

# LN-25 Wire Feeder

## Portable, Construction Wire Feeder

The LN-25 semiautomatic wire feeder is ideal for field or construction use. Since it is powered across the arc, no control cables are needed! Simply connect the weld cable, attach the arc sensing clip, and you're ready to go. This portable MIG and flux-cored wire feeder comes in a fully enclosed case to protect against damage on the job site. The LN-25 features a tool-less quick release mechanism for easy wire changing, and it accepts 10-44 lbs. (4.5-19.9 kg) wire packages for plenty of welding versatility.



### Processes

MIG Flux-Cored

### Advantage Lincoln

- For MIG and flux-cored arc welding processes using up to 44 lb. (19.9 kg) spools.
- Designed for .023-1/16" (0.6-1.6mm) solid, .035-5/64" (0.9-2.0mm) cored and .035-1/16" (0.9-1.6mm) aluminum wire sizes.
- Selectable dial for setting low range, 50-350 ipm (1.3-8.9m/min) wire feed speed or high range, 50-700 ipm (1.3-17.8m/min) wire feed speed.
- Includes DC voltmeter, voltmeter polarity switch and 15 ft. (4.6m) arc sensing lead and clip and 20" (508mm) weld power cable.
- For use with Magnum® flux-cored and MIG guns.
- Automatic overvoltage and motor overload shutdown protection.
- Double-latched case features an insulated gun holder and easy access to wire.
- Entire unit is compact and portable and will pass through a 16" (400mm) diameter manway.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Three-year warranty on parts and labor.

### Description

Output



### Base Unit Includes

Arc Sensing Lead & Clip, 15 ft. (4.5m), Weld Power Cable, 20" (508mm)

### Required Options

Gun and Cable Assembly, Drive Roll Kit, Weld Power Cable, Cable Lug, Twist-Mate Cable Plug

### Recommended General Options

Jumper Plug Kit, Remote Voltage and Output Control Kits, Gas Solenoid Kit, Internal Contactor Kit, Gas Flow Timer Kit, 30 lb. Adapter, Spindle Adapter

### Recommended Power Source Options

All Lincoln Engine Driven or Electric Welders with CV Capability

### Order

- K428 LN-25 Wire Feeder  
K449 LN-25 Wire Feeder with Internal Contactor and Gas Solenoid

### TECHNICAL SPECIFICATIONS

| Product Name         | Product Number | Input Power                  | Rated Output Current / 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) |
|----------------------|----------------|------------------------------|-----------------------------------|------------------------------------|--------------------------|--------------------------|--------------------------|---------------------------------|----------------------|
|                      |                |                              |                                   |                                    | Solid                    | Aluminum                 | Cored                    |                                 |                      |
| LN-25 Across-The-Arc | K428           | 15-40V DC (110V DC Max. OCV) | Up to 500A / 60%                  | 50 - 700 (1.2 - 17.7)              | .023 - 1/16" (0.6 - 1.6) | .035 - 1/16" (0.9 - 1.6) | .035 - 5/64" (0.9 - 2.0) | 14 x 7.4 x 21 (356 x 188 x 533) | 28 (12.7)            |
|                      | K449           |                              | Up to 300A / 60%                  |                                    |                          |                          |                          |                                 | 35 (15.4)            |

### PERFORMANCE

- 2-roll wire drive system for easy wire feeding.
- The LN-25 provides constant wire feed speed for use with constant voltage (CV) power sources, and arc sensing wire feed speed for use with constant current (CC) power sources<sup>(1)</sup>.

- Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.

*(1) Most semiautomatic wire welding processes perform better using CV power sources. Be sure the proper power source is used for your application. Contactor life may be shortened in applications using CC power sources with high OCV.*

### FEATURES

- Tool-less quick release wire drive tension system and gun cable connections for easy wire or gun changes.
- Optional gas solenoid, timer kit for preflow and postflow of gas, internal contactor, and remote voltage control kits are available.
- Standard Voltmeter

#### Key Controls

1. Optional Remote Voltage Control
2. Optional Gas Timer Flow Kit
3. Voltmeter Polarity Switch
4. Trigger Connection
5. Arc Sensing Lead and Clip
6. Skid Plate
7. Riveted Door and Hinge Assembly
8. Gun and Cable Connection
9. Voltmeter
10. Molded Case Door
11. Case Latches
12. Fold Down Carrying Handle



### QUALITY AND RELIABILITY

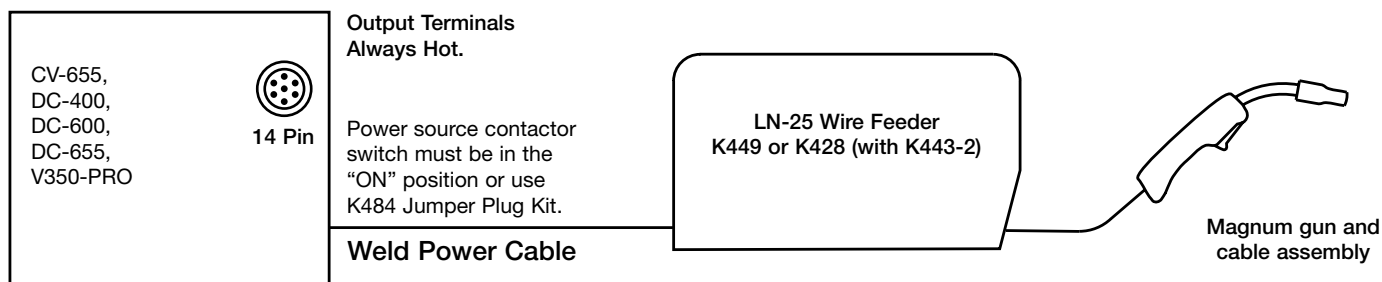
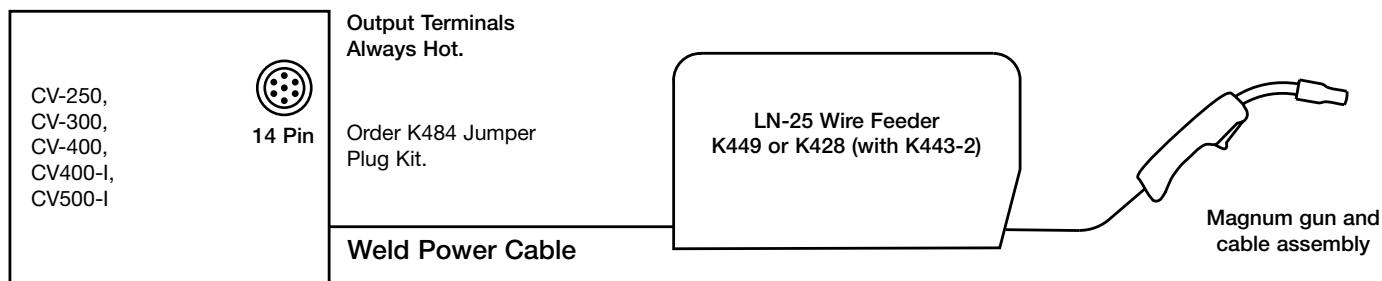
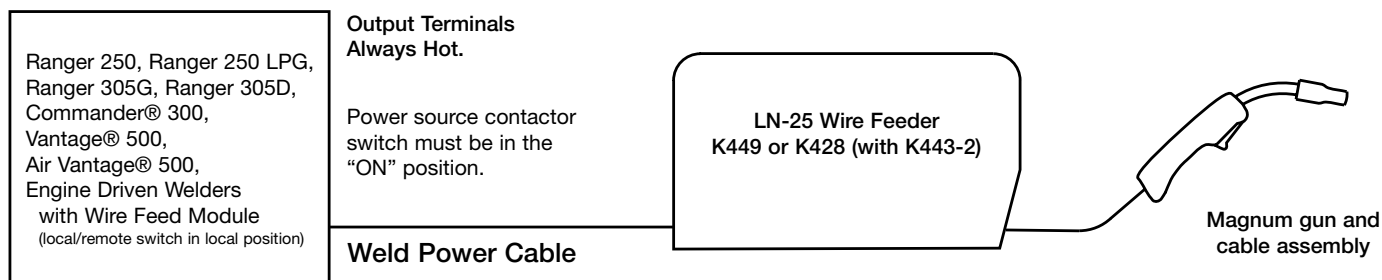
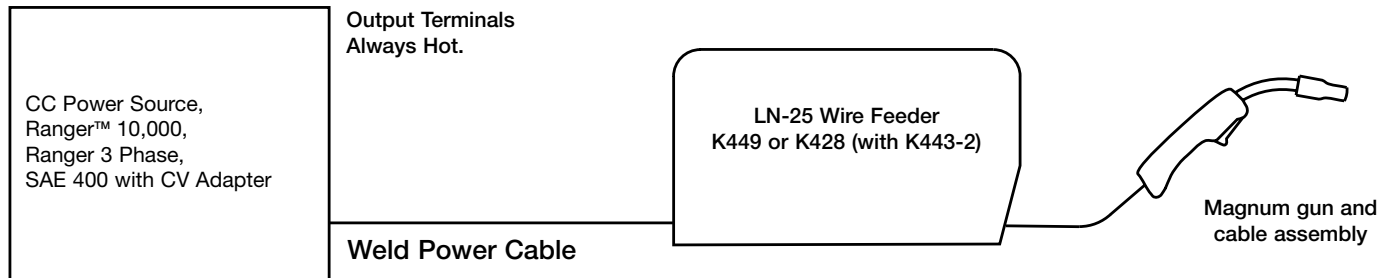
- Fully enclosed molded case meets UL94-VO flammability resistance and is heat, spatter, and impact resistant.
- Automatic overvoltage and motor overload shutdown protection.

- Three-year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9001 requirements.
- CSA approved.

**ACROSS THE ARC SET-UP (with Electrode Cold Operation)**

Electrode cold operation is available with K449 or K428 (with optional K443-2 Internal Contactor Kit installed).

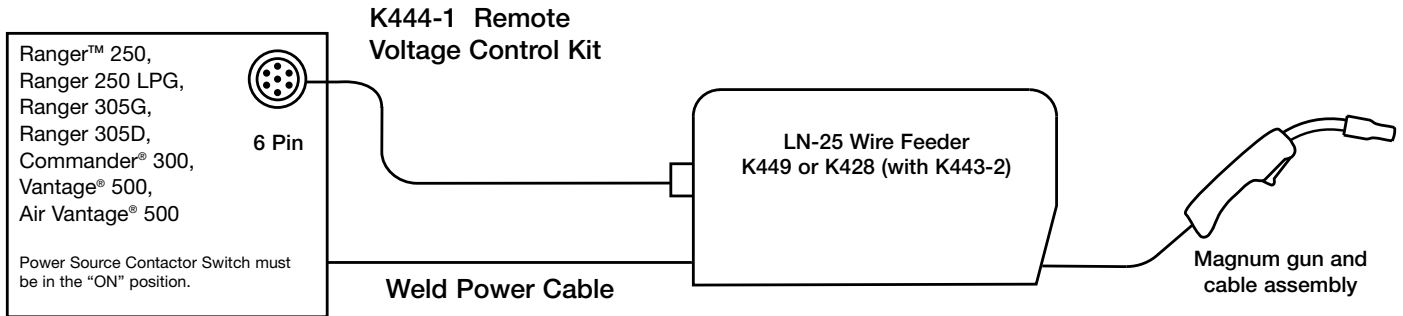
(Connections are for current equipment design. Subject to change without notice.)



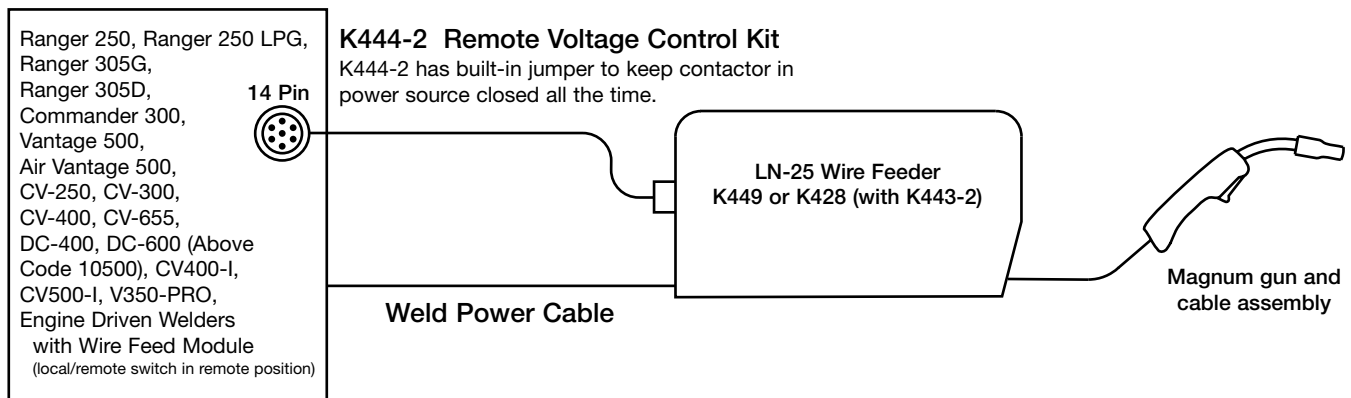
**ACROSS THE ARC SET-UP (with Electrode Cold Operation and Remote Voltage Control at LN-25)**

Electrode cold operation is available with K449 or K428 (with optional K443-2 Internal Contactor Kit installed).

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



Output Terminals Always Hot.



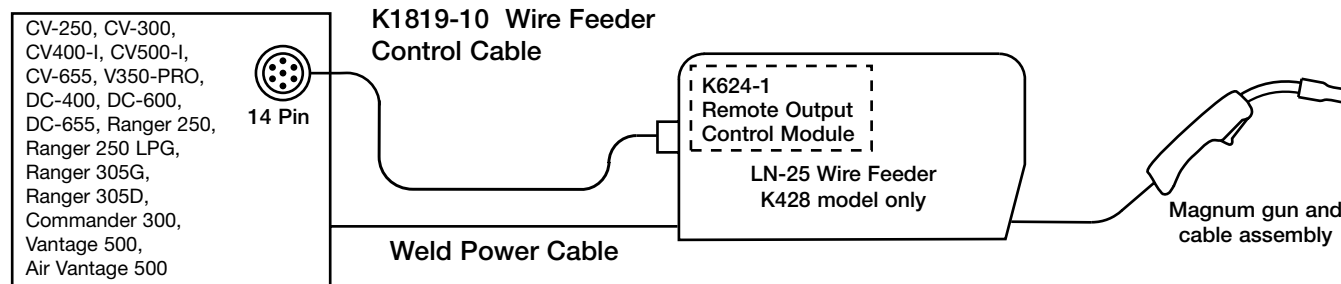
Output Terminals Always Hot.

**ACROSS THE ARC SET-UP (with Electrode Cold Operation and Remote Voltage Control at LN-25)**

For LN-25 K428 Model without Internal Contactor.

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

**42 Volt Remote Output Control Systems**



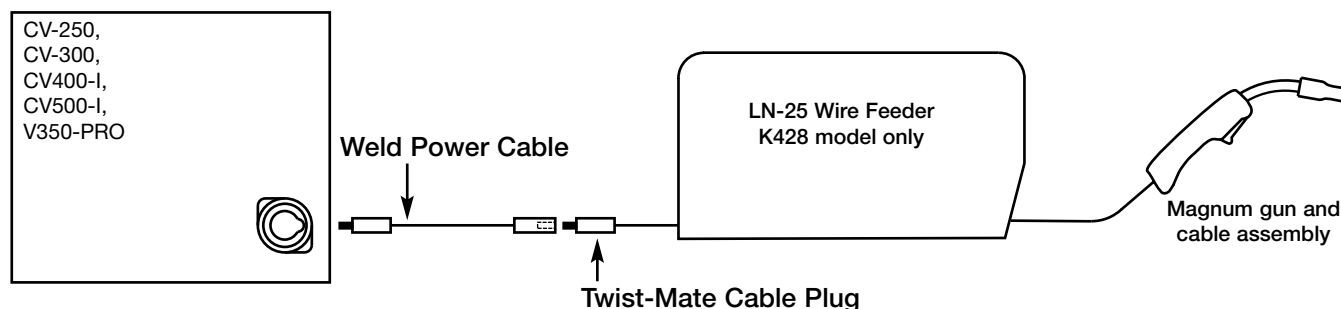
**Control Cable and Extensions**

**K1819-10** Wire Feeder Control Cable, 10 ft. (3.0m)

**K1797-25** 14-pin Extension Control Cable, 25 ft. (7.6m)

**K1797-50** 14-pin Extension Control Cable, 50 ft. (15.2m)

**WELD POWER CABLE SET-UP**



**Weld Power Cables**

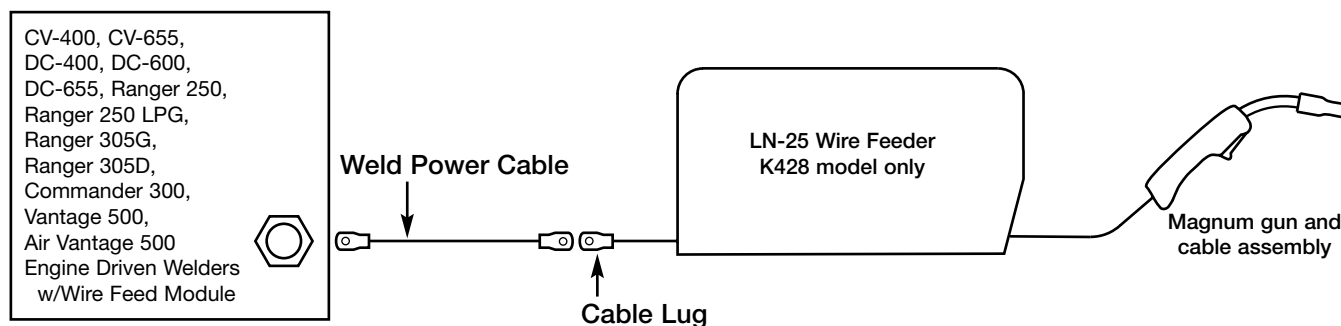
**K1841-25** Twist-Mate to Twist-Mate, 1/0, 350A, 60% duty cycle, 25 ft. (7.6m)

**K1841-50** Twist-Mate to Twist-Mate, 2/0, 350A, 60% duty cycle, 50 ft. (15.2m)

**Twist-Mate Cable Plugs**

**K852-70** for 1/0-2/0 cable

**K852-95** for 2/0-3/0 cable



**Weld Power Cables**

**K1842-10** Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0m)

**K1842-35** Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6m)

**K1842-60** Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2m)

**K1842-110** Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5m)

**Cable Lug**

**S1119-14** for 1/0-2/0 cable

## RECOMMENDED OPTIONS



Magnum 400 shown

### REQUIRED OPTIONS

#### 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

## DRIVE ROLL AND GUIDE TUBE KITS

| Wire Type and Sizes                                                                                            | Order Number                                               |
|----------------------------------------------------------------------------------------------------------------|------------------------------------------------------------|
| <b>Solid Wire:</b><br>.023 - .025" (0.6 mm)<br>.030" (0.8 mm)<br>.035" (0.9 mm)<br>.045 - .052" (1.2 - 1.4 mm) | KP653-025S<br>KP653-030S<br>KP653-035S<br>KP653-052S       |
| <b>Cored Wire:</b><br>.035" (0.9 mm)<br>.045 - .052" (1.2 - 1.4 mm)                                            | KP653-035C<br>KP653-052C                                   |
| <b>Solid or Cored Wire:</b><br>.052 - 1/16" (1.3 - 1.6 mm)<br>.068 - 5/64" (1.7 - 2.0 mm)                      | KP653-1/16<br>KP653-3/32                                   |
| <b>Aluminum Wire:</b><br>.035" (0.9 mm)<br>3/64" (1.2 mm)<br>1/16" (1.6 mm)                                    | KP654-035A<br>KP654-3/64A<br>KP654-1/16A                   |
| <b>Aluminum Wire (Clutched Drive Roll):</b><br>.035" (0.9 mm)<br>1.0 mm<br>3/64" (1.2 mm)<br>1/16" (1.6 mm)    | KP1682-035A<br>KP1682-1.0A<br>KP1682-3/64A<br>KP1682-1/16A |

## WELD POWER CABLES

| Order No. | Description                                                         |
|-----------|---------------------------------------------------------------------|
| K1841-25  | Twist-Mate to Twist-Mate, 1/0, 350A, 60% duty cycle, 25 ft. (7.6m)  |
| K1841-50  | Twist-Mate to Twist-Mate, 2/0, 350A, 60% duty cycle, 50 ft. (15.2m) |
| K1842-10  | Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0m)                |
| K1842-35  | Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6m)               |
| K1842-60  | Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2m)               |
| K1842-110 | Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5m)              |

### REQUIRED OPTIONS, CON'T



#### Twist-Mate Cable Plug

For connecting welding cable to output terminal receptacles. For 1/0 - 2/0 (50 - 70 mm<sup>2</sup>) cable.  
Order K852-70



#### Twist-Mate Cable Plug

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



#### Cable Lug

For #1 1/0-2/0 cable.  
Order S1119-14

### GENERAL OPTIONS



#### 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



#### Terminal Strip Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote output voltage control with power sources having a terminal strip.  
Order K444



#### 6 Pin Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote voltage control when used with power sources having a 6 pin MS-type connector.  
Order K444-1



#### 14 Pin Remote Voltage Control Kit

Provides 25 ft. (7.6m) of remote output voltage control and output jumper (2 and 4) for power sources having a 14 pin MS-type connector.  
Order K444-2



#### 42 Volt Remote Output Control Module

Provides remote voltage control and power source output control. Requires 42 volt auxiliary power. Mounts inside LN-25 control box. Requires K1819-10 Wire Feeder Control Cable.  
Order K624-1

## RECOMMENDED OPTIONS



**Wire Feeder Control Cable**  
10 ft. (3.0m) power source to wire feeder cable. Male 9 pin to female 14 pin.  
**Order K1819-10**



**Wire Feeder Control Cable Extension**  
Male 14 pin to female 14 pin. (Requires K1819-10.)  
**Order K1797-25** for 25 ft.  
**Order K1797-50** for 50 ft.



**Gas Solenoid Kit**  
Includes solenoid valve and mounting bracket. For K428 LN-25 model only. (Standard on K449 LN-25 model.)  
**Order K430-2**



**Internal Contactor Kit**  
Provides cold electrode until gun trigger is pressed and cold inch switch for loading wire. For K428 LN-25 model only. (Standard on K449 LN-25 model.)  
**Order K443-2**



**Gas Flow Timer Kit**  
For use with Gas Solenoid Kit. Provides adjustable delays for pre-flow and postflow of shielding gas.  
**Order K434-1**



**22-30 lb. Readi-Reel Adapter**  
Adapts 22-30 lb. (10-14kg) Lincoln Readi-Reels® of electrode to 2" (51mm) spindle. Wire not included.  
**Order K363P**



**14 lb. Innershield Coil Adapter**  
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2" (51mm) O.D. spindles. Wire not included.  
**Order K435**



**8" O.D. Spool Adapter**  
For small spools. Permits 8" (203mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles.  
**Order K468**

## LN-25 ORDER FORM

| PRODUCT DESCRIPTION                                            | ORDER NUMBER            | QUANTITY | PRICE |
|----------------------------------------------------------------|-------------------------|----------|-------|
| <b>LN-25 Wire Feeder</b>                                       | <b>K428</b>             |          |       |
| <b>LN-25 Wire Feeder w/Internal Contactor and Gas Solenoid</b> | <b>K449</b>             |          |       |
| <b>Required Options</b>                                        |                         |          |       |
| Magnum Gas-Shielded Gun and Cable Assemblies                   | See publication E12.10  |          |       |
| Magnum Self-Shielded Gun and Cable Assemblies                  | See publication E12.110 |          |       |
| Drive Roll and Guide Tube Kits                                 | See page 6              |          |       |
| Weld Power Cables                                              | See page 6              |          |       |
| Twist-Mate Cable Plug:                                         |                         |          |       |
| – for 1/0-2/0 cable                                            | K852-70                 |          |       |
| – for 2/0-3/0 cable                                            | K852-95                 |          |       |
| Cable Lug                                                      | S1119-14                |          |       |
| <b>Recommended General Options</b>                             |                         |          |       |
| Jumper Plug Kit                                                | K484                    |          |       |
| Terminal Strip Remote Voltage Control Kit                      | K444                    |          |       |
| 6-Pin Remote Voltage Control Kit                               | K444-1                  |          |       |
| 14-Pin Remote Voltage Control Kit                              | K444-2                  |          |       |
| 42 Volt Remote Output Control Module                           | K624-1                  |          |       |
| Wire Feeder Control Cable                                      | K1819-10                |          |       |
| Wire Feeder Control Cable Extension:                           |                         |          |       |
| 25 ft.(7.6m), 50 ft.(15.2m)                                    | K1797-25, -50           |          |       |
| Gas Solenoid Kit (standard on K449)                            | K430-2                  |          |       |
| Internal Contactor Kit (standard on K449)                      | K443-2                  |          |       |
| Gas Flow Timer Kit (K428 Requires K430-2)                      | K434-1                  |          |       |
| 22-30 lb. Readi-Reel Adapter                                   | K363P                   |          |       |
| 14 lb. Innershield Coil Adapter                                | K435                    |          |       |
| 8" O.D. Spool Adapter                                          | K468                    |          |       |
|                                                                | 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.

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