



Welding & Cutting Solutions

2017 Equipment Catalog







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Icons

Output Icons



For constant current stick and TIG processes



Alternating current welding output



Peak auxiliary power output



2-Roll Wire Feeder



For constant voltage MIG, flux-cored and subarc processes



Direct current welding output



Surge auxiliary power output



4-Roll Wire Feeder



For multiprocess constant current or constant voltage applications



Alternating or direct current welding output



Continuous auxiliary power output

Input Icons



Single phase input power



115 Volt AC Wire feeder input power



50 Hertz input power



Engine Driven: Diesel, Gas or LPG



Three phase input power



42 Volt AC Wire feeder input power



60 Hertz input power



115 V INPUT 230 V INPUT



Single or three phase input power



40 Volt DC Wire feeder input power



50/60 Hertz input power

Warranty Commitment



3 Year Warranty

You have a right to expect that the welding and cutting equipment, electrode and flux you purchase will be free of defects in workmanship and material. Standing behind the high quality of our products, Lincoln Electric's warranty commitment to its customers leads the industry in breadth and scope.



For example, our limited warranty extends to 7 Years on many of our main power rectifiers. With few exceptions, all industrial welders and power sources carry a full 3 Year Lincoln Electric warranty. Electrode, wire and flux are warranted for 1 full year, as are environmental systems.



Extended Warranty Available

If you choose, you can extend the duration of the Lincoln Electric warranty on your Lincoln Electric industrial welder and cutting machines by two years with the Lincoln Electric Extended Warranty. Available only in the United States and Canada. Visit our web site for more information.



Quality Systems

Choose welding suppliers wisely . . . look for third party certifications on the companies and products you select. In fact, some of your projects or customers may require it. Many Lincoln Electric manufacturing sites have been inspected and registered to the world's ISO standards. In fact, Lincoln Electric was the first welding manufacturer to be registered to the tough ISO 9001 and 14001 standards.

However, there's more. Equipment destined for harsh environments is often tested to IP21, IP23 and IP23S standards. Products intended for the Canadian market meet stringent CSA (Canadian Standards Association) standards. Electrode is tested to comply with AWS (American Welding Society) and often ASME Boiler Pressure codes, ABS (American Bureau of Shipping), CWB/CSA (Canadian Welding Bureau) and MIL qualifications. Certificates of Conformance are available at our web site.

Operator Manuals and Replacement Parts Lists

Service Navigator - Electronic Parts Catalog

Quickly navigate to service documentation for a particular machine by utilizing the code number filter.

CUSTOMER ASSISTANCE POLICY

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

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



STICK WELDERS

MODEL	OUTPUT			PROCESS				INPUT		FEATURES						
	Mode	Polarity	Current Range (Amps)	Stick	TIG Scratch	Touch Start TIG*	Arc Gouge	Phase	Hertz	Compact	115/230 Volt Auto-Sensing	Hot Start	Arc Force	Meters	7-yr Warranty (Power Rectifier)	Polarity Switch
COMMERCIAL																
Invertec® V155-S	CC	DC	5-155 DC	●		●		1	50/60	●	●	●	●			
AC 225™	CC	AC	40-225 AC	●				1	50/60	●						
AC/DC 225/125™	CC	AC/DC	30-125 DC 40-225 AC	●				1	50/60	●						●
INDUSTRIAL																
Idealarc® 250	CC	AC/DC	40-250 DC 35-300 AC	●			●	1	60							●
Invertec® V275-S	CC	DC	5-275 DC	●		●	●	1/3	50,60	●		●	●			
Idealarc® R3R-400	CC	DC	60-500 DC	●	●		●	3	60				●	●	●	●
Idealarc® R3R-500	CC	DC	75-625 DC	●	●		●	3	60				●	●	●	●

KEY: ● Excellent ● Good ● Optional

Invertec® V155-S

High-Performance Stick Welder In A Portable Package

- Two stick welding modes provide optimal welding performance for Soft [E7018] and Crisp [E6011] electrode applications
- Auto-Adaptive Arc Force minimizes spatter and electrode sticking in the puddle without compromising arc stability when stick welding
- Touch Start TIG® mode provides TIG welding capabilities in a stick machine
- Automatically connects to either 120V or 230V power



Processes

- Stick
- DC TIG

Output



Input



Literature

E2.141

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V155-S	K2605-1	120/1/50/60	75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG	24.0A 33.8A 21.5A 28.8A	5-155 Amps DC Max. OCV: 75V	11.3 x 6.2 x 15.4 (288 x 158 x 392)	14.7 (6.7)
		230/1/50/60	100A/24.0V/100% Stick 145A/25.8V/30% Stick 100A/14.0V/100% TIG 155A/16.2V/30% TIG	21.0A 31.0A 14.1A 22.8A			

⁽¹⁾Input amps on 60 Hz input.

AC 225™

Proven For Generations, Built To Last A Lifetime

- 40-225 amps AC output control allows for 3/16 in. [4.8 mm] diameter mild steel stick electrodes and 5/32 in. [4.0 mm] diameter of other electrode types.



Processes

- Stick

Output



Input



Literature

E2.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
AC 225™	K1170	230/1/60	225A/25V/20% ⁽¹⁾	50A	40-225 Amps Max. OCV: 79V	24 x 17.25 x 12 (610 x 438 x 305)	109 (49.5)

⁽¹⁾Except 75 amp setting which can be used continuously for 1 hour.

AC/DC 225/125™

An Iconic AC/DC Stick Welder That's Built To Last

- 225 amp AC output is enough for 3/16 in. (4.8 mm) diameter general purpose mild steel electrodes
- 125 amp DC output is enough for most 1/8 in. (3.2 mm) electrodes



Processes

- Stick

Output



Input



Literature

E2.60

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
AC/DC 225/125™	K1297	230/1/60	AC: 225A/25V/20% DC: 125A/25V/20%	AC: 50A DC: 36A	40-225 Amps AC Max. OCV: 79V 30-125 Amps DC Max. OCV: 73V	24 x 17.25 x 12 (610 x 438 x 305)	124 (56.3)

Idealarc® 250

Rugged. Reliable. Red.

- Up to 300 amps welding output in AC and 250 amps in DC polarity enables the operation of some 1/4 in. (6.4 mm) electrodes
- Suitable for use with a variety of stick electrode types, including low hydrogen, stainless steel, hardfacing, and cast iron
- Full-range continuous control provides precise command of heat input
- The K1053-9 Idealarc® 250 model features Power Factor Capacitors (PFC)



Processes

- Stick
- Gouging

Output



Input



Literature

E2.70

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® 250 w/PFC ⁽¹⁾	K1053-9	208/230/460/1/60	AC: 250A/30V/30% DC: 250A/30V/30%	75/68/34A	35-300 Amps AC Max. OCV: 72V 40-250 Amps DC Max. OCV: 70V	27 x 19 x 21.5 (686 x 483 x 546)	350 (159)
Base Model	K1053-8	230/460/575/1/60		86/43/34A			

⁽¹⁾PFC = Power Factor Capacitors

Invertec® V275-S

Cover All Your Bases

- Outstanding stick performance, including E6010 and E7018 and everything in between, for both whip and drag techniques
- Selectable Hot Start technology enables enhanced arc starting on thick and dirty material
- Full welding output regardless of input power



Processes

- Stick
- DC TIG
- Gouging

Output



Input



Literature

E2.161

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V275-S Base Model or Base Model w/Tweco® Style Receptacles⁰	K2269-1	208/230/460/575/3/60	275A/31V/35% 250A/30V/60% 200A/28V/100%	38/37/19/16A 34/33/17/14A 27/25/13/11A	5-275A	13.6 x 9.0 x 20.25 (345 x 229 x 514)	54.5 (24.7)
	K2269-3	208/230/460/575/1/60	275A/29-31V/35% 250A/30V/60% 200A/28V/100%	68/67/38/31A 63/62/33/27A 49/48/26/21A			
		220/380/400/ 415/440/3/50	250A/30V/35% 200A/28V/100%	32/20/19/18/17A 25/15/15/14/13A			
		220/380/400/ 415/440/1/50		63/42/40/38/36A 48/32/30/29/27A			

⁰With Tweco®-style output connectors. Tweco® is a registered trademark of Victor Technologies International, Inc.

Idealarc® R3R-400

Heavy-Duty Stick Welding For The Long Haul

- Polarity switch, voltmeter and ammeter (analog)
- Ideal for hardfacing applications
- Seven-year transformer warranty
- Wide operating range of 60-500 amps and exceptionally smooth arc with mild steel, low hydrogen and stainless steel electrodes
- Arc gouge using up to 5/16 in. (7.9 mm) diameter carbon electrode
- Stackable case design conserves floor space



Processes

- Stick
- DC TIG
- Gouging

Output



Input



Literature

E2.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® R3R-400	K1285-16	230/460/3/60	400A/36V/60%	74/37A	60-500A Max. OCV: 67V	27.5 x 22.3 x 32 (699 x 566 x 813)	402 (183)

Idealarc® R3R-500

More Amps For Heavy-Duty Stick Welding and Gouging

- Arc gouge with the R3R-500 using up to 3/8 in. (9.5 mm) diameter carbon electrode
- Polarity switch, voltmeter and ammeter (analog)
- Substantial amperage range at 72-625 amps for use on thicker materials
- Seven-year transformer warranty
- Stackable case design conserves floor space



Processes

- Stick
- DC TIG
- Gouging

Output



Input



Literature

E2.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® R3R-500	K1286-16	230/460/3/60	500A/40V/60%	88/44A	72-625A Max. OCV: 67V	27.5 x 22.3 x 32 (699 x 566 x 813)	446 (203)
	K1286-25	230/460/575/3/60					

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V155-S

Base Model (K2605-1)

- Stick electrode holder, cable and Twist Mate™ plug
- Work cable and clamp with Twist Mate plug
- Fully adjustable shoulder strap
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- Extra 120V 20 Amp plug

AC 225™

Base Model (K1170)

- Insulated electrode holder and cable
- Heavy duty work clamp and cable
- Helpful Welder's Guide
- Input Cable with integrated plug

AC/DC 225/125™

Base Model (K1297)

- Insulated electrode holder and cable
- Heavy duty work clamp and cable
- Helpful Welder's Guide
- Input Cable with integrated plug



Shown:
Invertec® V155-S



Shown:
AC 225™



Shown:
AC/DC 225/125™

Accessories

Product Name	Product No.	Inverter [®] V155-S		AC/DC 225 [™]		Idealarc [®] 250		Inverter [®] V275-S		Idealarc [®] R3R-400		Idealarc [®] R3R-500	
		Base Model	Base Model	Base Model	Base Model w/PFC	Base Model	Base Model	Base Model	Base Model w/Tweco [®]	Base Model	Base Model	Base Model	Base Model
		K2605-1	K1170	K1297	K1053-9	K1053-8	K2269-1	K2269-3	K1285-16	K1286-16	K1286-25		
GENERAL													
Wheel Kit	K761		•	•									
Undercarriage	K866				•	•							
Welding Cart with 80 cu. ft. (2.27 m ³) bottle capacity	K2275-1	•											
Twist Mate [™] Cable Plug for 6-4 Cable	K852-25	•											
Twist Mate [™] Cable Plug for 1/0-2/0, 50-70 mm ² Cable	K852-70						•	•					
Twist Mate [™] Cable Plug for 2/0-3/0, 70-95 mm ² Cable	K852-95						•	•					
Twist Mate [™] Receptacle for 1/0-2/0, 50-70 mm ² Cable	K1759-70						•	•					
Twist Mate [™] Receptacle for 2/0-3/0, 70-95 mm ² Cable	K1759-95						•	•					
Tweco [®] Style Cam-Lock Adapter Plug	K2946-1						•	•					
Arc Tracker [™]	K3019-1				•	•	•	•	•	•	•	•	•
Undercarriage – Hand moving	K841								•	•	•		
Work Lead Package, 15 ft. (4.6 m) 4/0 Cable	K2149-1								•	•	•		
Weld Fume Control System	See Fume Sec.	•	•	•	•	•	•	•	•	•	•	•	•
STICK													
Accessory Kit, 150 Amp	K875				•	•	•	•					
Accessory Kit, 400 Amp	K704				•	•	•	•	•	•	•	•	•
Stick Electrode Holder, Work Clamp, Cable & Twist Mate [™] Set	K2394-1						•	•					
Remote Output Control, 6-pin, 25 ft. (7.6 m)	K857						•	•	•	•	•	•	•
Remote Output Control, 6-pin, 100 ft. (30 m)	K857-1						•	•	•	•	•	•	•
TIG													
Pro-Torch [™] TIG Torches	See Guns Sec.						•	•	•	•	•	•	•
PTA-17V Flex Head Gas Vavle TIG Torch w/Ultra-Flex [™] Cable, 12.5 ft. (3.8 m), 1 pc.	K1782-13	•											
Small Twist Mate [™] Torch Adapter (with separate gas)	K960-2	•											
Parts Kit for PTA-17 Series Torches	KP508	•											
Deluxe Adjustable Gas Regulator & Hose Kit	K586-1	•							•	•	•		
TIG-Mate [™] 17V TIG Torch Starter Kit (air-cooled)	K2265-1						•	•					
Twist Mate [™] Torch Adapter (with separate gas)	K960-1						•	•					
Foot Amptrol [™]	K870						•	•	•	•	•	•	•
Hand Amptrol [™] (Rotary Track Style)	K963-3						•	•	•	•	•	•	•
TIG Module	K930-2								•	•	•		
Docking Kit	K939-1								•	•	•		
Contractor Kit	K938-1								•	•	•		
Control Cable, 9-pin to 6-pin and 115V plug	K936-3								•	•	•		
Control Cable Extension, 45 ft. (13.7 m)	K937-45								•	•	•		

Accessories

Product Name	Product No.	Accessories													
		Base Model	Inverterc® V155-S	Base Model	AC225™	Base Model	AC/DC 225/125™	Base Model	Idealarc® 250	Base Model	Inverterc® V275-S	Base Model	Idealarc® R3R-400	Base Model	Idealarc® R3R-500
		K2605-1													
		K1170													
		K1297													
		K1053-9													
		K1053-8													
		K2269-1													
		K2269-3													
		K1285-16													
		K1286-16													
		K1286-25													
2-YEAR EXTENDED WARRANTY															
Inverterc® V155-S	-		•												
AC 225™	-			•											
AC/DC 225/125™	-				•										
Idealarc® 250	-					•	•								
Inverterc® V275-S	-							•	•						
Idealarc® R3R-400	-											•			
Idealarc® R3R-500	-												•	•	



TIG WELDERS

MODEL	OUTPUT			PROCESS			INPUT		FEATURES						
	Mode	Polarity	TIG Current Range (Amps)	Stick	Touch Start TIG [®]	TIG High-Freq [™] Start	Phase	Hertz	Auto Sensing	Micro-Start [™] II	Auto-Balance [®]	Adjustable AC Frequency	Ready-Pak [®]	TIG Pulse	Adjustable AC Balance
CONVENTIONAL TECHNOLOGY															
Precision TIG [®] 225	CC	AC/DC	5-230	●		●	1	50/60		•	•		•	•	•
Precision TIG [®] 275	CC	AC/DC	2-340	●	●	●	1	50/60		•	•		•	• ^[3]	•
Precision TIG [®] 375	CC	AC/DC	2-420	●	●	●	1	50/60		•	•		•	•	•
INVERTER TECHNOLOGY															
Invertex [®] V155-S	CC	DC	5-155	●	●		1	50/60	•				•		
Invertex [®] V160-T	CC	DC	5-160	●	●	●	1	50/60	•					•	
Square Wave [®] TIG 200	CC	AC/DC	10-200 ^[1]	●		●	1	50/60	•			•		•	•
Aspect [®] 375	CC	AC/DC	2-375 ^[2]	●	●	●	1/3	50/60	•		•	•	•	•	•

KEY: ● Excellent ● Good ● Optional

^[1] 230 Volts

^[2] Three-phase

^[3] Pulse available with Advanced Pulse Control Panel

Invertec® V155-S

Best-in-Class TIG and Stick Performance

- Touch Start TIG® mode provides TIG welding capabilities in a stick machine
- Two stick welding modes provide optimal welding performance for Soft (E7018) and Crisp (E6011) electrode applications
- Auto-Adaptive Arc Force minimizes spatter and electrode sticking in the puddle without compromising arc stability when stick welding
- Automatically connects to 120V or 230V service



Processes

- Stick
- DC TIG

Output



Input



Literature

E2.141

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output ⁽¹⁾	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V155-S [Ready-Pak® Pkg.]	K2606-1	120/1/50/60	Stick: 75A/23.0V/100% Stick: 100A/24.0V/30% TIG: 105A/14.2V/100% TIG: 130A/15.2V/30%	24.0A 33.8A 21.5A 28.8A	5-155 Amps DC Max. OCV: 75V	11.3 x 6.2 x 15.4 (288 x 158 x 392) (machine only)	14.7 (6.7) (machine only)
		230/1/50/60	Stick: 100A/24.0V/100% Stick: 145A/25.8V/30% TIG: 100A/14.0V/100% TIG: 155A/16.2V/30%	21.0A 31.0A 14.1A 22.8A			

⁽¹⁾Input amps on 60 Hz input.

Invertec® V160-T

High Performance TIG Welding In A Compact Design

- High-frequency TIG starting makes it easy to establish an arc under a variety of conditions
- Built in pulsing functions help minimize heat input on thin materials, and provide for a faster freezing weld puddle for uphill welding on curved surfaces such as process piping
- Ideally suited for maintenance operations and other external field operations
- Automatically connects to 120V or 230V service



Processes

- Stick
- DC TIG

Output



Input



Literature

E3.105

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V160-T	K1845-1	120/1/50/60 20A Branch Circuit	TIG: 90A/14.6V/100% Stick: 60A/22.4V/100%	20A	5-160 Amps DC Max. OCV: 48V	13 x 8 x 17 (330 x 203 x 432)	24 (10.8)
		120/1/50/60 30A Branch Circuit	TIG: 110A/14.4V/100% Stick: 80A/23.2V/100%	25A			
		230/1/50/60 30A Branch Circuit	TIG: 130A/15.2V/100% Stick: 130A/25.2V/100%	20A			

Square Wave® TIG 200

200 Amp AC/DC TIG and Stick Welding Power Source

- Simple user interface makes machine setup easy
- Available features like pulse mode help make you a better TIG welder, faster
- High frequency starting for aluminum welding
- Built-in settings for more cleaning action or wider or tighter arc configurations for aluminum welding
- TIG welding for critical welds where precision and bead appearance are important
- Bonus of stick welding capability for outdoor work or thicker materials
- Plugs into a standard 120V or 230V circuit
- Portable and convenient to use – only 46 lb (21 kg)



Processes

- Stick
- AC/DC TIG

Output



Input



Literature

E3.38.1

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Square Wave® TIG 200	K5126-1	120/1/50/60	TIG: 125A/25% ⁽¹⁾ TIG: 100A/40% TIG: 85A/60% Stick: 75A/20% Stick: 65A/60%	22 17 14 19 16	TIG: 10-125A Stick: 10-90A	14 x 10.75 x 19.25 (358 x 282 x 502)	46 (21)
		230/1/50/60	TIG: 200A/25% TIG: 160A/40% TIG: 130A/60% Stick: 170A/20% Stick: 100A/60%	22 17 13 25 13	TIG: 10-200A Stick: 10-170A		

⁽¹⁾120V AC TIG 110A/25%

STACK DIMES AND SAVE DOLLARS.



The Square Wave® TIG 200 allows welding enthusiasts of all levels to explore their creativity. The user interface makes machine setup easy and includes advanced features that will help you become a better TIG welder, faster. Whether you're TIG welding aluminum or stick welding, this feature-packed, 46-pound machine is ready to work from either 120V or 230V circuit, so you can Take it Everywhere, Plug in Anywhere.™



Precision TIG® 225

Versatile TIG and Stick Welder

- Easy-to-use operator interface – select mode, polarity and weld
- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum
- Take full control: Adjust cleaning action or penetration on aluminum. Enable the TIG pulser to minimize distortion from excessive heat input
- Offers outstanding stick welding capabilities
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.37

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Precision TIG® 225 Ready-Pak® Pkg.	K2535-1	208/230/1/60	130A/40% 110A/60%	40% Duty Cycle: 61/55 60% Duty Cycle: 52/47	5-230 Amps AC 5-230 Amps DC Max. OCV: 75V	20.7 x 14.5 x 25.6 (526 x 368 x 650)	212 (96)
Ready-Pak® w/Cart Pkg.	K2535-2					31.2 x 19.8 x 38 (794 x 503 x 966)	258 (117)
Base Model	K2533-2	460/575/1/60		40% Duty Cycle: 28/22 60% Duty Cycle: 23/19		20.7 x 14.5 x 25.6 (526 x 368 x 650)	192 (87)
	K2534-1	380/400-415/1/50/60		40% Duty Cycle: 33/32 60% Duty Cycle: 28/27			

Precision TIG® 275

A TIG Welding Workhorse

- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum. Or, take full control to adjust cleaning or penetration.
- Delivers the widest output range in its class from 2-340 amps
- Upgrade with the optional Advanced Pulse Control panel to enable better control over heat input, resulting in less distortion on thin metals
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.51

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Precision TIG® 275 Ready-Pak® w/Cart Pkg.	K2618-1	208/230/460/1/60	275A/40% 225A/60%	40% Duty Cycle: 104/94/47A 60% Duty Cycle: 86/78/39	DC: 2-340A AC: 2-340A Max. OCV: 75V	49.7 x 28 x 41 (1262 x 711 x 1041)	641 (291)
Base Model	K2619-1						
	K2619-2	460/575/1/60		40% Duty Cycle: 47/38A 60% Duty Cycle: 39/31			
	K2620-1	220-230/380-400/ 415/1/50/60		40% Duty Cycle: 95/55/50A 60% Duty Cycle: 80/46/42			

Precision TIG® 375

Precision Welding, Maximum Range TIG Welder

- Tackle either end of the material thickness spectrum with the widest operating range in its class from 2 to 420 amps
- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum. Or, take full control to adjust cleaning or penetration.
- Standard pulse functions enable better control over heat input, resulting in less distortion on thin metals
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.51

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Precision TIG® 375 Ready-Pak® w/Cart Pkg.	K2624-1	208/230/460/1/60	375A/40% 350A/60%	40% Duty Cycle w/PFC: 112/102/51A 60% Duty Cycle: 102/92/46	DC: 2-420A AC: 2-420A Max. OCV: 80V	49.7 x 28 x 41 (1262 x 711 x 1041)	751 (341)
Base Model	K2622-1	230/460/575/1/60		40% Duty Cycle w/PFC: 102/51/41A 60% Duty Cycle: 92/46/37		31 x 22 x 26 (787 x 559 x 660)	507 (230)
	K2622-2						
	K2623-1	220-230/380-400/ 415/1/50/60	40% Duty Cycle w/PFC: 119/69/63A 60% Duty Cycle: 110/64/59				

Aspect® 375

Advanced TIG Technology Made Simple

- Effortless arc control for the smoothest welds
- AC Auto-Balance® makes it simple by automatically providing the optimal mix of cleaning and penetration on aluminum
- Activate Intellistart™ to provide for soft starts on thin materials for minimal distortion and hotter starts on thick materials
- Customize when you need it: Manage AC frequency, balance and offset to modify arc profile, cleaning action or penetration



Processes

- AC/DC TIG
- Stick

Output



Input



Literature

E3.117

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Aspect® 375 Base Model	K3945-1	3-Phase: 200-600/50/60	3-Phase: 330A/40% 300A/60%	3-Phase: 60% Duty Cycle: 29/26/15/12/10 40% Duty Cycle: 27/24/14/11/9	3-Phase: 2-375A	21 x 11.8 x 25.5 (533 x 300 x 648)	105 (47.6)
Ready-Pak® Pkg.	K3946-2	1-Phase: 200-230/50/60	1-Phase: 240A/40% 225A/60%	1-Phase: 60% Duty Cycle: 34/31/NA/NA/NA 40% Duty Cycle: 32/29/NA/NA/NA	1-Phase: 2-250A	47 x 23 x 45 (1194 x 584 x 1143)	290 (132)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V155-S

TIG Ready-Pak® Welding Package (K2606-1)

- Invertec® V155-S (K2605-1)
- Stick electrode holder & cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Work clamp & cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord [6.6 ft. (2 m)] with a 120V 15 Amp plug
- Extra 120V 20 Amp plug
- Gas Regulator & Hose (3000369)
- PTA-17V TIG torch w/Ultra-Flex™ cable and Twist Mate™ adapter
- PTA-17 TIG torch parts (KP508)
- Easy-Store/Easy-Carry Suitcase

Invertec® V160-T

Base Model (K1845-1)

- 115V Input cord (10 ft.) and plug (NEMA 5-15P)
- 20 Amp Plug (NEMA 5-20P)
- Twist Mate® Torch Adapter for PTA-9 or -17 one-piece torch
- Fully adjustable shoulder strap
- Work Clamp & Cable, 10 ft., (3.0 m)

Square Wave™ TIG 200

Base Model (K5126-1)

- PTA-17 Series 150A Air-Cooled TIG Torch with Flexible Head and Ultra-Flex™ Cable Assembly
- Foot Amptrol™
- Regulator/Flowmeter with Gas Hose
- Stick Electrode Holder
- Ground Clamp
- 120/230V Input Cords

Precision TIG® 225

Base Model (K2533-1)

- Torch Parts Storage Compartment
- Torch Hanger
- 10 ft. (3.0 m) Work Cable & Clamp
- Removable Lift Eye
- 9 ft. (2.7 m) Input Power Cord with NEMA 6-50P Plug
- NEMA 6-50R Receptacle
- TIG Procedure Guide
- GTAW (TIG) Handbook

Ready-Pak® Package (K2535-1)

- Everything Listed Above (K2533-2)
- PTA-17 TIG Torch with Ultra-Flex™ Cable Assembly
- Twist Mate Adapter
- TIG Torch Parts
- Gas Regulator & Hose (3000369)
- Foot Amptrol™
- Work Clamp and Cable, 10 ft. (3.0 m)

Ready-Pak w/Cart Package (K2535-2)

- Everything Listed Above (K2535-1)
- Understorage Cart



Shown:
Invertec® V155-S
Ready-Pak® Pkg.



Shown:
Precision TIG® 225
Ready-Pak® w/Cart Pkg.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Precision TIG® 275

Ready-Pak® w/Cart Package (K2618-1)

- Precision TIG® 275 (K2619-1)
- Under-Cooler Cart
- Foot Amptrol™
- Harris® Gas Flowmeter Regulator & 10 ft. (3.0 m) Hose Kit (3100338)
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- TIG Torch Parts Kit (KP510)
- Water Hose (2 included)
- 15 ft. (4.5 m) 2/0 Work Cable/Clamp
- PTA-9 or -17 Torch Adapter

Precision TIG® 375

Ready-Pak® w/Cart Package (K2624-1)

- Precision TIG® 375 (K2622-1)
- Under-Cooler Cart
- Foot Amptrol™
- Harris® Gas Flowmeter Regulator & 10 ft. (3.0 m) Hose Kit (3100338)
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- TIG Torch Parts Kit (KP510)
- Water Hose (2 included)
- 15 ft. (4.5 m) 2/0 Work Cable/Clamp
- Adapter for optional PTA-9 or -17 Torch, 3/8 in. (9.5 mm)

Aspect® 375

Ready-Pak® Package (K3946-2)

- Aspect 375® (K3945-1)
- Cool Arc® 47 Water Cooling System (K3950-1)
- TIG Welding Cart (K3949-1)
- 20H-320-25R 320 Amp Water Cooled TIG Torch (K4168-2)
- Twist Mate® Torch Cable Adaptor (K1622-5)
- TIG Torch Parts Kit (KP510)
- Foot Amptrol with 25 ft. (7.6m) Cable Assembly (K870)
- 15 ft. (4.5m) Work Lead Assembly (K1803-3)
- Gas Regulator With Hose (3100211)
- Low Conductivity Coolant (KP4159-1)



Shown:
Precision TIG® 275
Ready-Pak® w/Cart Pkg.



Shown:
Precision TIG® 375
Ready-Pak® w/Cart Pkg.



Shown:
Aspect® 375 Ready-Pak®

Accessories

Product Name	Product No.	Invertec® V155-S		Invertec® V160-T		Square Wave TIG 200		Precision TIG® 225		Precision TIG® 275		Precision TIG® 375		Aspect® 375
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2606-1	K1845-1	K5126-1	K2533-1	K2619-1	K2619-2	K2622-1	K2622-2	K3945-1				
GENERAL														
Undercarriage	K1869-1					•	•	•	•					
Understorage Cart	K2348-1				•									
Dual Cylinder Cart	K2617-1				•									
Inverter Cart	K3949-1													•
Welding Cart (80 cu ft. bottle capacity)	K2275-1	•	•											
Utility Cart (150 cu ft. bottle capacity)	K520		•	•										
Small Canvas Cover	K2377-1		•	•										
Medium Canvas Cover	K2378-1				•									
Advanced Control Panel	K2621-1					•	•							
Work Clamp & Cable Assembly	K2150-1					•	•	•	•					
Twist Mate™ Plug for 6-4 Cable	K852-25	•												
Weld Fume Control System	See Fume Sec.	•	•	•	•	•	•	•	•	•	•	•	•	•
STICK														
Stick Electrode Holder & Cable	K2374-1				•									
Stick Electrode Holder, Work Clamp, Cable & Twist Mate Set	K2394-1		•	•										
Stick Welding Accessory Kit, 150 Amp	K875					•	•							
Stick Welding Accessory Kit, 400 Amp	K704					•	•	•	•					
Remote Output Control, 25 ft (7.6 m)	K857					•	•	•	•					
Remote Output Control, 100 ft (3.0 m)	K857-1					•	•	•	•					
TIG														
Wireless Foot Pedal & Receiver	K4217-1				•	•	•	•	•	•	•	•	•	•
Replacement Wireless Pedal Transmitter	K4218-1				•	•	•	•	•	•	•	•	•	•
Replacement Wireless Receiver	K4219-1				•	•	•	•	•	•	•	•	•	•
Hand Amptrol™ (Rotary Track Style)	K963-3		•	•	•	•	•	•	•	•	•	•	•	•
Foot Amptrol™ with 25 ft (7.6 m) cable assembly	K870		•	•	•	•	•	•	•	•	•	•	•	•
Arc Start Switch	K814		•	•	•	•	•	•	•	•	•	•	•	•
PTA-9, PTW-20, 20-250-25R and 20H-320-25R Gas Lens Parts Kit	KP2414-1	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-9 -17 One Cable Torch Adapter	K2166-3					•	•	•	•					
PTA-9, -17, -26 Two Cable Torch Adapter	K2166-2					•	•	•	•					
PTA-26 One Cable Torch Adapter	K2166-1					•	•	•	•					
PTA-9 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc	K1781-1	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-9F Flex Head w/Ultra-Flex Cable TIG Torch Package, 12.5 ft (3.8 m), 1 pc	K1781-9	•	•	•	•	•	•	•	•	•	•	•	•	•

Accessories

Product Name	Product No.	Invertec® V155-S		Invertec® V160-T		Square Wave™ TIG 200		Precision TIG® 225		Precision TIG® 275		Precision TIG® 375		Aspect® 375
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2606-1	K1845-1	K5126-1	K2533-1	K2619-1	K2619-2	K2622-1	K2622-2	K3945-1				
TIG, CON'T.														
PTA-17 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc	K1782-1	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-17 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 1 pc	K1782-3	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-17 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 2 pc	K1782-4					•	•	•	•					
PTA-17 Pro-Torch™ TIG Torch, 150 amp, 12.5 ft (3.8 m), 1 pc	K1782-12	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-17FV Flex Head Gas Valve Pro-Torch™ TIG Torch w/Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc	K1782-13	•												
PTA-17F Ready-Pak®, 150 amp air-cooled TIG Torch w/Flex Head & Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc, and Twist-Mate™ adapter. Includes #7 nozzle, 1/16 in. (1.6 mm) and 3/32 (2.4 mm) collets & bodies, and E3 ⁺ tungsten	K1782-14	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-17F Pro-Torch™ TIG Torch, 150 amp air-cooled w/Flex Head and Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc	K1782-15	•	•	•	•	•	•	•	•	•	•	•	•	•
PTA-26 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc	K1783-1			•	•	•	•	•	•	•	•	•	•	•
PTA-26 200 Amp Air-Cooled TIG torch w/1 pc 25 ft (7.6 m) cable	K1783-3			•	•	•	•	•	•	•	•	•	•	•
PTA-26 200 Amp Air-Cooled TIG torch w/2 pc 25 ft (7.6 m) cable	K1783-4					•	•	•	•					
PTW-18 350 Amp Water-Cooled TIG torch with 12.5 ft (3.8 m) cable assembly	K1784-1				•	•	•	•	•	•	•	•	•	•
PTW-18 350 Amp Water-Cooled TIG torch w/3 pc. 25 ft (7.6 m) cable	K1784-2				•	•	•	•	•	•	•	•	•	•
PTW-20 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 3 pc braided	K1784-3		•	•	•	•	•	•	•	•	•	•	•	•
PTW-20 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 3 pc braided	K1784-4		•	•	•	•	•	•	•	•	•	•	•	•
20H-320-25R 320 Amp Water Cooled TIG Torch, 3 pc. 25 ft. (7.6 m) covered cable	K4168-2				•	•	•	•	•	•	•	•	•	•
Parts Kit For PTA-9 Series Torches	KP507	•	•	•	•	•	•	•	•	•	•	•	•	•
Parts Kit For PTA-17 Series Torches	KP508	•	•	•	•	•	•	•	•	•	•	•	•	•
Parts Kit For PTW-18 and PTA-26 Series Torches	KP509		•	•	•	•	•	•	•	•	•	•	•	•
Parts Kit for 20-250-25R, 20H-320-25R, and PTW-20 TIG Torches	KP510		•	•	•	•	•	•	•	•	•	•	•	•
TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)	K2266-1		•	•	•									
TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)	K2267-1		•	•	•									
Harris® Ar/CO2 Flowmeter/Regulator with 10 ft (3.0 m) Gas Hose Kit	3100211		•	•	•	•	•	•	•	•	•	•	•	•
Zippered Torch Cable Cover, 10 ft (3.0 m)	K918-1	•	•	•	•	•	•	•	•	•	•	•	•	•
Zippered Torch Cable Cover, 22 ft (6.7 m)	K918-2	•	•	•	•	•	•	•	•	•	•	•	•	•
Zippered Torch Cable Cover, Heavy Duty, 22 ft (6.7 m)	K918-4	•	•	•	•	•	•	•	•	•	•	•	•	•
Small Twist Mate™ TIG Torch Adapter (w/separate gas)	K960-2	•												
Twist Mate™ Torch Adapter, PTA-9 and -17	K1622-1		•	•	•									•
Twist Mate™ Torch Adapter, PTA-26	K1622-3		•	•	•									•
Twist Mate™ Torch Adapter, Water-Cooled (for use with Cool Arc® 40)	K1622-4		•	•	•									
Twist Mate™ Torch Adapter, Water-Cooled (for use with Cool Arc® 47)	K1622-5													•

Accessories

Product Name	Product No.																	
		Inverter [®] V155-S	Inverter [®] V160-T	Square Wave [™] TIG 200	Precision TIG [®] 225	Precision TIG [®] 275	Precision TIG [®] 375	Aspect [®] 375	Base Model	Base Model	Base Model	Base Model						
		K2606-1	K1845-1	K5126-1	K2533-1	K2619-1	K2619-2	K2622-1	K2622-2	K3945-1								
TIG, CON'T.																		
Cool Arc [®] 40 Water Cooler 115/1/50/60	K1813-1		•	•	•													
Cool Arc [®] 40 Water Cooler for 230V	K2187-1		•	•	•													
Cool Arc [®] 47 Water Cooling System	K3950-1																	•
Under-Cooler Cart Water Cooler	K1828-1					•	•	•	•									
Water Hose Kit, 25 ft (7.6 m) (5/8 LH CGA to 5/8 LH CGA)	K1859-2		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Magnum [®] Pro-Torch [™] TIG Torches	See 12.150			•														
Cut Length Consumables	See C1.10	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
2-YEAR EXTENDED WARRANTY																		
Inverter [®] V155-S	—	•																
Inverter [®] V160-T	—		•															
Square Wave [™] TIG 200	—			•														
Precision TIG [®] 225	—				•													
Precision TIG [®] 275	—					•	•											
Precision TIG [®] 375	—							•	•									
Aspect [®] 375	—																	•



MIG: WIRE FEEDER/WELDERS

MODEL	OUTPUT				PROCESS					INPUT		FEATURES							
	Current Range (Amps)	Wire Feed Speed Range ipm (m/min)	Solid Wire Size Range in (mm)	Cored Wire Size Range in (mm)	MIG	MIG Pulsed	Flux-Cored	Stick	Touch Start TIG*	Phase	Hertz	Portable	Consumable Storage	Meters/Digital Display	Synergic Control	Spool Gun Capable	Push-Pull Model	Diamond Core Technology*	Chopper Technology*
120 VOLT INPUT																			
POWER MIG® 140C	30-140	50-500 (1.3-12.7)	0.023-0.035 (0.6-0.9)	0.030-0.035 (0.8-0.9)	●	●				1	60	●				●		●	
120/230 VOLT INPUT																			
POWER MIG® 180 Dual	120V: 30-140 230V: 30-180	50-500 (1.3-12.7)	0.023-0.035 (0.6-0.9)	0.030-0.045 (0.8-1.2)	●	●				1	60	●				●		●	
POWER MIG® 210 MP	120V: 20-140 230V: 20-220	50-500 (1.3-12.7)	0.023-0.035 (0.6-0.9)	0.030-0.045 (0.8-1.2)	●		●	●	●	1	60	●	●	●		●			
208-230 VOLT INPUT																			
POWER MIG® 180C	30-180	50-500 (1.3-12.7)	0.025-0.035 (0.6-0.9)	0.030-0.045 (0.8-1.2)	●		●			1	60	●				●		●	
POWER MIG® 216	30-250	50-700 (1.3-17.7)	0.023-0.045 (0.6-1.2)	0.030-0.045 (0.8-1.2)	●		●			1	50/60		●			●		●	
POWER MIG® 256	30-300	50-700 (1.3-17.7)	0.023-0.045 (0.6-1.2)	0.030-0.045 (0.8-1.2)	●		●			1	60		●	●		●		●	
POWER MIG® 350MP	5-350	50-700 (1.3-17.7)	0.023-0.045 (0.6-1.2)	0.030-0.045 (0.8-1.2)	●	●	●	●	●	1	50/60		●	●	●	●	●		●

KEY: ● Excellent ● Good ● Optional

POWER MIG® 140C**MIG Welding Made Simple**

- 120-volt input enables you to plug in at home for repair projects or auto body work
- Consistent wire feeding through MAXTRAC® dual gear-driven drive roll system
- PC boards are fully encapsulated and additionally protected by a framed tray for maximum circuit protection
- Reliable wire delivery and extended tip life with Magnum® PRO gun and Copper Plus™ contact tips

**Processes**

- MIG
- Flux-Cored

Output**Input****Literature**

E7.23

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 140C	K2471-2	120/1/60	90A/19.5V/20%	20A	30-140A	50-500 (1.3-12.7)	14 x 10.15 x 18.6 (357 x 258 x 472)	58 (26.3)

POWER MIG® 180C**The Professional's Choice.™**

- 230-volt input power to tackle jobs big and small
- Consistent wire feeding through dual gear-driven drive rolls
- Encapsulated PC boards for optimal circuit protection

**Processes**

- MIG
- Flux-Cored

Output**Input****Literature**

E7.24

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 180C	K2473-2	208/230/1/60	130A/17V/30% 130A/20V/30%	20A	30-180A	50-500 (1.3-12.7) Max. OCV: 34	14 x 10.15 x 18.6 (357 x 258 x 472)	66 (30)

POWER MIG® 180 Dual

The Best of Both Worlds

- Choose 120-volt or 230-volt input power for light materials or thicker metals
- Consistent wire feeding through dual gear-driven drive rolls
- Encapsulated PC boards for optimal circuit protection
- Spool gun ready



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.28

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 180 Dual	K3018-2	120/1/60	120V: 90A/19.5V/20%	20A	30-140A	50-500 (1.3-12.7)	14 x 10.15 x 18.6 (357 x 258 x 472)	68 (31)
		208/230/1/60	208V: 130A/17.6V/30% 230V: 130A/20V/30%		30-180A			

POWER MIG® 210 MP

Versatile, Rugged & Simple To Use

- Lightweight and portable – just 40 lbs. (18 kg)
- Ready. Set. Weld® – intuitive push-and-turn digital controls make setup a breeze
- 210 Amps – the power to tackle any job



Processes

- MIG
- Flux-Cored
- DC Stick
- DC TIG

Output



Input



Literature

E7.50

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 210 MP	K3963-1	120/1/60 230/1/60	120V: 100A/19.0V/40% 230V: 200A/24V/25%	120V: 15A 230V: 14.7A	120V: 20-140A DC Max. OCV: 56V	50-500 (1.3-12.7)	14 x 10.75 x 19 (356 x 273 x 483)	40 (18)
Aluminum One-Pak®	K4195-1				230V: 20-220A DC Max. OCV: 56V			
TIG One-Pak®	K4195-2							

POWER MIG® 216

Best Wire Delivery from Spool to Spark

- Simple dual knob controls are ideal for sheet metal and autobody
- Fast and easy setup (no tools required) means less time prepping and more time welding
- Delivers a smooth arc and minimal spatter in any position
- Spool gun ready with Magnum® PRO 100 SG; spool gun capable with other models



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.52

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 216	K2816-2	208/230/1/60 220/1/50	170A/24V DC/60% 216A/22V DC/30%	208V: 33A @ 170A/24V DC/60% 208V: 40A @ 216A/22V DC/30% 230V: 30A @ 170A/24V DC/60% 230V: 36A @ 216A/22V DC/30%	30-250A	50-700 [1.6-17.8]	32.6 x 19.2 x 40.0 [828 x 488 x 1,016]	206.5 [93.7]

POWER MIG® 256

POWER MIG® with Precision Control

- Ideal for light industrial and maintenance work
- Weld up to 3/4 in. [19.1 mm] mild steel with self-shield flux-cored wire
- Digital meters help dial in exact settings and timer functions deliver additional weld control
- Spool gun ready for our premium Magnum® 250LX



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.55

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 256	K3068-1	208/230/1/60	250A/26V/40%	56/52A ⁽¹⁾	30-300A	50-700 [1.3-17.7]	31.8 x 18.9 x 38.8 [808 x 480 x 985]	220 [100]
	K3068-2 ⁽²⁾	230/460/575/1/60		50/24/19A				
One-Pak® w/Spool Gun	K3069-1	208/230/1/60		56/52A ⁽¹⁾				

⁽¹⁾Input current is at the rated output with the 115V auxiliary receptacle also drawing 15 amps.

⁽²⁾Does not include input cable.

POWER MIG® 350MP

The Professional's Choice!™ – Multi-Process Welder

- Weld stick, TIG and MIG with one multi-process machine
- Up to three ways to feed aluminum, including push gun, spool gun or push-pull gun, depending on frequency of use and budget
- Capable of advanced pulse processes to control heat input and penetration in the weld
- Consistent wire feeding through the all-metal MAXTRAC® dual gear-driven drive roll system



Processes

- Stick
- TIG
- MIG
- Pulsed
- Flux-Cored

Output



Input



Literature

E7.57

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Wire Feed Speed ipm (m/min)	H x W x D in (mm)	Net Wt. lb (kg)
POWER MIG® 350MP	K2403-2	208/230/460/575/1/50/60	300A/32V/60% ⁽¹⁾	72/62/31/25A	5-350A DC Max. OCV: 67V	50-700 (1.3-17.7)	31.8 x 18.9 x 38.8 (808 x 480 x 985)	255 (116)
Aluminum One-Pak® Pkg. for Trailer Mfg./General Fab.	K4023-1							
Aluminum One-Pak® Pkg. for Auto Body Repair	K4023-2							

⁽¹⁾40% on 208V input. Ratings based on 60 Hz operation.

POWER MIG[®] 210 MP

multi-process welder



3 PROCESSES ■ 2 INPUT VOLTAGES ■ 210 AMPS
ONE POWERFUL MACHINE



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

POWER MIG® 140C

Base Model (K2471-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

POWER MIG® 180C

Base Model (K2473-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

POWER MIG® 180 Dual

Base Model (K3018-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- 120V and 230V Input Cables
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

POWER MIG® 210 MP

Base Model (K3963-1)

- Magnum® PRO 175L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive Roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- 120V and 230V Input Cables
- Work Clamp and Cable, 10 ft. (3.0 m)
- Electrode Holder and Lead Assembly
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 0.5 lb. (0.23 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 0.5 lb. (0.23 kg) Spool of Innershield® NR®-211-MP Flux-Cored Wire

Aluminum One-Pak® Package (K4195-1)

- Everything listed above for Base Model
- Replacement Screen Shield
- Magnum® PRO 100SG Spool Gun

TIG One-Pak® Package (K4195-2)

- Everything listed above for Base Model
- Replacement Screen Shield
- PTA-17V Ultra-Flex™ TIG Torch, 12 ft. (3.8 m)
- Twist-Mate™ TIG Torch Adapter
- Foot Amptrol™
- Foot Amptrol™ Adapter

POWER MIG® 216

Base Model (K2816-2)

- Magnum® PRO 250L Gun, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- 230V Input Power Cable
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

POWER MIG® 256

Base Model (K3068-2)

- Magnum® PRO 250L Gun, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

Base Model (K3068-1)

- Everything listed with base model K3068-2
- 230V Input Power Cable

One-Pak® Package (K3069-1)

- Everything listed with base model K3068-1
- Magnum® 250LX Spool Gun
- Dual Cylinder Mounting Kit
- Extra Gas Regulator

POWER MIG® 350MP

Base Model (K2403-2)

- Magnum® PRO Curve 300, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- 230V Input Power Cable
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

Aluminum One-Pak® Package for Trailer Manufacturing/General Fab (K4023-1)

- Everything listed with base model
- Magnum® PRO AL gun G225A, 7-pin, 25 ft. (7.6 m)
- Aluminum Drive Roll Kit, 3/64 in. (1.2 mm)
- SuperGlaze® 5356 TM™ 3/64 in. (1.2 mm), 16 lb. (7.3 kg.) Spool

Aluminum One-Pak® Package for Auto Body Repair (K4023-2)

- Everything listed with base model
- Magnum® PRO AL gun G225A, 7-pin, 25 ft. (7.6 m)
- Aluminum Drive Roll Kit, 3/64 in. (1.2 mm)
- SuperGlaze® 5554 3/64 in. (1.2 mm), 16 lb. (7.3 kg.) Spool



Shown:
POWER MIG® 210 MP
Base Model with
Standard Accessories



Shown:
POWER MIG® 256
One-Pak® Package



Shown:
POWER MIG® 350 MP
One-Pak® Package

Accessories

Product Name	Product No.	POWER MIG® 140C	POWER MIG® 180C	POWER MIG® 180 Dual	POWER MIG® 210 MP	POWER MIG® 216	POWER MIG® 256	POWER MIG® 350MP	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	
		K2471-2	K2473-2	K3018-2	K3963-1	K2816-2	K3068-1	K3068-2	
GENERAL									
Welding Cart (80 cu. ft. bottle capacity)	K2275-1	•	•	•	•				
Utility Cart (150 cu. ft. bottle capacity)	K520	•	•	•	•				
Canvas Cover	K2377-1	•	•	•	•				
Canvas Cover	K2378-1					•	•	•	•
Spot Timer Kit	K2525-1	•	•	•					
Accessory Bag	K3071-1	•	•	•	•				
Connector Kit – POWER MIG®	K466-6					•	•	•	
8 in. (203.2 mm) O.D. Spool Adapter	K468					•	•	•	
Dual Cylinder Mounting Kit	K1702-1					•	•	•	•
Drive Roll, 0.025-0.030 in. (0.6-0.8 mm) Smooth	KP2529-1	•	•	•	•				
Drive Roll, 0.035 in. (0.9 mm) Smooth	KP2529-2	•	•	•	•				
Drive Roll, 0.030-0.045 in. (0.8-1.1 mm) Knurled	KP2529-3	•	•	•	•				
Inner Wire Guide, 0.025-0.035 in. (0.6-0.9 mm) Steel	KP2531-1	•	•	•	•				
Inner Wire Guide, 0.045 in. (1.1 mm) Steel	KP2531-2	•	•	•	•				
Drive Roll Kit, 0.023-0.030 in. (0.6-0.8 mm) Solid Wire	KP1696-030S					•	•	•	•
Drive Roll Kit, 0.035 in. (0.9 mm) Solid Wire	KP1696-035S					•	•	•	•
Drive Roll Kit, 0.035 and 0.045 in. (0.9 and 1.1 mm) Solid Wire	KP1696-1					•	•	•	•
Drive Roll Kit, 0.040 in. (1.0 mm) Solid Wire	KP1696-2					•	•	•	•
Drive Roll Kit, 0.045 in. (1.1 mm) Solid Wire	KP1696-045S					•	•	•	•
Drive Roll Kit, 0.030-.035 in. (0.8-0.9 mm) Cored Wire	KP1697-035C					•	•	•	•
Drive Roll Kit, 0.040-0.045 in.	KP1697-045C					•	•	•	•
Drive Roll Kit, 0.035 in. (0.9 mm) Aluminum Wire	KP1695-035A								•
Drive Roll Kit, 3/64 in. (1.2 mm) Aluminum Wire	KP1695-3/64A					•	•	•	•
Weld Fume Control System	—	•	•	•	•	•	•	•	•
STICK									
Accessory Kit, 150 Amp	K875								•
TIG									
Pro-Torch™ TIG Torches	See Gun Sec.				•				•
Parts Kit For PTA-17 Series Torches	KP508				•				•
Parts Kit For PTW-18 and -26 Series Torches	KP509								•
Foot Amptrol™	K870				•				•
Hand Amptrol™ (Rotary Track Style)	K963-3				•				•
POWER MIG® 210 MP TIG Amptrol® Adaptor Kit	K4104-1				•				
Arc Start Switch	K814								•
Cut Length Consumables	See C1.10				•				•

Accessories

Product Name	Product No.								
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		POWER MIG® 140C	POWER MIG® 180C	POWER MIG® 180 Dual	POWER MIG® 210 MP	POWER MIG® 216	POWER MIG® 256	POWER MIG® 350MP	
WIRE FEEDER / GUNS									
Magnum® PRO AL G225A Air-Cooled Push-Pull Guns									
7-pin, 15 ft. (4.5 m)	K3356-1								•
7-pin, 25 ft. (7.6 m)	K3356-2								•
7-pin, 35 ft. (10.6 m)	K3356-3								•
7-pin, 50 ft. (15.2 m)	K3356-4								•
Magnum® PRO AL G450W Water-Cooled Push-Pull Guns									
7-pin, 15 ft. (4.5 m)	K3358-1								•
7-pin, 25 ft. (7.6 m)	K3358-2								•
7-pin, 35 ft. (10.6 m)	K3358-3								•
7-pin, 50 ft. (15.2 m)	K3358-4								•
Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 25 ft. (7.6 m)	K2704-2								•
Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 50 ft. (15.2 m)	K2704-3								•
SPOOL GUN									
Magnum® PRO 100SG Spool Gun	K3269-1	•	•	•	•	•			
Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)	K487-25					•	•	•	
Magnum® SG Spool Gun Control Cable Adapter	K2445-1						•	•	
Magnum® 250LX™ Spool Gun	K2490-1					•	•	•	•
Adapter Kit for Magnum® SG or Magnum® 250LX™ Spool Gun	K2703-1					•			
Control Cable Extension, 25 ft. (7.6 m)	K2519-1						•	•	•
Spool Gun Holder	K1738-1								•
2-YEAR EXTENDED WARRANTY									
POWER MIG® 140C	—	•							
POWER MIG® 180C	—		•						
POWER MIG® 180 Dual	—			•					
POWER MIG® 210 MP	—				•				
POWER MIG® 216	—					•			
POWER MIG® 256	—						•	•	
POWER MIG® 350MP	—								•



MIG & FCAW: INDUSTRIAL WELDERS

MODEL	OUTPUT			PROCESS				INPUT		FEATURES		
	Mode	Polarity	Current Range (Amps)	MIG	Flux-Cored	Submerged Arc	Arc Gouging	Phase	Hertz	Digital Display	Stackable	7-yr. Warranty (on Power Rectifier)
300 AMPS												
Idealarc® CV305	CV	DC	50-400	●	●			3	60	•	•	•
400 AMPS												
Idealarc CV400	CV	DC	60-500	●	●		●	3	60		•	•

KEY: ● Excellent ● Good ● Optional

Idealarc® CV305

Dependable High Output Wire Welding

- Digital Ammeter/Voltmeter – view voltage presets and current during welding
- Easy access Twist Mate™ connections on the front of the machine
- Two output connectors allow you to connect to high or low inductance for optimal arc control



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E4.22

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® CV305 Base Models	K2400-1	208/230/460/3/60	315A/32.6V/100%	52/48/24A	50-400A 7-34V	24.6 x 19.5 x 27.0 (625 x 495 x 686)	300 (136)
	K2400-2	230/460/575/3/60		48/24/19A			
Ready-Pak® Pkg w/LF-72 Wire Feeder	K2395-2	208/230/460/3/60		52/48/24A		47.7 x 25.5 x 33.0 (1212 x 648 x 838)	423 (192)

50 Hertz models available.

Idealarc® CV400

Dependable High Output Wire Welding

- Connect wire feeders via either 14-pin MS-type or terminal strip
- 115V and 42V wire feeder auxiliary power with circuit breaker protection



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E4.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® CV400 Base Models	K1346-22 ⁽¹⁾	230/460/575/3/60	400A/36V/100% 450A/38V/60%	77/39/31A 80/40/32A	60-500A 12-42V	27.5 x 22.2 x 32 (699 x 564 x 813)	383 (174)
	K1346-13	230/460/3/60		77/39A 80/40A			
Ready-Pak® Pkg w/LF-72 Wire Feeder	K2439-2					42.8 x 22.2 x 32 (1087 x 564 x 813)	475 (215)
Ready-Pak® Pkg w/LF-74 Wire Feeder	K2496-2						

⁽¹⁾Made to order.

50 Hertz models available.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Idealarc® CV305

Ready-Pak® Package (K2395-2)

- CV305 Power Source (K2400-1)
- LF-72 Bench Model, Standard Duty Wire Feeder
- Standard Wire Reel Stand
- Work & Wire Feeder Weld Cable Package, includes 15 ft (4.5 m) Work Cable, 10 ft (3.0 m) Electrode Cable and Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire

Idealarc® CV400

CV400/LF-72 Ready-Pak® Package (K2439-2)

- CV400 Power Source (K1346-13)
- LF-72 Bench Model, Heavy Duty Wire Feeder
- Heavy Duty Wire Reel Stand
- Weld Power Cable, 10 ft. (3.0 m), Qty. 2
- Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire

CV400/LF-74 Ready-Pak® Package (K2496-2)

- CV400 Power Source (K1346-13)
- LF-74 Bench Model, Heavy Duty Wire Feeder
- Heavy Duty Wire Reel Stand
- Weld Power Cable, 10 ft. (3.0 m), Qty. 2
- Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire



Shown:
Idealarc® CV400/LF72
Ready-Pak®

Accessories

Product Name	Product No.	Idealarc® CV305		Idealarc® CV400	
		Base Model	Base Model	Base Model	Base Model
		K2400-1	K2400-2	K1346-22	K1346-13
GENERAL					
Remote Output Control, 25 ft. (7.6 m)	K857	•	•	•	•
Remote Output Control, 100 ft. (30 m)	K857-1	•	•	•	•
Remote Control Cable Adapter (required for use of K857 and K857-1)	K864	•	•	•	•
Twist Mate™ Cable Plug for 1/0-2/0 (50-70 mm ²) cable	K852-70	•	•		
Twist Mate™ Cable Plug for 2/0-3/0 (70-95 mm ²) cable	K852-95	•	•		
Jumper Plug Kit	K484 ⁽¹⁾	•	•	•	•
Undercarriage – Hand moving	K874	•	•		
Undercarriage – Hand moving	K841			•	•
Arc Tracker™	K3019-1	•	•	•	•
Weld Fume Control System	—	•	•	•	•
WIRE FEEDER					
LF-72, LF-74, LN-25 PRO	—	•	•	•	•
LN-8, LN-9, LN-10, DH-10, LN-25 PRO Dual Power, FlexFeed™ 74 HT, Activ8™	—			•	•

⁽¹⁾Made to order.



MULTI-PROCESS WELDERS

MODEL	OUTPUT		Current Range (Amps)	PROCESS						INPUT		FEATURES	
	Mode	Polarity		Stick	TIG	MIG	MIG Pulse	Flux-Cored	Submerged Arc	Arc Gouge	Phase	Hertz	CrossLinc®
INVERTER TECHNOLOGY													
Invertec® V350 PRO	CC/CV	DC	5-425	●	●	●	○	●	●	1/3	50/60		
FLEXTEC® 350X	CC/CV	DC	5-425	●	●	●		●	●	3	50/60	•	
FLEXTEC® 500	CC/CV	DC	5-500	●	●	●		●	●	3	50/60		
FLEXTEC® 500P	CC/CV	DC	5-500	●	●	●	●	●	●	3	50/60		•
AlumaFab®	CC/CV	DC	5-500			●	●			3	50/60		•
FLEXTEC® 650X	CC/CV	DC	10-815	●	●	●		●	●	3	50/60	•	
PERFORMANCE MONITORING													
Arc Tracker®	CC/CV	DC	—	●	●	●	●	●	●	1	50/60		
RECTIFIER TECHNOLOGY													
Idealarc® DC400	CC/CV	DC	60-500	●	●	●		●	●	3	60	•	
Idealarc® DC600	CC/CV	DC	70-850	●	●	●		●	●	3	60	•	

KEY: ● Excellent ◐ Good ○ Optional

Invertec® V350 PRO

Multi-Purpose Welder with Multiple Models

- Highly portable at less than 90 lb. (41 kg)
- Greater flexibility for input power for any environment or location
- All input voltages and frequencies are both single- and three-phase rated; no derating necessary on single-phase



Processes

- Stick
- DC TIG
- MIG
- Pulsed MIG (Advanced Process Panel only)
- Flux-Cored
- Gouging

Output



Input



Literature

E5.91

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V350 PRO Construction	K1728-5	200-208/230/ 380-415/460/575/ 1/3/50/60	350A/34V/60% 300A/32V/100%	3-Ph: 50/42/28-26/23/18 1-Ph: 94/85/54/42/37	5-425A Max. OCV: 80V DC	14.8 x 13.3 x 27.9 (376 x 338 x 709)	81 36.7
Factory	K1728-6						86 (39)
Factory [Tweco®]	K1728-13	208/230/415/460/ 575/1/3/50/60		3-Ph: 41-39/36/23-22/19/16 1-Ph: 76/69/41/36/31			86.5 (37.4)
CE Model	K1728-12	200-220/380-400/ 415-440/1/3/50/60	3-Ph: 350A/34V/60% 1-Ph: 320A/33V/60% 3-Ph: 300A/32V/100% 1-Ph: 275A/31V/100%	3-Ph: 48/28-27/26-24 1-Ph: 82/55-50/48-45 3-Ph: 41-37/28-22/22-21 1-Ph: 64/44-43/38-35			370 (168)
V350 PRO/LF-72 Ready-Pak® Pkg.	K2437-2	200-208/230/ 380-415/460/575/ 1/3/50/60	350A/34V/60% 300A/32V/100%	3-Ph: 50/42/28-26/23/18 1-Ph: 94/85/54/42/37		55.2 x 28.5 x 55.5 (1403 x 724 x 1410)	370 (168)

FLEXTEC® 350X

A Rugged Mult-Process Power Source for Maximum Flexibility

- Simple operator panel minimizes setup time
- Reliable components designed to run cool for long life in high temperature environments
- Flexible enough to work with across-the-arc, analog, digital or CrossLinc® wire feeders
- Embedded CrossLinc® Technology enables remote procedure setting at the feeder to save time and improve weld quality



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Arc Gouging

Output



Input



Literature

E5.97

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 350X Standard Construction	K4272-1	380/460/575/3/50/60	300A/32V/100% 350A/34V/60%	26/23/18	5-425A Max OCV 80V DC	17 x 13 x 23 (477 x 356 x 673)	82 (37)
Standard/LF-72 Heavy Duty One-Pak® Pkg.	K3438-1						77 (35)
Standard/Flex Feed® 84 Single Bench Heavy Duty One-Pak® Pkg.	K3439-1						179 (81)
Construction/LN-25X One-Pak® Pkg.	K4278-1						165 (75)
							127 (58)

Idealarc® DC400

Multiple Processes, Rugged Design

- Arc force control adjusts for a soft arc or a forceful driving arc in the stick/TIG mode
- Arc control adjustment changes the pinch effect of the arc to control spatter, fluidity and bead shape in the MIG/Flux-cored mode
- Voltage line compensation helps maintain weld consistency



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.20

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® DC400 w/115V Duplex GFCI	K1308-25	230/460/575/3/60	400A/36V/100% 450A/38V/60% 500A/40V/50%	3-Ph: 78/39/31A	60-500A 12-42V	27.5 x 22.3 x 33.1 (698 x 566 x 840)	473 (215)
w/Multi-Process Switch	K1308-12	230/460/3/60		3-Ph: 78/39A			

FLEXTEC® 500

It Doesn't Get Much Simpler Than Flextec®

- Streamlined operator panel minimizes set up time
- Components designed to run cool for long life in high temperature environments
- Compatible with a variety of wire feeders - analog, digital and across-the-arc
- Premium multi-process arc characteristics for wire stick and DC TIG processes



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Arc Gouging

Output



Input



Literature

E5.97

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 500 Base Model	K4091-1	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	18.8 x 14 x 26.5 (477 x 356 x 673)	125 (57)
w/Flex Feed™ 74 HT Ready-Pak® Pkg.	K4093-1					53.375 x 34.375 x 42 (1346 x 864 x 1067)	352 (160)
w/LF-72 Ready-Pak® Pkg.	K4094-1						
w/LF-74 Ready-Pak® Pkg.	K4095-1						
w/LF-72 One-Pak® Pkg.	K4096-1					—	185 (84)
w/Flex Feed® 84 One-Pak® Pkg.	K3440-1					—	206 (93)

FLEXTEC® 500P

FLEXible Technology™

- Inverter-based technology saves energy
- Small footprint and light weight improves portability in shipyards, construction sites and other large work areas that require operator mobility
- IP23 enclosure ensures protection against inclement weather and other harsh environments
- Run both analog and digital feeders with the Flextec 500P
- Synergistic and pulsing capabilities ensure a more consistent bead appearance.



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Arc Gouging

Output



Input



Literature

E5.97

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 500P Base Model	K4092-1	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	3-Ph: 39/31/31A 3-Ph: 33/27/27A	5-500A	18.8 x 14 x 26.5 (477 x 356 x 673)	156 (71)
w/Power Feed® 84 Ready-Pak® Pkg.	K4097-1						393 (178)
w/CE Filter Kit One-Pak® Pkg.	K4091-3						143 (65)

AlumaFab®

Tap Into Maximum Welding Potential

- Easy to set up and operate
- Rugged enough for any heavy-duty aluminum industrial application
- Overcome common welding issues like erratic feeding, arc instability and soot
- Just dial in and weld with the most commonly used waveforms
- Standard CV Pulse and CV Spray modes plus CC Pulse (Constant Current Pulse)



Processes

- MIG
- Pulse MIG
- CC Pulse

Output



Input



Literature

E5.93b

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)		
AlumaFab® Base Model	K4189-1	460/575/3/60	GMAW (CV): 450A/36.5V/100%	3-Ph: 60% Duty Cycle: 39 3-Ph: 100% Duty Cycle: 33	5-500A	18.8 x 14 x 26.5 (477 x 356 x 673)	152 (69)		
Air-Cooled One-Pak®, 15 ft (4.6 m)	K4186-1						411(186)		
Air-Cooled One-Pak®, 35 ft (10.7 m)	K4186-3						419 (190)		
Air-Cooled One-Pak®, 50 ft (15.2 m)	K4186-4						425 (193)		
Air-Cooled Gun Ready-Pak®, 25 ft (7.6)	K4186-2						400 (181)		
Water-Cooled One-Pak®, 15 ft (4.6 m)	K4187-1						GMAW-P (CV): 450A/36.5V/100%	GMAW-P (CV): 500A/39V/60%	547 (248)
Water-Cooled One-Pak®, 35 ft (10.7 m)	K4187-3								555 (252)
Water-Cooled One-Pak®, 50 ft (15.2 m)	K4187-4								560 (254)
Water-Cooled Gun Ready-Pak®, 25 ft (7.6)	K4187-2								460 (209)

Idealarc® DC600

Idealarc® with Submerged Arc Capacity

- Full range output voltage control provides easy operation and precise control
- Voltage Reduction Device™ (VRD®) reduces open circuit voltage for an additional level of safety
- Circuitry protected against moisture and corrosive environments



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® DC600 w/Multi-Process Switch	K1288-18	230/460/3/60	600A/44V/100% 680A/44V/60%	3-Ph: 108/54A	CV: 70-780A, 13-44V CC: 90-780 A, 24-42V	30.7 x 22.2 x 38 (781 x 565 x 965)	554 (251)
w/Meters	K1288-17						
	K1288-22	230/460/575/3/60		3-Ph: 108/54A/43.2A			
w/VRD®	K1288-28 ⁽¹⁾						

⁽¹⁾Made to order. **Note** » 50 Hertz models also available.

Arc Tracker®

Monitor Weld and Operator Performance

- Advanced digital controls sample the welding arc at extremely high speeds
- Simple plug-and-play design enables you to connect to any DC welding circuit, attach voltage leads and immediately monitor arc performance
- Easily calibrated for use in factory quality systems



Processes

- DC Arc Welding Circuits Only (10-1000A @ 100% Duty Cycle)
- Any DC Polarity Welding Process
- Any DC Welding Power Source

Output



Input



Literature

E5.99

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Arc Tracker™	K3019-1 (US/Int'l)	120-230/1/50/60	NEMA EW1: 1,000/44/100% DC IEC 60974-1: 1,000/44/100% DC	0.8A @ 120V AC	—	12 x 9 x 15 (305 x 220 x 645)	20 (9.0)

FLEXTEC® 650X

Multi-Process Power for Heavy Duty Applications

- CrossLinc® Technology delivers full functionality without control cables for greater productivity, enhanced quality and improved job site safety
- Compatible with most Lincoln Electric feeders including portable across-the-arc, CrossLinc®, ArLink® and common bench or boom models
- Engineered for outdoor use and harsh environments (IP23 rated)
- Substantial gouging capability with up to a 1/2 in. (12.7 mm) carbon



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Arc Gouging

Output



Input



Literature

E5.97

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 650X Base Model	K3425-1	380/460/575/3/50/60	750/44/60% ⁽¹⁾	61/50/40A	40-815A	21.8 x 16.1 x 29.3 (554 x 409 x 584)	165 (75)
w/LF-74 HD One-Pak® Pkg.	K3513-1		650/44/100% ⁽¹⁾	57/47/38A			—
w/Flex Feed® 84 One-Pak® Pkg.	K3514-1		GTAW: 750/34/60%		GTAW: 10-815A		
w/CE Filter One-Pak® Pkg.	K3515-1		GTAW: 650/34/100%		SMAW: 15-815A		
w/LF-72 Ready-Pak® Pkg.	K3511-1						
w/LF-74 Ready-Pak® Pkg.	K3512-1						

⁽¹⁾Output is limited to 600A/100% and 700A/60% when used with the K3091.1 Multi-Process Switch

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V350 PRO

Ready-Pak® Package [K2437-2]

- V350 PRO Factory Model [K1728-6]
- LF-72 Heavy Duty Wire Feeder [K2327-6]
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. [4.6 m]
- Work & Wire Feeder 2/0 Welding Cable Package, 10 ft. [3.0 m]
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]
- Inverter and Wire Feeder Cart [K1764-1]

FLEXTEC® 350X

FLEXTEC® 350X Standard/LF-72 Heavy Duty One-Pak® Package [K3438-1]

- FLEXTEC® 350X Standard Model [K4272-1]
- Input Power Cord, 8.5 ft [2.6 m]
- LF-72 Bench Model, Heavy Duty Wire Reel Stand [K2327-7]
- Magnum® PRO Curve™ 300 Gun & Cable Ready-Pak, 15 ft [4.5 m]
- 2-Roll Drive Roll and Wire Guide Combination Kit 0.035-0.045 [0.9-1.1 mm] Solid Wire
- Tweco® Connector Cable Package (includes 10 ft [3 m] Work Clamp & Cable and 10 ft [3 m] Electrode Cable)
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]

FLEXTEC® 350X Standard/Flex Feed® 84 Heavy Duty One-Pak® Package [K3439-1]

- FLEXTEC® 350X Standard Model [K4272-1]
- Input Power Cord, 8.5 ft [2.6 m]
- Flex Feed® 84 Single Bench Model, Heavy Duty Wire Reel Stand [K5000-2]
- 4-Roll Drive & Wire Guide Kit, 0.040-0.045 [1.0-1.1 mm] Solid Wire
- Magnum® PRO Curve™ 300 Gun & Cable Ready-Pak, 15 ft [4.5 m]
- Tweco® Connector Cable Package (includes 10 ft [3 m] Work Clamp & Cable and 10 ft [3 m] Electrode Cable)
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]

FLEXTEC® 350X Construction/LN-25X One-Pak® Package [K4278-1]

- FLEXTEC® 350X Construction Model [K4271-1]
- Input Power Cord, 8.5 ft [2.6 m]
- LN-25X [K4267-1]
- 2-Roll Drive Roll and Wire Guide Kit, 0.045 [1.1 mm] Cored
- Magnum® PRO Curve™ 300 Gun & Cable Ready-Pak, 15 ft [4.5 m]

FLEXTEC® 500

FLEXTEC® 500/Flex Feed™ 74 HT Ready-Pak® Package [K4093-1]

- FLEXTEC® 500 [K4091-1]
- Flex Feed™ 74 HT [K3883-13]
- 3/0 Welding Cable, 10 ft. [3.0 m]
- Work Lead Package, 15 ft. [4.5 m] cable
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]
- Inverter and Wire Feeder Cart [K3059-4]
- Inverter Cart Mounting Bracket Kit
- Flextec® 500/500P Locking Foot Kit
- Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak®, 15 ft. [4.5 m]

FLEXTEC® 500/LF-72 Ready-Pak® Package [K4094-1]

- FLEXTEC® 500 [K4091-1]
- LF-72 Bench Model, Heavy Duty [K2327-7]
- 3/0 Welding Cable, 10 ft. [3.0 m]
- Work Lead Package, 15 ft. [4.5 m] cable
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]
- Inverter and Wire Feeder Cart [K3059-4]
- 2-Roll Drive and Wire Guide Kit, 0.035-0.045 [0.9-1.1 mm] Solid Wire
- Flextec® 500/500P Locking Foot Kit
- Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak®, 15 ft. [4.5 m]

FLEXTEC® 500/LF-74 Ready-Pak® Package [K4095-1]

- FLEXTEC® 500 [K4091-1]
- LF-74 Bench Model, Heavy Duty [K2426-5]
- Magnum® PRO Curve™ 400 Gun & Cable Assembly
- 3/0 Welding Cable, 10 ft. [3.0 m]
- Work Lead Package, 15 ft. [4.5 m] cable
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]
- Inverter and Wire Feeder Cart [K3059-4]
- 4-Roll Drive and Wire Guide Kit, 0.035-0.045 [0.9-1.1 mm] Solid Wire
- Flextec® 500/500P Locking Foot Kit
- Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak®, 15 ft. [4.5 m]

FLEXTEC® 500/LF-72 One-Pak® Package [K4096-1]

- FLEXTEC® 500 [K4091-1]
- LF-72 Bench Model, Standard Duty [K2327-5]
- 3/0 Welding Cable, 10 ft. [3.0 m]
- Work Lead Package, 15 ft. [4.5 m] cable
- Harris® Gas Regulator/Flowmeter and 10 ft. [3.0 m] Hose Kit [3100211]
- 2-Roll Drive and Wire Guide Kit, 0.035-0.045 [0.9-1.1 mm] Solid Wire



Shown:
Flextec® 500/LF-72
Ready-Pak® Package

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

FLEXTEC® 500, con't.

FLEXTEC® 500/Flex Feed® 84 Ready-Pak® Package (K3440-1)

- FLEXTEC® 500 (K4091-1)
- Flex Feed® 84 Single Bench Model (K5000-2)
- 3/0 Welding Cable, 10 ft. (3.0 m)
- Work Lead Package, 15 ft. (4.5 m) cable
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit (3100211)
- 4-Roll Drive and Wire Guide Kit, 0.040-0.045 (1.0-1.1 mm) Solid Wire
- Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak®, 15 ft. (4.5 m)

AlumaFab®⁽¹⁾

Air-Cooled One-Pak® Package (K4186-1)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/15 ft (4.5 m) Cable

Air-Cooled One-Pak® Package (K4186-3)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/35 ft (10.6 m) Cable

Air-Cooled One-Pak® Package (K4186-4)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/50 ft (15.2 m) Cable

Air-Cooled Ready-Pak® Package (K4186-2)

- AlumaFab Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft (7.6 m) Cable

AlumaFab®, con't.

Water-Cooled One-Pak® Package (K4187-1)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/15 ft (4.5 m) Cable

Water-Cooled One-Pak® Package (K4187-3)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/35 ft (10.6 m) Cable

Water-Cooled One-Pak® Package (K4187-4)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/50 ft (15.2 m) Cable

Water-Cooled Ready-Pak® Package (K4187-2)

- AlumaFab® Multi-Process Welder (K4189-1)
- Power Feed® 25M Semi-Automatic Wire Feeder (K4191-1)
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/25 ft (7.6 m) Cable



Shown:
AlumaFab® Water-Cooled
Ready-Pak® Pkg.

⁽¹⁾ **AlumaFab Air-Cooled Ready-Pak and One-Paks Include:** Drive Roll Kits, Diffusors, Nozzles, Tips, Liners, Work Lead Package, Base Mounting Assembly and Arclink® Control Cable.
Alumafab Water-Cooled Ready-Pak And One-Paks Include: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package, Base Mounting Assembly and Arclink® Control Cable.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

FLEXTEC® 500P

FLEXTEC® 500P/Power Feed® 84

Ready-Pak® Pkg. [K4097-1]

- FLEXTEC® 500P [K4092-1]
- Power Feed® 84, Heavy Duty Wire Reel Stand [K3328-13]
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Flextec® 500/500P Locking Foot Kit
- 3/0 Welding Cable, 10 ft. (3.0 m)
- Work Lead Package, 15 ft. (4.5 m) cable
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [3100211]
- Inverter and Wire Feeder Cart
- Inverter Cart Mounting Bracket

FLEXTEC® 500P w/CE Filter Kit One-Pak® [K4097-1]

- FLEXTEC® 500P [K4092-1]
- Flextec 500 CE Filter Kit

Arc Tracker™

Base Model [K3019-1]

- Detachable input cord 6 ft. (1.8 m) with NEMA 5-15P plug and an IEC 60320 plug receptacle.
- Polarity specific arc voltage remote sense leads 15 ft. (4.6 m) [Qty. 2]

FLEXTEC® 650X

FLEXTEC® 650X/LF-74 One-Pak® Pkg. [K3513-1]

- FLEXTEC® 650X [K3425-1]
- LF-74 Wire Feeder (Heavy Duty) [K2426-5]
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Connector Kit for 10-Series Feeders
- Liner, .052-1/16, 15 ft (4.5 m)
- Drive Roll and Guide Tube Kit, 1/16 in. (1.6 mm) Cored
- Weld Cable Lug to Lug 3/0, 10 ft (3.0 m)
- Work Lead Package, 4/0, 15 ft. (4.5 m) Cable, GC500
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [3100211]

FLEXTEC® 650X, con't.

FLEXTEC® 650X/Flex Feed® 84 One-Pak® Pkg. [K3514-1]

- FLEXTEC® 650X [K3425-1]
- Power Feed® 84 Single Bench (Heavy Duty) [K5000-2]
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Connector kit for 10-Series Feeders
- Liner .052-1/16, 15 ft (4.5 m)
- Drive Roll and Guide Tube Kit, 1/16 in (1.6 mm) Cored
- Weld Cable Lug to Lug 3/0, 10 ft (3.0 m)
- Work Lead Package, 4/0, 15 ft. (4.5 m) Cable, GC500
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [3100211]

FLEXTEC® 650X/CE Filter One-Pak® Pkg. [K3515-1]

- FLEXTEC® 650X [K3425-1]
- FLEXTEC® 650X CE Filter [K3129-1]

FLEXTEC® 650X/LF-72 Ready-Pak® Pkg. [K3511-1]

- FLEXTEC® 650X [K3425-1]
- LF-72 Wire Feeder (Heavy Duty, no gun) [K2327-7]
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Drive Roll and Guide Tube Kit, 0.045 in. (1.2 mm) Cored
- Weld Cable
- Work Lead Package, 15 ft. (4.5 m) Cable
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [3100211]
- Inverter and Wire Feeder Cart

FLEXTEC® 650X/LF-74 Ready-Pak® Pkg. [K3512-1]

- FLEXTEC® 650X [K3425-1]
- LF-74 Wire Feeder (Heavy Duty) [K2426-5]
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Connector Kit for 10-Series Feeders
- Liner, 052-1/16, 10/12/15 ft (3.0/3.7/4.5 m) Gun [44-116-15]
- Drive Roll, 1.6 mm Cored [LF-74]
- Weld Cable
- Work Lead Package, 15 ft. (4.5 m) Cable, GC500
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [3100211]
- Inverter and wire feeder cart



Shown:
FLEXTEC® 500P/Power Feed® 84
Ready-Pak® Pkg.

Accessories

Product Name	Product No.	Invertec® V350 PRO				FLEXTEC® 350X		Idealarc® DC400		FLEXTEC® 500		Alumafab®		FLEXTEC® 500P		Idealarc® DL600		FLEXTEC® 650X		Arc Tracter®
		Base Model Construction	Base Model Factory	Base Model Adv. Process	Base Model Tweco Factory	Base Model Standard	Base Model Construction	Base Model w/GFCI	Base Model w/Multi-Process Switch	Base Model	Base Model	Base Model	Base Model w/Multi-Process Switch	Base Model w/Meters	Base Model w/Meters	Base Model w/VRD®	Base Model	Base Model		
		K1728-5	K1728-6	K1728-7	K1728-13	K4272-1	K4271-1	K1308-25	K1308-12	K4091-1	K4189-1	K4092-1	K1288-18	K1288-17	K1288-22	K1288-28	K3425-1	K3019-1		
GENERAL																				
Advanced Process Panel	K1763-1		•	•	•															
Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m)	K586-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Work and Wire Feeder 2/0 Weld Cable Package, 10 ft. (3.0 m)	K1803-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
3/0 Welding Cable, 10 ft. (3.0 m)	K1842-10									•		•							•	
Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable	K852-70	•	•	•	•															
Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable	K852-95	•	•	•	•															
Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable	K1759-70	•	•	•	•															
Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable	K1759-95	•	•	•	•															
Twist Mate™ to Lug Cable Adapter	K2176-1	•	•	•	•															
Tweco® Style Cam-Lock Adapter Plug	K2946-1	•	•	•	•															
LC-40 – Tweco® Style Plug (male, 1/0 thru 2/0), 1/0-2/0 (50-70 mm²)	K3416-70					•	•													
LC-40HD – Tweco® Style Plug (male, 3/0 thru 4/0), 2/0-4/0 (70-70-95 mm²)	K3416-90					•	•													
LC-40 – Tweco® Style Receptacle (female, 1/0 thru 2/0), 1/0-2/0 (50-70 mm²)	K3417-70					•	•													
LC-40HD – Tweco-Style Receptacle (female, 3/0 thru 4/0), 2/0-4/0 (70-70-95 mm²)	K3417-90					•	•													
Inverter and Wire Feeder Cart	K1764-1	•	•	•	•															
Single Cylinder Inverter and Wire Feeder Cart ⁽⁴⁾	K3059-4					•	•			•	•	•							•	
Dual Cylinder Inverter and Wire Feeder Cart ⁽⁴⁾	K3059-5					•	•			•		•							•	
Dual Cylinder Mounting Kit	K1702-1	•	•	•	•															
Inverter Cart Mounting Bracket Kit	K4068-1					•	•			•		•							•	
Undercarriage – Hand moving	K841							•	•											
Undercarriage – Hand moving	K842												•	•	•	•				
All-Terrain Undercarriage	K1737-1												•	•	•	•				
Universal Adapter Plug ⁽²⁾	K867	•	•	•	•															
Work Lead Package	K2149-1							•	•	•	•	•	•	•	•	•	•	•	•	•
Paralleling Kit (codes above 10500) ⁽³⁾	K1611 ⁽²⁾												•	•	•					
Paralleling Kit (codes below 10500) ⁽³⁾	K1897-1												•	•	•					
Arc Tracker™	K3019-1	•	•	•	•			•	•	•		•	•	•	•	•	•	•	•	•
FLEXTEC® 350 Locking Foot Kit	K4424-1					•	•													
FLEXTEC® 500 / 500P Locking Foot Kit	K3056-2									•	•	•								
Multi-Process Switch ⁽¹⁾	K3091-1					•	•			•		•							•	
Multi-Process Switch	K804-1							•	•				•	•	•	•				
FLEXTEC® 350X CE Filter Kit (380-575V AC)	K4420-1					•	•													
FLEXTEC® 500 CE Filter Kit (380-575V AC)	K3129-2									•		•								

⁽¹⁾Requires K3056-1 Base Mounting Kit ⁽²⁾Made to order ⁽³⁾Cannot be used with VRD® models ⁽⁴⁾Requires K4068-1 Inverter Cart Mounting Kit • Optional

Accessories

Product Name	Product No.	Invertec® V350 PRO				FLEXTEC® 350X		Idealarc® DC400		FLEXTEC® 500		AlumaFab®		FLEXTEC® 500P		Idealarc® DC600		FLEXTEC® 650X		Arc Tractor®	
		Base Model Construction	Base Model Factory	Base Model Adv. Process	Base Model Tweeco Factory	Base Model Standard	Base Model Construction	Base Model w/GFCI	Base Model w/Multi-Process Switch	Base Model	Base Model	Base Model	Base Model w/Multi-Process Switch	Base Model w/Meters	Base Model w/Meters	Base Model w/VRD®	Base Model	Base Model			
		K1728-5	K1728-6	K1728-7	K1728-13	K4272-1	K4271-1	K1308-25	K1308-12	K4091-1	K4189-1	K4092-1	K1288-18	K1288-17	K1288-22	K1288-28	K3425-1	K3019-1			
GENERAL, CON'T.																					
FLEXTEC® 650 CE Filter Kit (380-575V AC)	K3129-1																				•
GFCI Kit	K3157-1																				•
Harris® Model 355 Flowmeter Regulator & Hose, 10 ft. (3.0 m)	3100211					•	•			•		•									•
Weld Fume Control System	—	•	•	•	•			•	•	•	•	•	•	•	•	•	•	•	•	•	•
STICK																					
CrossLinc® Remote	K4345-1					•	•														•
Accessory Kit, 400 Amp	K704	•	•	•	•			•	•			•	•	•	•	•	•	•	•	•	•
Remote Output Control, 25 ft. (7.6 m)	K857	•	•	•	•	•	•	•	•			•	•	•	•	•	•	•	•	•	•
Remote Output Control, 100 ft. (30.5 m)	K857-1	•	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•	•	•	•
Remote Output Control, 25 ft. (7.6 m)	K857-2					•	•			•		•									•
Remote Control Cable Adapter	K864	•	•	•	•			•	•			•	•	•	•	•	•	•	•	•	•
TIG																					
TIG Module	K930-2	•	•	•	•			•	•			•	•	•	•	•	•	•	•	•	•
Control Cable (9-pin to 14-pin)	K936-1	•	•	•	•			•	•			•	•	•	•	•	•	•	•	•	•
Control Cable (9-pin to 115V plug)	K936-4	•	•	•	•																
12-pin to 6-pin Adapter	K2909-1					•	•			•		•									•
Control Cable Extension, 45 ft. (13.7 m)	K937-45							•	•			•	•	•	•	•	•	•	•	•	•
Adapter Cable – Male 14-pin Control Cable to Terminal Strip	K1798							•	•			•	•	•	•	•	•	•	•	•	•
Remote Control Cable Adapter	K864							•	•												
Hand Amptrol™ (Rotary Track Style)	K963-3	•	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•	•	•	•
Foot Amptrol™ with 6-pin Connector	K870	•	•	•	•			•	•			•	•	•	•	•	•	•	•	•	•
Foot Amptrol™ with 12-pin Connector	K870-2									•		•									•
Wireless Foot Pedal	K4217-1					•	•			•		•									•
Amptrol™ Adapter Kit	K843							•	•			•	•	•	•	•	•	•	•	•	•
Arc Start™ Switch	K814	•	•	•	•																•
Invertec® TIG Solenoid Kit	K1762-2	•	•	•	•																
Twist Mate™ Torch Adapter, PTA-9, -17	K1622-1	•	•	•	•																
Twist Mate™ Torch Adapter, PTA-26	K1622-3	•	•	•	•																
Twist Mate™ Torch Adapter, Water-Cooled	K1622-4	•	•	•	•																
Twist Mate™ Torch Adapter (with separate gas)	K960-1	•	•	•	•																
TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled)	K2265-1	•	•	•	•																
TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled)	K2266-1	•	•	•	•																
TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled)	K2267-1	•	•	•	•																
Docking Kit	K939-1							•	•			•	•	•	•	•	•	•	•	•	•
Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.2 m)	K586-1							•	•			•	•	•	•	•	•	•	•	•	•

Accessories

Product Name	Product No.	Invertec® V350 PRO		FLEXTEC® 350X		Idealarc® DC400		FLEXTEC® 500		AlumaFab®		FLEXTEC® 500P		Idealarc® DC600		FLEXTEC® 650X		Arc Tracter®		
		Base Model Construction	Base Model Factory	Base Model Adv. Process	Base Model Tweco Factory	Base Model Standard	Base Model Construction	Base Model w/GFCI	Base Model w/Multi-Process Switch	Base Model	Base Model	Base Model	Base Model w/Multi-Process Switch	Base Model w/Meters	Base Model w/Meters	Base Model w/VRD®	Base Model	Base Model		
		K1728-5	K1728-6	K1728-7	K1728-13	K4272-1	K4271-1	K1308-25	K1308-12	K4091-1	K4189-1	K4092-1	K1288-18	K1288-17	K1288-22	K1288-28	K3425-1	K3019-1		
MIG																				
Magnum® PRO AL G225A Push/Pull Air-Cooled Push-Pull Gun, 12 pin, 25 ft. (7.6 m)	K3355-2																			
Magnum® PRO AL G450W Push/Pull Water-Cooled Push-Pull Gun, 12 pin, 25 ft. (7.6 m)	K3357-2																			
Magnum® PRO Curve™ 300 Gun and Cable Ready-Pak, 15 ft. (4.5 m)	K2951-2-10-45						•	•												•
Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak, 15 ft. (4.5 m)	K2952-2-10-45									•										•
WIRE FEEDERS																				
Flex Feed™ 74 HT, FlexFeed™ 84, LF-72, LF-74, LN-10, DH-10, LN-25 PRO, LN-25 PRO Dual Power, LN-25 Pipe, Activ8™	—	•	•	•	•	•		•	•	•		•	•	•	•	•	•	•	•	•
LN-8, LN-9	—							•	•			•	•	•	•	•	•	•	•	•
NA Series	—																		•	•
LT-7	—											•	•	•	•	•	•	•	•	•
LN-25X	—					•	•													
LN-23P	—							•	•	•		•							•	•
Power Feed® 84	—					•				•		•								
Power Feed® 25M	—											•								
Power Feed® 25M Aluminum	—										•									
2-YEAR EXTENDED WARRANTY																				
Invertec® V350-PRO	—	•	•	•	•															
FLEXTEC® 350X	—					•	•													
Idealarc® DC400	—							•	•											
FLEXTEC® 500	—									•										
AlumaFab®	—										•									
FLEXTEC® 500P	—											•								
Idealarc® DC600	—												•	•	•	•				
FLEXTEC® 650X	—																		•	



ADVANCED PROCESS WELDERS

MODEL	OUTPUT			PROCESS								INPUT		FEATURES				
	Mode	Polarity	Current Range (Amps)	Stick	TIG	AC/DC TIG	MIG	MIG STT [®]	Tandem MIG [®]	AC MIG	Pulsed	Flux-Cored	Arc Gouge	Phase	Hertz	Waveform Control Technology [®]	ArkLink [®] Digital Communication	Inverter Efficiency
STT [®] PROCESS																		
Invertec[®] STT[®] II	STT [®]	DC	0-450 PEAK 0-125 BKGRND					●						3	50/60	●		●
Power Wave[®] Advanced Module	CC/CV	AC/DC	NA			●		●		●				NA	NA			
Power Wave[®] STT[®] Module	STT [®]	DC	NA					●						NA	NA	●	●	●
MULTI-PROCESS POWER WAVE [®]																		
Power Wave[®] C300	CC/CV	DC	5-300	●	●		●				●	●		1,3	50/60	●	●	●
Power Wave[®] S350	CC/CV	DC	5-350	●	●		●				●	●	●	1,3	50/60	●	●	●
Power Wave[®] S500	CC/CV	DC	5-550	●	●		○		●		●	●	●	3	50/60	●	●	●
Power Wave[®] S700	CC/CV	DC	20-900	●	●		●		○		●	●	●	3	50/60	●	●	●

KEY: ● Excellent ● Good ● Optional

Invertec® STT® II



Excellent Penetration, Higher Productivity

- Minimal spatter; can replace TIG welding in the root pass
- Controlled low heat input results in reduced distortion on thin materials
- Tremendous shielding gas flexibility (either low-cost 100 % CO₂ or Argon/CO₂ blends)



Processes
· MIG-STT*

Output
 

Input
 

Literature
E4.52

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® STT® II	K1525-1	208/230/460/3/60	225A/29V/60% 200A/28V/100%	32/30/16A	CURRENT Peak: 0-450A Background: 0-125A Max OCV: 85V	23.2 x 13.2 x 24.4 (589 x 336 x 620)	117 (53)
	K1526-1	200-208/220-230/ 380-415/440-460/3/50/60		33/30/15/17/16A			
	K1526-2	200/208/380/400/ 415/3/50/60		36/34/20/19/18A			

Power Wave® C300


Power and Wire Combined

- Welding output remains constant throughout the entire input voltage range
- CheckPoint™ technology enables you to track usage, store weld data, configure fault limits and more
- Ideal for educational settings and light to medium fabrication shops



Processes
· Stick
· DC TIG
· Pulsed DC TIG
· MIG
· Pulsed MIG
· Flux-Cored

Output
 

Input
 

Literature
E5.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® C300 ⁽¹⁾ Base Model	K2675-2	3-Ph 50/60: 208/220-230/380/415/460/575	300A/29V/40% 250/27V/100%	3-Ph/40% Duty Cycle: 30/28/16/14/11A	5-300A DC	18.8 x 14 x 24.8 (478 x 356 x 630)	100 (47.6)
Steel Ready-Pak® Pkg.	K2774-2	1-Ph 50/60: 208/220-230		1-Ph/40% Duty Cycle: 53/48/29A	WFS: 50-700 ipm (1.27-17.8 m/min)	33 x 20 x 42 (838 x 508 x 1067)	180 (81.6)
Educational Ready-Pak® Pkg.	K2774-4						

⁽¹⁾Wire Size Range, in.(mm) : Solid - 0.023-0.045 [0.6-1.2] ; Cored - 0.035-0.045 [0.9-1.2]

Power Wave® S350

Portable, Versatile, Powerful

- Equipped with a complete portfolio of high-performance wave forms, providing flexibility to tackle any welding application
- Comes standard with Power Wave Manager software tools, simplifying welding setup and operation
- CheckPoint™ production monitoring software allows you to track equipment usage, store weld data, configure fault limits and more
- Compact and durable case is IP23-rated to withstand harsh environments



Processes

- Stick
- DC TIG
- Pulsed DC TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E5.110

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® S350 Base Model	K2823-3	208/230/380-415/460/575/1/3/50/60	GMAW: 350A/31.5V/40% ⁽¹⁾ 300A/29V/100%	3-Ph/40% Duty Cycle: 39/35/19/17/14A	5-350A ⁽³⁾	20.40 x 14 x 24.80 (518 x 356 x 630)	85 (38.6)
Ready-Pak® Pkg. (Steel)	K3005-3		SMAW: 325A/33V/40% ⁽¹⁾ 250A/30V/100%	3-Ph/100% Duty Cycle: 31/28/15/14/11A		52 x 39 x 26 (1321 x 991 x 660)	450 (204.1)
			GTAW-DC: 350A/24V/40% 300A/22V/100%	1-Ph/40% Duty Cycle: 60/67 ⁽²⁾ /na/na/na			
				1-Ph/100% Duty Cycle: 60/53/na/na/na			

⁽¹⁾230 Volt/1 Phase inputs, the peak rating is at 30% duty cycle, except for GTAW. ⁽²⁾Based on the U.S. National Electrical Code. ⁽³⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

Power Wave® S350 Aluminum

Advanced Performance Tailored for Aluminum

- System designed and configured for aluminum applications
- Access advanced processes such as Pulse-on-Pulse® and Power Mode® to customize the aluminum welding experience for your application



Processes

- Aluminum Only
- MIG
- Pulsed MIG
- CC Pulse
- Pulse-on-Pulse

Output



Input



Literature

E5.93b

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® S350 Aluminum Base Model	K4188-1	208/230/380-415/460/575/1/3/50/60	GMAW: 350A/31.5V/40% ⁽¹⁾ 300A/29V/100%	3-Ph/40% Duty Cycle: 39/35/19/17/14A	5-350A ⁽³⁾	20.40 x 14 x 24.80 (518 x 356 x 630)	85 (38.6)
Air-Cooled One-Pak® Packages	K4184-1 K4184-3 K4184-4		SMAW: 325A/33V/40% ⁽¹⁾ 250A/30V/100%	3-Ph/100% Duty Cycle: 31/28/15/14/11A		52 x 39 x 26 (1321 x 991 x 660)	
Air-Cooled One-Pak® Package with Advanced Module Aluminum	K4184-5		GTAW-DC: 350A/24V/40% 300A/22V/100%	1-Ph/40% Duty Cycle: 60/67 ⁽²⁾ /na/na/na			
Air-Cooled Ready-Pak® Package	K4184-2			1-Ph/100% Duty Cycle: 60/53/na/na/na			450 (204.1)
Water-Cooled One-Pak® Packages	K4185-1 K4185-2 K4185-3 K4185-4						

⁽¹⁾230 Volt/1 Phase inputs, the peak rating is at 30% duty cycle, except for GTAW. ⁽²⁾Based on the U.S. National Electrical Code. ⁽³⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

Power Wave® S500

Multi-Process Power and Versatility

- Equipped with a complete portfolio of high-performance wave forms, providing flexibility to tackle any welding application
- Comes standard with Power Wave Manager™ software tools, simplifying welding setup and operation
- CheckPoint™ production monitoring software allows you to track equipment usage, store weld data, configure fault limits and more
- Compact and durable case is IP23-rated to withstand harsh environments



Processes

- Stick
- DC TIG
- Pulsed DC TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E5.115

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® S500 Base Model	K2904-1	208/230/380-415/460/575/3/50/60	GMAW: 550A/41.5V/40% 450A/36.5V/100%	3-Ph/40% Duty Cycle: 81/73/41/37/29A	5-550A	22.5 x 14 x 24.8 (571 x 355 x 630)	150 (68)
w/Power Feed® 84 Ready-Pak® Pkg.	K3187-2		SMAW: 550A/42V/40% 450A/38V/100%	3-Ph/100% Duty Cycle: 60/54/31/27/21A		51.7 x 34.4 x 53.4 (1313 x 874 x 1356)	376 (171)
w/Power Feed® 84 One-Pak® Pkg.	K3186-2		GTAW-DC: 550A/32V/40% 450A/38V/100%			—	—

Power Wave® S700

High Output Power for Automated Environments

- Intended for high amperage, high duty cycle semiautomatic, mechanized or robotic applications in the heavy equipment, transportation and other industries
- Add AutoDrive® 19 Tandem modules to access waveform modes specifically designed for Synchronized Tandem MIG



Processes

- Stick
- TIG
- MIG
- Pulsed MIG
- Flux-Cored
- Tandem MIG*
- Carbon Arc Gouging

Output



Input



Literature

E5.120

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® S700	K3279-1 ⁽¹⁾	380-415/440-460/500/575/3/50/60	700/44/100% (900A/44/60%)	55/46/42/38A (74/60/56/49A)	20-900A	30.1 x 19.1 x 36.7 (765 x 485 x 932)	385 (175)

⁽¹⁾Internal filter is required to meet CE conducted emission requirements. K2444-4 CE Filter must be used with K3279-1.

Power Wave® STT® Module

Add STT® for Exceptional Arc Control

- Add STT® (Surface Tension Transfer®) process capability to any S-Series Power Wave for enhanced puddle and burnthrough control
- Improve performance on thin metal or critical pipe root pass welding applications
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models



Processes
 · GMAW-STT®

Output


Input


Literature
 E5.190

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® STT® Module	K2902-1 US/Int'l Model	40V DC	100% Duty Cycle ⁽¹⁾ : 450A	n/a	n/a	11.5 x 14 x 24.8 (292 x 356 x 630)	47 (21.3)
	K2921-1 CE Model		60% Duty Cycle ⁽¹⁾ : 500A 40% Duty Cycle ⁽¹⁾ : 550A Peak (Max) ⁽¹⁾ : 750A				

⁽¹⁾Dependent on host welding power source output.

Power Wave® Advanced Module

Expand Your Welding Capabilities

- Adds AC waveform control for Pulsed MIG, and Gas Tungsten Arc (TIG) Welding
- Hi-frequency starting for TIG welding capability
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models
- Includes STT process capability, making this module ideal for automotive, pipe and thin metal applications



Processes
 · GMAW-STT®
 · AC-GMAW-P
 · GTAW: AC, DC-, AC/DC

Output


Input


Literature
 E5.191

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® Advanced Module	K2912-1	40V DC	100% Duty Cycle ⁽¹⁾ : 300A @ 32V 40% Duty Cycle ⁽¹⁾ : 350A @ 34V Peak (Max) ⁽¹⁾ : 600A	n/a	n/a	11.5 x 14 x 25 (292 x 356 x 635)	70.5 (32)

⁽¹⁾Host welding power source will be limited to these outputs.

Power Wave® Advanced Module Aluminum

Expand Your Welding Capabilities

- Adds AC Pulsed MIG and AC TIG with hi-frequency starting for Aluminum
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models



Processes

- GMAW-P (AC)
- GTAW AC

Output



Input



Literature

E5.191

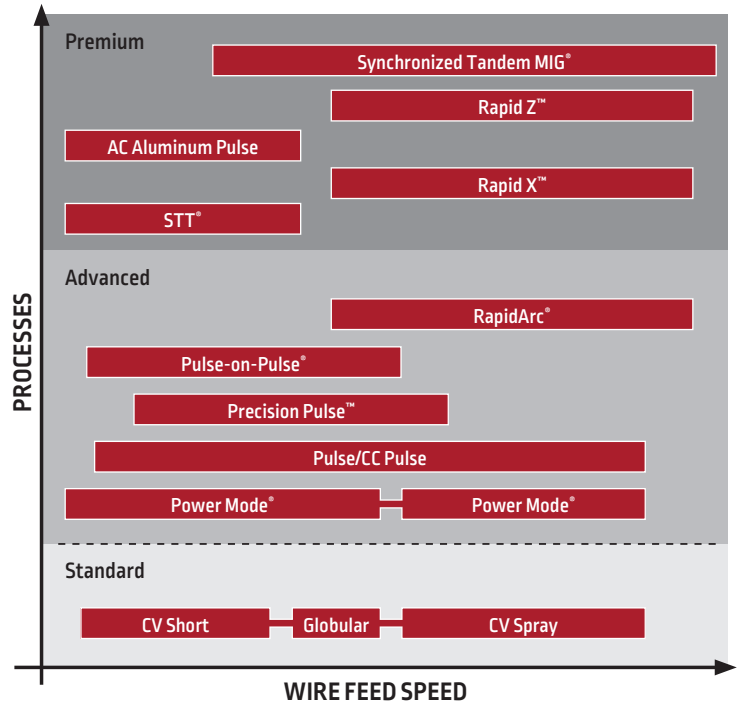
Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® Advanced Module Aluminum	K4192-1	40V DC	100% Duty Cycle ⁽¹⁾ : 300A @ 32V 40% Duty Cycle ⁽¹⁾ : 350A @ 34V Peak (Max) ⁽¹⁾ : 600A	n/a	n/a	11.5 x 14 x 25 (292 x 356 x 635)	70.5 (32)

⁽¹⁾Host welding power source will be limited to these outputs.

LINCOLN ELECTRIC

Advanced MIG (GMAW) Processes

Your local Lincoln Electric distributor and Lincoln Electric Technical Sales Representative, backed by our Applications Engineering Department, can help you select the advanced process and equipment that can improve your results. Request a demo to see how we can help reduce costs, enhance quality or increase productivity in your operations.



Synchronized Tandem MIG [®]	Steel » Synchronized Tandem MIG [®] overcomes deposition rate limitations of a single wire by using two wires and specific waveforms. The result is deposition rates nearly double rates possible with a single wire as well as faster travel speeds.	Power Wave [®] S700 Power Wave [®] S500 Power Wave [®] R500
Rapid Z™	Zinc » Rapid Z™ is a process designed to increase stability and travel speeds, while reducing spatter and internal porosity on Zinc coated materials.	Power Wave [®] S500 w/Advanced Module Power Wave [®] S350 w/Advanced Module Power Wave [®] R500 w/Advanced Module Power Wave [®] R350 w/Advanced Module
AC Aluminum Pulse	Aluminum » With the help of the Power Wave [®] Advanced Module, GMAW aluminum welding results can be improved over traditional DC positive aluminum MIG welding. By switching the polarity of the arc, heat input is reduced and deposition rates are enhanced.	Power Wave [®] S500 w/Advanced Module Power Wave [®] S350 w/Advanced Module Power Wave [®] S350 Aluminum with Advanced Module Aluminum
Rapid X™	Steel & Stainless » Rapid X™ is a premium MIG pulse mode designed to deliver higher travels speeds and extremely low spatter levels.	Power Wave [®] S500 w/STT [®] Module Power Wave [®] S350 w/STT [®] Module Power Wave [®] R500 w/STT [®] Module Power Wave [®] R350 w/STT [®] Module
STT [®]	Steel, Stainless & High Nickel » This precision MIG mode delivers premium and consistent root pass results on pipe with low reject rates and excellent gap bridging capabilities. STT [®] can also be used to reduce spatter and control heat input on sheet metal applications.	Power Wave [®] S350 w/Digital STT [®] Power Wave [®] R350 w/Digital STT [®] Invertec [®] STT [®] II Power Wave [®] S500 w/STT [®] Module Power Wave [®] R500 w/STT [®] Module
RapidArc [®]	Steel & Stainless » RapidArc [®] is an accelerated MIG pulse mode with a short arc length compared to pulse and CV-spray for high travel speed applications.	Power Wave [®] C300 Power Wave [®] S700
Pulse-on-Pulse [®]	Aluminum » This arc modulation MIG pulse mode can deliver a TIG (GTAW)-like bead appearance.	Power Wave [®] S500 Power Wave [®] S350
Precision Pulse™	Steel & Stainless » This enhanced MIG pulse mode features a tight, focused arc for fast vertical up welding and outstanding out-of-position puddle control.	Power Wave [®] S350 Aluminum Power Wave [®] R500
Pulse	Steel, Stainless, Aluminum & more » Traditional MIG pulse mode uses a pulse for the metal transfer, which avoids a short and allows for a wide operating range, characterized by low to high wire feed speed, many different materials and virtually no spatter.	Power Wave [®] R350 Power Wave [®] i400
Power Mode [®]	Steel, Stainless & Aluminum » This enhanced MIG mode can deliver excellent arc stability with reduced spatter at high travels speeds, resulting from an extended short arc range at higher wire feed speed procedures. It also yields a tight and stable arc in spray transfer.	
CV	Steel, Stainless & Aluminum » CV is the conventional mode for MIG welding. This general purpose MIG welding mode uses constant voltage for short arc, globular and spray transfer.	

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® STT® II

Base Models [K1525-1, K1526-1, K1526-2]

- STT® II Sense Lead Kit, 25 ft. (7.6 m)

Power Wave® C300

Base Model [K2675-2]

- Drive Roll Kit, 0.035/0.045 in. (0.9/1.2 mm)
- Input Cord, 10 ft. (3.0 m)
- Work Lead & Clamp, 10 ft. (3.0 m)

Steel Ready-Pak® Package [K2774-2]

- Everything listed above for Base Model
- Power Wave® C300 Undercarriage
- Magnum® PRO Curve™ 300 Gun Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)

Educational Ready-Pak® Package [K2774-4]

- Everything listed above [K2774-2]
- TIG Torch Twist Mate™ to Stud Adapter Cable with 2 ft. (0.61 m) Gas Hose
- PTA-17 Pro-Torch™ TIG Torch
- Twist Mate™ Torch Adapter
- Parts Kits for PTA-17 Series Torches
- Foot Amptrol™
- Stick Electrode Holder and Cable

Power Wave® S350

Base Model [K2823-3]

- Input Power Cord, 10 ft. (3.0 m)

Steel Ready-Pak® Package [K3005-3]

- Power Wave® S350 [K2823-3]
- Power Feed® 84 Bench Model [K3328-13]
- 0.035 in. (0.9 mm) and 0.040-0.045 in. (1.0-1.1 mm) Drive Roll & Wire Guide Kits
- Magnum® PRO Curve™ 400 Gun Pkg., 15 ft. (4.5 m)
- Work & Wire Feeder Power Cables Pkg.
- Inverter and Wire Feeder Cart
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)

Power Wave® S350 Aluminum⁽¹⁾

Air-Cooled One-Pak® Package [K4184-1]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/15 ft. (4.5 m) Cable

Air-Cooled One-Pak® Package [K4184-3]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/35 ft. (10.6 m) Cable

Air-Cooled One-Pak® Package [K4184-4]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/50 ft. (15.2 m) Cable

Air-Cooled One-Pak® Package [K4184-5]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Power Wave Advanced Module Aluminum [K4192-1]
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft. (7.6 m) Cable

Air-Cooled Ready-Pak® Package [K4184-2]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft. (7.6 m) Cable



Shown:
Power Wave® C300
Educational Ready-Pak® Pkg.



Shown:
Power Wave® S350 Aluminum
Ready-Pak® Pkg.

⁽¹⁾Power Wave S350 Aluminum Air-Cooled Ready-Pak and One-Paks include the following accessories: Drive Roll Kits; Diffusers; Nozzles; Tips; Liners; Work Lead Package. (K4184-5 Advanced Module One-Pak also includes: Foot Pedal, TIG Torch and TIG Kit).

Power Wave S350 Aluminum Water-Cooled One-Paks include the following accessories: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Power Wave® S350 Aluminum⁽¹⁾, con't.

Water-Cooled One-Pak® Package (K4185-1)

- Power Wave® S350 Aluminum (K4188-1)
- Power Feed® 25M (K4191-1)
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/15 ft. (4.5 m) Cable

Water-Cooled One-Pak® Package (K4185-2)

- Power Wave® S350 Aluminum (K4188-1)
- Power Feed® 25M (K4191-1)
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/25 ft. (7.6 m) Cable

Water-Cooled One-Pak® Package (K4185-3)

- Power Wave® S350 Aluminum (K4188-1)
- Power Feed® 25M (K4191-1)
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/35 ft. (10.6 m) Cable

Water-Cooled One-Pak® Package (K4185-4)

- Power Wave® S350 Aluminum (K4188-1)
- Power Feed® 25M (K4191-1)
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Work & Wire Feeder Power Cables Pkg.
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/50 ft. (15.2 m) Cable

Power Wave® S500

Power Feed® 84 One-Pak® Package (K3186-2)

- Power Wave® S500 (K2904-1)
- Power Feed® 84 Bench Model (K3328-13)
- 0.040-0.045 (1.0-1.1 mm) Drive Roll & Wire Guide Kit
- Work Lead Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO Curve 400 Gun Pkg., 15 ft. (4.5 m)

Power Feed® 84 Ready-Pak® Package (K3187-2)

- Everything listed above (K3186-2)
- Inverter & Wire Feeder Cart

Power Wave® STT® Module

Base Model (US/International) (K2902-1)

- Power Source Output Pigtail Adapter Cable (Tweco®-style)
- Remote Voltage Sense Lead, 25 ft. (3.7 m)

Power Wave® Advanced Module

Base Model (K2912-1)

- Power Source Output Pigtail Adapter Cable (Tweco®-style)
- 25 ft. (7.6 m) Remote Voltage Sense Lead
- ArcLink® Output Receptacle
- Differential Input and Output (Sync Tandem Output)
- Shielding Gas Input

Power Wave® Advanced Module Aluminum

Base Model (K4192-1)

- Power Source Output Pigtail Adapter Cable (Tweco®-style)
- 25 ft. (7.6 m) Remote Voltage Sense Lead
- ArcLink® Output Receptacle
- Differential Input and Output (Sync Tandem Output)
- Shielding Gas Input

⁽¹⁾Power Wave S350 Aluminum Air-Cooled Ready-Pak and One-Paks include the following accessories:

Drive Roll Kits, Diffusers, Nozzles, Tips, Liners, Work Lead Package. (K4184-5 Advanced Module One-Pak also includes: Foot Pedal, TIG Torch and TIG Kit).

Power Wave S350 Aluminum Water-Cooled One-Paks include the following accessories: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package.

Accessories

Product Name	Product No.	Invertec STT® II	Power Wave® C300	Power Wave® S350	Power Wave® S350 Aluminum	Power Wave® S500	Power Wave® S700
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2629-1	K2675-2	K2823-3	K4188-1	K2904-1	K3297-1
GENERAL							
Canvas Cover	K2378-1		•				
Understorage Cart	K2734-2		•				
Inverter and Wire Feeder Cart	K1764-1	•		•			
Inverter and Wire Feeder Cart	K3059-2			•	•	•	
Dual Cylinder Inverter and Wire Feeder Cart	K3059-3			•		•	
12-pin to 6-pin Adapter Cable	K2909-1		•	•		•	•
12-pin to 7-pin Adapter Cable	K2910-1		•				
Cool Arc® 40 Water Cooler 115/1/50/60	K1813-1	•	•	•	•	•	•
Cool Arc® 55	K3086-1			•		•	•
Cool Arc® 55 S	K3086-2			•		•	•
Cool Arc® 55 Aluminum	K4190-1				•		
S-Series User Interface Kit	K3001-2			•		•	
Power Wave® STT® Module	K2902-2			•		•	
115V Auxiliary Power Kit	K2829-1			•			
DeviceNet™ Kit	K2827-1			•		•	
CE Filter	K2444-4						•
Tweco®-Style Adapter Plug	K2946-1			•			
Sense Lead Kit, 25 ft. (7.6 m)	K940-25	•	•	•	•	•	•
Sense Lead Kit, 75 ft. (22.9 m)	K940-75	•	•	•	•	•	•
Heavy Duty Process Sense Lead, 50 ft. (15.2 m)	K1811-50	•		•	•	•	•
Heavy Duty Process Sense Lead, 100 ft. (30.5 m)	K1811-100	•		•	•	•	•
Work Lead Package	K2149-1					•	•
Coaxial Weld Power Cable (350A), 25 ft. (7.6 m)	K1796-25	•				•	•
Coaxial Weld Power Cable (350A), 50 ft. (15.2 m)	K1796-50	•				•	•
Coaxial Weld Power Cable (300A), 75 ft. (22.9 m)	K1796-75	•				•	•
Coaxial Weld Power Cable (300A), 100 ft. (30.5 m)	K1796-100	•				•	•
Coaxial Weld Power Cable (#1, Lug to Lug), 100 ft. (30.5 m)	K2593-100	•				•	•
Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable	K852-70	•					
Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable	K852-95	•					
Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable	K1759-70	•					
Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable	K1759-95	•					
Twist Mate™ to Lug Cable Adapter	K2176-1	•					

Accessories

Product Name	Product No.	Invertec STT® II	Power Wave® C300	Power Wave® S350	Power Wave® S350 Aluminum	Power Wave® S500	Power Wave® S700
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2629-1	K2675-2	K2823-3	K4188-1	K2904-1	K3297-1
TIG							
TIG Torches, see E.12.150 or Guns and Torches section pg. 147-163	–		•	•	•	•	•
Foot Amptrol™ 12-pin	K870-2		•	•	•	•	
Hand Amptrol™ 12-pin	K963-4		•	•	•	•	
TIG Torch Twist Mate™ to Stud Adapter Cable, 2 ft. (0.61 m) Gas Hose	K2505-3		•				
Tweco® Air-Cooled Adapter	K1622-6			•			
Tweco®-Style Cam Lock Adapter, 26 Series Torches	K960-3			•			
Tweco®-Style Cam Lock Adapter, 17 Series Torches	K960-4			•			
WIRE FEEDER							
Fast-Mate™ Adapter	K489-8		•				
Drive Roll Kit 0.035 in. (0.9 mm) Aluminum	KP1695-035A		•				
Drive Roll Kit 3/64 in. (1.2 mm) Aluminum	KP1695-3/64A		•				
Power Feed® 25M, Power Feed® 84	–			•		•	•
Power Feed® 25M Aluminum, Power Wave® Advanced Module Aluminum	–				•		
LN-25 PRO Dual Power	–	•					
Work and Wire Feeder Weld Cable Package with Tweco®-Style Plugs	K1803-2			•	•		
AutoDrive® 19 Controller	K3004-2			•		•	•
AutoDrive® 19 Tandem Controller	K3171-1					•	•
AutoDrive® S	K4303-1			•	•	•	•
AutoDrive® SA	K4129-1			•	•	•	•
Power Wave® STT® Module (US/International)	K2902-1			•		•	
Power Wave® STT® Module (CE)	K2921-1			•		•	
Power Wave® Advanced Module	K2912-1			•		•	
Power Wave® Advanced Module Aluminum	K4192-1			•	•		
Water Cooler Hoses (CGA to CGA)	K1859-2		•	•	•	•	•
Water Connection Kit	K590-6						•

Accessories

Product Name	Product No.	Invertec STT® II	Power Wave® C300	Power Wave® S350	Power Wave® S350 Aluminum	Power Wave® S500	Power Wave® S700
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2629-1	K2675-2	K2823-3	K4188-1	K2904-2	K3297-1
MIG							
Magnum® PRO AL G225A Air-Cooled Push-Pull Guns							
12-pin, 15 ft. (4.5 m)	K3355-1		•	•		•	•
12-pin, 25 ft. (7.6 m)	K3355-2		•	•	•	•	•
12-pin, 35 ft. (10.6 m)	K3355-3		•	•		•	•
12-pin, 50 ft. (15.2 m)	K3355-4		•	•		•	•
7-pin, 15 ft. (4.5 m)	K3356-1		•				
7-pin, 25 ft. (7.6 m)	K3356-2		•				
7-pin, 35 ft. (10.6 m)	K3356-3		•				
7-pin, 50 ft. (15.2 m)	K3356-4		•				
Magnum® PRO AL G450W Water-Cooled Push-Pull Guns							
12-pin, 15 ft. (4.5 m)	K3357-1			•		•	•
12-pin, 25 ft. (7.6 m)	K3357-2			•	•	•	•
12-pin, 35 ft. (10.6 m)	K3357-3			•		•	•
12-pin, 50 ft. (15.2 m)	K3357-4			•		•	•
7-pin, 15 ft. (4.5 m)	K3358-1		•				
7-pin, 25 ft. (7.6 m)	K3358-2		•				
7-pin, 35 ft. (10.6 m)	K3358-3		•				
7-pin, 50 ft. (15.2 m)	K3358-4		•				
Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 25 ft. (7.6 m)	K2704-2		•				
Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 50 ft. (15.2 m)	K2704-3		•				
SPOOL GUN							
Magnum® 250LX™ Spool Gun	K2490-1		•				
Magnum® 250LX™ Spool Gun Control Cable Extension, 25 ft. (7.6 m)	K2519-1		•				
2-YEAR EXTENDED WARRANTY							
Invertec® STT® II	—	•					
Power Wave® C300	—		•				
Power Wave® S350	—			•			
Power Wave® S350 Aluminum	—				•		
Power Wave® 455M	—						
Power Wave® 455M/STT®	—						
Power Wave® S500	—					•	
Power Wave® S700	—						•



MULTI-OPERATOR WELDING SYSTEMS

MODEL				PROCESS						INPUT		FEATURES			
	Mode	Polarity	Current Range (Amps)	Stick	TIG	MIG	Pulsed	Flux-Cored	Arc Gouge	Phase	Hertz	DC+ Welding Only	Touch-Start TIG*	One Disconnect Switch	IP23 Rated
RACK SYSTEMS															
Invertec® V275-S	CC	DC	5-275	●	●				●	3	50,60		•	•	
Invertec® V350 PRO	CC/CV	DC	5-425		●	●		●	●	3	50/60		•	•	
FLEXTEC™ 350X	CC/CV	DC	5-425	●	●	●		●	●	3	50/60		•	•	•
FLEXTEC™ 500	CC/CV	DC	5-500	●	●	●		●	●	3	50/60	•	•	•	•
FLEXTEC™ 650X	CC/CV	DC	40-815	●	●	●		●	●	3	50/60		•	•	•
MULTI-ARC SYSTEM															
Multi-Weld™ 350	CC/CV	DC+ only	30-350	●	●	●		●	●	NA	NA	•			

KEY: ● Excellent ● Good ● Optional

Invertec® V275-S Inverter Racks

Compact, Efficient and Weather-Resistant

- Basic DC stick, DC TIG and gouging capability
- Available 4 and 8 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- Gouging

Output



Input



Literature

E5.92

Product Name	Output Connection	Product Number	Input Power ⁽¹⁾ Voltage/Phase/Hertz	Rated Output: Current/ Voltage/Duty Cycle ⁽²⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V275-S 4-Pack Rack	Tweco®	K2666-1	208/230/460/575/3/60	275A/31V/35%	96/89/46/39A	5-275A	55.69 x 38.5 x 33.5 (1414 x 978 x 851)	520 (236)
			220/380/400/415/440/3/50	250A/30V/35%	89/53/53/50/46A			
8-Pack Rack	Tweco®	K2666-2	208/230/460/575/3/60	275A/31V/35%	161/149/77/65A		55.69 x 58.5 x 33.5 (1414 x 1486 x 851)	986 (447)
			220/380/400/415/440/3/50	250A/30V/35%	149/89/89/83/77A			

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

Invertec® V350 PRO Inverter Racks

Multi-Purpose, Multi-Process

- Handles DC stick, DC TIG, MIG, flux-cored and gouging
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.92

Product Name	Output Connection	Product Number	Input Power ⁽¹⁾ Voltage/Phase/Hertz	Rated Output: Current/ Voltage/Duty Cycle ⁽²⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Invertec® V350 PRO 4-Pack Rack	Tweco®	K2667-1	208/230/380-415/460/ 575/3/50/60	350A/34V/60%	138/128/78/67/57A	5-425A	60 x 44.5 x 33.5 (1524 x 1130 x 851)	796 (361)
					185/171/104/90/76A			
6-Pack Rack	Tweco®	K2667-2					60 x 59 x 33.5 (1524 x 1499 x 851)	1039 (471)

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

FLEXTEC® 350X Inverter Racks

Simple, Reliable. Flexible.

- Ready for DC stick, DC TIG, MIG and flux-cored welding
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Output



Input



Literature

E5.92

Product Name	Output Connection	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle ⁽¹⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 350X 4-Pack Compact Expandable Rack Standard Model	Tweco®	K3403-1	380/460/575/3/50/60	350A/34V/60% 300A/32V/100%	74/68/68 (4-Pack) 125/113/113 (8-Pack)	5-425A	59.72 x 37.5 x 32.88 (1516 x 952 x 835)	620 (281)
6-Pack Rack Standard Model	Tweco®	K4281-1					100/90/90A	71.22 x 48 x 35.5 (1809 x 1219 x 902)
4-Pack Compact Expandable Rack Construction Model	Tweco®	K3402-1			74/68/68 (4-Pack) 125/113/113 (8-Pack)	59.72 x 37.5 x 32.88 (1516 x 952 x 835)	620 (281)	
6-Pack Rack Construction Model	Tweco®	K4277-1			74/68/68	70.25 x 49.5 x 33 (1784 x 1257 x 838)	675 (306)	

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.

FLEXTEC® 500 Inverter Racks

Faster Setup, More Arc Time

- Ready for DC stick, DC TIG, MIG and flux-cored welding and arc gouging
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.92

Product Name	Output Connection	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle ⁽¹⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 500 4-Pack Rack	Lug	K4098-1	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	71.22 x 36 x 35.5 (1809 x 914 x 902)	800 (363)
6-Pack Rack	Lug	K4099-1			39/31/31 33/27/27		71.22 x 48 x 35.5 (1809 x 1219 x 902)	1100 (499)

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.



FLEXTEC® 650X Inverter Racks

Simple Operation, Advanced Gouging Power

- Handles DC stick, DC TIG, MIG, Flux-Cored and Gouging
- Available 4 pack configuration
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.92

Product Name	Output Connection	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle ⁽¹⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
FLEXTEC® 650X 4-Pack Rack	Stud	K3510-1	380/460/575/3/50/60	650A/44V/100% 750A/44V/60%	202/167/105A	10-815A	71.22 x 37 x 35.32 (1809 x 940 x 897)	—

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.

Multi-Weld™ 350

More Arcs, Less Hassle

- Promotes safety by reducing the number of high-voltage input power connections
- High-efficiency design uses less than half the power of other grid systems
- Capable of continuous operation at 350 amps



Processes (DC+ only)

- Stick
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.302

Product Name	Product Number	Input Power ⁽¹⁾ Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle ⁽²⁾	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Multi-Weld™ 350	K1735-1	80V DC	350A/34V/100% (DC+ only output)	165A	15-40V 30-350A Max. OCV: 78V	11.6 x 10 x 21.5 (295 x 254 x 546)	67 (30)

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

Accessories

Product Name	Product No.	Multi-Weld™ 350		Invertec® V275-S		Invertec® V350 PRO		FLEXTEC® 350X				FLEXTEC® 500		FLEXTEC® 650
		Base Model	4-Pack Rack	8-Pack Rack	4-Pack Rack	6-Pack Rack	4-Pack Rack Standard	6-Pack Rack Standard	4-Pack Rack Construction	6-Pack Rack Construction	4-Pack Rack	6-Pack Rack	4-Pack Rack	
		K1735-1	K2666-1	K2666-2	K2667-1	K2667-2	K3403-1	K4281-1	K3402-1	K4277-1	K4098-1	K4099-1	K3144-1	
GENERAL														
Distribution Box	K1736-1	•												
Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable	K852-70	•	•	•	•	•	•	•	•	•	•	•	•	•
Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable	K852-95	•	•	•	•	•	•	•	•	•	•	•	•	•
Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable	K1759-70	•	•	•	•	•	•	•	•	•	•	•	•	•
Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable	K1759-95	•	•	•	•	•	•	•	•	•	•	•	•	•
Tweco® Style Cam-Lock Adapter Plug	K2946-1	•	•	•	•	•	•	•	•	•	•	•	•	•
LC-40, Tweco® Style Plug (male, 1/0 Thru 2/0)	K3416-70						•	•	•	•				
LC-40, Tweco® Style Receptacle (female, 1/0 Thru 2/0)	K3417-70						•	•	•	•				
LC-40HD, Tweco® Style Plug (male, 3/0 Thru 4/0)	K3416-90						•	•	•	•				
LC-40HD, Tweco® Style Receptacle (female, 3/0 Thru 4/0)	K3417-90						•	•	•	•				
Remote Output Control, 25 ft. (7.6 m)	K857	•												•
Remote Output Control, 100 ft. (30 m)	K857-1	•												•
Flextec 350X Empty 4-Pack Rack	K3400-1						•		•					
Flextec 350X 4-Pack to 8-Pack Rack Conversion Kit	K3410-1						•		•					
Flextec 350X Locking Foot Kit	K4424-1						•	•	•	•				
Caster Kit	K2665-1	•	•	•	•	•	•	•	•	•	•	•	•	•
Weld Fume Control System	—	•	•	•	•	•	•	•	•	•	•	•	•	•
POWER SOURCE														
Idealarc® DC1000	K1386-3	•												
Idealarc® DC1500	K1275	•												
SAE-500®	K1278-11	•												
Vantage® 500	K2405-2	•												
WIRE FEEDER														
LN-25 PRO Wire Feeders	—						•	•	•	•				
LN-25X Wire Feeders	—	•	•	•	•	•	•	•	•	•	•	•	•	•
2-YEAR EXTENDED WARRANTY														
Multi-Weld™ 350	—	•												



ENGINE DRIVES: COMMERCIAL

MODEL	OUTPUT				PROCESS							FEATURES										
	Mode	Polarity	Current Range (Amps)	AC Generator Power ⁽¹⁾ (watts)	Stick	Pipe	DC TIG Scratch Start	Touch Start TIG [®]	AC TIG	MIG	Flux-Cored	Arc Gouge in (mm)	Reactor Technology	Chopper Technology [®]	Tube Frame	Enclosed Case	Electric Fuel Gauge	Remote Capable	Downhill Pipe Mode	Arc Force Control	Hot Start	Digital Meters
GASOLINE																						
Bulldog[®] 5500	CC	AC	70-140 AC	5,500 S 4,000 C	●								•		•							
Outback[®] 145	CC	DC	50-145 DC	4,750 P 4,250 C	●								•		•							
Outback[®] 185	CC	DC	50-185 DC	5,700 P 5,200 C	●								•		•							
Ranger[®] 225	CC/ CV	DC	50-225 DC	10,500 P 9,000 C	●		●		●	●	5/32 (4.0)	•			•							
Ranger[®] 250 GXT	CC/ CV	AC/ DC	50-250 DC 50-250 AC	11,000 P 10,000 C	●		●	●	●	●	3/16 (4.8)	•			•	•	•					
Ranger[®] 305G and Ranger[®] 305 EFI	CC/ CV	DC	20-305 DC 40-300 DC Pipe 20-250 DC TIG	10,500 P 9,500 C	●	●	●		●	●	3/16 (4.8)	•			•	•	•	•	•	•	•	•
LIQUID PROPANE GAS																						
Ranger[®] 305 LPG	CC/ CV	DC	20-300 DC 40-300 DC Pipe 20-250 DC TIG	10,000 P 9,000 C	●	●	●		●	●	3/16 (4.8)	•			•		•	•	•	•	•	•
DIESEL																						
Ranger[®] 305 D	CC/ CV	DC	20-305 DC 40-300 DC Pipe 20-250 DC TIG	10,000 P 9,500 C	●	●	●		●	●	3/16 (4.8)	•			•	•	•	•	•	•	•	•

KEY: ● Excellent ● Good ● Optional

⁽¹⁾ C=Continuous P=Peak S=Surge

Bulldog® 5500

The Stick Welder's Best Friend –
Engine-Driven Welder

- AC welding with up to 1/8 in. (3.2 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 5,500 watts of surge AC generator power



Processes

- Stick

Output



Input



Literature

E6.32

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Bulldog® 5500	K2708-2	125A AC/20V/30% 100A AC/25V/60%	70-140A AC 5,500 W surge 4,000 W continuous	Kohler® CH395	1	9.5 @ 3600	25.6 x 21.8 x 31.5 (651 x 553 x 800)	198 (90)

Outback® 145

Built for The Great Outdoors

- DC welding with up to 1/8 in. (3.2 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 4,750 watts of peak AC generator power



Processes

- Stick

Output



Input



Literature

E6.65

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Outback® 145	K2707-2	80A DC/25V/100% 100A DC/25V/60% 125A DC/25V/30%	50-145A DC 4,750 W peak 4,250 W continuous	Kohler® CH395	1	9.5 @ 3600	25.6 x 21.8 x 31.5 (651 x 553 x 800)	234 (106)

Outback® 185

Unleash the Power

- All engine controls on the front panel
- DC welding with up to 5/32 in. (4.0 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 5,700 watts of peak AC generator power



Processes

- Stick

Output



Input



Literature

E6.70

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Outback® 185	K2706-2	100A DC/25V/100% 130A DC/25V/60% 150A DC25V/20%	50-185A DC 5,700 W peak 5,200 W continuous	Kohler® CH440	1	14 @ 3600	25.6 x 21.8 x 31.5 (651 x 553 x 800)	295 (134)

Ranger® 225

Arm Yourself with The Right Welder For The Job

- Totally enclosed case protects the engine and limits noise
- Up to 225 amps of smooth DC welding output
- 10,500 watts of peak AC generator power
- 12 gallon (45 L) tank for extended run times



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.89

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 225	K2857-1	225A DC CC/25V/40% 210A DC CC/25V/100% 200A DC CV/20V/100%	50-225A DC 15-25V CV 10,500 W peak 9,000 W continuous	Kohler® OHV Command® CH23S	2	23 @ 3600	29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920)	514 (233)

Ranger® 250 GXT

Extra Power, Extra Performance

- AC/DC multi-process welding output
- 12 gallon fuel tank for long run times
- Plenty of AC generator power
- Choice of painted or stainless steel



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.96

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 250 GXT	K2382-4	250A AC/DC CC/25V/100% 250A DC CV/25V/100%	50-250A AC/DC 14-28V CV 11,000 W peak 10,000 W continuous	Kohler® OHV Command CH730 (Electric Fuel Pump)	2	23 @ 3600	29.9 x 21.5 x 42.3 (759 x 546 x 1073) To top of exhaust tube: 36.2 (920)	602 (273)
w/ Stainless Steel Roof, Case Sides and Engine Doors	K2382-5							
w/ Fall Camo™ Wrapped Roof, Case Sides and Engine Doors	K2382-10							

Ranger® 305 G

An Engine-Driven Welder for All Seasons

- This portable powerhouse is designed for use with gas-powered equipment fleets
- Equipped with digital weld meters to accurately monitor welding output
- 12 gallon (45 L) tank for extended run times
- 10,500 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.117

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 305 G Base Model	K1726-5	305A DC CC/29V/100% 300A DC CV/29V/100%	20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 10,500 W peak 9,500 W continuous	Kohler® OHV Command® CH730 Gas Electric Fuel Pump	2	23 @ 3600	29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920)	510 (231)
One-Pak® Pkg.	K2353-2						—	—

Ranger® 305 G EFI

Fuel-Efficient Engine-Driven Welder/Generator

- Equipped with digital weld meters to accurately monitor welding output
- 12 gallon [45 L] tank for extended run times
- Electric fuel pump helps avoid vapor lock during high-altitude operation
- Choose the Ranger 305 G EFI (electronic fuel injection) for easier starts in cold weather and lower fuel consumption, with no choke starting required
- 12,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.117

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 305 G EFI Base Model	K3928-1	305A DC CC/29V/100% 300A DC CV/29V/100%	20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 12,000 W peak 9,500 W continuous	Kohler® OHV Command® ECH740 Gas Electric Fuel Pump Electric Fuel Injection	2	25 @ 3600	29.9 x 21.5 x 42.3 (759 x 546 x 1074)	510 (231)
Fall Camo Model	K3928-10						To top of exhaust tube: 36.2 (920)	

Ranger® 305 LPG

Engine-Driven Low Emission Welder/Generator

- Choose the Ranger 305 LPG for those environments where gasoline and diesel emissions are not acceptable
- Top-of-the-line Kohler® overhead valve (OHV) 25 HP Command® LPG engine
- Digital weld meters monitor actual welding output
- 10,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.119

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 305 LPG Base Model	K2937-1	300A DC CC/25V/100% 300A DC CV/25V/100%	20-300A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 10,000 W peak 9,000 W continuous	Kohler® OHV Command® CH730 LP	2	25 @ 3600	29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920)	480 (218)
One-Pak® Pkg.	K2944-1						—	—

Ranger® 305 D

Diesel Power, Expanded Capabilities – Engine-Driven Welder/Generator

- Choose the Ranger 305 D for extended fuel efficiency and compatibility with diesel-powered fleets.
- Meets all EPA Tier 4 requirements
- Digital weld meters to monitor actual welding output
- Arc force control for a soft or more forceful digging arc
- 10,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.118

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	# of Cyl.	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Ranger® 305 D Base Model	K1727-4	305A DC CC/29V/100% 300A DC CV/29V/100%	20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V 10,000 W peak 9,500 W continuous	Kubota® D722 Diesel EPA Tier 4 Final	3	18.8 @ 3600	29.9 x 21.5 x 50.3 (759 x 546 x 1327) To top of exhaust tube: 35.8 (909)	698 (317)
One-Pak® Pkg.	K2352-5						—	—

LIMITED TIME OFFER

Show Your COLORS

FALL CAMO™ RANGER® 250 GXT AND RANGER 305 G EFI



Ranger 250 GXT Fall Camo
Order K2382-10 \$4125.00

Ranger 305 G EFI Fall Camo
Order K3928-10 \$5375.00

All prices are in U.S. Dollars (\$). This program supersedes and replaces all previous Lincoln Electric rebate programs. This program may be discontinued at any time.

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What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Ranger® 305 G

One-Pak® Package (K2353-2)

- Ranger® 305 G
- LN-25 Ironworker® Wire Feeder
- K126™ PRO 350 Amp Innershield® Gun
- Accessory Kit, 400 Amp
- 5/64 in. (2.0 mm) Innershield® NR®-233, 25 lb. (11.3 kg) Spool

Ranger® 305 LPG

One-Pak® Package (K2944-1)

- Ranger® 305 LPG
- Factory Undercarriage
- Welding Gas Cylinder/LPG Tank Holder
- LPG Tank Strap
- Accessory Kit, 400 Amp
- 1/8 in. (3.2 mm) Excalibur® 7018 MR Stick Electrode, Six 10 lb. (4.5 kg) Easy Open Cans

Ranger® 305 D

One-Pak® Package (K2352-5)

- Ranger® 305 D
- LN-25 Ironworker® Wire Feeder
- K126™ PRO 350 Amp Innershield® Gun
- Accessory Kit, 400 Amp
- 5/64 in. (2.0 mm) Innershield® NR®-233, 25 lb. (11.3 kg) Spool



Shown:
Ranger® 305 G
One-Pak®



Shown:
Ranger® 305 LPG
One-Pak®



Shown:
Ranger® 305 D
One-Pak®

Accessories

Product Name	Product No.	Bulldog® 5500	Outback® 145	Outback® 185	Rangerr® 225	Rangerr® 250 GXT	Rangerr® 305 G	Rangerr® 305 G EFI	Rangerr® 305 LPG	Rangerr® 305 D	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model [Stainless]	Base Model	Base Model	Base Model	Base Model
		K2708-2	K2707-2	K2706-2	K2857-1	K2382-4	K2382-5	K1726-5	K3928-1	K2937-1	K1727-4
GENERAL											
Accessory Kit, 150 Amp	K875	•	•	•							
Undercarriage	K2722-1	•	•	•							
All-Terrain Undercarriage	K1737-1				•	•	•	•	•		
Factory Undercarriage	K1770-1				•			•	•	•	
Lift Bail Kit	K2819-1	•	•	•							
Canvas Cover	K2804-1	•	•	•							
Canvas Cover	K886-2				•	•	•	•	•	•	
Power Plug Kit, 20 amp	K802N				•	•	•	•	•	•	•
Full-KVA Power Plug (1-phase)	T12153-9				•	•	•	•	•	•	•
GFCI Receptacle Kit, 120V, 20 Amp (2 required)	K1690-1	•	•	•	•	•	•	•	•		
Spark Arrestor Kit	K1898-1				•	•	•	•			
Spark Arrestor Kit	K2793-1			•							
Welding Gas Cylinder/LPG Tank Holder	K1745-1				•	•	•	•	•	•	
LPG Tank Strap (requires K1745-1)	K2361-1									•	
Small 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch	K2635-1				•	•	•	•	•		•
Fender and Light Kit	K2639-1				•	•	•	•	•		•
Cable Rack	K2640-1				•	•	•	•	•		•
Polarity/Multi-Process Switch	K2642-1							•	•	•	•
Docking Kit	K2663-1							•	•	•	•
STICK											
Accessory Kit, 400 Amp	K704				•	•	•	•	•	•	•
Accessory Kit, 150 Amp	K875				•	•	•			•	•
Remote Output Control, 25 ft (7.6 m)	K857					•	•	•	•	•	•
Remote Output Control, 100 ft (30.5 m)	K857-1					•	•	•	•	•	•
Remote Output Control with 120V AC, 100 ft (30.5 m), 20 amp capacity	K2627-2					•	•	•	•	•	•
TIG											
Pro-Torch™ TIG Torch PTA-26, 25 ft (7.6 m), 2 pc	K1783-4					•	•				
Pro-Torch™ TIG Torch PTA-26V, 25 ft (7.6 m), 2 pc	K1783-9				•			•	•	•	•
Parts Kit For PTW-18 and PTA-26 Series Torches	KP509				•	•	•	•	•	•	•
Control Cable (9-pin to 6-pin and 115V plug)	K936-3					•	•				
Control Cable Extension, 45 ft (13.7 m)	K937-45					•	•				
Hand Amptrol™ (Rotary Track Style)	K963-3					•	•	•	•	•	•
Foot Amptrol™	K870					•	•	•	•	•	•

Accessories

Product Name	Product No.	Bulldog® 5500	Outback® 145	Outback® 185	Ranger® 225	Ranger® 250 GXT	Ranger® 305 G	Ranger® 305 G EFI	Ranger® 305 LPG	Ranger® 305 D	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model [Stainless]	Base Model	Base Model	Base Model	Base Model
		K2708-2	K2707-2	K2706-2	K2857-1	K2382-4	K2382-5	K1726-5	K3928-1	K2937-1	K1727-4
TIG, CONT.											
Contact Kit	K938-1					•	•				
Docking Kit	K939-1					•	•				
Full-KVA Adapter Kit (1-phase)	K1816-1			•	•	•	•	•	•	•	
Square Wave™ TIG 175	K1478-5			•			•	•	•	•	
TIG Module	K930-2					•	•				
WIRE FEEDER											
K126™ PRO FCAW-SS Gun, 15 ft (4.6 m), 0.062-5/64 in (1.6-2.0 mm)	K126-12				•	•	•	•	•	•	•
Drive Roll Kit, 5/64 in (2.0 mm) Cored/Solid	KP1697-5/64					•	•				
Drive Roll Kit, 0.068-0.072 in (1.7-1.8 mm) Solid/Cored Wire	KP1697-068				•	•	•	•	•	•	•
Magnum® PRO 350 Ready-Pak®, 15 ft (4.6 mm), 0.035-5/64 in (0.9-2.0 mm). (Includes K466-10 Connector Kit)	K2652-2-10-45				•			•	•	•	•
Drive Roll Kit, 0.035 in and 0.045 in (0.9 and 1.1 mm) Solid Wire	KP1696-1				•	•	•	•	•	•	•
POWER MIG® 140C	K2471-2	•	•	•							
POWER MIG® 180C	K2473-2		•	•	•	•	•	•	•	•	•
LN-25 PRO Wire Feeder	K2613-5				•	•	•				
LN-25 Ironworker® Wire Feeder	K2614-9							•	•	•	•
SPOOL GUN											
Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m)	K487-25							•	•	•	•
SG Control Module	K488							•	•	•	•
Control Module Input Cable, 14-pin MS-type & Lug, 10 ft. (3.0 m)	K691-10							•	•	•	•
Magnum® PRO 100SG Spool Gun (requires POWER MIG® 140C)	K3269-1	•									
Magnum® PRO 100SG Spool Gun (requires POWER MIG® 140C or 180C)	K3269-1		•	•							
Magnum® PRO 100SG Spool Gun (requires POWER MIG® 180C)	K3269-1				•	•	•	•	•	•	•
PLASMA CUTTING											
Tomahawk® 375 Air	K2806-1			•							
Tomahawk® 1000	K2808-1				•	•	•	•	•	•	•
2-YEAR EXTENDED WARRANTY											
Bulldog® 5500	—	•									
Outback® 145	—		•								
Outback® 185	—			•							
Ranger® 225	—				•						
Ranger® 250 GXT	—					•	•				
Ranger® 305 G	—							•			
Ranger® 305 G EFI	—								•		
Ranger® 305 LPG	—									•	
Ranger® 305 D	—										•

• Optional



ENGINE DRIVES: INDUSTRIAL

MODEL	OUTPUT				PROCESS							FEATURES							
	Mode	Polarity	Current Range (Amps)	AC Generator Power (watts) C = Continuous P = Peak	Stick	Pipe	DC TIG Scratch Start	Touch Start TIG*	AC TIG	MIG	Flux-Cored	Arc Gouge in (mm)	Pure DC Generator	Chopper Technology*	Stainless Steel Case	Corrosive Environments	Weld Meters	Voltage Reduction Device™ (VRD™)	Air Compressor
200-400 AMP MODELS																			
Classic® 300 HE	CC	DC	40-350 DC	1-Phase: 3,000 C	●	●	●			○	○	3/16 (4.8)	●						
SAE-300® HE	CC	DC	50-390 DC	1-Phase: 3,000 C	●	●	●			○	○	1/4 (6.3)	●						
Classic® 300 MP	CC/CV	DC	40-350 DC	1-Phase: 3,000 C	●	●	●			●	●	1/4 (6.3)	●		optional				
SAE-300® MP	CC/CV	DC	40-350 DC	1-Phase: 3,000 C	●	●	●			●	●	1/4 (6.3)	●		optional				
Cross Country™ 300	CC/CV	DC	40-300 DC Pipe 20-250 DC TIG	3-Phase: 12,500 P / 11,000 C 1-Phase: 11,500 P / 10,000 C	●	●		●	○	●	●	1/4 (6.3)	●		optional		●	optional	
Vantage® 300	CC/CV	DC	30-400 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 12,500 P / 11,000 C 1-Phase: 11,500 P / 10,000 C	●	●		●	○	●	●	1/4 (6.3)	●		●		●	●	
Vantage® 400	CC/CV	DC	30-500 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 19,000 P / 17,000 C 1-Phase: 12,000 P / 11,000 C	●	●		●	○	●	●	5/16 (8.0)	●		●		●	●	
500-700 AMP MODELS																			
SAE-500®	CC	DC	80-575 DC	1-Phase: 3,000 C	●	●	◐				○	3/8 (9.5)	●						
SAE-500® Severe Duty	CC	DC	80-575 DC	1-Phase: 3,000 C	●	●	◐				○	3/8 (9.5)	●		●	●			
Vantage® 500 Compact Case	CC/CV	DC	30-525 DC 40-300 DC Pipe 20-250 DC TIG	3-Phase: 22,000 P / 20,000 C 1-Phase: 13,000 P / 12,000 C	●	●		●	○	●	●	3/8 (9.5)	●		●		●	●	
Vantage® 520 SD	CC/CV	DC	30-520 CC/CV 20-250 TIG	3-Phase: 17,000 C 1-Phase: 11,000 C	●	●		●	○	●	●	5/16 (8.0)	●		●		●	●	
Vantage® 600 SD	CC/CV	DC	30-600 CC/CV 20-350 TIG	3-Phase: 20,000 C 1-Phase: 12,000 C	●	●		●	○	●	●	3/8 (9.5)	●		●		●	●	
Air Vantage® 600 SD	CC/CV	DC	30-600 CC/CV 20-350 TIG	3-Phase: 20,000 C 1-Phase: 12,000 C	●	●		●	○	●	●	3/8 (9.5)	●		●		●	●	●

KEY: ● Excellent ◐ Good ○ Optional

Classic® 300 HE

Fuel Efficiency in Pipeline and Construction Welding

- All-copper windings enhance arc stability for a smooth, high-performance arc
- Five current ranges with overlap for stick welding and other processes where slope control is desired. Fine tuning within each range
- EPA Tier 4 rating on Kubota® D1503 diesel engine



Processes

- Stick
- TIG
- MIG⁽¹⁾
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.156

⁽¹⁾ With Wire Feed Module.
Rated 300 amps, 35 volts
at 60% duty cycle.

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Classic® 300 HE Base Model	K3198-1	250A/30V/100% 300A/32V/60%	40-350A DC	Kubota® D1503 Diesel EPA Tier 4	3	24.7 @ 1800	37.1 x 24.3 x 62.8 (943 x 616 x 1594)	1371 (622)
One-Pak® Pkg.	K2386-5		1-Ph/AC Power: 3,000 watts				To top of exhaust tube: 45.5 (1156)	—
Ready-Pak® Pkg.	K2387-5							—

SAE-300® HE

Dual Control for Pipeline Welding

- Current controls allow for sharper arc on root and hot passes, or softer arc on pipe welding with low-hydrogen electrode
- All-copper windings enhance arc stability for a smooth, high-performance arc
- Perkins® or Kubota® engines offer fuel savings compared to previous models



Processes

- Stick
- TIG
- MIG⁽¹⁾
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.162

⁽¹⁾ With Wire Feed Module.
Rated 300 amps, 35 volts
at 60% duty cycle.

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
SAE-300® HE Base Model (Kubota®)	K3201-1	250A/30V/100% 300A/32V/60%	50-390A DC	Kubota® D1503 Diesel EPA Tier 4	3	24.7 @ 1800	37.1 x 24.3 x 62.8 (943 x 616 x 1594)	1432 (649)
Base Model w/Wire Feed Module	K3201-2		1-Ph/AC Power: 3,000 watts				To top of exhaust tube: 45.5 (1156)	—
One-Pak® Pkg.	K3956-5							—
Ready-Pak® Pkg.	K3959-5							—
SAE-300® HE Base Model (Perkins®)	K3202-1			Perkins® 403F-15T Turbo-Charged Diesel EPA Tier 4				1419 (644)
One-Pak® Pkg.	K3957-5							—
Ready-Pak® Pkg.	K3960-5							—

Classic® 300 MP

Excellent for Pipelines, Construction and Maintenance.

- Pure DC generator design enables precise control
- Temperature stabilization
- Choose the Classic® 300 MP for traditional five step current control
- Custom ARC® current adjustment allows for fine tuning of heat input at the arc (Perkins® model only)
- Multi-process ready for stick, wire and TIG welding
- Comes standard with an engine block heater



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.157

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Classic 300 MP Base Model [Perkins®]	K4263-1	NEMA Ratings: 250A/30V/100% 300A/32V/60%	40-350A DC 220 - Max 160 - 240 120 - 190 80 - 130 Min - 90	Perkins® 403F-15T Diesel EPA Tier 4	3	24.7 @ 1800	37.1 x 24.3 x 62.8 (943 x 616 x 1594)	1,364 (619)
Base Model [Kubota®]	K4264-1	Max. OCV: 90V DC	1-Ph/AC Power: 3,000 watts	Kubota® D1503 Diesel EPA Tier 4				1,377 (625)

SAE-300® MP

Quality. Efficiency. Endurance.

- Temperature stabilization
- Pure DC generator ensures smooth, stable arc
- Dual continuous current control allows coarse tuning, fine tuning and everything in between
- Multi-process ready for stick, wire and TIG welding
- Comes standard with an engine block heater



Processes

- Stick
- Flux-Cored
- MIG
- TIG

Output



Input



Literature

E6.163

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
SAE-300® MP Base Model/Gray Painted Steel Case [Perkins®]	K4089-1	NEMA Ratings 250A/30V/100% 300A/32V/60%	40-350A 1-Ph/AC Power: 3,000 watts	Perkins® 403F-15T Diesel EPA Tier 4	3	24.7 @ 1800	37.1 x 24.3 x 62.8 (943 x 616 x 1594)	1,419 (644)
Stainless Steel Case [Perkins®] w/Factory-Installed Wireless Remote	K4089-2	Max. OCV: 90V DC						
SAE-300® MP Base Model/Gray Painted Steel Case [Kubota®]	K4090-1			Kubota® D1503 Diesel EPA Tier 4				1,432 (649)
Gray Painted Steel Case [Kubota®] w/Factory-Installed Wireless Remote	K4090-2							

Cross Country® 300

Purpose-Built For Pipe Welding

- Compact and portable: lighter weight and smaller footprint for easy transport
- Dual controls are designed for pipeline welding
- Supports DC, stick, wire and TIG processes
- Powerful generator for grinders, pumps and travel trailers
- Comes standard with an Engine Block Heater



Processes

- Stick
- Flux-Cored
- MIG
- TIG

Output



Input



Literature

E6.170

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Cross Country® 300 Base Model/Gray Painted Steel Case	K4166-1	300A/32V/100% 350A/28V/100%	40-300A CC/CV 20-250A TIG	Kubota® V1505 Liquid-Cooled EPA Tier 4 Final Compliant	4	22 @ 1800	31.9 x 25.3 x 56 (810 x 643 x 1422)	1034 (469)
Gray Painted Steel Case w/Factory-Installed Wireless Remote	K4166-2		3-Ph/AC Power: 11,000 watts					
Stainless Steel Case w/Factory-Installed Wireless Remote	K4166-3		1-Ph/AC Power: 10,000 watts					
Gray Painted Steel Case w/K4268-1 Wired Remote One-Pak® Pkg.	K4166-7							

Vantage® 300

Quiet, Compact, Multi-Process Construction, Pipe and Rental Welder/Generator

- Five process modes, including arc gouging with up to 1/4 in. (2.4 mm) carbons
- Plenty of AC Generator Power
- Delivers great arc starts and a smooth arc for stick, TIG or wire welding



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.206

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Vantage® 300 Base Model	K2409-4	300A/32V/100% 350A/28V/100%	30-400A DC 40-300A Pipe 20-250A DC TIG 14-32V CV	Kubota® V1505 Liquid-Cooled EPA Tier 4 Final Compliant	4	22 @ 1800	35.9 x 25.3 x 60 (913 x 642 x 1524)	1035 (469)
One-Pak® Pkg.	K2452-5							
Ready-Pak® Pkg.	K2453-5		3-Ph/AC Power: 12.5 kW p, 11 kW c 1-Ph/AC Power: 11.5 kW p, 10 kW c					

Vantage® 400

Multi-Process Welding with Extra Power

- Multi-Process Welding, separate Arc Gouge Mode
- Plenty of AC Generator Power
- Compact case with stainless steel enclosure
- Industrial Perkins® diesel engine



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.210

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Vantage® 400 Base Model	K2410-7	400A/36V/100% 450A/32V/100%	30-500A DC 40-300A Pipe 20-250A DC TIG 14-36V CV	Perkins® 404D-22 Diesel EPA Tier 4 Final (AB&T)	4	32.7 @ 1800	35.9 x 25.3 x 60 (913 x 642 x 1524)	1230 (559)
One-Pak® Pkg.	K2508-7						To top of exhaust tube: 46.6 (1184)	—
Ready-Pak® Pkg.	K2509-7		3-Ph/AC Power: 19 kW p, 17 kW c 1-Ph/AC Power: 12 kW p, 11 kW c					—

SAE-500®

Built for High Amperage Stick Jobs

- Rugged construction protects internal components in rough environments
- Large diameter stick welding and arc gouging up to 3/8 in. (9.5 mm) carbon
- Ideal for multiple arc applications with the Multi-Weld™ 350 system



Processes

- Stick
- TIG
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.182

⁽¹⁾ With CV Adapter. Rated at 400 amps, 35 volts at 60% duty cycle.

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
SAE-500® Base Model	K4053-1	400A /40V/100% 500A/40V/60%	80-575A DC 1-Ph/AC Power: 3,000 watts	Deutz® TD2.9L4 Diesel EPA Tier 4 Final Compliant	4	64 @ 1800	45.8 x 28 x 83 (1164 x 711 x 2109) To top of exhaust tube: 54.3 (1379)	2111 (957.5)

SAE-500[®] Severe Duty[™]

Take Stick to The Extreme

- Designed to withstand offshore salt spray and other corrosive environments with all-copper coils, a coated radiator and wire connections and sealed switches
- Stainless steel and hot-dip galvanized case and internal sheet metal
- Spark arrestor and engine air intake shutdown per Mineral Management Services Code
- Remote control included



Processes

- Stick
- TIG
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.182

⁽¹⁾ With CV Adapter. Rated at 400 amps, 35 volts at 60% duty cycle. (Not available with upgrades for severe duty environments.)

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
SAE-500 [®] Severe Duty [™] Base Model	K3955-1	400A/40V/100% 500A/40V/60%	80-575A DC 1-Ph/AC Power: 3,000 watts	Deutz [®] TD2.9L4 Diesel EPA Tier 4 Final Compliant	4	64 @ 1800	45.8 x 28 x 83 (1164 x 711 x 2109) To top of exhaust tube: 54.3 (1379)	2111 (957.5)

Vantage[®] 500 Compact Case

Truck Mounting is Easy

- Designed for truck mounting where space and weight capacity are limited
- 500 amps @ 100% duty cycle and 20,000 watts of AC generator power
- Multi-process capability, including CC-stick, pipe, CV-wire, DC Touch Start TIG[®] and arc gouging
- Stainless steel enclosure for corrosion resistant protection and durability
- Arc gouging with up to 3/8 in. (9.5 mm) carbons



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.214

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Vantage [®] 500 Compact Case Base Model	K2686-2	500A/40v/100% 525A/38V/60%	30-525A DC 40-300A Pipe 20-250A DC TIG 14-40V CV	Perkins [®] 404D-22T Turbo Diesel EPA Tier 4 Final (AB&T)	4	45 @ 1850	35.9 x 25.3 x 60.0 (913 x 642 x 1524) To top of exhaust tube: 46.6 (1184)	1290 (586)
One-Pak [®] Pkg.	K3244-3							—
Ready-Pak [®] Pkg.	K2728-3		3-Ph/AC Power: 20 kW continuous 1-Ph/AC Power: 12 kW continuous					—

Vantage® 520 SD

A Superior Arc With A Superior Engine

- Upgraded for Tier 4 Final compliance with a cleaner, more reliable engine
- Ideal for 400-amp, 36-volt 100% duty cycle welding
- Arc Gouges with up to 5/16 in. (8.0 mm) carbon electrodes
- Low maintenance, reliable operation



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Vantage® 520 SD Base Model	K4107-1	@ 104° F (40° C): 400A/36V/100% 450A/32V/100% 520A/30V/60%	30-520A CC/CV 20-250A TIG	Deutz® D2.9L4 Naturally Aspirated Diesel Engine EPA Tier 4 Final Compliant	4	34.8 @ 1800	39.1 x 28.4 x 65.1 (994 x 721 x 1654)	1526 (692)
One-Pak® Pkg.	K4173-1		3-Ph/AC Power: 17 kW continuous					—
Ready-Pak® Pkg. 1	K4138-1		1-Ph/AC Power: 11 kW continuous					—
Ready-Pak® Pkg. 3	K4138-12		—					—
Ready-Pak® Pkg. 6	K4138-129	—	—	—				

Vantage® 600 SD

A Superior Arc With A Superior Engine

- Upgrade for Tier 4 Final compliance with a cleaner, more reliable engine
- Ideal for 575-amp, 43-volt 100% duty cycle welding
- Arc Gouges with up to 3/8 in. (9.5 mm) carbon electrodes
- Low maintenance reliable operation



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)	
Vantage® 600 SD Base Model	K3239-1	@ 104° F (40° C): 575A/43V/100% 600A/40V/60%	30-600A CC/CV 20-350A TIG	Deutz® Turbo Charged TD2.9L4 Diesel EPA Tier 4 Final Compliant	4	64 @ 1800	42 x 32.9 x 69 (1067 x 836 x 1753)	1662 (753)	
One-Pak® Pkg.	K3245-5		3-Ph/AC Power: 20,000 watts					To top of exhaust tube: 50.8 (1290)	—
Ready-Pak® Pkg. 1	K4136-1		1-Ph/AC Power: 12,000 watts					—	
Ready-Pak® Pkg. 3	K4136-12		—					—	
Ready-Pak® Pkg. 6	K4136-129	—	—	—					

Air Vantage® 600 SD

A Superior Arc With A Superior Engine

- Upgrade for Tier 4 Final compliance with a cleaner, more reliable engine
- Belt-driven compressor with separate gauges to monitor compressor hours and pressure
- Less wiring and fewer connections means less downtime for maintenance and repair
- Ideal for 575-amp, 43-volt 100% duty cycle welding
- Arc Gouges with up to 3/8 in. (9.5 mm) carbon electrodes



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

Product Name	Product Number	Rated Output: Current/Voltage/Duty Cycle	Output Range	Engine	No. of Cylinders	HP & Speed (rpm)	H x W x D in (mm)	Net Wt. lb (kg)
Air Vantage® 600 SD Base Model	K3242-1	@ 104° F [40° C]: 575A/43V/100% 600A/40V/60%	30-600A CC/CV 20-350A TIG	Deutz® Turbo Charged TD2.9L4 Diesel EPA Tier 4 Final Compliant	4	64 @ 1800	42 x 32.9 x 69 (1067 x 836 x 1753)	1737 (787)
One-Pak® Pkg.	K3958-5		3-Ph/AC Power: 20,000 watts				To top of exhaust tube: 50.8 (1290)	—
Ready-Pak® Pkg. 1	K4137-1		1-Ph/AC Power: 12,000 watts				—	
Ready-Pak® Pkg. 3	K4137-12		Compressor: 60 SCFM, 100 PSI				—	
Ready-Pak® Pkg. 6	K4137-129						—	

STACKING IRON

S I N C E 1 9 1 1



Lincoln Electric knows the pipeline business because we've been a part of it from the beginning. It's a heritage that we don't take lightly. Because you've given us the opportunity to work alongside you all these years, we've been able to produce pipeline welding machines and electrodes engineered to give you everything you need to get the job done. We back these products with a dedicated pipe applications team – available when you need them – because second chances don't come easy on a pipeline spread.

LINCOLN[®]
ELECTRIC

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Classic® 300 HE

One-Pak® Package (K2386-5)

- Classic® 300 HE
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package (K2387-5)

- Includes everything above (K2386-5)

SAE-300® HE

One-Pak® Package (Kubota®) (K3956-5)

- SAE-300® HE w/o Wire Feed Module (K3201-1)
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package (Kubota®) (K3959-5)

- Includes everything above (K3956-5)

One-Pak® Package (Perkins®) (K3957-5)

- SAE-300® HE without Wire Feed Module (K3201-1)
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

SAE-300® HE, con't.

Ready-Pak® Package (Perkins®) (K3960-5)

- Includes everything above (K3957-5)

SAE-300® MP

Ready-Pak® Package 2 (K4089-1-RP2)

- SAE-300® MP (Perkins®) (K4089-1)
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch

Ready-Pak® Package 3 (K4089-1-RP3)

- Includes everything above (K4089-1-RP2)
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 1 (K4089-1-RP1)

- Includes everything above (K4089-1-RP3)
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- Work Cable 2/0, 50 ft. (15.2 m)
- 300A Electrode Holder
- 300A Work Clamp
- Cable Connectors, Qty. 2

Cross Country® 300

One-Pak® Package (K4166-7)

- Cross Country® 300 with Gray Painted Steel Case
- 125 ft (38.1 m) Wired Remote Control with 115V Auxiliary Power



Shown:
Classic® 300 HE
One-Pak® Package



Shown:
SAE-300® HE
Ready-Pak® Package

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Vantage® 300

One-Pak® Package (K2452-5)

- Vantage® 300
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package (K2453-5)

- Includes everything above (K2452-5)

Vantage® 400

One-Pak® Package (Perkins®) (K2508-7)

- Vantage® 400
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 400A Electrode Holder
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- 500A Work Clamp
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package (Perkins®) (K2509-7)

- Includes everything above (K2508-7)

Vantage® 500 Compact Case

Ready-Pak® Package (Perkins®) (K2728-5)

- Vantage® 500
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 400A Electrode Holder
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- 500A Work Clamp
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors

Vantage® 520 SD

Ready-Pak® Package 3 (K4138-12)

- Vantage® 520 SD (K4107-1)
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 (K4138-129)

- Includes everything above (K4138-12)
- LoJack® Device

Ready-Pak® Package 1 (K4138-129)

- Includes everything in Package 3 (K4138-12)
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package (K4173-1)

- Includes everything in Package 1 (K4138-1)



Shown:
Classic® 300 HE
One-Pak® Package



Shown:
SAE-300® HE
Ready-Pak® Package



Shown:
Vantage® 400
Ready-Pak® Package



Shown:
Vantage® 500
Compact Case
One-Pak® Package

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Vantage® 600 SD

Ready-Pak® Package 3 [K4136-12]

- Vantage® 600 SD [K3239-1]
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 [K4136-129]

- Includes everything above [K4136-12]
- LoJack® Device

Ready-Pak® Package 1 [K4136-1]

- Includes everything in Package 3 [K4136-12]
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package [K3245-5]

- Includes everything above [K4136-1]

Air Vantage® 600 SD

Ready-Pak® Package 3 [K4137-12]

- Air Vantage® 600 SD [K3242-1]
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 [K4137-129]

- Includes everything above [K4137-12]
- LoJack® Device

Ready-Pak® Package 1 [K4137-1]

- Includes everything in Package 3 [K4137-12]
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package [K3958-5]

- Includes everything above [K4137-1]

Accessories

Product Name	Product No.	Classic® 300 HE		SAE-300® HE		Classic® 300 MP		SAE-300® MP		Cross Country® 300		Vantage® 300		Vantage® 400		SAE-500®		SAE-500® Severe Duty™		Vantage® 500 Compact Case		Vantage® 520 SD		Vantage® 600 SD		Air Vantage® 600 SD		
		Base Model (K3198-1)	Base Model (Kubota) (K3201-1)	Base Model (Kubota) (K3201-2 (WF Module))	Base Model (Perkins) (K3202-1)	Base Model (Perkins) (K4263-1)	Base Model (Kubota) (K4264-1)	Base Model (Perkins) (K4089-1)	Base Model (Kubota) (K4090-1)	Base Model (K4166-1)	Base Model (K2409-4)	Base Model (Perkins) (K2410-7)	Base Model (K4053-1)	Base Model (K3955-1)	Base Model (K2686-2)	Base Model (K4107-1)	Base Model (K3239-1)	Base Model (K3242-1)										
GENERAL																												
Power Plug Kit	K802D	•	•	•	•	•	•	•	•					•	•													
Power Plug Kit, 20 amp	K802N									•	•	•								•	•	•						
Ether Start Kit (Deutz®)	K887-1																											
Spark Arrestor Kit	K903-1	•	•	•	•	•	•	•	•					•						•								
Spark Arrestor Kit	K1898-1									•	•																	
Spark Arrestor Kit	K3985-1																						•	•	•			
Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch	K2636-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Large Two-Wheel Trailer & Duo-Hitch® Ball/Eye Hitch	K2637-2																•	•									•	•
Four-Wheel Steerable Yard Trailer with Duo-Hitch® Ball/Eye Hitch	K2641-2													•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Fender and Light Kit	K2639-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Cable Rack	K2640-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Stainless Steel Sheet Metal Kit	K2423-1	•	•	•	•	•	•	•	•																			
Full KVA Power Plug (1-Phase)	T12153-9													•	•	•						•	•	•	•	•	•	•
Full KVA Power Plug (3-Phase)	T12153-10													•	•	•						•	•	•	•	•	•	•
Full-KVA Adapter Kit (1-Phase)	K1816-1													•	•	•						•	•	•	•	•	•	•
VRD (Voltage Reduction Device) Kit	K4212-1											•																
Polarity/Multi-Process Switch	K2642-1													•	•							•						
Docking Kit	K2663-1													•	•							•						
Cold Weather Heater and Tarp Kit (Perkins®)	K2679-1															•						•						
Cold Weather Heater and Tarp Kit (Kubota®)	K2735-1															•												
Cold Weather Kit	K4213-1											•																
GFCI Receptacle Kit, 120V, 20 Amp	K1690-1																					•	•					
Air Filter Kit	K3088-1																											•
Deluxe Adjustable Gas Regulator & Hose Kit	K586-1																								•	•	•	•
ArLink™ "T" Connector Kit	K2429-1																							•	•	•	•	•
Multi-Weld™ 350 (For DC+ Welding Only)	K1735-1																							•	•			

Accessories

Product Name	Product No.	Classic [®] 300 HE		SAE-300 [®] HE		Classic [®] 300 MP		SAE-300 [®] MP		Cross Country [®] 300		Vantage [®] 300		Vantage [®] 400		SAE-500 [®]		SAE-500 [®] Severe Duty [™]		Vantage [®] 500 Compact Case		Vantage [®] 520 SD		Vantage [®] 600 SD		Air Vantage [®] 600 SD		
		Base Model (K3198-1)	Base Model (Kubota) (K3201-1)	Base Model (Kubota) (K3201-2 (WF Module))	Base Model (Perkins) (K3202-1)	Base Model (Perkins) (K4263-1)	Base Model (Kubota) (K4264-1)	Base Model (Perkins) (K4089-1)	Base Model (Kubota) (K4090-1)	Base Model (Kubota) (K4166-1)	Base Model (Kubota) (K2409-4)	Base Model (Perkins) (K2410-7)	Base Model (Kubota) (K4053-1)	Base Model (Kubota) (K3955-1)	Base Model (Perkins) (K2686-2)	Base Model (Kubota) (K4107-1)	Base Model (Perkins) (K3239-1)	Base Model (Kubota) (K3242-1)										
STICK																												
Accessory Kit, 400 Amp	K704	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Remote Output Control, 25 ft (7.6 m), 6-pin connector	K857					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Remote Output Control, 100 ft (30 m), 6-pin connector	K857-1					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Remote Output Control Detachable Box, 125 ft (38.1 m)	K4330-1					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Remote Control Kit, 100 ft (30.5 m)	K924-4	•	•	•	•												○											
125 ft (38.1 m) Remote Output Control with 120V AC Receptacles/Detachable Box	K4268-1					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
TIG																												
Pro-Torch [™] TIG Torch PTA-26V, 25 ft (7.6 m), 2 pc	K1783-9	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Parts Kit For PTW-18 and PTA-26 Series Torches	KP509	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Control Cable (9-pin to 115V plug)	K936-4	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Control Cable Extension, 45 ft (13.7 m)	K937-45	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Arc Start [™] Switch	K814	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Contact Kit	K938-1	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Foot Amptrol [™]	K870					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Hand Amptrol [™] (Rotary Track Style)	K963-3					•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
TIG Module	K930-2	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Square Wave [™] TIG 175	K1478-5										•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Square Wave [™] TIG 200	K5126-1										•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
MULTI-PROCESS																												
Invertec [®] V350 PRO Multi-Process Welder (Construction Model)	K1728-5																									•	•	•
WIRE FEEDER																												
Wire Feed Module	K3964-1	•	•		•																							
Remote Control Kit, 100 ft (30.5 m)	K2464-1	•	•	•	•																							
K126 [™] PRO Innershield [®] Gun, .062-3/32, 15 ft (4.6 m)	K126-11										•																	
K126 [™] PRO Innershield [®] Gun, 1/16-5/64, 15 ft (4.6 m)	K126-12	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Magnum [®] PRO 350 Ready-Pak [®] , 15 ft (4.6 m), 0.035-5/64 in. (0.9-2.0 mm) (Includes K466-10 Connector Kit)	K2652-2-10-45	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

○ Included • Optional

Accessories

Product Name	Product No.	Classic® 300 HE		SAE-300® HE				Classic® 300 MP		SAE-300® MP		Cross Country® 300		Vantage® 300		Vantage® 400		SAE-500®		SAE-500® Severe Duty™		Vantage® 500 Compact Case		Vantage® 520 SD		Vantage® 600 SD		Air Vantage® 600 SD	
		Base Model (K3198-1)	Base Model (Kubota) (K3201-1)	Base Model (Kubota) (K3201-2 (WF Module))	Base Model (Perkins) (K3202-1)	Base Model (Perkins) (K4263-1)	Base Model (Kubota) (K4264-1)	Base Model (Perkins) (K4089-1)	Base Model (Kubota) (K4090-1)	Base Model (K3198-1)	Base Model (Kubota) (K2409-4)	Base Model (Perkins) (K2410-7)	Base Model (K3955-1)	Base Model (K2686-2)	Base Model (K4107-1)	Base Model (K3239-1)	Base Model (K3242-1)												
WIRE FEEDER, CON'T																													
CV Adapter (with MS-Type connection, local/remote switch)	K385-2																		•	•									
Heavy Duty ArcLink® Control Cable, 25 ft (7.6 m)	K2683-25																					•	•	•					
Heavy Duty ArcLink® Control Cable, 50 ft (15.0 m)	K2683-50																					•	•	•					
Heavy Duty ArcLink® Control Cable, 100 ft (30.5 m)	K2683-100																					•	•	•					
Flex Feed™ 74 HT	K3883-5																					•		•	•				
LN-25 Pipe Wire Feeder	K2614-5			•		•	•	•	•	•	•	•	•	•	•	•	•					•	•	•	•	•	•	•	
LN-25 Ironworker® Wire Feeder	K2614-9			•		•	•	•	•	•	•	•	•	•	•	•	•					•	•	•	•	•	•	•	
Power Feed® 25M Wire Feeder, Aluminum Case	K2536-8																						•	•	•				
Power Feed® 25M Wire Feeder, Plastic Case	K2536-5																						•	•	•				
SPOOL GUN																													
Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft (7.6 m)	K487-25	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•					•	•	•	•	•	•	•	
SG Control Module	K488	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•					•	•	•	•	•	•	•	
Control Module Input Cable, 14-pin MS-type & Lug, 10 ft (3.0 m)	K691-10	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•					•	•	•	•	•	•	•	
POWER MIG® 210 MP	K3963-1												•	•	•	•	•					•	•	•	•	•	•	•	
PLASMA CUTTING																													
Tomahawk® 1000	K2808-1																						•	•					

Accessories

Product Name	Product No.																							
		Classic [®] 300 HE	Base Model	Base Model (Kubota [®])	SAE-300 [®] HE	Base Model (Kubota [®])	Base Model (Perkins [®])	Classic [®] 300 MP	Base Model (Perkins [®])	Base Model (Kubota [®])	SAE-300 [®] MP	Base Model (Perkins [®])	Base Model (Kubota [®])	Cross Country [®] 300	Vantage [®] 300	Vantage [®] 400	SAE-500 [®]	SAE-500 [®] Severe Duty [™]	Vantage [®] 500 Compact Case	Vantage [®] 520 SD	Vantage [®] 600 SD	Air Vantage [®] 600 SD		
		K3198-1	K3201-1	K3201-2 (WF Module)	K3202-1	K4263-1	K4264-1	K4089-1	K4090-1	K4166-1	K2409-4	K2410-7	K4053-1	K3955-1	K2686-2	K4107-1	K3239-1	K3242-1						
2-YEAR EXTENDED WARRANTY																								
Classic [®] 300 HE	-	•																						
SAE-300 [®] HE (Kubota [®])	-		•	•																				
SAE-300 [®] HE (Perkins [®])	-				•																			
Classic [®] 300 MP (Perkins [®])	-					•																		
Classic [®] 300 MP (Kubota [®])	-						•																	
SAE-300 [®] MP (Perkins [®])	-							•																
SAE-300 [®] MP (Kubota [®])	-								•															
Cross Country [®] 300	-									•														
Vantage [®] 300	-										•													
Vantage [®] 400 (Perkins [®])	-											•												
SAE-500 [®]	-												•											
SAE-500 [®] Severe Duty	-													•										
Vantage [®] 500 Compact Case	-														•									
Vantage [®] 520 SD	-															•								
Vantage [®] 600 SD	-																•							
Air Vantage [®] 600 SD	-																						•	



SEMI-AUTOMATIC WIRE FEEDERS

MODEL	OUTPUT			PROCESS					FEATURES			
	Wire Feed Speed Range ipm (m/min) High Speed Low Speed	Solid Wire Size Range: in (mm) High Speed Low Speed	Cored Wire Size Range: in (mm) High Speed Low Speed	MIG	Pulsed MIG	MIG-STT [®]	Flux-Cored	Submerged Arc	MAXTRAC [®] Wire Drive System	Gouging (CCAG)	2-Roll Drive	4-Roll Drive
BENCH AND BOOM MODELS												
ANALOG												
LF-72	50-800 (1.3-20.3)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	●		●		•		•	
LF-74	100-800 (2.5-20.3)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	●		●		•		•	
LN-8	50-600 (1.3-15.2)	0.040-3/32 (1.0-2.4)	0.045-0.120 (1.2-3.0)	●			●	●			•	
LN-9	50-600 (1.3-15.2)	0.040-3/32 (1.0-2.4)	0.045-0.120 (1.2-3.0)	●			●	●			•	•
Flex Feed [®] 74 HT	50-700 (1.3-17.8)	0.025-3/32 (0.6-2.4)	0.035-0.120 (0.9-3.0)	●			●		•	•	•	•
Flex Feed [®] 84	35-700 (0.9-17.8)	0.025-3/32 (0.6-2.4)	0.035-0.120 (0.9-3.0)	●			●	●	•	•	•	•
Flex Feed [®] 84 Dual ⁽¹⁾	35-750 (0.9-19.1)	0.025-3/32 (0.6-2.4)	0.035-0.120 (0.9-3.0)	●			●	●	•	•	•	•
ARCLINK[®]												
Power Feed [®] 84	50-700 (1.3-17.8)	0.025-1/16 (0.6-1.6)		●	●	●	●		•		•	•
Power Feed [®] 84 Dual ⁽¹⁾	50-500 (1.3-12.7)	0.025-3/32 (0.6-2.4)	0.035-0.120 (0.9-3.0)	●	●	●	●		•		•	•
FIELD MODELS												
ANALOG												
Activ8 [™]	50-800 (1.3-20.3)	0.023-0.052 (0.6-1.3)	0.035-5/64 (0.9-2.0)	●	◐		●		•		•	
LN-23P	30-170 (0.76-4.3)	0.023-0.052 (0.6-1.3)	0.068-5/64 (1.7-2.0)				●				•	
LN-25 PRO Standard	50-700 (1.3-17.8)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	◐		●		•		•	
LN-25 PRO Extra Torque	50-400 (1.3-10.1)	0.023-1/16 (0.6-1.6)	0.030-3/32 (0.8-2.4)	●	◐		●		•		•	
LN-25 PRO Dual Power	50-700 (1.3-17.8)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	◐	◐	●		•		•	•
LN-25 Pipe	50-700 (1.3-17.8)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	◐		●		•		•	•
LN-25 Ironworker [®]	50-700 (1.3-17.8)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●	◐		●		•		•	•
LN-25X w/CrossLinc [™] Technology	50-700 (1.3-17.8)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	●			●		•		•	•
ARCLINK[®]												
Power Feed [®] 25M	50-800 (1.3-20.3) 30-400 (0.76-10.1)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0) 0.030-3/32 (0.8-2.4)	●	●	●	●		•		•	•
Power Feed [®] 25M Aluminum	50-800 (1.3-20.3) 30-400 (0.76-10.1)	0.023-1/16 (0.6-1.6)	—	●	●				•		•	•

KEY: ● Excellent ◐ Good ● Optional

(1) Extended wire feed speed and wire size range on dual models.

Activ8®

Get Tough and Get Moving

- Small size and weight makes it easy to fit through ship manways and move around job sites
- Compatible with compact 8 in (203 mm) wire spools
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.61

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Activ8® Base Model	K2999-1	15-110V DC	330A/60%	50-800 (1.3-20.3)	GMAW: 0.23-0.52 (0.6-1.3)	11.8 x 7.6 x 19.8 (298 x 193 x 503)	27 (12.2)
One-Pak® Pkg.	K3289-1				FCAW: 0.035-5/64 (0.9-2.0)		

LN-23P

Tough. Proven. Reliable.

- Equipped with trigger interlock circuit to reduce operator fatigue
- Gun-mounted two-position switch allows on-the-fly change to 83% of the preset wire feed speed
- Completely enclosed wire reel keeps the wire free of contaminants
- Ideal for self-shielded flux-cored welding on pipelines and other extreme worksites



Processes

- Flux-Cored

Output



Input



Literature

E8.90

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-23P	K316L-1	14-50V DC (90V DC Max. OCV)	350A/60%	30-170 (0.8-4.3)	0.068-5/64 (1.7-2.0)	20.5 x 9 x 19 (520 x 230 x 480)	27 (12.3)

LN-25 PRO Standard

Simplicity and Reliability

- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25 PRO ⁽¹⁾ Standard	K2613-5	15-110V DC	450A/60%	50-700 (1.3-17.7)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

⁽¹⁾Includes a Flow Meter

LN-25 PRO Extra Torque

For Larger Wire Diameters on Thicker Material

- Extra Torque model allows up to 3/32 in. (2.4 mm) wire diameter welding
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25 PRO ⁽¹⁾ Extra Torque	K2613-7	15-110V DC	450A/60%	30-400 (0.8-10.1)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

⁽¹⁾Includes a Flow Meter

LN-25 PRO Dual Power

Extend Your Process Capabilities

- Dual Power model features across-the-arc and control cable power and includes remote control capability and digital display for amps and wire feed speed
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- MIG-STT®
- Pulsed
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

⁽²⁾Control Cable

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25 PRO ⁽¹⁾ Dual Power	K2614-6	15-110V DC or 24-42V AC	450A/60%	50-700 (1.3-17.7)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

⁽¹⁾Includes a Flow Meter

LN-25 Pipe

Ready for Innershield® Pipe Welding

- This specialized version includes a 14 lb. (6.4 kg) coil adapter, 5/64 in. (2.0 mm) drive rolls and guide tubes, has the WFS range preset to Low and does not include a flowmeter
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

Product Name	Product Number	Input Power Voltage/Phase/Hz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25 Pipe	K2614-5	15-110V DC	450A/60%	50-700 (1.3-17.7)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

LN-25 Ironworker®

Pro Features. Faster Feed.

- The Ironworker version includes 5/64 in. (2.0 mm) drive rolls and guide tubes, has the WFS range preset to High and does not include a flowmeter
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾ Across-the-Arc

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25 Ironworker®	K2614-9	15-110V DC	450A/60%	50-700 (1.3-17.7)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

LN-25X with CrossLinc™ Technology

Full Control. Fewer Cables.

- Reduce job site clutter and eliminate unnecessary movement of personnel around the site
- Full voltage control at the feeder results in the correct settings for every weld and allows the operator to accurately compensate for voltage drop across long cable runs
- Set up faster and eliminate trips to the power source to make adjustments
- Fully encapsulated and environmentally protected electronics



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.107.1

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-25X with CrossLinc™ Technology	K4267-1	15-110V DC	450A/60%	50-700 (1.3-17.7)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)

Power Feed® 25M

Advanced Process Control.
Portable Design.

- Mode select panel enables easy access to the Power Wave® library of waveforms
- Internal LED lighting illuminates the wire drive, while internal heating controls humidity around the welding wire
- Dual procedure and user memory presets allow the operator to set A/B procedures and easily recall custom welding modes for common applications
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging

Output



Input



Literature

E8.271

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Duty Cycle/Gearing	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Power Feed® 25M Aluminum Case	K2536-4	40V DC	500A/60% GEARING: Standard Speed (factory setting)	SOLID: 50-800 (1.3-20.3) CORED: 50-800 (1.3-20.3)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0)	14.5 x 8.5 x 23.5 (368 x 216 x 597)	35 (15.9)
Plastic Case	K2536-5		500A/60% GEARING: Extra Torque	SOLID: 30-400 (0.8-10.2) CORED: 30-400 (0.8-10.2)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4)		

Power Feed® 25M Aluminum

Advanced Aluminum Control.

- Push-pull capability maximizes performance on aluminum by ensuring uniform feeding
- Mode select panel enables easy access to the Power Wave® library of aluminum waveforms
- Internal LED lighting illuminates the wire drive, while internal heating controls humidity around the welding wire
- Dual procedure and user memory presets allow the operator to set A/B procedures
- Optimize gas delivery for aluminum process
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging

Output



Input



Literature

E8.271

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Duty Cycle/Gearing	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Power Feed® 25M Aluminum	K4191-1	40V DC	500A/60% GEARING: Standard Speed (factory setting)	SOLID: 50-800 (1.3-20.3) CORED: 50-800 (1.3-20.3)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0)	14.5 x 8.5 x 23.5 (368 x 216 x 597)	35 (15.9)
			500A/60% GEARING: Extra Torque	SOLID: 30-400 (0.8-10.2) CORED: 30-400 (0.8-10.2)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4)		

LF-72

Wire Feed Consistency

- Two roll industrial shop wire feeder available in multiple configurations for boom or bench mounting
- Brass-to-brass gun connections for better electrical conductivity that results in better arc performance
- Calibrated wire feed speed dial ensures precise and accurate settings
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E8.11

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range: imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LF-72 Base Model (w/o gun or cable)	K2327-4	24-42V AC 50/60 Hz 9 Amps	500A/60%	50-800 (1.3-20.3)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	24 (11)
Bench Model Standard Duty	K2327-5					12.6 x 10.9 x 22.5 (320 x 277 x 574)	52 (24)
Bench Model Heavy Duty	K2327-6					15.3 x 13.0 x 27.7 (389 x 330 x 704)	69 (31)
Bench Model Heavy Duty (w/o gun)	K2327-7					15.3 x 13.0 x 27.7 (389 x 330 x 704)	63 (29)

LF-74

Four Roll Feeding for Longer Runs

- Four roll industrial shop wire feeder recommended for larger diameter wires, longer gun cables or long boom conduits
- Brass-to-brass gun connections for better electrical conductivity that results in better arc performance
- Calibrated wire feed speed dial ensures precise and accurate settings
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E8.11

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range: imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LF-74 Base Model	K2426-4	24-42V AC 50/60 Hz 9 Amps	600A/60%	50-800 (1.3-20.3)	SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	27 (12)
Bench Model Heavy Duty	K2426-5					15.3 x 13.0 x 27.7 (389 x 330 x 704)	63 (29)

LN-8

Reliable Wire Feeding in any Environment

- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-8	K297	115V AC 50/60 Hz	600A/60%	50-600 (1.3-15.2)	SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 (2.8)	10.9 x 9.8 x 9.6 (277 x 248 x 244)	36 (16.3)

LN-9

Semiautomatic Feed for Larger Wire

- LN-9 includes a digital meter that can be set to display voltage or wire feed speed
- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-9	K357-1	115V AC 50/60 Hz	600A/60%	50-600 (1.3-15.2)	SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 (2.8)	11.5 x 11.3 x 11.5 (292 x 287 x 292)	42 (19)

Flex Feed® 74 HT

High-Torque, High Performance

- Select models include contactors to electrically isolate the gouging stud
- 2-step trigger interlock enhances operator comfort for longer welds
- Feed plate can be located on either right or left side of the weld drive housing for easy integration into any work center



Processes

- MIG
- Flux-Cored
- Hand-Held SAW
- Gouging (CCAG) - with gouging option installed

Output



Input



Literature

E8.203

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Flex Feed™ 74 HT MIG Package	K3883-5	24-42V AC 50/60 Hz	600A/60% (wire drive only)	20 TOOTH ⁽¹⁾ : 50-500 (1.3-12.7)	SOLID: 0.025-3/32 [0.6-2.4] 0.025-1/16 [0.6-1.6]	13.3 x 15.5 x 23.6 (338 x 394 x 599) wire drive only	47 (21)
Advanced MIG Package	K3883-12		500A/60% (wire drive w/gouging kit)	30 TOOTH : 50-700 (1.3-19.0)	CORED: 0.035-0.120 [0.9-3.0] 0.035-5/64 [0.9-2.0]	25.2 x 15.5 x 27.9 (640 x 394 x 709)	55 (25)
Structural Steel Package	K3883-13		600A/30% (gouging stud)				63 (29)
Heavy Fab One-Pak® Pkg.	K3883-15						75 (34)

⁽¹⁾Installed from factory

NOTE: Other Bench Configurations available. See Literature.

Flex Feed® 84

An industrial wire feeder for high-productivity, heavy fab applications

- Designed especially for consistent feeding over long conduit runs and large diameters wires
- Power Path™ electrical isolation on models with stud for gouging operations
- Advanced MaxTrac® cast aluminum wire drive system features patented tool-less drive roll and split wire guide design
- Configure for single, dual, bench or boom setups as your workspace changes



Processes

- GMAW
- FCAW
- SAW
- CAG (Carbon Arc Gouging available with gouging option installed)

Output



Input



Literature

E8.204.1

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range: in (mm)		H x W x D in (mm)	Net Wt. lb (kg)
					Solid	Cored		
FlexFeed® 84 Single Head	K5000-2	24-42V AC 50/60 Hz 10 amps	Wire Drive: 600A/60%	Standard Speed / Installed 20 Pinion Gear ⁽¹⁾ : 35-500 [0.9-12.7]	0.025-3/32 [0.6-2.4]	0.035-0.120 [0.9-3.0]	16.5 x 15.5 x 28 (419 x 394 x 711)	56 (25.4)
			Wire Drive with Contactors or Gouging: 500A/60%	Standard Speed / 30 Pinion Gear: 50-750 [1.3-19.0]	0.025-1/16 [0.6-1.6]	0.035-5/64 [0.9-2.0]		
			Gouging Stud: 600A/30%	High Speed / Installed 20 Pinion Gear: 50-750 [1.3-19.0]	0.025-1/16 [0.6-1.6]	0.035-5/64 [0.9-2.0]		
			Wire Drive w/Contactors: 500A/60%	High Speed / Installed 20 Pinion Gear: 50-1200 [1.3-30.4]	0.025-0.045 [0.6-1.1]	0.035-1/16 [0.9-1.6]		

⁽¹⁾Installed from factory. NOTE: Other Bench and Boom configurations available. See literature.

Flex Feed® 84 Dual

An industrial wire feeder for high-productivity, heavy fab applications

- Designed especially for consistent feeding over long conduit runs and large diameter wires
- Dual models include Power Path™ electrical isolation on the non-active drive and gun for added safety
- Advanced MaxTrac® cast aluminum wire drive system features patented tool-less drive roll and split wire guide design
- Configure for single, dual, bench or boom setups as your workspace changes



Processes

- GMAW
- FCAW
- SAW
- CAG (Carbon Arc Gouging available with gouging option installed)

Output



Input



Literature

E8.204.1

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range: in (mm)		H x W x D in (mm)	Net Wt. lb (kg)
Flex Feed® 84 Dual	K5002-2	24-42V AC 50/60 Hz 10 amps	Wire Drive: 600A/60%	Standard Speed / Installed 20 Pinion Gear ⁽¹⁾ : 35-500 (0.9-12.7)	0.025-3/32 (0.6-2.4)	0.035-0.120 (0.9-3.0)	16.5 x 22.5 x 30.6 (419 x 572 x 777)	101 (45.8)
			Wire Drive with Contactors or Gouging: 500A/60%	Standard Speed / 30 Pinion Gear: 50-750 (1.3-19.0)	0.025-1/16 (0.6-1.6)	0.035-5/64 (0.9-2.0)		
			Gouging Stud: 600A/30%	High Speed / Installed 20 Pinion Gear: 50-750 (1.3-19.0)	0.025-1/16 (0.6-1.6)	0.035-5/64 (0.9-2.0)		
			Wire Drive w/Contactors: 500A/60%	High Speed / Installed 20 Pinion Gear: 50-1200 (1.3-30.4)	0.025-0.045 (0.6-1.1)	0.035-1/16 (0.9-1.6)		

⁽¹⁾Installed from factory.

NOTE: Other Bench and Boom configurations available. See literature.

Power Feed® 84

Advanced Multi-Process Digital Control

- Includes eight user memories for complete WPS recall and a USB port to transfer memory data
- Feed plate (Power Feed® 84) can be located on either right or left side of the wire drive housing for easy integration into any work environment
- Advanced interface includes Auto-Settings to simplify process set up
- ArcLink® digital communications protocol enables fast, advanced communication with any ArcLink®-enabled welding power source



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging (CCAG)

Output



Input



Literature

E8.268

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Power Feed® 84 Single Bench Model	K3328-13	40V DC	600A/60% (wire drive only) 500A/60% (wire drive w/gouging kit) 600A/30% (gouging stud)	20 TOOTH ⁽¹⁾ : 50-750 (1.3-19.0) 30 TOOTH : 50-1200 (1.3-30.4)	SOLID ⁽²⁾ : 0.025-3/32 (0.6-2.4) CORED ⁽²⁾ : 0.035-0.120 (0.9-3.0)	25.2 x 15.5 x 27.9 (640 x 394 x 709) single wire drive only	62 (28.1)

⁽¹⁾Installed from factory. ⁽²⁾Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear.
NOTE: Other Bench and Boom Configurations available. See Literature.

Power Feed® 84 Dual

Advanced Multi-Process Digital Control

- Includes 16 user memories for complete WPS recall and a USB port to transfer memory data
- Feed plate (Power Feed® 84) can be located on either right or left side of the wire drive housing for easy integration into any work environment
- Advanced interface includes Auto-Settings to simplify process set up
- ArcLink® digital communications protocol enables fast, advanced communication with any ArcLink®-enabled welding power source



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging (CCAG)

Output



Input



Literature

E8.268

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range : imp (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Power Feed® 84 Dual Bench Model	K3330-5	40V DC	600A/60% (w/o PowerPath™ contactors) 500A/60% (wire drive w/gouging kit)	20 TOOTH ⁽¹⁾ : 50-750 (1.3-19.0) 30 TOOTH : 50-1200 (1.3-30.4)	SOLID ⁽²⁾ : 0.025-3/32 (0.6-2.4) CORED ⁽²⁾ : 0.035-0.120 (0.9-3.0)	25.2 x 22.5 x 30.6 (640 x 572 x 777) dual wire drive only	119 (53.9)

⁽¹⁾Installed from factory. ⁽²⁾Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear.
NOTE: Other Bench and Boom Configurations available. See Literature.



More Control. Fewer Cables.



FLEXTEC[®] 350X and LN-25X
with CrossLinc[™] Technology.



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Activ8®

Required Accessories for all models

- Weld Power Cable
- Coaxial Weld Power Cable
- Drive Roll and Wire Guide Kit

Base Model (K2999-1)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- Gun Bushing

One-Pak® Package (K3289-1)

- Magnum® PRO Curve™ 300 Ready-Pak®

LN-23P

Required Accessories for all models

- Magnum® Self-Shielded Gun and Cable Assembly
- Adapter Kit (K350) for Terminal Strip Connection
- Adapter Kit (K350-1) for 14-pin MS-Type Connection

Base Model (K316L-1)

- Control Cable, 25 ft. (7.6 m)
- 1/0 Electrode Cable, 25 ft. (7.6 m)
- Drive Rolls and Guide Tubes, 3/32 in. (2.4 mm)

LN-25 PRO Standard

Base Model (K2613-5)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 PRO Extra Torque

Base Model (K2613-7)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 PRO Dual Power

Base Model (K2614-6)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 Pipe

Base Model (K2614-5)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-400 ipm)
- 14 lb. Innershield® coil adapter

LN-25 Ironworker®

Base Model (K2614-9)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-700 ipm)

LN-25X with CrossLinc™ Technology

Base Model (K4267-1)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-700 ipm)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Power Feed® 25M

Base Model, Aluminum Case [K2536-4]

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

Base Model, Plastic Case [K2536-5]

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

Power Feed® 25M Aluminum

Base Model [K4191-1]

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

LF-72

Required Accessories for all models

- Weld Power Cable

Base Model w/o Gun or Cable [K2327-4]

- 0.035/0.045 in. (0.9/1.1 mm) Drive Rolls & Cable

Bench Model, Standard Duty [K2327-5]

- Magnum® PRO 350 Gun & Cable, 15 ft. (4.6 m)
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Standard Duty Wire Reel Stand
- 44 lb. (20 kg) Wire Package, Max.

Bench Model, Heavy Duty (No Gun) [K2327-7]

- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

LF-72, con't.

Bench Model, Heavy Duty [K2327-6]

- Magnum® PRO 350 Gun & Cable, 15 ft. (4.6 m)
- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

LF-74

Required Accessories for all models

- Weld Power Cable

Base Model [K2426-4]

- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Rolls & Guide Kit

Bench Model, Heavy Duty [K2426-5]

- Everything listed above
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

LN-8

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LN-9

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Flex Feed™ 74 HT

Required Accessories for all models

- Drive Roll Kits
- Control Cable

MIG Package Model (K3883-5)

- Basic User Interface
- Standard Duty Reel Stand
- Control Cable

Advanced MIG Package Model (K3883-12)

- Digital User Interface
- Heavy Duty Reel Stand
- Control Cable
- Lift Bail

Structural Steel Package Model (K3883-13)

- Basic User Interface
- Heavy Duty Reel Stand
- Control Cable
- Gouge Kit
- Lift Bail

Heavy Fab One-Pak® Package (K3883-15)

- Everything listed above (K3883-13)
- Magnum® PRO Curve™ 300 Gun

Flex Feed™ 84

Required Accessories for all models

- Drive Roll Kits
- Weld Power Cable

Single Bench Model (K5000-2)

- Single Wire Drive
- Heavy Duty Wire Reel Stand
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 10 ft. (3.0 m)

Flex Feed™ 84 Dual

Required Accessories for all models

- Drive Roll Kits
- Control Cable
- Weld Power Cable

Dual Bench Model (K5002-2)

- Dual Wire Drive
- Heavy Duty Wire Reel Stand
- Contactors
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 10 ft. (3.0 m)

Power Feed™ 84

Required Accessories for all models

- Drive Roll Kits

Single Bench Model (K3328-13)

- Single Wire Drive
- Heavy Duty Wire Reel Stand
- USB
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 8 ft. (2.4 m)

Power Feed™ 84 Dual

Required Accessories for all models

- Drive Roll Kits

Dual Bench Model (K3330-5)

- Dual Wire Drive
- Heavy Duty Wire Reel Stand
- USB
- Contactors
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 8 ft. (2.4 m)

Accessories

Product Name	Product No.	Accessories										
		Base Model	LN-23P	LN-25 PRO Standard	LN-25 PRO Extra Torque	LN-25 PRO Dual Power	LN-25 Pipe	LN-25 Ironworker®	LN-25X w/ CrossLinc™ Technology	Power Feed™ 25M	Power Feed™ 25M Aluminum	
REQUIRED (see charts in Accessories Section)												
Weld Power Cables	—	•		•	•	•	•	•	•	•	•	•
Coaxial Weld Power Cables	—	•								•	•	•
Drive Roll and Wire Guide Kits	—	•		•	•	•	•	•	•	•	•	•
Control Cables and Adapters	—			•	•	•	•	•	•			
Push-Pull Guns	—									•	•	•
ArcLink®/Linc-Net™ Control Cables	—									•	•	•
350A FCAW-SS Gun, 10 ft. (3.0 m), 0.068-5/64 in. (1.7-2.0 mm)	K345-10		•									
GENERAL												
Gun Receiver Bushing	K1500-1	•		•	•	•	•	•	•	•	•	•
Gun Receiver Bushing	K1500-2	•		•	•	•	•	•	•	•	•	•
Magnum® 550 Gun Adapter	K1500-3	•		•	•	•	•	•	•	•	•	•
Miller® Gun Receiver Bushing	K1500-4	•		•	•	•	•	•	•	•	•	•
OXO® Gun Receiver Bushing	K1500-5			•	•	•	•	•	•	•	•	•
Dual Schedule Fast-Mate Adapter™ 10 Series	K489-7	•		•	•	•	•	•	•	•	•	•
Plastic Case	K3061-1	•										
Work and Wire Feeder 2/0 Weld Cable, 10 ft. (3.0 m) Package	K1803-1	•										
Twist Mate™ Cable Plug, For 2/0-3/0, 70-95 mm² cable	K852-95	•		•	•	•	•	•	•			
Tweco®-Style Adapter Plug	K2946-1	•										
Jumper Plug Kit	K484	•		•	•	•	•	•	•			
GC-300 Work Clamp	K910-1	•										
GC-500 Work Clamp	K910-2	•										
Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m)	K586-1	•								•	•	
Wire Feed Speed Meter Kit (LN-8)	K261											
Portable Digital Wire Feed Speed Meter	K283	•										
Incoming Bushing for Lincoln® Conduit, 0.025-1/16 in. (0.6-1.6 mm) wire	K1546-1											
Incoming Bushing for Lincoln® Conduit, 1/16-1/8 in. (1.6-3.2 mm) wire	K1546-2	•										
Inlet Bushing, quick connect style	K3929-1											
Flow Meter Kit	K3156-1	•										
LN-23P Adapter Kit, For Terminal Strip Connection	K350		•									
LN-23P Adapter Kit, For 14-pin Connection	K350-1		•									
Adapter for Competitive Power Sources	K2335-1			•	•	•	•	•	•			
Preflow, Postflow and Burnback Timer Kit	K2330-2			•	•	•	•	•	•			
14 lb. (6.4 kg) Innershield Coil Adapter	K435			•	•	•	•	•	•			
8 in. (203.2 mm) O.D. Spool Adapter	K468			•	•	•	•	•	•			

Accessories

Product Name	Product No.											
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		Activ8®	LN-23P	LN-25 PRO Standard	LN-25 PRO Extra Torque	LN-25 PRO Dual Power	LN-25 Pipe	LN-25 Ironworker®	LN-25X w/ CrossLinc™ Technology	Power Feed® 25M	Power Feed® 25M Aluminum	
GENERAL, CON'T.												
Replacement Case Kit - Polycarbonate	K2596-2			•	•	•	•	•	•	•	•	•
Micro Wire Straightener	K1733-4			•	•	•	•	•	•	•	•	
12-Pin to 6-Pin Adapter Cable	K2909-1									•	•	•
12-Pin to 7-Pin Adapter Cable	K2910-1									•	•	•
ArcLink® "T" Cable Connector	K2429-1									•	•	•
Remote Output Control (12-Pin), 25 ft. (7.6 m)	K857-2									•	•	•
Water Connection Kit	K590-6									•	•	•
Shielding Gas Filter	KP3103-1	•										
Shield Gas Flow Sensor	K3338-1											
Quick Connect Conduit Inlet Bushing	K3929-1											
Push-Pull Gun Adapter Kit	K2339-1									•	•	•
TIG												
PTA-17 Pro-Torch™ TIG Torch, 12.5 ft. (3.8 m), 2 pc	K1782-2									•	•	•
PTA-17 Pro-Torch™ TIG Torch, 25 ft. (7.6 m), 2pc	K1782-4									•	•	•
PTA-26 Pro-Torch™ TIG Torch, 12.5 ft. (3.8 m), 2pc	K1783-2									•	•	•
PTA-26 Pro-Torch™ TIG Torch, 25 ft. (7.6 m), 2pc	K1783-4									•	•	•
Foot Amptrol®, 12-Pin	K870-2									•	•	•
Hand Amptrol®, 12-Pin	K963-4									•	•	•
POWER SOURCES												
CV400, Invertec® STT® II, Multi-Process welders (CC/CV), Engine Driven Welders	—	•										
MIG Welders (CV), Multi-Process Welders (CC/CV), Engine Driven Welders	—		•									
Power Wave® S350, S350 Aluminum, S500, 455M, 455M/STT®, R350, R500, 655R, AlumaFab®	—									•	•	•
2-YEAR EXTENDED WARRANTY												
Activ8™	—	•										
LN-23P	—		•									
LN-25 PRO Standard	—			•								
LN-25 PRO Extra Torque	—				•							
LN-25 PRO Dual Power	—					•						
LN-25 Pipe	—						•					
LN-25 Ironworker®	—							•				
LN-25X	—								•			
Power Feed® 25M	—									•	•	
Power Feed® 25M Aluminum	—											•

Accessories

Product Name	Product No.	LF-72 Wire Feeder		LF-74 Wire Feeder		LN-8 Wire Feeder		LN-9 Wire Feeder		Flex Feed™ 74 HT		Flex Feed™ 84		Flex Feed™ 84 Dual		Power Feed™ 84		Power Feed™ 84 Dual		
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2327-4	K2327-5	K2327-6	K2327-7	K2426-6	K2426-7	K297	K357-1	K3883-5	K3883-12	K3883-13	K3883-15	K5000-2	K5002-2	K3328-13	K3330-5			
REQUIRED (see charts in Accessories Section)																				
Weld Power Cables	—	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Coaxial Weld Power Cables	—																	•	•	
Drive Roll and Wire Guide Kits	—	•	•	•	•	•	•												•	•
Drive Roll and Guide Tube Kits	—							•	•	•	•	•	•	•	•					
Control Cables and Adapters	—	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
GENERAL																				
Gun Receiver Bushing	K1500-1	•	•	•	•	•	•													
Gun Receiver Bushing	K1500-2	•	•	•	•	•	•													
Magnum® 550 Gun Adapter	K1500-3	•	•	•	•	•	•													
Miller® Gun Receiver Bushing	K1500-4	•	•	•	•	•	•													
OXO® Gun Receiver Bushing	K1500-5	•	•	•	•	•	•													
Dual Schedule Fast-Mate Adapter™ 10 Series	K489-7	•	•	•	•	•	•													
Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m)	K586-1	•	•	•	•	•	•													
Wire Feed Speed Meter Kit (LN-8)	K261							•	•											
Portable Digital Wire Feed Speed Meter	K283							•	•	•	•	•	•	•	•	•	•	•	•	•
Incoming Bushing for Lincoln® Conduit, 0.025-1/16 in. (0.6-1.6 mm) wire	K1546-1	•	•	•	•	•	•			•	•	•	•	•	•	•	•	•	•	•
Incoming Bushing for Lincoln® Conduit, 1/16-1/8 in. (1.6-3.2 mm) wire	K1546-2	•	•	•	•	•	•			•	•	•	•	•	•	•	•	•	•	•
Inlet Bushing, quick connect style	K3929-1									•	•	•	•							
Incoming Ball Bearing Bushing for Lincoln® Conduit	K1551-2													•	•					
Adapter for Competitive Power Sources	K2335-1	•	•	•	•	•	•													
Adapter for Competitive Power Sources	K2335-2													•	•					
Burnback Kit	K202							•	•											
Postflow and Burnback Timer Kit	K2330-1	•	•	•	•	•	•													
Preflow, Postflow and Burnback Timer Kit	K2330-2																			
14 lb. (6.4 kg) Innershield Coil Adapter	K435		•	•	•	•	•	•	•											
8 in. (203.2 mm) O.D. Spool Adapter	K468		•	•	•	•	•	•	•											
Remote Voltage Control Kit	K2329-1	•	•	•	•	•	•													
Spindle Kit, 2 Inch (50.8 mm) Hub	K162-1	•	•	•	•	•	•													
Harris® Argon/CO2 Flowmeter Regulator & Hose Kit, 10 ft. (3.0 m)	3100211	•	•	•	•	•	•													
Adapter Cable, Male 14-pin Control Cable to Terminal Strip	K1798	•	•	•	•	•	•													

Accessories

Product Name	Product No.	LF-72 Wire Feeder				LF-74 Wire Feeder		LN-8 Wire Feeder	LN-9 Wire Feeder	Flex Feed® 74 HT			Flex Feed® 84	Flex Feed® 84 Dual	Power Feed® 84	Power Feed® 84 Dual	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2327-4	K2327-5	K2327-6	K2327-7	K2426-6	K2426-7	K297	K357-1	K3883-5	K3883-12	K3883-13	K3883-15	K5000-2	K5002-2	K3328-13	K3330-5
GENERAL, CON'T.																	
42 Volt Transformer Kit	K1520-1	•	•	•	•	•	•			•	•	•	•	•	•		
Standard Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max.	K2328-1	•				•								•	•		
Standard Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max.	K3342-1									•	•	•	•	•	•	•	•
Heavy Duty Wire Reel Stand, 60 lbs. (27.2 kg) spools, max.	K1524-3	•				•		•	•								
Heavy Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max. & up to 60 lbs. (27.2 kg) coils. (includes K3341-1 Lift Bail)	K3343-1									•	•	•	•	•	•	•	•
Undercarriage	K163-1		•	•	•		•					•	•			•	•
Cart Bracket (for K3059-2 or K3059-3 carts)	K4068-1													•	•		
Bench to Boom Conversion Kit	K5004-2													•	•		
Plastic Wire Cover, 30-40 lbs. (13.6-18.1 kg)	K1634-1		•	•	•		•	•	•								
Plastic Wire Cover, up to 60 lbs. (27.2 kg)	K1634-2			•	•		•	•	•								
Spool Cover, 30-40 lbs. (13.6-18.1 kg) spools	K1634-4									•	•	•	•	•	•	•	•
Spool Cover, 50-60 lbs. (22.7-27.2 kg) coils	K3340-1									•	•	•	•	•	•	•	•
Insulated Lift Bail, 60 lbs. (27.2 kg) spools, max.	K1555-1			•	•		•	•	•								
Lift Bail	K3341-1									•	•	•	•	•	•	•	•
Light Duty Caster Kit	K1556-1			•	•		•	•	•								
Swivel Platform	K1557-1			•	•		•	•	•								
22-30 lb. (10-13.6 kg) Readi-Reel® Adapter	K363P							•	•								
50-60 lb. (22.7-27.2 kg) Coil Adapter, 2 in. (50.8 mm) spindle	K1504-1			•	•		•	•	•	•	•	•	•	•	•		
Gas Solenoid Kit (for codes above 9131)	K425							•	•								
Wire Reel and Flux Tank Assembly	K305							•	•								
Mechanized Hand Travel Unit	K110							•	•								
Squirtmobile® Power Pack, 50 ft. (15.2 m)	K161-50							•	•								
Wire Straightener	K1733-1									•	•	•	•	•	•	•	•
Water Connection Kit	K590-6									•	•	•	•	•	•	•	•
Shielding Gas Filter	KP3103-1									•	•	•	•	•	•	•	•
Shield Gas Flow Sensor	K3338-1															•	•
Quick Connect Conduit Inlet Bushing	K3929-1															•	•

Accessories

Product Name	Product No.	LF-72 Wire Feeder				LF-74 Wire Feeder		LN-8 Wire Feeder	LN-9 Wire Feeder	Flex Feed® 74 HT				Flex Feed® 84	Flex Feed® 84 Dual	Power Feed® 84	Power Feed® 84 Dual
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K2327-4	K2327-5	K2327-6	K2327-7	K2426-6	K2426-7	K297	K357-1	K3883-5	K3883-12	K3883-13	K3883-15	K5000-2	K5002-2	K3328-13	K3330-5
POWER SOURCES																	
MIG Welders [CV], Multi-Process Welders [CC/CV]	—	•	•	•	•	•	•										
Multi-Process Welders [CC/CV] (excludes Invertec® V350 PRO and Flextec™ 450)	—							•	•								
Multi-Process Welders [CC/CV]	—									•	•	•	•				
Power Wave® models	—															•	•
2-YEAR EXTENDED WARRANTY																	
LF-72 Wire Feeder	—	•	•	•	•												
LF-74 Wire Feeder	—					•	•										
LN-8 Wire Feeder	—							•									
LN-9 Wire Feeder	—								•								
Flex Feed® 74 HT	—									•	•	•	•				
Flex Feed® 84	—													•			
Flex Feed® 84 Dual	—														•		
Power Feed® 84	—															•	
Power Feed® 84 Dual	—																•

SUBMERGED ARC and AUTOMATIC EQUIPMENT

WIRE FEEDER MODEL	OUTPUT				PROCESS			INPUT	FEATURES									
	Power Source Required	Wire Feed Speed Range ipm (m/min)	Solid Wire Size Range: in (mm)	Cored Wire Size Range: in (mm)	MIG	Flux-Cored	Submerged Arc		Power	2-Roll Drive	4-Roll Drive	Digital Display						
SEMI-AUTOMATIC WIRE FEEDERS																		
LN-8 and LN-9	DC600	50-800 (1.3-20.3)	0.040-3/32 (1.0-2.4)	0.045-.120 (1.1-3.0)		●	●	115VAC										
MECHANIZED WIRE FEEDERS																		
LT-7 Tractor	DC600, DC1000	100-400 (2.5-10.2)	3/32-3/16 (2.4-4.8)	3/32-3/16 (2.4-4.8)			●	115VAC										
Cruiser™ and Tandem Cruiser™	Power Wave® AC/DC 1000® SD	15-500 (0.4-12.5)	1/16-7/32 (1.6-5.6)	—			●	40VAC	•	•	•							
AUTOMATIC WIRE FEEDERS																		
NA-3 Control and Heads	DC600, DC1000, DC1500	25-600 (0.6-15.2)	0.035-7/32 (0.9-5.6)	0.045-5/32 (1.1-4.0)	●	●	●	115VAC										
NA-4 Control and Heads	AC1200	subject to arc voltage used	1/16-7/32 (1.6-5.6)	—			●	115VAC										
NA-5 Control and Heads	DC600, DC1000, DC1500	25-775 (0.6-19.7)	0.035-7/32 (0.9-5.6)	0.045-5/32 (1.1-4.0)	●	●	●	115VAC			•							
MAXsa® 10 Controller and MAXsa® 22 Feed Head	Power Wave® AC/DC 1000® SD	10-500 (0.25-12.7)	1/16-7/32 (1.6-5.6)	—			●	40VAC	•	•	•							
MAXsa® 19 Controller and MAXsa® 29 Feed Head	Power Wave® AC/DC 1000® SD	10-500 (0.25-12.7)	1/16-7/32 (1.6-5.6)	—			●	40VAC	•	•	•							
WELDER MODEL	OUTPUT			PROCESS						INPUT		FEATURES						
	Mode	Polarity	Current Range (Amps)	Stick	TIG	MIG	Pulsed	Flux-Cored	Submerged Arc	Arc Gouge	Phase	Hertz	Waveform Control Technology®	ArkLink® Digital Communication	Production Monitoring	Stackable	7-yr. Warranty (on Power Rectifier)	
ANALOG																		
Idealarc® DC600	CC/CV	DC	70-680	●	◐	◐		●	●	●	3	60					•	•
Idealarc® DC1000	CC/CV	DC	150-1300					●	●	●	3	60					•	•
Idealarc® DC1500	CC/CV	DC	200-1500					●	●	●	3	60						•
Idealarc® AC1200	CC/CV	AC	200-1500					●			1	60						•
DIGITAL																		
Power Wave® AC/DC 1000® SD	CC/CV	AC/DC	100-1000						●		3	50/60	•	•	•			

KEY: ● Excellent ◐ Good ○ Optional

LN-8

Reliable Wire Feed in any Environment

- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm [m/min]	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-8 Wire Feeder Base Model	K297	115V AC 50/60 HZ	600A/60%	NA	50-600 (1.3-15.2)	SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 [2.8]	10.9 x 9.8 x 9.6 (277 x 248 x 244)	36 (16.2)

LN-9

Semiautomatic Feed for Larger Wire

- Standard digital meter can be set for volts, inches per minute or meters per minute
- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm [m/min]	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LN-9 Wire Feeder Base Model	K357-1	115V AC 50/60 HZ	600A/60%	NA	50-600 (1.3-15.2)	SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 [2.8]	11.5 x 11.3 x 11.5 (292 x 287 x 292)	42 (19)

LT-7 Tractor

Track Greater Submerged Arc Productivity

- Calibrated tractor drive travels 6 to 70 ipm (12.7-127.0 m/min)
- Vertical head lift adjuster for adjusting electrical stick-out from 1/2 to 5 inches
- Control box can be mounted on either left or right, eliminating the need to return to the power source for routine procedure changes
- Welds horizontal fillets, lap and butt joints to the left or right side of the tractor frame for convenience



Processes

- Submerged Arc

Output



Input



Literature

E9.70

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
LT-7 Tractor Base Model	K227-1	115V AC 50/60 Hz	600A/100% 1100A/100% (w/water cooling)	NA	100-400 (2.5-10.2)	SOLID: 3/32-3/16 (2.4-4.8)	27.5 x 33 x 14 (698 x 838 x 356)	120 (54)
Track Model	K395-1							130 (59)

Cruiser™ Tractor

Rigid, Configurable and Quick

- For butt and fillet joints on plate welding common in bridge or barge decking, tank fabrication or shipbuilding
- Set up with or without a track and three or four wheel operation
- Strong, rigid and stiff where you need it most – frame, mast, clamps, wheels and outriggers
- Deposition rates up to 30 lbs (13.6 kg) per hour



Processes

- Submerged Arc

Output



Input



Literature

E9.170

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Cruiser™ Tractor ⁽¹⁾ Base Model	K3048-2	40V DC	1000A/100%	142:1	15-200 (0.4-5.0)	SOLID: 3/32-7/32 (2.4-5.6)	29 x 23 x 36 (736 x 584 x 914)	207 (94)
				95:1 ⁽²⁾	15-300 (0.4-7.6)	1/16-1/8 (1.6-3.2)		
				57:1 ⁽²⁾	50-500 (1.3-12.7)	1/16-3/32 (1.6-2.4)		

⁽¹⁾Travel Speed, in/min. (m/min) : 10-100 (0.25-2.5) ⁽²⁾Optional Gearing

Tandem Cruiser™ Tractor

Double the Deposition

- Deposition rates up to 30 lbs (13.6 kg) per hour per arc for greater productivity on thick materials
- For butt and fillet joints on plate welding common in bridge or barge decking, tank fabrication or shipbuilding
- Set up with or without a track and three or four wheel operation
- Strong, rigid and stiff where you need it most – frame, mast, clamps, wheels and outriggers



Processes

- Submerged Arc

Output



Input



Literature

E9.170

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
Cruiser™ Tractor ⁽¹⁾ Tandem Model	K3083-1	40V DC	1000A/100%	142:1	15-200 (0.4-5.0)	SOLID: 3/32-7/32 (2.4-5.6)	36.5 x 45.5 x 41.5 (927 x 1156 x 1054)	300 (136)
				95:1 ⁽²⁾	15-300 (0.4-7.6)	1/16-1/8 (1.6-3.2)		
				57:1 ⁽²⁾	50-500 (1.3-12.7)	1/16-3/32 (1.6-2.4)		

⁽¹⁾Travel Speed, in/min. (m/min) : 10-100 (0.25-2.5) ⁽²⁾Optional Gearing

NA-3S Controller

DC Submerged Arc Control

- Delivers arc sensing or constant wire feed speed control with hot or cold starting for use with either constant current or constant voltage DC power sources
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
NA-3S Controller	K210-2	NA	NA	NA	25-650 (0.6-16.5)	SOLID: 0.035-7/32 (0.9-5.6)	NA	NA

NA-4 Controller

Battle Arc Blow with AC Multiple Arc Welding

- Delivers arc sensing control with hot or cold starting for use with constant current AC power sources for submerged arc welding, including AC-AC tandem arc and AC-AC-AC triple arc systems and single electrode submerged arc when arc blow limits the DC welding current and travel speeds
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
NA-4 Controller	K388-2	NA	NA	NA	25-650 (0.6-16.5) ⁽¹⁾	SOLID: 0.035-7/32 (0.9-5.6)	NA	NA

⁽¹⁾Subject to arc voltage used

NA-3S/NA-4 and NA-3SF/NA-4F Feed Heads

Deposit More. Travel Faster.

- Handles wide range of wire diameters and produces a wide wire feed speed range
- Proven, rugged construction minimizes downtime and maintenance costs



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
NA-3S/NA-4 Head	K208A	NA	NA	NA	15-290 (0.4-7.4) ⁽¹⁾	SOLID: 3/32-7/32 (2.4-5.6)	NA	NA
NA-3SF/NA-4F Head	K209A					SOLID: 0.035-3/32 (0.9-2.4)		
NA-3S/NA-4 Head	K208B				22-425 (0.6-10.8) ⁽¹⁾	SOLID: 0.035-3/32 (0.9-2.4)		
NA-3SF/NA-4F Head	K209B							

⁽¹⁾Subject to arc voltage used

NA-5 Controller

Precise Mechanized Automation Control

- Digital display monitors preset or actual wire feed speed and voltage
- Includes timer controls for burnback, wire react time and weld cycle stop
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.30

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
NA-5 Controller	K356-2	NA	NA	NA	25-775 [0.6-19.7]	SOLID: 0.035-7/32 [0.9-5.6]	NA	NA

NA-5S and NA-5SF Feed Head

Superior Mechanized Submerged Arc Wire Feeding

- Choose with or without control box, wire reel, brake and flux hopper
- Handles wide range of wire diameters and produces a wide wire feed speed range
- Proven, rugged construction minimizes downtime and maintenance costs



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.30

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
NA-5S Head	K346A	NA	NA	NA	15-290 [0.4-7.4]	SOLID: 3/32-7/32 [2.4-5.6]	NA	NA
NA-5SF Head	K347A					SOLID: 1/16-3/32 [1.6-2.4]		
NA-5S Head	K346B				22-425 [0.6-10.8]	SOLID: 1/16-3/32 [1.6-2.4]		
NA-5SF Head	K347B							

MAXsa® 10 Controller

Severe Duty. Digital Ready.

- Waveform Control Technology® enables the user to choose from a library of pre-programmed modes
- Eight procedure memories enable the user to pre-set and save optimal welding parameters
- Hand-held pendant allows operation from 4-100 ft (1.2-30.5 m) with an ArcLink® extension cable
- IP23 rated for operation in harsh environments
- Easy PLC interfacing to control fixture travel, timers and other system commands



Processes
• Submerged Arc

Output



Input



Literature
E9.181

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
MAXsa® 10 Controller	K2814-3	40V DC	NA	NA	NA	NA	15 x 13 x 4 (381 x 259 x 102)	25 (11.3)

MAXsa® 22 Feed Head

Drive Large Diameter Submerged Arc Wires

- Rotational feed head adjustment in two planes allows flexible, accurate setup for fixturing or arc locating. Optional horizontal and vertical lift adjuster enables additional positioning flexibility
- Can be used in single, tandem, Twinarc® or multiple arc applications
- IP23 rated for harsh environments



Processes
• Submerged Arc

Output



Input



Literature
E9.181

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
MAXsa® 22 Feed Head (includes Flux Hopper)	K2370-2	40V DC	1000A/100%	142:1 ⁽⁰⁾	15-200 (0.4-5.0)	SOLID: 3/32-7/32 (2.4-5.6)	12 x 14 x 10 (305 x 355 x 254)	80 (36.3)
				95:1	15-300 (0.4-7.6)	1/16-1/8 (1.6-3.2)		
				57:1	50-500 (1.3-12.7)	1/16-3/32 (1.6-2.4)		

⁽⁰⁾142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-3, K2312-3, or K2311-1)

MAXsa® 19 Controller

Integrator-Ready Submerged Arc Control

- Specifically designed to relay wire feed commands to the MAXsa® 29 feed head when a customer-supplied user interface is used in integrator-driven applications
- I/O connector block for start/stop, forward/reverse feed and shutdown input interfacing with external accessories
- Status indicator aids diagnostic system troubleshooting
- IP23 rated to withstand harsh environments



Processes

- Submerged Arc

Output



Input



Literature

E9.181

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
MAXsa® 19 Controller	K2626-4	40V DC	NA	NA	NA	NA	9 x 10.5 x 3 (229 x 267 x 76)	7 (3.2)

MAXsa® 29 Feed Head

Ready for Integrator and Robotic Automation

- Intended for integrator and robotic submerged arc applications using the Power Wave® AC/DC 1000® SD power source.
- Closed loop speed control enables full control over starting, running and stopping wire feed speed
- Multi-axis rotational feed head adjustment in one plane allows flexible, accurate setup for fixturing
- IP23 rated to withstand harsh environments
- For use in single, tandem, Twinarc® or multiple arc applications



Processes

- Submerged Arc

Output



Input



Literature

E9.181

Product Name	Product Number	Input Power: Voltage	Rated Output: Current/Duty Cycle	Gearing	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D in (mm)	Net Wt. lb (kg)
MAXsa® 29 Feed Head	K2312-2	40V DC	1000A/100%	142:1 ⁽¹⁾	15-200 (0.4-5.0)	SOLID: 3/32-7/32 (2.4-5.6)	13 x 16 x 10 (330 x 406 x 254)	35 (15.9)
				95:1	15-300 (0.4-7.6)	1/16-1/8 (1.6-3.2)		
				57:1	50-500 (1.3-12.7)	1/16-3/32 (1.6-2.4)		

⁽¹⁾142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-3, K2312-3, or K2311-1)

Idealarc® DC600

Idealarc® with Submerged Arc Capacity

- Full range output voltage control provides easy operation and precise control
- Voltage Reduction Device™ (VRD®) reduces open circuit voltage for an additional level of safety (specify VRD® model)
- Circuitry protected against moisture and corrosive environments
- Seven-year warranty on power rectifier



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® DC600 ⁽¹⁾ Base Models	K1288-22	230/460/575/3/60	600A/44V/100%	108/54/43.2A	CV: 70-850A 13-44V CC: 90-850A 24-42V	30.7 x 22.2 x 38 (781 x 565 x 965)	522 (237)
	K1288-17	230/460/3/60	680A/44V/60%	108/54A			
w/Multi-Process Switch	K1288-18						

⁽¹⁾50 Hertz models also available

Idealarc® DC1000

Rugged Constructon. Simple Controls.

- Full range output control provides easy operation and precise arc control
- Terminal strip and output studs accommodate remote connections and cable
- Low profile case allows installation of a workbench and for stacking up to two machines to conserve floor space
- Internal components are coated to protect against moisture and corrosion; removable side panels allow easy access to internal parts
- Seven-year warranty on power rectifier



Processes

- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.50

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® DC1000 ⁽¹⁾ Base Models	K1386-3	230/460/3/60	1000A/44V/100%	193/96.5A	16-46V 150-1300A	30.7 x 22.5 x 39 (781 x 572 x 991)	821 (372)
	K1386-4	575/3/60		77.2A			

⁽¹⁾50 Hertz models also available

Idealarc® DC1500

Plenty of Power for Mechanized Automation

- Mode switch selects the desired output characteristics for the process being used
- Internal components protected against moisture and corrosive environments
- Terminal strip and output studs allow for remote connections and cable
- Produces outstanding arc characteristics on both constant voltage and constant current processes
- Seven-year warranty on power rectifier



Processes

- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.60

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® DC1500 ⁽¹⁾ Base Model	K1275	460/3/60	1500A/44V/100% 1500A/60V/100%	184A	200-1500A 20-60V	57.2 x 22.3 x 38 (1453 x 566 x 965)	1420 (644)

⁽¹⁾50 Hertz models also available

Idealarc® AC1200

AC Large Wire Diameter Welding

- Controls adjust output settings while welding or at idle
- Internal components protected against moisture and corrosive environments
- Includes Scott® connection taps for two AC welding heads operating in tandem
- Specifically designed for submerged arc welding with the NA-4 wire feeder and control on AC-AC tandem arc and AC-AC-AC triple arc systems and single electrode submerged arc when arc blow limits the DC welding current and travel speeds
- Three output studs with overlapping ranges
- Seven-year warranty on power rectifier



Processes

- Submerged Arc

Output



Input



Literature

E5.70

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Idealarc® AC1200	K3140-2	380/415/440/460 ⁽¹⁾ /1/50/60	1200A/44V/100%	230/201/190/182A	50/60 HZ: 240-1500A 30-44V 60 HZ: 200-1500A 28-44V	62.2 x 22 x 38 (1580 x 559 x 965)	1636 (742)

Power Wave® AC/DC 1000® SD

Speed. Quality. Efficiency.

- Software-based controls allow for upgrading options as new features become available
- Eliminate downtime. Easy polarity switching requires no hardware reconfiguration
- 3-phase voltage input eliminates the imbalance associated with transformer-based AC welding machines



Processes

- DC+ Submerged Arc
- DC- Submerged Arc
- Balanced AC Submerged Arc
- Variable AC Submerged Arc

Output



Input



Literature

E9.181

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® AC/DC 1000® SD ⁽¹⁾	K2803-1	380/400/460/500/ 575/3/50/60	1000A/44V/100%	82/79/69/62/55A	100-1000A	49.2 x 19.2 x 46.2 (1250 x 488 x 1174)	800 (363)

⁽¹⁾Filter is required to meet CE conducted emission requirements. The K2444-3 must be used with the K2803-2

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

LN-8

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LN-9

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LT-7 Tractor

Required Accessories for all models

- Nozzle Assembly
- Weld Power Cable

Base Model (K227-1)

- Control Cable, 25 ft. (7.6 m)

Cruiser™ and Tandem Cruiser™ Tractor

Required Accessories for all models

- ArcLink® Control Cable
- Track Section

Base Model (K3048-2, K3083-1)

- Conduit Tubing, 5 ft. (1.5 m)
- 5/32 in. (4.0 mm), 600 Amp Contact Nozzle Assembly;
5/32 in. (4.0 mm) Contact Tip
- Nozzle Extension, 5 in. (127 mm)
- Curved Nozzle Extension, 45°
- Nozzle Extension Insulator
- Flux Tubing and Hose Clamps
- Wire Reel Assembly
- Wheels for Track Operation
- Front and Rear Outriggers
- Enclosed Wire Reel (2 for Tandem)
(NOTE: Does not include a Control Cable)
- Wire Straightener (2 for Tandem)

NA-3 and NA-4 Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

NA-5 Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

MAXsa® Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

Accessories

Product Name	Product No.	LN-8 Wire Feeder		LN-9 Wire Feeder		LT-7 Tractor		Cruiser™ Tractor		Tandem Cruiser™ Tractor		NA-3 Controls & Heads		NA-4 Controls & Heads		NA-5 Controls & Heads		MAXsa® Controllers and Feed Heads		Idealarc® DC600		Idealarc® DC1000		Idealarc® DC1500		Idealarc® AC1200		Power Wave® AC/DC 1000® SD			
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model		
GENERAL																															
Submerged Arc Gun and Cable Assemblies [®]	—	•	•																												
Drive Roll and Guide Tube Kits [®]	—	•	•							•	•	•																			
Control Cables and Adapters [®]	—	•	•	•	•					•	•	•																	•		
Weld Power Cables [®]	—	•	•	•	•					•	•	•																			
Contact Nozzle Assembly for 3/32, 1/8 and 5/32 in. (2.4, 3.2 and 4.0 mm) Wire	K231-1			•	•					•	•	•																			
Positive Contact Nozzle Assembly for 3/32-1/8 in. (2.4-3.2 mm) Wire	K148A			•	•					•	•	•																			
Positive Contact Nozzle Assembly for 5/32-3/16 in. (4.0-4.8 mm) Wire	K148B			•	•					•	•	•																			
Wire Reel and Flux Tank Assembly	K305	•	•																												
Heavy Duty Process Sense Lead, 50 ft. (15.2 m)	K1811-50																													•	
Heavy Duty Process Sense Lead, 100 ft. (30.5 m)	K1811-100																													•	
Robotic Cable Adapter, 14-Pin to 22-Pin, 18 in. (457 mm)	K1805																													•	
Heavy Duty Wire Reel Stand	K1524-3	•	•																												
Insulated Lift Bail	K1555-1	•	•																												
Light Duty Caster Kit	K1556-1	•	•																												
Swivel Platform	K1557-1	•	•																												
50-60 lb. (22.4-27.2 kg) Coil Adapter, 2 in. (50.8 mm) spindle	K1504-1	•	•				•	•																							
Plastic Wire Cover - up to 60 lbs. (27.2 kg)	K1634-2	•	•																												
Wire Feed Speed Meter Kit (LN-8)	K261	•	•																												
Burnback Kit	K202	•	•																												
Undercarriage	K163-1	•	•																												
Mechanized Hand Travel Unit	K110	•	•																												
Squirtmobile® Power Pack, 50 ft. (15.2 m)	K161-50	•	•																												
Portable Digital Wire Feed Speed Meter	K283	•	•																												
LT-7 Drive Roll 052-1/16 (2 required)	KP2268-1			•	•																										
LT-7 Drive Roll 068-3/32 (2 required)	KP2268-2			•	•																										
LT-7 Drive Roll 3/32-3/16 (2 required)	KP2268-3			•	•																										
LT-7 Drive Roll 045-052 (2 required)	KP2268-4			•	•																										
Drive Roll Center 5/64-3/32 Tiny Twin	KP1890-1			•	•																										
Drive Roll Side 5/64-3/32 Tiny Twin	KP1890-2			•	•																										
Guide Tube Assembly 068-3/16 Incoming	KP1984-1			•	•																										
Guide Tube 3/32-3/16 Outgoing	KP1985-1			•	•																										
Guide Tube Outgoing Tiny Twinarc®	KP1986-1			•	•																										
Guide Tube Incoming Tiny Twin Tractor	KP2127-1			•	•					•	•																				

Accessories

Product Name	Product No.																			
		LN-8 Wire Feeder	LN-9 Wire Feeder	LT-7 Tractor	Cruiser™ Tractor	Tandem Cruiser™ Tractor	NA-3 Controls & Heads	NA-4 Controls & Heads	NA-5 Controls & Heads	MAXsa® Controllers and Feed Heads	Idealarc® DC600	Idealarc® DC1000	Idealarc® DC1500	Idealarc® DC1200	Power Wave® AC/DC 1000® SD					
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model					
		K297	K357-1	K227-1	K395-1	K3048-2	K3083-1	Various model #s	Various model #s	Various model #s	Various model #s	K1288-22	K1288-17	K1288-18	K1386-3	K1386-4	K1275	K3140-2	K2803-1	
GENERAL, CON'T.																				
Control to Head Cable Extension, 26 ft. (7.9 m)	K335-26																			
Control to Head Cable Extension, 46 ft. (14.0 m)	K338-46																			
Nozzle Extension for 5/32 in. (4.0 mm) Wire	K149-5/32			●	●				●	●	●	●								
Nozzle Extension, 5 in. (127 mm)	KP2721-1																			
Nozzle Extension, 45°	KP2721-2					●	●													
Horizontal Fillet and Lap Adapter Kit	K232			●	●															
Flat Fillet Adapter Kit	K229			●	●															
Butt Seam Guide Kit	K230			●	●															
Track Section, 70 in. (1.8 m)	K396			●	●	●	●													
Concentric Flux Cone Assembly	K285			●	●				●	●	●	●								
Tube and Clamp Kit	K3090-1					●	●													
Cross Slide Assembly	K3089-1					●	●													
Wire Straightener	K1733-5					●	●	●	●	●	●									
Tiny Twinarc® Solid Wire Straightener	K281							●	●	●	●									
Conduit	KP3095-1					●	●													
Tiny Twin Kit	K3070-1					●	●													
Butt Joint Guide	K3154-1					●	●													
Start Controls P.C. Board for Automatics	K221								●	●										
Crater Fill Controls P.C. Board for Automatics	K245								●	●										
Horizontal Adjuster, 2 in. (50.8 mm)	K96								●	●	●	●								
Vertical Lift Adjuster, 4 in. (101.6 mm)	K29								●	●	●	●								
TC-3 High Capacity Travel Carriage, Multiple Heads & Controls, 5-75 ipm.	K325HCS								●	●	●	●								
Automatic Flux Hopper Assembly	K219								●	●										
Wire Reel Assembly for 50-60 lb. (22.7-27.2 kg) Coils (without high frequency insulation)	K299								●	●	●	●								
Spreadarc Oscillator	K278-1								●	●	●	●								
Narrow Gap Deep Groove Nozzle	K386								●	●	●	●								
Contact Jaw Assembly for 1/8-7/32 in. (3.2-5.6 mm) Wire	K226R								●	●	●	●								
Nozzle Tip	KP2108-1B1										●	●								
Contact Tip, 5/64 in. (2.0 mm), 3/8-24 in. (9.5-609.6 mm) thread	KP2082-2B1							●	●											
Liner Spring, 0.133 in. ID, 0.240 in. OD, 12.60 in. (3.4 mm ID, 6.1 mm OD, 320.0 mm)	KP2095-15										●	●								
Contact Tip, Pressure Shoe Type, 1/16 in. (1.6 mm) wire diameter	KP1966-2B1										●	●								
Weld Power Cable, Lug to Lug 4/0, 35 ft. (10.7 m), qty. 2	K2163-35																			●
Weld Power Cable, Lug to Lug 4/0, 60 ft. (18.3 m), qty. 2	K2163-60																			●

Accessories

Product Name	Product No.	Accessories														
		LN-8 Wire Feeder	LN-9 Wire Feeder	LT-7 Tractor	Cruiser™ Tractor	Tandem Cruiser™ Tractor	NA-3 Controls & Heads	NA-4 Controls & Heads	NA-5 Controls & Heads	MAXsa® Controllers and Feed Heads	Idealarc® DC600	Idealarc® DC1000	Idealarc® DC1500	Idealarc® AC1200	Power Wave® AC/DC 1000® SD	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	
GENERAL, CON'T.																
Weld Power Cable, Lug to Lug 4/0, 600A, 60%,110 ft. (33.5 m)	K1842-110															
Severe Duty Contact Tip, 3/32 in. (2.4 mm)	KP1962-3B1							●	●							
Severe Duty Contact Tip, 1/8 in. (3.2 mm)	KP1962-1B1							●	●							
Severe Duty Contact Tip, 5/32 in. (4.0 mm)	KP1962-4B1							●	●							
Severe Duty Contact Tip, 3/16 in. (4.8 mm)	KP1962-2B1							●	●							
Severe Duty Contact Tip, 7/32 in. (5.6 mm)	KP1962-5B1							●	●							
Extended Life Contact Tip, 3/32 in. (2.4 mm)	KP3162-3B1							●	●	●						
Extended Life Contact Tip, 1/8 in. (3.2 mm)	KP3162-1B1							●	●	●						
Extended Life Contact Tip, 5/32 in. (4.0 mm)	KP3162-4B1							●	●	●						
Extended Life Contact Tip, 3/16 in. (4.8 mm)	KP3162-2B1							●	●	●						
Extended Life Contact Tip, 7/32 in. (5.6 mm)	KP3162-5B1							●	●	●						
Tiny Twinarc® Assembly for 1/16 in. (1.6 mm) Wire	K129-1/16							●	●	●	●					
Tiny Twinarc® Assembly for 5/64 in. (2.0 mm) Wire	K129-5/64							●	●	●	●					
Tiny Twinarc® Assembly for 3/32 in. (2.4 mm) Wire	K129-3/32							●	●	●	●					
Submerged Arc Twinarc® Nozzle for 5/64, 3/32 and 1/8 in. (2.0, 2.4 and 3.2 mm) Wire	K225							●	●	●	●					
Tandem Arc Framework Assembly	K387							●	●	●	●					
Tandem Arc Wire Reels and Mountings	K390							●	●	●	●					
Flux Hopper Assembly	K389							●	●	●	●					
Control to Head Cable Extension, 46 ft. (14.0 m)	K338-46															
Control to Head Cable Extension, 26 ft. (7.9 m)	K335-26															
Solenoid Kit	K223									●						
Spindle Kit, 2 in. (50.8 mm) Hub	K162-1									●	●					
Start or Crater Module	K334									●						
Weld Timer Module - max time 9.99 sec.	K337-10									●						
Remote Interface Module	K336									●						
Automatic Flux Hopper Assembly	K219									●	●					
Mounting Bracket for TC-3	K2462-1									●						
Multi-Process Switch	K804-1									●	●	●				
Arc Tracker™	K3019-1									●	●	●	●	●		
Paralleling Kit*	K1897-1									●	●	●	●	●		
Paralleling Kit*	K1611-1									●	●	●	●	●		
All-Terrain Undercarriage	K1737-1									●	●	●	●	●		
Undercarriage - Hand moving	K842									●	●	●	●	●		
Factory Undercarriage	K1770-1												●	●		
42 Volt Transformer Kit	K1520-1												●	●		

NOTE » *On Idealarc DC600, cannot be used with VRD models.

● Optional

Accessories

Product Name	Product No.	LN-8 Wire Feeder		LN-9 Wire Feeder		LT-7 Tractor		Cruiser™ Tractor		Tandem Cruiser™ Tractor		NA-3 Controls & Heads		NA-4 Controls & Heads		NA-5 Controls & Heads		MAXsa® Controllers and Feed Heads		Idealarc® DC600		Idealarc® DC1000		Idealarc® DC1500		Idealarc® AC1200		Power Wave® AC/DC 1000® SD	
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K297	K357-1	K227-1	K395-1	K3048-2	K3083-1	Various model Hs	Various model Hs	Various model Hs	Various model Hs	K1288-22	K1288-17	K1288-18	K1386-3	K1386-4	K1275	K3140-2	K2803-1										

GENERAL, CON'T.

Remote Output Control, 25 ft., (7.6 m)	K857																												
Remote Output Control, 100 ft., (30.5 m)	K857-1																												
Amptrol™ Adapter Kit	K843																												
Adapter Cable, Male 14-pin Control Cable to Terminal Strip	K1798																												
Paralleling Kit	K1900-1																												
CE Filter	K2444-3																												
Weld Fume Control System	—	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•

WIRE FEEDERS

LN-8	—																												
LN-9	—																												
LT-7	—																												
Cruiser™ Tractor	—																												
Tandem Cruiser™ Tractor	—																												
NA-3S	—																												
NA-4	—																												
NA-5	—																												
MAXsa® Controllers	—																												

POWER SOURCES

Idealarc® DC600	—																												
Idealarc® DC1000	—																												
Idealarc® DC1500	—																												
Idealarc® AC1200	—																												
Power Wave® AC/DC 1000® SD	—																												

2-YEAR EXTENDED WARRANTY

LN-8 Submerged Arc Wire Feeder	—	•																											
LN-9 Submerged Arc Wire Feeder	—		•																										
LT-7 Tractor	—			•																									
LT-7 Tractor Track Model	—				•																								
NA-3 Controls	—																												
NA-4 Control	—																												
NA-3S/NA-4 Head	—																												
NA-3SF/NA-4 Head	—																												
NA-5 Control	—																												
NA-5S Head	—																												
NA-5SF Head	—																												
Idealarc® DC600	—																												
Idealarc® DC1000	—																												
Idealarc® DC1500	—																												
Idealarc® AC1200	—																												
Power Wave® AC/DC 1000® SD	—																												



WELDING GEAR

VIKING™ HELMETS » Industrial Passive™ · 1740 Series · 1840 Series · 2450 Series · 2450D Series · 3350 Series · PAPR

RED LINE® APPAREL » Welding Gear Ready-Paks® · Gloves · Jackets/Shirts/Lab Coat/Apron/Sleeves · Caps/Doo Rags/Beanies · Safety Glasses/Goggles/Face Shield

RADIUS® TOOLS » Magnetic Fixtures & Hand Lifters · Brushes · Chipping Hammers · Welpers® · Welding Pliers · Curtains/Blankets · Rod Ovens · Welding Fluids

VIKING™ Industrial Passive™

Low Cost, Low-Tech,
High-Value Protection

- Fixed Shade 11
- 2 Year Warranty
- Ratchet headgear
- Meets ANSI Z87.1 and CSA Z94.3 Standards
- An affordable option for students
- Hard hat and magnifying “cheater” lens capable



Processes

- All

Order Number

- K3371-1
Industrial Passive

Literature

E14.507

VIKING™ 1740

Make it Your Own:
A Great Welding Helmet at a Great Price

- Replaceable batteries
- Lightweight and compact
- Continuously variable 9-13 shade, sensitivity and delay
- Hard hat and magnifying “cheater” lens capable
- 2 Year Warranty



Processes

- All

Order Number

- K3282-1 Black

Literature

E14.506

Product Name	Lens Switching Speed	Variable Shade/Control	Magnifying “Cheater” Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light [seconds]	Arc Sensors	TIG Amp Rating	Cartridge Size in (mm)	View Size in (mm)	Temp. Range °C (°F)	Net Wt. oz (g)
VIKING™ 1740	1/25,000 seconds	9-13 / Internal	Yes	4/Internal	Variable	0.1-1.0 Fully Adjustable	2	AC/DC: ≥ 5 Amp	DINS: 4.33 x 3.54 (110 x 90)	3.78 x 1.67 (96 x 42.5)	Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158)	18.6 (528)

VIKING™ 1840 Series

Superior Optical Clarity at a Superior Price

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- New pivot style head gear
- Convenient external shade control
- Lightweight and compact
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3023-3 Black
- K3173-3 All American*
- K4175-3 Aztec™

Literature

E14.501

Product Name	Lens Switching Speed	Variable Shade/Control	Battery Replacement Type	Magnifying “Cheater” Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light (seconds)	Arc Sensors	TIG Amp Rating	Cartridge/View Size in (mm)	Temp. Range °C (°F)	Net Wt. oz (g)
VIKING™ 1840	1/25,000 seconds	9-13 / Internal	CR2450 Replaceable Lithium Battery (Qty. 1)	Yes	3.5/Internal	Continuous	0.1-1.0 Fully Adjustable	2	AC: > 5 amp DC: > 3 amp	Cartridge DINs: 4.33 x 3.54 (110 x 90) View: 3.78 x 1.85 (96 x 47)	Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158)	18.8 (533)

VIKING™ 2450 Series

The Ideal Choice for the Journeyman Fabricator

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Fastest switching speed in its class
- Designed for long hours of comfortable wear with the new pivot style headgear
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3028-3 Black
- K4411-3 White Tail Camo™
- K3029-3 Heavy Metal*
- K3035-3 Street Rod*
- K3174-3 All American*
- K3099-3 Graveyard Shift*
- K4437-3 Jessi the Welder

Literature

E14.501

Product Name	Lens Switching Speed	Variable Shade/Control	Battery Replacement Type	Magnifying “Cheater” Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light (seconds)	Arc Sensors	TIG Amp Rating	Cartridge/View Size in (mm)	Temp. Range °C (°F)	Net Wt. oz (g)
VIKING™ 2450	1/25,000 seconds	5-13 / Internal	CR2450 Replaceable Battery (Qty. 2)	Yes	3.5/Internal	Continuous	0.1-1.0 Fully Adjustable	4	AC: > 2 amp DC: > 2 amp	Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.82 x 2.44 (97 x 62)	Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158)	21 (595)

VIKING™ 2450D

Are You Ready to Go Digital?

- 4C™ Lens Technology
- Digital push-button operator interface
- Welding, Cutting and Grind Modes
- Fastest switching speed in its class
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3230-3 Black

Literature

E14.501

Product Name	Lens Switching Speed	Variable Shade/Control	Battery Replacement Type	Magnifying “Cheater” Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light (seconds)	Arc Sensors	TIG Amp Rating	Cartridge/View Size in (mm)	Temp. Range °C (°F)	Net Wt. oz (g)
VIKING™ 2450D	1/25,000 seconds	4-13 / Internal	CR2450 Replaceable Battery (Qty. 2)	Yes	4 / Internal	Digital Display Control	0.1-1.0 Fully Adjustable	4	AC: > 2 amp DC: > 2 amp	Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.82 x 2.44 (97 x 62)	Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158)	21 (595)

VIKING™ 3350 Series

Defining a New Standard in Welding Helmets

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Largest viewing area in the VIKING™ line
- For the customer who refuses to compromise
- Superior comfort with the pivot style headgear
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3034-3 Black
- K4181-3 Foose Imposter™
- K4412-3 White Tail Camo™
- K4034-3 Code Red®
- K3372-3 Jessi vs. The Robot™
- K4158-3 Zombie™
- K3175-3 All American®
- K3248-3 Twisted Metal®
- K3039-3 Terracuda®
- K3100-3 Motorhead®
- K3101-3 Mojo®
- K3255-3 Polar Arc®
- K3428-3 Steampunk

Literature

E14.501

Product Name	Lens Switching Speed	Variable Shade/Control	Battery Replacement Type	Magnifying “Cheater” Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light (seconds)	Arc Sensors	TIG Amp Rating	Cartridge/View Size in (mm)	Temp. Range °C (°F)	Net Wt. oz (g)
VIKING™ 3350	1/25,000 seconds	5-13 / Internal	CR2450 Replaceable Battery (Qty. 1)	Yes	3.5/Internal	Continuous	0.1-1.0 Fully Adjustable	4	AC: > 2 Amp DC: > 2 Amp	Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.74 x 3.34 (95 x 85)	Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158)	21 (595)

BETTER OPTICS. BETTER WELDS.

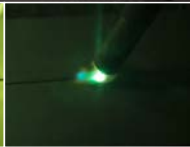
See The Puddle Clearer Than Ever Before!

Our exclusive new **4C™ lens technology upgrade** to Lincoln Electric's VIKING™ welding helmets provides a filtering lens with the clearest view of the welding puddle on the market today. This new technology reduces eye strain by minimizing the traditional green coloring in the helmet view screen in both active and inactive states. Available on the 1840, 2450 and 3350 series helmets.

Inactive State

Active State – Shade 8 MIG

CURRENT
TECHNOLOGY



4C
TECHNOLOGY



LINCOLN[®]
ELECTRIC

VIKING™ 3350 PAPR™

Comfort, Performance And Efficiency

- Lightweight and comfortable
- Battery run time is a minimum of 8 hours, outpacing competing systems
- Audible and vibrating alarms notify user of low air flow or low battery



Processes

- All

Order Number

- K3930-1

Literature

- E14.744

Product Name	Lens Switching Speed	Variable Shade/Control	Magnifying "Cheater" Capable Lens	Grind Mode Shade/Control	Light Sensitivity Control	Delay Control Dark to Light (seconds)	Arc Sensors	TIG Amp Rating	Cartridge Size in (mm)	View Size in (mm)	Temp. Range °C (°F)	Net Wt. lb (kg)
VIKING™ 3350 PAPR™	1/25,000 seconds	5-13 / Internal	Yes	3.5/Internal	Continuous	0.1-1.0 Fully Adjustable	4	AC: > 2 Amp DC: > 2 Amp	US: 5.25 x 4.50 (133 x 114)	3.74 x 3.34 (95 x 85)	Operating: -5 to +55 (23 to 131) Storage: -20 to +70 (-4 to +158)	6.19 (2.8) (Entire system)

Standard Welding Gear Ready-Pak®

Get all the Welding Gear You Need

- Features Traditional Khaki FR Cloth Jacket and Industrial Passive Shade 11 Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

- K4416-M
- K4416-L
- K4416-XL
- K4416-2XL
- K4416-3XL

K3096-1

- Replacement Lincoln Industrial Duffle Bag

Literature

- E14.743

Traditional Welding Gear Ready-Pak®

All the Welding Gear a Student or Aspiring Welder Needs to Get Started

- Features Traditional FR Cloth Jacket and VIKING™ 1840 Black Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

K3105-M
K3015-L
K3105-XL
K3105-2XL
K3105-3XL

K3096-1

Replacement Lincoln Industrial Duffle Bag

Literature

MC11-76

Jessi Combs Women's Welding Gear Ready-Pak®

Get all the Women's Welding Gear You Need

- Jacket and gloves are sized and tailored for women
- Features Jessi Combs Women's Shadow™ FR Welding Jacket and Jessi vs. the Robot™ VIKING™ 3350 Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

K3238-XS
K3238-S
K3238-M
K3238-L
K3238-XL

K3096-1

Replacement Lincoln Industrial Duffle Bag

Literature

MC13-174

Premium Welding Gear Ready-Pak®

Our First-Class Welding Gear Package

- Complete with top grade personal protective equipment
- Long lasting quality
- Comfortable and stylish



Order Number

K3236-M
K3236-L
K3236-XL
K3236-2XL

K3096-1

Replacement Lincoln Industrial Duffle Bag

Literature

MC12-81

Roll Cage™ Welding Rigging Gloves

Dual Purpose, Complete Protection

- Silicone knuckles protect fingers and back of the hand from impact and injury
- Extended cuffs protect the wrists and forearms from heat and sparks
- Palm padding reinforces high wear areas



Order Number
 K3109-S
 K3109-M
 K3109-L
 K3109-XL
 K3109-2XL

Premium Leather MIG/Stick Welding Gloves

Crafted for Every-Day Duty

- Designed for optimal dexterity and durability
- Superior comfort, durability and dexterity
- Flame retardant foam lining provides heat resistance



Order Number
 K2980-M
 K2980-L
 K2980-XL

Traditional MIG/Stick Welding Gloves

Built to Protect, Built to Last

- One size fits all
- Designed for comfort and durability



Order Number
 K2979-ALL

Leather TIG Welding Gloves

Precision Fit for Precision Welding

- Optimal fit and dexterity for TIG welding applications
- Heat-resistant gauntlet for wrist protection



Order Number
 K2981-M
 K2981-L
 K2981-XL

Heat-Resistant Welding Gloves

Be Cool, Be Comfortable

- Reflects 95% of radiant heat
- Aluminized rayon backing
- Unlined palm for increased control and reduced fatigue



Order Number
 K2982-L
 K2982-XL

Full Leather Steelworker® Gloves

Deliver Fit and Flexibility

- Designed for light welding or metalworking
- Strong all-leather construction
- Hook-and-loop wrist closure ensures a snug fit



Order Number
 K2977-S
 K2977-M
 K2977-L
 K2977-XL
 K2977-2XL

Traditional Split Leather-Sleeved Jacket

Minimum Weight, Maximum Durability

- Split cowhide sleeves resist spatter and wear and lightweight FR cloth keeps you cool
- Inside pocket and adjustable snap sleeves
- Good protection, economically priced



Order Number

K3106-M
K3106-L
K3106-XL
K3106-2XL
K3106-3XL

Shadow™ Grain Leather-Sleeved Jacket

Protection, Comfort and Freedom

- For MIG or stick welding
- Flip up collar and extra front panel flap provide full closure
- Spatter guard lining
- Quality craftsmanship



Order Number

K2987-M
K2987-L
K2987-XL
K2987-XXL
K2987-XXXL

Shadow™ Split Leather-Sleeved Jacket

Quality, Durability, Protection, Comfort: The Ideal Jacket for MIG or Stick

- Split cowhide sleeves and cool FR material on the chest
- Ideal for stick and MIG welding
- Flip up collar and a lined flap on the back close for extra protection
- Two horizontal hip pockets with secured flaps



Order Number

K2986-M
K2986-L
K2986-XL
K2986-XXL
K2986-XXXL
K2986-5XL

Heavy-Duty Leather Welding Jacket

Protection for the Tough Jobs

- Heavy-duty split cowhide leather chest and sleeves provide superior protection
- FR cloth back keeps you cool
- Ideal for heavy stick and MIG welding
- Flip up collar, extra front flap for full closure and spatter guard lining



Order Number

K2989-M
K2989-L
K2989-XL
K2989-XXL
K2989-XXXL

Traditional FR Cloth Jacket – Khaki

The Ideal Light Duty Welding Jacket

- Crafted from 100% flame-retardant material
- Provides maximum protection
- Adjustable dual snap sleeves and convenient inside pocket



Order Number

K3317-M
K3317-L
K3317-XL
K3317-2XL
K3317-3XL

Traditional FR Cloth Jacket – Black

The Ideal Light Duty Welding Jacket

- Crafted from 100% flame-retardant material
- Provides maximum protection
- Adjustable dual snap sleeves and convenient inside pocket



Order Number

K2985-M
K2985-L
K2985-XL
K2985-XXL
K2985-XXXL

FR Welding Shirt – Khaki

Safety and Comfort in a Single Shirt

- Ideal for light-duty welding
- Durable enough for daily use
- Adjustable dual-snap sleeves
- Features a single pocket with flap and pencil holder



Order Number

K3382-M
K3382-L
K3382-XL
K3382-2XL

FR Welding Shirt – Black

Safety and Comfort in a Single Shirt

- Ideal for light-duty welding
- Durable enough for daily use
- Adjustable dual-snap sleeves
- Features two chest pockets with flaps and a pencil holder slot



Order Number

K3113-M
K3113-L
K3113-XL
K3113-2XL
K3113-3XL

FR Welding Lab Coat

All-Purpose Protection

- 9 oz. 100% flame retardant material
- Knee length offers extended protection for light-duty welding
- Ideal for instructors, supervisors and occasional welders



Order Number

K3112-M
K3112-L
K3112-XL

Split-Leather Welding Apron

Provides an Extra Layer of Protection

- Heavy-duty split cowhide construction
- Harness system adjusts to any size and weight
- Great addition for any welding jacket or shirt



Order Number

K3110-ALL

Split-Leather FR Welding Sleeves

Stay Protected, Stay Cool

- Durable, flame-retardant material adds spatter and heat resistance
- Split leather panels in high wear areas



Order Number

K3111-ALL

Custom Embroidery Available!

Get custom Red Line™ apparel for your school or shop, or personalize it just for you.

- Add custom single or multi-color logos to Red Line™ FR cloth jackets, welding shirts or lab coats



Welding Doo Rag FR

Do the Lincoln Rag

- 100% flame retardant material
- Mesh lining for fast sweat evaporation
- Machine washable



Order Number
K2993-ALL

All American™ Doo Rag

American Headgear

- 100% cotton
- Mesh lining for fast sweat evaporation
- Machine washable



Order Number
K3204-ALL

All American™ Welding Cap

Stars, Stripes and Sparks

- 100% cotton
- Cushioned insert provides comfort and absorbs sweat
- Flat-stitched seams for superior comfort
- Machine washable



Order Number
K3203-ALL

Welding Beanie FR

Top Off with Lincoln Electric

- Machine washable
- Flame-retardant



Order Number
K2994-L
K2994-XL

Padded Safety Glasses

Padded Safety Glasses are
Easy on the Eyes

- Comfortable, non-slip strap material
- 360° foam liner keeps dust out and enhances comfort
- For long hours of comfort



Meets Requirements

- ANSI Z87.1
- CSA Z94.3

Order Number

K3119-1

Face Shield

Full Frontal Protection

- Large, impact-resistant shield wraps around entire face
- Ideal for grinding, polishing, deburring and other operations



Meets Requirements

- ANSI Z87.1
- CSA Z94.3

Order Number

K3120-1
KP3164-1 (Lens only)

Shade 5 Cutting and Grinding Goggles

Shades of Protection

- For plasma and oxyfuel cutting operations
- 100% surface seal keeps sparks, spatter, particles, sand, dirt and heat away from your eyes



Meets Requirements

- ANSI Z87.1

Order Number

K3118-1

Shade 3 Cutting and Grinding Goggles

Shades of Protection

- For chipping, grinding and machining operations.
- 100% surface seal keeps sparks, spatter, particles, sand, dirt and heat away from your eyes



Meets Requirements

- CSA Z94.3
- ANSI Z87.1

Order Number

K3118-2

Finish Line™ Clear Safety Glasses

Safe, Sleek and Stylish

- Flexible nosepiece and adjustable temple tips for added comfort
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2966-1

Women's Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

- Sized 10% smaller than our similar models
- Light weight makes these models easy to wear
- Anti-fog and anti-scratch coating



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K3250-S
K3250-M

Lincoln Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

- Light weight makes these models easy to wear
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2965-1

Traditional Lincoln Clear Safety Glasses

Traditional Safety Glasses

- Frameless clear lens
- Light weight makes these models easy to wear
- Inexpensive and ideal for student, team or bulk purchases



Meets Requirements

- ANSI Z87.1+

Order Number

K3104-1

Lincoln Cover 2® Clear Safety Glasses

Protect Your Eyes and Your Glasses

- Worn over your own prescription glasses
- Ratcheting adjustable-length temples
- Integrated brow guard and side shields offer added impact protection
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2968-1

Bifocal Clear Safety Glasses

See Safety More Clearly

- Full eye coverage
- Slip resistant temples



Meets Requirements

- ANSI Z87.1

Order Number

K3117-100 1.0 Diopter
K3117-150 1.5 Diopter
K3117-200 2.0 Diopter
K3117-250 2.5 Diopter

Finish Line™ Outdoor Safety Glasses

Keep Your Eye on the Finish Line

- Flexible nosepiece and adjustable temple tips for added comfort
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2970-1

Lincoln Starlite® Outdoor Safety Glasses

Safe, Sleek and Stylish

- Silver mirror coating added to the lens for protection from the sun
- Frameless lens provides a wide field of vision
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2969-1

I-Beam™ Red Outdoor Safety Glasses

Sturdy Protection

- Durable impact protection
- Flexible nosepiece and temple tips add comfort
- Silver mirror lens
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2972-1

I-Beam™ Black Outdoor Safety Glasses

Sturdy Protection

- Durable impact protection
- Flexible nosepiece and temple tips add comfort
- Red mirror lens
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2971-1

Lincoln Starlite® IR 5 Safety Glasses

Infra-Red Shielding

- Shade 5 infra-red protection intended for cutting and grinding
- Unitary frameless style provides a wide field of vision
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2967-1

Jessi vs. The Robot™ Auto-Darkening Welding Helmet

VIKING™ 3350 Series

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Largest viewing area in the VIKING™ line
- For the customer who refuses to compromise
- Superior comfort with the pivot style headgear



Processes

- All

Order Number

K3372-3

Literature

E14.501

Jessi The Welder™ Auto-Darkening Welding Helmet

VIKING™ 2450 Series

- 4C Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Largest viewing area in the VIKING™ line
- 3 Year Warranty



Processes

- All

Order Number

K4437-3

Literature

E14.501

Jessi Combs Women's Shadow™ Welding Jacket

A Jacket Designed with Women in Mind

- Split cowhide sleeves with cooling FR cloth front and back
- Flip up collar, adjustable snap sleeves and snap cinch waist
- Two horizontal flap pockets
- Ideal for MIG or stick welding



Order Number

K3114-XS

K3114-S

K3114-M

K3114-L

K3114-XL

Literature

MC12-107

Jessi Combs MIG/Stick Welding Gloves

Not Your Brother's Welding Gloves

- Designed and sized for women's hands
- Durable split cowhide and cotton lining
- Long-lasting work life



Order Number

K3232-S

K3232-M

Literature

MC12-107

Jessi Combs Women's Steelworker® Gloves

For Her: A Glove For The Multi-Tasker

- Sized for women's hands
- Top grain cowhide ensures durability and maximizes dexterity
- For fabrication or light welding
- All leather construction



Order Number

K3231-XS

K3231-S

K3231-M

Literature

MC12-107

Women's Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

See page 140



JESSI COMBS
Metal fabricator,
TV personality and
fastest woman land
speed record holder.

Pivot Angle Magnetic Fixture

Tacking Welds Just Got Easier

- Designed for repetitive work at uncommon angles
- Convenient single lock handle makes it fast and easy to select an angle



Order Number
• K3310-1

Literature
E14.800

Multi Angle Fixture

Tacking Welds Just Got Easier

- Set up in seconds
- Magnet technology allows for complete on/off control and precise positioning
- Easy to position on flat or round stock



Order Number
• K3309-1

Literature
E14.800

Mini Multi Angle Fixture

Tacking Welds Just Got Easier

- Designed for small steel parts
- Pipe notch for use on round stock
- No batteries or electricity required



Order Number
• K3318-1

Literature
E14.800

Manual Hand Lifter

Get a Handle on Steel

- For small part lifting and sheet dragging
- Work faster and more efficiently with fewer injuries
- No batteries or electricity required



Order Number
• K3311-1

Literature
E14.800

Electric Hand Lifter

Battery Powered Steel Handling

- No cords to clutter the workplace
- For small part handling and removing parts from burn tables
- Battery power light blinks when battery needs recharging
- 60 lb (27.2 kg) lifting force



Order Number
• K3312-1

Literature
E14.800

Stainless Steel & Aluminum Welding

3 X 7 Row Stainless Steel Wire Brush

This handy toothbrush style is just right for light cleaning on stainless steel in confined or hard to reach areas.

2 X 9 Row Stainless Steel Wire Brush

A slight curve in the handle improves grip. Ideal for general or light cleaning on stainless steel.

3 X 19 Row Stainless Steel Wire Brush

This general purpose brush is intended for long life and efficient surface cleaning on stainless steel.



Length, in. (mm)

- 7.5 [191] [3x7 Brush]
- 8.5 [216] [2x9 Brush]
- 13.75 [349] [3x19 Brush]

Order Number

- K3179-1 [3x7 Brush]
- K3180-1 [2x9 Brush]
- K3181-1 [3x19 Brush]

Alloy Welding

3 X 7 Row Brass Wire Brush for Aluminum

This compact toothbrush style can be used for light cleaning on aluminum in confined or hard to reach areas. Brass bristles are easy on aluminum surfaces.

2 X 9 Row Brass Wire Brush for Aluminum

The slightly curved handle improves grip for general light cleaning on aluminum. Brass bristles gently remove oxide layer on aluminum.



Length, in. (mm)

- 7.5 [191] [3x7 Brush]
- 8.5 [216] [2x9 Brush]

Order Number

- K3182-1 [3x7 Brush]
- K3183-1 [2x9 Brush]

Carbon Steel Welding

3 X 19 Row Carbon Steel Wire Brush

Select this popular tempered steel bristle pattern for efficient general cleaning on carbon steels.

4 X 16 Row Carbon Steel Wire Brush

Tempered steel bristles make fast work of rust, mill scale and paint on carbon steels. Comfortable curved handle.



Length, in. (mm)

- 13.75 [349] [3x19 Brush]
- 9.5 [241] [4x16 Brush]

Order Number

- K3184-1 [3x19 Brush]
- K3185-1 [4x16 Brush]

Combination Packs

Wire Brush Three Pack

This compact toothbrush style set is easy to stow in your bag and perfect for small projects. Includes brass bristle brush for aluminum, stainless bristle brush for stainless steel and a nylon bristle brush for general cleaning on carbon steel.



Length, in. (mm)

- 7.5 [191]

Order Number

- K3189-1

Chipping Hammer

Tackle Dirt and Slag Head-On

- Shock reducing spiral handle with hook
- Head includes spike and flat sides



Processes

- Stick
- Flux-Cored

Order Number

K4022-1

Literature

E14.742

Welper®

Multi-Use MIG Tool

- Designed for MIG welding operations with eight functions in a single pair of pliers
- Spring loaded for easy opening and closing
- Comfortable handle
- Chrome vanadium steel



Processes

- MIG
- Flux-Cored

Order Number

K4014-2

Literature

E14.740

Welding Pliers

Single Tool, Multiple Functions

- Up to six functions
- Spring loaded for easy opening and closing
- Heat treated for durability



Processes

- MIG

Order Number

K4014-1

Literature

E14.741

Welding Curtain, 6 x 6 ft. (1.8 x 1.8 m)

Bring the Curtain Down on Sparks
and Spatter

- Intended to be hung vertically
- Rated for temperatures up to 1022°F (550°C)
- Protects workers from injury and parts and equipment from damage



Meets Requirements

- FM approved for ANSI/FM 4950

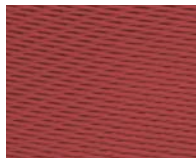
Order Number

K3252-1

Welding Blanket, 6 x 6 ft. (1.8 x 1.8 m)

We've Got You Covered

- Intended to be used horizontally
- Rated for temperatures up to 1,022°F (550°C)
- Protects workers from injury and parts and equipment from damage
- Easy to position in any shop



Meets Requirements

- FM approved for ANSI/FM 4950

Order Number

K3253-1

High Temperature Welding Blanket, 6 x 6 ft. (1.8 x 1.8 m)

Keep the Heat Off

- Intended to be used horizontally
- Rated for temperatures up to 2012°F (1,100°C)
- Protects workers from injury and parts and equipment from damage
- Easy to position in any shop



Meets Requirements

- FM approved for ANSI/FM 4950

Order Number

K3254-1

Hydroguard® Rod Canister

Easy to Carry. Easy to Protect.

- Protect and carry 10 lb. (4.5 kg) of stick electrode up to 14 in. (355.6 mm) in length
- Rubber seal makes the container moisture-resistant



Processes
• Stick

Order Number
K3166-1
K3167-1 (strap)

Hydroguard® Portable Welding Rod Oven

Outstanding Moisture Resistance for Improved Weld Quality

- Transport a maximum of 10 lb. (4.5 kg) of up to 18 in. (457.2 mm) electrode
- Maintains electrodes at a constant 300°F (149°C) temperature
- Power-On light to visually confirm operation



Processes
• Stick

Output
Preset at 300°F (149°C)

Input



Order Number
K2939-1 (115V)
K2939-2 (230V)

Literature
E14.701

Hydroguard® Bench Rod Oven

Outstanding Moisture Resistance for Improved Weld Quality

- Circular Shape Directs Airflow
- Adjustable Thermostat
- Flexible Interior Configuration
- Variable Moisture Vent
- Handy Shelf
- Data Logger Capable



Processes
• Stick Electrode
• MIG Wire

Output
100-550°F
(38-288°C)

Input



Order Number
K2942-1 (120V)
K2942-2 (240/480V)
K3148-1 (Thermometer Kit)

Literature
E14.702

Specifications Chart » VIKING™ 3350 PAPR™

PAPR (Powered Air-Purifying Respirator) Specifications	
Size of Blower Assembly (W x T x D)	8 x 7.5 x 3 in. (203 x 191 x 76 mm)
Weight of Blower (including battery, belt and filters)	2.20 lb. (1.0 kg)
Air Flow	Low Speed: 180+ lpm (6+ cfm) High Speed: 210+ lpm (7.4+ cfm)
Operating Temperature	23° to 131°F (-5° to 55°C)
Battery Type	Lithium Ion (Rechargeable)
Battery Charge Time	Three hours
Battery Charges	500 charges
Belt Size ⁽¹⁾	29 to 52 in. (736 to 1321 mm)
Respirator Approval ⁽²⁾	NIOSH 42 cfr 84 Approved Powered Air-Purifying Respirator (PAPR)
Assigned Protection Factor ⁽³⁾	25
Helmet Replacement Battery	CR 2450
Battery Life	8 Hours
Charge	115 Volt Input
Alarms	Audible and Vibrate
Head Gear	FR Flame Retardant
Optical Class	1/1/1/1 (per EN 379)
Lens Switching Speed (sec)	1/25,000
Variable Shade/Control	5-13 Internal
Magnifying "Cheater" Capable Lens	Yes
Grind Mode Shade/Control	3.5 Internal
Light Sensitivity Control	Continuous
Delay Control Dark to Light (sec)	0.1 -1.0 Fully Adjustable
Arc Sensors	4
TIG AMP Rating	DC > 2 Amp AC > 2 Amp
Helmet Compliance	ANSI Z87.1-2010, CSA Z94.3, CE
Cartridge Size	US 5.25 x 4.50 in. (133 x 114 mm)
View Size	3.7 x 3.34 in. (95 x 85mm)
Blower Assembly	1 Year Warranty
ADF Helmet	3 Year Warranty

⁽¹⁾ Belt size maximum of 60 in. (1524 mm) with belt extension accessory.

⁽²⁾ Refer to NIOSH respirator approval label for system configuration.

⁽³⁾ APF=25 for loose fitting Powered Air-Purifying Respiratory according to OSHA 3352-02 2009, when the employer implements a continuing, effective respirator program in compliance with the Respiratory Protection Standard (29 CFR 1910).

Specifications Chart

Welding Gloves

HAND SIZING FOR GLOVES (measure the width of the hand as shown) 

Product Name	Product Number	Mens Gloves – in (cm)					Womens Gloves – in (cm)		
		Small 8.0 [20]	Medium 8.5 [22]	Large 9.0 [23]	X Large 9.5 [24]	2X Large 10.0 [25]	X Small 7.0 [18]	Small 7.5 [19]	Medium 8.0 [20]
Roll Cage™ Welding Rigging Gloves	K3109-xx	•	•	•	•	•			
Premium Leather MIG/Stick Welding Gloves	K2980-xx		•	•	•				
Traditional MIG/Stick welding Gloves	K2979-xx	•	•	•	•	•			
Full Leather Steelworker® Gloves	K2977-xx	•	•	•	•	•			
Leather TIG Welding Gloves	K2981-xx		•	•	•				
Heat-Resistant Welding Gloves	K2982-xx			•	•				
Jessi Combs Women's MIG/Stick Welding Gloves	K3232-xx							•	•
Jessi Combs Women's Steelworker® Gloves	K3231-xx						•	•	•

Specifications Chart

Welding Apparel

Part No./ Size	Chest Measurement in (cm)	Sleeve Length in (cm)	Torso Size in (cm)	Coat Length in (cm)
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Traditional Split Leather-Sleeved Jacket

K3106-M	40-42 (102-107)	31 (79)	30 (76)	
K3106-L	44-46 (112-117)	32 (81)	30 (76)	
K3106-XL	48-50 (122-127)	33 (84)	30 (76)	
K3106-2XL	52-54 (132-137)	34 (86)	30 (76)	
K3106-3XL	56-58 (142-147)	35 (89)	30 (76)	

Shadow™ Grain Leather-Sleeved Jacket

K2987-M	40-42 (102-107)	31 (79)	30 (76)	
K2987-L	44-46 (112-117)	32 (81)	31 (79)	
K2987-XL	48-50 (122-127)	33 (84)	32 (81)	
K2987-2XL	52-54 (132-137)	34 (86)	33 (84)	
K2987-3XL	56-58 (142-147)	35 (89)	34 (86)	

Shadow™ Split Leather-Sleeved Jacket

K2986-M	40-42 (102-107)	31 (79)	30 (76)	
K2986-L	44-46 (112-117)	32 (81)	31 (79)	
K2986-XL	48-50 (122-127)	33 (84)	32 (81)	
K2986-2XL	52-54 (132-137)	34 (86)	33 (84)	
K2986-3XL	56-58 (142-147)	35 (89)	34 (86)	
K2986-5XL	60-66 (152-168)	35 (89)	34 (86)	

Heavy Duty Leather Welding Jacket

K2989-M	40-42 (102-107)	31 (79)	30 (76)	
K2989-L	44-46 (112-117)	32 (81)	31 (79)	
K2989-XL	48-50 (122-127)	33 (84)	32 (81)	
K2989-2XL	52-54 (132-137)	34 (86)	33 (84)	
K2989-3XL	56-58 (142-147)	35 (89)	34 (86)	

Traditional FR Cloth Jacket

Khaki

K3317-M	40-42 (102-107)	31 (79)	30 (76)	
K3317-L	44-46 (112-117)	32 (81)	30 (76)	
K3317-XL	48-50 (122-127)	33 (84)	30 (76)	
K3317-2XL	52-54 (132-137)	34 (86)	30 (76)	
K3317-3XL	56-58 (142-147)	35 (89)	30 (76)	

Black

K2985-M	40-42 (102-107)	31 (79)	30 (76)	
K2985-L	44-46 (112-117)	32 (81)	30 (76)	
K2985-XL	48-50 (122-127)	33 (84)	30 (76)	
K2985-2XL	52-54 (132-137)	34 (86)	30 (76)	
K2985-3XL	56-58 (142-147)	35 (89)	30 (76)	

Part No./ Size	Chest Measurement in (cm)	Sleeve Length in (cm)	Torso Size in (cm)	Coat Length in (cm)
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FR Welding Shirt

Khaki

K3382-M	40-42 (102-107)	32 (81)	32 (81)	
K3382-L	44-46 (112-117)	33 (84)	33 (84)	
K3382-XL	48-50 (122-127)	34 (86)	34 (86)	
K3382-2XL	52-54 (132-137)	35 (89)	35 (89)	

Black

K3113-M	40-42 (102-107)	32 (81)	32 (81)	
K3113-L	44-46 (112-117)	33 (84)	33 (84)	
K3113-XL	48-50 (122-127)	34 (86)	34 (86)	
K3113-2XL	52-54 (132-137)	35 (89)	35 (89)	
K3113-3XL	56-58 (142-147)	36 (91)	36 (91)	

FR Welding Lab Coat

K3112-M	40-42 (102-107)	31 (79)		45 (114)
K3112-L	44-46 (112-117)	32 (81)		45 (114)
K3112-XL	48-50 (122-127)	33 (84)		45 (114)

Split Leather Welding Apron

K3110-ALL	One Size Fits All			
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Split Leather FR Welding Sleeves

K3111-ALL		21 (53)		
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Part No./ Size	Bust Size in (cm)	Sleeve Length in (cm)	Torso Size in (cm)	Waist Size in (cm)
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Jessi Combs Women's Shadow™ Split Leather-Sleeved Jacket

K3114-XS	32-36 (81-91)	28 (71)	27 (68)	28-32 (71-81)
K3114-S	36-39 (91-99)	28 (71)	27 (68)	32-34 (81-86)
K3114-M	39-41 (99-104)	29 (74)	27 (68)	34-36 (86-91)
K3114-L	41-43 (104-109)	30 (76)	27 (68)	36-38 (91-96)
K3114-XL	43-46 (109-117)	31 (79)	27 (68)	38-42 (96-107)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Welding Gear Ready-Pak® Packages

Standard Welding Gear Ready-Pak®

- Lincoln Industrial Duffle Bag
- Industrial Passive Welding Helmet
- Traditional Khaki FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Lincoln Startlite® Clear Safety Glasses
- Welding Doo Rag FR
- Spring Handle Chipping Hammer
- Radius™ Welding Pliers
- Radius 3 x19 Carbon Steel Wire Brush

Traditional Welding Gear Ready-Pak®

- Lincoln Industrial Duffle Bag
- VIKING™ Black 1840 Series Auto-Darkening Helmet
- Traditional FR Cloth Jacket
- Roll Cage™ Welding Rigging Gloves
- Full Leather Steelworker™ Gloves
- Lincoln Starlite® Clear Safety Glasses
- Welding Doo Rag FR

Jessi Combs Women's Welding Gear Ready-Pak®

- Lincoln Industrial Duffle Bag
- VIKING™ Jessi vs. The Robot™ 3350 Series Auto-Darkening Helmet
- Jessi Combs Women's Shadow™ FR Welding Jacket
- Jessi Combs MIG/Stick Welding Gloves
- Jessi Combs Steelworker® Gloves
- Women's Starlite® Clear Safety Glasses
- Welding Doo Rag FR

Premium Welding Gear Ready-Pak®

- Lincoln Industrial Duffle Bag
- VIKING™ Black 3350 Series Auto-Darkening Helmet
- Shadow™ Split Leather-Sleeved Jacket
- Roll Cage™ Welding Rigging Gloves
- Full Leather Steelworker® Gloves
- Finish Line™ Clear Safety Glasses
- Split Leather FR Welding Sleeves
- Welding Doo Rag FR

VIKING™ 3350 PAPR™

Includes

- Blower Unit
- VIKING™ 3350 Black Helmet
- Head Cover
- Hose
- 2 Particulate Filters
- 29-52 in. (736.6-1,320.8 mm) Padded Belt
- Shoulder Strap
- 120V Battery Charger
- Duffle Bag
- Rechargeable Battery
- Pre-Filter
- Spark Guard
- Hose Cover
- Extra helmet cover lenses:
 - Inside quantity, 2
 - Outside quantity, 5
- Instruction Manual



Shown:
Standard Welding Gear
Ready-Pak®



Shown:
VIKING™ 3350 PAPR™

Replacement Parts » Welding Helmets

Product Name	Dimensions	Package Quantity	Product Number	VIKING™ Industrial Passive™	700G Series	750S Series	VIKING™ 1740 Series	VIKING™ 1840 Series	VIKING™ 2450 Series	VIKING™ 2450D Series	VIKING™ 3350 Series
Shade 11 Filter Plate	4.50 x 5.25 in. (114 x 133 mm)	1	KP4003-1	•							
1740 ADF Cartridge	DIN 110 X 90	1	KP3284-1				•				
700G/1840 ADF Cartridge	DINS 110 X 90	1	KP2853-3		•			•			
2450 Series ADF Cartridge	STD 4 X 5	1	KP2932-3						•		
2450D Series ADF Cartridge	STD 4 X 5	1	KP3243-3							•	
3350 Series ADF Cartridge	STD 4 X 5	1	KP3045-3								•
750S Series ADF Cartridge	STD 4 X 5	1	KP2899-1			•					
700G/750S/1840 Inside Cover Lens	96 x 51.6 x 1.0 mm (3.78 x 2.03 x .04 in)	5	KP2897-1		•	•		•			
Outside Clear Cover Lens	114 x 133 x 1.0 mm (4.5 x 5.25 x .04 in)	5	KP2898-1	•		•			•	•	•
Outside Clear Cover Lens	112 x 91.3 x 1.5 mm (4.41 x 3.59 x .06 in)	5	KP2913-1		•						
2450 Inside Clear Cover Lens	98.5 x 66.5 x 1.0 mm (3.88 x 2.62 x .04 in)	5	KP2931-1						•	•	
1740/1840 Outside Clear Cover Lens Pack	114 x 100 x 1.5 mm (4.5 x 3.94 x .06 in)	5	KP3043-1				•	•			
3350 Inside Clear Cover Lens	94.7 x 89.7 x 1.0 mm (3.73 x 3.53 x .04 in)	5	KP3044-1								•
1740 Inside Clear Cover Lens Kit	95.9 x 47.2 x 1.00 mm	5	KP3283-1				•				
Retaining Frame	2 x 4.25 Frame, 2.5 Mag	1	KP4004-1	•							
Cheater Lens 1.00 Mag	2 x 4.25 Frame, 1.0 Mag	1	KP3046-100	•	•		•	•	•	•	•
Cheater Lens 1.25 Mag	2 x 4.25 Frame, 1.25 Mag	1	KP3046-125	•	•		•	•	•	•	•
Cheater Lens 1.50 Mag	2 x 4.25 Frame, 1.5 Mag	1	KP3046-150	•	•		•	•	•	•	•
Cheater Lens 1.75 Mag	2 x 4.25 Frame, 1.75 Mag	1	KP3046-175	•	•		•	•	•	•	•
Cheater Lens 2.00 Mag	2 x 4.25 Frame, 2.0 Mag	1	KP3046-200	•	•		•	•	•	•	•
Cheater Lens 2.25 Mag	2 x 4.25 Frame, 2.25 Mag	1	KP3046-225	•	•		•	•	•	•	•
Cheater Lens 2.50 Mag	2 x 4.25 Frame, 2.5 Mag	1	KP3046-250	•	•		•	•	•	•	•
Sweatband	N/A	2	KP2930-1	•	•	•	•	•	•	•	•
Sweatband	N/A	2	KP2854-1		•	•					
VIKING™ Ratchet Style Headgear Kit	N/A	1	KP4100-1	•			•	•	•	•	•
VIKING™ Pivot Headgear Kit	N/A	1	KP3908-1					•	•	•	•
700G/750S Headgear with Sweatband	N/A	1	KP2851-1		•	•					
Hard Hat Adapter	N/A	1	KP3047-1	•			•	•	•	•	•
2450D Black Replacement Shell	N/A	1	S27978-54					•			
2450D Outside Cover Lens Seal	N/A	1	S27978-58				•	•			
2450D ADF Holder	N/A	1	S27978-55				•	•			
Black Replacement Shell	N/A	1	S27978-31	•					•	•	•
Outside Cover Lens Seal	N/A	1	S27978-32	•		•			•	•	•
ADF Holder	N/A	1	S27978-33	•					•	•	•
Black Replacement Shell (matte finish)	N/A	1	S27978-95				•				

Replacement Parts » VIKING™ 3350 PAPR™

Product Name	Dimensions	Package Qty.	Product Number
VIKING™ 3350 PAPR™ Helmet Assembly (package includes Headgear and Headcovering)	N/A	1	K3930-1
Outside Cover Lens	5.25 x 4.5 in	5	KP2898-1
Outside Cover Lens Seal	N/A	1	S27978-32
3350 Auto-Darkening Lens	N/A	1	KP3045-2
Inside Cover Lens	3.53 x 3.73 in	5	KP3044-1
Lens Holder	N/A	1	S27978-33
Headgear (including plenum and sweatband)	N/A	1	KP3942-1
Sweatband	N/A	2	KP3943-1
Headcovering (w/hook and loop attachment)	N/A	1	KP3940-1
Blower Assembly (PKG includes filter cover assembly)	N/A	1	KP3944-1
Battery Pack-Standard	N/A	1	KP3937-1
HE Filter Assembly	N/A	2	KP3934-2
HE Filter Assembly	N/A	6	KP3934-6
Pre-filter	N/A	6	KP3935-1
Spark Screen	N/A	1	KP3936-1
Battery Charger	N/A	1	KP3932-1
PAPR Belt Assembly	N/A	1	KP5123-1
Shoulder Strap Assembly	N/A	1	KP5124-1
Belt Extension (extends belt to 60 in.)	N/A	1	KP3939-1
Hose Assembly with Cover	N/A	1	KP5122-1
Cheater Lens 1.00 MAG	2 X 4.25 FRAME, 1.0 MAG	1	KP3046-100
Cheater Lens 1.25 MAG	2 X 4.25 FRAME, 1.25 MAG	1	KP3046-125
Cheater Lens 1.50 MAG	2 X 4.25 FRAME, 1.5 MAG	1	KP3046-150
Cheater Lens 1.75 MAG	2 X 4.25 FRAME, 1.75 MAG	1	KP3046-175
Cheater Lens 2.00 MAG	2 X 4.25 FRAME, 2.0 MAG	1	KP3046-200
Cheater Lens 2.25 MAG	2 X 4.25 FRAME, 2.25 MAG	1	KP3046-225
Cheater Lens 2.50 MAG	2 X 4.25 FRAME, 2.5 MAG	1	KP3046-250
Duffle Bag	N/A	1	K3096-1



GUNS AND TORCHES

MAGNUM® PRO GUNS » L-Series · Curve™ Series · Barrel Series · Fume Extraction · Innershield® · Robotic · Spool Guns · Push-Pull

MAGNUM® GUNS » 100 Series · 200 Series · 300 Series · 400 Series · 500 Series

SPECIALIZED GUNS » Submerged Arc · Innershield®

PRO-TORCH™ TIG TORCHES » Air-Cooled · Water-Cooled

Magnum® PRO 100L Gun and Cable Assembly

Light and Compact

- Ideal for most home, farm and small shop projects, auto body work and light maintenance or repair applications
- Copper Plus® contact tips extend tip life to lower overall operational costs
- Lightweight curved handle provides a comfortable grip that keeps your hand cool during long welds
- Integrated gun connector is designed for POWER MIG® wire feeder/welders



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 140C
- POWER MIG® 180C
- POWER MIG® 180 Dual

Literature

E12.31

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps)	Duty Cycle [%] (100% CO ₂)	Wire Diameter Range in (mm)
Magnum® PRO 100L	K3080-1	10 (3.0)	100	40	0.025-0.045 [0.6-1.1]

Magnum® PRO 175L Gun and Cable Assembly

Compact and Powerful

- Ideal for most home, farm and small shop projects, as well as auto body work and light maintenance and repair applications
- Copper Plus® contact tips extend tip life to lower overall operational costs
- Integrated gun connector is designed for Lincoln Electric POWER MIG® wire feeder/welders
- Rated for higher output
- Includes a gun hanger for storage



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 210 MP

Literature

E12.33

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps)	Duty Cycle [%] (100% CO ₂)	Wire Diameter Range in (mm)
Magnum® PRO 175L	K4076-1	10 (3.0)	175	40	0.025-0.045 [0.6-1.1]

Magnum® PRO 250L Gun and Cable Assembly

Medium Duty MIG Welding Gun

- With sufficient amperage for bigger jobs, the Magnum® PRO 250L is recommended for medium-duty job shop and production applications
- High-quality copper expendable parts ensure superior electrical contact and heat dissipation
- Chrome plated gun tube for enhanced spatter resistance
- Integrated gun connector is designed for POWER MIG® wire feeder/welders



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 216
- POWER MIG® 256

Literature

E12.32

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps)	Duty Cycle [%] (100% CO ₂)	Wire Diameter Range in (mm)
Magnum® PRO 250L	K3081-2	15 (4.5)	250	40	0.025-0.045 [0.6-1.1]

Magnum® PRO Curve™ 200 Series

Compact Industrial Grade Construction

- Two finger trigger for increased operator comfort
- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Curve™ 200 Series	K2950-1	10 (3.0)	200/150	60/60	0.025-3/64 (0.6-1.2)
	K2950-2	15 (4.5)			
Ready-Pak® Package ⁽¹⁾	K2950-2-10-45	15 (4.5)	200/150	60/60	0.025-3/64 (0.6-1.2)

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

Magnum® PRO Curve™ 300 Series

A Step Up on the Curve

- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Dual trigger leads for faster repairs and less downtime
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Curve™ 300 Series	K2951-1	10 (3.0)	300/200	60/60	0.025-5/64 (0.6-2.0)
	K2951-2	15 (4.5)			
	K2951-3	20 (6.1)			
	K2951-4	25 (7.6)			
Dual Procedure (Switch Control)	K3130-1	10 (3.0)	300/200	60/60	0.025-5/64 (0.6-2.0)
	K3130-2	15 (4.5)			
	K3130-3	20 (6.1)			
	K3130-4	25 (7.6)			
Dual Schedule (Trigger Control)	K3092-1	10 (3.0)	300/200	60/60	0.025-5/64 (0.6-2.0)
	K3092-2	15 (4.5)			
	K3092-3	20 (6.1)			
	K3092-4	25 (7.6)			
Ready Pak® Package	K2951-2-6-45 ⁽¹⁾	15 (4.5)	300/200	60/60	0.025-5/64 (0.6-2.0)
	K2951-2-10-45 ⁽²⁾				
	K2951-2-10-116 ⁽³⁾				

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-6 Connector Kit.

⁽²⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

⁽³⁾Includes 0.052-1/16 in. (1.3-1.6 mm) liner and K466-10 Connector Kit

Magnum® PRO Curve™ 400 Series

Get in Front of the Curve

- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Dual trigger leads for faster repairs and less downtime
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Curve™ 400 Series	K2952-1	10 (3.0)	400/400	60/50	0.025-5/64 (0.6-2.0)
	K2952-2	15 (4.5)			
	K2952-3	20 (6.1)			
	K2952-4	25 (7.6)			
Dual Procedure (Switch Control)	K3098-1	10 (3.0)	400/400	60/50	0.025-5/64 (0.6-2.0)
	K3098-2	15 (4.5)			
	K3098-3	20 (6.1)			
	K3098-4	25 (7.6)			
Dual Schedule (Trigger Control)	K3093-1	10 (3.0)	400/400	60/50	0.025-5/64 (0.6-2.0)
	K3093-2	15 (4.5)			
	K3093-3	20 (6.1)			
	K3093-4	25 (7.6)			
Short Neck	K3055-1	10 (3.0)	400/400	60/50	0.025-5/64 (0.6-2.0)
	K3055-2	15 (4.5)			
	K3055-3	20 (6.1)			
	K3055-4	25 (7.6)			
Ready-Pak® Package ⁽¹⁾	K2952-2-10-45	15 (4.5)	400/400	60/50	0.025-5/64 (0.6-2.0)

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

Magnum® PRO Barrel 250 Gun

Compact Industrial Grade Construction

- Built for extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Aircraft grade aluminum gun tube for extended service life
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Barrel 250 Gun	K2651-1	10 (3.0)	250/250	100/100	0.035-5/64 (0.9-2.0)
	K2651-2	15 (4.5)			
	K2651-3	20 (6.1)			
	K2651-4	25 (7.6)			
Ready-Pak® Package ⁽¹⁾	K2651-2-6-45	15 (4.5)	250/250	100/100	0.035-0.045 (0.9-1.2)

⁽¹⁾Includes 0.035-0.045 liner and K466-6 connector kit

Magnum® PRO Barrel 350 Gun

Step up to More Applications

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Barrel 350 Gun	K2652-1	10 (3.0)	350/285	100/100	0.035-5/64 (0.9-2.0)
	K2652-2	15 (4.5)			
	K2652-3	20 (6.1)			
	K2652-4	25 (7.6)			
Dual Procedure (Switch Control)	K3131-1	10 (3.0)	350/285	100/100	0.035-5/64 (0.9-2.0)
	K3131-2	15 (4.5)			
	K3131-3	20 (6.1)			
	K3131-4	25 (7.6)			
Dual Schedule (Trigger Control)	K3132-1	10 (3.0)	350/285	100/100	0.035-5/64 (0.9-2.0)
	K3132-2	15 (4.5)			
	K3132-3	20 (6.1)			
	K3132-4	25 (7.6)			
Ready-Pak® Package ⁽¹⁾	K2652-2-10-45	15 (4.5)	350/285	100/100	0.035-0.045 (0.9-1.2)

⁽¹⁾Includes 0.035-0.045 in. liner and K466-10 connector kit

Magnum® PRO Barrel 450 Gun

Tackle Just About Any MIG
or Flux-Cored Job

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Barrel 450 Gun	K2653-1	10 (3.0)	450/325	100/100	0.035-5/64 (0.9-2.0)
	K2653-2	15 (4.5)			
	K2653-3	20 (6.1)			
	K2653-4	25 (7.6)			
Dual Procedure (Switch Control)	K3133-1	10 (3.0)	450/325	100/100	0.035-5/64 (0.9-2.0)
	K3133-2	15 (4.5)			
	K3133-3	20 (6.1)			
	K3133-4	25 (7.6)			
Dual Schedule (Trigger Control)	K3134-1	10 (3.0)	450/325	100/100	0.035-5/64 (0.9-2.0)
	K3134-2	15 (4.5)			
	K3134-3	20 (6.1)			
	K3134-4	25 (7.6)			
Ready-Pak® Package ⁽¹⁾	K2653-2-10-45	15 (4.5)	450/325	100/100	0.035-0.045 (0.9-1.2)

⁽¹⁾Includes 0.035-0.045 in. liner and K466-10 connector kit

Magnum® PRO Barrel 550 Gun

Designed for High Amperage Welding

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ / Mixed	Duty Cycle (%) CO ₂ / Mixed	Wire Diameter Range in (mm)
Magnum® PRO Barrel 550 Gun	K2655-1	10 (3.0)	550/375	100/100	0.035-1/8 (0.9-3.2)
	K2655-2	15 (4.5)			
	K2655-3	20 (6.1)			
	K2655-4	25 (7.6)			
Dual Procedure (Switch Control)	K3135-1	10 (3.0)	550/375	100/100	0.035-1/8 (0.9-3.2)
	K3135-2	15 (4.5)			
	K3135-3	20 (6.1)			
	K3135-4	25 (7.6)			
Dual Schedule (Trigger Control)	K3136-1	10 (3.0)	550/375	100/100	0.035-1/8 (0.9-3.2)
	K3136-2	15 (4.5)			
	K3136-3	20 (6.1)			
	K3136-4	25 (7.6)			

Magnum® Welding Guns

Classic Gas-Shielded Guns

- Comfortable curved handle design
- Available in a number of amperage ranges and gun cable lengths
- Rotating gun tube and gun hanger clip
- Rated at 60% duty cycle



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.10

Product Name	Cut Length ft (m)	Wire Diameter, in (mm)											
		0.025-0.035 (0.6-0.9)			0.035-0.045 (0.9-1.2)			0.052-1/16 (1.3-1.6)			1/16-5/64 (1.6-2.0)		
		Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package

Magnum® Guns Series

100L	10 (3.0)			K530-5			K530-3 (FCAW-SS only)						
				K530-6 ⁽¹⁾									
200	10 (3.0)				K497-2								
	15 (4.5)				K497-1	K498-1	K497-21 ⁽²⁾						
300	10 (3.0)				K470-1								
	15 (4.5)				K470-2		K1802-1 ⁽²⁾	K470-4			K470-6		
400 Standard	10 (3.0)				K471-1								
	15 (4.5)				K471-2	K479-2	K2286-1 ⁽²⁾ K471-21 ⁽³⁾	K471-4	K479-4	K471-22 ⁽³⁾	K471-6	K479-6	
	20 (6.1)				K471-10			K471-11					
	25 (7.6)				K471-13			K471-14			471-15		
400 Dual Schedule	15 (4.5)								K575-2				
400 Dual Procedure	15 (4.5)				K1722-2								
400 Short Neck	15 (4.5)				K541-3								
450WC	15 (4.5)						K684-12 ⁽⁴⁾			K684-12 ⁽⁴⁾		K684-12 ⁽⁴⁾	
550	15 (4.5)							K598-7			K598-11 ⁽⁵⁾		

Magnum 100L » ⁽¹⁾Includes 4-pin MS-Type connection for trigger control

Magnum 200 » ⁽²⁾Includes K466-1 Connector Kit

Magnum 300 » ⁽³⁾Includes K466-10 Connector Kit

Magnum 400 Standard » ⁽²⁾Includes K466-1 Connector Kit ⁽³⁾Includes K466-10 Connector Kit

Magnum 450WC » ⁽⁴⁾0.035-1/16 in. (0.9-1.6 mm) Solid Wire, 0.045-5/64 in. (1.2-2.0 mm) Flux-Cored Wire

Magnum 550 » ⁽⁵⁾600A Open End 5/64-3/32 in. (2.0-2.4 mm) Solid Wire

Magnum® PRO Fume Guns

Production-Ready Source Fume Extraction

- Rated at 100% duty cycle
- Innovative strain relief swivels to take pressure off the operator's wrist
- Four standard trigger leads
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Select the more compact 350 amp model or the high amperage 550 amp model for thicker materials



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.02

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Fume Gun 350 [Ⓛ]	K2649-1	15 (4.5)	350/285	100/100	0.035-5/64 (0.9-2.0)
Magnum® PRO Fume Gun 550 [Ⓛ]	K2650-1	15 (4.5)	550/375	100/100	0.035-1/8 (0.9-3.2)

[Ⓛ]Recommended with X-Tractor® 3A, 5A, and 8A. See Weld Fume Control Section for other Fume Extraction attachments and accessories.

K126™ PRO

The Leader in Construction Welding Guns

- Replaceable liner
- Interchangeable gun connectors expand compatibility with a wide range of feeders
- Integrated trigger leads in coaxial cable resists job site abrasion
- Stainless steel gun tube jacket and plated steel strain relief resist spatter and extend life
- Available with a variety of reverse and non-reverse gun tube jackets



Processes

- Flux-Cored Self-Shielded

Literature

E12.111

Product Name	Product Number	Gooseneck Angle	Gun Connector Power Pin	Amperage Rating 60% Duty Cycle	Wire Diameter Range in (mm)	Cable Length ft (m)
K126™ PRO	K126-10	62°	Lincoln Electric K613-6	350	0.035-0.120 (0.9-3.0)	10 (3.0)
	K126-11					15 (4.5)
	K126-12		Tweco #4 K466-10			
	K126-13	30°	Lincoln Electric K613-6			

Innershield® Guns

Classic Flux-Cored Self-Shielded Guns

- A number of models are offered for amperage ratings from 350 to 600 amps
- Rated at 60% duty cycle



Processes

- Flux-Cored Self-Shielded

Literature

E12.110

Product Name	Rated Current @ 60% Duty Cycle	Length ft (m)	Feeding Capability – Wire Diameter, in (mm)								Tube Angle
			0.062 (1.6)	1/16 (1.6)	0.068 (1.7)	0.072 (1.8)	5/64 (2.0)	3/32 (2.4)	7/64 (2.8)	0.120 (3.0)	
K126-1 Classic	350A	10 (3.0)	•	•	•	•	•	•			62°
K126-2 Classic		15 (4.5)	•	•	•	•	•				
K345-10		10 (3.0)			•	•	•				90°
K115-1	450A	10 (3.0)							•	•	82°
K115-2		15 (4.5)							•	•	
K115-3		10 (3.0)						•			
K115-4		15 (4.5)						•			
K115-8		15 (4.5)							•	•	45°
K115-10	15 (4.5)						•				
K116-2	600A	15 (4.5)							•	•	Straight

Submerged Arc Guns

For Hand-held Submerged Arc Applications

- Suitable for 5/64 and 3/32 in. (2.0 and 2.4 mm) wire diameters
- Ideal for submerged arc short welds or seams with poor fit up best address by an operator
- Rated 600 amps



Processes

- Submerged Arc

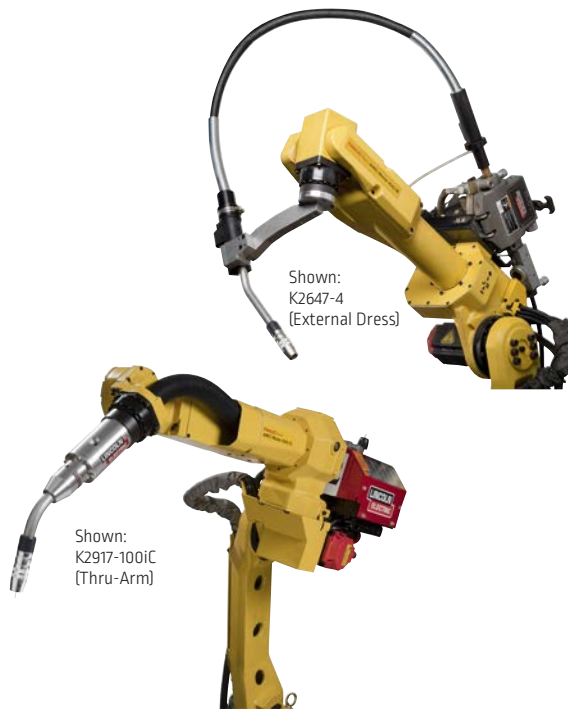
Literature

Product Name	Product Number	Rated Current (Amps)	Wire Diameter Range in (mm)	Cable Length ft (m)
Submerged Arc Gun	K113-1	600	5/64 (2.0)	15 (4.5)
	K113-2	600	3/32 (2.4)	15 (4.5)
Mechanized Submerged Arc Gun	K114	600	5/64-3/32 (2.0-2.4)	15 (4.5)

Magnum® PRO Robotic Guns

External Dress and Thru-Arm Torches

- No need to recalibrate TCP when switching between 350 amp and 550 amp torch expendable parts
- Cables exceed industry standards by a factor of two in durability testing
- 350A and 550A rated consumables are interchangeable across all gun models
- HexConnect™ full face contact gun bushing ensures better electrical conductivity
- Extended reach mounting bracket optimizes clearance for tough-to-reach welding applications



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.03

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps)	Duty Cycle [%] (100% CO ₂)	Wire Diameter Range in (mm)
EXTERNAL DRESS GUN (AIR-COOLED)					
Magnum® PRO Robotic 550	K2647-4	4 (1.2)	550	100	0.035-5/64 (0.9-2.0)
	K2647-5L	5.5 (1.7)			
	K2647-8	8 (2.4)			
	K2647-11	11 (3.3)			
THRU-ARM GUN (AIR-COOLED)					
Magnum® PRO Robotic 550	K3353-100iC	Predetermined length per robotic arm selection	550	100	0.035-5/64 (0.9-2.0)
Fanuc® 100iC Ready-Pak®	K3359-100iC				
w/Air Blast®	K3359-100iCA				
w/Wire Brake	K3359-100iCW				
Fanuc® 120iC Ready-Pak®	K3359-120iC				
w/Air Blast	K3359-120iCA				
w/Wire Brake	K3359-120iCW				
Fanuc® 100iC/6L Ready-Pak®	K3359-100iC/6L				
w/Air Blast	K3359-100iC/6LA				
w/Wire Brake	K3359-100iC/6LW				
Fanuc® 120iC/10L Ready-Pak®	K3359-120iC/10L				
w/Air Blast	K3359-120iC/10LA				
w/Wire Brake	K3359-120iC/10LW				

Magnum® PRO 100SG Spool Gun

Precise Feeding Performance

- Lightweight and easy to use
- Ergonomic grip and balanced design
- Excellent trigger feedback, even through a welding glove
- No bulky adapter module required
- Premium Magnum® PRO expendable gun parts improve heat dissipation and extend life



Processes

- MIG

Literature

E12.20

Product Name	Product Number	Length ft (m)	Wire Size Range in (mm)	Rated Current/ Duty Cycle	Machine	Adapter
Magnum® PRO 100SG	K3269-1	10 (3.0)	0.030-0.035 (0.8-0.9)	130A/30%	POWER MIG® 140C POWER MIG® 180C POWER MIG® 180 Dual POWER MIG® 210 MP POWER MIG® 216	None

Magnum® SG Spool Gun

Full-Control Wire Feeding

- Large handle and trigger for easy use with gloved hands
- Clear spool gun drive cover makes it easy to check the wire drive path
- Rugged nozzle designed to withstand harsh industrial environments
- 250 amp rating and generous 25 ft (7.5 m) gun cable



Processes

- MIG

Literature

E12.22

Product Name	Product Number	Length ft (m)	Wire Size Range in (mm)	Rated Current/ Duty Cycle	Machine	Adapter
Magnum® SG Spool Gun	K487-25	25 (7.5)	.025-3/64 (0.6-1.2)	250A/60%	POWER MIG® 216	K2703-1
					POWER MIG® 256	K2445-1

Magnum® 250LX™ Spool Gun

Professional Grade Durability and Performance

- Adjust wire speed remotely at the gun for fewer trips back to the power source
- Adjustment-free spool brake automatically prevents wire tangles
- 280 amp rating and generous 25 ft (7.5 m) gun cable
- Tool-less drive tension makes fine adjustment easy



Processes

- MIG
- Pulsed

Literature

E12.25

Product Name	Product Number	Length ft (m)	Wire Size Range in (mm)	Rated Current/ Duty Cycle	Machine	Adapter
Magnum® 250LX™ Spool Gun	K2490-1	25 (7.5)	.025-3/64 (0.6-1.2)	CO ₂ : 300A/60% Ar : 280A/60% Ar : 200A/100%	POWER MIG® 216	None
					POWER MIG® 256	None
					POWER MIG® 350MP	K2703-1
					Power Wave® C300	K2910-1

Cougar™ Pistol-Grip Air-Cooled Push-Pull Guns

Comfortable Grip. Industrial Performance.

- Fatigue-reducing design is intended for operators who prefer an upright pistol-grip
- Premium Magnum® PRO expendable gun parts improve heat dissipation and extend life
- Tool-less Drive Roll Changes – Our slip-fit dual-groove drive rolls install without tools and feature a D-contour to prevent unwanted spinning



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.16

Product Name	Product Number	Current Rated Current 100% Argon	Wire Diameter Range in (mm)	Cable Length ft (m)
Cougar™ Pistol-Grip Air-Cooled Guns	K2704-2	300A @ 60% Duty Cycle	0.035-1/16 (0.9-1.6)	25 (7.6)
	K2704-3			50 (15.2)

Magnum® PRO AL Air-Cooled Push-Pull Guns

Superior Features. Superior Feeding for Aluminum.

- Just remove a single set screw to easily remove the Quick-Change™ liner
- Uses Magnum® PRO expendables common with all of our other Magnum® PRO MIG guns
- Recessed adjustment dial is located at the bottom of the handle to prevent a change while welding
- EZ-Lock™ system allows you to change or rotate barrels anytime



Processes

- MIG
- Pulsed MIG

Output



Input



Literature

E12.14

Product Name	Product Number 12-Pin	Product Number 7-Pin	Current Rated Current 100% Argon	Wire Diameter Range in (mm)	Cable Length ft (m)
Magnum® PRO AL G225A Air-Cooled Guns					
Front Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip)	K3420-1	K3421-1	225A @ 60% Duty Cycle	0.035-1/16 (0.9-1.6) aluminum and cored wire	15 (4.6)
	K3420-2	K3421-2			25 (7.6)
	K3420-3	K3421-3			35 (10.7)
	K3420-4	K3421-4			50 (15.2)
Rear Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip)	K3355-1	K3356-1	225A @ 60% Duty Cycle	0.035-1/16 (0.9-1.6) aluminum and cored wire	15 (4.6)
	K3355-2	K3356-2			25 (7.6)
	K3355-3	K3356-3			35 (10.7)
	K3355-4	K3356-4			50 (15.2)

Magnum® PRO AL Water-Cooled Push-Pull Guns

Superior Features. Superior Feeding for Aluminum.

- Just remove a single set screw to easily remove the Quick-Change™ liner
- Uses Magnum® PRO expendables common with all of our other Magnum® PRO MIG guns
- Recessed adjustment dial is located at the bottom of the handle to prevent a change while welding
- EZ-Lock™ system allows you to change or rotate barrels anytime



Processes

- MIG
- Pulsed MIG

Output



Input



Literature

E12.14

Product Name	Product Number 12-Pin	Product Number 7-Pin	Current Rated Current 100% Argon	Wire Diameter Range in (mm)	Cable Length ft (m)
Magnum® PRO AL G450W Water-Cooled Guns					
Front Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3422-1	K3423-1	450A @ 60% Duty Cycle	0.035-1/16 (0.9-1.6) aluminum and cored wire	15 (4.6)
	K3422-2	K3423-2			25 (7.6)
	K3422-3	K3423-3			35 (10.7)
	K3422-4	K3423-4			50 (15.2)
Rear Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3357-1	K3358-1	450A @ 60% Duty Cycle	0.035-1/16 (0.9-1.6) aluminum and cored wire	15 (4.6)
	K3357-2	K3358-2			25 (7.6)
	K3357-3	K3358-3			35 (10.7)
	K3357-4	K3358-4			50 (15.2)

PTA-9 Series

Compact Low-Amperage Air-Cooled Torch

- Great choice for low amperage applications
- Available as a basic fixed head torch or also with Ultra-Flex cable for added maneuverability
- Rated 125 amps at 60% duty cycle



Processes

- TIG

Literature

E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in [mm]	Length ft (m)	Number of Cables
Air-Cooled TIG Torches					
PTA-9	K1781-1	125A @ 60%	0.020-1/8 (0.5-3.2)	12.5 (3.8)	1
	K1781-3			25.0 (7.6)	
PTA-9F Ultra-Flex™	K1781-9 ⁽¹⁾	125A @ 60%	0.020-1/8 (0.5-3.2)	12.5 (3.8)	1

⁽¹⁾Pre-configured package with K1622-1 Twist Mate™ adapter and 1/16 in. (1.6 mm) gas lens collet body, collet and gas lens installed

PTA-17 Series

Your Go-To Air-Cooled TIG Torch

- Industrial TIG torch commonly used for a great number of applications
- Available in basic fixed head, flexible head, valve, flex head with valve, and fixed head with Ultra-Flex™ cable models
- Rated 150 amps at 60% duty cycle



Processes

- TIG

Literature

E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in [mm]	Length ft (m)	Number of Cables
Air-Cooled TIG Torches					
PTA-17	K1782-1	150A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1782-2			12.5 (3.8)	2
	K1782-3			25.0 (7.6)	1
	K1782-4			25.0 (7.6)	2
PTA-17F	K1782-10	150A @ 60%	0.020-5/32 (0.5-4.0)	25.0 (7.6)	1
PTA-17FV	K1782-13	150A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1782-11			25.0 (7.6)	1
PTA-17V	K1782-6	150A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1782-7			12.5 (3.8)	2
	K1782-8			25.0 (7.6)	1
	K1782-9			25.0 (7.6)	2
PTA-17 Ultra-Flex™	K1782-12	150A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
PTA-17F Ultra-Flex™	K1782-15	150A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
PTA-17F Ultra-Flex™ Ready-Pak ⁽¹⁾	K1782-14				

⁽¹⁾PTA-17 TIG Torch Ready-Pak® Includes: 150 Amp Air-Cooled Torch Package with Flexible Head and 12.5 ft. (3.8 m) Ultra-Flex™ Cable Assembly with Twist-Mate™ Adapter. Includes: #7 Nozzle, 1/16 in. (1.6 mm) and 3/32 in. (2.4 mm) Collets, Collet Bodies and E3® Tungsten

PTA-26 Series

High Amperage Air-Cooled TIG Torch

- High amperage air-cooled industrial TIG torch typically used for thicker materials
- Available in basic fixed head, flexible head, valve, and flex head with valve models



Processes
· TIG

Literature
E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in (mm)	Length ft (m)	Number of Cables
Air-Cooled TIG Torches					
PTA-26	K1783-1	200A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1783-2			12.5 (3.8)	2
	K1783-3			25.0 (7.6)	1
	K1783-4			25.0 (7.6)	2
PTA-26F	K1783-10	200A @ 60%	0.020-5/32 (0.5-4.0)	25.0 (7.6)	1
PTA-26FV	K1783-11	200A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	1
				25.0 (7.6)	1
PTA-26V	K1783-7	200A @ 60%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	2
	K1783-8			25.0 (7.6)	1
	K1783-9			25.0 (7.6)	2

PTW-20

Premium Water-Cooled TIG Torch for Most Applications

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control



Processes
· TIG

Literature
E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in (mm)	Length ft (m)	Number of Cables
Water-Cooled TIG Torches					
PTW-20	K1784-3	250A @ 100%	0.020-1/8 (0.5-3.2)	12.5 (3.8)	3
	K1784-4			25.0 (7.6)	

PTW-18

Premium High Amperage Water-Cooled TIG Torch

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control



Processes
· TIG

Literature
E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in (mm)	Length ft (m)	Number of Cables
Water-Cooled TIG Torches					
PTW-18	K1784-1	350A @ 100%	0.020-5/32 (0.5-4.0)	12.5 (3.8)	3
	K1784-2			25.0 (7.6)	

20H-320-25R**Premium High Amperage Water-Cooled
TIG Torch Package**

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control
- 320 Amps of capacity through industry standard 20 series front end torch design
- Includes premium cable cover

**Processes**

- TIG

Literature

E12.150

Product Name	Product Number	Rated Current/ Duty Cycle	Tungsten Range in (mm)	Length ft (m)	Number of Cables
20H-320-25R	K4168-2	320A @ 100%	0.020-1/8 (0.5-3.2)	25 (7.6)	3

Specifications Chart

Pro-Torch™ TIG Torches Adapters

Model	Adapter Product No.
For Precision TIG® 275 and 375 Power Sources	
PTA-26, 26V, 26F, 26FV (one-piece power cable)	K2166-1
PTA-9, 9F, 17F, 17V, 17FV (one-piece power cable)	K2166-3
PTA-17V, -26V (one-piece power cable)	K2166-2
PTW-18, 20 and 20H-320	None required
For Power Sources with 1/2 in Output Terminals (including TIG Module)	
PTW-18, 20 and 20H-320	K2505-2, K1622-4
PTA-26, 26F, 26V, 26FV (one-piece cable)	K2505-2, K1622-3
PTA-9 (one-piece cable)	K2505-2, K1622-1
PTA-17V, 26V (two-piece cable)	None required
For Square Wave® TIG 175, Square Wave® TIG 200, Precision TIG® 225, Invertec® V160-T, Aspect® 375 and Power Sources with Twist Mate™ Receptacle (w/Gas Pass Through)	
PTA-9, -9F, 17, 17F, 17V, 17FV (one-piece cable)	K1622-1
PTW-18, 20 and 20H-320	K1622-4, K1622-5 ⁰¹
PTA-26, 26V, 26F, 26FV (one-piece cable)	K1622-3
For Power Sources with Tweco-Style Output Terminal and Separate Gas	
PTW-18, 20, 20H-320	K1622-6
PTA-17V, 17VF (one-piece cable)	K960-4
PTA-26V, 26FV (one-piece cable)	K960-3
For Power MIG® 210 MP and Power Sources with Twist Mate™ Receptacle and Separate Gas	
PTA-17V, 17FV (one-piece cable)	K960-1
For Invertec® V155-S and Power Sources with Small Twist Mate™ Receptacle and Separate Gas	
PTA-17V, 17FV (one-piece cable)	K960-2

⁰¹Recommended for the Aspect® 375



CUTTING SYSTEMS

HAND-HELD PLASMA CUTTERS » Tomahawk® 375 Air · Tomahawk® 625 · Tomahawk® 1000 · Tomahawk® 1500

CNC PLASMA CUTTING SYSTEMS » FlexCut® 80 · FlexCut® 125 · Torchmate® X Series · Torchmate® TMX PRO · Torchmate® 4400/4800 · Spirit® II High Definition Plasma Cutting Systems · Burny® Shape Cutting Controllers · Software and Accessories for CNC Cutting Systems

CNC TUBE & PIPE CUTTING SYSTEMS » MASTERPIPE® Mini Profiler · MASTERPIPE® Profiler · MASTERTUBE® Cutter · VERNON® Abrasive Saw

ROBOTIC CNC STRUCTURAL STEEL PLASMA CUTTING SYSTEM » PythonX® II

Tomahawk® 375 Air

Plasma Cutting with Built-In Air

- Rated for up to 3/8 in. (9.5 mm) max cuts
- Internal air compressor enables operation in environments where external compressed air is not available
- Extremely portable at only 40 lbs. (18 kg)
- Touch Start™ system delivers reliable plasma arc initiation without high frequency
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc



Processes

- Plasma Cutting

Output



Input



Literature

E11.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
Tomahawk® 375 Air	K2806-1	208/230/1/60	13A @ 85.2V 100% 18A @ 87.2V 60% 25A @ 90V 35%	21.7A Pilot Current: 17A	10-25A	80-110 PSI (6.0-7.5 Bar)	70 psi @ 125-200 SCFH 5 Bar @ 80L/min	15.2 x 8.5 x 18.9 (385 x 215 x 480)	40 (18)

Tomahawk® 625

Plasma Cutting that Gets Around

- Rated for up to 5/8 in. (15.9 mm) max cuts
- Efficient electrode and nozzle design save money in the long run
- Compatible with Lincoln Electric Ranger® or Vantage® engine drives
- Touch Start™ system delivers reliable plasma arc initiation without high frequency
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc
- CNC cutting compatible - machine torch available



Processes

- Plasma Cutting

Output



Input



Literature

E11.200

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
Tomahawk® 625 w/Hand Torch	K2807-1	208/230/1/50/60	24A @ 89.6V 100% 29A @ 91.8V 60% 40A @ 96.0V 35%	36.8A Pilot Current: 17A	10-40A	80-110 PSI (6.0-7.5 Bar)	70 psi @ 125-200 SCFH 5 Bar @ 80L/min	15.2 x 8.5 x 18.9 (385 x 215 x 480)	34 (15.4)

Tomahawk® 1000

Plasma Cutting for Production Capacity

- Rated for up to 1 in. (25.4 mm) max cuts
- Touch Start™ system assures reliable arc initiation without generating disruptive high-frequency radio waves
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc
- CNC cutting compatible - machine torch available



Processes

- Plasma Cutting

Output



Input



Literature

E11.300

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
Tomahawk® 1000 w/Hand Torch	K2808-1	208/230/380-415/460/575/1/3/50/60	3-Ph / 50% Duty Cycle: 24.6/21.1/11.4/9.3/7.6 3-Ph / 100% Duty Cycle: 17.4/14.9/7.3/6.6/5.4 1-Ph / 50% Duty Cycle: 26.7/24.3/NA/NA/NA 1-Ph / 100% Duty Cycle: 37.8/34.3/NA/NA/NA	37.8 (Max.) Pilot Current: 20A	20-60A	87-109 PSI (6.0-7.5 Bar)	80 psi @ 275 SCFH 5.5 Bar @ 130L/min.	15.2 x 8.5 x 22.1 (385 x 215 x 561)	62 (28.1)

Tomahawk® 1500

Heavy-Duty, 100 Amps, 60% Duty Cycle

- Hand held cutting up to 1 1/4 in (31.75 mm)
- Virtually dross-free cuts reduce parts clean-up
- Reliable arc starting without high frequency
- PowerConnect® Technology for automatic voltage sensing



Processes

- Plasma Cutting
- Gouging

Output



Input



Literature

E11.400

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Gas Pressure Required	Gas Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
Tomahawk® 1500	K2809-1	200-208/230/380/460/575/3/50/60	60A/140V/100% 80A/140V/80% 100A/140V/60%	3PH/100% : 31/28/16/14/12 3PH/80% : 41/37/21/18/14 3PH/60% : 49/43/27/22/18	5-100A	87 to 109 PSI (6.0-7.5 Bar)	380 SCFH @ 80 PSI 180 SLPM @ 5.5 Bar	17.9 x 11.8 x 25.4 (455 x 301 x 645)	96 (44)
		230/1/50/60	60A/140V/100% 80A/140V/80%	1PH/100% : 48 1PH/80% : 62	25-80A				
		200-208/1/50/60	60A/140V/100% 80A/140V/60%	1PH/100% : 52 1PH/60% : 71					

Torchmate® 4400 | 4800

4x4 and 4x8 CNC Plasma Cutting Tables

- Exceptional repeatability and performance
- Rapid delivery and set-up time
- Produces up to 65% faster cut speeds
- Standard FlexCut® 80 mechanized plasma cutter already included
- Optional FlexCut® 125 mechanized plasma cutter available as substitute



Processes

- Plasma Cutting
- Plasma Marking

Literature

FlexCut® 80

Heavy-Duty, 80 Amps, 80% Duty Cycle

- Mechanized piercing up to 3/4 in. (19mm)
- Maximize productivity with up to 65% faster cut speeds with less bevel than the competition
- Up to three times longer consumable life
- Reliable arc starting without high frequency
- For mechanized and hand held applications



Processes

- Plasma Cutting
- Gouging

Cutting Type

- Mechanized Cutting
- Hand Cutting

Output



Input



Literature

E11.315

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Gas Pressure Required	Gas Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
FlexCut® 80	K4809-1	200-208/230/380/460/575/3/50/60	60A/140V/100% 80A/140V/80%	3-Ph/100% 31/28/16/14/12 3-Ph/80% 41/37/21/18/14	25-80A	87-109 PSI (6.0-7.5 Bar)	380 SCFH @ 80 psi 180 SLPM @ 5.5 Bar	17.9 x 11.8 x 25.4 (455 x 301 x 645)	96 (44)
		230/1/50/60	60A/140V/100% 80A/140V/80%	1-Ph/100% 48 1-Ph/80% 62					
		200-208/1/50/60	60A/140V/100% 80A/140V/60%	1-Ph/100% 52 1-Ph/60% 71					

FlexCut® 125

Make the Cut with Speed and Power

- Mechanized piercing of 1 in. (25mm)
- Plasma Cutting, Gouging and Marking Capabilities
- Up to 6 times longer consumable life
- Reliable arc starting without high frequency



Processes

- Plasma Cutting
- Marking

Cutting Type

- Mechanized Cutting

Output



Input



Literature

E11.320

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Air Pressure Required	Air Flow Rate	H x W x D in (mm)	Net Wt. lb (kg)
FlexCut® 125	K4811-1	380/400/415/460/ 575/3/50/60	125A/175V/100%	3-Ph/100% 40/40//40/33/28	3-Ph 20-125A	90-120 PSI (6.21-8.27 Bar)	550 SCFH @ 90 psi (260 SLPM @ 6.21 Bar)	20.72 x 12.25 x 25.53 (526 x 311 x 648)	118 (53.5)

NOTE: FlexCut™ 125 only available with the purchase of Torchmate® 4400/4800

Torchmate® X Series

Heavy Duty Cutting Table Systems

- 5,500lb fully assembled water table
- Supports up to 4" mild steel plate
- Pneumatically controlled water level
- Holds three tools (plasma, oxy-fuel, and plate marker)
- Table sizes available from 5x10 to 8x22
- Gantry kits available for reduced cost



Processes

- Plasma Cutting
- Oxyfuel Cutting
- Plasma Marking
- Plate Marking

Input



Literature

Product Name	Cutting Area ⁽¹⁾ ft (m)	Input Power ⁽²⁾ amps/volts	Traverse Speed ⁽²⁾ ipm (m/min)	Cut Speed ⁽²⁾⁽³⁾ ipm (m/min)	Machine Resolution in (µm)	Machine Size (footprint) in (mm)	Net Wt. lb (kg)
TM X Series™ 5X10 Table	5 x 10 (1.5 x 3.0)	15A/110V	up to 500 (12.7)	up to 500 (12.7)	0.0004 (10.16)	92.2 x 154.4 (2,341.9 x 3,921.8)	Approx. 5500 (2,494.8)
TMX-HD 6X10 Table	6 x 10 (1.8 x 3.0) Single tool	10A/220V 20A/110V	up to 550 (13.97)			104.2 x 154.4 (2,646.7 x 3,921.8)	Approx. 4600 (2,086.5)

⁽¹⁾With specific Tool Set (some restrictions apply). ⁽²⁾Multiple control platforms. ⁽³⁾Cut speeds dependant on process.

Torchmate® TMX PRO

Industrial Grade Cutting

- Includes Burny® shape cutting controller with UltraSharp® bolt hole technology, motion control engine, 15 in. (381 mm) touchscreen, multi-tasking and remote diagnostics, a Spirit® II 400 plasma cutting power source, integrated water table and more
- Gantry features heavy wall, precision-planed structural steel and drive components, including a ball screw-driven tool carriage for smooth, vibration free movement
- Table features a dual driven gantry, a hardened helical gear rack and self-cleaning hardened rails



Processes

- Plasma Cutting
- Oxyfuel Cutting
- Plasma Marking

Input



Literature

Product Name	Cutting Area ⁽¹⁾ ft (m)	Input Power ⁽²⁾ amps/volts	Traverse Speed ⁽²⁾ ipm (m/min)	Cut Speed ⁽²⁾⁽³⁾ ipm (m/min)	Machine Resolution in (µm)	Machine Size (footprint) in (mm)	Net Wt. lb (kg)
TMX PRO TMX-PRO 6X10 Table	6 x 10 [1.8 x 3.0] All tools	10A/220V	up to 1000 [25.4]	up to 1000 [25.4]	0.000000 [0.00000]	131.2 x 178.5 [3,332.5 x 4,533.9]	Approx. 8200 [3,719.5]

⁽¹⁾With specific Tool Set (some restrictions apply). ⁽²⁾Multiple control platforms. ⁽³⁾Cut speeds dependant on process.

Spirit® II FineLine® High-Definition Plasma Cutting Systems

Precise Cuts for Downstream-Ready Production

- Spirit® II series plasma cutting power sources provide exceptional pierce, cut and marking capabilities with high definition edge quality of 2 degrees or less of cut edge bevel



Processes

- Plasma Cutting
- Plasma Marking

Output



Input



Literature

- E15.16 (Spirit® II 150)
- E15.15 (Spirit® II 275)
- E15.14 (Spirit® II 400)

Product Name	Product Number	Input Power: Volts/Amps	Rated Output ⁽¹⁾ : Current/Duty Cycle	Mild Steel Production Capacity, in (mm)	Max. Thickness, in (mm) (edge start w/dross)	Gas Supply: Plasma/ Shield/Marking	H x W x D in (mm)	Net Wt. lb (kg)
Spirit® II 150 w/ built-in INOVA®	See Literature	208	150A DC @ 100%	1.25 [32.0]	1.5 [38.0]	O ₂ / O ₂ / Ar	38.4 x 29.0 x 43.2 [975 x 737 x 1097]	953 [432]
		220				O ₂ / Air / Ar		
		240						
Spirit® II 275 w/ built-in INOVA®		380	275A DC @ 100%	1.5 [38.0]	2.5 [65.0]	Air / Air / Ar	38.4 x 29.0 x 43.2 [975 x 737 x 1097]	1270 [576]
		400				Air / N ₂ / Ar		
		415						
Spirit® II 400 w/ built-in INOVA®		440	400A DC @ 100%	2.0 [50.0]	3.0 [75.0]	H17 ⁽²⁾ / N ₂ / Ar	39.9 x 34.2 x 49.5 [1013 x 869 x 1257]	1922 [872]
		480						
		600						

⁽¹⁾@ 104°F [40°C] ⁽²⁾H17=50% N₂ , 32.5% Ar , 17.5% H₂

Burny® Shape Cutting Controllers

Advanced Motion Control

- Phantom® II and Phantom® ST II shape cutting controllers feature an intuitive touchscreen display and the ability to control 2 plasma stations, 6 oxyfuel stations, 1 marker and multiple auxiliary functions



Processes

- Plasma Cutting
- Plasma Marking

Output



Input



Literature

- E15.45 (Phantom® II)
- E15.46 (Phantom® ST II)

Software and Accessories for CNC Cutting Systems

Programs and Peripheral Equipment to Augment and Enhance Your Cutting Processes

- Torch height control, oxyfuel accessories, plate marking systems, appropriate computers and torch holders
- Training is available at our site or yours to be sure your team understands how to operate and maintain your system
- New AccuMove™ 2 driver software makes fast work of part set up, and our compatibility with a number of CAD-CAM programs allow accurate file imports



Literature

MASTERPIPE™ Mini Profiler

Economical CNC Pipe Cutting Solution

- Two-axis pipe cutting and profiling with outside diameter of 2-8 in. (51-203 mm) and length up to 25 ft (7.6 m) and 1000 lbs (454 kg) weight.
- One button moves the torch carriage so material can be safely loaded, positioned for cutting and unloaded
- Modular design allows you to start with a five foot bed and add five foot extensions up to 25 feet (7.6 m)
- Optional Arc Voltage Height Control provides consistent plasma cut quality and arc length for cleaner cuts on tube and pipe that may be out of round



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

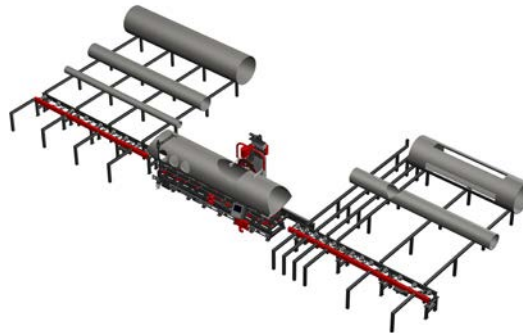
Product Name	Input Power Voltage/Phase/Hertz	Pipe Capacity: Diameter, in (mm)	Pipe Capacity: Weight, lb (kg)	Cutting Speed ⁽¹⁾ ipm (m/min)	H x W x D ft (m)	Net Wt. lb (kg)
MASTERPIPE™ Mini Profiler Base 5 ft. Section	120/1/60	OD: 1.0-8.0 (25.4-203.2) (recommended production)	1000 (453.59) max. 700 lb/ft (317.5 kg/m)	200 (5.1) max. (depending on cutting tool)	52 x 28 x 92 (15.85 x 8.53 x 28.04)	1000 (453.6)
Base 5 ft. Expansion					37 x 23 x 63 (11.28 x 7.01 x 19.20)	Dependent on Configuration

⁽¹⁾Dependent on system configuration and material being cut.

MASTERPIPE™ Profiler

Simple, Accurate Cuts Every Time

- Ideal for process and power piping, mechanical and HVAC contracting, shipbuilding, offshore, structural pipe trusses and pressure vessel fabrication
- Servo-driven systems engage for loading/unloading, support and rotate pipe during cutting, position the torch for precise profiling and compensate for out-of-round pipe
- Reusable part-cutting programs are created at the machine, remote PC or from popular 3D pipe modeling programs
- Unlike chucking machines, the MPM fully supports the pipe and remnant offering safe, simple operation and more efficient material handling.



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

Product Name	Input Power Voltage/Phase/Hertz	Pipe Capacity: Diameter, in (mm)	Pipe Capacity: Weight, lb (kg)	Cutting Speed ⁽¹⁾ ipm (m/min)	H x W x D ft (m)	Net Wt. lb (kg)
MASTERPIPE™ Profiler	120/1/60	OD: 1.0-12 in.	600 (272.2) max.	200 (5.1) max.	6 x 12 x 4 (1.83 x 3.66 x 1.22)	2500 (1134)
		Length up to: 40 ft (12.2 m)	50 lb/ft max (22.7 kg/m)			

⁽¹⁾Dependent on system configuration and material being cut.

MASTERTUBE™ Plasma Profiler MTC

High Performance Square, Rectangular and Round Pipe and Tube Cutting

- Ideal for space frames, handrails, safety guards, recreational structures and automotive aftermarket components
- Plasma cutting system offers immediate ignition and excellent cut quality on carbon, stainless and non-ferrous materials
- Programming and operation are simple with the WinMPM™ software, using menus and simple graphical icons to make saddle miter, multiple intersection and centerline offset cuts as well as circular and rectangular holes



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

VERNON Abrasive Saw

Speed, Simplicity, Quality

- Abrasive wheels cut and bevel all types of materials from 2-24 in. (50.8-609.6 mm)
- Ideal for pipe and supply warehouses, mechanical contractors, HVAC fabricators and other industries
- Integrated pipe conveyors permit one person to load and unload pipe from either direction, improving safety and lowering cycle times
- Yields a "machined"-like uncontaminated surface ready for immediate fit-up and welding



Processes

- Abrasive Cutting

Input



Literature

PythonX® II

Robotic CNC Plasma Cutting System for Structural Steel Fabrication

- Replaces drill line, bandsaw, angle line, plate/bar line, coping machine, marking machine, burning machine
- Makes all cuts and features in one pass
- Cut floorspace, time and investment by 80% compared to the 7 conventional processes it replaces



Processes

- Plasma Cutting

Output



Input



Literature

DESIGN | CUT | WELD



Now you can have all the tools you need to make your fabrication projects come to life—from one brand. The new Torchmate® 4400 and 4800 cutting tables give you to 65% faster cut speeds, improved cut quality, and exceptional repeatability.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Tomahawk® 375 Air

Base Model (K2806-1)

- Internal air compressor (external air connection also standard)
- LC25 Torch with 10 ft. (3.0 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Shoulder strap
- Input power cord

Tomahawk® 625

Base Model (K2807-1)

- LC40 Hand Torch, 20 ft. (6.0 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Shoulder strap
- Input power cord

Tomahawk® 1000

Hand Torch Base Model (K2808-1)

- LC65 Hand Torch with 25 ft. (7.5 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Input power cord

Tomahawk® 1500

Base Model (K2809-1)

- LC105 Hand Torch 25 ft. (7.6 m) (K2849-1)
- Consumable Starter Kit for LC105 Torch
- Work Clamp and Cable
- Air Regulator and Pressure Gage
- Input Power Cord

One-Pak® Package (K3477-1)

- LC105 Hand Torch 25 ft. (7.6 m) (K2849-1)
- Consumable Starter Kit for LC105 Torch

One-Pak® Package (K3477-2)

- LC105 Hand Torch 50 ft. (15.2 m) cable
- Consumable starter kit

Torchmate® 4400|4800

Includes

- Fully assembled dual-tool CNC plasma cutting table with full 4x4 or 4x8 tool reach
- FlexCut® 80 plasma cutter
- Water table fume extraction
- Arc-voltage digital height control
- Industrial touch screen HMI
- Preinstalled Torchmate CAD/CAM design software
- Consumable starter kit
- Input power cord

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

FlexCut® 80

Base Model (K4809-1)

- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Input power cord

One-Pak® Package (K4139-3)

- FlexCut® 80 (K4809-1)
- Consumable Starter Kit for LC105M Torch
- LC105M Machine Torch w/25 ft. (7.6 m) Lead Cable (K2849-3)

One-Pak® Package (K4139-4)

- FlexCut® 80 (K4809-1)
- Consumable Starter Kit for LC105M Torch
- LC105M Machine Torch w/50 ft. (15.2 m) Lead Cable (K2849-4)

FlexCut® 125

Base Model (K4811-1)

- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Input power cord

One-Pak® Package (K4327-3)

- FlexCut™ 125 (K4811-1)
- Consumable Starter Kit
- LC125M Machine Torch w/25 ft. (7.6 m) Lead Cable (K4300-4)

One-Pak® Package (K4327-4)

- FlexCut™ 125 (K4811-1)
- Consumable Starter Kit for Mechanized Cutting
- LC125M Machine Torch with 50 ft. (15.2 m) Lead Cable (K4300-5)

One-Pak® Package (K4327-5)

- FlexCut™ 125 (K4811-1)
- Consumable Starter Kit for Mechanized Cutting
- LC125M Machine Torch with 75 ft. (22.9 m) Lead Cable (K4300-6)

Accessories » Tomahawk® Plasma Cutters

Product Name	Product No.	Tomahawk® 375 Air		Tomahawk® 625		Tomahawk® 1000		Tomahawk® 1500	
		Base Model	Base Model Hand Torch	Base Model Hand Torch	Base Model Hand Torch	Base Model Mechanized	Base Model Hand Torch	Base Model Hand Torch	Base Model Hand Torch
		K2806-1	K2807-1	K2808-1	K2808-2	K2809-1			

EXPENDABLE PARTS – STANDARD CUTTING

Electrode (LC25)	KP2842-1	•							
Nozzle, 25A (LC25)	KP2842-2	•							
Retaining Cap (LC25)	KP2842-3	•							
Swirl Ring (LC25, LC40)	KP2842-4	•							
Spacer (LC25)	KP2842-5	•							
Electrode (LC40)	KP2843-1		•						
Nozzle, 40A (LC40)	KP2843-2		•						
Swirl Ring (LC25, LC40)	KP2842-4		•						
Retaining Cap (LC40)	KP2843-5		•						
Spacer (LC40, LC65)	KP2843-10		•	•	•				
Electrode (LC65)	KP2844-1			•	•				
Nozzle, 40A (LC65)	KP2844-2			•	•				
Nozzle, 50A (LC65)	KP2844-3			•	•				
Nozzle, 60A (LC65)	KP2844-4			•	•				
Retaining Cap, 40, 60A (LC65)	KP2844-9			•	•				
Shield, 40, 60A (LC65M)	KP2844-13			•	•				
Swirl Ring, 40A, 50A, 60A (LC65)	KP2844-14			•	•				

EXPENDABLE PARTS – CONTACT CUTTING

Nozzle (Direct Contact), 25A (LC40)	KP2843-9		•						
Nozzle (Direct Contact), 40A (LC40)	KP2843-3		•						
Swirl Ring, 40A, 50A, 60A (LC65)	KP2844-14			•	•				
Nozzle (Direct Contact), 40A (LC65)	KP2844-5			•	•				
Retaining Cap, 40, 60A (LC65)	KP2844-9			•	•				
Nozzle (Shielded Contact), 50A (LC65)	KP2844-6			•	•				
Nozzle (Shielded Contact), 60A (LC65)	KP2844-7			•	•				
Retaining Cap (Shielded Contact) (LC65)	KP2844-10			•	•				
Shield, 50A, 60A (LC65)	KP2844-11			•	•				

EXPENDABLE PARTS – GOUGING

Nozzle (Gouging) (LC40)	KP2843-4		•						
Retaining Cap (Gouging) (LC40)	KP2843-6		•						
Gouge Shield (LC40)	KP2843-8		•						
Swirl Ring, 40A, 50A, 60A (LC65)	KP2844-14			•	•				
Nozzle (Gouging) (LC65)	KP2844-8			•	•				

Product Name	Product No.	Tomahawk® 375 Air		Tomahawk® 625		Tomahawk® 1000		Tomahawk® 1500	
		Base Model	Base Model Hand Torch	Base Model Hand Torch	Base Model Hand Torch	Base Model Mechanized	Base Model Hand Torch	Base Model Hand Torch	Base Model Hand Torch
		K2806-1	K2807-1	K2808-1	K2808-2	K2809-1			

EXPENDABLE PARTS – GOUGING, CON'T.

Retaining Cap (Shielded Contact) (LC65)	KP2844-10			•	•				
Gouge Shield (LC65)	KP2844-12			•	•				

GENERAL

Plasma Circle Cutting Guide Kit	K2886-1	•	•	•	•				
Canvas Cover	K2377-1	•	•	•	•				
Accessory Bag	K3071-1	•	•	•	•				
LC25 Handheld Plasma Torch, 10 ft. (3.0 m)	K2846-1	•							
LC40 Handheld Plasma Torch, 20 ft. (6.1 m)	K2847-1		•						
LC40 Machine Plasma Torch, 20 ft. (6.1 m)	K2847-2		•						
Torchmate® 2X2™ CNC Prototyping System/Tomahawk® 625 One-Pak®	K3128-1		•						
LC65 Handheld Plasma Torch, 25 ft. (7.5 m)	K2848-1			•	•				
LC65 Handheld Plasma Torch, 50 ft. (15 m)	K2848-2			•	•				
LC65M Machine Plasma Torch, 25 ft. (7.5 m)	K2848-3			•	•				

EXPENDABLE PARTS – HAND CUTTING

Electrode (LC105)	KP4141-1								•
Nozzle-40A (LC105)	KP4141-4								•
Nozzle-60A (LC105)	KP4141-5								•
Nozzle - 80A (LC105)	KP4141-6								•
Nozzle-100A (LC105)	KP4141-7								•
Swirl Ring (LC105)	KP4141-9								•
Retaining Cap (Contact) (LC105)	KP4141-8								•
Shield Cap-40A (LC105)	KP4141-13								•
Shield Cap-60-80A (LC105)	KP4141-2								•
Shield Cap-100A (LC105)	KP4141-3								•
Drag Shield Cap-40A (LC105)	KP4141-14								•
Drag Shield Cap-60-80A (LC105)	KP4141-15								•
Drag Shield Cap-100A (LC105)	KP4141-16								•
Gouging Nozzle-80A (LC105)	KP4141-18								•
Gouging Nozzle-100A (LC105)	KP4141-19								•
Gouging Shield Cap-80-100A (LC105)	KP4141-17								•

Accessories » FlexCut™ Plasma Cutters

Product Name	Product No.	FlexCut™ 80		FlexCut™ 125	
		Base Model Machine Torch	K4809-1	Base Model Machine Torch	K4811-1
EXPENDABLE PARTS – MACHINE CUTTING					
Electrode (LC105M)	BK12849-1	•			
Shield Cap, 40A (LC105M)	BK12849-1	•			
Shield Cap, 60A-80A (LC105M)	BK12849-2	•			
Nozzle, 40A (LC105M)	BK12849-4	•			
Nozzle, 60A (LC105M)	BK12849-5	•			
Nozzle, 80A (LC105M)	BK12849-6	•			
Retaining Cap (LC105M)	BK12849-8	•			
Swirl Ring (LC105M)	BK12849-9	•			
Retaining Cap (Contact-CTP) (LC105M)	BK12849-10	•			
LC125(M) Electrode, 45-125A	BK14300-1			•	
LC125(M) Shield Cap, 45A-65A	BK14300-3			•	
LC125(M) Shield Cap, 85A-105A-125A	BK14300-4			•	
LC125(M) Nozzle, 45A	BK14300-7			•	
LC125(M) Nozzle, 65A	BK14300-8			•	
LC125(M) Nozzle, 85A	BK14300-9			•	
LC125(M) Nozzle, 105A	BK14300-10			•	
LC125(M) Nozzle, 125A	BK14300-11			•	
LC125(M) Swirl Ring, 45A-125A	BK14300-13			•	
LC125(M) Retaining Cap, 45A-125A, CTP	BK14300-15			•	
EXPENDABLE PARTS – HAND CUTTING					
Electrode (LC105)	KP2845-1	•			
Shield (LC105)	KP2845-2	•			
Shield Cap Gouging (LC105)	KP2845-4	•			
Nozzle, 40A (LC105)	KP2845-5	•			
Nozzle, 60A (LC105)	KP2845-6	•			
Nozzle, 80A (LC105)	KP2845-7	•			
Nozzle (Gouging) (LC105)	KP2845-9	•			
Retaining Cap (Contact) (LC105)	KP2845-10	•			
Swirl Ring (LC105)	KP2845-11	•			
GENERAL					
LC125M Machine Plasma Torch 25 ft (7.5 m)	K4300-4			•	
LC125M Machine Plasma Torch 50 ft (15 m)	K4300-5			•	
LC125M Machine Plasma Torch 75 ft (22.5 m)	K4300-6			•	

Accessories » Spirit® II Plasma Cutting Power Sources

Product Name	Product No.	Spirit® II150	Spirit® II275	Spirit® II400
		Base Model See Lit. for K-number	Base Model See Lit. for K-number	Base Model See Lit. for K-number
EXPENDABLE PARTS – SHIELD CAP				
Shield Cap, 30A (Mild Steel, Aluminum)	BK277145	•	•	•
Shield Cap, 50A (Mild Steel)	BK277115	•	•	•
Shield Cap, 50A (Aluminum), 70A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum)	BK277150	•	•	•
Shield Cap, 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277286	•	•	•
Shield Cap, 150A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277117	•	•	•
Shield Cap, 30A (Stainless Steel-Air)	BK277144	•	•	•
Shield Cap, 50A (Stainless Steel-Air)	BK277149	•	•	•
Shield Cap, 100A (Stainless Steel-H17)	BK277146	•	•	•
Shield Cap, 150A (Stainless Steel-H17)	BK277298	•	•	•
EXPENDABLE PARTS – INNER RETAINING CAP				
Inner Retaining Cap, 30A-70A (Mild Steel, Aluminum), 70A (Stainless Steel-Air)	BK277153	•	•	•
Inner Retaining Cap, 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277151	•	•	•
Inner Retaining Cap, 150A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277152	•	•	•
Inner Retaining Cap, 150A (Stainless Steel-H17), 200A/275A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum)	BK277266	•	•	•
Inner Retaining Cap, 30A/50A (Stainless Steel-Air)	BK277110	•	•	•
EXPENDABLE PARTS – NOZZLE				
Nozzle, 30A (Mild Steel, Aluminum)	BK277120	•	•	•
Nozzle, 50A (Mild Steel, Aluminum)	BK277122	•	•	•
Nozzle, 70A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277125	•	•	•
Nozzle, 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277284	•	•	•
Nozzle, 150A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277293	•	•	•
Nozzle (for Silver), 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK279484	•	•	•
Nozzle (for Silver), 150A (Mild Steel, Stainless Steel-Air, Aluminum)	BK279493	•	•	•
Nozzle, 30A (Stainless Steel-Air) Stainless Steel (Air)	BK277121	•	•	•
Nozzle, 50A (Stainless Steel-Air) Stainless Steel (Air)	BK277123	•	•	•
Nozzle, 70A (Stainless Steel-H17) Stainless Steel (H17)	BK277124	•	•	•
Nozzle, 100A (Stainless Steel-H17) Stainless Steel (H17)	BK277126	•	•	•
Nozzle, 150A (Stainless Steel-H17) Stainless Steel (H17)	BK277297	•	•	•
EXPENDABLE PARTS – SWIRL RING				
Swirl Ring, 30A (Aluminum), 30A/50A (Mild Steel), 70A (Stainless Steel-H17)	BK277140	•	•	•
Swirl Ring, 50A/70A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277142	•	•	•
Swirl Ring, 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK277283	•	•	•
Swirl Ring (for Silver), 100A (Mild Steel, Stainless Steel-Air, Aluminum)	BK279483	•	•	•
Swirl Ring (for Silver), 150A (Mild Steel, Stainless Steel-Air, Aluminum)	BK279439	•	•	•
Swirl Ring, 150A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum), 260A (Stainless Steel-H17)	BK277139	•	•	•
Swirl Ring, 30A (Stainless Steel-Air) Stainless Steel (Air)	BK277138	•	•	•
Swirl Ring, 100A (Stainless Steel-H17) Stainless Steel (H17)	BK277141	•	•	•



WIRE DELIVERY

BULK PACKAGE EQUIPMENT » Drum and Box Heads • Drum and Box Covers • Drum, Reel Box Handling Equipment

CONDUIT » Weld Wire Conduit • Conduit Connectors • Conduit Hangers, Clamps, Sleeves

DISPENSING EQUIPMENT » Wire Feed Assist • Bulk Reel Dispensing • Wire Straightners • Infinity-Pak

ROBOTIC TORCH MAINTENANCE » Power Ream®

WIRE DELIVERY TOOLS » Wire Level Gauge • Accessories

Bulk Package Hoods and Accessories for Drums and Boxes

Coverage for Consumables

- Tough polyethylene construction for long shop life
- Dual windows for easy operator access
- Available for round, square and octagon-shaped packages



Processes

- MIG
- Flux-Cored

Drum and Box Covers

Bulk Package Protection

- Tough, fire-resistant PVC construction
- Provides effective protection of fiber or cardboard drums located near the weld cell
- Available for round, square and octagon-shaped bulk wire packages



Processes

- MIG
- Flux-Cored

Drum, Reel and Box Handling Equipment

Packages on the Move

- Dollies available for drum or boxes with up to 1000 lb (453 kg) capacity
- Staging carts available for drums or reels with up to 1000 lb (453 kg) capacity
- Variety of lifters for chimeless and chimed drums



Processes

- MIG
- Flux-cored

Weld Wire Conduit

Wire Delivery at any Length

- Choose from polymer or extra flexible material
- Available in pre-cut lengths up to 30 ft. (9.1 m) or in bulk
- Self-threading or compression style connectors available



Processes

- MIG
- Flux-cored
- Submerged Arc

Conduit Connectors

Make the Welding Connection

- Variety of types and sizes available
- Rounded internal shoulders for smooth wire feeding
- Union kits and bulkhead connector



Processes

- MIG
- Flux-cored
- Submerged Arc

Conduit Hangers, Clamps and Sleeves

Wire Support

- Hanger prevents excessive sag in conduit to existing structures
- Sleeves protect conduit from operating environment
- Use clamps to secure conduit to existing structures



Processes

- MIG
- Flux-cored
- Submerged Arc

Wire Feed Assist

Extra Drive for Your Wire Feed

- Reduces pulling force required from feed motor
- Enables longer conduit runs
- Adjustable torque setting prevents bird nesting
- For .035-1/8 in. (0.9-3.2 mm) wire diameters



Processes

- MIG
- Flux-Cored

Input

Compressed Shop Air

Wire Straighteners

Get It Straight

- Straighten or recast all types of wires
- Lightweight, yet rugged
- Equipped with locating calibration on face of unit and fine adjustment scale on tension knob



Processes

- MIG
- Flux-cored
- Submerged Arc

Dispensing Equipment for Bulk Reels

The Reel Deal

- Universal base plate design fits wood or plastic reels with 1-5/16 in. (33 mm) or 5 in. (127 mm) center arbors
- Twin locking cams secure base plate to reel for stability
- Smooth acceleration and deceleration of feed arm



Processes

- MIG
- Flux-Cored

Infinity-Pak® Dispensing System

Continuous Wire, Continuous Welding

- Butt welding and flash removal process take only seconds
- Configurations for every environment, including 2-station, 4-station and wall mount
- ASTM certified and the bulk package is 100% recyclable
- Use with a variety of Lincoln Electric SuperArc® wire alloys



Processes
• MIG

Output



Input



Literature
MC14-97

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Air Pressure and Flow	Input Current @ Rated Output	Input Current	H x W x D in (mm)	Net Wt. lb (kg)
Infinity-Pak® Butt Welder	K3924-1	110V 5 Amps	—	—	—	42 x 20 x 24 (1067 x 208 x 610)	100 (43.4)
Butt Welder and Docking Station	K3921-1					—	—
With 2 Stations	K3926-1					—	—
With 4 Stations	K3927-1					—	—
Wall Mount	K4106-1					—	—

Power REAM® Torch Maintenance System

Eliminate Torch Spatter

- Removes and reduces spatter accumulation on robotic torches for improved welding performance
- Simple push-button “No Error” programming technique
- Only reamer to offer an automatic retry feature



Processes
• MIG

Input



Product Number
K2391-1 (Base Model)

Literature
E10.110

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Air Pressure and Flow	Input Current @ Rated Output	Input Current	H x W x D in (mm)	Net Wt. lb (kg)
Power REAM®	K2391-1	24V DC	80 PSI 15 SCFM	1100 rpm 0.65 HP	0.50A DC	with reservoir 24.9 x 8.9 x 13.2 (633 x 228 x 337) without reservoir 19.5 x 8.9 x 13.2 (495 x 228 x 337)	62 (28)

Wire Level Gauge

Keep an Eye on Wire Supply

- Detects level of wire remaining in the drum or box
- Wire level displayed visually with color and percentage scale
- Useable with 500 lb. (227 kg) or 1000 lb. (453 kg) package



Processes

- MIG
- Flux-Cored

Wire Delivery Accessories

Additional Tools

- Draw gauge accurately measures the draw weight of welding wire pulling through conduit in English or metric at the touch of a button
- Nozzle cleaning tool removes spatter; choice of five sizes
- Conduit cutter trims all diameters of polymer conduit with ease



Processes

- MIG
- Flux-cored
- Submerged Arc

High Speed, Low Porosity.
Process Z for zinc-coated materials.

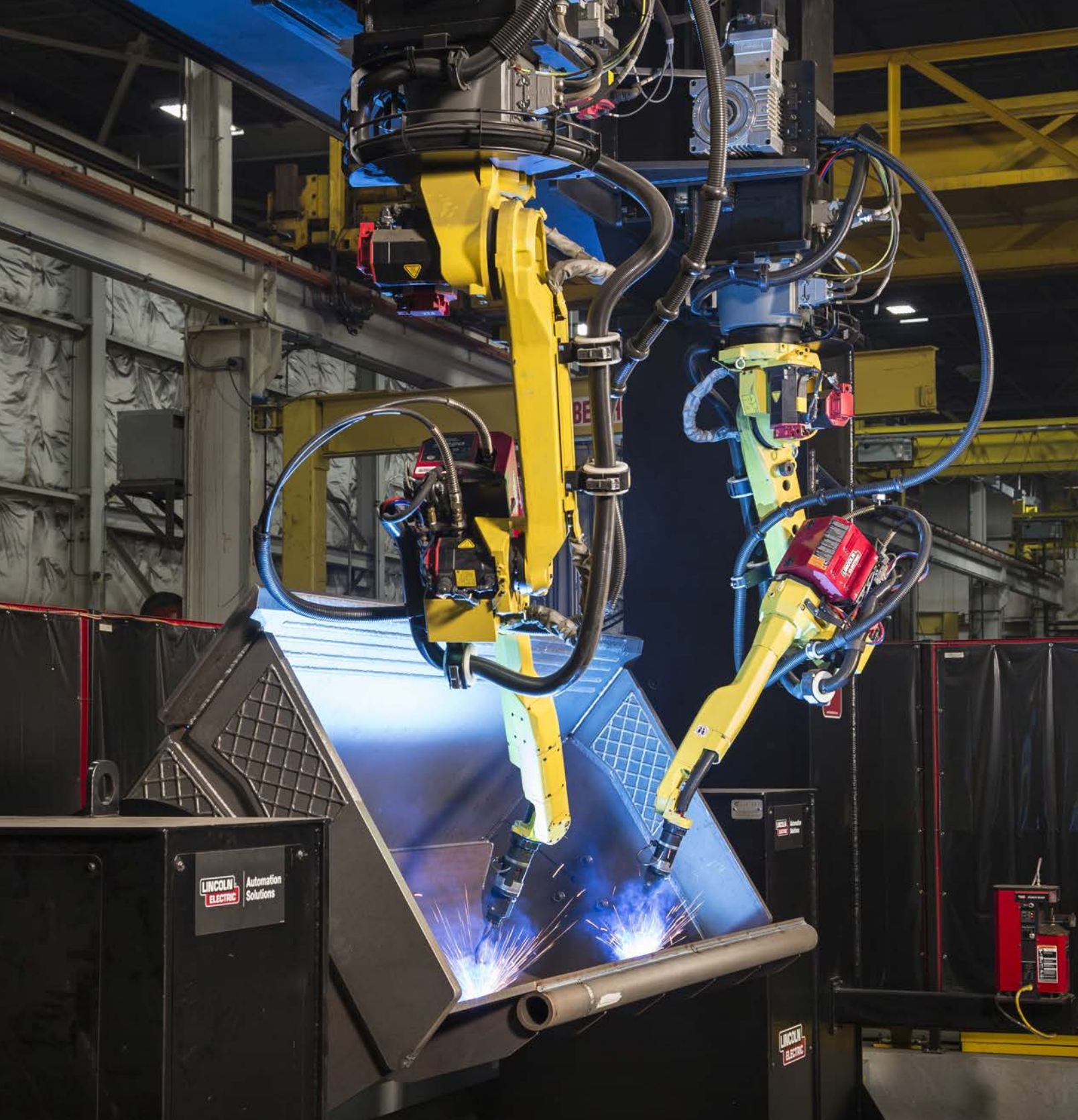


When it comes to welding zinc-coated materials for the automotive industry, you're often forced to make hard choices between reducing spatter, increasing weld speed or minimizing porosity. **Process Z™** gives you all three, without forcing you to compromise. Get better, faster, higher quality welds with Process Z.



Accessories » Infinity-Pak®

Product Name	Product No.			
		Infinity-Pak® with 2 Stations	Infinity-Pak® with 4 Stations	Infinity-Pak® Wall Mount
	K3926-1			
	K3927-1			
	K4106-1			
GENERAL				
Wire Sizer with 0.035 in (0.9 mm) dies	K3910-1	•	•	•
Wire Sizer replacement dies for 0.035 in (0.9 mm) wire	K3911-1	•	•	•
Wire Sizer with 0.045 in (1.2 mm) dies	K3913-1	•	•	•
Wire Sizer replacement dies for 0.045 in (1.2 mm) wire	K3912-1	•	•	•
Wire Sizer with 0.052 in (1.3 mm) dies	K3914-1	•	•	•
Wire Sizer replacement dies for 0.052 in (1.3 mm) wire	K3915-1	•	•	•
Wire Sizer with 0.062 in (1.6 mm) dies	K3917-1	•	•	•
Wire Sizer replacement dies for 0.062 in (1.6 mm) wire	K3918-1	•	•	•
Wire Sizer with 0.078 in (2.0 mm) dies	K3919-1	•	•	•
Wire Sizer replacement dies for 0.078 in (2.0 mm) wire	K3920-1	•	•	•
Butt welder and docking station combination	K3921-1	•	•	•
Butt welder (110V) portable	K3924-1	•	•	•
Hood Cover	K3997-1	•	•	•



AUTOMATION SOLUTIONS

CUTTING » Flat and Plate · Tube and Plate · Structural · Stamping and Forming · Tooling · Positioning Equipment

WELDING » Mechanized · Robotic · Orbital · Laser · System Integration · Environmental Systems

Cutting

Lincoln Electric's cutting systems produce superior cuts at lower operating costs. The range of solutions, including plasma cutters and oxy fuel systems, cut any shape, including flat plate, tube and pipe, and structural. Our cutting systems are used in numerous industries and by home hobbyists and in a variety of applications.



Stamping and Metal Forming

Lincoln Electric has an extensive depth of experience in stamping and metal forming, integrating and supporting all brands of equipment. We offer servo transfer systems of various sizes and configurations, blank stacking and de-stacking solutions for pre- and post-press applications, press-to-press automation, and robotic solutions.



Tooling

Complete in-house designs of machining and fabricating systems are available. Our turnkey systems come with full robot programming and can be integrated into your processes. The broad product offering is used for automotive components, heavy equipment and general fabrication, and in the manufacture of large components.



Positioning Equipment

We custom-design a variety of positioners, conveyors and gantry systems for many applications. Our deep understanding of kinematics helps us develop a total solution for manufacturing and fabricating operations. Our post-installation support delivers optimal service.



Mechanized Welding

We offer single and multiple arc systems. Our completely integrated mechanized systems handle incoming and outgoing materials that require submerged arc and open arc welding. Components of our mechanized systems include:

- Systems and Manipulators
- Seam Tracker™ Systems
- Jaw chucks
- Motorized and manual slides
- Pipe support stands
- Turning and idle rolls
- Accessories



Orbital Welding

Lincoln Electric has a full range of robustly designed TIG and MIG flux-cored orbital welding solutions, along with specially designed consumables. Our solutions' modular systems provide maximum flexibility and asset utilization. The system provides:

- Industry-leading welding performance
- Software solutions for data collection and field service
- Improved system serviceability
- Support



Robotic Welding

With in-depth knowledge of all welding process and applications, Lincoln Electric has engineered and installed thousands of robotic welding systems. These robotic welding solutions allow manufactures to weld simple to complex parts with a high degree of repeatability and efficiency. Lincoln Electric provides three types of robotic welding systems:

- Pre-configured, including the Auto-Mate® series, are fixed tables, turntables and positioner systems that can be delivered in two to four weeks.
- Pre-engineered are systems with various configuration options including positioners, safety systems, welding equipment and robotic arms.
- Custom systems are uniquely designed and fully automated for virtually any welding process or application.



Laser Welding

We have a unique understanding on a range of laser processes, including laser cutting, autogenous laser welding, hybrid laser arc welding, laser hot wire cladding, and laser brazing. We have deep relationships with the expert resources in laser manufacturing, optics component assembly and research laboratories.



System Integration

Lincoln Electric is your single point of contact for system design development. Our dedicated project managers will deliver a comprehensive turnkey system thanks to experienced designers, programmers and technicians, as well as extensive manufacturing capabilities. Our in-house engineering and development teams provide process development, tool and controls design, simulation services, and PLC and robot system programming. We ensure success by understanding the customer's facility and requirements, managing changes and becoming an extension of the customer's launch team.



Environmental Solutions

Welding is a safe occupation when sufficient measures are taken to protect fabricators from potential hazards. We offer a range of stand-alone and facility solutions to achieve this goal, including:

- Portable and stationary fume extraction units
- Extraction arms and hoods
- Dwindraft tables
- Engineered control systems
- Guardian™ Fire Safety System
- Fume guns

We can integrate our environmental solutions with other automation products.





WELD FUME CONTROL

MODEL	FILTER		PROCESS				INPUT	FEATURES				
	System	Size: ft ² (m ²)	Stick	TIG	MIG	Flux-Cored		Volts/Phase/Hz	Mobile	Start/Stop Sensor	Filter Indicator Gauge	Single Arm System
PORTABLE												
Miniflex [®]	Disposable	130 (12)	●	●	●	●	115/1/50/60 230/1/50/60	●	●	●	●	
X-Tractor [®] 1GC	Self-Cleaning	30 (2.8)	●	●	●	●	120/1/50/60 230/1/50/60	●	●		●	
Mobiflex [®] 100-NF	Non-Filtration	—	●	●	●	●	115/1/60 230/1/50	●				
MOBILE												
Mobiflex [®] 200-M	Disposable	538 (50)	●	●	●	●	115/1/50/60	●		●	●	
Mobiflex [®] 400-MS	Self-Cleaning	325 (30)	●	●	●	●	115/1/60	●		●	●	
STATIONARY												
X-Tractor [®] 3A, 5A, 8A	Self-Cleaning	up to 108 (10)	●	●	●	●	230/3/60 460/3/60					
Statiflex [®] 200-M	Disposable	538 (50)	●	●	●	●	—			●	●	●
Statiflex [®] 400-MS	Self-Cleaning	325 (30)	●	●	●	●	—			●	●	
DownFlex [®] 100-NF	Non-Filtration	—	●	●	●	●	—					
DownFlex [®] 200-M	Disposable	560 (52)	●	●	●	●	208/230/460/3/60			●		
DownFlex [®] 400-MS/A	Self-Cleaning	560 (52)	●	●	●	●	208/230/460/3/60		optional ●	●		

ROBOTIC SYSTEMS » Formed Extraction Hood

ENGINEERED SYSTEMS » Modular Extraction Hood • Statiflex[®] Filter Banks • The Circulator[®] • Push/Pull Systems • High and Low Vacuum Central Systems

FIRE SAFETY » Guardian[™] Fire Safety Solutions

KEY: ● Excellent ● Good ● Optional

Miniflex®

Industry-Leading Portability and Ease of Use

- High vacuum system designed for confined and hard-to-reach spaces
- Ideal for light duty welding applications
- Start/Stop sensor reduces energy consumption
- Quick and easy filter replacement and maintenance



Shown: Miniflex® One-Pak® Package (K4260-2)

Processes

- Stick (light duty)
- TIG
- MIG
- Flux-Cored (light duty)

Input



Literature

E13.11

- 3-Year Warranty
- Made in the USA of US and foreign content

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Sound Level	Air Flow CFM	Power Rating HP	Filter Surface Area ft² (m²)	H x W x D in (mm)	Net Wt. lb (kg)
Miniflex® Base Unit	K3972-3	120/1/50/60	12.0A	80 dBA	H : 108 L : 95	2.4 (1.2/motor)	118 (11)	29 x 15.6 x 16.8 (736 x 396 x 427)	40 (18.1)
	K2497-18	230/1/50/60	7.5A						
One-Pak Pkg.	K4260-2	120/1/50/60	12.0A						41 (18.6)

X-Tractor® 1GC

Move It Where You Need It

- Intended for light duty welding in small shops, maintenance applications and for home/hobby projects
- Rotary air jet filter cleaning system
- Quiet operation at <74 dBA
- Automatic Stop/Start provides extraction only when needed
- Reduces filter change-over and overall costs



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

MC14-40

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft² (m²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
X-Tractor® 1GC	K652-1	120/1/50/60	15A	30.1 (2.8)	H : 115 L : 55	13.4 x 26.8 x 15.8 (340 x 680 x 400)	38 (16.5)
	K652-2	230/1/50/60	9A				

Mobiflex® 100-NF

Fume Doesn't Stand A Chance

- Ideal for construction sites or applications where fume removal does not require filtration
- Weighs only 37.5 lbs. (17 kg)
- Low 69 dB(A) noise level
- Maximum 32 ft. (9.7 m) reach distance with Hood and Hose Set and Extension Hose Set



Shown: Mobiflex® 100-NF with Hose and Hood Set (K1688-1)

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input

1 PHASE 60 Hz 50 Hz

Literature

E13.42

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft² (m²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
Mobiflex® 100-NF	K1666-3	115/1/60	10A	No Filtration, Exhaust Only	Up to 765 depending on length of hose(s) used	23.1 x 18.9 x 18.6 (587 x 480 x 472)	37.5 (17)
	K2497-11	230/1/50	5A				

Mobiflex® 200-M

Fume Doesn't Stand A Chance

- Filter status indicator monitors the amount of particulate in the filter cartridge to alert the user for filter replacement
- Generous airflow (735 CFM with LFA 3.1/4.1 extraction arm) and large filter capacity [538 ft² (50 m²)]
- Choose from two arm lengths (10 ft. and 13 ft.) or select a hose/hood set
- Manual or optional automatic on/off (arc sensor) operation



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input

1 PHASE 50/60 Hz 50 Hz 60 Hz

Literature

E13.21

- 3-Year Warranty
- Made in the USA of US and foreign content

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft² (m²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)	
Mobiflex® 200-M MERV 14 Filter Base Unit	K1653-4	115/1/50/60	7.2A	Cellulose/ 538 (50)	735	36 x 32 x 48 (900 x 810 x 1210)	216 (98)	
	w/LFA 3.1 10 ft. Arm One-Pak® Pkg.						K4259-2	249 (112.9)
	w/LFA 3.1 10 ft. Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.						K4259-3	
	w/LFA 4.1 13 ft. Arm One-Pak® Pkg.						K4259-4	250 (113.4)
	w/LFA 4.1 13 ft. Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.						K4259-5	253 (114.6)
MERV 14 Filter Base Unit Export	K2497-12	230/1/50/60	3.7A				220 (99.8)	
Mobiflex® 200-M MERV 16 Filter Base Unit	K1653-5	115/1/50/60	7.2A	High-Efficiency Cellulose-Polyester/ 538 (50)	735	36 x 32 x 48 (900 x 810 x 1210)	225 (102.1)	
	w/LFA 3.1 10 ft. Arm One-Pak® Pkg.						K4259-6	254 (115.2)
	w/LFA 3.1 10 ft. Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.						K4259-7	258 (117)
	w/LFA 4.1 13 ft. Arm One-Pak® Pkg.						K4259-8	262 (118.8)
	w/LFA 4.1 13 ft. Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.						K4259-9	263 (119.3)

Mobiflex® 400-MS

Mobile Self-Cleaning Fume Extraction System

- RotaPulse® automatic cleaning system simplifies filter maintenance
- Filter status indicator monitors amount of particulate in filter cartridge to alert the user for filter maintenance or replacement
- Generous airflow (735 CFM with LFA 3.1/4.1 extraction arm) and large filter capacity [325 ft² (30 m²)]
- Choose from two arm lengths (10 ft. and 13 ft.) or select a hose/hood set
- Manual or optional automatic on/off (arc sensor) operation



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

E13.21

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft ² (m ²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
Mobiflex® 400-MS with MERV 14 Filter Base Unit	K1741-1	115/1/60	10A	Cellulose/ 325 (30)	735	40 x 32 x 48 (1020 x 810 x 1210)	255 (115.7)
with MERV 16 Filter Base Unit	K1741-2			High-Efficiency Cellulose-Polyester/ 325 (30)			
with MERV 14 Filter Base Unit Export	K2497-4	230/1/50	9A	Cellulose/ 325 (30)			286 (129.7)

X-Tractor® Stationary Systems

Heavy Duty Multi-Arc Fume Extraction

- These high vacuum systems are ideal for use with multiple nozzles and fume guns
- An integrated automatic filter cleaning system simplifies maintenance
- Select the X-Tractor® 3A for 1 nozzle and up to 3 fume guns, the 5A for 3 nozzles and up to 5 fume guns and the 8A for 5 nozzles and up to 8 fume guns



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

MC14-44

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft ² (m ²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
X-Tractor® 3A	K3965-1	230/3/60	9.7A	Polyester-based/ 30.1 (2.8)	165	29.1 x 16.9 x 43.3 (740 x 430 x 1100)	192 (87)
	K3965-2	460/3/60	4.6A				
X-Tractor® 5A	K3966-1	230/3/60	20A	Polyester-based/ 53.82 (5)	285	33.1 x 28.0 x 55.1 (840 x 710 x 1400)	242 (110)
	K3966-2	460/3/60	10A				
X-Tractor® 8A	K3967-1	230/3/60	40A	Polyester-based/ 107.64 (10)	475	43.3 x 28.0 x 55.1 (1100 x 710 x 1400)	309 (140)
	K3967-2	460/3/60	21A				

Statiflex® 200-M

Convenient Wall-Mounted System

- Intended for facilities with fixed work stations and little available floor space
- Designed for light to medium fume extraction and filtration
- Generous airflow up to 735 CFM with LFA 3.1 or 4.1 extraction arms and SF2400 fan
- Large filter capacity [538 ft² (50 m²)] increases efficiency, filter life and reduces operational costs



Shown:
Single Arm Base Unit

Processes

- Stick (light duty)
- TIG
- MIG
- Flux-Cored (light duty)

Literature

E13.14

- 3-Year Warranty

- Made in the USA of US and foreign content

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft ² (m ²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
Statiflex® 200-M MERV 14 Filter Base Unit Single Arm	K1654-4	N/A	N/A	Cellulose/ 538 (50)	735	36 x 32 x 28 (900 x 810 x 730)	66 (30)
w/LFA 3.1 10 ft. Single Arm One-Pak® Pkg.	K4261-2	115/1/60					
w/LFA 3.1 10 ft. Single Arm & Arc Sensor/ Lamp Kit One-Pak® Pkg.	K4261-6						
w/LFA 4.1 13 ft. Single Arm One-Pak® Pkg.	K4261-3						
w/LTA 2.0 3.0-4.5 ft. Telescopic Arm One-Pak® Pkg.	K4261-4						
w/LTA 2.0-CW 5.0-8.2 ft. Telescopic CW Single Arm One-Pak® Pkg.	K4261-5						
w/LTA 2.0 3.0-4.5 ft. Telescopic Single Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.	K4261-7						
Statiflex® 200-M MERV 14 Filter Base Unit Dual Arm	K1654-5			N/A	N/A	Cellulose/ 538 (50)	1200
w/LFA 3.1 10 ft. Dual Arm One-Pak® Pkg.	K4261-8	115/1/60					
w/LFA 3.1 10 ft. Dual Arm & Arc Sensor/ Lamp Kit One-Pak® Pkg.	K4261-12						
w/LFA 4.1 13 ft. Dual Arm One-Pak® Pkg.	K4261-9						
w/LTA 2.0 3.0-4.5 ft. Telescopic CW Dual Arm One-Pak® Pkg.	K4261-10						
w/LTA 2.0-CW 5.0-8.2 Telescopic CW Arm One-Pak® Pkg.	K4261-11						
w/LTA 2.0 3.0-4.5 ft. Telescopic Dual Arm & Arc Sensor/Lamp Kit One-Pak® Pkg.	K4261-13						
Statiflex® 200-M MERV 16 Filter Base Unit Single Arm	K1654-6			N/A	N/A	Cellulose-Polyester/ MERV 16 538 (50)	

Statiflex® 400-MS

Self-Cleaning Wall-Mounted System

- RotaPulse® automatic cleaning system simplifies filter maintenance
- Intended for facilities with fixed work stations and little available floor space
- Designed for light to medium fume extraction and filtration
- Generous airflow up to 735 CFM with LFA 3.1 or 4.1 extraction arms and SF2400 fan
- Large filter capacity at 323 ft³ (30 m³)



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

E13.14

• 3-Year Warranty

• Made in the USA of US and foreign content

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft ² (m ²)	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)*
Statiflex® 400-MS MERV 14 Filter Base Unit Single Arm	K1742-1	N/A	N/A	Cellulose/ 323 (30)	735	45 x 28 x 26 (1140 x 720 x 660)	111 (50.5)
MERV 16 Filter Base Unit Single Arm	K1742-2			High Efficiency Cellulose-Polyester/ 323 (30)			119 (53.9)

*Includes pre-filter box

Fume Extraction Arms

Built with the Welder in Mind

- Ultra-light dent and scratch-resistant material
- 360 degree rotatable hood
- Advanced spring-balanced internal mechanism holds the position you set



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

E13.16

• 3-Year Warranty

• Made in the USA of US and foreign content

Product Name	Product Number	Use With	Arm Length ft (m)	CFM with SF2400 Fan (with no filtration)	H x W in (mm)	Net Wt. lb (kg)
LFA 3.1	K2633-5	Mobiflex®	10 (3.1)	760	8 x 118 (203 x 3000)	33 (15)
	K1655-8	Statiflex®				34 (15.4)
LFA 3.1 (w/ Arc Sensor/Lamp Kit)	K2633-6	Mobiflex®				34 (15.4)
LFA 4.1	K2633-7	Mobiflex®	13 (4.1)	760	8 x 157 (203 x 4000)	37 (16.7)
	K1655-9	Statiflex®				38 (17)
LFA 4.1 (w/ Arc Sensor/Lamp Kit)	K2633-8	Mobiflex®				38 (17)
LFA 4.1-LC (Low Ceiling)	K1655-13	Statiflex®				33 (15)
LFA 2.0	K1655-12	Statiflex®	6.5 (2.0)	760	8 x 85 (203 x 2160)	33 (15)
LTA 2.0 Telescopic	K1655-10	Statiflex®	Variable from 3.0-4.5 (1.0-1.5)	780	8 x 39.5-55 (203 x 1000-1400)	15.4 (7)
LTA 2.0-CW, Telescopic	K1655-14	Statiflex®	Variable from 5.0-8.2 (1.5-2.5)		8 x 62-100.5 (203 x 1575-2553)	59.5 (27)

DownFlex® Tables

All in One Workbench and Extraction System

- DownFlex® 200-M and 400-MS/A models feature strong back and down draft extraction capacity, 3 stage spark arrestor and sizable 560 ft² (52 m²) of filter media
- The 100-NF model is designed for fabricators that prefer to add their own extraction system to the downdraft table



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding

Input⁽²⁾



Literature

MC13-38

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

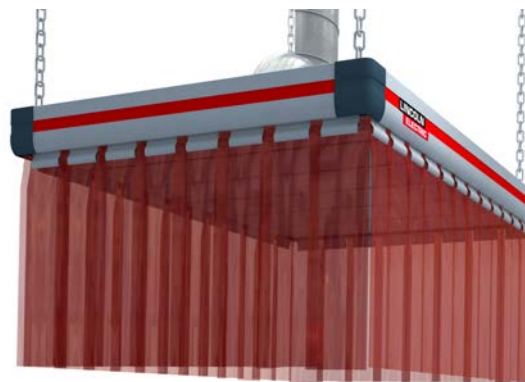
⁽²⁾ 200-M and 400-MS/A only.

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	Filter Type/ Filter Size, ft² [m²]	Air Flow CFM	H x W x D in (mm)	Net Wt. lb (kg)
DownFlex® 400-MS/A	K2751-3	208/230/460/3/60	11/10/5A	Cellulose-Polyester Fiber Filter 560 (52)	N/A	60.8 x 54.3 x 39.4 (1544 x 1380 x 1005)	562 (255)
DownFlex® 200-M	K2751-2	208/230/460/3/60	11/10/5A	Cellulose-Polyester Fiber Filter 560 (52)	N/A	60.8 x 54.3 x 39.4 (1544 x 1380 x 1005)	540 (245)
DownFlex® 100-NF	K2751-9	N/A	N/A	No Filtration	N/A	58.9±3 x 53.8 x 35.9 (1494±75 x 1366 x 911)	300 (136)

Modular Extraction Hood

Modular. Effective. Multi-Process.

- Engineered to contain and extract welding, cutting, arc gouging and grinding fume from the work environment
- Perimeter pull technology maximizes fume extraction effectiveness at lower airflow rates
- Modular aluminum construction enables easy assembly, cleaning and service



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Arc Gouging
- Grinding⁽¹⁾

Literature

MC12-05

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

Product Name	Product Number/Sizes	Recommended Extraction Capacity	Recommended Air Velocity in Connected Duct
Modular Extraction Hood	See MC12-05 for full list of product numbers and sizes	290-474 CFM per square meter of hood (27-44 CFM per square foot of hood)	3,000-3,500 ft/min

Formed Extraction Hood

Your Fume Solution for Robotic Systems

- The ideal solution for welding fume extraction on robotic cells
- Designed and sized to fit Lincoln Electric pre-engineered robotic cells
- Incorporate a modular Statiflex® self-cleaning filter bank into the hood design for filtration of welding fume



Shown: System 20 with Fume Hood and integrated fan/filteration unit

Processes

- TIG
- MIG
- Flux-Cored
- Metal-Cored

Literature

MC12-05

Statiflex® Filter Bank

High Efficiency Industrial Fume Extraction and Filtering

- Ideal for filtering fume and particulate generated by welding, cutting, arc gouging and grinding
- Multi-flow technology disperses incoming air evenly throughout the filter bank, resulting in longer filter life
- Pulse amplifier technology creates a uniform, high-energy pulse of compressed air to clean the filters
- Available with 4-48 filter cartridges



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Arc Gouging
- Grinding⁽¹⁾

Input



Product Number

See Literature for more information

Literature

MC12-05

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

Product Name	Filter Type	Fan Sizes HP
Statiflex® Filter Banks (4 to 48 filter cartridges)	Rated MERV 16 or MERV 11	1.5-75

The Circulator®

Make a Cleaner Work Environment

- Free-standing general filtration system for weld fume control; ideal for manufacturing and fabrication facilities, and offers an economical alternative to a push/pull system
- Intended to supplement an existing source extraction system as well as natural draft/forced ventilation to reduce overall concentration of welding fume, dust and dirt in operator areas
- Green Drive™ control system reduces energy costs and increases filter life by continually monitoring operation and automatically adjusting airflow to maintain optimal performance levels



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Metal-Cored

Input



Literature

MC11-37

Push/Pull Systems

Improve General Workplace Air Quality

- Remove fume and metal particulate layer from the air of your metalworking facility before it settles back to the floor
- Ideal for environments where workers are in spaces where effective source capture is difficult
- Effective when fabricating large weldments and when the welder needs to frequently change positions



Push/Pull System installed at Elgin Sweeper Company

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Metal-Cored

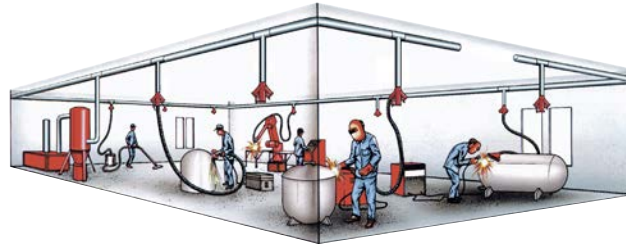
Literature

MC11-106

High Vacuum Central Systems

Compact Multi-Station Source Extraction

- A cost effective choice that uses a central turbine and filter to supply suction throughout the plant
- Uses smaller ductwork and lower airflow values
- Header ducts are frequently one size throughout the entire system



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Grinding⁽¹⁾

Literature

MC11-107

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

Low Vacuum Central Systems

Low Noise Multi-Station Source Extraction

- Low-vacuum, exhaust systems for source capture applications
- Ideal for addressing welding fume removal in educational environments and manufacturing plants that require multiple station drops
- Easy arm positioning, low noise levels
- Optional automatic On/Off control reduces energy costs



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Literature

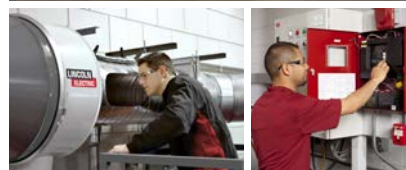
MC11-107

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

Guardian™ Fire Safety Solutions

Prevention, Detection, Suppression

- Prevent fire with a Spark Guardian™ spark arrestor and an Oil Guardian™ limestone feeder. The Spark Guardian helps to keep sparks and cigarette butts from reaching the combustible filter or dustbin debris. The Oil Guardian continuously injects limestone powder into the fume control system ductwork which absorbs vaporized oil generated when welding on oily parts. The resulting dry matter is blown off the filters during the cleaning cycle.
- Detect fire early with the Guardian Control™ detection panel to reduce damage to your filter system if combustion occurs
- Suppress fire with a Flame Guardian™ aerosol generator inside the filter bank to quickly extinguish a fire



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Product Number

See page 219

Literature

MC12-20

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Miniflex®

Base Model (K3972-3)

- 8 ft. length x 1.75 in. I.D. (2.4 m x 45 mm) extraction hose
- LongLife-H main filter
- HEPA filter
- Pre-Filter
- 2 spare sets of carbon brushes and seals for motors

One-Pak® Package (K4260-2)

- Everything listed above (K3972-3)
- EN 20 Nozzle, Bell Shaped

X-Tractor® 1GC

Base Model (K652-1, K652-2)

- Hose-to-Tube Adapter, 1.75-2.0 in. (45-50 mm)
- Hose-to-Tube Adapter, 1.75-1.5 in. (45-38 mm)
- 16 ft. length x 1.75 in. I.D. (5 m x 45 mm) extraction hose
- 2 spare sets of carbon brushes for motors
- Filter cartridge

Mobiflex® 100-NF

Required Accessories

- Hose and Hood Set, 16 ft. (4.9 m)
- Exhaust or Extension Hose Set, 16 ft. (4.9 m)

Base Models (K1666-3, K2497-11)

- Exhaust Fan Unit
- Carrying Handle
- Sturdy Base/Stand

Mobiflex® 200-M

Required Accessories

- Extraction Arm
- Hose and Hood Kit

Base Models (200-M MERV14: K1653-4, K2497-12; 200-M MERV 16: K1653-5)

- Filter
- Plastic housing
- Flexible Hose, 8 in. (203 mm)
- 19 ft. (6 m) 115 VAC Input Power Cord (not on K2497-2 and K2497-3)
- Transformer Relay Kit

Mobiflex® 200-M (cont)

Mobiflex® 200-M MERV14 (K4259-2) and 200-M MERV16 (K4259-6) One-Pak® Package

- Everything listed for a Base Model
- LFA 3.1 10 ft (3.0 m) Arm

Mobiflex® 200-M MERV14 (K4259-3) and 200-M MERV16 (K4259-7) One-Pak® Package

- Everything listed for a Base Model
- LFA 3.1 10 ft (3.0 m) Arm & Arc Sensor/Lamp Kit

Mobiflex® 200-M MERV14 (K4259-4) and 200-M MERV16 (K4259-8) One-Pak® Package

- Everything listed for a Base Model
- LFA 4.1 13 ft (4.0 m) Arm

Mobiflex® 200-M MERV14 (K4259-5) and 200-M MERV16 (K4259-9) One-Pak® Package

- Everything listed for a Base Model
- LFA 4.1 13 ft (4.0 m) Arm & Arc Sensor/Lamp Kit

Mobiflex® 400-MS

Required Accessories

- Extraction Arm
- Flexible Hose, 8 in. (203 mm)
- Rubber Seals, 8 in. (203 mm) (Qty. 2)

Base Models (400-MS MERV14: K1741-1, K2497-4; 400-MS MERV16: K1741-2)

- Filter
- Plastic housing
- Flexible Hose, 8 in. (203 mm)
- 19 ft. (6 m) 115 VAC Input Power Cord (not on K2497-2 and K2497-3)
- Transformer Relay Kit

X-Tractor® 3A, 5A and 8A

Required Accessories

- Nozzles or Fume Extraction Guns
- Connection Kits
- Hoses, Adapters

Base Model (3A: K3965-1, K3965-2; 5A: K3966-1, K3966-2; 8A: K3967-1, K3967-2)

- Filter Cartridge
- Automatic Filter Cleaning System
- Internal Compressed Air Regulator
- Automatic Operation Connection
- Starter/Overload Switch

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Statiflex® 200-M Single Arm

Required Accessories

- Extraction Arm
- Stationary Fan
- Overload Switch or Lamp Kit with Arc Sensor
- Wall Mounting Bracket

Base Models [200-M MERV 14: K1654-4; 200-M MERV 16: K1654-6]

- Filter
- Filter Housing
- Hose - 8 in. [203 mm] diameter, 4.9 ft. [1.5 m] long
- Hose Clamps - 8 in. [203 mm] [Qty. 2]
- Rubber Seal
- Mounting Bracket
- Reducer

One-Pak® Package [K4261-2]

- Everything listed above for a Base Model
- LFA 3.1 10 ft [3.0 m] Arm
- Starter Overload Switch
- Wall Mounting Bracket
- SF2400 Stationary Fan

One-Pak® Package [K4261-3]

- Everything listed above for a Base Model
- LFA 4.1 13 ft [4.0 m] Arm
- Starter Overload Switch
- Wall Mounting Bracket
- SF2400 Stationary Fan

One-Pak® Package [K4261-4]

- Everything listed above for a Base Model
- LTA 2.0 3.0-4.5 ft [0.9-1.4 m] Telescopic Arm
- Starter Overload Switch
- Wall Mounting Bracket
- SF2400 Stationary Fan

One-Pak® Package [K4261-5]

- Everything listed above for a Base Model
- LTA 2.0-CW 5-8.2 ft [1.5-2.5 m] Telescopic Arm
- Starter Overload Switch
- SF2400 Stationary Fan

One-Pak® Package [K4261-6]

- Everything listed above for a Base Model
- LFA 3.1 10 ft [3.0 m] Arm & Arc Sensor/Lamp Kit
- Wall Mounting Bracket
- SF2400 Stationary Fan

Statiflex® 200-M Single Arm, con't.

One-Pak® Package [K4261-7]

- Everything listed above for a Base Model
- LTA 2.0 3.0-4.5 ft [0.9-1.4 m] Telescopic Arm & Arc Sensor/Lamp Kit
- Wall Mounting Bracket
- SF2400 Stationary Fan

Statiflex® 200-M Dual Arm

Required Accessories

- Extraction Arm [Qty. 2]
- Stationary Fan [Qty. 2]
- Overload Switch or Arc Sensor/Lamp Kit [Qty. 2]
- Wall Mounting Brackets [Qty. 2]

Base Model [200-M MERV 14: K1654-5]

- Filter
- Filter Housing
- Hoses, 8 in. [203 mm] diameter [Qty. 2]
- Hose Clamps, 8 in. [203 mm] diameter [Qty. 4]
- Rubber Seals [Qty. 2]
- Non-Return Valves, 8 in. [203 mm] [Qty. 2]
- Reducers [Qty. 2]
- Adapters [Qty. 2]
- Mounting Bracket

One-Pak® Package [K4261-8]

- Everything listed above for a Base Model
- LFA 3.1 10 ft [3.0 m] Arm [Qty. 2]
- Starter Overload Switch [Qty. 2]
- Wall Mounting Bracket [Qty. 2]
- SF2400 Stationary Fan [Qty. 2]

One-Pak® Package [K4261-9]

- Everything listed above for a Base Model
- LFA 4.1 13 ft [4.0 m] Arm [Qty. 2]
- Starter Overload Switch [Qty. 2]
- Wall Mounting Bracket [Qty. 2]
- SF2400 Stationary Fan [Qty. 2]

One-Pak® Package [K4261-10]

- Everything listed above for a Base Model
- LTA 2.0 3.0-4.5 ft [0.9-1.4 m] Telescopic Arm [Qty. 2]
- Starter Overload Switch [Qty. 2]
- Wall Mounting Bracket [Qty. 2]
- SF2400 Stationary Fan [Qty. 2]

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Statiflex® 200-M Dual Arm, con't.

One-Pak® Package (K4261-11)

- Everything listed above for a Base Model
- LTA 2.0-CW 5-8.2 ft (1.5-2.5 m) Telescopic Arm (Qty. 2)
- Starter Overload Switch (Qty. 2)
- SF2400 Stationary Fan (Qty. 2)

One-Pak® Package (K4261-12)

- Everything listed above for a Base Model
- LFA 3.1 10 ft (3.0 m) Arm & Arc Sensor/Lamp Kit (Qty. 2)
- Wall Mounting Bracket (Qty. 2)
- SF2400 Stationary Fan (Qty. 2)

One-Pak® Package (K4261-13)

- Everything listed above for a Base Model
- LTA 2.0 3.0-4.5 ft (0.9-1.4 m) Telescopic Arm & Arc Sensor/Lamp Kit (Qty. 2)
- Wall Mounting Bracket (Qty. 2)
- SF2400 Stationary Fan (Qty. 2)

Statiflex® 400-MS Single Arm

Required Accessories

- Extraction Arm
- Stationary Fan
- Arc Sensor/Lamp Kit
- Wall Mounting Bracket

Base Model (400-MS MERV 14: K1742-1, 400-MS MERV 16: K1742-2)

- Filter
- Filter Housing
- Particulate Collection Bin
- Pre-Filter Box
- Hoses, 6 in. (152 mm) diameter (Qty. 2)
- Hose Clamps (Qty. 4)
- Rubber Seals (Qty. 2)
- Mounting Brackets (Qty. 2)
- Control Cable for Filter Cleaning Mechanism

DownFlex® 100-NF, DownFlex® 200-M and DownFlex® 400-MS/A

Base Model (100-NF: K2751-1; 200-M: K2751-2; 400-MS/A: K2751-3)

- Sturdy Welding Table
- Backdraft Panel
- Side Panels
- Filters & Controls (not on 100-NF)

Modular Extraction Hood

Required Accessories

- Exhaust Fan and Controls
- Filtration Unit

Statiflex® Filter Banks

Base Model

- Filter Bank
- Dust Drum(s)

Accessories

Product Name	Product No.	Miniflex®		X-Tractor® 16C		Mobiflex® 100-NF		Mobiflex® 200-M		Mobiflex® 400-MS		X-Tractor® 3A		X-Tractor® 5A		X-Tractor® 8A			
		Base Model (120V)	Base Model (230V)	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model		
		K3972-3	K2497-18	K652-1	K652-2	K1666-3	K2497-11	K1653-4	K1653-5	K2497-12	K1741-1	K1741-2	K2497-4	K3965-1	K3965-2	K3966-1	K3966-2	K3967-1	K3967-2
REQUIRED																			
Hose and Hood Set, 16 ft. (4.9 m)	K1668-1					•	•												
Exhaust or Extension Hose Set, 16 ft. (4.9 m)	K1668-2					•	•												
Hose and Hood Kit	K1668-3							•	•		•	•							
LFA 3.1 10 ft. (3 m) Extraction Arm	K2633-5							•	•	•	•	•	•						
LFA 4.1 13 ft. (4 m) Extraction Arm	K2633-7							•	•	•	•	•	•						
LFA 3.1 10 ft. (3 m) Extraction Arm w/Lamp	K2633-6							•	•	•	•	•	•						
LFA 4.1 13 ft. (4 m) Extraction Arm w/Lamp	K2633-8							•	•	•	•	•	•						
GENERAL																			
EN 20 Nozzle	K2389-5	•	•	•	•									•	•	•	•	•	•
SHM-300 Suction Head for Manual Welding, 12 in. (300 mm)	K639-1	•	•	•	•									•	•	•	•	•	•
SHFA Flat Suction Head with Flexible Arm	K639-5	•	•	•	•									•	•	•	•	•	•
UNM Suction Head for Heavy Smoke	K639-6	•	•	•	•									•	•	•	•	•	•
NKT Nozzle Kit, 1 in. x 8 ft. Hose (254 mm x 2.4 m), 1.75 in. (45 mm) Hose Adapter	K2389-3	•	•	•	•									•	•	•	•	•	•
NKC Nozzle Kit, 1 in. x 8 ft. Hose (254 mm x 2.4 m), 1.75 in. (45 mm) Hose Adapter	K2389-4	•	•	•	•									•	•	•	•	•	•
Extraction Hose, 1.75 in. x 16 ft. (45 mm x 4.9 m)	K2389-8	•	•	•	•									•	•	•	•	•	•
Extraction Hose, 1.75 in. x 8 ft. (45 mm x 2.4 m)	K2389-9	•	•	•	•									•	•	•	•	•	•
Hose-to-Hose Adapter, 1.75 x 1.75 in. (45 x 45 mm)	K2389-10	•	•	•	•														
Hose Connection Outlet	K2389-2	•	•																
Wall Mounting Bracket	K2389-7	•	•																
Connection Kit, X-Tractor® 3A	K3968-1													•	•				
Connection Kit, X-Tractor® 5A/8A	K3969-1															•	•	•	•
Gun Mounted Nozzle Kit (OT-25)	K639-20			•	•									•	•	•	•	•	•
Starter Overload Switch for 230V	K1494-3																		

Accessories

Product Name	Product No.	Miniflex®		X-Tractor® 16C		Mobiflex® 100-NF		Mobiflex® 200-M		Mobiflex® 400-MS		X-Tractor® 3A		X-Tractor® 5A		X-Tractor® 8A			
		Base Model (120V)	Base Model (230V)	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model		
		K3972-3	K2497-18	K652-1	K652-2	K1666-3	K2497-11	K1653-4	K1653-5	K2497-12	K1741-1	K1741-2	K2497-4	K3965-1	K3965-2	K3966-1	K3966-2	K3967-1	K3967-2
GENERAL, CON'T.																			
LongLife-H Filter	KP2390-1	•	•																
HEPA Filter	KP2390-4	•	•																
Pre-filter	KP2390-3	•	•																
Filter Cartridge for X-Tractor®	KP2069-1			•	•								•	•					
Cellulose Filter	KP1673-1							•	•	•									
MERV 16 Cellulose/Polyester Filter	KP1673-3							•	•	•									
Activated Carbon Filter	KP2389-1	•	•																
Activated Carbon Filter	KP1852-1							•	•	•									
Cellulose Filter	KP1673-2										•	•	•						
MERV 16 Cellulose/Polyester Filter	KP1673-4										•	•	•						
Pre-Filter	KP1673-5							•	•	•									
Pre-Filter	KP1673-6										•	•	•						
Filter, X-Tractor® 5A, 3G, 4G	KP2061-1															•	•		
Filter, X-Tractor® 8A	KP3984-1																	•	•
Miniflex® Filter One-Pak®	KP2390-5	•	•																

Accessories

Product Name	Product No.	Statiflex® 200-M			Statiflex® 400-MS		DownFlex® 100-NF	DownFlex® 200-M	DownFlex® 400-MS/A
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
REQUIRED FOR STATIFLEX® 200-M SINGLE AND DUAL ARM AND STATIFLEX® 400-MS SINGLE ARM⁽¹⁾⁽²⁾									
Extraction Arms [Category 2]									
LTA 2.0 Telescopic Extraction Arm	K1655-10	•	•	•	•	•			
LFA 2.0 6.5 ft. (2 m) Extraction Arm	K1655-12	•	•	•	•	•			
LFA 3.1 10 ft. (3 m) Extraction Arm	K1655-8	•	•	•	•	•			
LFA 4.1 13 ft. (4 m) Extraction Arm	K1655-9	•	•	•	•	•			
LFA 4.1-LC Low Ceiling 13 ft. (4 m) Extraction Arm	K1655-13	•	•	•	•	•			
LTA 2.0-CW Telescopic Extraction Arm	K1655-14	•	•	•	•	•			
Standard System [Category 3A] – Requires fan, starting control and mounting brackets									
SF2400 Stationary Fan (1 HP)	K1656-9	•	•	•	•	•			
Starter Overload Switch for 115V	K1494-2	•	•	•					
Starter Overload Switch for 230V	K1494-3	•	•	•					
Arc Sensor/Lamp Kit for Wall Mounted Arms ⁽²⁾	K1669-4 ⁽²⁾	•	•	•	•	•			
SF2400 Wall Mounting Bracket (use with LFA 3.1 and 4.1)	K1657-1	•	•	•	•	•			
SF2400 Wall Mounting Bracket (use with LTA 2.0, LFA 2.0 and LFA 4.1-LC)	K1657-2	•	•	•	•	•			
Extension Crane System [Category 3B] – Requires fan, starting control and extension crane									
SF4200 Stationary Fan (2 HP)	K1656-4	•		•	•	•			
Starter/Overload Switch for SF4200 Fan	K1494-10	•		•					
Arc Sensor/Lamp Kit for SF4200 Fan	K1669-10	•		•	•	•			
EC 2 Extension Crane, 7 ft. (2.1 m)	K1671-1	•		•	•	•			
EC 4 Extension Crane, 14 ft. (4.3 m)	K1671-2	•		•	•	•			

Statiflex 200-M Single and Dual Arm and Statiflex 400-MS Single Arm » ⁽¹⁾For a Single Arm Package, choose one item from Category 2, and one item each from Systems 3A or 3B. For a Dual Arm Package, choose two items from Category 2, and two items each from System 3A.

Statiflex 400-MS Single Arm » ⁽²⁾Requires Arc Sensor/Lamp Kit to operate Statiflex 400-MS Self-Cleaning Controls.

• Required • Optional

Accessories

Product Name	Product No.	Statiflex® 200-M			Statiflex® 400-MS		DownFlex® 100-NF	DownFlex® 200-M	DownFlex® 400-MS/A
		Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model	Base Model
		K1654-4	K1654-5	K1654-6	K1742-1	K1742-2	K2751-1	K2751-2	K2751-3
GENERAL									
230V Conversion Kit for SF2400 Fan	K1750-1	•	•	•	•	•			
Air Exhaust Silencer	K1534-2	•	•	•	•	•			
Non-Return Valve	K1743-2		•						
Central System Connection Kit	K2752-10						•		
Dust Container	K2752-11						•		
Plasma Cutting Work Grid (max. 50A)	K2752-2						•	•	•
Working Light Kit	K2752-3						•	•	•
Mounting Kit for Bench Vise (cannot use with K2752-2)	K2752-8						•	•	•
Current Activated Start/Stop Sensor (400-MS/A only)	K2752-4								•
Motion Activated Start/Stop Sensor (400-MS/A only)	K2752-5								•
Wheel Kit (max. load 330 lb./149.7 kg)	K2752-6							•	•
Silencer/Outlet Duct	K2752-7							•	•
Dust Tray Lid	K2752-9							•	•
Cellulose Filter	KP1673-1	•	•	•					
MERV 16 Cellulose/Polyester Filter	KP1673-3	•	•	•					
Activated Carbon Filter	KP1852-1	•	•	•					
Cellulose Filter	KP1673-2				•	•			
MERV 16 Cellulose/Polyester Filter	KP1673-4				•	•			
Pre-Filter	KP1673-5	•	•	•					
Pre-Filter	KP1673-6				•	•			
Pre-Spark Arrestors (qty. 2)	KP4052-1							•	•
Spark Arrestors (qty. 2)	KP2752-12						•	•	•
LongLife Filter	KP2752-13							•	•
HEPA Filter Kit	K2752-1							•	•
HEPA Filter for K2752-1	KP2752-14							•	•

Accessories

Guardian™ Fire Safety Solutions

Product Name	Product Number
PREVENTION	
Spark Guardian™ 10	AD1387-4
Spark Guardian™ 16	AD1387-5
Spark Guardian™ 20	AD1387-6
Oil Guardian™ 480/3/60	AD1387-23
DETECTION AND SUPPRESSION	
Guardian™ Control	AD1387-29
Smoke Detector T600	S29287-55
Smoke Detector T1500	S29287-56
Heat Detector Set	AD1387-25
Spark Detector Set	AD1387-27
Sliding Valve, 10 in (254 mm)	AD1387-49
Sliding Valve, 12 in (305 mm)	AD1387-50
Sliding Valve, 16 in (406 mm)	AD1387-51
Sliding Valve, 20 in (508 mm)	AD1387-52
Sliding Valve, 24 in (610 mm)	AD1387-53
Solenoid Valve	AD1387-54
Flame Guardian™ 200	AD1387-55
Flame Guardian™ 500	AD1387-56
Replacement Aerosol Canister, Flame Guardian™ 200	AD1387-55
Replacement Aerosol Canister, Flame Guardian™ 500	AD1387-56



EDUCATION SOLUTIONS

MODEL	JOINT CONFIGURATIONS						POSITIONS						STAND	PROCESS				INPUT					
	Flat Plate	Tee Joint	Groove Joint	6 in. Diameter Schedule 40 Pipe	2 in. Diameter XXS Pipe		1G	2F	2G	3F	3G	4F		4G	5G	6G	All Position	Tabletop	SMAW	GMAW	FCAW-GS	FCAW-SS	Phase

Welding Education Trainers

VRTEX® Engage	●	●	●				●	●	●	●							●	●	●	●		1	50/60	115/230
VRTEX® Mobile	●	●	●				●	●	●	●	●						●	●	●	●	●	1	50/60	115/230
VRTEX® 360	●	●	●	●	●		●	●	●	●	●	●	●	●	●	●		●	●	●	●	1	50/60	115/230
REALWELD®	●	●	●				●	●	●	●	●							●	●	●		1	50/60	115/230

WELDING EQUIPMENT » Power Wave® 300 Ready-Pak® Package · ClassMate™ Robotic Education Cell · Welding Booths · Welding Gear
CUTTING EQUIPMENT » CNC Plasma Cutting 4400 and Other Tables

KEY: ● Excellent ● Good ● Optional

Education Solutions

One Stop. One Partner.

With a century of experience in welding, and more recently, cutting and automation, Lincoln Electric is best positioned to be your welding partner. We used our experience to develop curriculum alongside experienced educators. And we call on that same expertise to provide other services to educators and trainers at every level.

- Qualified School Discounts
- Online Education Resource and Purchasing Portal
- Student Competitions
- Resources for the Classroom or Lab
- Train-the-Trainer Professional Development
- Welding Booth and Fume System Design
- Youth Organization and Union Partnerships
- Grant Writing Consultation



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Oxyfuel Cutting

Literature

MC16-30

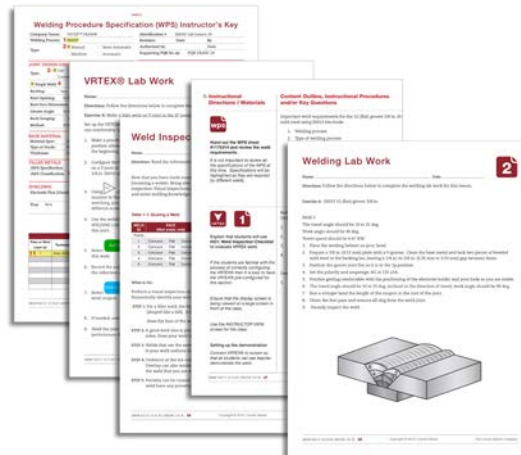
U/LINC™ Welding and Cutting Curriculum

Teach Your Trade. We'll Do the Rest.

Log on to the Learning Management System (LMS) and access the assets you need for each day or week.

Three levels, 24 programs, hundreds of lesson plans, videos, student activities and assessments.

- Addresses welding safety to robotics and CNC plasma cutting and everything in between
- Aligned with AWS SENSE, state competencies and most national standards
- Can be articulated between high schools and community colleges
- Developed by educators for educators – 35 instructors contributed material. Tested in the Lincoln Electric welding school. Reviewed by curriculum staff at two universities.



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Oxyfuel Cutting

Literature

MC15-52

Classroom and Lab Support Materials

Expand Your Training Program

- VRTEX® 360 Extensions™ upgrades add functionality, welding base materials, joints, bend test and instructor capabilities
- Project-Based Lessons are designed to education common core standards and American Welding Society SENSE standards
- Curriculum provide best practices for blending traditional and virtual welding, classroom videos and more



Processes

- Stick
- MIG
- Flux-Cored

Product Number

- K3205-1 VRTEX® 360 New Lessons in Arc Welding, SMAW Curriculum
- K3206-1 VRTEX® 360 New Lessons in Arc Welding, GMAW Curriculum
- K3976-1 Robotic Welding Project Based Lessons, Book 1
- K3976-2 Robotic Welding Project Based Lessons, Book 2
- K4057-1 VRTEX® Project Based Lesson 1 - Student Workbook
- K4057-2 VRTEX® Project Based Lesson 1 - Instructor Guide
- K4058-1 VRTEX® Project Based Lesson 2 - Student Workbook
- K4143-1 Introduction to CNC Plasma Arc Cutting
- AD2435-2 VRTEX® 360 Upgrade 2
- AD2435-3 VRTEX® 360 Upgrade 3
- AD2435-4 VRTEX® 360 Upgrade 4
- AD2435-5 VRTEX® 360 Upgrade 5
- AD2435-6 VRTEX® 360 Upgrade 6

Education Resource and Purchasing Portal

Easy Access. Reduced Program Costs

- 24/7 Online purchasing with access to history and tracking information
- Discounted pricing for qualified schools on electrode, personal protection gear, expendable parts and Magnum® accessories
- FREE shipping on online orders greater than \$500
- Access classroom training and safety materials
- Stream educational videos



VRTEX® Engage

Virtual Reality Outreach Arc Welding Trainer

- The portable system sets up anywhere to introduce the skilled trades to students
- Provides an introductory environment that incorporates STEM features, exposure to welding safety, procedures and techniques
- With VRTEX Engage, there are no licensing requirements or annual fees for use
- Housed in a sturdy rolling hardshell case, contains a complete learning environment. Just open the box and get started
- Instant feedback and assessments
- Video replay for instructor or student review and analysis on the welding process



Processes Simulated

- GMAW: Short arc, spray and pulse
- FCAW: Self-shielded
- SMAW

Input



Literature

MC15-105

Supported by:

U/LINC™ curriculum

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	H x W x D in (mm)	Net Wt. lb (kg)
VRTEX® Engage	K3435-1	115/230/1/50/60	1A @ 115 0.5A @ 230	24.5 x 19.37 x 12.22 (622.3 x 492 x 310.4)	55 (24.9)

VRTEX® Mobile

Virtual Reality Arc Welding Trainer

- Basic to Intermediate Trainer
- Ideal for basic training, recruitment and welder screening activities in education or industry
- Easily transported
- Supports flat plate, tee joint and butt joint welding
- Replay and demo modes



Processes Simulated

- GMAW: Short arc, spray and pulse
- FCAW: Gas-shielded and Self-shielded
- SMAW

Input



Literature

MC12-93

Supported by:

U/LINC™ curriculum

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Input Current @ Rated Output	H x W x D in (mm)	Net Wt. lb (kg)
VRTEX® Mobile	K3434-1	115/230/1/50/60	4A @ 115 2A @ 230	Machine: 32.5 x 19.5 x 38.5 (826 x 496 x 978) Coupon Stand w/Arm 17 x 12 x 14 (431 x 305 x 356) Monitor: 14.4 x 15.4 x 8.0 (366 x 392 x 204) Crate: 42.5 x 24 x 48 (1080 x 610 x 1220)	Machine & Stand: 125 (56.7) Monitor: 20 (9.0) Crate: 155 lbs (70.3 kg)

Power Wave® C300 Education Ready-Pak® Package

Multi-Process Student-Ready Welding Package

- Includes everything you need to get started to teach MIG, TIG and stick welding
- Power Wave® C300 features an internal wire feeder and an output range of 5-300 amps
- Efficient, power saving inverter platform
- CheckPoint™ and WeldScore™ monitoring tools allow instructors to analyze weld data
- PowerConnect™ Technology automatically adjusts to 200-600V, 50 or 60 Hz input power



Supported by: U/LINC™ curriculum

Processes

- Stick
- DC TIG
- Pulsed DC TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E5.100

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output: Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Wt. lb (kg)
Power Wave® C300 [®] Educational Ready-Pak® Pkg.	K2774-4	3-Ph 50/60: 208/220-230/380-415/ 460/575 1-Ph 50/60: 208/220-230	300A/29V/40% 250/27V/100%	3-Ph/40% Duty Cycle: 30/28/16/14/11A 1-Ph/40% Duty Cycle: 53/48/29A	5-300A DC WFS: 50-700 ipm (1.27-17.8 m/min)	33 x 20 x 42 (838 x 508 x 1067)	180 (81.6)

ClassMate™ Robotic Welding Education Cell

Advancing the Manufacturing Skills of the Next Generation

- Teaching robotics, crucial to global competitiveness, can accelerate student skills and employment rates
- Demonstrate and teach real-life industrial robotic concepts, programming and welding
- Ideal for advanced manufacturing welding lab and classrooms, recruitment, trade schools, workforce development
- Fits through a standard doorway and expands for greater work surface area
- Includes robot, welding equipment, integrated safety, teach pendant, software and more
- WeldPro® virtual robotic software simulates a robotic arc welding process in 3-D space
- Robotic Welding Project Based Lessons offers complete project curriculum, including learning activities, step-by-step instructions and discussion questions



Processes

- GMAW
- Pulsed GMAW
- Flux-Cored

Input



Literature

E10.122

Supported by:
U/LINC™ curriculum

Product Name	Product Number	Input Power	H x W x D in (mm)	Net Wt. lb (kg)
ClassMate™ Package 1: Basic	AD2446-1	120V for Robot Operation and Programming	Sides Expanded: 81.23 x 64.82 x 70 (2063 x 1646 x 1778)	1000 (453.6)
Package 2: Intermediate	AD2446-2	208/230/380-415/460/575/1/3/50/60 for Welding Operation	Sides Folded: 81.23 x 32 x 70 (2063 x 813 x 1778)	
Package 3: Advanced	AD2446-3			

Torchmate® 4400 Educational Package

Add CNC Cutting to Your Program

- Ideal 2-D cutting platform for schools, colleges and training centers
- Unlimited Software Licensing for students and one Master Teacher license
- Receive a fully assembled table with base and slate - Just connect air and water
- Torchmate® Visual Machine Designer™ software makes it easy to understand nesting, scanning, tool path concepts and more



Processes

- Plasma Cutting

Literature

Supported by:
U/LINC™ curriculum

Standard Welding Gear Ready-Pak®

Start Your Career Off Right

- Features Traditional FR Cloth Jacket and VIKING™ 1840 Black Helmet
- Long lasting quality
- Comfortable and stylish

Note: Welding gear and electrodes available at discounted prices to qualified schools on the Education Resource and Purchasing Portal



Order Number

- K4416-M
- K4416-L
- K4416-XL
- K4416-2XL
- K4416-3XL

K3096-1
Replacement Lincoln®
Industrial Duffle Bag

Literature

E14.743

Welding Booths

For Stationary Training or Production Environments

- Available options include Work Table with Adjustable Overhead Welding Bracket, Lockable Storage Cabinet and Welding Curtain
- Weld fume source extraction can be added to the booth and connected to a central system
- Rugged steel construction stands up to the demands of a training or production environment
- Available 5 x 5 ft (1.5 x 1.5 m) or 6 x 6 ft (1.8 x 1.8 m) sizes meet AWS guidelines for booth width and depth
- Easy installation



Shown with Optional Lockable Storage Cabinet, Work Table and Extraction Arm.

Processes

- (Dependent on welding power source)
- Stick
 - TIG
 - MIG
 - Flux-Cored
 - Plasma Cutting
 - Oxyfuel Cutting

Literature

MC10-87

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

VRTEX® Engage

System [K3435-1]

- 115 volt input cable
- MIG/FCAW gun device
- SMAW Kit

VRTEX® Mobile

One-Pak® Package [K3434-1]

- Mobile Virtual Welding Machine
- Tabletop Stand
- Arm Rest
- Welding Helmet
- GMAW Gun / SMAW Stinger
- Coupons
 - Flat plate
 - Tee Joint
 - Groove Joint
 - Curriculum
 - Project Based Lessons

VRTEX® 360

System [K3433-1]

- Mobile Virtual Welding Machine
- Welding Stand
- Welding Helmet
- GMAW Gun
- Retractable SMAW Welding Device
- Coupons
 - Flat Plate
 - Tee Joint
 - Groove Joint
 - 2 in. (50.8 mm) diameter XXS Pipe
 - 6 in. (152.4 mm) diameter Sch 40 Pipe
- Curriculum
- Project-based lessons for student and instructor

REALWELD®

Base System [K4344-1]

- REALWELD® System
- Clamps
- Fixtures - 6 in. (152 mm) - Set of 3
- 17 in. (432 mm) Protective Screen Covers
- Calibration Tools

One-Pak Package® [K4344-3]

- Everything listed above
- Power Wave® C300 welding power source [K2675-2]
- Understorage Cart [K2734-2]
- Miniflex® fume extraction system [K3972-3]
- EN 20 Extraction Nozzle [K2389-5]

Power Wave® C300

Educational Ready-Pak® Package [K2774-4]

- Drive Roll Kit, 0.035/0.045 in. (0.9/1.2 mm)
- Input Cord, 10 ft. (3.0 m)
- Work Lead & Clamp, 10 ft. (3.0 m)
- Power Wave® C300 Undercarriage
- Magnum® PRO Curve™ 300 Gun Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- TIG Torch Twist Mate™ to Stud Adapter Cable with 2 ft. (0.61 m) Gas Hose
- PTA-17 Pro-Torch™ TIG Torch
- Twist Mate™ Torch Adapter
- Parts Kits for PTA-17 Series Torches
- Foot Amptrol™
- Stick Electrode Holder and Cable



Shown:
REALWELD®
One-Pak® Package
(K4344-3)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

ClassMate™ Robotic Welding Education Cell

Package 1:Basic (AD2446-1)

- Robotic 3-in-1 Welding Fixture
- Miniflex® Welding Fume Extractor
- EN 20 Extraction Nozzle
- Custom Lettering Program
- Robotic Welding Project Based Lesson
- Basic Robotic Programming Class
- Standard 120VAC input power connection

Package 2:Intermediate (AD2446-2)

- Includes everything above (AD2446-1)
- WeldPRO® Training Program and Software

Package 3:Advanced (AD2446-3)

- Includes everything above (AD2446-2)
- IRVision 2D vision camera system

Torchmate® 4400 Educational System

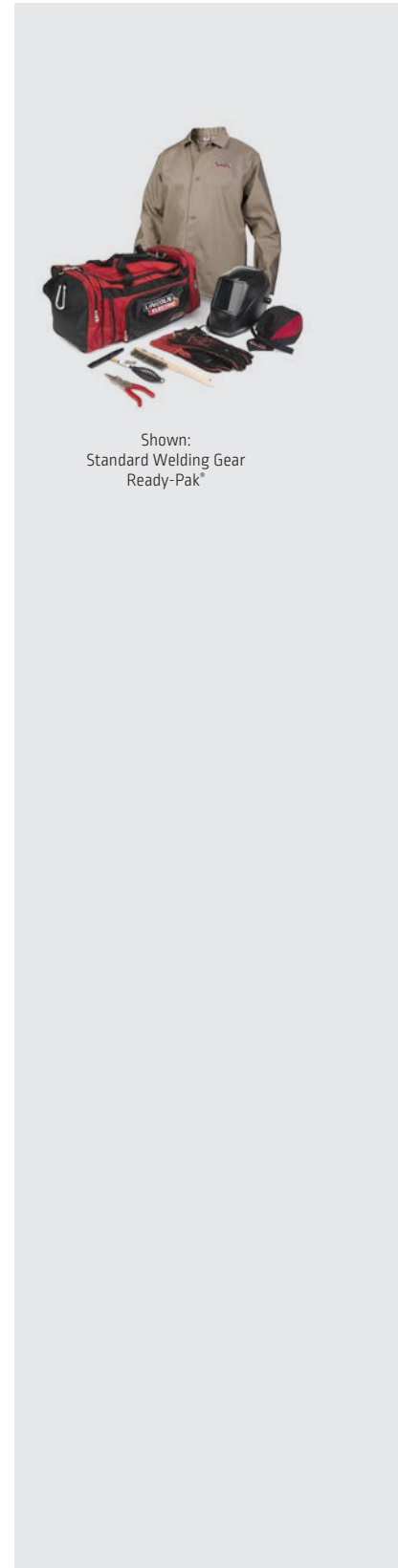
System Includes

- Waterbed Table
- True Arc Voltage Height Control
- USB Electronics Box (cabling included)
- Torchmate® Visual Machine Designer™ Software

Standard Welding Gear Ready-Pak®

Includes

- Lincoln® Industrial Duffle Bag
- Industrial Passive Welding Helmet
- Traditional Khaki FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Lincoln® Startlite® Clear Safety Glasses
- FR Doo Rag
- Spring Handle Chipping Hammer
- Radius™ Welding Pliers
- Radius 3 x19 Carbon Steel Wire Brush









Shown:
Standard Welding Gear
Ready-Pak®









DRIVE AND CABLE ACCESSORIES

Accessories




Feed Plate Gun Adapters

FEED PLATE GUN ADAPTERS COMPATIBLE WITH 10-SERIES, LF-SERIES AND LN-25 PRO FEEDERS					
K1500-1	K1500-2	K1500-3	K1500-4	K1500-5	Magnum® PRO Fast-Mate™
<p>for Lincoln Electric gun power pins</p> <p>Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8</p> 	<p>for Tweco® #2 - #4 gun power pins</p> <p>Compatible Gun Connector Kits K466-10 K466-2 K466-6</p> 	<p>for Tweco® #5 gun power pins</p> <p>Compatible Gun Connector Kits K613-7 K613-2</p> 	<p>for Miller® Electric gun power pins</p> <p>Compatible Gun Connector Kits K466-3 K613-3</p> 	<p>for OXO® gun power pins</p> 	<p>Compatible Gun Connector Kits K489-1 K489-2 K489-7 K489-8</p> 

FEED PLATE GUN ADAPTERS COMPATIBLE WITH 84-SERIES FEEDERS					
K3344-1	K3345-1	K3346-1	K3347-1	K3348-1	K3349-1
<p>For Lincoln Electric gun power pins</p> <p>Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8</p> 	<p>for Tweco® #2 - #4 gun power pins</p> <p>Compatible Gun Connector Kits K466-10 K466-2 K466-6</p> 	<p>for Tweco® #5 gun power pin</p> <p>Compatible Gun Connector Kits K613-7 K613-2</p> 	<p>for Miller® Electric gun power pins</p> <p>Compatible Gun Connector Kits K466-3 K613-3</p> 	<p>for OXO® gun power pins</p> 	<p>Magnum® Fast-Mate™</p> <p>Single and dual procedure guns</p> 

Accessories

Weld Power Cables

Product Name	Product Number	Description	Connection	Length ft (m)
Weld Power Cables   	K1840-10	Weld Power Cable, 1/0, 350A, 60% duty cycle	Twist Mate™ to Lug	10 (3.1)
	K1842-10	Weld Power Cable, 3/0, 600A, 60% duty cycle	Lug to Lug	10 (3.1)
	K1842-35			35 (10.7)
	K1842-60			60 (18.3)
	K1842-110			110 (33.5)
	K1841-25	Weld Power Cable, 1/0, 350A, 60% duty cycle	Twist Mate™ to Twist Mate™	25 (7.6)
	K1841-50	Weld Power Cable, 2/0, 350A, 60% duty cycle		50 (15.2)
	K2163-35 ⁽¹⁾	Weld Power Cable, 4/0	Lug to Lug	35 (10.7)
	K2163-60 ⁽¹⁾			60 (18.3)
	K1796-25	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle	Lug to Lug	25 (7.6)
K1796-50	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle	50 (15.2)		
K1796-75	Coaxial Weld Power Cable, 1/0, 325A, 60% duty cycle	75 (22.8)		
K1796-100	Coaxial Weld Power Cable, 1/0, 300A, 60% duty cycle	100 (30.4)		
K2593-100	Coaxial Weld Power Cable, #1, 250A, 100% duty cycle	Lug to Lug	100 (30.4)	

Weld Cable Connectors






Product Name	Product Number	Description
Plug   	K852-25	Twist Mate™ Plug for #6 - #4 Cable
	K852-50	Twist Mate™ Plug for #2 - #1 Cable
	K852-70	Twist Mate™ Plug for 1/0 & 2/0 Cable
	K852-95	Twist Mate™ Plug for 3/0 & 4/0 Cable
	K3416-70	Tweco® Plug for 1/0 & 2/0 Cable
	K3416-90	Tweco® Plug for 3/0 & 4/0 Cable
Receptacle  	K1759-70	Twist Mate™ Receptacle for 1/0 & 2/0 Cable
	K1759-95	Twist Mate™ Receptacle for 3/0 & 4/0 Cable
	K3417-70	Tweco® Receptacle for 1/0 & 2/0 Cable
	K3417-90	Tweco® Receptacle for 3/0 & 4/0 Cable
Electrode Holder 	K909-6	T300 Electrode Holder (for DC Welder Only)
	K909-7	EH-305HD Electrode Holder, 300A, 60% Duty Cycle
	K909-8	EH-405HD Electrode Holder, 400A, 60% Duty Cycle
Ground Clamp 	K910-1	GC-300 Work Clamp, 300A, 60% Duty Cycle
	K910-2	GC-500 Work Clamp, 500A, 60% Duty Cycle
Other	K2487-1	Insulated CT40FS, Tweco® to Lug

Weld Power Cables » ⁽¹⁾Two cables per package.





Accessories » Control Cables and Adapters

Product Name	Product Number	Description	Connection	Use	Length ft (m)
Wire Feeder Control Cables 	K1501-10	Wire Feeder Control Cable	Male 14-pin to Female 9-pin	LN-10, DH-10	10 (3.1)
	K1818-10		Male 14-pin to Female 6-pin	LN-7	10 (3.1)
	K1819-10		Male 14-pin to Female 8-pin	LN-742, LN-25	10 (3.1)
	K1820-10		Male 14-pin to Female 9-pin	LN-8, LN-9, NA-3, NA-4, NA-5	10 (3.1)
	K1822-25		—	LT-7	25 (7.6)
	K2393-1		Male 14-pin to Female 8-pin	LN-23P (K316L-2)	25 (7.6)
	K2393-2		75 (22.8)		
Extensions and Adapters 	K1797-10	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder. LN-15, FlexFeed, LF-72, LF-74, LN-25 PRO Dual Power	10 (3.1)
	K1797-25				25 (7.6)
	K1797-50				50 (15.2)
	K1797-100				100 (30.4)
	K1798	Adapter Cable Male 14-pin Control Cable to Terminal Strip of Power Source	Terminal Strip to Female 14-pin	—	—
ArcLink®/Linc-Net™ Control Cables 	K1543-8	ArcLink®/Linc-Net™ Control Cable	Male 5-pin to Female 5-pin	For Power Wave®/ Power Feed® Systems, Power Feed 25M, Power Feed 84	8 (2.4)
	K1543-16				16 (4.9)
	K1543-25				25 (7.6)
	K1543-50				50 (15.2)
	K1543-100				100 (30.4)
	K2683-25	Heavy Duty ArcLink®/Linc-Net™ Control Cable			25 (7.6)
	K2683-50				50 (15.2)
	K2683-100				100 (30.4)
Submerged Arc/Automation 	K1785-2	Heavy Duty Control Cable	Male 14-pin to Female 14-pin	For synchronizing Power Wave® AC/DC 1000® SD units and connecting MAXsa™ Feed Heads and MAXsa™ Controllers. For use with FANUC® arms having integrated cable. For connecting Control Unit to Wire Drive in LN-10, DH-10 Boom applications.	1.5 (0.46)
	K1785-4				4 (1.2)
	K1785-8				8 (2.4)
	K1785-12				12 (3.6)
	K1785-16				16 (4.9)
	K1785-25				25 (7.6)
	K1785-50				50 (15.2)
	K1785-100				100 (30.4)
	K2709-25	Wire Drive Control Cable	Male 14-pin to Female 14-pin	For external dress of FANUC® robotic arm or hard automation.	25 (7.6)
	K2709-50				50 (15.2)
	K2709-100				100 (30.4)

Accessories » Drive Roll and Wire Guide Kits

Product Name	Product Number	Description/Wire Size, in [mm]	Wire Feeders
2-ROLL WIRE DRIVE SYSTEMS			
Solid Wire (includes stainless steel) 	KP1696-030S	0.023-0.030 [0.6-0.8]	Activ8™
	KP1696-035S	0.035 [0.9]	LF-72
	KP1696-1	0.035, 0.045 [0.9, 1.2]	LN-25 PRO
	KP1696-2	0.040 [1.0]	LN-25 PRO Dual Power
	KP1696-045S	0.045 [1.2]	Power Feed® 25M
	KP1696-052S	0.052 [1.4]	POWER MIG® 216
Cored Wire 	KP1696-1/16S	1/16 [1.6]	POWER MIG® 216
	KP1697-035C	0.030-0.035 [0.8-0.9]	POWER MIG® 256
	KP1697-045C	0.040-0.045 [1.0-1.2]	POWER MIG® 350MP
	KP1697-052C	0.052 [1.4]	
	KP1697-1/16C	1/16 [1.6]	
	KP1697-068	0.068-0.072 [1.7-1.8]	
Aluminum Wire 	KP1697-5/64	5/64 [2.0]	
	KP1697-3/32 ⁽¹⁾	3/32 [2.4]	
	KP1695-035A	0.035 [0.9]	
	KP1695-040A	0.040 [1.0]	
Solid Wire 	KP1695-3/64A	3/64 [1.2]	
	KP1695-1/16A	1/16 [1.6]	
	KP2529-1	0.025/0.030 [0.6/0.8]	POWER MIG® 140C
Cored Wire 	KP2529-2	0.035 [0.9]	POWER MIG® 180C
	KP2529-3	0.030/0.045 [0.8/ 1.2]	POWER MIG® 180 Dual POWER MIG® 210 MP


Product Name	Product Number	Description/Wire Size, in [mm]	Wire Feeders
4-ROLL WIRE DRIVE SYSTEMS			
Solid Wire	KP4335-035S	0.035 [0.9]	AutoDrive® S
	KP4335-040S	0.040 [1.0]	
	KP4335-045S	0.045 [1.2]	
Aluminum Wire	KP4335-035A	0.035 [0.9]	AutoDrive® SA
	KP4335-364A	3/64 [1.2]	
	KP4335-116A	1/16 [1.6]	
Aluminum Wire	KP4414-035A	0.035 [0.9]	AutoDrive® SA
	KP4414-364A	3/64 [1.2]	
	KP4414-116A	1/16 [1.6]	

Product Name	Product Number	Description/Wire Size, in [mm]	Wire Feeders
4-ROLL WIRE DRIVE SYSTEMS			
Solid Wire, Smooth V Groove 	KP1505-030S	0.023-0.030 [0.6-0.8]	AutoDrive® 4R100
	KP1505-035S	0.035 [0.9]	AutoDrive® 4R200
	KP1505-040S	0.040 [1.0]	DH-10
	KP1505-045S	0.045 [1.2]	FlexFeed™ 74 HT
	KP1505-052S	0.052 [1.4]	FlexFeed™ 84 Single
	KP1505-1/16S	1/16 [1.6]	FlexFeed™ 84 Dual
Cored Steel Wire, Knurled V Groove (Knurled V Groove with matching Smooth U Groove) 	KP1505-1	0.035, 0.045 [0.9, 1.2]	LF-74
	KP1505-2	0.040 [1.0]	LN-10
	KP1505-035C	0.030-0.035 [0.8-0.9]	Power Feed® 10M
	KP1505-045C	0.040-0.045 [1.0-1.2]	Power Feed® 10M Dual
	KP1505-052C ⁽³⁾	0.052 [1.4]	Power Feed® 10R
	KP1505-1/16C ⁽³⁾	1/16 [1.6]	Power Feed® 84 Single
Cored or Solid Steel Wire, Knurled V Groove 	KP1505-7/64H ⁽²⁾⁽³⁾	7/64 [2.8] Hardfacing	Power Feed® 84 Dual
	KP1505-035C	0.030-0.035 [0.8-0.9]	
	KP1505-045C	0.040-0.045 [1.0-1.2]	
	KP1505-052C ⁽³⁾	0.052 [1.4]	
	KP1505-1/16C ⁽³⁾	1/16 [1.6]	
	KP1505-068 ⁽³⁾	0.068-0.072 [1.7-1.8]	
	KP1505-5/64 ⁽³⁾	5/64 [2.0]	
	KP1505-3/32 ⁽³⁾	3/32 [2.4]	
	KP1505-7/64 ⁽²⁾⁽³⁾	7/64 [2.8]	
	KP1505-.120 ⁽²⁾⁽³⁾	0.120 [3.2]	
Hardfacing Wires, Knurled, Smooth V Groove 	KP1505-7/64C	7/64 [2.8]	
	KP1505-7/64H ⁽²⁾⁽³⁾	7/64 [2.8] Hardfacing	
Aluminum Wire, Smooth U Groove 	KP1507-035A	0.035 [0.9]	
	KP1507-040A	0.040 [1.0]	
	KP1507-3/64A	3/64 [1.2]	
	KP1507-1/16A ⁽³⁾	1/16 [1.6]	
	KP1507-3/32A ⁽²⁾	3/32 [2.4]	

⁽¹⁾Not for use with the LF-72. ⁽²⁾Not for use with the LF-74. ⁽³⁾Not for use with the AutoDrive 4R100.





Accessories » Drive Roll and Guide Tube Kits

Product Name	Product Number	Description/Wire Size, in (mm)	Wire Feeders
2-ROLL WIRE DRIVE SYSTEMS			
Solid Wire 	KP653-025S	0.023-0.025 [0.6-0.6]	LN-7 GMA
	KP653-030S	0.030 [0.8]	LN-23P
	KP653-035S	0.035-0.040 [0.9-1.0]	LN-25
	KP653-052S	0.045-0.052 [1.2-1.4]	
Cored Wire 	KP653-035C	0.035 [0.9]	LN-25
	KP653-052C	0.045-0.052 [1.2-1.4]	
Solid or Cored Wire 	KP653-1/16	1/16 [1.6]	LN-25
	KP653-3/32 ⁽²⁾	0.068-3/32 [1.7-2.4]	
Hardfacing	KP653-7/64H ⁽¹⁾	7/64 [2.8]	LN-25
Aluminum Wire	KP654-035A	0.035 [0.9]	LN-25
	KP654-3/64A	3/64 [1.2]	
	KP654-1/16	1/16 [1.6]	
Solid Wire	KP502-052	0.040, 0.045-0.052 [1.0, 1.2-1.4]	LN-8
	KP502-1/16	1/16 [1.6]	LN-9
Cored Wire	KP502-052C	0.045-0.052 [1.0-1.4]	LN-9
	KP502-1/16C	1/16-0.062 [1.6-1.6]	
	KP502-120	7/64-0.120 [2.8-3.0]	
Solid or Cored Wire	KP502-3/32	0.068-3/32 [1.7-2.4]	LN-9
Hardfacing	KP502-7/64H	7/64 [2.8]	LN-9

Product Name	Product Number	Description/Wire Size, in (mm)	Wire Feeders
2-ROLL WIRE DRIVE SYSTEMS			
Solid Wire Drive Roll	KP1899-1	3/32-7/32 [2.4-5.6]	NA-3S
	KP1899-2	1/16, 5/64, 3/32 [1.6, 2.0, 2.4]	NA-4
	KP1899-3	0.035, 0.045, 0.052 [0.9, 1.2, 1.4]	NA-5
Cored Wire Drive Roll	KP1899-4	0.045-0.052 [1.0-1.4]	NA-5
Knurled Drive Roll 	KP1885-1	3/32-7/32 [2.4-5.6]	NA-5
	KP1886-1	1/16-3/32 [1.6-2.4]	
Outgoing Guide	KP1963-1	3/32-7/32 [2.4-5.6]	NA-5
Incoming Guide	KP2116-2	3/32-7/32 [2.4-5.6]	NA-5

⁽¹⁾Not for use with the LN-25 PRO and LN-25 PRO Dual Power. ⁽²⁾For LN-7 only.

Welding Safety Checklist

Hazard	Factors To Consider	Precaution Summary
Electric Shock Can Kill 	<ul style="list-style-type: none"> Wetness Welder in or on workpiece Electrode holder and cable insulation 	<ul style="list-style-type: none"> Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood. Wear dry, hole-free gloves. (Change as necessary to keep dry.) Do not touch electrically "hot" parts or electrode with bare skin or wet clothing If wet area and welder cannot be insulated from workpiece with dry insulation, use a semiautomatic, constant-voltage welder or stick welder with voltage reducing device. Keep electrode holder and cable insulation in good condition. Do not use if insulation damaged or missing.
Fumes and Gases Can Be Dangerous 	<ul style="list-style-type: none"> Confined area Positioning of welder's head Lack of General ventilation Electrode types (i.e.: manganese, chromium, etc. – see SDS) 	<ul style="list-style-type: none"> Use ventilation or exhaust to keep air breathing zone clear, comfortable. Use helmet and positioning of head to keep fumes clear of the breathing zone. Read warnings on electrode container and Safety Data Sheet (SDS) for electrode Provide adequate ventilation to ensure airborne exposures remain below applicable limits. Use special care when welding in a confined area. Do not weld unless ventilation is adequate. Use a respirator unless exposure assessments indicate otherwise.
Welding Sparks Can Cause Fire or Explosion 	<ul style="list-style-type: none"> Containers which have held combustibles Flammable materials 	<ul style="list-style-type: none"> Do not weld on containers which have held combustible materials (unless strict AWS F4.1 procedures are followed). Check before welding. Remove flammable materials from welding area or shield from sparks, heat. Keep a fire watch in area during and after welding. Wear fire retardant clothing and hat. Use earplugs when welding overhead.
Arc Rays Can Burn Eyes and Skin 	<ul style="list-style-type: none"> Process: Gas-shielded arc most severe 	<ul style="list-style-type: none"> Select a filter lens which is adequate for your welding process under ANSI Z49.1, Section 4. Always use helmet when welding. Provide non-flammable shielding to protect others. Wear clothing which protects skin while welding.

Arc Welding Fumes and Gases

The **fume plume** contains solid particles from the consumables, base metal, and base metal coating. For common mild steel arc welding, depending on the amount and length of exposure to these fumes, most immediate or short term effects are temporary, and include symptoms of burning eyes and skin, dizziness, nausea, and fever. Long-term exposure to welding fumes can lead to siderosis (iron deposits in the lungs) and may affect pulmonary function. Bronchitis and some lung fibrosis have been reported.

Some compounds which may be in welding fume, and reported health effects of overexposure are below. See the SDS for the consumable product used for specific information.

- Barium** may cause severe stomach pain, slow pulse rate; irregular heartbeat, ringing of the ears, convulsion and muscle spasms. In extreme cases can cause death.
- Cadmium** fumes can be fatal even under brief overexposures, with symptoms much like metal fume fever.
- Chromium** and its compounds are on the IARC (International Agency for Research on Cancer) and NTP (National Toxicology Program) lists as posing a cancer risk to humans. Some forms of these metals are known or suspected to cause lung cancer in processes other than welding and asthma has been reported.
- Manganese:** Manganese overexposure may affect the central nervous system, resulting in poor coordination, difficulty in speaking, and tremor of arms or legs. This condition is considered irreversible.
- Nickel:** Nickel and its compounds are on the IARC (International Agency for Research on Cancer) and NTP (National Toxicology Program) lists as posing a cancer risk to humans.
- Silica:** Overexposure can cause severe lung damage (silicosis). Crystalline silica is present in submerged arc flux.
- Zinc:** Overexposure to zinc may cause metal fume fever with symptoms similar to the common flu.

Your work area has adequate ventilation when there is enough ventilation and/or exhaust to control worker exposure to hazardous materials in the welding fumes and gases so the applicable limits for those materials is not exceeded. See the SDS for the legal limits, the OSHA PEL (Permissible Exposure Limit), and the recommended guideline, the ACGIH TLV (Threshold Limit Value). Confirm that if the worker exposure does not exceed the applicable exposure limit for compounds in the fumes and gases by having an industrial hygienist take and analyze a sample of the breathing air. A respirator may be required if exposure cannot be controlled to the PEL or TLV.

Read the product label and material safety data sheet for the electrode posted in the work place or in the electrode or flux container to see what fumes can be reasonably expected from use of the product and to determine if special ventilation is needed. Know what the base metal is, and determine if these is any paint, plating, or coating that could expose you to toxic fumes and/or gases. Remove it from the metal being welded, if possible.

If you start to feel uncomfortable, dizzy or nauseous, you may be overexposed to fumes and gases, or suffering from oxygen deficiency. Stop welding and get some fresh air immediately. Notify your supervisor and co-workers so the situation can be corrected and other workers can avoid the hazard. Be sure you are following these safe practices, the consumable labeling and SDS and improve the ventilation in your area. Do not continue welding until the situation has been corrected.



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