

LN-8 and LN-9

Processes

Flux-Cored, Submerged Arc

Product Number

K297 LN-8

K357-1 LN-9

See back for complete specs

Input Power

115 VAC 50/60 Hz

Input Current at Rated Output

208V:39A / 230V:35A

Output Capacity Current/Duty Cycle

600A @ 60%

Wire Size Range

.040-3/32 in (1.0-2.4 mm)

Wire Feed Speed

50 - 600 IPM (1.3 - 15.2 m/min)

Weight/Dimensions (H x W x D)

See Back

Semiautomatic Wire Feeders

The LN-8 and LN-9 are semiautomatic wire feeders providing dependable performance and reliable operation, making them ideal for shop or field operations. For precise wire feeding and quality welds, the LN-8 and LN-9 feature controlled wire feed speed and voltage during starting for clean, positive starts and reduced stubbing, skipping and spatter.

FEATURES

- ▶ **Completely enclosed case** - Protects the heavy duty wire drive mechanism from damage, yet allows easy access to drive rolls.
- ▶ **Rugged and durable design** - Recognized throughout the industry for its long life and years of trouble-free wire feeding.
- ▶ **Standard digital meter** - Can be set to read volts, inches or meters/minute on the LN-9.
- ▶ **Control of wire feed speed and voltage at the wire feeder** - Eliminates the need to return to the power source to adjust procedures.
- ▶ **Optional Burnback Kit** - Provides adjustable delay of power source output shut off to prevent the electrode from sticking in the weld metal when using high wire feed speeds.

APPLICATIONS

- ▶ Fabrication
- ▶ Structural
- ▶ Heavy Equipment
- ▶ Construction



LN-8 and LN-9 shown with options.

RECOMMENDED WELDERS

- ▶ CV-400
- ▶ CV-655
- ▶ DC-400
- ▶ DC-600
- ▶ DC-655
- ▶ Vantage® 500
- ▶ Air Vantage® 500

INPUT



OUTPUT

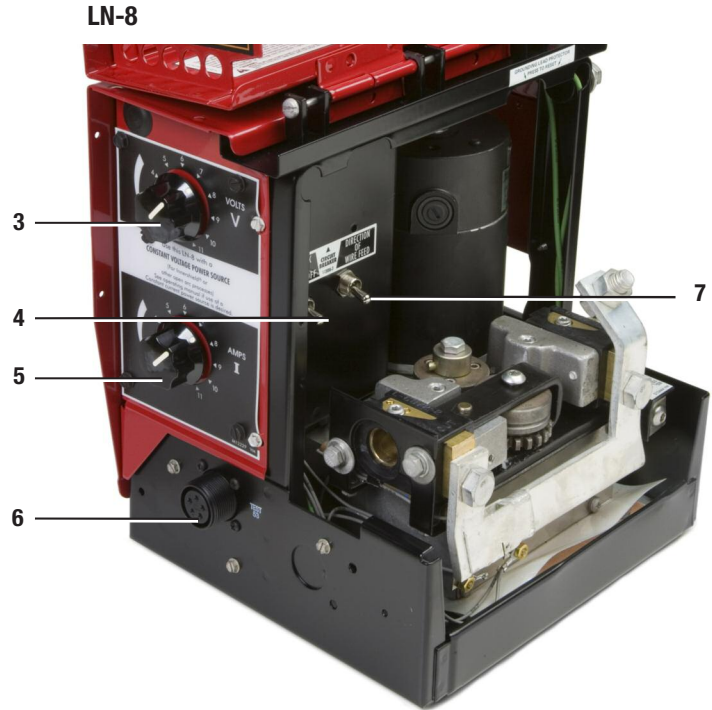
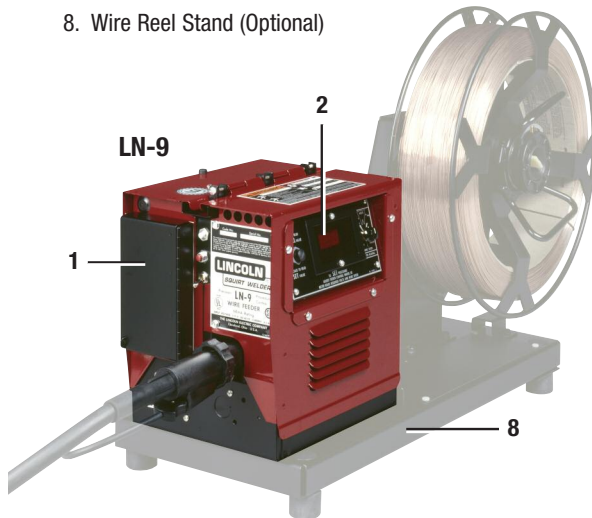


Two Year Extended
Warranty Available in
U.S.A. and Canada



KEY CONTROLS

1. Lockable Control Panel Cover
2. Digital Meters on LN-9
3. Voltage Control
4. 2-Step Trigger Interlock
5. Amperage Control
6. Gun Trigger Connector
7. Wire Feeding Direction Switch
8. Wire Reel Stand (Optional)



REQUIRED OPTIONS

DRIVE ROLL AND GUIDE TUBE KITS

Steel Wire Sizes / in. (mm)	LN-8 and LN-9
Solid Wire: .040, .045 - .052 (1.0 - 1.4) 1/16 (1.6)	KP502-052 KP502-1/16
Cored Wire: .045 - .052 (1.0 - 1.4) 1/16 - .062 (1.6) 7/64 - .120 (2.8 - 3.0)	KP502-052C KP502-1/16C KP502-120
Solid or Cored Wire: .068 - 3/32 (1.7 - 2.4)	KP502-3/32
Hardfacing: 7/64 (2.8)	KP502-7/64H

CONTROL CABLES

Cable Type	Description
Wire Feeder Control Cable K1820-10	Male 9 pin to female 14 pin
Wire Feeder Control Cable Extensions K1797-10 - 10 ft. (3.0 m) K1797-25 - 25 ft. (7.5 m) K1797-50 - 50 ft. (15.2 m) K1797-100 - 100 ft. (30.4 m)	Male 14 pin to female 14 pin

WELD POWER CABLES

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

RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES

GUN & CABLE ASSEMBLIES



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



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



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)**



Magnum® Submerged Arc Gun
Rated 600 amps, 60%, 15 ft. (4.5 m) cable. **Order K113-1** for 5/64 in. (2.0 mm) electrode size **Order K113-2** for 3/32 in. (2.4 mm) electrode size



Mechanized SAW Gun
Rated 600 amps 60%, for 5/64 and 3/32 in. (2.0 and 2.4 mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit. **Order K114**



Flux Cone
Fits K113 submerged arc guns for welding without the Continuous Flux Feed Tank Assembly. **Order K119**

GENERAL OPTIONS



Universal Wire Reel Stand
For use with Lincoln Electric 10-60 lbs. (4.5-27.2 kg) wire packages that use a 2 in. (51 mm) spindle. Hole in stand fits over lift bail. **Order K1524-3**



Light Duty Caster Kit
Mounts to the K1524-3 wire reel stand. Allows for easy movement of wire feeder. **Order K1556-1**



Swivel Platform
Mounts to the lift bail on the power source and bottom of the K1524-1. Wire feeder may be lifted off if needed. Compatible with Light Duty Caster Kit. Includes "lazy susan" parts tray. **Order K1557-1**



Insulated Lift Bail
Allows the entire wire feeder to be hung from a crane or hook. Use with K1524-3. **Order K1555-1**



50-60 lb. Coil Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln Electric electrode to 2" (51 mm) spindle. **Order K1504-1**



14 lb. Innershield® Coil Adapter
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. **Order K435**



Plastic Wire Cover
Plastic enclosure for wire packages. **Order K1634-1** for 30-40 lbs. (13.6-19.9 kg) **Order K1634-2** for up to 60 lbs. (27.2 kg)



Control Cable to Terminal Strip Adapter
Connects 14-pin control cable to power sources with terminal strip. **Order K1798**



Gas Solenoid Kit
Includes solenoid valve and mounting bracket. **Order K425** (above code 9131)



Wire Feed Speed Meter Kit
Analog meter indicates welding voltage and wire feed speed directly on a 0-60 volt scale. **Order K261**



Burnback Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds. Includes a cold inch switch. **Order K202**



Magnetic Flux Screen Separator
For submerged arc welding. Removes foreign magnetic particles from reused flux. **Order K58**



Wire Reel and Flux Tank Assembly
Includes flux tank, undercarriage, and reel and brake assembly in open shroud. **Order K305**



Undercarriage
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stand. **Order K163**



Mechanized Hand Travel Unit
Carries the K114 Mechanized SAW Gun along the joint at a preset travel speed to help the operator make better welds 10% to 25% faster than with manual travel. Speed range is 7-60 ipm (0.2-1.5 m/min). Requires a K161 Power Pack to drive unit. **Order K110**



Power Pack
Includes travel mag-amp circuit required when using either a Squirtmobile or Mechanized Hand Travel Unit with a K114 SAW gun. Mounts near power source. Connect to the power source for input power. 50 ft. (15 m). **Order K161-50**



Portable Digital Wire Feed Speed Meter
When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute. **Order K283**

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)			H x W x D inches (mm)	Net Weight lbs. (kg)
					Cored	Solid	Hardfacing		
LN-8	K297	115 VAC 50/60 Hz	600A @ 60%	50-600 (1.3-15.2)	.045-.120 (1.2-3.0)	.040-3/32 (1.0-2.4)	7/64 (2.8)	10.9 x 9.8 x 9.6 (227 x 248 x 244)	36 (16.2)
LN-9	K357-1							11.5 x 11.3 x 11.5 (292 x 287 x 292)	42 (19)

**For best welding results with Lincoln Electric equipment,
always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.**

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.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

