

Magnum[®] PRO AL Push-Pull Guns

Processes

MIG, Pulsed MIG for Aluminum

Product Number

See product specification table on back for details

See back for details

Amperage Rating 100% Argon Gas:

Air-Cooled: 225A @ 60% Duty Cycle

Water-Cooled: 450A @ 60% Duty Cycle

Wire Diameter Range: in (mm)

0.035 - 1/16 (0.9 - 1.6) Aluminum

Cable Length: ft (m)

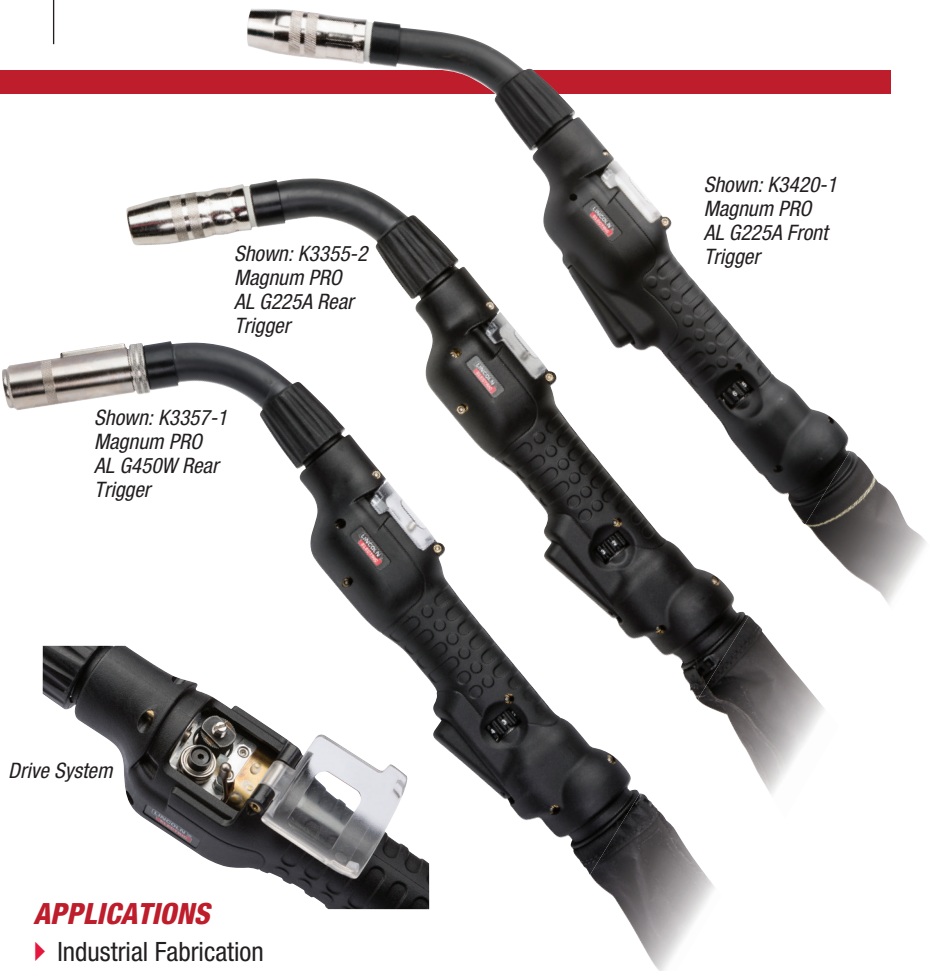
See back for details

Aluminum Push-Pull Gun

The new Magnum[®] PRO AL models are designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

FEATURES

- ▶ **Superior push-pull wire feeding technology** – Reduces friction in the wire feed path, resulting in smooth feeding and minimizing damage to the wire.
- ▶ **Quick-Change Liner** – Simply remove the set screw to quickly and easily change the liner.
- ▶ **Magnum PRO expendables** – Utilizes common expendables with all Magnum PRO MIG Guns. 550A expendables are standard with the Magnum PRO AL.
- ▶ **Patented EZ-Lock™ system** – Allows you to change or rotate barrels anytime.
- ▶ **Lightweight, ergonomic handle** – Weight distribution is equally balanced between front and back for better feel and control.
- ▶ **Recessed adjustment dial** – Conveniently located on the bottom of the handle to prevent a change while welding.
- ▶ **Flip-up drive roll cover** – Located at the thumb rest for easy access to wire. Quick wire release for easy wire adjustments.
- ▶ **Complete with a insulated groove drive roll and an insulated idler roll** – Provides a consistent arc. Drives will handle aluminum wire from 0.035 - 1/16 in. (0.9 - 1.6 mm) diameter.



APPLICATIONS

- ▶ Industrial Fabrication
- ▶ Heavy Equipment
- ▶ Automotive

RECOMMENDED WIRE FEEDERS

- ▶ Power Feed[®] 84
- ▶ Power Feed 25M
- ▶ Power Feed 25M Aluminum

RECOMMENDED WIRE FEEDER/WELDERS

- ▶ POWER MIG[®] 350MP
- ▶ Power Wave[®] C300

INPUT



OUTPUT



THE LINCOLN ELECTRIC COMPANY

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PH: 216-481-8100 • www.lincolnelectric.com

| CONTACT TIPS 350A ⁽¹⁾ | |
|----------------------------------|--|
| Wire Diameter in. (mm) | Order Number |
| 0.035 (0.9) | KP2744-035AT |
| 3/64 (1.2) | KP2744-364AT KP2744-364AT5356 KP2744-364AT-B100 ⁽¹⁾ |
| 1/16 (1.6) | KP2744-116AT KP2744-116AT5356 KP2744-116AT-B100 ⁽¹⁾ |

(1)Sold in quantity of 100

| CONTACT TIPS SPRING LOADED 550A | |
|---------------------------------|--------------|
| Wire Diameter in. (mm) | Order Number |
| 0.035 (0.9) | KP3374-035A |
| 3/64 (1.2) | KP3374-364A |

| CONTACT TIPS 550A ⁽¹⁾ | |
|----------------------------------|---|
| Wire Diameter in. (mm) | Order Number |
| 0.035 (0.9) | KP2745-035AT |
| 3/64 (1.2) | KP2745-364AT ⁽¹⁾ KP2745-364AT5356 KP2745-364AT-B100 ⁽²⁾ |
| 1/16 (1.6) | KP2745-116AT KP2745-AT5356 KP2745-116AT-B100 ⁽²⁾ |

(1)This size tip furnished with gun
(2)Sold in quantity of 100

| CONDUIT LINERS | |
|---------------------------|--------------|
| Description ft (m) | Order Number |
| Conduit Liner – 15 (4.5) | KP3991-15 |
| Conduit Liner – 25 (7.6) | KP3991-25 |
| Conduit Liner – 35 (10.6) | KP3991-35 |
| Conduit Liner – 50 (15.2) | KP3991-50 |

| JUMP LINERS | |
|------------------------------------|--------------|
| Description in. (mm) | Order Number |
| Jump Liner 1/16 (1.6) | KP3376-1 |
| Jump Liner 0.035 - 3/64 (0.9 -1.2) | KP3376-3 |

| COOLANT | |
|------------------------------------|--------------|
| Description in. (mm) | Order Number |
| 1 Gallon (order in multiples of 4) | KP3379-4 |
| 5 Gallon | KP3379-5 |

| DRIVE ROLLS | |
|---|--------------|
| Description in. (mm) | Order Number |
| Knurled Insulated | KP3990-1 |
| 0.035 (0.89) Groove Insulated ⁽¹⁾ | KP3989-1 |
| 3/64 (1.19) & 1/16 (1.59) Groove Insulated ⁽¹⁾ | KP3989-2 |

(1) includes drive roll and insulated idler roll assembly

| OPTIONAL 6 in. STRAIGHT AND CURVED GUN TUBE ASSEMBLIES | | |
|--|--------|---------------------------|
| 350A/550A Expendables Compatibility/Threaded Diffuser | | |
| Compatible Guns | Degree | Order Number |
| Straight, Air- & Water-Cooled | 180° | KP3380-180 |
| Air- & Water-Cooled | 60° | KP3380-60 |
| Air- & Water-Cooled | 45° | KP3380-45 ⁽³⁾ |
| 550A Expendables ONLY/Fixed Diffuser | | |
| Straight & Water-Cooled Gun Tube Assembly | 180° | KP3381-180 ⁽¹⁾ |
| Water-Cooled Gun Assembly | 60° | KP3381-60 ⁽⁴⁾ |
| Water-Cooled Gun Assembly | 45° | KP3381-45 ⁽¹⁾ |
| Air- & Water-Cooled | 60° | KP3988-60 ⁽²⁾ |
| Air- & Water-Cooled | 45° | KP3988-45 ⁽²⁾ |

- (1) Water-Cooled ONLY. Diffuser and nozzles are both water cooled. Use with water-cooled nozzle KP3375-1
(2) Diffuser is water-cooled. Nozzle is standard air-cooled Magnum PRO 550A Expendable (KP2743-1-62RA)
(3) Included with K3355-XX and K3356-XX guns
(4) Included with K3357-XX and K3358-XX guns

| IDLER ROLLS | |
|------------------------|--------------|
| Description in. (mm) | Order Number |
| 3/64 (1.19) Insulated | KP3992-364 |
| 0.035 (0.89) Insulated | KP3992-035 |
| 1/16 (1.59) Insulated | KP3992-116 |

RECOMMENDED ACCESSORIES



7-pin to 12-pin Adapter
Use for connecting 7-pin push-pull guns such as the Magnum® PRO AL to a 12-pin feeder connector.
Order K2910-1

| 350A SERIES EXPENDABLES | |
|--------------------------------------|--------------|
| Description | Order Number |
| Gas Diffuser, each | KP2746-1 |
| Gas Diffuser, 25 pcs. | KP2746-1-B25 |
| Insulator, 350A Gun Tube, each | KP3982-1 |
| Insulator, 350A Gun Tube, 25 pcs. | KP3982-1-B25 |
| Gas Nozzle Assembly 5/8 in (15.9 mm) | KP2742-1-62R |

For all possible options, reference bulletin E12.09.

| 550A SERIES EXPENDABLES | |
|--------------------------------------|---------------|
| Description | Order Number |
| Gas Diffuser | KP2747-1A |
| Insulator, 550A Gun Tube, each | KP3982-2 |
| Insulator, 550A Gun Tube, 25 pcs. | KP3982-2-B25 |
| Gas Nozzle Assembly 5/8 in (15.9 mm) | KP2743-1-62RA |

Use with water-cooled nozzle KP3375-1
For all possible options, reference bulletin E12.09

| PRODUCT SPECIFICATIONS | | | | | | |
|---|-----------------------|----------------------|--------------------------------|--|--|--|
| Product Name | Product Number 12-Pin | Product Number 7-Pin | Amperage Rating 100% Argon Gas | Wire Diameter Range in (mm) | Cable Length ft (m) | |
| Magnum® PRO AL G225A Front Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip) | K3420-1 | K3421-1 | 225A @ 60% Duty Cycle | 0.035 - 1/16 (0.9 - 1.6) aluminum and cored wire | 15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2) | |
| | K3420-2 | K3421-2 | | | | |
| | K3420-3 | K3421-3 | | | | |
| | K3420-4 | K3421-4 | | | | |
| Magnum® PRO AL G225A Rear Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip) | K3355-1 | K3356-1 | 450A @ 60% Duty Cycle | | 15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2) | |
| | K3355-2 | K3356-2 | | | | |
| | K3355-3 | K3356-3 | | | | |
| | K3355-4 | K3356-4 | | | | |
| Magnum® PRO AL G450W Front Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip) | K3422-1 | K3423-1 | | | 15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2) | |
| | K3422-2 | K3423-2 | | | | |
| | K3422-3 | K3423-3 | | | | |
| | K3422-4 | K3423-4 | | | | |
| Magnum® PRO AL G450W Rear Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip) | K3357-1 | K3358-1 | | | 15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2) | |
| | K3357-2 | K3358-2 | | | | |
| | K3357-3 | K3358-3 | | | | |
| | K3357-4 | K3358-4 | | | | |

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