

LN-25 Wire Feeder

Portable, Construction Wire Feeder

The LN-25 semiautomatic wire feeder is ideal for field or construction use. Since it is powered across the arc, no control cables are needed! Simply connect the weld cable, attach the arc sensing clip, and you're ready to go. This portable MIG and flux-cored wire feeder comes in a fully enclosed case to protect against damage on the job site. The LN-25 features a tool-less quick release mechanism for easy wire changing, and it accepts 10-44 lbs. (4.5-19.9 kg) wire packages for plenty of welding versatility.



Processes

MIG Flux-Cored

Advantage Lincoln

- For MIG and flux-cored arc welding processes using up to 44 lb. (19.9 kg) spools.
- Designed for .023-1/16" (0.6-1.6mm) solid, .035-5/64" (0.9-2.0mm) cored and .035-1/16" (0.9-1.6mm) aluminum wire sizes.
- Selectable dial for setting low range, 50-350 ipm (1.3-8.9m/min) wire feed speed or high range, 50-700 ipm (1.3-17.8m/min) wire feed speed.
- Includes DC voltmeter, voltmeter polarity switch and 15 ft. (4.6m) arc sensing lead and clip and 20" (508mm) weld power cable.
- For use with Magnum® flux-cored and MIG guns.
- Automatic overvoltage and motor overload shutdown protection.
- Double-latched case features an insulated gun holder and easy access to wire.
- Entire unit is compact and portable and will pass through a 16" (400mm) diameter manway.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Three-year warranty on parts and labor.

Description

Output



Base Unit Includes

Arc Sensing Lead & Clip, 15 ft. (4.5m), Weld Power Cable, 20" (508mm)

Required Options

Gun and Cable Assembly, Drive Roll Kit, Weld Power Cable, Cable Lug, Twist-Mate Cable Plug

Recommended General Options

Jumper Plug Kit, Remote Voltage and Output Control Kits, Gas Solenoid Kit, Internal Contactor Kit, Gas Flow Timer Kit, 30 lb. Adapter, Spindle Adapter

Recommended Power Source Options

All Lincoln Engine Driven or Electric Welders with CV Capability

Order

- K428 LN-25 Wire Feeder
K449 LN-25 Wire Feeder with Internal Contactor and Gas Solenoid

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current / Duty Cycle	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	Aluminum	Cored		
LN-25 Across-The-Arc	K428	15-40V DC (110V DC Max. OCV)	Up to 500A / 60%	50 - 700 (1.2 - 17.7)	.023 - 1/16" (0.6 - 1.6)	.035 - 1/16" (0.9 - 1.6)	.035 - 5/64" (0.9 - 2.0)	14 x 7.4 x 21 (356 x 188 x 533)	28 (12.7)
	K449		Up to 300A / 60%						35 (15.4)

PERFORMANCE

- 2-roll wire drive system for easy wire feeding.
- The LN-25 provides constant wire feed speed for use with constant voltage (CV) power sources, and arc sensing wire feed speed for use with constant current (CC) power sources⁽¹⁾.

- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.

(1) Most semiautomatic wire welding processes perform better using CV power sources. Be sure the proper power source is used for your application. Contactor life may be shortened in applications using CC power sources with high OCV.

FEATURES

- Tool-less quick release wire drive tension system and gun cable connections for easy wire or gun changes.
- Optional gas solenoid, timer kit for preflow and postflow of gas, internal contactor, and remote voltage control kits are available.
- Standard Voltmeter

Key Controls

1. Optional Remote Voltage Control
2. Optional Gas Timer Flow Kit
3. Voltmeter Polarity Switch
4. Trigger Connection
5. Arc Sensing Lead and Clip
6. Skid Plate
7. Riveted Door and Hinge Assembly
8. Gun and Cable Connection
9. Voltmeter
10. Molded Case Door
11. Case Latches
12. Fold Down Carrying Handle



QUALITY AND RELIABILITY

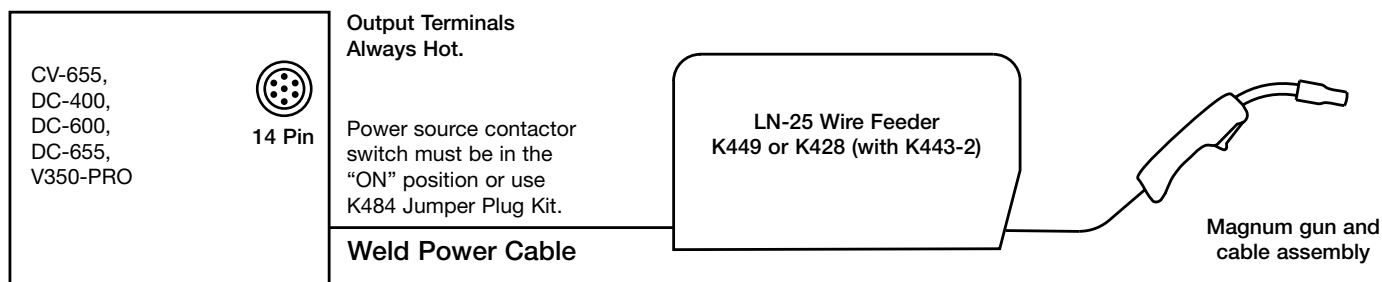
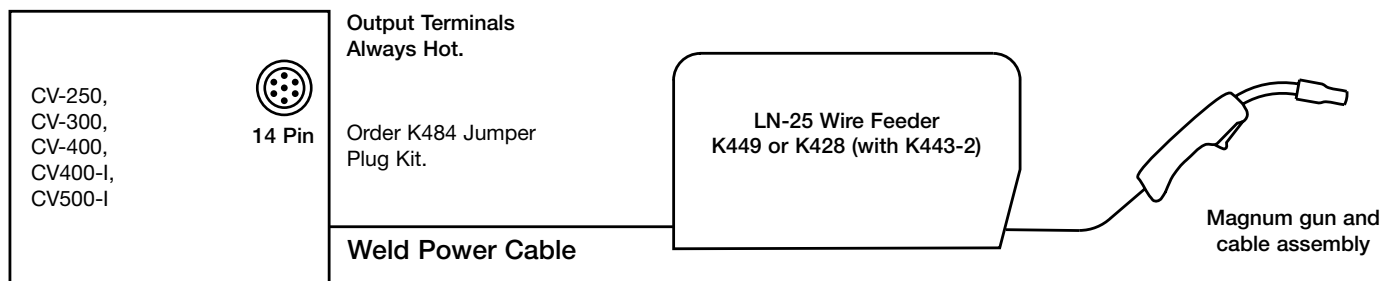
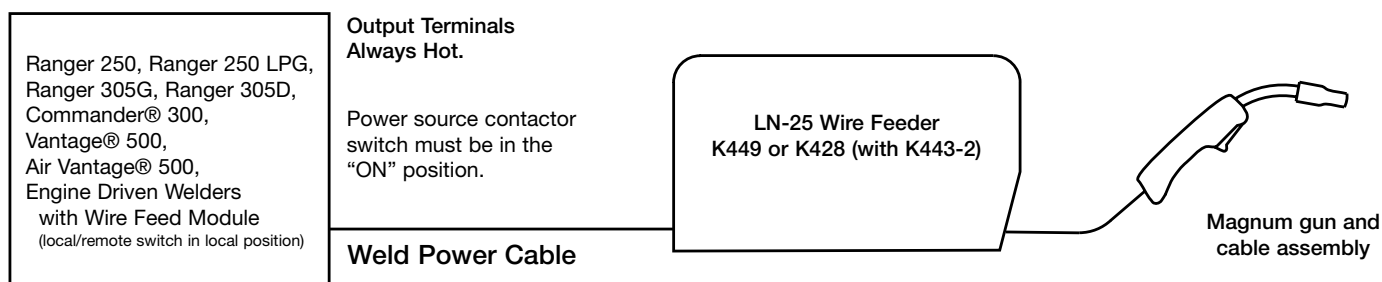
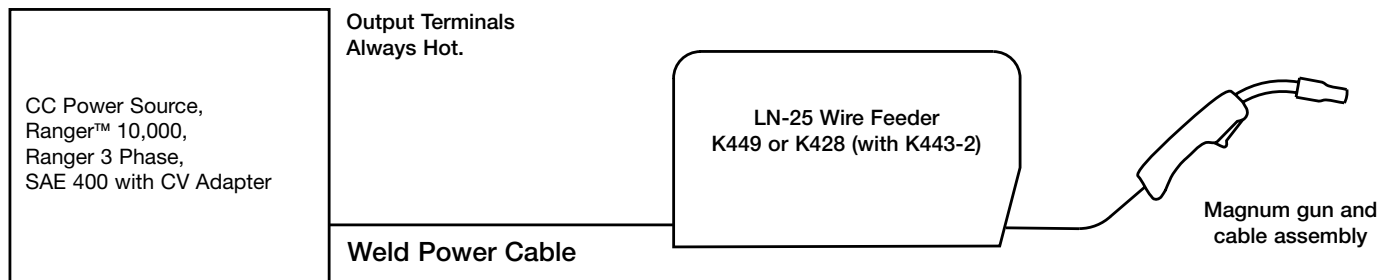
- Fully enclosed molded case meets UL94-VO flammability resistance and is heat, spatter, and impact resistant.
- Automatic overvoltage and motor overload shutdown protection.

- Three-year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9001 requirements.
- CSA approved.

ACROSS THE ARC SET-UP (with Electrode Cold Operation)

Electrode cold operation is available with K449 or K428 (with optional K443-2 Internal Contactor Kit installed).

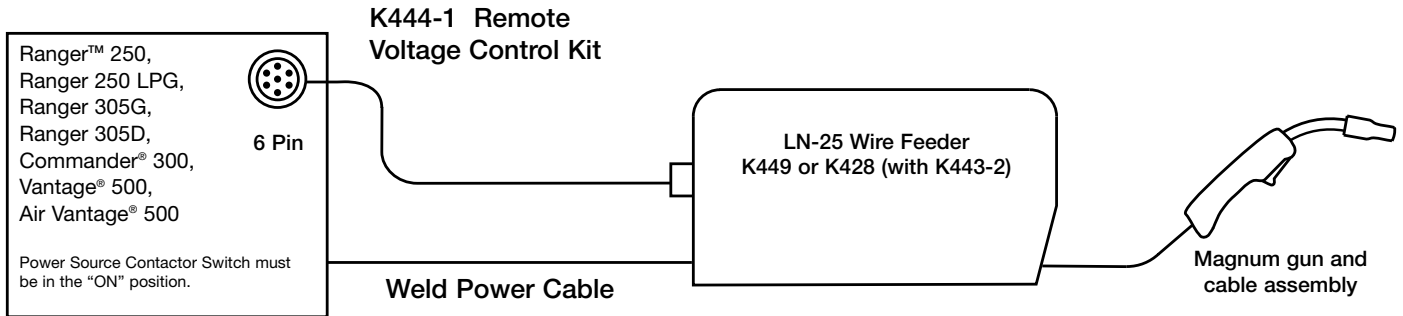
(Connections are for current equipment design. Subject to change without notice.)



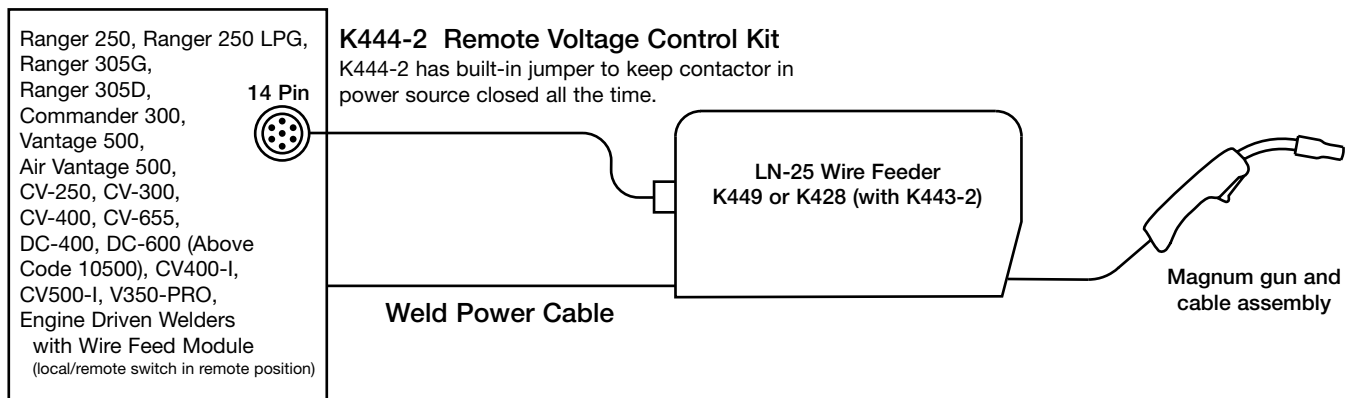
ACROSS THE ARC SET-UP (with Electrode Cold Operation and Remote Voltage Control at LN-25)

Electrode cold operation is available with K449 or K428 (with optional K443-2 Internal Contactor Kit installed).

(Connections are for current equipment design. Subject to change without notice.)



Output Terminals Always Hot.



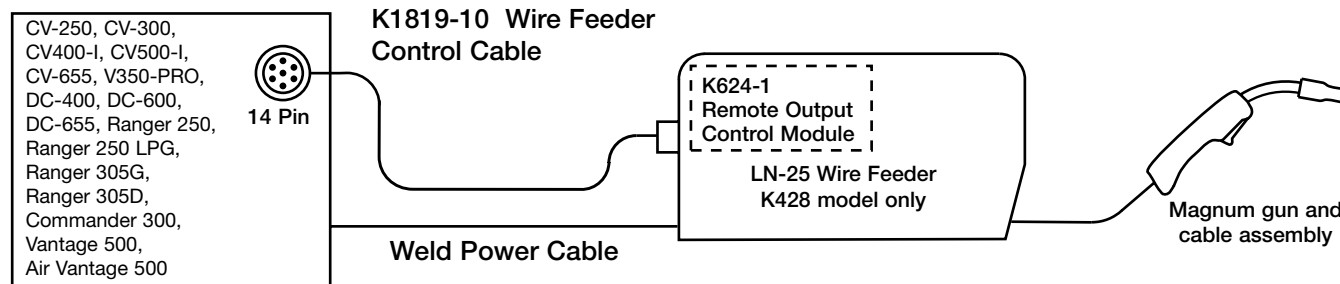
Output Terminals Always Hot.

ACROSS THE ARC SET-UP (with Electrode Cold Operation and Remote Voltage Control at LN-25)

For LN-25 K428 Model without Internal Contactor.

(Connections are for current equipment design. Subject to change without notice.)

42 Volt Remote Output Control Systems



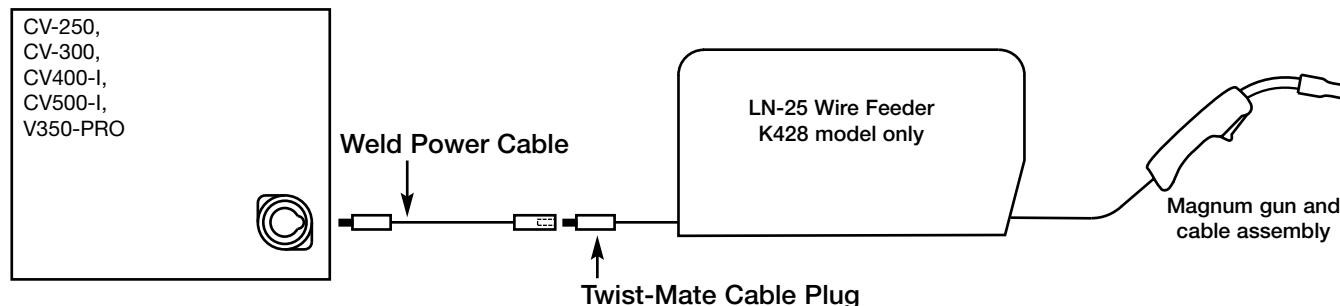
Control Cable and Extensions

K1819-10 Wire Feeder Control Cable, 10 ft. (3.0m)

K1797-25 14-pin Extension Control Cable, 25 ft. (7.6m)

K1797-50 14-pin Extension Control Cable, 50 ft. (15.2m)

WELD POWER CABLE SET-UP



Weld Power Cables

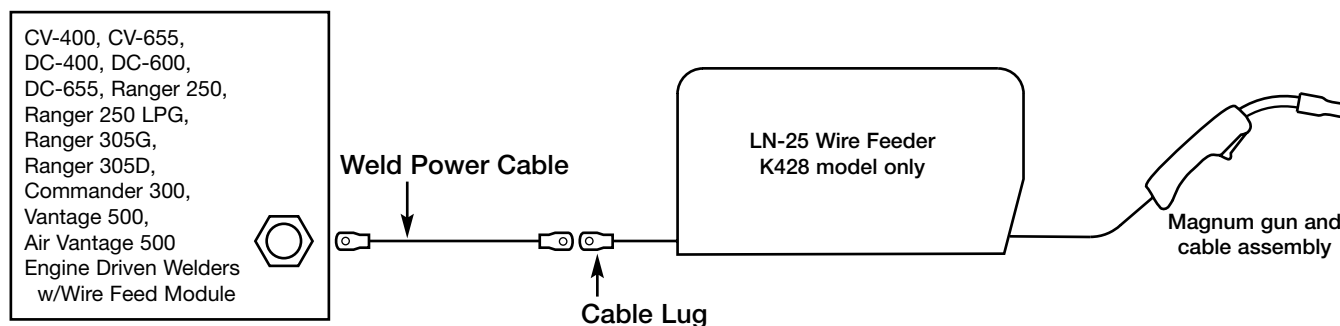
K1841-25 Twist-Mate to Twist-Mate, 1/0, 350A, 60% duty cycle, 25 ft. (7.6m)

K1841-50 Twist-Mate to Twist-Mate, 2/0, 350A, 60% duty cycle, 50 ft. (15.2m)

Twist-Mate Cable Plugs

K852-70 for 1/0-2/0 cable

K852-95 for 2/0-3/0 cable



Weld Power Cables

K1842-10 Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0m)

K1842-35 Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6m)

K1842-60 Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2m)

K1842-110 Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5m)

Cable Lug

S1119-14 for 1/0-2/0 cable

RECOMMENDED OPTIONS



Magnum 400 shown

REQUIRED OPTIONS

Magnum Gas-Shielded Gun and Cable Assemblies

Available 200-550 amps, air-cooled, gas-shielded welding guns.
See publication E12.10



K126 Innershield Gun shown

Magnum Self-Shielded Gun and Cable Assemblies

Available 250-600 amps.
See publication E12.110

DRIVE ROLL AND GUIDE TUBE KITS

Wire Type and Sizes	Order Number
Solid Wire: .023 - .025" (0.6 mm) .030" (0.8 mm) .035" (0.9 mm) .045 - .052" (1.2 - 1.4 mm)	KP653-025S KP653-030S KP653-035S KP653-052S
Cored Wire: .035" (0.9 mm) .045 - .052" (1.2 - 1.4 mm)	KP653-035C KP653-052C
Solid or Cored Wire: .052 - 1/16" (1.3 - 1.6 mm) .068 - 5/64" (1.7 - 2.0 mm)	KP653-1/16 KP653-3/32
Aluminum Wire: .035" (0.9 mm) 3/64" (1.2 mm) 1/16" (1.6 mm)	KP654-035A KP654-3/64A KP654-1/16A
Aluminum Wire (Clutched Drive Roll): .035" (0.9 mm) 1.0 mm 3/64" (1.2 mm) 1/16" (1.6 mm)	KP1682-035A KP1682-1.0A KP1682-3/64A KP1682-1/16A

WELD POWER CABLES

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

REQUIRED OPTIONS, CON'T

Twist-Mate Cable Plug

For connecting welding cable to output terminal receptacles. For 1/0 - 2/0 (50 - 70 mm²) cable.
Order K852-70



Twist-Mate Cable Plug

For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 95 mm²) cable.
Order K852-95



Cable Lug

For #1 1/0-2/0 cable.
Order S1119-14



GENERAL OPTIONS

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



Terminal Strip Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote output voltage control with power sources having a terminal strip.
Order K444



6 Pin Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote voltage control when used with power sources having a 6 pin MS-type connector.
Order K444-1



14 Pin Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote output voltage control and output jumper (2 and 4) for power sources having a 14 pin MS-type connector.
Order K444-2



42 Volt Remote Output Control Module

Provides remote voltage control and power source output control. Requires 42 volt auxiliary power. Mounts inside LN-25 control box. Requires K1819-10 Wire Feeder Control Cable.
Order K624-1



RECOMMENDED OPTIONS



Wire Feeder Control Cable
10 ft. (3.0m) power source to wire feeder cable. Male 9 pin to female 14 pin.
Order K1819-10



Wire Feeder Control Cable Extension
Male 14 pin to female 14 pin. (Requires K1819-10.)
Order K1797-25 for 25 ft.
Order K1797-50 for 50 ft.



Gas Solenoid Kit
Includes solenoid valve and mounting bracket. For K428 LN-25 model only. (Standard on K449 LN-25 model.)
Order K430-2



Internal Contactor Kit
Provides cold electrode until gun trigger is pressed and cold inch switch for loading wire. For K428 LN-25 model only. (Standard on K449 LN-25 model.)
Order K443-2



Gas Flow Timer Kit
For use with Gas Solenoid Kit. Provides adjustable delays for pre-flow and postflow of shielding gas.
Order K434-1



22-30 lb. Readi-Reel Adapter
Adapts 22-30 lb. (10-14kg) Lincoln Readi-Reels® of electrode to 2" (51mm) spindle. Wire not included.
Order K363P



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



8" O.D. Spool Adapter
For small spools. Permits 8" (203mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles.
Order K468

LN-25 ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
LN-25 Wire Feeder	K428		
LN-25 Wire Feeder w/Internal Contactor and Gas Solenoid	K449		
Required Options			
Magnum Gas-Shielded Gun and Cable Assemblies	See publication E12.10		
Magnum Self-Shielded Gun and Cable Assemblies	See publication E12.110		
Drive Roll and Guide Tube Kits	See page 6		
Weld Power Cables	See page 6		
Twist-Mate Cable Plug:			
– for 1/0-2/0 cable	K852-70		
– for 2/0-3/0 cable	K852-95		
Cable Lug	S1119-14		
Recommended General Options			
Jumper Plug Kit	K484		
Terminal Strip Remote Voltage Control Kit	K444		
6-Pin Remote Voltage Control Kit	K444-1		
14-Pin Remote Voltage Control Kit	K444-2		
42 Volt Remote Output Control Module	K624-1		
Wire Feeder Control Cable	K1819-10		
Wire Feeder Control Cable Extension:			
25 ft.(7.6m), 50 ft.(15.2m)	K1797-25, -50		
Gas Solenoid Kit (standard on K449)	K430-2		
Internal Contactor Kit (standard on K449)	K443-2		
Gas Flow Timer Kit (K428 Requires K430-2)	K434-1		
22-30 lb. Readi-Reel Adapter	K363P		
14 lb. Innershield Coil Adapter	K435		
8" O.D. Spool Adapter	K468		
	TOTAL:		

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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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.

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