

LN-8

Semiautomatic, Constant Speed Wire Feeder

The LN-8 is a semiautomatic constant speed wire feeder providing dependable performance and reliable operation, making it ideal for shop or field operations. For precise wire feeding and quality welds, the LN-8 features controlled wire feed speed and voltage during starting for clean, positive starts and reduced stubbing, skipping and spatter. Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed. This wire feeder is easy to use with a quick release gun and cable connection for easy set up, and large wire feed and voltage control knobs that are easy to adjust with gloved hands.



Shown with options

Processes

MIG Flux-Cored Submerged Arc

Advantage Lincoln

- Unique drive roll design provides positive feeding and quick reloading by simply inserting the wire into the incoming guide tube. The drive rolls and guide tubes are designed for long life and precise wire feeding.
- Completely enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to drive rolls.
- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.
- Control circuit features “cold electrode” when the gun trigger is released for added safety.
- Solid state control compensates for wire drag and input line variations to maintain accurate 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.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Three-year warranty on parts and labor.

Description

Output  Input 

Required Options

Gun and Cable Assembly, Drive Roll Kit, Control Cable, Weld Power Cable

Recommended General Options

Universal Wire Reel Stand, Insulated Lift Bail, Light Duty Caster Kit, Swivel Platform, Spindle Adapter, Readi-Reel® Adapter, Coil Adapter, Cover Kit, Meter Kit, Gas Solenoid Assembly, Burnback Kit, Magnetic Flux Screen Separator, Flux Screen, Wire Reel and Flux Tank Assembly, Continuous Flux Feeding Tank Assembly, Undercarriage, Squirtmobile®, Mechanized Hand Travel Unit, Power Pack, Portable Digital Wire Feed Speed Meter

Recommended Power Source Options

CV-400, CV-500-I, CV-655, DC-400, DC-600, DC-655, DC-1000

Order

K297 LN-8 Wire Feeder

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Curret/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)
LN-8	K297	115 VAC 50/60 Hz	600A @ 60%	50-600 (1.3-15.2)	Cored .045-.120 (1.2-3.0)	Solid .030-3/32" (0.8-2.4)	10.9 x 9.8 x 9.6 (227 x 248 x 244)	36 (16.2)

A CLOSER LOOK

PERFORMANCE

- Unique drive roll design provides positive feeding and quick reloading by simply starting wire into guide tube. The drive rolls and guide tubes are designed for long life and precise wire feeding.
- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.
- Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed.

FEATURES

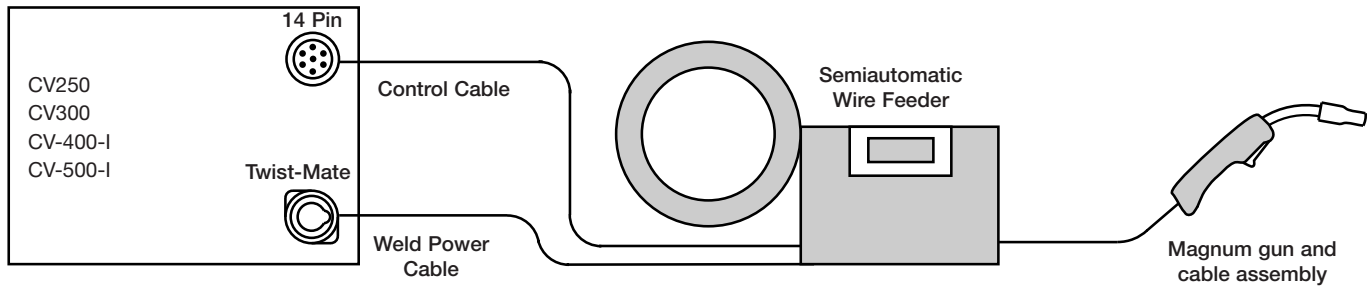
- Large, easy to use wire feed speed and voltage controls that are easy to adjust with gloved hands.
- Can be boom mounted or use optional Universal Wire Reel Stand, Casters, and/or Swivel Platform and mount on power source for extra versatility.
- Low voltage (24 volts) gun trigger circuit for added safety.
- Compatible with many Lincoln power sources including the CV-250, CV-300, CV-400, CV-655, DC-400, DC-600, DC-655, Ranger 250, Classic 300, Ranger 305, Commander 300, Vantage 500, and Air Vantage 500.
- 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.

QUALITY AND RELIABILITY

- Three-year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Rugged and durable design recognized throughout the industry for its long life and years of trouble-free wire feeding.
- Completely enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to rolls.
- Control circuit features "cold electrode" when the gun trigger is released for added safety.

CONTROL AND WELD POWER CABLES SELECTION GUIDE

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



Control Cables

K1820-10 Wire Feeder Control Cable - 10 ft.

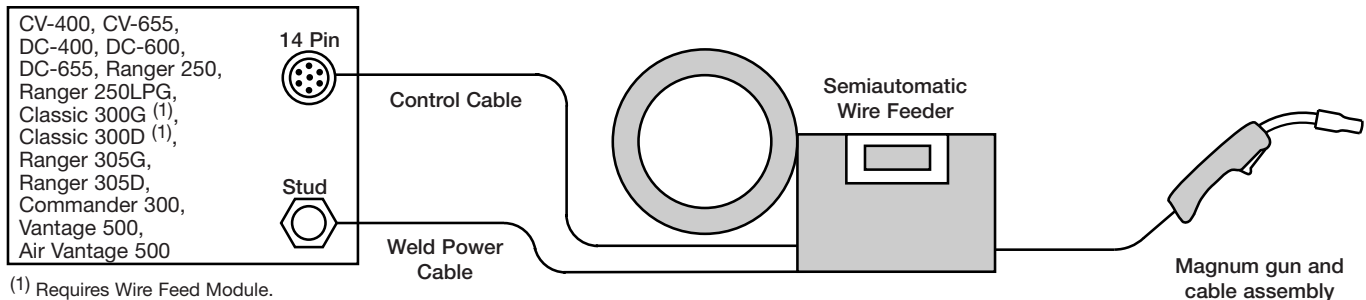
Control Cable Extensions

K1797-25 14-pin Extension Control Cable - 25 ft

K1797-50 14-pin Extension Control Cable - 50 ft.

Weld Power Cables

K1840-10 Twist-Mate to Lug, 1/0, 350A, 60% Duty Cycle - 10 ft.



(1) Requires Wire Feed Module.

Control Cables

K1820-10 Wire Feeder Control Cable - 10 ft.

Control Cable Extensions

K1797-25 14-pin Extension Control Cable - 25 ft.

K1797-50 14-pin Extension Control Cable - 50 ft.

Weld Power Cables

K1842-10 Lug to Lug, 3/0, 600A, 60% Duty Cycle - Weld Power Cable - 10 ft.

K1842-35 Lug to Lug, 3/0, 600A, 60% Duty Cycle - Weld Power Cable - 35 ft.

K1842-60 Lug to Lug, 3/0, 600A, 60% Duty Cycle - Weld Power Cable - 60 ft.

K1842-110 Lug to Lug, 4/0, 600A, 60% Duty Cycle - Weld Power Cable - 110 ft.

RECOMMENDED OPTIONS

REQUIRED OPTIONS

DRIVE ROLL AND GUIDE TUBE KITS	
Steel Wire Sizes	LN-8
Solid Wire: .030 - .035 (0.8 - 0.9 mm) .040, .045 - .052 (1.0 - 1.4 mm) 1/16 (1.6 mm)	KP502-035 KP502-052 KP502-1/16
Cored Wire: .045 - .052 (1.0 - 1.4 mm) 1/16 - .062 (1.6 mm) 7/64 - .120" (2.8 - 3.0 mm)	KP502-052C KP502-1/16C KP502-120
Solid or Cored Wire: .068 - 3/32" (1.7 - 2.4 mm)	KP502-3/32
Hardfacing: 7/64" (2.8 mm)	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 K1797-25 - 25 ft. K1797-50 - 50 ft.	Male 14 pin to female 14 pin
Adapter Cable for Control Cable to Terminal Strip Power Sources K1798	Female 14 pin control cable to Terminal Strip

WELD POWER CABLES	
Order No.	Description
K1840-10	Twist-Mate to Lug, 1/0, 350A, 60% duty cycle, 10 ft.
K1842-10	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft.
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft.
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft.
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft.

GUN & CABLE ASSEMBLIES



Magnum 400 shown

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



Magnum Submerged Arc Gun

Rated 500 amps, 15 ft. (4.5m) cable, for 1/16" (1.6mm) electrode size. Order K112



Magnum Submerged Arc Gun

Rated 600 amps, 15 ft. (4.5m) cable, for 5/64" (2.0mm) electrode size. Order K113-1



Magnum Submerged Arc Gun

Rated 600 amps, 15 ft. (4.5m) cable, for 3/32" (2.4mm) electrode size. Order K113-2



Mechanized SAW Gun

Rated 600 amps, for 5/64 and 3/32" (2.0 and 2.4mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit or Squirtmobile. Order K114



Flux Cone

Fits K112 and 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 10-60 lb. (4.5-27.2 kg) wire packages that use a 2" (51mm) spindle. Hole in stand fits over lift bail.
Order K1524-1



Light Duty Caster Kit
Mounts to the K1524-1 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 K1524-1.
Order K1555-1



50-60 lb. Readi-Reel® Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln electrode to 2" (51mm) spindle.
Order K438



20-30 lb. Readi-Reel® Adapter
Adapts 22-30 lb. (10-14 kg) Lincoln Readi-Reels of electrode to 2" (51mm) spindle.
Order K363P



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

GENERAL OPTIONS, CONT.



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



8" O.D. Spool Adapter
For small spools. Permits 8" (200mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles.
Order K468



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)



Gas Solenoid Kit
Includes solenoid valve and mounting bracket.
Order K437 (below code 9132)
Order K425 (above code 9131)



Wire Feed Speed Meter Kit
Contains an analog which 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

GENERAL OPTIONS, CONT.



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



Flux Screen
For submerged arc welding.
Removes large particles from reused flux. Includes air-driven vibrator.
Order K310



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



Continuous Flux Feeding Tank Assembly
For submerged arc welding.
Includes air filter, pressure regulator, gauge, tank, 18 ft. (5.4m) flux hose, funnel and lift bail assembly to mount wire feeder.
Order K320



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

GENERAL OPTIONS, CONT.



Squirtmobile
Self-propelled trackless carriage carries K114 Mechanized SAW Gun on long welds for automatic welder economy without high fixtures costs. Requires a K161 Power Pack to drive unit.
Order K62



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.
Order K161-25 for 25 ft. (7.5m)
Order K161-50 for 50 ft. (15m)



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

LN-8 ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
LN-8 WIRE FEEDER	K297		
REQUIRED OPTIONS			
Magnum Gas-Shielded Gun and Cable Assemblies	see publication E12.10		
Magnum Self-Shielded Gun and Cable Assemblies	see publication E12.100		
Submerged Arc Gun and Cable Assemblies	see page 5		
Drive Roll and Guide Tube Kits	see page 5		
Control Cable	see page 5		
Weld Power Cable	see page 5		
RECOMMENDED GENERAL OPTIONS			
Universal Wire Reel Stand	K1524-1		
Light Duty Caster Kit	K1556-1		
Swivel Platform	K1557-1		
Insulated Lift Bail	K1555-1		
50-60 lb. Readi-Reel Adapter	K438		
20-30 lb. Readi-Reel Adapter	K363P		
50-60 lb. Coil Adapter	K1504-1		
14 lb. Innershield Coil Adapter	K435		
8" O.D. Spool Adapter	K468		
Plastic Wire Cover (for 30-44 lb. wire packages)	K1634-1		
Plastic Wire Cover (for up to 60 lb. wire packages)	K1634-2		
Gas Solenoid Kit (below code 9132)	K437		
Gas Solenoid Kit (above code 9131)	K425		
Wire Feed Speed Meter Kit	K261		
Burnback Kit	K202		
Magnetic Flux Screen Separator	K58		
Flux Screen	K310		
Wire Reel and Flux Tank Assembly	K305		
Continuous Flux Feeding Tank Assembly	K320		
Undercarriage	K163		
Squirtmobile	K62		
Mechanized Hand Travel Unit	K110		
Power Pack (Available in 25 ft. or 50 ft. lengths)	K161-25, -50		
Portable Digital Wire Feed Speed Meter	K283		
RECOMMENDED POWER SOURCE OPTIONS			
CV-400	see publication E4.30		
CV-500-I	see publication E4.30.1		
CV-655	see publication E4.40		
DC-400	see publication E5.20		
DC-600	see publication E5.40		
DC-655	see publication E5.46		
DC-1000	see publication E5.50		
	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.

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.