

# LN-25 PRO™

## SEMI-AUTOMATIC WIRE FEEDERS



Shown:  
LN-25 PRO Standard Model  
(K2613-5)

## PORTABLE INDUSTRIAL WIRE FEEDERS

LN-25 PRO series wire feeders are designed to be simple, reliable and easy to service. These voltage-sensing feeders are compatible with any CV welding power source. Whether you are an ironworker, pipeline welder, or weld at a construction site, shipbuilding facility or metal fabrication shop, we have the right semi-automatic wire feeder for you.

### Processes »

MIG, MIG-STT<sup>®</sup>, Flux-Cored

### Applications »

Construction, Shipbuilding, Rental Fleet, Pipe, Metal Fabrication

### Output »



### Input »



All Models  
Across the Arc



K2614-6 Only  
Control Cable

### Product Numbers »

K2613-5 PRO Standard  
K2613-7 PRO Extra Torque  
K2614-6 PRO Dual Power  
K2614-5 PIPE  
K2614-9 Ironworker<sup>®</sup>

<sup>®</sup> STT<sup>™</sup> capability only with K2614-6 Dual Power Model and K1525-1 Invertex<sup>®</sup> STT<sup>™</sup> II power source.

# FEATURES

- **MAXTRAC® Wire Drive System** – Heavy-duty cast aluminum wire drive system provides reliable feeding and more durability.
- Tachometer feedback allows for accurate wire feed speed.
- **Dual Range Wire Feed Speed** – Delivers greater precision at low end wire feed speeds.
- **Trigger Interlock Switch** – Provides enhanced operator comfort for long welds.
- **Replaceable and Flame Resistant Case** – Can be replaced in less than five minutes.
- **Potted PC Boards** – For moisture and corrosion protection.

## CHOOSE THE RIGHT MODEL FOR YOUR APPLICATION

	LN-25 PRO Standard	LN-25 PRO Extra Torque	LN-25 PRO Dual Power	LN-25 Pipe	LN-25 Ironworker®
MAXTRAC Wire Drive System	•	•	•	•	•
Trigger Interlock Switch	•	•	•	•	•
Replaceable, Flame Resistant Case	•	•	•	•	•
Internal Contactor	•	•	•	•	•
Gas Solenoid	•	•	•	•	•
Arc Sensing Lead and Clip , 15, ft. (4.5 m)	•	•	•	•	•
Two Gun Bushings (K1500-2 Tweco® style installed; K1500-1 Lincoln style loose)	•	•	•	•	•
4/0 Input Power Cable w/Lug - 18.5 In.	•	•	•	•	•
Potted PC Boards for Moisture and Corrosion Protection	•	•	•	•	•
Dual Range Wire Feed Speed	•	•	•	•	•
Flow Meter	•	•	•		
Dual Digital Display for Wire Feed Speed/Amperage and Voltage			•	•	•
CC/CV Switch	•	•	•		
Analog Voltage Meter	•	•			
5/64 in. (2.0 mm) cored wire drive rolls and guide kit (KP1697-5/64) included				•	•
Extra Torque for up to 3/32 in. Diameter Wire Welding		•			
STT®-Ready with Remote Control Capabilities (Control cable compatible with K1525-1 Invertec® STT II Power Source)			•		
14 lb. (6 kg) Innershield® Coil Adapter (K435) Included				•	

K2613-5  
LN-25 PRO Standard

K2613-7  
LN-25 PRO Extra Torque

K2614-6  
LN-25 PRO Dual Power



K2614-5  
LN-25 PIPE

K2614-9  
LN-25 Ironworker



## CONTROLS

### LN-25 PRO/LN-25 PRO Extra Torque



1. Analog Voltmeter
2. Wire Feed Speed Knob
3. Dual Range Speed Switch
4. 5-Pin Gun Trigger Connector
5. Work Sense Lead
6. Thermal Protection LED
7. Welding Polarity Indicator LED
8. Gas Purge Pushbutton
9. Flow Meter Valve
10. Shielding Gas Inlet
11. Electrode Lead

### LN-25 PRO Dual Power



1. Wire Feed Speed/Amperage Digital Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connector
6. Work Sense Clip Connection
7. Thermal LED
8. Voltage Digital Display
9. Voltage LED
10. Remote Voltage Control Knob (not presettable)
11. Gas Purge Pushbutton
12. Flow Meter Valve
13. Shielding Gas Inlet
14. 14-Pin Control Cable Input
15. Electrode Lead

NOTE: In across-the-arc mode, voltage knob does not control voltage. Must be adjusted at power source.

### LN-25 PIPE AND IRONWORKER



1. Wire Feed Speed/Amperage Digital Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connection
6. Work Sense Clip Connection
7. Thermal LED
8. Voltage Digital Display
9. Voltage LED
10. Gas Purge Button
11. Shielding Gas Inlet
12. Electrode Lead

## LN-25 ONE-PAK® PACKAGES

ONE-PAK®		ONE-PAK® COMPONENT INFORMATION	
Product Number	Description	Product Number	Description
K4101-1	LN-25 PRO Standard Wire Feeder / Magnum® PRO Curve™ 300 Gun 	K2613-5	LN-25 PRO Wire Feeder Standard
		K2951-2-10-45	Magnum PRO Curve 300 Welding Gun Ready-Pak® 15 ft
		KP1697-045C	Drive Roll Kit .040-.045 in. (1.0-1.2 mm) Cored Wire
K4101-2	LN-25 PRO Standard Wire Feeder / K126® PRO FCAW-S Gun 	K2613-5	LN-25 PRO Wire Feeder Standard
		K126-12	K126 PRO Innershield® 350A FCAW-SS Welding Gun 15 ft 1/16-5/64
		KP1697-5/64	Drive Roll Kit 5/64 in. (2.0 mm) Solid/Cored Wire
		KP1697-1/16C	Drive Roll Kit 1/16 in. (1.6 mm) Cored Wire

## ACCESSORIES

### FEED PLATE GUN ADAPTERS

K1500-1 <sup>(1)</sup>	K1500-2 <sup>(2)</sup>	K1500-3	K1500-4	K1500-5	K489-7
<b>Lincoln Electric</b>	<b>Tweco® #2 - #4</b>	<b>Tweco #5</b>	<b>Miller® Guns</b>	<b>OXO® Guns</b>	<b>Fast-Mate™ / Euro Connector</b>
Compatible gun connector kits:	Compatible gun connector kits:	Compatible gun connector kits:	Compatible gun connector kits:		Compatible with weld guns with Fast-Mate or Euro connectors
K466-1 K613-1 K613-6 K466-8	K466-10 K466-2 K466-6	K613-7 K613-2	K466-3 K613-3		
					

<sup>(1)</sup>Included with machine. <sup>(2)</sup>Installed in machine.

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.

### MAXTRAC DRIVE ROLL & WIRE GUIDE KITS

Description	Product Number
<b>Steel Wire Sizes (includes stainless steel):</b>	
.023-.030 in (0.6-0.8 mm)	KP1696-030S
.035 in (0.9 mm)	KP1696-035S
.045 in (1.2 mm)	KP1696-045S
.052 in (1.4 mm)	KP1696-052S
.035, .045 in (0.9, 1.2 mm)	KP1696-1
.040 in (1.0 mm)	KP1696-2
1/16 in (1.6 mm)	KP1696-1/16S
<b>Cored Wire Sizes:</b>	
.030-.035 in (0.8-0.9 mm)	KP1697-035C
.040-.045 in (1.0-1.2 mm)	KP1697-045C
.052 in (1.4 mm)	KP1697-052C
1/16 in (1.6 mm)	KP1697-1/16C
<b>Steel or Cored Wire Sizes:</b>	
.068-.072 in (1.8 mm)	KP1697-068
5/64 in (2.0 mm)	KP1697-5/64
3/32 in (2.4 mm)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
.035 in (0.9 mm)	KP1695-035A
.040 in (1.0 mm)	KP1695-040A
3/64 in (1.2 mm)	KP1695-3/64A
1/16 in (1.6 mm)	KP1695-1/16A

### WELD POWER CABLES

Description	Product Number	
1/0 Cable	Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
	Twist Mate to Twist Mate, 1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
2/0 Cable	Tweco-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. (15.2 m)	K2485-2
	Tweco-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K2484-2
	Twist Mate to Twist Mate, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50
3/0 Cable	Tweco-Style male plug and female receptacle 3/0, 600A, 60% duty cycle, 50 ft. (15.2 m)	K2485-3
	Tweco-Style male plug and 0.53 lug, 3/0, 600A, 60% duty cycle, 50 ft. (15.2 m)	K2484-3
	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
4/0 Cable	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

### CONTROL EXTENSION CABLES (FOR DUAL POWER MODEL ONLY)

Description	Product Number
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

## RECOMMENDED POWER SOURCES

### LN-25 PRO

The LN-25 PRO line is powered "Across-the Arc". This means that it uses the open circuit voltage of the power source to power the feeder and can run off of any power source with 15-110V DC available at the studs. This gives excellent wire feeder portability because no control cable is needed. That means the LN-25 Pro machines will power off any machine that provides 15-110V DC at the studs.

The LN-25 PRO Dual Power wire feeder may also be powered through a control cable. Listed below are recommended power sources.

· *Flextec® Family* · *Ranger® Engine Driven Welders* · *Vantage® Engine Driven Welders* · *CV Family* · *Idealarc® DC Family* ·

## RECOMMENDED ACCESSORIES



**K126 PRO Innershield® Gun**  
350 A, 60% duty cycle air-cooled gun for flux-cored self-shielded Innershield welding. Magnum PRO expendable parts.  
**Order K126-11 (15 ft/4.5 m, K613-6 Gun Connector)**  
**Order K126-12 (15 ft/4.5 m, K466-10 Gun Connector)**  
See publication E12.111



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



**Magnum PRO Gun and Cable Assemblies**  
250-550 amps, air-cooled, gas-shielded welding guns.  
See publication E12.01



**Magnum PRO Curve Semiautomatic Guns**  
Magnum PRO Curve guns for MIG or flux-cored, gas-shielded 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



**Prewflow, Postflow and Burnback Time 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**



**Work and Wire Feeder 2/0 Weld Cable Package**  
Includes Twist Mate connectors, work clamp, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.  
**Order K1803-1**



**Weld Cable Package Work & Power Lead 2/0 - Tweco Male & GC500 / Tweco Male & Lug - 10 ft (3 m)**  
Includes Tweco-style Cam-Lock connectors, work clamps, 10 ft. (3.0 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.  
**Order K1803-2**



**Weld Cable Package - Work Lead - TM & GC500 Ground Clamp (2/0, 350A, 60%) - 15 ft (4.5 m)**  
Includes Twist Mate (Dinse) connector, ground clamp, 15 ft. (4.5 m) 2/0 cable. Rated 350 amps, 60% duty cycle.  
**Order K1803-3**



**Work Clamp**  
Jaws open full 2-1/2 in. (63 mm). Welding cable lug bolts directly to the work clamp. 60% duty cycle. Select K910-1 for 300 Amp applications. K910-2 for 500 Amp.  
**Order K910-1 & K910-2**



**Tweco-Style Plug**  
Female, 1/0 through 2/0.  
**Order K3416-70**



**Tweco-Style Receptacle**  
Female, 1/0 through 2/0.  
**Order K3417-70**



**Tweco-Style Plug**  
Male, 3/0 through 4/0.  
**Order K3416-90**



**Tweco-Style Receptacle**  
Female, 3/0 through 4/0.  
**Order K3417-90**



**Deluxe Adjustable Gas Regulator**  
Deluxe Gas Regulator for Mixed Gases, Adapter for CO<sub>2</sub> and 10 ft. (3.0m) Hose.  
**Order K586-1**



**Wire Feed Speed Meter**  
A wire feed speed meter with digital display.  
**Order K283**



**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**



**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**



**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**



**Replacement Case Kit**  
Replace a damaged case without replacing the entire unit.  
**Order K2596-2 (plastic)**



**Twist Mate Cable Plug**  
For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 90 mm<sup>2</sup>) cable.  
**Order K852-95**

## PRODUCT SPECIFICATION

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Flow Meter	Wire Feed Speed Range ipm (m/min)	Wire Size Range - in. (mm)			Dimensions H x W x D in (mm)	Net Weight lb (kg)
						Solid	Cored	Aluminum		
<b>LN-25 PRO</b>										
Standard	K2613-5	15-110 VDC	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)	Approx. 38 (17)  (varies per model)
Extra Torque	K2613-7				30-400 (0.8-10.1)		.030-3/32 (0.8-2.4)			
Dual Power	K2614-6	15-110 VDC or 24-42 VAC	50-700 (1.3-17.7)		.030-5/64 (0.8-2.0)					
PIPE	K2614-5	15-110 VDC	No							
Ironworker	K2614-9									



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