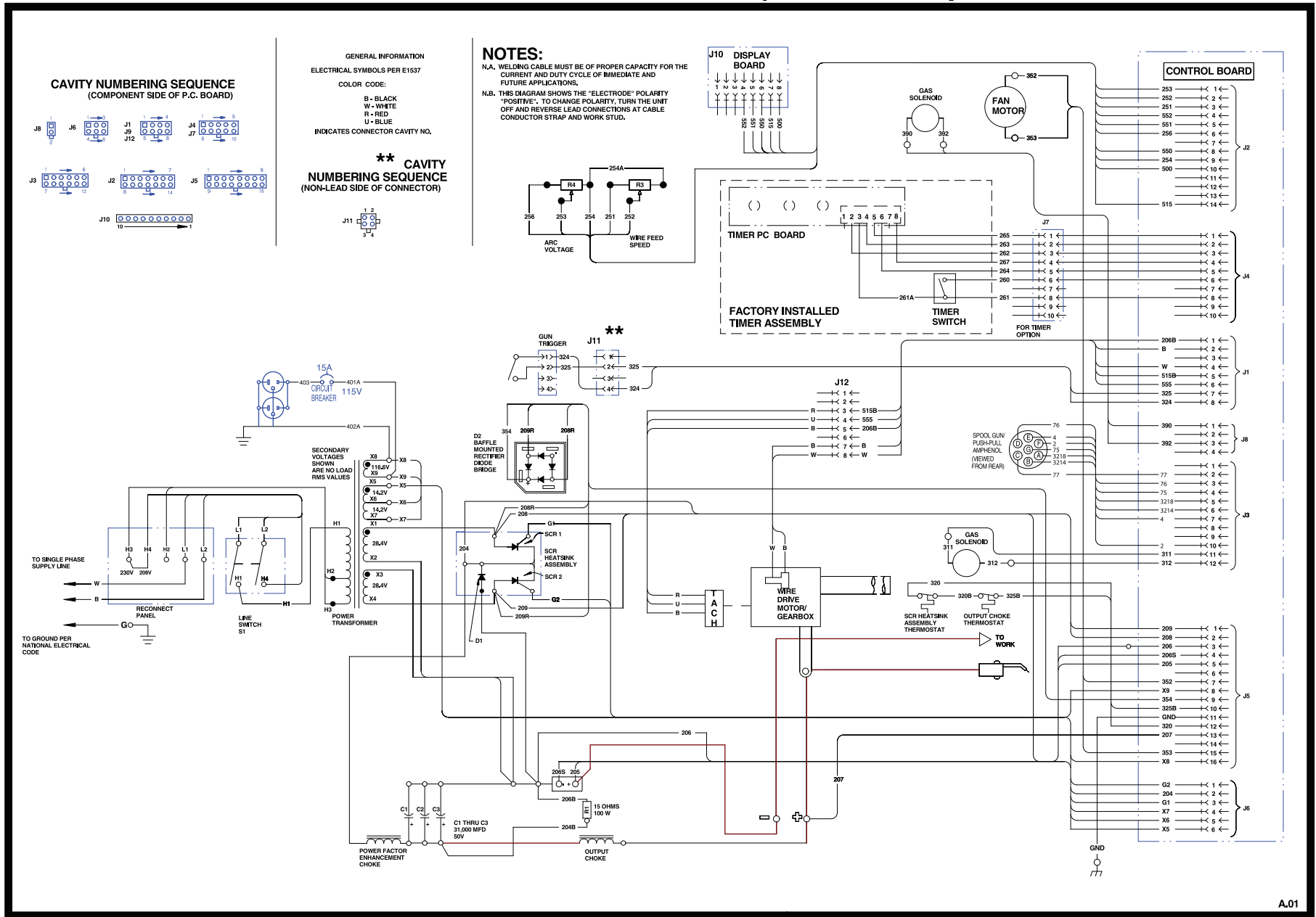
1. Make sure gas supply is connected properly and turned "on".
2. If the gas solenoid does actuate (click) when the gun trigger is pulled there may be a restriction in the gas supply line.
3. The gun cable assembly may be faulty. Check or replace.
4. If gas solenoid does not operate when gun trigger is pulled the problem is within the POWER MIG® 255XT.
5. Make sure the gun is pushed all the way into gun mount and is properly seated.



### **CAUTION**

If for any reason you do not understand the test procedures or are unable to perform the tests/repairs safely, contact your **LOCAL AUTHORIZED LINCOLN ELECTRIC FIELD SERVICE FACILITY** for assistance before you proceed.

# POWER MIG 255XT (208/230V)

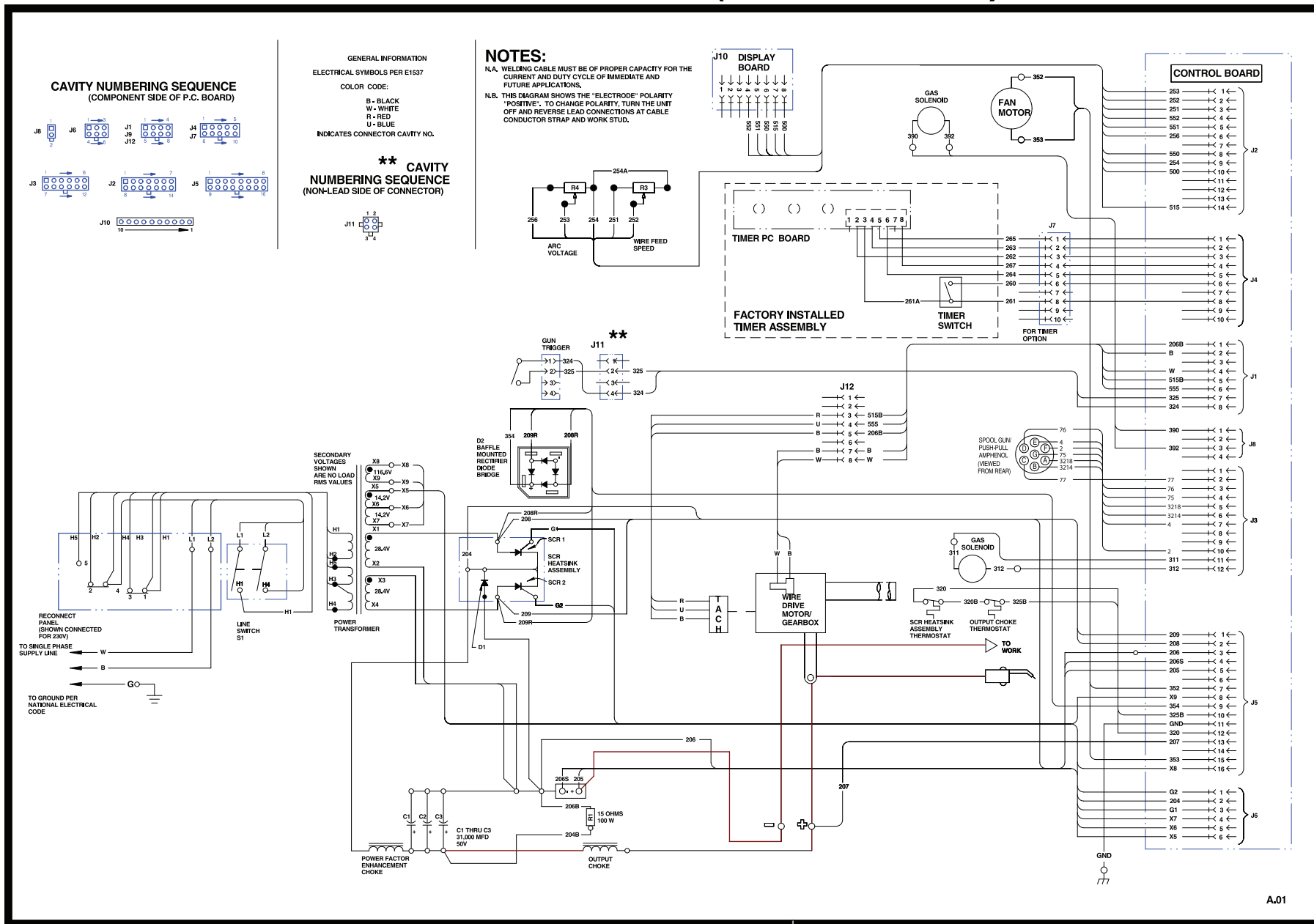


A.01

L12464-1

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.

# POWER MIG 255XT (230/460/575V)

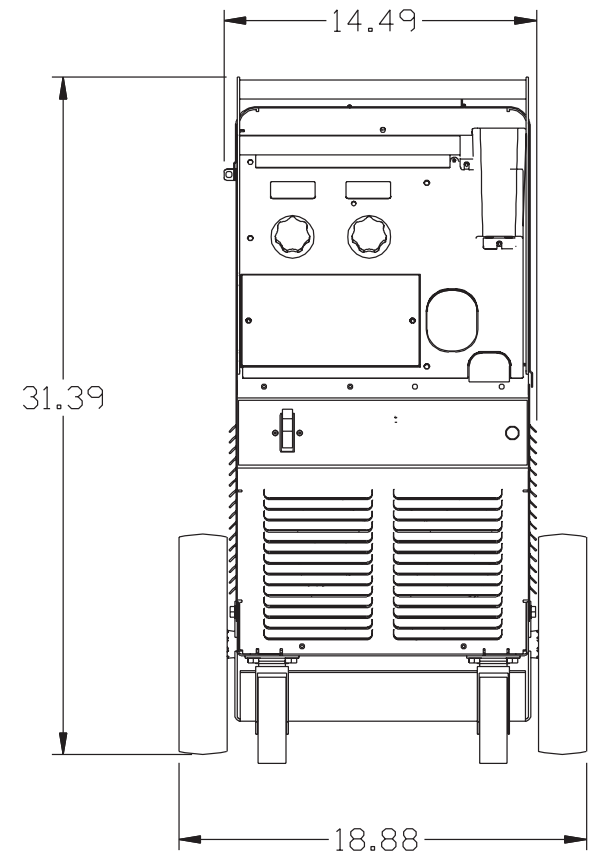
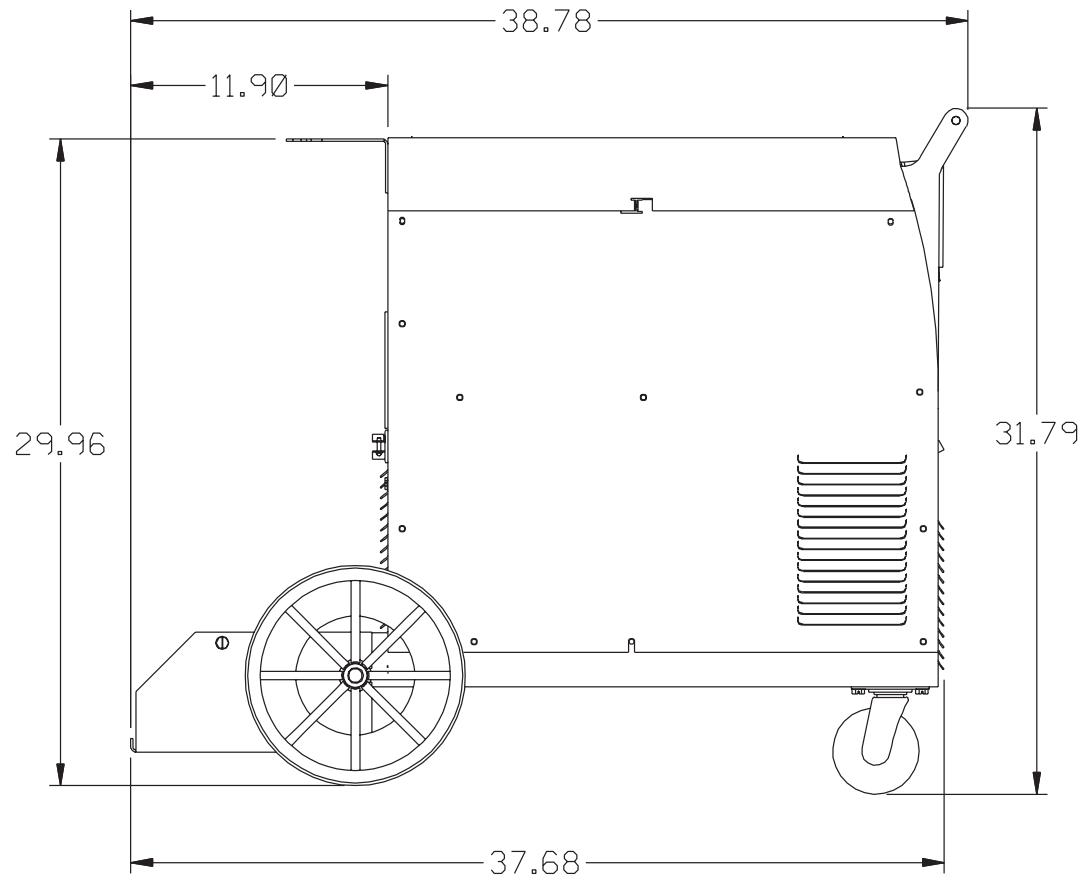


A.01






L12506-1

NOTE: This diagram is for reference only. It may not be accurate for all machines covered by this manual. The specific diagram for a particular code is pasted inside the machine on one of the enclosure panels. If the diagram is illegible, write to the Service Department for a replacement. Give the equipment code number.

**DIMENSION PRINT POWER MIG®  
255XT**



**A  
M19231**

				
<p><b>WARNING</b></p>	<ul style="list-style-type: none"> <li>● Do not touch electrically live parts or electrode with skin or wet clothing.</li> <li>● Insulate yourself from work and ground.</li> </ul>	<ul style="list-style-type: none"> <li>● Keep flammable materials away.</li> </ul>	<ul style="list-style-type: none"> <li>● Wear eye, ear and body protection.</li> </ul>	<ul style="list-style-type: none"> <li>● Keep your head out of fumes.</li> <li>● Use ventilation or exhaust to remove fumes from breathing zone.</li> </ul>

		
<ul style="list-style-type: none"><li>● Turn power off before servicing.</li></ul>	<ul style="list-style-type: none"><li>● Do not operate with panel open or guards off.</li></ul>	<b>WARNING</b>

**READ AND UNDERSTAND THE MANUFACTURER'S INSTRUCTION FOR THIS EQUIPMENT AND THE CONSUMABLES TO BE USED AND FOLLOW YOUR EMPLOYER'S SAFETY PRACTICES.**