

# POWER FEED® 25M

Advanced Wire Feeder



## Advanced Process Control

This compact portable wire feeder comes packed with advanced capabilities and is built for both field and shop environments. Featuring our MAXTRAC® drive system, full controls and procedural memory presets, the Power Feed® 25M is ready for advanced process welding on almost any application.

- Comprehensive Control - Dual Procedure allows you to set an A and B procedure to simplify 'on-the-fly' switching. Memory presets allow the operator to easily recall up to 8 memories and specify the range of operation for the application.
- Push-Pull Functionality - Delivers Premium aluminum performance by offering uniform feeding, as well as the ability to extend gun to feeder distance
- Rugged, Portable Design - Compact case design ideal for tight, harsh environments.

### Processes »

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

### Output »



### Input »



### Applications »

Metal Fabrication  
Construction  
Shipbuilding

### Product Number »

K2536-4 Red Aluminum Case  
K2536-5 Plastic Case

## FEATURES

- » **Internal Lighting** - Illuminates the wire drive to aid operators working in dark environments
- » **Internal Heating** - Maintains control of humidity by keeping consumables warm and protected within the enclosed case
- » **Advanced Process Control** – Easily access and control advanced weld process parameters and optimize arc characteristics
- » **ArcLink® Communication** – Industry-leading system communication for faster arc start detection time. Plug and play simplicity - no external hardware required

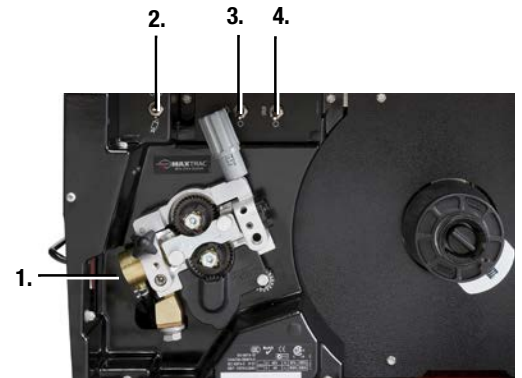
### Recommended Power Sources

- » Power Wave® S350
- » Power Wave S500
- » Power Wave S700
- » Flextec® 350X
- » Flextec 500X
- » Flextec 650X

## MAXTRAC® WIRE DRIVE SYSTEM

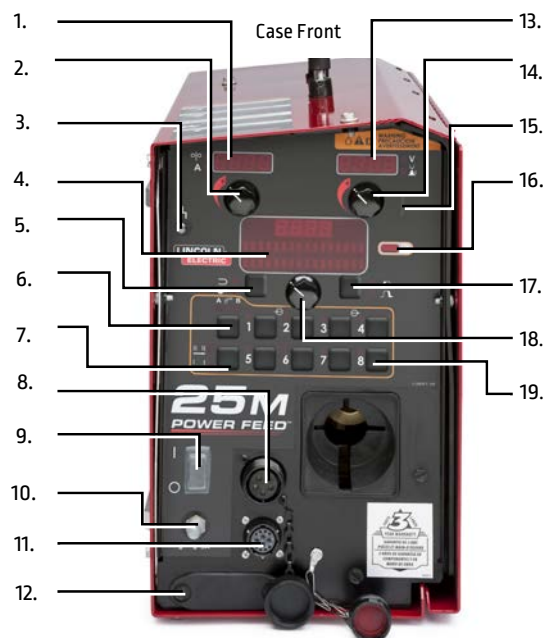


1. **Two Roll MAXTRAC® Wire Drive System**
  - Two gear driven rolls with patented groove design. No tools needed to remove rolls
  - Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
  - Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.
2. **Gas Purge/Cold Feed Switch** - Allows convenient purging of shielding gas and cold electrode feeding.
3. **Light Switch** - Turns on high intensity LED's to illuminate the inside of wire feeder.
4. **Heater Switch** - The built-in heater warms the inside air to protect consumables from moisture.



## KEY CONTROLS

1. **Left Display** - Shows wire feed speed or amperage.
2. **WFS/Amperage Control** - Adjust WFS for MIG and flux-cored; adjust amps for stick or TIG.
3. **Status LED** - Shows a steady green when properly communicating to the power source.
4. **Main Display** - Shows detailed welding and diagnostic information.
5. **Arc Control** - Adjust arc characteristics to match individual preferences.
6. **Dual Procedure** - Toggle between two weld procedures while welding.
7. **2-Step/4-Step Control** - For trigger interlock capability.
8. **Gun Trigger Connector (5-pin)** - Connection for push-only guns.
9. **On/Off Power Switch** - Protected from the elements.
10. **3 Amp Circuit Breaker** - Protects the 12-pin accessories.
11. **12-pin Remote Connection** - For connecting remote output control or push-pull gun.
12. **Cover** - Covers location for optional water cooling line.
13. **Right Display** - Shows voltage or trim.
14. **Continuous Volts/Trim Control** - Adjust voltage for MIG and flux-cored; adjust arc length (trim) for Pulsed MIG.
15. **Thermal LED** - Lights when the drive overheats.
16. **Set-Up** - Lights when feeder is set-up.
17. **Advanced Process Options** - Control pre-weld and post-weld settings to optimize arc starts and stops.
18. **Weld Mode Search** - Search for an appropriate mode based on material, process, shielding gas and other parameters.
19. **Memory Presets** - Store up to 8 customized weld procedures.



## ACCESSORIES

### ARCLINK®/LINC-NET™ CONTROL EXTENSION CABLES

Length ft. (m)	Product Description	Order Number
8 (2.5)	ArcLink®/Linc-Net® Control Cable	K1543-8
25 (7.6)	ArcLink®/Linc-Net® Control Cable	K1543-25
50 (15.2)	ArcLink®/Linc-Net® Control Cable	K1543-50
100 (30.4)	ArcLink®/Linc-Net® Control Cable	K1543-100
25 (7.6)	Heavy duty ArcLink® Control Cable	K2683-25
50 (15.2)	Heavy duty ArcLink® Control Cable	K2683-50
100 (30.4)	Heavy duty ArcLink® Control Cable	K2683-100

### 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>(1)</sup>

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

<sup>(1)</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 in. (mm)	Order Number
<b>Steel Wire Sizes (includes stainless steel):</b>	
0.023-0.030 (0.6-0.8)	KP1696-030S
0.035 (0.9)	KP1696-035S
0.045 (1.2)	KP1696-045S
0.052 (1.4)	KP1696-052S
0.035, 0.045 (0.9, 1.2)	KP1696-1
0.040 (1.0)	KP1696-2
1/16 (1.6)KP1696-1/16S	
<b>Cored Wire Sizes:</b>	
0.030-0.035 (0.8-0.9)	KP1697-035C
0.040-0.045 (1.0-1.2)	KP1697-045C
0.052 (1.4)	KP1697-052C
1/16 (1.6)KP1697-1/16C	
<b>Steel or Cored Wire Sizes:</b>	
0.068-0.072 (1.8)	KP1697-068
5/64 (2.0)	KP1697-5/64
3/32 (2.4)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
0.035 (0.9)	KP1695-035A
0.040 (1.0)	KP1695-040A
3/64 (1.2)	KP1695-3/64A
1/16 (1.6)KP1695-1/16A	

### Gun Bushings / Feed Plate Gun Adapters

K1500-1 (Comes installed on feeder)	K1500-2	K1500-3	K1500-4	K1500-5	K489-7
Lincoln Electric  Compatible gun connector kits K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4  Compatible gun connector kits K466-10 K466-2 K466-6	Tweco #5  Compatible gun connector kit K613-7 K613-2	Miller® guns  Compatible gun connector kits K466-3 K613-3	OXO® guns	Magnum® PRO Fast-Mate™ / Euro Connector Compatible gun connector kits K489-1 K489-2 K489-7 K489-8
					

Tweco® is a registered trademark of Victor Technologies.  
Miller® is a registered trademark of Miller Electric Mfg. Co.  
Oxo® is a registered trademark of Miller Electric Mfg. Co.



**Magnum® PRO Curve™**

Choose for MIG or flux-cored welding. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum® PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.

See Publication E12.05



**Magnum® PRO AL Pistol Grip**

Pistol Grip models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

Order K3478-1 (15 ft),  
K3478-2 (25 ft)  
K3478-3 (35 ft)



**Magnum® PRO AL**

Models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

See Publication E12.14 for more options



**Water Connection Kit**

Includes fittings for use with water-cooled guns and Magnum® coolers. Kit provides for one gun.

Order K590-6



**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



**Portable Feeder Case-Plastic**

Replace a damaged case without replacing the entire unit.

Order K2596-2



**6-pin to 12-pin Adapter**

Use for adapting existing 6-pin remote controls such as the K870, K857, and K963-3 to the new 12-pin connector.

Order K2909-1



**7-pin to 12-pin Adapter**

Use for connecting 7-pin push-pull guns such as the Magnum® Pro AL and Python® Plus to the new 12-pin connector.

Order K2910-1



**Remote Output Control with 12-pin Universal Connector**

Consists of a control box with choice of two cable lengths. Permits remote adjustment of output.

Order K857-225 ft. (7.6 m)  
Order K857-3100 ft. (30.5 m)

**TIG OPTIONS**



**PTA-17150 Amp**

**Air-Cooled TIG Torch**  
Order K1782-2 for 12.5 ft. (3.8 m) length, 2-cable  
Order K1782-4 for 25 ft. (7.6 m) length, 2-cable



**PTA-26200 Amp**

**Air-Cooled TIG Torch**  
Order K1783-2 for 12.5 ft. (3.8 m) length, 2-cable  
Order K1783-4 for 25 ft. (7.6 m) length, 2-cable



**Foot Amptrol™ with 12-pin Universal Connector**

Provides 25 ft. (7.6 m) of remote current control for TIG welding.

Order K870-2



**Hand Amptrol™ with 12-pin Universal Connector**

Provides 25 ft. (7.6 m) of remote current control for TIG welding.

Order K963-4

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
						Solid	Cored		
Power Feed 25M Aluminum Case	K2536-4	40 VDC	500A/60%	Standard speed (factory setting)	GMAW: 50-800 [1.3 - 20.3] FCAW: 50-800 [1.3 - 20.3]	0.023-1/16 [0.6-1.6]	0.030-5/64 [0.8-2.0]	14.5 x 8.5 x 23.5 [368 x 216 x 597]	35 [15.9]
Power Feed 25M Plastic Case	K2536-5			Extra-torque	GMAW: 30-400 [0.8-10.2] FCAW: 30-400 [0.8-10.2]	0.023-1/16 [0.6-1.6]	0.030-3/32 [0.8-2.4]		



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