

LN™-25 PRO

Portable Industrial Wire Feeders

Built upon the tradition and success of the LN™-25, the new LN™-25 PRO is designed to be simple, reliable and easy to service. The LN™-25 PRO is ideal for field construction and fabrication, shipyards, and rental companies.

The MAXTRAC® wire drive enhances performance, while the replacement case—and many other upgrade options—can be installed in less than five minutes.

The LN™-25 PRO is available in 3 models:

- **Standard** • **Extra Torque** • **Dual Power**

The **Extra Torque** model features additional torque gearing for reliable feeding of large diameter flux-cored wires.

The **Dual Power** model features a voltage control knob for superior arc control, digital meters for increased monitoring, MIG-STT® capability, and can be powered with either a control cable or across the arc.

Processes

MIG, MIG-STT®, Pulsed, Flux-Cored



K2614-1
LN™-25 PRO Dual Power

K2613-1
LN™-25 PRO Standard



Key Features

- **Performance – All Models**
 - 2-Step/trigger interlock provides comfort for long welds.
 - Sturdier and rugged spindle design with an incorporated brake.
- **Performance – Standard and Extra Torque Models**
 - Analog Voltmeter with polarity indicator LED automatically adjusts to welding polarity.
 - Non-linear wire feed speed gives single range control, yet maintains sensitivity with low wire feed speed.
- **Performance – Dual Power Model**
 - Digital meters for increased monitoring.
 - Display shows wire feed speed or amperage and welding voltage.
- **Reliability**
 - Lightweight, impact and flame resistant polycarbonate case design keeps the internal components protected.
 - Potted and trayed PC board protects against moisture and corrosion.
 - Reel locking mechanism eliminates spindle cross threading.
- **Serviceability**
 - Case can be replaced in less than 5 minutes - eliminates downtime.
 - Timer kit available to prevent the electrode from sticking in the crater when using high wire feed speeds.

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Gas Solenoid & 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	K2613-1	15-110 VDC	325A/100% 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)	37 (16)
LN™-25 PRO Extra Torque	K2613-2				30-400 (0.8-10.1)		.030-3/32 (0.8-2.4)			
NEW LN™-25 PRO Dual Power	K2614-1	15-110 VDC or 24-42 VAC	50-700 (1.3-17.7)	.030-5/64 (0.8-2.0)						

FEATURES

1. 2 Step/Trigger Interlock Switch
 • Provides comfort for long welds

2. CV/CC Switch
 • Allows use of CC power source

3. Optional Timer Kit (Prewflow, Postflow & Burnback)
 • Prevents electrode from sticking in crater when using high wire feed speeds

4. Spool Retainer

5. Spindle Brake
 • Heavy-duty design with an adjustable brake incorporated

6. Brass to Brass Interchangeable Gun Bushings
 • More reliable electrical conductivity—no oxide build-up
 • More efficient energy transfer—lower voltage drops
 • Easily adapt any number of Lincoln Magnum® or alternate brand guns

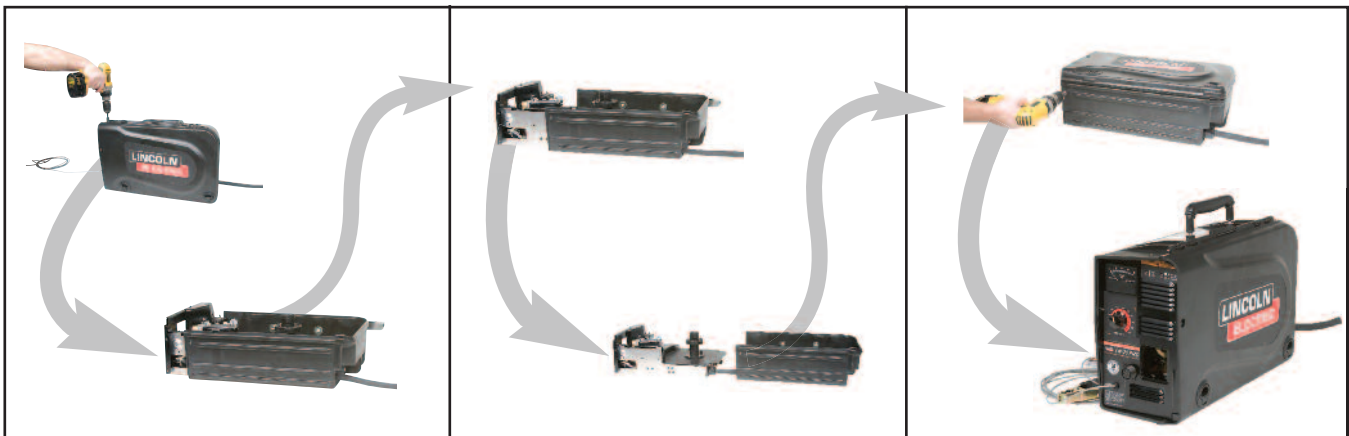
7. Patent-Pending Drive Rolls (not shown)
 • Steel Wire—new design delivers 20% more feeding force
 • Aluminum Wire—chrome-plated to resist aluminum build-up

8. Patented Split Wire Guides
 • Full support for wire throughout the drive path
 • Removable outer wire guide for easy access
 • No tools required
 • No birdnesting

9. Twist-Lock Drive Roll Hubs
 • Fast, tool-less changeovers

10. Cold Feed Switch
 • Provides added safety by keeping welding wire electrically “cold” until trigger is pressed

EASY CASE REPLACEMENT IN MINUTES - Now a damaged case does not require ordering a new unit!



1. Remove Screws

2. Remove inside frame from case

3. Put frame in a new case and replace screws

KEY CONTROLS

LN™-25 PRO



1. Analog Voltmeter
2. Wire Feed Speed Knob
3. 5 Pin Gun Trigger Connector
4. Work Sense Lead
14.5 ft (4.4 m)
5. Thermal Protection LED
6. Welding Polarity Indicator LED

1. Gas Purge Pushbutton
2. Flow Meter Ball
3. Flow Meter Valve
4. Shielding Gas Inlet
5. Electrode Lead
14 in (356 mm)
6. Optional Water-Cooled
Gun Connections

LN™-25 PRO DUAL POWER



1. Wire Feed Speed/Amperage Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-pin Gun Trigger Connector
6. Work Clip Connection
7. Thermal LED
8. Voltage Display
9. Voltage LED
10. Remote Voltage Control Knob
(not presettable)

1. 14 Pin Control Cable Input

NOTE: In across-the-arc mode, voltage knob does not control voltage—adjust at power source.

REQUIRED OPTIONS

MAXTRAC® DRIVE ROLL & WIRE GUIDE KITS

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

FEED PLATE GUN RECEIVER BUSHINGS

K1500-1 Gun Receiver Bushing *	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)	K1500-4 Gun Receiver Bushing (Optional)	K1500-5 Gun Receiver Bushing (Optional)	K489-7 Fast-Mate Gun Receiver Bushing (Optional)
<ul style="list-style-type: none"> Magnum® 200, 300 and 400 gun and cable assemblies with K466-1 connector kit. Lincoln Innershield® gun and cable assembly. Magnum® 550 gun and cable assembly with K613-1 connector kit. 	<ul style="list-style-type: none"> Magnum® 200 and 400 fully assembled guns (K497-2x and K471-2x). Magnum® 200, 300 and 400 gun and cable assemblies with K466-10 connector kit. Guns with Tweco® #2, #3, and #4 connectors. 	<ul style="list-style-type: none"> Magnum® 550 gun and cable assembly with K613-7 connection. Guns with Tweco® #5 connectors. 	<ul style="list-style-type: none"> Magnum® 200, 300 and 400 gun and cable assemblies with K466-3 connector kit. 	<ul style="list-style-type: none"> To adapt to OXO® guns. 	<ul style="list-style-type: none"> Magnum® gun and cable assemblies with Fast-Mate connections. Handles both single and dual procedure guns.

* Shipped loose with every unit.



RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES

 <p>Magnum® Gas-Shielded Gun and Cable Assemblies Available 200-550 amps air-cooled, gas-shielded welding guns. See publication E12.10</p>	 <p>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</p>	 <p>Replacement Case Kit Replace a damaged case without replacing the entire unit Order K2596-1 (aluminum) Order K2596-2 (plastic)</p>
 <p>Magnum® Self-Shielded Gun and Cable Assemblies Available 250-600 amps. See publication E12.110</p>	 <p>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</p>	 <p>Twist-Mate™ Cable Plug For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 90 mm²) cable. Order K852-95</p>
 <p>Prewflow 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</p>	 <p>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</p>	 <p>Micro Wire Straightener Straightens .035 - 1/16 in. (0.9 - 1.6 mm) wire for use with portable feeders. Order K1733-4</p>

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

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