

# LN-25 PRO Wire Feeders

## Processes

MIG, MIG-STT<sup>®(1)</sup>, Pulsed, Flux-Cored

## Product Number

K2613-5 PRO Standard  
K2613-7 PRO Extra Torque  
K2614-6 PRO Dual Power  
K2614-5 PIPE

**K2614-9 Ironworker<sup>®</sup>**

See back for complete specs

## Input Power

15-110 VDC (Standard/Extra Torque/  
Pipe/Ironworker<sup>®</sup>)  
15-110 VDC or 24-42 VAC (Dual Power)

**Output Capacity Current/Duty Cycle**  
450A/60%

**Wire Size Range**  
See Back

## Wire Feed Speed Range

See Back

## Weight/Dimensions (H x W x D)

Weight varies per model  
15 x 8.7 x 23.2 in.  
(381 x 221 x 589 mm)

## Portable Industrial Wire Feeders

LN-25 PRO series wire feeders are designed to be simple, reliable and easy to service. Whether you are an ironworker, pipeline welder, or weld at a construction site, shipbuilding facility or metal fabrication shop, we have the right semiautomatic wire feeder for you.

### FEATURES

#### ▶ Maxtrac<sup>®</sup> Wire Drive System -

Heavy-duty cast aluminum wire drive system provides reliable feeding and durability.

#### ▶ Dual Range Wire Feed Speed -

Delivers greater precision at low end wire feed speeds.

#### ▶ Trigger Interlock Switch -

Provides operator comfort for long welds.

#### ▶ Replaceable and Flame Resistant Case

Rugged and durable case can be replaced in less than five minutes.

#### ▶ Potted PC Boards -

For moisture and corrosion protection.

### APPLICATIONS

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



### WHAT'S INCLUDED STANDARD/EXTRA TORQUE/DUAL POWER

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

### PIPE

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

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

### IRONWORKER<sup>®</sup>

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

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

### OUTPUT



### INPUT

All Models  
Across the Arc



K2614-6 Only  
Control Cable



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

(1) STT<sup>®</sup> capability only with K2614-6 Dual Power Model.



Web Update 05/12

Publication E8.101 | Issue Date 03/11  
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**LINCOLN<sup>®</sup>**  
**ELECTRIC**  
THE WELDING EXPERTS<sup>®</sup>

**CHOOSE THE RIGHT MODEL FOR YOUR APPLICATION**



	LN-25 PRO Standard	LN-25 PRO Extra Torque	LN-25 PRO Dual Power	LN-25 PIPE	LN-25 Ironworker®
Maxtrac® Wire Drive System	●	●	●	●	●
Dual Range Wire Feed Speed	●	●	●	●	●
CC/CV Switch	●	●	●		
Trigger Interlock Switch	●	●	●	●	●
Replaceable, Flame Resistant Case	●	●	●	●	●
Potted PC Boards For Moisture and Corrosion Protection	●	●	●	●	●
Flow Meter	●	●	●		
Extra Torque For Up To 3/32 in. Diameter Wire Welding		●			
STT® Ready With Remote Control Capabilities			●		
Digital Display For Amperage and Wire Feed Speed			●	●	●
14 lb. (6 kg) Innershield® Coil Adapter (K435)				●	

**REQUIRED OPTIONS**

**MAXTRAC® DRIVE ROLL & WIRE GUIDE KITS**

Description	Order No.
<b>Steel Wire Sizes (includes stainless steel):</b>	
.023-.030 in (0.6-0.8 mm)	KP1696-030S
.035 in (0.9 mm)	KP1696-035S
.045 in (1.2 mm)	KP1696-045S
.052 in (1.4 mm)	KP1696-052S
.035, .045 in (0.9, 1.2 mm)	KP1696-1
.040 in (1.0 mm)	KP1696-2
1/16 in (1.6 mm)	KP1696-1/16S
<b>Cored Wire Sizes:</b>	
.030-.035 in (0.8-0.9 mm)	KP1697-035C
.040-.045 in (1.0-1.2 mm)	KP1697-045C
.052 in (1.4 mm)	KP1697-052C
1/16 in (1.6 mm)	KP1697-1/16C
<b>Steel or Cored Wire Sizes:</b>	
.068-.072 in (1.8 mm)	KP1697-068
5/64 in (2.0 mm)	KP1697-5/64
3/32 in (2.4 mm)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
.035 in (0.9 mm)	KP1695-035A
.040 in (1.0 mm)	KP1695-040A
3/64 in (1.2 mm)	KP1695-3/64A
1/16 in (1.6 mm)	KP1695-1/16A

**WELD POWER CABLES**

Description	Order No.
Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)	K1842-10
Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)	K1842-35
Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)	K1842-60
Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)	K1842-110
Twist Mate™ to Twist Mate™, 1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
Twist Mate™ to Twist Mate™, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50

**CONTROL EXTENSION CABLES**

Description	Order No.
Control Cable Extension, 10 ft. (3.0 m) - male 14 pin to female 14 pin	K1797-10
Control Cable Extension, 25 ft. (7.6 m) - male 14 pin to female 14 pin	K1797-25
Control Cable Extension, 50 ft. (15.2 m) - male 14 pin to female 14 pin	K1797-50
Control Cable Extension, 100 ft. (30.4 m) - male 14 pin to female 14 pin	K1797-100

## KEY CONTROLS

### LN-25 PRO/LN-25 PRO EXTRA TORQUE



- |                                   |                         |
|-----------------------------------|-------------------------|
| 1. Analog Voltmeter               | 8. Gas Purge Pushbutton |
| 2. Wire Feed Speed Knob           | 9. Flow Meter Ball      |
| 3. Dual Range Speed Switch        | 10. Flow Meter Valve    |
| 4. 5-Pin Gun Trigger Connector    | 11. Shielding Gas Inlet |
| 5. Work Sense Lead                | 12. Electrode Lead      |
| 6. Thermal Protection LED         |                         |
| 7. Welding Polarity Indicator LED |                         |

### LN-25 PRO DUAL POWER



- |   |                                |
|---|--------------------------------|
| 1. Wire Feed Speed/Amperage Display               | 11. Gas Purge Pushbutton       |
| 2. Wire Feed Speed LED                            | 12. Flow Meter Ball            |
| 3. Amperage LED                                   | 13. Flow Meter Valve           |
| 4. Wire Feed Speed Knob                           | 14. Shielding Gas Inlet        |
| 5. 5-Pin Gun Trigger Connector                    | 15. 14-Pin Control Cable Input |
| 6. Work Clip Connection                           | 16. Electrode Lead             |
| 7. Thermal LED                                    |                                |
| 8. Voltage Display                                |                                |
| 9. Voltage LED                                    |                                |
| 10. Remote Voltage Control Knob (not presettable) |                                |

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

### LN-25 PIPE / IRONWORKER®



- |                                     |                         |
|-------------------------------------|-------------------------|
| 1. Wire Feed Speed/Amperage Display | 10. Gas purge button    |
| 2. Wire Feed Speed LED              | 11. Shielding Gas Inlet |
| 3. Amperage LED                     | 12. Electrode Lead      |
| 4. Wire Feed Speed Knob             |                         |
| 5. 5-pin Gun Trigger Connector      |                         |
| 6. Work Clip Connection             |                         |
| 7. Thermal LED                      |                         |
| 8. Voltage Display                  |                         |
| 9. Voltage LED                      |                         |

### RECOMMENDED POWER SOURCES

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

## FEED PLATE GUN RECEIVER BUSHINGS

K1500-1 Gun Receiver Bushing	K1500-2 Gun Receiver Bushing	K1500-3 Gun Receiver Bushing	K1500-4 Gun Receiver Bushing	K489-7 Fast-Mate Gun Receiver Bushing
<ul style="list-style-type: none"> <li>Magnum® PRO Curve™ 200, 300 and 400 with K466-1 connector kit.</li> <li>Magnum® PRO 250, 350 and 450 with K466-1 connector kit.</li> <li>Magnum® PRO 550 with K613-1 connector kit.</li> <li>K126™ PRO Innershield®</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® PRO 200, 300 and 400 w/K466-10 connector kit.</li> <li>Magnum® PRO 250, 350 and 450 w/K466-10 connector kit.</li> <li>Magnum® PRO 550 with K613-7 connector kit.</li> <li>K126™ PRO Innershield®</li> <li>Guns with Tweco® #2, #3, and #4 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® PRO 550 with K613-3 connector kit.</li> <li>K126™ PRO Innershield®</li> <li>Guns with Tweco® #5 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® PRO 200, 300 and 400 w/K466-3 connector kit.</li> <li>Magnum® PRO 250, 350 and 450 w/K466-3 connector kit.</li> <li>Magnum® PRO 550 with K613-3 connector kit.</li> <li>K126™ PRO Innershield®</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® with Fast-Mate™ connections.</li> <li>Handles single and dual procedure guns.</li> </ul>

## RECOMMENDED ACCESSORIES

**K126 PRO Innershield® Gun**  
350A, 60% duty cycle air-cooled gun for flux-cored self-shielded Innershield® welding. Magnum® PRO expendable parts.  
**Order K126-11 (15 ft/4.5 m, K613-6 Gun Connector)**  
**Order K126-12 (15 ft/4.5 m, K466-10 Gun Connector)**

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

**8 In. O.D. Spool Adapter**  
For small spools. Permits 8 in. (203 mm) O.D. spools to be mounted on 2 in. (51 mm) or 2.5 in. (64 mm) O.D. spindles.  
**Order K468**

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

**Prewflow, Postflow and Burnback Timer Kit**  
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.  
**Order K2330-2**

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

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

**Jumper Plug Kit**  
For use with CV only power sources with 14 pin MS-type wire feeder connections and no contactor control switch. Jumper plug kit closes contactor for always hot welding output.  
**Order K484**

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

**Magnum® PRO Curve™ Semiautomatic Guns**  
Magnum® PRO Curve™ guns for MIG or flux-cored, gas-shielded welding. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum® PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.  
**See publication E12.05**

**14 Lb. Innershield® Coil Adapter**  
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. Wire not included.  
**Order K435**

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

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## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Flow Meter	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)			Dimensions H x W x D in. (mm)	Net Weight Lbs. (kg)
						Solid	Cored	Aluminum		
LN-25 PRO Standard	K2613-5	15-110 VDC	450A/60%	Yes	50-700 (1.3-17.7)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	Approx. 37 (16) Varies per model
LN-25 PRO Extra Torque	K2613-7				30-400 (0.8-10.1)		.030-3/32 (0.8-2.4)			
LN-25 PRO Dual Power	K2614-6				15-110 VDC or 24-42 VAC		50-700 (1.3-17.7)			
LN 25 PIPE	K2614-5	15-110 VDC	No							
LN-25 Ironworker®	K2614-9									

### CUSTOMER ASSISTANCE POLICY

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