

# Power Feed® 84 and Power Feed® 84 Dual

## Processes

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

## Product Number

K3328-XX – Single Feeder Models  
K3330-XX – Dual Feeder Models  
K3336-XX – Control Boxes

\* See back for details

## Input Power

40 VDC

## Output Capacity Current/Duty Cycle

600A/60%

## Wire Size Range

.025-.120 in. (0.6 - 3.0 mm)<sup>(3)</sup>

## Wire Feed Speed

50-1200 (1.3-30.4)<sup>(1)(2)</sup>

## Weight/Dimensions (H x W x D)

25.2 x 15.5 x 27.9 (640 x 394 x 709)  
single wire drive

## Digital Control Semiautomatic Wire Feeders

The Power Feed 84 family raises the bar for advanced process feeders by providing comprehensive process adjustability and control in a simple to use, rugged design.

### FEATURES

#### ▶ Simple & Customizable Controls –

- New Auto-Settings simplify process setup
- Eight User Memories – Per feed head for complete welding procedure recall
- USB Port – Simplifies machine setup and expands user profiles
- User Interface – Can be customized to display customer specific information

#### ▶ Rugged Design –

- Improved isolation & environmental protection
- Robust connection points allow for reliable operation in tough conditions

#### ▶ Modular Platform – Modularity ensures the feeder can be configured to fit a variety of application needs

<sup>(1)</sup> 20 tooth pinion gear installed in the wire drive as equipped from the factory.

<sup>(2)</sup> To achieve a wire feed speed of 1200, the feeder is configured with a 30 tooth pinion gear

<sup>(3)</sup> Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear



Power Feed 84 Dual and Power Feed 84

### RECOMMENDED POWER SOURCES

- ▶ Power Wave® 455M
- ▶ Power Wave 455M/STT®
- ▶ Power Wave S350
- ▶ Power Wave S500
- ▶ Power Wave S700

### WHAT'S INCLUDED

#### Bench Models Include:

- ▶ All bench models include a standard #2 - #4 gun adapter
- ▶ 20 tooth pinion gear
- ▶ All wire feeders with a wire reel stand include a 8 ft. (2.4 m) control cable (K1543-8)
- ▶ All wire feeders without a wire reel stand include a conduit inlet bushing (K3929-1)



Two Year Extended  
Warranty Available  
in the U.S.A. and  
Canada



## KEY CONTROLS

1. Amperage and voltage displays
2. Mode selection and customizable process display
3. Process configuration menus
4. Dual procedure setup
5. Feed head selection
6. User memory selection
7. USB port
8. 12 pin remote connection
9. Gun trigger connector (5 pin amphenol)
10. Cold feed and gas purge



## REQUIRED OPTIONS



**4-Roll  
Wire Drive  
Systems**




Product Number	Description/Wire Size inches (mm)
<i>Solid Wire, Smooth V Groove</i>	
KP1505-030S	.023-.030 (0.6-0.8)
KP1505-035S	.035 (0.9)
KP1505-045S	.045 (1.2)
KP1505-052S	.052 (1.4)
KP1505-1/16S	1/16 (1.6)
KP1505-1	.035, .045 (0.9, 1.2)
KP1505-2	.040 (1.0)
<i>Cored Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C <sup>(3)</sup>	.052 (1.4)
KP1505-1/16C <sup>(3)</sup>	1/16 (1.6)
KP1505-7/64H <sup>(2)(3)</sup>	7/64 (2.8) Hardfacing (Knurled V Groove with matching Smooth U Groove)
<i>Cored or Solid Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C	.052 (1.4)
KP1505-1/16C	1/16 (1.6)
KP1505-068	.068 -.072 (1.8)
KP1505-5/64	5/64 (2.0)
KP1505-3/32	3/32 (2.4)
KP1505-7/64	7/64 (2.8)
KP1505-.120	.120 (3.2)
<i>Hardfacing Wires, Knurled, Smooth V Groove</i>	
KP1505-7/64C	7/64 (2.8)
KP1505-7/64H	7/64 (2.8) Hardfacing
<i>Aluminum Wire, Smooth U Groove</i>	
KP1507-035A	.035 (0.9)
KP1507-040A	.040 (1.0)
KP1507-3/64A	3/64 (1.2)
KP1507-1/16A	1/16 (1.6)
KP1507-3/32A	3/32 (2.4)

## Magnum<sup>®</sup> PRO Gun Ready Pak<sup>®</sup>

Product Name	Product Number	Cable Length
Magnum PRO Curve 200 Ready-Pak (with K466-10 Gun Connector)	K2950-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-6 Gun Connector)	K2951-2-6-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-116	15 (3.0)
Magnum PRO Curve 400 Ready-Pak (with K466-10 Gun Connector)	K2952-2-10-45	15 (3.0)
Magnum PRO 250 (Barrel) Ready-Pak (with K466-6 Gun Connector)	K2651-2-6-45	15 (3.0)
Magnum PRO 350 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2652-2-10-45	15 (3.0)
Magnum PRO 450 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2653-2-10-45	15 (3.0)

**REQUIRED OPTIONS**

**Control Cables and Adapters**

	Product Number	Description	Connection	Use	Length ft. (m)	
	<b>ArcLink®/Linc-Net™ Control Cables</b>	K1543-8	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin	For Power Wave/Power Feed Systems	8 (2.4)
		K1543-16	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		16 (4.9)
		K1543-25	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		25 (7.6)
		K1543-50	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		50 (15.2)
		K1543-100	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		100 (30.4)
		K2683-25	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin	For Power Wave/Power Feed Systems	25 (7.6)
		K2683-50	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		50 (15.2)
		K2683-100	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		100 (30.4)

**FEED PLATE GUN ADAPTERS**

K3344-1	K3345-1	K3346-1	K3347-1	K3348-1	K3349-1
Lincoln Electric	Tweco® #2 - #4	Tweco® #5	Miller® guns	OXO® guns	Magnum® Fast-Mate™
Compatible gun connector kit K466-1 K613-1 K613-6 K466-8	Compatible gun connector kit K466-10 K466-2 K466-6	Compatible gun connector kit K613-7 K613-2	Compatible gun connector kit K466-3 K613-3		Single and dual procedure guns
					

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.

**RECOMMENDED ACCESSORIES**

**GENERAL OPTIONS**



**Inlet Bushing, quick connect style**  
Included with Power Feed 84 feeders without a wire reel stand.  
Order K3929-1



**Wire Straightener**  
Straightens wire for the better, smoother feeding.  
Order K1733-1

**Coil Adapter**  
50-60 lb coil adapter for 2 inch spindles. For use with K3343-1 heavy duty wire reel stand.  
Order K1504-1



**Wire Reel Stands – Standard Duty**  
Use for spools up to 44 lbs. (20 kg) max.  
Order K3342-1



**Wire Reel Stands - Heavy Duty**  
For Spools up to 44 lbs. (20 kg) and coils up to 60 lbs. (27 kg). Includes K3341-1 lift bail.  
Order K3343-1



**Lift Bail**  
Insulated lift bail for suspending the wire feeder. Requires either standard duty or heavy duty wire reel stand.  
Order K3341-1



**Spool Cover**  
Order K1634-4 for use with 30-40 lb. spools.  
K3340-1 for use with 50-60 lb coils.



**Shielding Gas Filter**  
Protects the gas solenoid and gun from contaminants.  
Order KP3103-1



**Inverter Cart Mounting Kit**  
Use for mounting feeder to an inverter cart  
Order K4068-1

**Undercarriage**  
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stands.  
Order K163-1

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	User Interface	Reel Stand			Gouge Kit	Contactor	Input Power	Output Capacity Current/Duty Cycle	Wire Size Range in. (mm)	Wire Feed Speed ipm (m/min)	H x W x D inches (mm)	Net Weight lbs. (kg)	Availability
			Standard	Heavy Duty	USB									
<b>Single Wire Drive</b>														
Power Feed 84	K3328-1							40 VDC	600A/60% (wire drive only)	Solid <sup>(3)</sup> .025 - 1/16 (.06 - 1.6)	50-1200 (1.3-30.4) <sup>(1)(2)</sup>	25.2 x 15.5 x 27.9 (640 x 394 x 709) single wire drive	36 (16.3)	S
	K3328-2	•											36 (16.3)	A
	K3328-6	•	•										52 (23.5)	A
	K3328-3	•			•								38 (17.2)	S
	K3328-4	•				•							41 (18.5)	A
	K3328-11	•				•							36 (16.3)	A
	K3328-7	•	•			•							54 (24.4)	P
	K3328-13	•			•	•							62 (28.1)	S
	K3328-12	•				•	•						38 (17.2)	S
	K3328-8	•	•				•						57 (25.8)	A
	K3328-5	•				•	•						43 (19.5)	A
	K3328-9	•	•			•	•						54 (24.4)	A
<b>Dual Wire Drive</b>														
Power Feed 84	K3330-1							40 VDC	600A/60% (wire drive only)	Solid <sup>(3)</sup> .025 - 1/16 (.06 - 1.6)	50-1200 (1.3-30.4) <sup>(1)(2)</sup>	25.2 x 22.5 x 30.6 (640 x 572 x 777) dual wire drive	64 (29.0)	S
	K3330-2	•											64 (29.0)	A
	K3330-6	•	•										91 (41.2)	A
	K3330-3	•			•								66 (29.9)	S
	K3330-4	•				•							74 (33.5)	A
	K3330-7	•	•			•							93 (42.1)	P
	K3330-8	•	•				•						101 (45.8)	A
	K3330-10	•			•	•							109 (49.4)	P
	K3330-9	•	•			•	•						103 (46.7)	A
	K3330-5	•			•	•	•						119 (53.9)	S
<b>Boom Control Boxes Only</b>														
Power Feed 84	K3336-2	•						40 VDC					6.5 (2.9)	S
	K3336-3												6.5 (2.9)	S

All Power Feed 84 units are equipped with a standard #2 - #4 Tweco® gun adapter

<sup>(1)</sup> 20 tooth pinion gear installed in the wire drive as equipped from the factory.

<sup>(2)</sup> To achieve a wire feed speed of 1200, the feeder is configured with a 30 tooth pinion gear

<sup>(3)</sup> Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear

S - In-stock; normally in-stock for immediate shipment

P - One-Pak® of stocked items; normally in-stock for immediate shipment

A - Assemble upon order; typically ships in 5 business days

**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 information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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.

