

**NEW!**

**SEMI-AUTOMATIC FEEDER & MULTI-PROCESS POWER SOURCE**

# The Power Feed™ 25M & Power Wave® System



## Premium welding solution with a portable design!

Industry focused welding solutions that meet your needs - isn't that what you're looking for?

The Power Feed™/Power Wave® packages have traditionally offered advanced controls, premium welding, reliable and quality products. Now with the introduction of a portable, high technology feeder, we bring these features to the operator in a package that can weld anywhere.

Lincoln offers this full featured design in a robust package that can meet industry challenges. The lightweight construction, durable case, as well as the patented design of the MAXTRAC® wire drive system delivers the results you need. Recommended equipment packages are prepared to meet your needs for aluminum fabrication, high-alloy construction, and pipeline welding environments.

### Processes

MIG, Pulsed, STT®, Flux-Cored, Stick, TIG, Gouging,



Output



Input



## Advantage Lincoln

- **TOTAL s2f™ Aluminum Welding Solution**
  - TOTAL s2f™ is Lincoln Electric's complete aluminum welding solution from equipment to consumable to welding process – the premier welding solution.
- **Push-Pull Capability Standard**
  - Push-pull functionality delivers premier aluminum performance by offering uniform feeding, as well as a flexible system for extending the gun.
- **Hardened and Construction Ready**
  - Built tough for rough environments. From construction to shipbuilding, this design will meet your expectations. Packaged standard with a durable aluminum case or an optional plastic case.
- **Internal Lighting**
  - Working in an environment with little light? We have the answer with high intensity LEDs that will illuminate the wire drive.
- **Internal Heating**
  - Maintains control of humidity on your consumable by keeping the package warmed and protected in an enclosed case.
- **Mode Select Panel (MSP4)**
  - High tech made easy to use, the Mode Select Panel introduced on the Power Feed™ 10M is now portable. The panel allows easy access to the Power Wave® library of waveforms. Advanced controls and set-up options are only a fingertip away!
- **Dual Procedure and Memory Buttons**
  - Dual procedures allow you to set-up an A and B procedure to simplify 'on-the-fly' switching. Memory buttons are here so you do not have to memorize procedures! Allows the operator to easily press a button to get the waveform and specify the range of operation for their application.
- **Portable**
  - Fits through a 16" (406 mm) diameter or 12x18" (305 x 457 mm) elliptical manhole and weighs 35 lbs. (15.9 kg).

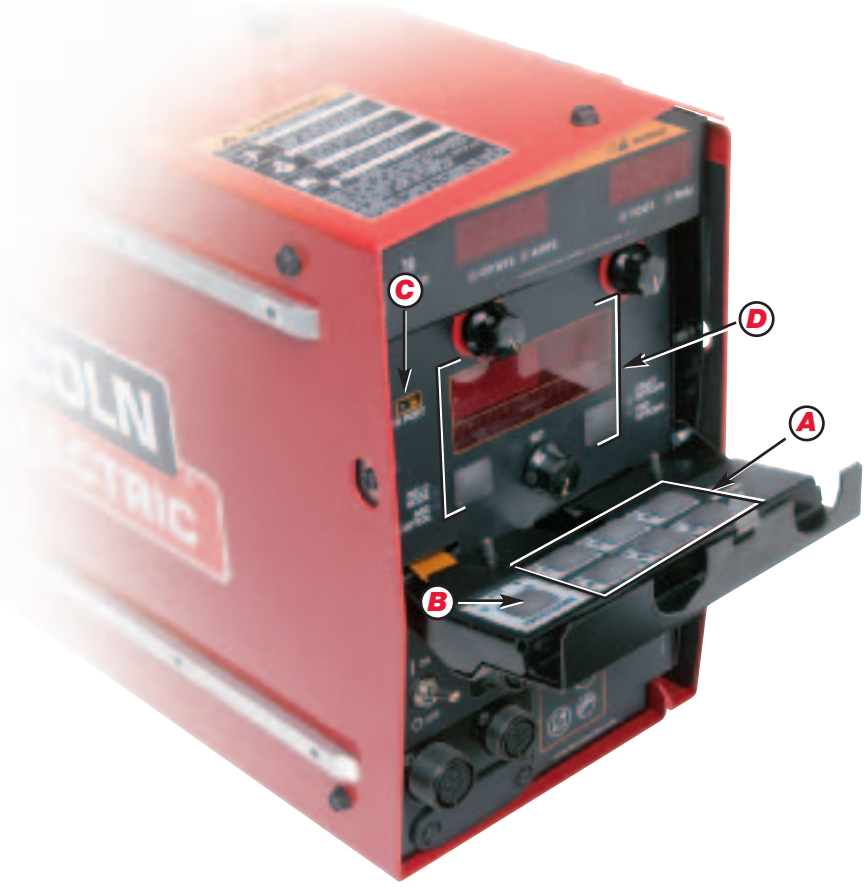
### TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Gearing	Wire Feed Speed Range IPM (m/min)	Wire Size Range in. (mm)	Dimensions HxWxD Inches (mm)	Net Weight lbs (kg)
Power Feed™ 25M	K2536-1	40 VDC	Standard speed (factory setting)	GMAW: 50-800 ipm (2.5 - 20.3 m/min) FCAW: 50-800 ipm (2.5 - 20.3 m/min)	GMAW: .023- 1/16" (0.6-1.6mm) FCAW: .030-5/64" (0.8-2.0mm)	14.5 x 8.5 x 23.5 (368 x 216 x 597)	35 (15.9)
			Extra-torque	GMAW: 30-400 ipm (1.3-10.4 m/min) FCAW: 30-400 ipm (1.3-10.4 m/min)	GMAW: .023- 1/16" (0.6-1.6mm) FCAW: .030-3/32" (0.8-2.4mm)		

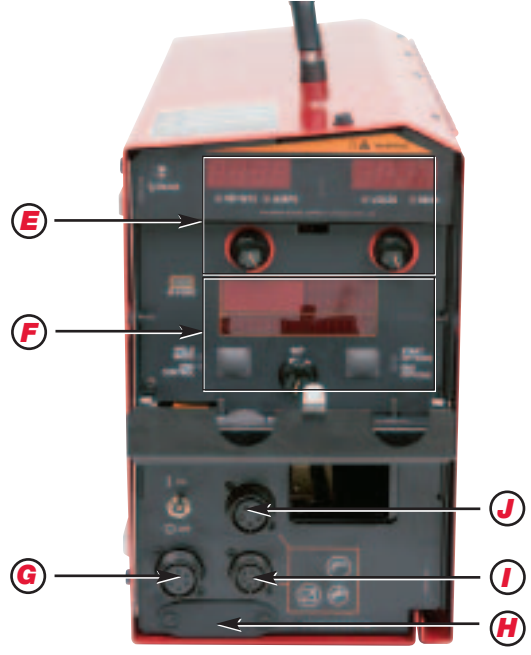
**FEATURES**

**Case Front Controls**

The Power Wave®/Power Feed™ digital solution provides all controls to the user where they need them - in the hands of the operator. The Power Feed™ 25M portable design delivers the precision of digital meters and displays and permits full control over the welding variables, and in a design to meet the field industry needs. The system incorporates the ability to provide the operator a range of operation and then the ability to lock the controls to ensure that welding is done according to the procedures defined.



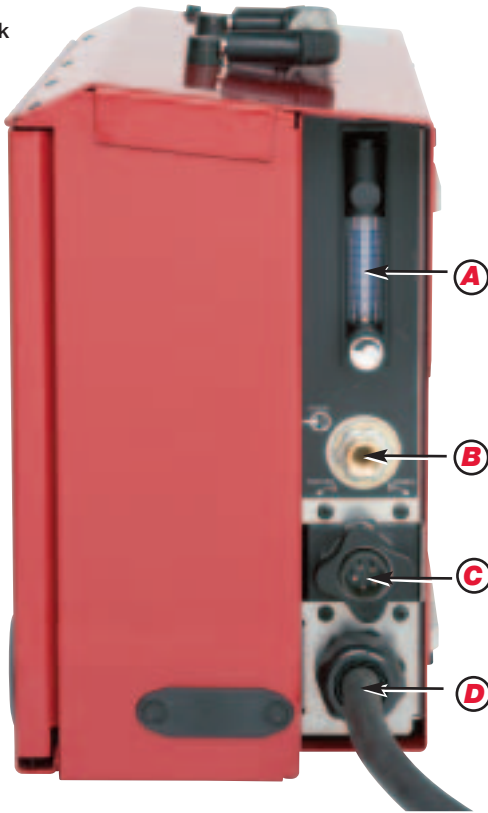
- A 6 Pin Remote Connector**
  - Allows the user to store a procedure and set their range of operation for welding. Memories may be recalled with the memory buttons or by double-clicking the gun trigger.
- B Dual Procedure Button**
  - Allows a quick selection of procedure A or B while welding. The selection of a procedure memory works in coordination with a Lincoln Magnum® dual procedure gun, or with quick release/pull on a standard MIG gun. A setup menu option allows this control.
- C Infrared Port (IR) Port**
  - For use with Weld Manager™, a Palm® OS based application designed to simplify user set-up and reduce downtime related to equipment configuration and security.
- D Mode Select Panel (MSP4)**
  - Provides easy selection of weld mode as well as setting arc control (inductance), start options and end options. A hidden menu allows you to customize the user interface to your particular setup needs.



- E Dual Encoder Display**
  - Bright high intensity display of voltage and wire feed speed and amps.
- F Mode Select Panel (MSP4) - as shown above**
  - Allows selection of weld mode and access to start options, end options and arc control.
- G 6 Pin Remote Connector**
  - Use with a remote output control kit or a foot pedal.
- H Water Cooled Gun Kit Connection (optional)**
  - Requires K590-6.
- I 7 Pin Push Pull Connector**
  - Connects Python® Plus, Python®, or Cobramatic guns.
- J Standard 5 Pin Gun Trigger Connection**

**HARDWARE FEATURES**

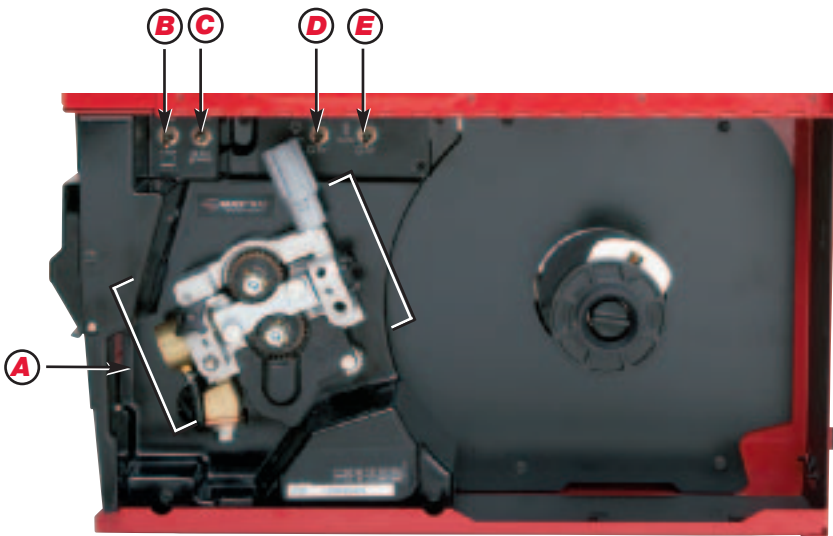
Case Back



- A Flowmeter with Control Value**
  - Used to regulate and monitor shielding gas flow at the feeder to compensate for long shielding gas hoses.
- B Shielding Gas Input**
  - Rugged, one piece solenoid includes a screen to filter dirt.
- C 5 Pin ArcLink® Connector**
  - Now with a patent pending Spin-Nut for easy connection of the cable.
- D 4/0 Electrode Lead <sup>(1)</sup>**
  - Rated for high amperage welding.

<sup>(1)</sup> Add Connector of your choice

An Inside Look



- A 2 Roll MAXTRAC® Drive**
  - Two gear driven rolls with patent pending groove design. No tools needed to take rolls on or off. (Note: some rolls have grooves of different sizes)
  - Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
  - Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.
- B 2 Step/4 Step Switch**
  - Offers the user flexibility in choosing 2 Step for switching weld output on and off in direct response to the trigger, or 4 Step which offers a 'trigger interlock' capability or to give the welder control over the amount of time spent in arc start, weld, and arc end time.
- C Gas Purge/Cold Feed Switch**
  - Clears shielding gas with cold feed electrode for safety.
- D Light Switch**
  - Turns on high intensity LED's to illuminate the inside of wire feeder.
- E Heater Switch**
  - The built-in heater warms the inside air to protect consumables from moisture.

# TOTAL s2f™

PROCESS

EQUIPMENT

CONSUMABLES

TOTAL s2f™ is Lincoln Electric's complete aluminum welding solution from equipment to consumable to welding process - the premier welding solution for your needs. The TOTAL s2f™ aluminum welding process focuses on the details from the start 2 finish of every weld. Delivering a soft aluminum arc, consistent starting, conditioned ending, and improved cleaning action, the result is superior welding on tough aluminum jobs.

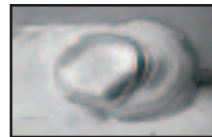
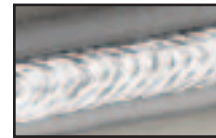
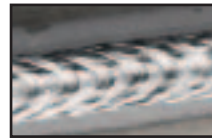
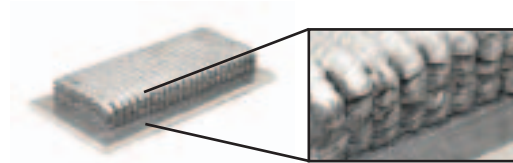
**TOTAL s2f™ is the answer!**

PROCESS

EQUIPMENT

CONSUMABLES

- **Excellent Starting** - The Pulse and Pulse-on-Pulse™ aluminum waveforms provide smooth reliable starting for a great beginning to every weld.
- **Superior Bead Appearance** - With the fine-tuned controls of the Power Wave® product platform, the welding variables can be carefully controlled. The result is an improved ability to reduce fine spatter and provide a robust waveform against soot on the weld.
- **Hybrid Crater Fill Function** - The termination of the weld is done in a gradual manner to ensure the creation of a convex bead to prevent crater cracking.
- **An Outstanding End** - Ending the weld with a consistent length and no ball on the end of the wire provides for a great start to the next weld. This is done by ensuring that the arc is extinguished at the same point every time; creating a wire tip consistently conditioned for the next start.



PROCESS

EQUIPMENT

CONSUMABLES

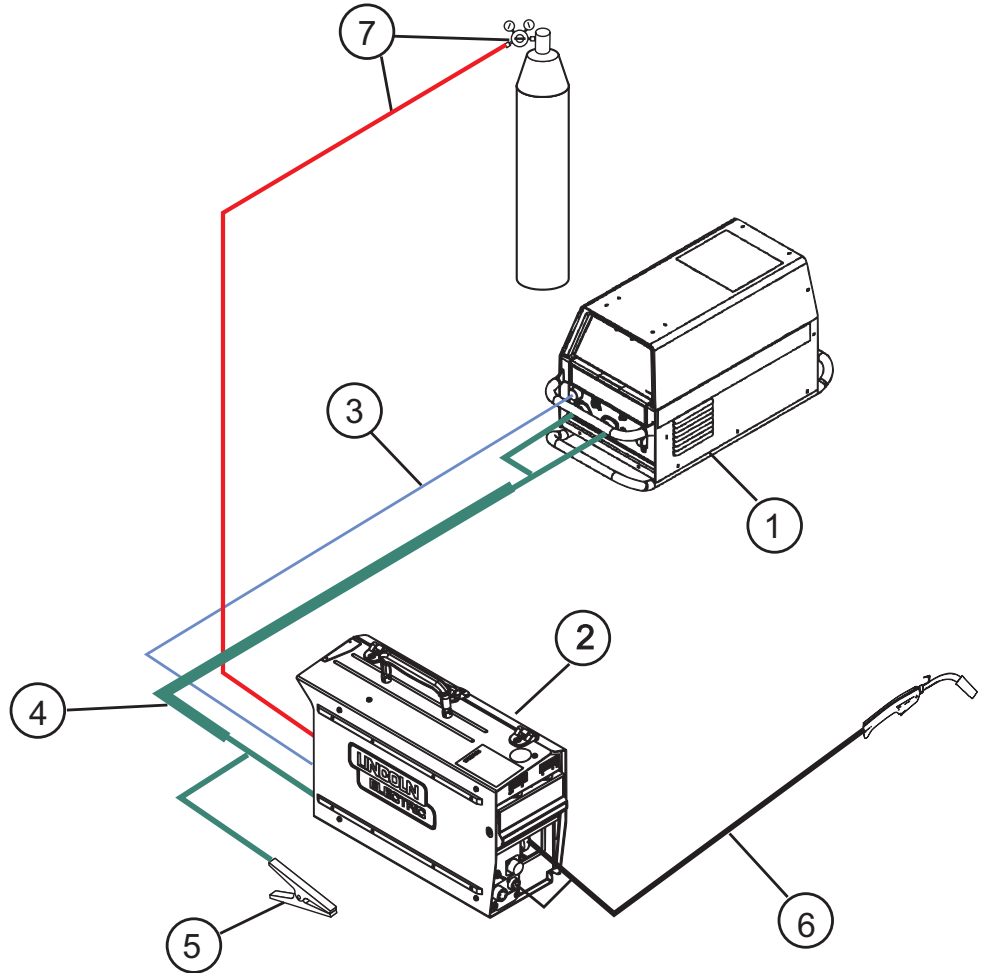
For superior welding performance, turn to Super Glaze® aluminum MIG wire from Lincoln Electric®.

Super Glaze® minimizes the problems usually associated with aluminum wire feeding such as birdnesting, tangling and burnback to provide a stable arc, great feedability and exceptional control - every time you weld! The keys are Super Glaze's smooth surface finish and consistent chemical composition. What this means for you is quality wire that produces a quality weld, Start-2-Finish.



PROCESS EQUIPMENT CONSUMABLES

TOTAL s2f™ EQUIPMENT SYSTEM CONFIGURATION



RECOMMENDED EQUIPMENT ALUMINUM

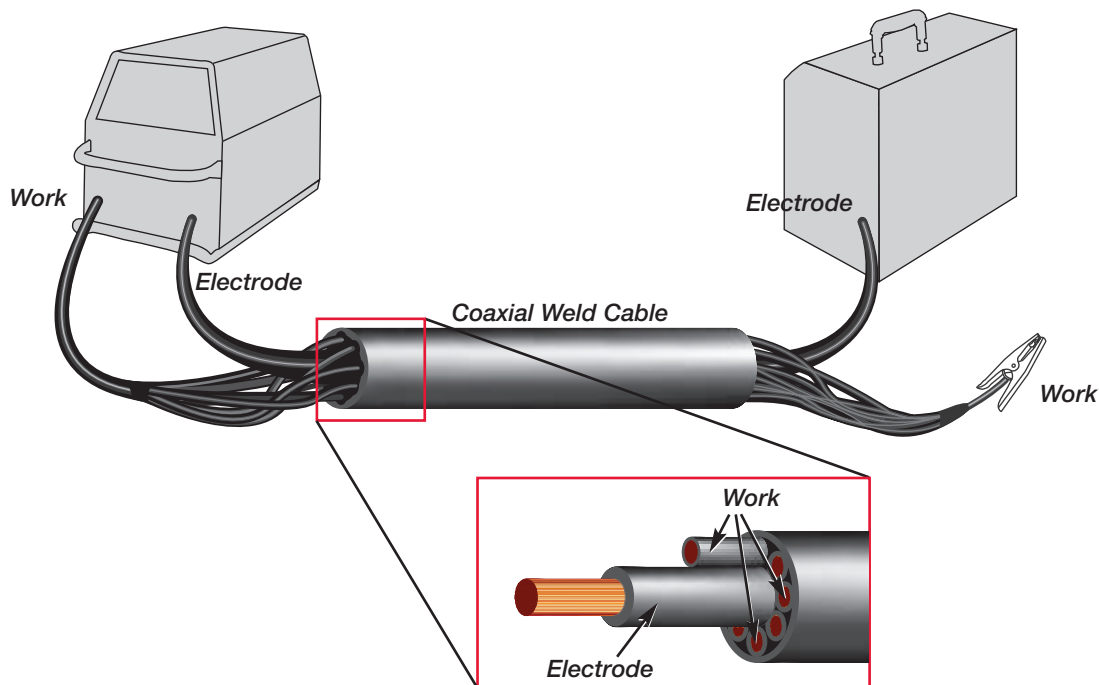
Product Number	Product Description	Quantity Required	
① K2368-1 or K2202-1 or K2203-1	Power Wave® 355M Power Wave® 455M Power Wave® 455M/STT (depending on customer needs)	1	
② K2536-1	Power Feed™ 25M	1	
③ K1543-xx	ArcLink® Control Cable	1	
④ K1803-1	Work and Wire Feeder 2/0 Weld Cable Package	1	
⑤ K910-2	Work Clamp (500A @ 60% Duty Cycle)	1	
⑥	K2447-x or	Python® Plus Push-Pull Air-Cooled Gun (no adapter required)	1
	K2212-x	Python® Push-Pull Water-Cooled Gun (requires water connection and push-pull gun connection kits)	1
	K590-6	Water Connection Kit	1
	K2339-1	Push-Pull Gun Connection Kit	1
⑦	K586-1	Deluxe Regulator for Mixed Shielding Gases and Hose (4.3 ft)	1
	KP1695-xx	Drive Roll Kit, 2 Roll, Aluminum Wire (specify wire size)	1
	ER5356	Super Glaze® Aluminum MIG Wire (16 lb. Spool)	

**PROCESS CONTROLS****Coaxial Weld Cables**

Coaxial welding cables are specially designed welding cables for pulse welding or STT® welding. Coaxial weld cables feature low inductance, allowing fast changes in the weld current. Regular cables have a higher inductance which may distort the pulse or STT® waveshape. Inductance becomes more severe as the weld cables become longer.

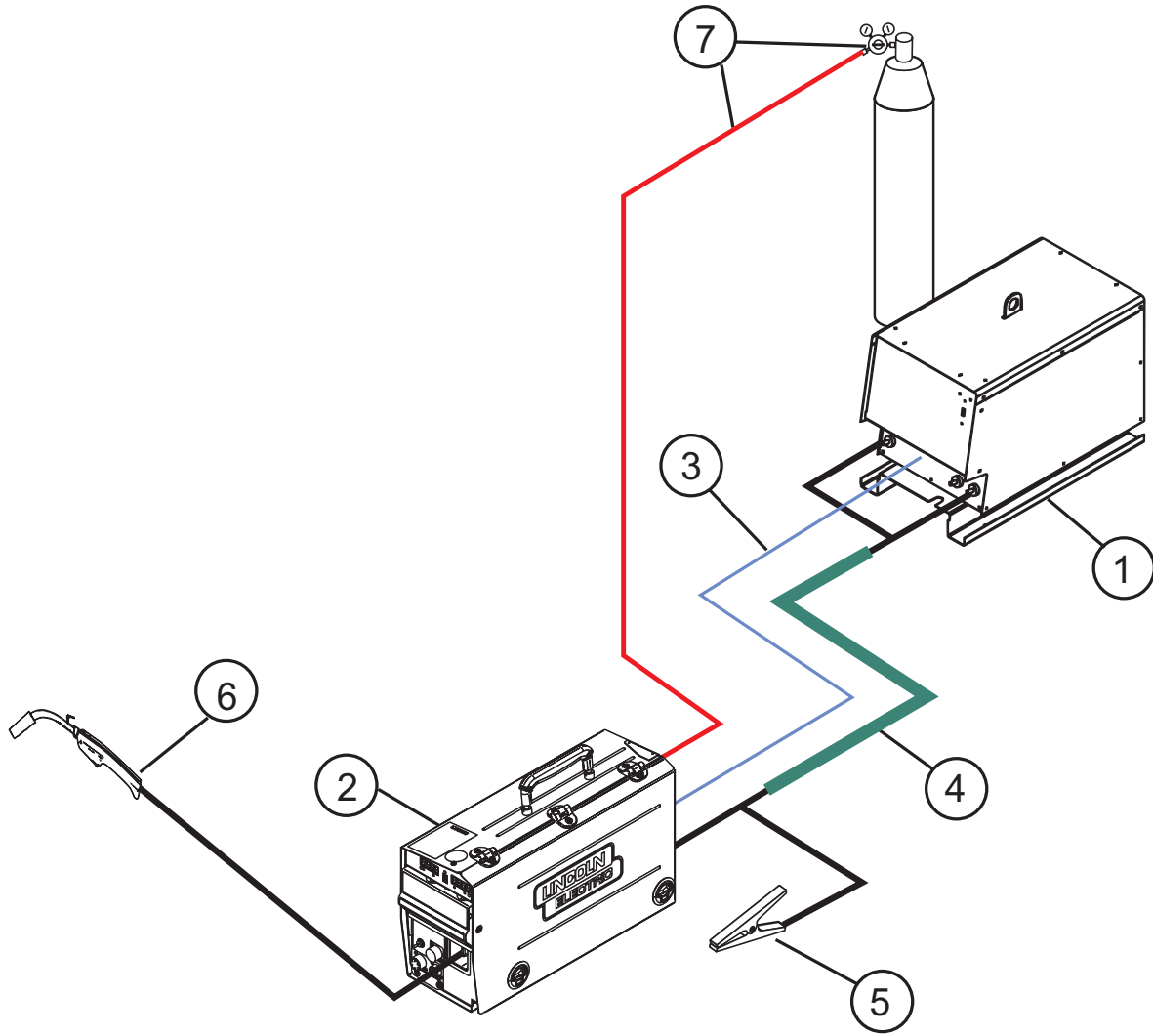
A coaxial weld cable is constructed with multiple smaller leads wrapped around one large lead. The large inner lead connects to the electrode stud on the power source and the electrode connection on the wire feeder. The small leads combine together to form the work lead, one end attached to the power source and the other end to the work piece.

**Coaxial weld cables are recommended for all pulse and STT® welding, especially when the total weld cable length (electrode cable + work cable) exceeds 50 feet (7.6m)**

**QUALITY AND RELIABILITY**

- Rugged aluminum case, sturdy controls and quality meter displays.
- Ambient temperature range for operation (-40° C to +50° C) (-40° F to +122° F).
- Designed to resist electrical noise.
- Conforms to cCSA<sub>UL</sub> / CE Standards: EN 60974-5.
- Meets IP23 rating.
- PC Boards are potted, trayed and filled with epoxy for ultimate protection in harsh environments.
- Three-year Lincoln warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.





RECOMMENDED EQUIPMENT FOR STT®

Product Number	Product Description	Quantity Required
①	K2203-1 Power Wave® 455M/STT	1
②	K2536-1 Power Feed™ 25M	1
③	K1543-xx ArcLink® Digital Control Cables	1
④	K1796-xx or K2593-xx Coaxial Weld Power Cable, Lug to Lug, 1/0 Coaxial Weld Power Cable, Lug to Lug, #1	1
⑤	K910-2 Work Clamp (500A @ 60% Duty Cycle)	1
⑥	K497-6 Magnum® 200 Gun (requires connection kit)	1
	K466-1 Gun connector kit	1
⑦	K586-1 Deluxe Regulator for Mixed Shielding Gases and Hose (4.3 ft)	1
	KP1696-xx Drive Roll Kit (Solid)	1
	KP1695-xx Drive Roll Kit (Cored)	1
	WK1811-75 Heavy Duty Sense Lead	1
	K857 Remote Output Control	1

Note: For best results: Attach the work sense lead as close as possible to the welding arc.

**POWER GENERATION INDUSTRY SOLUTION**

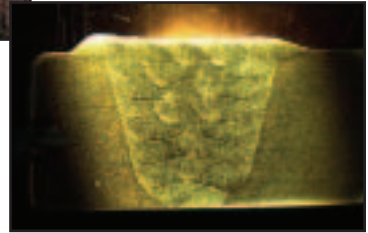
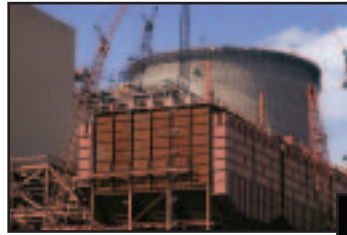
**FLUE GAS DESULFURIZATION (FGD) FABRICATION**

**Waveform Development, Equipment and Consumables**

The installation of air pollution control equipment in the power generation industry, required by government environmental regulatory agencies, permits the use of higher sulfur bearing coal. The primary purpose of the air pollution control systems, also referred to as flue gas desulfurization (FGD) equipment, is to remove sulfur compounds that form during combustion before they enter the atmosphere.

The base materials used to contain and remove the sulfur from the plume offer excellent corrosion resistance to the higher concentrations of acids that form during the plume processing. The base materials employed in these acidic environments include 2205, Ferallium 255, and several of the common chrome bearing nickel alloy base materials (625, C276, C22, and others).

Refer to NX 3.80 Flue Gas Desulfurization (FGD) Fabrication



GMAW-P Test Macro on 263 base alloy

**Waveform Control Technology®**

from the Lincoln Electric Company is suited to meet the demands of these code quality installations. Special GMAW pulsed spray metal transfer welding programs are available for use with Lincoln consumables and recommended shielding gas blends designed to meet quality and productivity expectations.

**Consumable Technology**

Lincoln Electric's extensive line of stainless steel and high alloy products are available in a variety of packaging options.



Plastic Spools

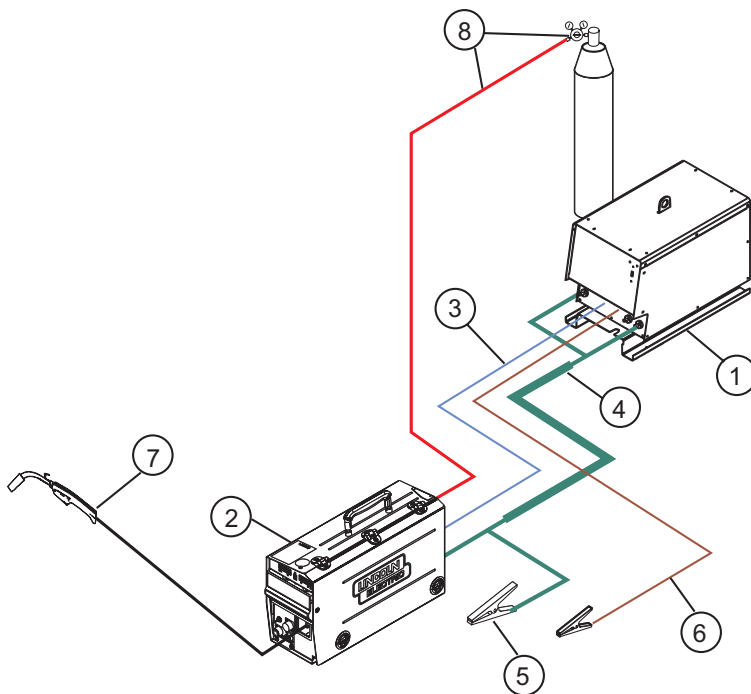


Easy Open Cans



Sahara Ready-Pak®

**POWER GENERATION SYSTEM FIELD SET-UP**



**RECOMMENDED EQUIPMENT PULSED MIG**

Product Number	Product Description	Quantity Required
① K2368-1 or K2202-1 or K2203-1	Power Wave® 355M Power Wave® 455M Power Wave® 455M/STT	1
② K2536-1	Power Feed™ 25M	1
③ K1543-xx	ArcLink® Digital Control Cables	1
④ K1796-xx or K2593-xx	Coaxial Weld Power Cable, Lug to Lug, 1/0 Coaxial Weld Power Cable, Lug to Lug, #1	1
⑤ K910-2	Work Clamp (500A @ 60% Duty Cycle)	1
⑥ WK1811-75	Heavy Duty Sense Lead	1
⑦ K470-1	Magnum® 10 ft, 300A GMAW Torch	1
K466-10	Gun connector kit	1
⑧ K586-1	Deluxe Regulator for Mixed Shielding Gases and Hose (4.3 ft)	1
K2176-1	Twist-Mate™ to lug cable adapter	2
KP23-37	Tapered nozzle (3/8" ID)	1
KP14T-35 KP14T-40 KP14T-45	Tapered contact tips	1
KP1696-xx	Drive Roll Kit (Solid)	1
KP1697-xx	Drive Roll Kit (Cored)	1
K1733-4	Micro wire straightener	1

Note: Power Wave® 355M comes with Twist-Mate™ to lug connection.



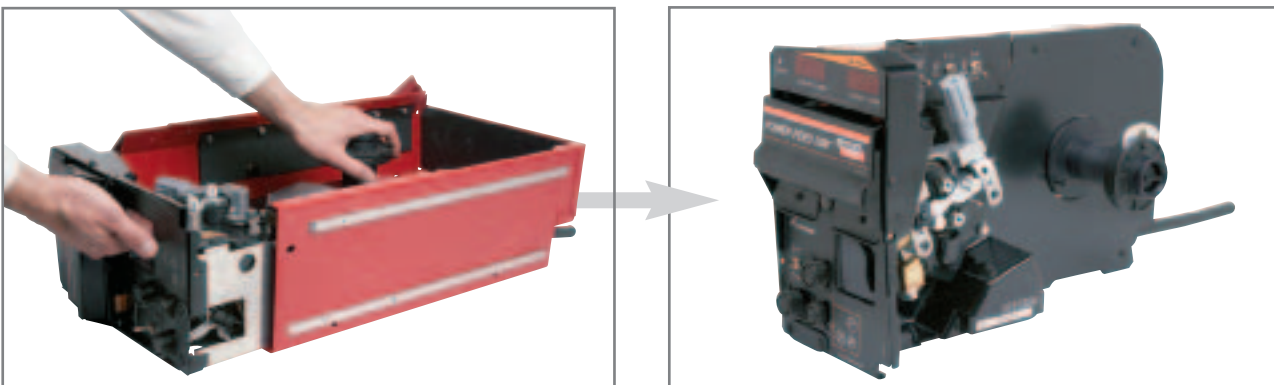
**PATENT PENDING EASY CASE REPLACEMENT**

Now a damaged case does not require ordering a new unit.

- 1 Remove screws



- 2 Remove inside module from case



- 3 Put module in a new case and assemble screws



**OPTIONS**

**ARCLINK®/LINC-NET CONTROL CABLES**

Length <sup>(1)</sup> ft. (m)	Order Number
8 (2.5)	K1543-8
16 (4.8)	K1543-16
25 (7.6)	K1543-25
50 (15.2)	K1543-50
100 (30.4)	K1543-100

<sup>(1)</sup> Without weld cable

**WELD POWER CABLES**

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
10 (3)	600	60%	3/0	K1842-10
35 (10.5)	600	60%	3/0	K1842-35
60 (18)	600	60%	3/0	K1842-60
110 (33.5)	600	60%	3/0	K1842-110

Note: All sizes are lug to lug connection type.

**COAXIAL WELD POWER CABLES<sup>(2)</sup>**

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
25 (7.6)	250	100%	#1	K2593-25
	300	60%	#1	K2593-25
	350	60%	1/0	K1796-25
50 (15.2)	250	100%	#1	K2593-50
	300	60%	#1	K2593-50
	350	60%	1/0	K1796-50
75 (22.8)	300	60%	1/0	K1796-75
100 (30.4)	250	100%	#1	K2593-100
	300	60%	1/0	K1796-100

<sup>(2)</sup> Recommended for STT® and pulse welding when using long distances between feeder and power source.

Note: All sizes are lug to lug connection type.

**DRIVE ROLL & WIRE GUIDE KITS**

Description	Power Feed 25M
<b>Steel Wire Sizes (includes stainless steel):</b>	
.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
<b>Cored Wire Sizes:</b>	
.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
<b>Steel or Cored Wire Sizes:</b>	
.068-.072" (1.8 mm)	KP1697-068
5/64" (2.0 mm)	KP1697-5/64
3/32" (2.4 mm)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
.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

**FEED PLATE GUN RECEIVER BUSHINGS**

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



**GENERAL OPTIONS**



**Magnum® Gas-Shielded Gun and Cable Assemblies**  
Available 200-550 amps, air-cooled, gas-shielded welding guns. See publication E12.10



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



**Python® Plus Push-Pull Air-Cooled Gun (no connection kit required)**  
The Python® Plus push-pull air-cooled gun features the same great performance and ergonomics as the standard Python® gun but features a Magnum® style back end for easy connection to a Lincoln Wire Feeder without an adapter. The ergonomic handle design, fingertip controls and foolproof set-up make the Python® the most advanced gooseneck gun on the market. The Python® Plus gun with standard air-cooled barrel is rated 200A @100% duty cycle, 250A @50% duty cycle.  
**Order K2447-1**  
for Air-Cooled 15 ft. (4.5 m)  
**Order K2447-2**  
for Air-Cooled 25 ft. (7.6 m)  
**Order K2447-3**  
for Air-Cooled 50 ft. (15.2 m)



**Python® Push-Pull Water-Cooled Gun (requires water connection and push-pull gun connection kits)**  
The Python® gun has a separate wire and conduit, power and gas connections.  
**Order K2212-1**  
for Water-Cooled 15 ft. (4.5 m)  
**Order K2212-2**  
for Water-Cooled 25 ft. (7.6 m)  
**Order K2212-3**  
for Water-Cooled 50 ft. (15.2 m)



**Water Connection Kit**  
Includes fittings for use with water-cooled guns and Magnum® Coolers. Kit provides for one gun.  
**Order K590-6**



**Push-Pull Gun Connection Kit**  
For push-pull guns. Includes push-pull gun receiver bushing, fittings, modified gas-bypass valve, valve removal tool and control cable extension assembly.  
**Order K2339-1**



**Deluxe Adjustable Gas Regulator & Hose Kit**  
Accommodates CO<sub>2</sub>, Argon, or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.  
**Order K586-1**

**Micro Wire Straightener**  
Straightens .035"–1/16" (0.9–1.6 mm) wire for use with portable feeders.  
**Order K1733-4** for Power Feed™ 25M



**ArcLink® "T" Connector Kit**  
For connecting multiple feeders to a single power source.  
**Order K2429-1**



**Portable Feeder Case**  
Replace a damaged case without replacing the entire unit.  
**Order K2596-1 Aluminum (shown)**  
**Order K2596-2 Plastic**

**POWER FEED™ 25M & POWER WAVE® SYSTEM ORDER FORM**

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
<b>POWER FEED™ 25M &amp; POWER WAVE® SYSTEM</b>	<b>K2536-1</b>		
<b>RECOMMENDED GENERAL OPTIONS</b>			
Magnum® Gun and Cable Assemblies	See publication E12.10		
Magnum® Self-Shielded Gun and Cable Assemblies	See publication E12.110		
Python® Plus Push-Pull Air-Cooled Gun (no connection kit required)			
- 15 ft. (4.5 m)	K2447-1		
- 25 ft. (7.6 m)	K2447-2		
- 50 ft. (15.2 m)	K2447-3		
Python® Push-Pull Water-Cooled Gun (requires water connection and push-pull gun connection kits)			
- 15 ft. (4.5 m)	K2212-1		
- 25 ft. (7.6 m)	K2212-2		
- 50 ft. (15.2 m)	K2212-3		
Water Connection Kit	K590-6		
Push-Pull Gun Connection Kit	K2339-1		
Deluxe Regulator for Mixed Shielding Gases and Hose 4.3 ft.	K586-1		
ArcLink/Linc-Net Control Cables without weld cable	See table on page 10		
Drive Roll and Wire Guide Kits	See table on page 10		
Coaxial Weld Power Cables	See table on page 10		
Weld Power Cables	See table on page 10		
Micro Wire Straightener	K1733-4		
ArcLink® "T" Connector Kit	K2429-1		
Portable Feeder Case			
- Aluminum	K2596-1		
- Plastic	K2596-2		
<b>RECOMMENDED POWER SOURCE OPTIONS</b>			
Power Wave® 355M	see publication E5.146		
Power Wave® 455M	see publication E5.161		
Power Wave® 455M/STT	see publication E5.161		
	<b>TOTAL:</b>		

**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](http://www.lincolnelectric.com) for any updated information.



**THE LINCOLN ELECTRIC COMPANY**

22801 St. Clair Ave., Cleveland, OH 44117-1199 • 216.481.8100 • [www.lincolnelectric.com](http://www.lincolnelectric.com)