Welding & Cutting Equipment

PRODUCT CATALOGUE

www.lincolnelectriceurope.com
VIKING™ PAPR 3350
NEW WELDING HELMET WITH POWERED AIR PURIFYING RESPIRATOR
P. 122-125
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Using this catalogue

**Invertec® 160SX**

**Professional Performance. Industrial Innovation**

The Invertec® 160SX is built to perform: rugged and robust on site in conjunction with a generator or within a workshop combining both a rugged industrial construction with excellent arc characteristics. The lightweight but solid and compact machine is portable everywhere - lightweight, easy to handle, can operate with up to 60% reduced input cables by up to 50%... the V205S can be virtually anywhere.

**Features**

- *Maximum output of 200A allows the use of 1.6 mm wire on 16A input.*
- *Continuous Duty Cycle 85%.*
- *Portable Elements - lightweight, easy to handle, can operate with up to 60% reduced input cables by up to 50%.*
- *Electronic Current Control (ECC)*
- *V205S compliant with the latest European standard EN 61000-3-12.
- *Advanced Invertor Technology - Smart switching 230/400V single phase enables connection of input cables by up to 50%.*
- *Compliant with the latest European standard EN 61000-3-12.*
- *Power Factor Correction (PFC) gives low current input.*
- *Extended Input Voltage Range - Smart switching input voltage allows use from either a single phase 230V or 240V mains supply.*
- *Green Welding Initiative - PFC gives low current consumption, energy saving, low current harmonics and reduction of the total (THD) produced by the welding process.*

**Processes**

- *For constant current stick and TIG processes.*
- *For constant voltage MIG, flux-cored and subarc processes.*
- *For multi-process constant current or constant voltage applications.*

**Output Icons**

- **CC** For constant current stick and TIG processes.
- **AC** For constant voltage MIG, flux-cored and subarc processes.
- **DC** For multi-process constant current or constant voltage applications.

**Input Icons**

- **115V** Single phase input power.
- **230V** Three phase input power.
- **40V** 40 Volt DC Wire feeder input power.
- **48V** 48 Volt AC Wire feeder input power.
- **506** 50 Hertz input power.
- **504** 60 Hertz input power.
- **508** 50 Hertz AC Wire feeder input power.

**Recommended consumables**

- K10095-1-15M
- K10513-17-4V
- K10513-17-8V

**Recommended arc welding processes for the product.**

- **Stick**
- **Lift TIG**
- **Hardfacing**
- **Wearshield® MM, ME / RepTec**
- **Arosta®, Limarosta®, Jungo® 304L, 316L, 309S**
- **Pantafix®, Omnia® 46; Baso® G, Pantafix®**
- **120, 48SP**

**Input & Output Icons**

- **NEW!**

**Color Coding**

Each section of the catalogue is color-coded.

**Warranty**

Warranty signs shown at every product.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Current Voltage</th>
<th>Power</th>
<th>Efficiency</th>
<th>Note</th>
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<tr>
<td>S205T</td>
<td>230/400V</td>
<td>200A</td>
<td>85%</td>
<td></td>
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</table>

**Catalogue Section Tab**

1. Identifies catalogue section for easy-to-find products.
2. Official Lincoln product name.
3. Brief description of the product.
4. Opening Paragraph

This is a general description of the product. It may also include features and applications.

**Key Features**

This section highlights the key features and benefits of the product.

**Product Picture**

Detailed photo of Lincoln products.

**Recommended consumables**

See below for descriptions.

**Unit Includes**

These sections list options that are included for the product.

**Key Options**

All options available.

**Ordering**

To order, select the product number that best fits your welding needs.

**Green Initiative**

Lincoln Electric awareness program to reduce environmental impact.

**Parts & Labour**

See below for descriptions.

**Technical Specifications**

Common specifications, ratings, dimensions and weight of the product.

**NEW! Icon**

Informs about new products.

From simple jobs to advanced applications, Lincoln Electric offers a full range of stick electrodes

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*Photos and illustrations are non-contractual – they may differ from the actual product in details and colour.*
STICK WELDERS
Versatile Stick Welders for Shop or Field
Weld a Wide Range of Materials and Thicknesses
Conventional or Inverter Models
## Stick Welders

<table>
<thead>
<tr>
<th>Inverter</th>
<th>Output Range (A)</th>
<th>Voltage (V)</th>
<th>Stick Lift TIG</th>
<th>TIG Stretch</th>
<th>Arc Gouge Auto-sensing/PFC</th>
<th>Hot Start</th>
<th>Arc Force Meters</th>
<th>Warranty (Years)</th>
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<tr>
<td><strong>Invertec® 135S</strong></td>
<td>10-120</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>■ ■ ■ ■</td>
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<tr>
<td><strong>Invertec® 150S</strong></td>
<td>10-140</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>■ ■ ■ ■</td>
<td></td>
<td>■ ■ ■</td>
<td>2</td>
</tr>
<tr>
<td><strong>Invertec® 170S</strong></td>
<td>10-160</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>■ ■ ■ ■</td>
<td></td>
<td>■ ■ ■</td>
<td>2</td>
</tr>
<tr>
<td><strong>Invertec® 160SX</strong></td>
<td>5-160</td>
<td>115/230</td>
<td>●</td>
<td>●</td>
<td>■ ■ ■ ■</td>
<td></td>
<td>■ ■ ■</td>
<td>3</td>
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<tr>
<td><strong>Invertec® V205-S</strong></td>
<td>5-200</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
<td>■ ■ ■ ■</td>
<td></td>
<td>■ ■ ■</td>
<td>3</td>
</tr>
<tr>
<td><strong>Invertec® 270SX</strong></td>
<td>5-270</td>
<td>400</td>
<td>●</td>
<td>●</td>
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<td></td>
<td>■ ■ ■</td>
<td>3</td>
</tr>
<tr>
<td><strong>Invertec® 400SX</strong></td>
<td>5-400</td>
<td>400</td>
<td>●</td>
<td>●</td>
<td>○</td>
<td></td>
<td>■ ■ ■</td>
<td>3</td>
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</tbody>
</table>

**Conventional**

| LINC 405-S  | CC DC  | 15-400 | 230/400 | ●      | ○ | ○ | • | 2 |
| LINC 405-SA | CC DC  | 15-400 | 230/400 | ●      | ○ | ○ | • | 2 |
| LINC 406    | CC DC  | 30-400 | 220/380/440 | ● | ○ | ▲ | • | 2 |
| LINC 635-S  | CC DC  | 15-670 | 230/400 | ●      | ○ | ▲ | • | 2 |
| LINC 635-SA | CC DC  | 15-670 | 230/400 | ●      | ○ | ▲ | • | 2 |
| HOT ROD 500-S | CC DC  | 50-625 | 380/415 220/380/400 | ● | ○ | ▲ | • | 3 |

**Key:**
- ● Excellent
- ● Good
- ▲ Possible
STICK WELDERS

Invertec® 135S, 150S, 170S
Small, powerful and robust

The Invertec® 135S, 150S and 170S offer a range of machines built with the job in mind. These stick machines are suited to a variety of applications and working environments, ensuring that there will be a machine to meet your needs. The design has been focused on providing excellent welding and starting behaviour in a robust and reliable package. Each unit is equipped with a unique set of features and capabilities to guarantee perfect welding for your application. Welding machines need to be tough. At Lincoln Electric, we know that modern equipment needs to be capable of handling harsh environmental conditions. That is why we have built this range in a robust metal case, with large rubber corners and push control buttons for added protection. Rugged and robust on one hand, portable on another, the Invertec® 135S, 150S and 170S are lightweight and easy to handle in any situation.

Features
• Robust design: unique rubber corners and metal housing to withstand tough environmental conditions.
• Premium arc: advanced Lincoln technology and Lincoln know-how guarantees optimum performance every time.
• Power Surplus: additional power for superior arc control.
• Auto Adaptive Arc Force (150S and 170S).
• Built in "Hot Start" for stable arc with lower spatter level (150S and 170S).
• Long cables: primary power extension cables up to 60 m can be used with the 150S and 170S.
• Lift TIG with excellent striking without tungsten contaminations (150S and 170S).
• Portable lightweight, small and robust.

Technical Specifications

<table>
<thead>
<tr>
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<tbody>
<tr>
<td>Invertec® 135S</td>
<td>K12033-1</td>
<td>230V/1Ph</td>
<td>10-120</td>
<td>120A/24.8V@25%</td>
<td>14</td>
<td>5.0</td>
<td>224 x 148 x 315</td>
<td>IP21 / F</td>
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<td>K12033-1-P</td>
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<tr>
<td>Invertec® 150S</td>
<td>K12034-1</td>
<td></td>
<td>10-140</td>
<td>140A/25.6V@25%</td>
<td>17</td>
<td>7.4</td>
<td>244 x 148 x 365</td>
<td>IP23 / F</td>
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<td></td>
<td>K12034-1-P</td>
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<tr>
<td>Invertec® 170S</td>
<td>K12035-1</td>
<td></td>
<td>10-160</td>
<td>160A/26.4V@20%</td>
<td>23</td>
<td>7.8</td>
<td>244 x 148 x 365</td>
<td>IP23 / F</td>
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</tbody>
</table>

Processes
• Stick
• Lift TIG (Invertec® 150S and 170S)
• TIG Scratch (Invertec® 135S)

Recommended Consumables
• Steel: Pantafix®, Omnia® 46, Baso® 6, 120, 485P
• Stainless steel: Arosta®, Limarosta®, Jungo® 304L, 316L, 309S
• Hardfacing: Wearshield® MM, ME / RepTec

Unit Includes
• 2 m input cable
• Carrying strap

Key Options
• KIT-140A-16-3M Cable Kit 140A ~ 16 mm² ~ 3 m
• KIT-140A-25-5M Cable Kit 140A ~ 25 mm² ~ 5 m
• K10529-17-4VS TIG torch LTP 17 GV ~ 4 m

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Among other tests, the Invertec® 135S, 150S and 170S were subjected to extreme temperature environmental testing.
Invertec® 160SX
Professional Performance. Industrial Innovation

The Invertec® 160SX is built to perform: rugged and robust on one hand, portable in another. Lightweight and easy to handle in a wide variety of applications, it is ideal for professional industrial maintenance and small industrial projects, both on site and in workshops. Equipped with Power Factor Correction (PFC) Invertec® 160SX provides almost 30% output with the same input current. PFC reduces the power dissipation on input cables by up to 50%. Compliant with the latest European standard EN 61000-3-12.

Features
- More Power – 30% more output current with the same input current allows welding with up to 4.0mm electrode from a 16A input.
- Portable Everywhere – Lightweight, easy to handle, can operate with up to 100m mains extension cables and suitable to use from a generator.
- Robust Design, Industrial Use – Electrical safety (IP23), potted PC boards and optimum airflow reduces contamination to extend the equipments life in the harshest environmental conditions.
- Excellent Welding Experience – Good arc ignition with a smooth stable arc, Soft and Crisp mode, Auto Adaptive Arc Force an optimum choice for welding with every type of electrode.
- Cellulosic Capability – No electrode is too difficult to weld with. Suitable for small diameter pipe welding.
- Extended Input Voltage Range – Smart switching input power allows use from either a single-phase 115V or 230V mains supply.
- Green Welding Initiative – PFC gives low current harmonics and reduction of the total CO₂ produced by the welding process.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
<th>Dimensions WxDxH (mm)</th>
<th>Protection/Insulation Class</th>
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</thead>
<tbody>
<tr>
<td>Invertec® V205-S</td>
<td>K2019-1</td>
<td>230/400V/50Hz</td>
<td>5-200</td>
<td>200A/28V@15%</td>
<td>100A/26.8V@100%</td>
<td>12/20</td>
<td>15</td>
<td>385 x 278 x 480</td>
</tr>
</tbody>
</table>

Invertec® V205-S
Smart switching, full flexibility

Manufactured using the latest digital inverter technology, combining both a rugged industrial construction with excellent arc characteristics. The lightweight but solid build of this machine makes it suitable for operation on site in conjunction with a generator or within a workshop environment, providing maximum flexibility. The smart switching 230/400V single phase enables connection of the V205S virtually everywhere.

Features
- Smart switching 230/400V single phase.
- Excellent arc characteristics.
- Maximum output of 200A allows the use of electrodes up to 4.0 mm.
- Excellent stick rutile, basic and cellulosic welding performance.
- Adjustable “Arc Force” and “Hot Start” as standard.
- Features “Lift TIG” with no tungsten contamination.
- Fully featured and user-friendly control panel with digital display allow precise setting of welding current.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
<th>Dimensions WxDxH (mm)</th>
<th>Protection/Insulation Class</th>
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<td>Invertec® V205-S</td>
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<td>230/400V/50Hz</td>
<td>5-200</td>
<td>200A/28V@15%</td>
<td>100A/26.8V@100%</td>
<td>12/20</td>
<td>15</td>
<td>385 x 278 x 480</td>
</tr>
</tbody>
</table>
STICK WELDERS

Invertec® 270SX
Invertec® 400SX

Professional welders for tough conditions

The Invertec® 270SX & 400SX Stick and Lift TIG welders have been designed and manufactured to combine both a rugged industrial construction with excellent arc characteristics. The machines are built to handle harsh environmental conditions using Lincoln tunnel technology to separate the PCBs and sensitive parts from contaminating cooling airflow. The robust metal case with large protective rubber corners make them suitable for operation on site in conjunction with a generator, or within a workshop environment, providing maximum flexibility and durability. Intensive and extensive testing in the Lincoln lab guarantees the quality of these welders.

Features
• Robust, built for heavy environmental conditions.
• Fully featured and user friendly control panel with digital display allows precise setting of welding current.
• Soft and Crisp mode: multiple arc modes for different electrode types.
• Auto Adaptive Arc force: standard in Soft and Crisp modes the automatic variable Arc Force operates when required.
• Adjustable Hot Start and Arc Force allow a smooth start/restart of the electrode and prevent sticking of the electrode in the weld pool.
• Features “Lift TIG” with no tungsten contamination.
• Maximum output of 270A and 400A allows the use of 5.0 mm (270SX) and 6.3 mm (400SX) electrodes.

Technical Specifications

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<tr>
<td>Invertec® 270SX</td>
<td>K12040-1</td>
<td>400V/3Ph</td>
<td>5-270</td>
<td>270A/30.8V/10%</td>
<td>200A/28V/100%</td>
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<td>Invertec® 400SX</td>
<td>K12042-1</td>
<td>400V/3Ph</td>
<td>5-400</td>
<td>400A/36V/10%</td>
<td>300A/32V/100%</td>
<td>36</td>
<td>495 x 301 x 632</td>
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Processes
• Stick
• Lift TIG
• Gouging [400SX]

Recommended Consumables
• Steel
  - Pantafix®, Omnia® 46; Baso® G, 120, 48SP
• Stainless steel
  - Arosta®, Limarosta®, Jungo® 304L, 316L, 309S
• Hardfacing
  - Wearshield® MM, ME / RepTec

Unit Includes
• 3 m input cable

Key Options
• KIT-250A-35-5M Cable Kit 250A – 35 mm² – 5 m
• KIT-300A-50-5M Cable Kit 300A – 50 mm² – 5 m
• KIT-400A-70-5M Cable Kit 400A – 70 mm² – 5 m
• K10529-17-4V TIG torch LTP 17 GV – 4 m
• K10529-17-8V TIG torch LTP 17 GV – 8 m
• K10955-1-15M Remote control – 15 m
• W0200002 Undercarriage (270SX)
• K2694-1 Undercarriage (400SX)

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LINC 405-S & SA, LINC 406
LINC 635-S & SA

The rugged and distinguished workhorses

Exceptionally rugged conventional stick rectifiers built to be used under harsh environmental conditions. The units are available in two versions:
- the basic LINC 405-S and LINC 635-S ready to support stick welding with all rutile, basic and cellulosic electrodes.
- LINC 406, LINC 405-SA and LINC 635-SA complete with the additional features of Arc Force, Hot Start and digital meters.

Features
- Rugged conventional welding rectifier with excellent arc characteristics.
- Capable to weld rutile, basic and cellulose electrodes.
- Arc gouging capability.
- Hot Start supporting excellent arc starting (SA & 406).
- Arc Force to prevent sticking of the electrode in the welding pool (SA & 406).
- Digital meters showing welding amperage (SA & 406).
- Easy to understand graphic control panels.
- Fan on demand (F.A.N.™) built-in reduces power and the intake of dust and fumes.
- Ready to be moved. Equipped with wheels, pull bar and two lifting hooks.
- Lift TIG DC capability (SA only).

Technical Specifications

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<tr>
<td>LINC 405-S</td>
<td>K4002-2</td>
<td>230 / 400 V / 3Ph</td>
<td>15 - 400</td>
<td>400A / 36V / 35% / 240A / 29V / 100%</td>
<td>63 / 40</td>
<td>126</td>
<td>640 x 580 x 700</td>
<td>IP23 / H</td>
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<td>LINC 405-SA</td>
<td>K4002-1</td>
<td>220 / 380 / 440 V / 3Ph</td>
<td>20 - 400</td>
<td>670A / 44V / 35% / 400A / 36V / 100%</td>
<td>100 / 63</td>
<td>150</td>
<td>670 x 580 x 700</td>
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<tr>
<td>LINC 406</td>
<td>K4104-1</td>
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<td>30 - 400</td>
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<td>LINC 635-S</td>
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<td>15 - 670</td>
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<tr>
<td>LINC 635-SA</td>
<td>K4038-1</td>
<td>220 / 380 / 440 V / 3Ph</td>
<td>20 - 670</td>
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</tbody>
</table>

Processes
- Stick
- Lift TIG DC (-SA)
- Gouging

Recommended Consumables
- Steel
  - Pantafix®, Omnia® 46, Baso® G, 120, 485P
  - Stainless steel
  - Arosta®, Limarosta®, Jungo® 304L, 316L, 309S
- Hardfacing
  - Wearshield® MM, ME / RepTec

Unit Includes
- 5 m input cable

Key Options
- KIT-400A-70-5M Cable Kit 400A
  - 70 mm² – 5 m
- GRD-400A-70-xM Ground cable 400A
  - 70 mm² – 10/15 m
- E/H-400A-70-xM Electrode holder 400A
  - 70 mm² – 5/10 m
- FL060180600-L FLAIR 600 Gouging Torch
- K10095-1-15M Remote control – 15 m
HOT ROD 500S
The tough and powerful professional welder

The constant current welding rectifier HOT ROD 500-S is a three phase heavy duty power source with a current range of 50-625A. This machine is fan cooled and enclosed in a rigid case with removable side panels for convenient servicing, and on a frame suitable for stacking up to three machines. The control circuit compartment is totally potted for complete protection and located behind an inspection panel for easy access. The unit is completely weatherproof and designed for extreme environmental conditions. Whether using mild steel, low hydrogen, stainless steel or hardfacing electrodes, the HOT ROD 500-S produces a smooth, quality arc for consistent results day-in day-out. If you need a reliable machine for arc air gouging, the HOT ROD 500S can help you do that too.

Features
- Excellent arc characteristics for a wide range of electrode types.
- Maximum output of 625A allows the use of electrodes up to 6.3 mm and air carbon gouging with 8 mm electrodes.
- Compatible with rutile, basic and cellulosic electrodes.
- Stackable case design with built-in lift hook allows easy storage and handling.
- Submersion dipped transformer assembly and fully potted Power Circuit Board for added corrosion and moisture protection.
- Input voltage compensation for constant output.
- Thermostatic overload protection.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A) (slow)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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</thead>
<tbody>
<tr>
<td>HOT ROD 500S</td>
<td>K14089-1</td>
<td>380/415V/3Ph</td>
<td>50-625</td>
<td>625A/64V/95%</td>
<td>63</td>
<td>203</td>
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<td>IP23 / H</td>
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<td>K14089-2</td>
<td>220/380/410V/3Ph</td>
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<td>350A/35V/60%</td>
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</table>

Processes
- Stick
- Gouging
- TIG

Recommended Consumables
- Steel
  - Pantafix®, Omnia® 46; Baso® 6, 120, 485P
- Stainless steel
  - Arosta®, Limarosta®, Jungo® 304L, 316L, 309S
- Hardfacing
  - Wearshield® MM, ME / RepTec

Unit Includes
- 5 m input cable

Key Options
- K10376 Adapter M14/DIN5e
- E/H-400A-70-xM Electrode holder, 400A – 70 mm² – 5/10 m
- GRD-600A-95-10M Ground cable 600A – 95 mm² – 10 m
- K14092-1 48V AC socket (1500W) kit
- K14090-1 A/V meter kit
- FL060180600-L FLAIR 600 Gouging Torch
- K10095-1-15M Remote control – 15 m
STICK WELDERS

Lincoln TIG Welders Give You the Power to Perform!™

• Precision Arc Control
• Code Quality Results
• Convenient High Value Features

ACCESSORY KITS

Cable kits (ground/electrode) with ground cable & electrode holder (clamp)

Item n°:
- KIT-140A-16-3M (140A – 16 mm² – 3 m)
- KIT-140A-25-5M (140A – 25 mm² – 5 m)
- KIT-200A-25-3M (200A – 25 mm² – 3 m)
- KIT-200A-35-5M (200A – 35 mm² – 5 m)
- KIT-300A-50-5M (300A – 50 mm² – 5 m)
- KIT-400A-70-5M (400A – 70 mm² – 5 m)

Cable kits (ground)

Item n°:
- GRD-400A-70-10M (400A – 70 mm² – 10 m)
- GRD-400A-70-15M (400A – 70 mm² – 15 m)
- GRD-600A-95-10M (600A – 95 mm² – 10 m)

REMOTE CONTROLS

1 potentiometer, 6-pins, 15 m

Item n°: K10095-1-15M

Extension cable

Item n°: K10398

UNDERCARRIAGES

2-wheeled cart, delivered as a kit. For use with V2055, 2705X

Item n°: W0200002

4-wheeled undercarriage with gas cylinder platform delivered as a kit. For use with 400SX.

Item n°: K2694-1

TIG TORCHES

The Linc Torch Premium (LTP) range is enhancing our current range of TIG torches, providing even better performance for the welder’s comfort. Designed to meet the challenges of a variety of applications in maintenance, fabrication or construction sites, the new torches are offered in both air-cooled and water-cooled version.

Linc Torch Premium LTP 17 GV, manual valve
140A DC / 100A AC @ 35%

10-25 mm² connector
- K10529-17-4VS LTP 17 G, 4 m

35-50 mm² connector
- K10529-17-4V LTP 17 G, 4 m
- K10529-17-6V LTP 17 G, 8 m

LINCOLN ELECTRIC WELDING EQUIPMENT

BUILT TO PERFORM
TIG WELDERS

Precision Arc Control
Code Quality Results
Convenient High Value Features
### ASPECT® 300
The TIG AC/DC new aspect!

### TIG Welders

#### DC Inverter

<table>
<thead>
<tr>
<th>Model</th>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (Amps)</th>
<th>Voltage (V)</th>
<th>Stick Lift</th>
<th>TIG HF</th>
<th>TIG PULSE</th>
<th>Auto reconnect</th>
<th>Power Factor Correction (PFC)</th>
<th>Variable AC freq</th>
<th>Memory</th>
<th>Meters</th>
<th>Warranty (years)</th>
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<tbody>
<tr>
<td>Invertec® 170TX</td>
<td>CC</td>
<td>DC</td>
<td>5-170</td>
<td>230</td>
<td>●</td>
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<td>Invertec® 170TPX</td>
<td>CC</td>
<td>DC</td>
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<td>230</td>
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<td>●</td>
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<tr>
<td>Invertec® V205-TP 2V</td>
<td>CC</td>
<td>DC</td>
<td>5-200</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
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<tr>
<td>Invertec® V270-T</td>
<td>CC</td>
<td>DC</td>
<td>5-220</td>
<td>115/230</td>
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<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>3</td>
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<td>CC</td>
<td>DC</td>
<td>5-270</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
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<td>2</td>
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<td>CC</td>
<td>DC</td>
<td>5-270</td>
<td>230/400</td>
<td>●</td>
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<td>●</td>
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<td>●</td>
<td>●</td>
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<td>2</td>
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<td>Invertec® 300TPX</td>
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<td>5-300</td>
<td>400</td>
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<td>●</td>
<td>●</td>
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<tr>
<td>Invertec® 400TPX</td>
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<td>●</td>
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<td>3</td>
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</tbody>
</table>

**KEY:**
- ● Excellent
- ● Good
- ▲ Possible

#### AC/DC Inverter

<table>
<thead>
<tr>
<th>Model</th>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (Amps)</th>
<th>Voltage (V)</th>
<th>Stick Lift</th>
<th>TIG HF</th>
<th>TIG PULSE</th>
<th>Auto reconnect</th>
<th>Power Factor Correction (PFC)</th>
<th>Variable AC freq</th>
<th>Memory</th>
<th>Meters</th>
<th>Warranty (years)</th>
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<tbody>
<tr>
<td>Aspect® 300</td>
<td>CC</td>
<td>AC/DC</td>
<td>2-300</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>●</td>
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</tr>
</tbody>
</table>

### Key Features:
- Smart Switching, Full Flexibility
- Designed and Engineered for Durability
- Professional TIG welders for Tough Conditions
- Industrial TIG welders for Tough Conditions

**Lincoln Electric**

www.lincolnelectric.com
Invertec® V205-TP-2V
Smart switching, full flexibility

The Invertec® V205-TP-Pulse is manufactured in a lightweight but robust outer casing, making it portable and ideal for operation, even in the most hazardous environments. The smart switching 230/400V single phase allows it to be utilised anywhere on site and workshops. It features HF TIG ignition, Lift TIG ignition, 2 or 4 step, variable down slope and postflow control, a digital pre-set meter with a Hold function and built-in Variable Pulse.

Features
• Smart switching 230/400V single phase.
• HF and Lift TIG ignition.
• HIGH speed PULSE to adjust the arc focus, reduce distortion and increase travel speed.
• Excellent arc characteristics for rutile, basic and cellulosic electrodes up to 4.0 mm.
• Fan as needed (F.A.N.™) built-in reduces power and the intake of dust and fumes.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A) (slow)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Invertec® V205-TP-2V</td>
<td>K10201-1</td>
<td>230/400V/1Ph</td>
<td>5-200</td>
<td>200A/28V/100%</td>
<td>15/20</td>
<td>16.2</td>
<td>358 x 275 x 480</td>
<td>IP23S / H</td>
</tr>
</tbody>
</table>

Invertec® V270-T & TP
Designed and Engineered for Durability

The Invertec® V270-T/TP is manufactured in a lightweight but robust outer casing, making it portable and ideal for operation, even in the most hazardous environments. It features HF TIG ignition, Lift TIG ignition, 2 or 4 step, variable down slope and postflow control, a digital preset meter with a Hold function and built-in Variable Pulse (for TP models). 2V models can be connected both to 195V AC and 230V AC supply. It can be simply changed to a water cooled unit by adding the COOL ARC® 20 Water Cooler.

Features
• Excellent arc characteristics for a wide range of applications.
• Generator compatible, ideal for site use.
• HF and Lift TIG ignition.
• Fully functional user-friendly control panel for easy setup of welding parameters.
• HIGH speed PULSE to adjust the arc focus, reduce distortion and increase travel speed (TP models).
• Fan as needed (F.A.N.™) built-in reduces power and the intake of dust and fumes.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A) (slow)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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<tbody>
<tr>
<td>Invertec® V270-T</td>
<td>K10203-1</td>
<td>400V/3Ph</td>
<td>5-270</td>
<td>270A/28V/100%</td>
<td>15</td>
<td>15.2</td>
<td>385 x 275 x 480</td>
<td>IP23S / H</td>
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<tr>
<td>Invertec® V270-TP</td>
<td>K10204-1</td>
<td>380V/3Ph</td>
<td>5-200</td>
<td>200A/28V/100%</td>
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<td>15.2</td>
<td>385 x 275 x 480</td>
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<td>230/400V/5Ph</td>
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<td>15</td>
<td>15.2</td>
<td>385 x 275 x 480</td>
<td>IP23S / H</td>
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</tbody>
</table>
Invertec® 170TX & TPX
Invertec® 220TPX
Professional TIG welders for tough conditions

The Invertec® 170TX, 170TPX and 220TPX TIG and Stick welders combine a rugged industrial construction with excellent arc characteristics. They are full function DC TIG inverters with excellent arc control and perfect Arc Start in any welding conditions. All the machines have been designed, not only as a TIG welder, but to also operate as a stick welder with a variety of popular stick electrodes. Their portable rugged design makes them ideal for both in shop or field use. The Invertec® 170TX is the base model with basic TIG and Stick functions. The Invertec® 170TPX has additional features including Pulse TIG, 10 memory locations, TIG Spot welding for improved TIG welding performances. The Invertec® 220TPX includes all the same features and advantages as the Invertec 170TPX model with the addition of Power Factor Correction (PFC) circuitry that allows TIG welding UP to 220A with 16A single phase input voltage. All the machines are designed to operate on engine driven generators.

Features
• Advanced inverter technology for superior TIG performance.
• Full function user-friendly control panel layout with graph and a numeric display make it easy to set all welding parameters.
• Rugged construction: electrical safety (IP23), potted PC boards and optimum airflow reduce contamination to extend the equipment’s life in the harshest environmental conditions.
• HF and Lift TIG ignition meeting all requirements.
• Perfect TIG HF starting with pre-settable stating mode.
• Complete TIG parameters setting: Pulse TIG with variable frequency that allows the welder to adjust the arc focus to suit the applications, 10 memory location for personalized welding setting, TIG Spot welding (170TPX, 220TPX).
• PFC (Power Factor Correction) advantages: 30% more output current with the same input current, suitable for 115-230V (+15%/-10%) single phase, low current consumption, energy saving, low current harmonics and reduction of the total CO₂ produced by the welding process (220TPX).

Processes
• Stick
• Lift TIG / TIG HF
• TIG Pulse (170TPX, 220TPX)

Recommended Consumables
• Steel
  LNT 25, LNT 26, LNT Ni1, LNT 19
• Stainless steel
  LNT 304L, 316L, 309LSi

Unit Includes
• 2m input cable
• Gas connection kit

Key Options
• KIT-200A-25-3M Cable Kit 200A
  – 25 mm² – 3 m
• KIT-200A-35-5M Cable Kit 200A
  – 35 mm² – 5 m
• KIT-250A-35-5M Cable Kit 250A
  – 35 mm² – 5 m
• GRD-200A-35-5M Ground cable 200A
  – 35 mm² – 5/10 m
• K10529-17-x TIG torch LTP 17 G – 140A
  – 4/8m
• K10529-26-x TIG torch LTP 26 G – 180A
  – 4/8m
• K10529-20-x TIG torch LTP 20 W
  – 220A – 4/8m
• K870 Foot Amptrol
• K14147-1 Remote control – 15 m
• K14148-1 Extension for remote control 15m

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output (TIG)</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
<th>Dimensions (mm)</th>
<th>Protection/Insulation Class</th>
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<tbody>
<tr>
<td>Invertec® 170TX</td>
<td>K12054-1</td>
<td>230V/Ph</td>
<td>5-170</td>
<td>170A/16.8V/15%</td>
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<td>12</td>
<td>328 x 212 x 465</td>
<td>IP23 / H</td>
</tr>
<tr>
<td>Invertec® 170TPX</td>
<td>K12055-1</td>
<td>115/230V/Ph</td>
<td>2-220</td>
<td>220A/18.8V/15%</td>
<td>13</td>
<td>13</td>
<td>328 x 212 x 465</td>
<td>IP23 / H</td>
</tr>
</tbody>
</table>

www.lincolnelectric.com
Invertec® 300TPX
Invertec® 400TPX

Industrial TIG welders for tough conditions

The Invertec® 300 and 400TPX have been manufactured in a light-weight but robust outer casing, making them portable and ideal for operation even in the most hazardous environments. These machines feature HF TIG ignition, Lift TIG ignition, 2 or 4 step, variable down slope, post-flow control, digital pre-set meters with hold functions and built-in variable Pulse. Unique pre-settable starting mode allows excellent HF arc start in any welding conditions. Both machines are equipped with ten memory slots allowing for setting of personal welding parameters and procedures.

TIG Spot welding mode completes the extensive list of TIG welding features. Both machines have been designed, not only as a TIG welder, but to also operate as a stick welder with a variety of popular stick electrodes including Cellulosic. They can be simply converted to a water-cooled unit by adding the COOLARC® 21 (300TPX) or COOLARC® 46 (400TPX) water-coolers. Robust, stable and well equipped carts are available for easy movement of the units.

Features
• Advanced inverter technology for superior TIG performance.
• Full function user-friendly control panel layout with graph and a numeric display make it easy to set all welding parameters.
• Rugged construction: electrical safety (IP23), potted PC boards and optimum airflow reduce contamination to extend the equipment’s life in the harshest environmental conditions.
• HF and Lift TIG ignition meeting all requirements.
• Perfect TIG HF starting with pre-settable starting mode.
• Complete TIG parameters setting: Pulse TIG with variable frequency that allows the welder to adjust the arc focus to suit the applications, 10 memory location for personalized welding setting, TIG Spot welding.
• Water coolers and Carts available

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
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<td>300A/222/40%</td>
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<td>400A/262/35%</td>
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<tr>
<td></td>
<td>K12043-1</td>
<td>500V/3Ph</td>
<td></td>
<td>400A/262/35%</td>
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</table>
ASPECT® 300
The TIG AC/DC new aspect!

ASPECT® 300 is an industrial AC/DC TIG welding machine designed and manufactured using the latest inverter digital technology. This machine has been designed and built to perform in the most hazardous environments at high outputs: 300A at 35% duty cycle both in TIG AC and TIG DC application. The controller provides all the features you would expect from industrial AC/DC TIG inverter welding machines combined with a user-friendly front panel layout, setting advanced TIG parameters has never been so simple!
The top class features like the 2A minimum current, the multiple AC mode selection (including four different wave shapes), the optimized TIG start with adjustable electrode type and HF polarity, makes the unit the right choice to suit any application. It can be simply changed to water-cooled by adding the COOL ARC® 46 Water Cooler. A robust, stable and well equipped cart is available for easy movement of the unit.

Features
- Advanced inverter technology for superior TIG performance.
- Superb welding characteristics with TIG DC, TIG AC and Stick welding processes.
- Adjustable cleaning and penetration for perfect aluminium welding.
- Variable AC frequency (40-400Hz) for control of travel speed and penetration.
- Full function user-friendly control panel layout with graph and a numeric display make it easy to set all welding parameters.
- Rugged construction: electrical safety (IP23), potted PC boards and optimum airflow reduce contamination to extend the equipment’s life in the harshest environmental conditions.
- PFC (Power Factor Correction) advantages: 30% more output current with the same input current, suitable for 230-400V (+15%-10%) three phase, low current consumption, energy saving, low current harmonics and reduction of the total CO₂ produced by the welding process.
- Water coolers and Carts available.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size [A] (blown)</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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<tr>
<td>ASPECT® 300</td>
<td>K12058-1</td>
<td>230V400V/3Ph/50Hz</td>
<td>2-300</td>
<td>300A/220V/15%</td>
<td>12/20</td>
<td>43</td>
<td>455 x 301 x 632</td>
<td>IP21 / H</td>
</tr>
</tbody>
</table>

Processes
- Stick DC, Stick AC
- TIG DC, TIG AC
- Lift TIG, TIG HF
- TIG Pulse

Recommended Consumables
- Steel: LNT 25, LNT 26, LNT Ni1, LNT 19
- Stainless steel: LNT 304L, 316L, 309L
- Aluminium: SuperGlaze®

Unit Includes
- 3m input cable
- Gas connection kit

Key Options
- KIT-300A-50-xM Cable Kit 300A
- 50 mm² – 5/10m
- E/H-300A-50-xM Electrode holder 300A
- 50 mm² – 5/10m
- GRD-300A-50-xM Ground cable 300A
- 50 mm² – 5/10m
- K10529-26-x TIG torch LTP 26 G
- 180A – 4/8m
- K10529-18-x TIG torch LTP 18 W
- 220A – 4/8m
- K10529-18SC-8 TIG torch LTP 18 W SC
- 400A – 8m
- KP10516-11 Accessory kit LT77/1026
- 1.6-2.4 mm
- KP10516-12 Accessory kit LT77/1826
- 2.4-3.2 mm
- K870 Foot Amptral
- K14147-1 Remote control – 15 m
- K14148-1 Extension for remote control 15 m
- K14105-1 Water cooler COOL ARC® 46
- K10420-1 Coolant Acroxx D5x10
- K14129-1 Cart TPX
ACCESSORY KITS

Accessories

Cable kits (ground/electrode)

- KIT-140A-16-3M (140A – 16 mm² – 3 m)
- KIT-140A-25-5M (140A – 25 mm² – 5 m)
- KIT-200A-25-3M (200A – 25 mm² – 3 m)
- KIT-200A-35-5M (200A – 35 mm² – 5 m)
- KIT-250A-35-5M (250A – 35 mm² – 5 m)
- KIT-200A-25-3M (200A – 25 mm² – 3 m)
- KIT-250A-35-5M (250A – 35 mm² – 5 m)
- KIT-300A-50-5M (300A – 50 mm² – 5 m)
- KIT-400A-70-5M (400A – 70 mm² – 5 m)

Cable kits (ground)

- GRD-200A-35-5M (200A – 35 mm² – 5 m)
- GRD-200A-35-10M (200A – 35 mm² – 10 m)
- GRD-300A-50-5M (300A – 50 mm² – 5 m)
- GRD-300A-50-10M (300A – 50 mm² – 10 m)
- GRD-400A-70-10M (400A – 70 mm² – 10 m)
- GRD-600A-95-10M (600A – 95 mm² – 10 m)

REMOTE CONTROLS

- 1 potentiometer, 6-pins, 15 m Item no: K10095-1-15M
- Foot Amptrol, 6-pins, 7.6 m Item no: K870

TIG WELDERS

The Linc Torch Premium (LTP) range is enhancing our current range of TIG torches, providing even better performance for the welder’s comfort. Designed to meet the challenges of a variety of applications in maintenance, fabrication or construction sites, the new torches are offered in both air-cooled and water-cooled version.

Air cooled

<table>
<thead>
<tr>
<th>Description</th>
<th>Model</th>
<th>Item no</th>
</tr>
</thead>
<tbody>
<tr>
<td>LT 17 G / LTP 17 G / 140A DC-100A AC @ 35%</td>
<td>LT 17 G 4M Ergo</td>
<td>K10513-17-4</td>
</tr>
<tr>
<td>LT 17 G 6M Ergo</td>
<td>K10513-17-8</td>
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</tr>
<tr>
<td>LT 17 G 4M Lever</td>
<td>K10513-17-4L</td>
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<td>LT 17 G 8M Ergo</td>
<td>K10513-17-8</td>
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</tr>
<tr>
<td>LT 17 G 4M Valve Conn. 10-25</td>
<td>K10513-17-4V</td>
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<tr>
<td>LT 17 G 8M Valve Conn. 35-50</td>
<td>K10513-17-8V</td>
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<tr>
<td>LT 17 G 8M Lever</td>
<td>K10513-17-8L</td>
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</tr>
<tr>
<td>LT 26 G / LTP 26 G / 180A DC-130A AC @ 35%</td>
<td>LT 26 G 4M Ergo</td>
<td>K10529-26-4</td>
</tr>
<tr>
<td>LT 26 G 8M Ergo</td>
<td>K10529-26-8</td>
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<tr>
<td>LT 26 G 4M Lever</td>
<td>K10529-26-4L</td>
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<tr>
<td>LT 26 G 8M Valve Conn. 35-50</td>
<td>K10529-26-8V</td>
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<tr>
<td>LT 26 G 8M Lever</td>
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Water cooled

<table>
<thead>
<tr>
<th>Description</th>
<th>Model</th>
<th>Item no</th>
</tr>
</thead>
<tbody>
<tr>
<td>LT 20 W / LTP 20 W / 220A DC-165A AC @ 100%</td>
<td>LT 20 W 4M Lever</td>
<td>K10513-20-4F</td>
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<tr>
<td>LT 20 W 8M Ergo</td>
<td>K10513-20-8</td>
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</tr>
<tr>
<td>LT 20 W 8M Valve Conn. 35-50</td>
<td>K10513-20-8V</td>
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<tr>
<td>LT 20 W 8M Lever</td>
<td>K10513-20-8L</td>
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</tr>
<tr>
<td>LT 18 W / LTP 18 W / 220A DC-165A AC @ 100%</td>
<td>LT 18 W 4M Ergo</td>
<td>K10518-18-4</td>
</tr>
<tr>
<td>LT 18 W 8M Ergo</td>
<td>K10518-18-8</td>
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<tr>
<td>LT 18 W 8M Valve Conn. 35-50</td>
<td>K10518-18-8V</td>
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<tr>
<td>LT 18 W 8M Lever</td>
<td>K10518-18-8L</td>
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</tr>
<tr>
<td>LT 18 W SC / 400A DC-280A AC @ 100%</td>
<td>LT 18 W SC 4M Ergo</td>
<td>K10529-18-8</td>
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</table>

ACCESSORY KITS

Cable kits (ground/electrode)

- KIT-140A-16-3M (140A – 16 mm² – 3 m)
- KIT-140A-25-5M (140A – 25 mm² – 5 m)
- KIT-200A-25-3M (200A – 25 mm² – 3 m)
- KIT-200A-35-5M (200A – 35 mm² – 5 m)
- KIT-250A-35-5M (250A – 35 mm² – 5 m)
- KIT-300A-50-5M (300A – 50 mm² – 5 m)
- KIT-400A-70-5M (400A – 70 mm² – 5 m)

Accessories

Cable kits (ground)

- GRD-200A-35-5M (200A – 35 mm² – 5 m)
- GRD-200A-35-10M (200A – 35 mm² – 10 m)
- GRD-300A-50-5M (300A – 50 mm² – 5 m)
- GRD-300A-50-10M (300A – 50 mm² – 10 m)
- GRD-400A-70-10M (400A – 70 mm² – 10 m)
- GRD-400A-70-15M (400A – 70 mm² – 15 m)
- GRD-600A-95-10M (600A – 95 mm² – 10 m)

REMOTE CONTROLS

- 1 potentiometer, 6-pins, 15 m Item no: K10095-1-15M
- Foot Amptrol, 6-pins, 7.6 m Item no: K870

TIG TORCHES

Air cooled

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<tr>
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<tbody>
<tr>
<td>LT 17 G 4M Ergo</td>
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<tr>
<td>LT 17 G 8M Ergo</td>
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<td>LT 17 G 4M Lever</td>
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<td>LT 17 G 8M Ergo</td>
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<td>LT 17 G 8M Lever</td>
<td>K10513-17-8L</td>
<td></td>
</tr>
<tr>
<td>LT 26 G / LTP 26 G / 180A DC-130A AC @ 35%</td>
<td>LT 26 G 4M Ergo</td>
<td>K10529-26-4</td>
</tr>
<tr>
<td>LT 26 G 8M Ergo</td>
<td>K10529-26-8</td>
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<tr>
<td>LT 26 G 4M Lever</td>
<td>K10529-26-4L</td>
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<tr>
<td>LT 26 G 8M Valve Conn. 35-50</td>
<td>K10529-26-8V</td>
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<tr>
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<td>K10529-26-8L</td>
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Water cooled

<table>
<thead>
<tr>
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<th>Model</th>
<th>Item no</th>
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</thead>
<tbody>
<tr>
<td>LT 20 W / LTP 20 W / 220A DC-165A AC @ 100%</td>
<td>LT 20 W 4M Lever</td>
<td>K10513-20-4F</td>
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<tr>
<td>LT 20 W 8M Ergo</td>
<td>K10513-20-8</td>
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<tr>
<td>LT 20 W 8M Valve Conn. 35-50</td>
<td>K10513-20-8V</td>
<td></td>
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<tr>
<td>LT 20 W 8M Lever</td>
<td>K10513-20-8L</td>
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</tr>
<tr>
<td>LT 18 W / LTP 18 W / 220A DC-165A AC @ 100%</td>
<td>LT 18 W 4M Ergo</td>
<td>K10518-18-4</td>
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<tr>
<td>LT 18 W 8M Ergo</td>
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<td>LT 18 W 8M Valve Conn. 35-50</td>
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<td>LT 18 W 8M Lever</td>
<td>K10518-18-8L</td>
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<tr>
<td>LT 18 W SC / 400A DC-280A AC @ 100%</td>
<td>LT 18 W SC 4M Ergo</td>
<td>K10529-18-8</td>
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</tbody>
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UNDERCARRIAGES

- Undercarriage with gas cylinder platform, delivered as a kit, for use with 400TPX, Aspect 300 Item no: K14129-1
- 2-wheeled cart, delivered as a kit, for use with V205-TP and V270-TP Item no: W0200002

WATER COOLERS

COOL ARC® 20 for use with V205/V270 Item no: K12031-1

Coolant ACOROX (2x5l) Item no: K10420-1

COOL ARC® 21 for use with 300TPX Item no: K14103-1

COOL ARC® 46 for use with 400TPX/ASPECT 300 Item no: K14105-1

QUALITY MAKES THE DIFFERENCE
MIG & FLUX-CORED WELDERS

Recommended for industrial job shops and manufacturing applications
Optimized for CV processes
Designed for use with a variety of wire feeders
## MIG Flux-Cored Welders

### Handy MIG
- Superbly simple, powerfully portable

### Weld Pak™ 2000
- Smart, multi-process, compact

### Powertec® 161C, 191C, 231C, 271C
- The Professional’s Choice

### Powertec® 255C, 305C
- Powerful compact, excellent economics

### Powertec® 305C, 355C, 425C PRO
- Premium arc, synergic style

### Powertec® 305S, 365S, 425S, 505S
- Powerful potential

### CV-425, CV-510
- High Output. Reliable Workhorses!

### MIG Compact
- **CV-425, CV-510**
  - High Output. Reliable Workhorses!

### Powertec® 305C, 355C, 425C PRO
- Premium arc, synergic style

### Powertec® 305S
- CV DC 30-300

### Powertec® 365S
- CV DC 30-365

### Powertec® 425S
- CV DC 30-425

### Powertec® 505S
- CV DC 30-505

### CV425
- CV DC 10-420

### CV510
- CV DC 10-505

---

### MIG Packages

<table>
<thead>
<tr>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (A)</th>
<th>Voltage (V)</th>
<th>MIG</th>
<th>Flux Cored</th>
<th>nb steps</th>
<th>Drive rolls</th>
<th>WFS (m/min)</th>
<th>Warranty (years)</th>
<th>FEATURES</th>
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<td>CV DC</td>
<td>45-80</td>
<td>230</td>
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<td>●</td>
<td>2</td>
<td>1-20</td>
<td>3</td>
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<tr>
<td>Weld Pak™ 2000</td>
<td>CV DC</td>
<td>20-180</td>
<td>230</td>
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<td>●</td>
<td>2</td>
<td>1-20</td>
<td>3</td>
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<tr>
<td>Powertec® 161C</td>
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<td>30-150</td>
<td>230</td>
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<td>Powertec® 191C</td>
<td>CV DC</td>
<td>30-180</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>8</td>
<td>1-20</td>
<td>3</td>
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<tr>
<td>Powertec® 231C</td>
<td>CV DC</td>
<td>30-220</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>12</td>
<td>1-20</td>
<td>3</td>
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<td>Powertec® 271C</td>
<td>CV DC</td>
<td>30-255</td>
<td>230</td>
<td>●</td>
<td>●</td>
<td>12</td>
<td>1-20</td>
<td>3</td>
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<td>Powertec® 255C</td>
<td>CV DC</td>
<td>25-250</td>
<td>230/400-450</td>
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<td>●</td>
<td>●</td>
<td>30</td>
<td>2/4</td>
<td>1-20</td>
<td>3</td>
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<td>Powertec® 305C PRO</td>
<td>CV DC</td>
<td>30-280</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
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<td>4</td>
<td>1-20</td>
<td>3</td>
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<td>Powertec® 355C PRO</td>
<td>CV DC</td>
<td>30-350</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
<td>30</td>
<td>4</td>
<td>1-20</td>
<td>3</td>
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<tr>
<td>Powertec® 425C PRO</td>
<td>CV DC</td>
<td>30-420</td>
<td>230/400</td>
<td>●</td>
<td>●</td>
<td>30</td>
<td>4</td>
<td>1-20</td>
<td>3</td>
<td></td>
</tr>
</tbody>
</table>

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### WIRE FEEDERS
- LF22-M, LF24-M, LF24-M PRO
- LF33S, LF33

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**KEY:** ● Excellent  ● Good ▲ Possible

[www.lincolnelectric.com](http://www.lincolnelectric.com)
Handy MIG
Superbly simple, powerfully portable

Compact, portable and lightweight wire feed welders plug into a 230V, 16 amps outlet. These machines are ideally suited to the light maintenance and repair such as the small garage works and jobs around the farm. Four voltage settings and continuous wire feed speed adjustment allow to weld light gauge mild steel. Easy to get started, since practically everything you will need to weld is included – gun and cable assembly, work cable & clamp, spool of solid wire, contact tips and hand shield with filter plate and lens. Also a chipping hammer/brush, so you can use your Handy MIG to weld straight away.

Features
• Suitable for the welding of most thin sheet steel applications.
• Connects to 230V, 16 amps outlet.
• Safe operation – no electrical current until trigger is pressed.
• Compact, portable, lightweight and easy to use.
• Ideal for general light maintenance projects.
• Continuous wire feed speed adjustment and four selectable voltage steps for precise control.
• Fan-cooled or expectancy.
• Supplied ready to weld.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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</thead>
<tbody>
<tr>
<td>Handy MIG</td>
<td>K34000-1</td>
<td>230V/1Ph</td>
<td>45-80</td>
<td>70A/175V/20%</td>
<td>16</td>
<td>18</td>
<td>345 x 220 x 455</td>
<td>IP21 H</td>
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</table>

Weld Pak™ 2000
Smart, multi-process compact

The Weld PAK™ 2000 is a completed multi-process DC voltage arc welding machine. It is ideally suited to weld thin sheet metal and for repair and maintenance works. It’s perfect tool for light Steel applications. This compact can be easy movable. You need only plug the welder into 230V outlets. It is recommended for MIG/MAG applications (including Stainless Steel), for Innershield gasless flux cored arc welding and also for Stick application with Rutile and Basic electrodes. The Weld PAK™ 2000 is designed to feed wire from 0.6 mm to 1.1 mm (steel, stainless steel and flux-cored) on B300 and S200 spools. A quality welding performance depends on a quality wire drive system. For this reason we have equipped the Weld PAK with professional feeder with large rolls. The Weld PAK™ 2000 has been designed to meet Lincoln’s standards of performance and reliability. As a result we confidently provide a Lincoln two-year warranty on parts and labour.

Features
• Superior arc behaviour with premium starting performance and arc stability
• User friendly User Interface with step-less controlled output current
• Easy to change polarity
• Professional wire feeding system

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection Class</th>
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<tbody>
<tr>
<td>Weld Pak™2000</td>
<td>K34134-1</td>
<td>230V/1Ph</td>
<td>20-180</td>
<td>180A/235V/20%</td>
<td>25</td>
<td>275</td>
<td>600 x 280 x 800</td>
<td>IP23</td>
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</tbody>
</table>
The Professional’s Choice

The Powertec® 161C, 191C, 231C and 271C are all designed to provide a range of machines with a variety of welding outputs suitable for operating from a single-phase mains supply. The Powertec® range begins with the 161C, which is ideal for the welding of thin sheet metal applications, repair and maintenance works. This machine has excellent arc and starting characteristics, allowing you to complete your welding project efficiently, quickly and professionally with minimal spatter levels.

It is a perfect tool for small workshop, car body repair or for the farm. The Powertec® 191C and 231C have the power required for light construction applications, yet still offer the flexibility to weld thin material like the Powertec® 161C. The Powertec® 271C truly is the multi-purpose model in this range, ideal for both welding thin material and also light to medium construction work.

Features
- Superior arc behaviour with premium starting performance and arc stability.
- Excellent control, with Burnback control, Spot welding function, 2/4 stroke feature (except PT161C) and additional voltage settings.
- Optional volt and ammeter (except PT161C).
- Easy to change polarity.
- Professional wire feeding system.
- Equipped with Euro connector and ground cable assembly.

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Features
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Features
- Superior arc behaviour with premium starting performance and arc stability.
- Excellent control, with Burnback control, Spot welding function, 2/4 stroke feature (except PT161C) and additional voltage settings.
- Optional volt and ammeter (except PT161C).
- Easy to change polarity.
- Professional wire feeding system.
- Equipped with Euro connector and ground cable assembly.
Powertec® 255C, 305C

Powerful compact, excellent economics

The design of the Powertec® 255C and 305C was driven by the need to provide our customers with a range of machines offering a variety of welding outputs. The range begins with the 255C, which is an ideal machine for welding of thin sheet metal applications. With excellent arc and starting characteristics this machine allows welding projects to be completed efficiently, quickly and professionally with minimal spatter levels. The Powertec® 255C is a more powerful version, still capable of welding thin material but with the extra power required for light fabrication work. The Powertec® 305C truly is a multi-purpose model, ideal for both thin sheet applications and light to medium fabrication work. The Powertec® 305C will operate in either Short Arc welding or Full Spray modes with a 1.0 mm wire.

Features

- Products developed with a focus on applications.
- Excellent starting performance (stable and dynamic).
- Voltage selectors with multiple steps for precise adjustment.
- Excellent drive system with large diameter drive roll.
- Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
- Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
- Optional Volt Ammeter kit and polarity change kit.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size [A]</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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<tbody>
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<td>400V/3Ph</td>
<td>250</td>
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<td>230400V/3Ph</td>
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<td>10-300</td>
<td>100A/29V/99%</td>
<td>40025</td>
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</table>

Key Operations

- K10429-25-<xM> MIG gun LGS 250 G – 200A – 3/4/5 m
- K10429-36-<xM> MIG gun LGS 360 G – 300A – 3/4/5 m
- KP14016-<x> Drive roll kit range (DR)
- KP14017-<x> Drive roll kit range (GR)
- K10158-1 Readies reel mounting stand (15 kg)
- K14077-1 Kit polarity change
- K14049-1 Meter kit
- K14009-1 CO₂ heater connection kit

Processes

- MIG
- Flux-cored

Recommended Consumables

- Steel
  - Ultramag®, Supramig®, Supramig Ultra®
- Flux-cored
  - Innershield® NR211-MP
- Aluminium
  - SuperGlaze®
**Powertec® 305C PRO, 355C PRO**

**Powertec® 425C PRO**

**Premium arc, synergic style**

The Powertec® PRO range of MIG welding machines is superior in all respects. All have excellent arc characteristics and very low spatter levels with argon mix or 100% CO₂ shielding gas. The extensive set of features on all Powertec® Pro’s includes 2/4-step run-in, wire inch and gas purging. Two digital meters indicates clearly the welding voltage and arc length which when combined with the synergic control allows optimum and easy setting with controllability. Select the synergic control and voltage and the wire feed speed will then be adjusted automatically to suit. All machines come equipped with a rugged four-roll drive system with a powerful 90 watt motor. The machines also have a lower cylinder platform, allowing easy loading and unloading of the gas cylinder.

**Features**

- Products developed with a focus on applications.
- Superb Arc behaviour with Argon Mix and 100% CO₂.
- Excellent drive system (4 rolls) with large diameter drive roll and powerful motor.
- Electronic feedback system on the four-roll wire drive will guarantee consistent wire feed speed.
- Voltage selectors with multiple steps for precise adjustment.
- Synergic control to support easy control by the welder.
- Bright digital Volt and Ammeter.
- Completed with an extensive set of features.
- Large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.

---

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size (A/50%)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection / Insulation Class</th>
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<tr>
<td>Powertec® 305C PRO</td>
<td>K14057-1</td>
<td>230/400/50/3Ph</td>
<td>30-280</td>
<td>280/280/40%</td>
<td>32/20A</td>
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<td>890 x 565 x 1060</td>
<td>IP23 / H</td>
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<td>Powertec® 355C PRO</td>
<td>K14058-1</td>
<td>230/400/50/3Ph</td>
<td>30-350</td>
<td>350/315/40%</td>
<td>40/25A</td>
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<td>Powertec® 425C PRO</td>
<td>K14059-1A</td>
<td>230/400/50/3Ph</td>
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**Processes**

- MIG
- Flux-cored

**Recommended Consumables**

- Steel
  - Ultramag®, Supramig®, Supramig Ultra®
  - Innershield® NR211-MP, Outershield® MC710-H
  - Stainless steel
  - LNM 304L, 316L, 309LSi
  - Aluminium
  - SuperGlaze®

**Unit Includes**

- Undercarriage
- 5 m input cable
- Work clamp and cable assembly (3 m)
- Gas hose (2 m)
- Drive roll kit

**Key Options**

- K10429-25-xM MIG gun LGS 250 G
  - 200A – 3/4/5 m
- K10429-36-xM MIG gun LGS 360 G
  - 300A – 3/4/5 m
- K10429-505-xM MIG gun LGS 505 W
  - 450A – 3/4/5 m
- KP14017-x Drive roll kit range (4R)
- K10158-1 Readi-reel mounting stand (15 kg)
- K14071-1 DR system kit (grill)
- K14009-1 CO₂ heater connection kit (except PT 305C)
- K14037-1 Water cooler COOL ARC® 25
- K10420-1 Coolant Acorox (2x5l) (PT425C only)
Powertec® 305S, 365S, 425S, 505S

Powerful potential

With the full range of Powertec® power sources and the LF22M & 24M (Pro) wire feeders, Lincoln is able to offer you unrivalled choice of step voltage MIG machines. With multiple output levels available across the power source range; 2 or 4 roll feeders with or without meters and a variety of interchangeable features, the choice is huge: there are 12 different combinations which give the Powertec® range unparalleled flexibility. Design of the LF22M, 24M and 24M Pro feeders focused on ruggedness, physical dimensions and ease of use. The result is an incredibly rugged casing with the primary controls on the exterior and secondary controls secure within the protective casing close to the wire drive.

Features

- Products developed with a focus on applications.
- Superb Arc behaviour with Argon Mix and 100% CO₂.
- Voltage selectors with multiple steps for precise adjustment.
- Two choke tabs to support superb Arc behaviour.
- Fan as needed (F.A.N.™).
- Synergic control to support easy control by the welder with LF24M Pro.
- Bright digital volt and ammeter with LF24M and LF24M Pro.
- Completed with an extensive set of features.
- Large diameter wheels, push/pull bar and lifting eyes.
- Easy to convert to water-cooled by simply adding the Coolarc 25 (except PT 305S).
- Processes
  - MIG
  - Flux-cored
- Recommended Consumables
  - Steel: Ultramag®, Supramig®, Supramig Ultra®
  - Flux-cored: Innershield® NR211-MP, Outershield® MC710-H
  - Stainless steel: LNM 304L, 316L, 309LSti
  - Aluminium: SuperGlaze®
- Unit Includes
  - Undercarriage
  - 5m input cable
  - Work clamp and cable assembly (3m)

Technical Specifications of Wire Feeders

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage [50-60Hz]</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size [A]</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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<tr>
<td>Powertec® 305S</td>
<td>K4061-1</td>
<td>230460V/3Ph</td>
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<td>300A/29V@15%</td>
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<td>IP23 / H</td>
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<td>230460V/3Ph</td>
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<td>350A/31.5V@40%</td>
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<td>Powertec® 425S</td>
<td>K4062-1A</td>
<td>230460V/3Ph</td>
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<td>Powertec® 505S</td>
<td>K4063-1A</td>
<td>230460V/3Ph</td>
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Technical Specifications of Wire Feeders

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<th>Product</th>
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<th>Wire Size Range (mm)</th>
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<td>34-44V AC</td>
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<td>LF-24M PRO</td>
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<td>1.0-2.0</td>
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</table>
CV-425 & CV-510
High Output. Reliable Workhorses!

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

Features
• Potted and encapsuled printed circuit board controls in separate dust free compartments.
• Different feeders for construction and shipyards, all with meters, with or without synergy or memory; just select the one of your choice.
• Superb arc behaviour with argon mix and 100% CO₂.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

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• Potted and encapsuled printed circuit board controls in separate dust free compartments.
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• Superb arc behaviour with argon mix and 100% CO₂.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

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• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

Features
• Potted and encapsuled printed circuit board controls in separate dust free compartments.
• Different feeders for construction and shipyards, all with meters, with or without synergy or memory; just select the one of your choice.
• Superb arc behaviour with argon mix and 100% CO₂.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

Features
• Potted and encapsuled printed circuit board controls in separate dust free compartments.
• Different feeders for construction and shipyards, all with meters, with or without synergy or memory; just select the one of your choice.
• Superb arc behaviour with argon mix and 100% CO₂.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.

The CV-425 and CV-510 are industrial power sources designed for heavy duty applications. Both power sources meet IP23 protection which means that they will operate in the most arduous environmental conditions experienced, in such places as shipyards or offshore yards. The machines have been designed so that all the sensitive components are enclosed in a compartment free from dust and separated from the air-flow needed to cool the machine. The PCB within the machines is completely encapsulated which will provide maximum protection from the elements. Both the CV-425 and CV-510 power sources are tested at +40°C and rated at 60% duty cycle. As a result of this rigorous testing and specifications, it allows these machines to operate and weld in any environment at a 100% duty cycle. Like all Lincoln machines the CV-425 and 510 are designed with the application in mind.

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• Superb arc behaviour with argon mix and 100% CO₂.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.
• Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
• Completed with an extensive set of features.
STICK WELDERS

www.lincolnelectriceurope.com

MIG FLUX-CORED WELDERS

ACCESSORY KITS

Interconnection cables
Fast-mate [x2], gas hose, protection, (2.5, 5, 10, 15, 20, 25 & 30 m)
Item n°:
• K10347-PG-xM
  (air cooled)
• K10347-PGW-xM
  (water cooled)

Kits
Item n°:
• K14049-1 A/V meter kit Powertec C
• K14073-1 A/V meter kit LF22m
• K14071-1 Kit grill Powertec C PRO
• K14071-2 Kit grill Powertec S
• K14071-1 Kit Polarity change Powertec 255C/305C

WATER COOLERS

COOL ARC® 25
Item n°:
K14037-1

Coolant ACOROX
[2x5l]
Item n°:
K10420-1

MIG GUNS

LINE GUN™ range
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a "rotating ball joint" at the end of the gun grip.

Air cooled guns
• LGS 150G, 150A @ 60%
  K10429-15-xM 3 m, 4 m or 5 m
• LGS 250G, 200A @ 60%
  K10429-25-xM 3 m, 4 m or 5 m
• LGS 360G, 300A @ 60%
  K10429-36-xM 3 m, 4 m or 5 m

Water cooled guns
• LGS 505W, 450A @ 100%
  K10429-505-xM 3 m, 4 m or 5 m

DRIVE ROLL KITS

2 rolls
• KP14016-0.8 0.6-0.8 mm – solid wire
• KP14016-1.0 0.8-1.0 mm – solid wire
• KP14016-1.2 1.0-1.2 mm – solid wire
• KP14016-1.1R 0.9-1.1 mm – cored wire
• KP14016-1.6R 1.2-1.6 mm – cored wire
• KP14016-1.2A 1.0-1.2 mm – aluminium wire

4 rolls
• KP14017-0.8 0.6-0.8 mm – solid wire
• KP14017-1.0 0.8-1.0 mm – solid wire
• KP14017-1.2 1.0-1.2 mm – solid wire
• KP14017-1.6 1.2-1.6 mm – solid wire
• KP14017-1.1R 0.9-1.1 mm – cored wire
• KP14017-1.6R 1.2-1.6 mm – cored wire
• KP14017-2.4R 1.6-2.4 mm – cored wire
• KP14017-1.6A 1.2-1.6 mm – aluminium wire
• KP14017-2.4A 2.4-2.4 mm – aluminium wire

ACCESSORY KITS

Interconnection cables
Fast-mate [x2], gas hose, protection, (2.5, 5, 10, 15, 20, 25 & 30 m)
Item n°:
• K10347-PG-xM
  (air cooled)
• K10347-PGW-xM
  (water cooled)

Kits
Item n°:
• K14049-1 A/V meter kit Powertec C
• K14073-1 A/V meter kit LF22m
• K14071-1 Kit grill Powertec C PRO
• K14071-2 Kit grill Powertec S
• K14071-1 Kit Polarity change Powertec 255C/305C

WATER COOLERS

COOL ARC® 25
Item n°:
K14037-1

Coolant ACOROX
[2x5l]
Item n°:
K10420-1

MIG GUNS

LINE GUN™ range
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a "rotating ball joint" at the end of the gun grip.

Air cooled guns
• LGS 150G, 150A @ 60%
  K10429-15-xM 3 m, 4 m or 5 m
• LGS 250G, 200A @ 60%
  K10429-25-xM 3 m, 4 m or 5 m
• LGS 360G, 300A @ 60%
  K10429-36-xM 3 m, 4 m or 5 m

Water cooled guns
• LGS 505W, 450A @ 100%
  K10429-505-xM 3 m, 4 m or 5 m

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2 rolls
• KP14016-0.8 0.6-0.8 mm – solid wire
• KP14016-1.0 0.8-1.0 mm – solid wire
• KP14016-1.2 1.0-1.2 mm – solid wire
• KP14016-1.1R 0.9-1.1 mm – cored wire
• KP14016-1.6R 1.2-1.6 mm – cored wire
• KP14016-1.2A 1.0-1.2 mm – aluminium wire

4 rolls
• KP14017-0.8 0.6-0.8 mm – solid wire
• KP14017-1.0 0.8-1.0 mm – solid wire
• KP14017-1.2 1.0-1.2 mm – solid wire
• KP14017-1.6 1.2-1.6 mm – solid wire
• KP14017-1.1R 0.9-1.1 mm – cored wire
• KP14017-1.6R 1.2-1.6 mm – cored wire
• KP14017-2.4R 1.6-2.4 mm – cored wire
• KP14017-1.6A 1.2-1.6 mm – aluminium wire
• KP14017-2.4A 2.4-2.4 mm – aluminium wire

Delivering on our commitments of welding expertise across a broad range of industry applications

From the most technologically demanding to the most basic application, we help our customer find the best, most economical and productive solutions to meet the productivity and quality requirements specific to their individual needs.
MULTI-PROCESS WELDERS
For Heavy Manufacturing and Fabrication
One Machine for Stick, TIG, Wire Welding and Arc Gouging
Ruggedly Built for Tough Environments
### Multi-Process Welders

<table>
<thead>
<tr>
<th>Compact Inverter</th>
<th>OUTPUT</th>
<th>INPUT</th>
<th>PROCESS</th>
<th>FEATURES</th>
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<tbody>
<tr>
<td>Speedtec® 180C</td>
<td>CV DC</td>
<td>20-200</td>
<td>230</td>
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<td>Speedtec® 215C</td>
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<td>5-425</td>
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<td>CC/CV DC</td>
<td>5-425</td>
<td>380/460/575</td>
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<td>CC/CV DC</td>
<td>10-815</td>
<td>380/460/575</td>
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<th>INPUT</th>
<th>PROCESS</th>
<th>FEATURES</th>
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<td>CC/CV DC</td>
<td>60-500</td>
<td>230/400</td>
<td>● ● ● ●</td>
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</table>

**KEY:** ● Excellent  ● Good  ▲ Possible
MULTI-PROCESS WELDERS

Speedtec® 180C
Speedtec® 200C
Speedtec® 215C NEW!

Many tasks, many locations

The SPEEDTEC® 180C, 200C & 215C are small but powerful single phase inverter based, multi-process machines. Lincoln Electric has constructed a fully professional machine packed with features, into a small light-weight compact housing maximising portability. These features make our range extremely versatile; they can be used for many different applications and can be easily moved around production facilities or transported to any location effortlessly. These units can be powered from the mains supply or are also suitable for use with motor generators. The SPEEDTEC® 180C, 200C & 215C units have been equipped with Power Factor Correction (PFC), a feature which supports high output welding current from a single phase 230V/1Ph 50/60Hz supply allowing it to be used with a long (up to max 100m) primary extension cable. With electronically designed welding waveforms Lincoln Electric offers these multi-process units for MIG, Stick or TIG modes; it’s just a question of choosing the right model. The SPEEDTEC® 180C, 200C & 215C are ready to tackle many different welding applications. The welding performance gives excellent results for Steel, Stainless Steel and Aluminium (using 200mm dia. spools). The SPEEDTEC® 180C, 200C & 215C machines work perfectly with mixed gas and 100% CO₂ also with self-shielding wires (Innershield).

Features
- Compact and Robust, Innovative, Portable and Lightweight, Anyplace, Anywhere.
- Multiple Tasks: Speedtec® 180C: CV MIG, FCW, Stick \ Speedtec® 200C/215C: CV MIG, CV Synergic, FCAW, Stick, Lift TIG.
- Power Factor Correction (PFC), More Welding Power, consumes 30% less energy than conventional equipment, Generator Compatible.
- User Friendly Operation: Icon control panel (Speedtec® 180C) Icon control colour TFT Interface screen (Speedtec® 200C/215C).
- Smart housing: 15kg spool capability, helpful shelves, 48% lower weight, compared to conventional MIG equipment (Speedtec® 215C).

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output (GMAW)</th>
<th>Fuse Size (A) (slow)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Speedtec® 180C</td>
<td>K14098-1</td>
<td>230V/1Ph</td>
<td>20-200</td>
<td>200A/20%</td>
<td>16</td>
<td>173</td>
<td>396 x 246 x 527</td>
<td>IP23</td>
</tr>
<tr>
<td>Speedtec® 200C</td>
<td>K14099-1</td>
<td>115/230V/1Ph</td>
<td>20-200</td>
<td>240A/25%</td>
<td>16</td>
<td>42.0</td>
<td>780 x 400 x 750</td>
<td></td>
</tr>
<tr>
<td>Speedtec® 215C</td>
<td>K14146-1</td>
<td>420V/1Ph</td>
<td>20-200</td>
<td>250A/30%</td>
<td>16</td>
<td>42.0</td>
<td>780 x 400 x 750</td>
<td></td>
</tr>
</tbody>
</table>

Processes
- Stick
- Flux-Cored
- Lift TIG
- MIG

Recommended Consumables
- Steel
- Ultramag®
- Flux-cored
- Innershield® NR® 211-MP
- Aluminium
- SuperGlaze®

Unit Includes
- Input cable
- Ground cable (3 m)
- Gas hose (2 m)
- Drive roll (0.8-1.0 mm)

Key Options
- KP14016-x Drive roll kit
- K10428-15-xM MIG gun LGS 150 G – 150A – 3/4/5 m
- K10429-25-xM MIG gun LGS 250 G – 200A – 3/4/5 m
- K10523-17-x TIG torch LTP 17 G – 140A – 4/6 m
- K14114-1 Cart ST/TPX (180C/200C)
- K14115-1 Tool box for Cart ST/TPX (180C/200C)
- E/H-200A-25-3M Electrode holder, 200A – 25 mm² – 3 m
- KIT-200A-25-3M Cable Kit 200A – 25 mm² – 3 m
- R-1019-125-08R Spool adapter for 5kg B300 (D15C)
- R-1019-125-10R Spool adapter for 5kg (D15C)

www.lincolnelectriceurope.com

rev. E-GMAW10-EN-17-10-16
Speedtec® 405S
Speedtec® 505S

High output, reliable industrial machine

The Speedtec® range is the solution for Industrial Multi-process applications. With modular and compact design this welding set is easy to move around site. Transport is trouble free thanks to the lower weight of this new design. With the latest high frequency inverter technology, the arc is precisely controlled, many times faster than conventional analogue power sources. The electrical characteristics of the welding power can be changed by software in real time updates. A wide range of synergic programs are available as standard allowing simple yet precise control of welding parameters for the best results every time. The Speedtec® machines utilise the very latest power source technology for efficiency and lower energy consumption. Their advanced Inverter technology will save both time as well as energy. Driven by Lincoln Electric’s Green Initiative, we aim to reduce the costs to you as well as the environment. These welding sets are available as 400A rated at 80% or 500A rated at 60% duty cycle (at 40°C). With the PF-46 wire feed unit the welding set can support the MIG processes with synergic programs for Steel, Stainless Steel, Aluminium and Flux cored wires. Lift TIG and Stick functions are available as standard.

Features
- Premium welding behaviour on CV MIG & Stick welding.
- Variable inductance control.
- Synergic capability.
- Job control with limits secured by a password (PF-46).
- Continuous control of wire feed Speed and voltage.
- Remote control on the gun (PF-46 & optional for PF-44).
- Pre-setting (PF-41 excl.) & Multi procedure (PF-46).

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Input Power</th>
<th>Output Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions (HxWxD) (mm)</th>
<th>Protection Class</th>
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</thead>
<tbody>
<tr>
<td>PF-41</td>
<td>KX4163-1</td>
<td>4</td>
<td>A/W</td>
<td>40V DC</td>
<td>500A (60%)</td>
<td>1.5-100</td>
<td>Solid: 1.2-1.4</td>
<td>1.7</td>
<td>460 x 300 x 640</td>
<td>IP23</td>
</tr>
<tr>
<td>PF-42</td>
<td>KX4107-1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Cored: 0.8-1.4</td>
<td>1.6</td>
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<td>PF-44</td>
<td>KX4108-1</td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1.8</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PF-46</td>
<td>KX4109-1</td>
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<td></td>
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<td></td>
<td></td>
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<td>18.5</td>
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Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Type &amp; Circuit Breaker Type</th>
<th>Weight (kg)</th>
<th>Dimensions (HxWxD) (mm)</th>
<th>Protection Class</th>
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<tbody>
<tr>
<td>Speedtec® 405S</td>
<td>KX4137-1</td>
<td>400V/50Ph</td>
<td>20-400A</td>
<td>400A/34V/80%</td>
<td>32A</td>
<td>50</td>
<td>515x300x635</td>
<td>IP23</td>
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<tr>
<td>Speedtec® 505S</td>
<td>KX4136-1</td>
<td>500V/50Ph</td>
<td>20-500A</td>
<td>500A/39V/60%</td>
<td>32A</td>
<td>50</td>
<td>515x300x635</td>
<td>IP23</td>
</tr>
</tbody>
</table>

Technical Specifications of Wire Feeders
Invertec® V350-PRO

Design smart, Built tough

The multi-process Invertec® V350 PRO is an efficient, lightweight and portable choice for training, fabrication or construction applications. Smart operation allows it to handle any stick, TIG and MIG applications. This CE model has full Amphenol connections and a remote control. Its plug-and-play intelligence allows it to automatically adjust to your wire feeder instantly.

Features
- Excellent welding behaviour on CV MIG and Stick Welding.
- Continuous control choke.
- Tough durable case with roll bars and skid.
- Bright, large digital meters.
- Control panel is simple in design and easy to operate.
- Its plug-and-play intelligence allows it to automatically adjust to your wire feeder instantly.
- Digital display for Wire feed speed and Voltage.
- Adjustable Pre and Post flow.
- Perfect feeding.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size [A]</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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</thead>
<tbody>
<tr>
<td>V350PRO</td>
<td>K1328-12</td>
<td>230V/400V/50Hz</td>
<td>6-425</td>
<td>275A/31V/100%-1Ph 300A/35V/60%-1Ph</td>
<td>63A</td>
<td>375</td>
<td>373 x 317 x 706</td>
<td>IP23 / F</td>
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</table>

Idealarc® DC-400

Simple DC multi-process welding

This heavy duty, industrial, three-phase, multi-process power source scores big in MIG, flux-cored, submerged arc, stick and DC TIG welding. It’s a great choice for arc gouging, too. Flexibility doesn’t mean that it’s complicated – the DC-400 is easy to set-up and use. Changeover between processes is as simple as turning the multi-process switch. On-board ammeter and voltmeter make monitoring of key welding parameters easy. Inductance and arc force controls allow the operator to efficiently refine the arc for the job in hand.

Features
- Standard Volt and Ammeter.
- Solid state circuitry for long life and repetitive welding applications.
- Arc control adjustment changes pinch effect of the arc to control spatter, fluidity and bead shape in the MIG Flux-Cored mode.
- Mode switch for selecting desired output characteristics.
- Outstanding welding performance with a single range full output control potentiometer.
- Low profile case allows stacking machines up to three high to conserve floor space.

Technical Specifications

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
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<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Idealarc® DC-400</td>
<td>K1309-17</td>
<td>230V/400V/50Hz</td>
<td>60-500</td>
<td>500A/40V/V100-1Ph 450A/80V/60%-1Ph 400A/60V/100%-1Ph</td>
<td>77/45</td>
<td>275</td>
<td>782 x 566 x 640</td>
<td>IP23 / F</td>
</tr>
</tbody>
</table>
Flextec® 350X CE
Rugged Multi-Process Power Sources for Maximum Flexibility

Out on the construction jobsite or in most fabrication shops, it pays to keep it simple. The Flextec® 350X multi-process welders are designed for that kind of environment. They are easy to setup and easy to operate, yet rugged and flexible enough to be used in construction, fabrication, shipbuilding and other heavy-duty applications.

Features
• Desert Duty Rated™ for extreme temperatures up to 65°C.
• VRO® Voltage Reduction Device reduces Open Circuit Voltage for added safety.
• Offered in 4 and 6 pack rack configurations.

• Wide 5-425 amperage range.
• Capable of arc gouging with 4.8 mm carbons.
• “X” = CrossLin™: you get voltage control at the feeder without an additional control cable.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50/60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A) Slow</th>
<th>Weight (kg)</th>
<th>Dimensions (mm)</th>
<th>Protection Class</th>
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<tbody>
<tr>
<td>Flextec® 350X standard</td>
<td>K4284-1</td>
<td>380/460/575/3Ph</td>
<td>5-425A</td>
<td>300A/225/200%</td>
<td>350A/400/240%</td>
<td>41.9</td>
<td>417</td>
<td>IP23</td>
</tr>
<tr>
<td>Flextec® 350X construction</td>
<td>K4283-1</td>
<td>380/460/575/3Ph</td>
<td>5-425A</td>
<td>350A/400/240%</td>
<td>350A/400/240%</td>
<td>417</td>
<td>477 x 356 x 673</td>
<td>IP23</td>
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</table>

Flextec® 650X
Flexible technology™

This multi-process welder delivers respectively up to 815A of welding power for a variety of applications, including construction and fabrication. It features an IP23 rating for outdoor operation and storage and the latest inverter technology will save you real money on the utility costs associated with your welding operations.

Features
• Flexible multi-process capability – including stick, Touch Start TIG® (DC), MIG, flux-cored welding and carbon arc gouging with up to a 9.5 mm and 12.7 mm carbon.
• CV submerged arc welding with all advantages and saves of the inverter technology is possible with Flextec 650X.
• The Future is Now™ – you no longer have to pay a premium price to gain the advantages of inverter technology over conventional welders. Faster arc response, low power consumption and enhanced portability.
• Bright digital amp and volt meters – easy to monitor, even in sunlight and presettable for precise procedure control.

• Compact, durable case – Tough IP23 enclosure rating ensures the Flextec™ 650X will withstand extreme field environments.
• Selectable Hot Start – turn it off for thin material or flip it on to get the extra starting amperage you need for thick, rusty or dirty material.
• Variable arc control – in stick mode, vary the arc force to obtain the “soft” or “crisp” arc you want as conditions require. In CV modes, vary the pinch or inductance to control spatter, fluidity and bead appearance.
• Desert Duty® rated – welding outputs are rated for extreme temperature operation up to 55°C.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Fuse Size (A) Slow</th>
<th>Weight (kg)</th>
<th>Dimensions (mm)</th>
<th>Protection/Insulation Class</th>
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<tbody>
<tr>
<td>Flextec® 650X</td>
<td>K3515-1</td>
<td>380/460/575/3Ph</td>
<td>10-815A</td>
<td>145A/300/700%</td>
<td>605/320/400%</td>
<td>54.8</td>
<td>454 x 175 x 745</td>
<td>IP23 / H</td>
</tr>
</tbody>
</table>
**Arc Tracker™**

**Portable, Powerful. Weld Performance Monitoring**

The ARC TRACKER™ is a high-performance, portable product designed to accurately measure the True Energy delivered into a weld from any welding machine (DC process only). The ARC TRACKER™ will accurately measure the welding parameters (arc voltage, arc current and weld time) and provide a real-time calculation of the True Energy into the weld. While welding, the True Energy [in joules (J)] for the weld will be accurately displayed on the user interface.

**Features**

- Advanced digital controls sample the welding parameters at extremely high speeds.
- Compatible with any DC welding process power source and wire feeder.
- Connect to any DC welding circuit, attach voltage sense leads and begin monitoring weld performance immediately.
- The Arc Tracker™ auto-senses any input voltage between 120 – 230 Volts AC.

- Communicates weld data status to your network via standard Ethernet.
- Easily calibrated for use in factory quality systems.
- Arc Tracker™ software tools are available at powerwavesoftware.com, including: - Power Wave® Manager - Production Monitoring™ - CheckPoint™.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Rated Output</th>
<th>Current Draw</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
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</thead>
<tbody>
<tr>
<td>Arc Tracker™</td>
<td>K3019-1</td>
<td>120-230/1Ph</td>
<td>1000A/44VDC/100%</td>
<td>0.8A @ 120VAC</td>
<td>9</td>
<td>305 x 220 x 380</td>
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</tbody>
</table>

**LACI**

**Lincoln ArcLink Communication Interface**

LACI is a module which allows to connect Speedtec®405/505 S/SP to any LAN network. Supported by Lincoln Electric software solutions: Power Wave Manager and Checkpoint – cloud based data management system, LACI enables machine to store important data (current, voltage, WFS, consumable usage, OEE, etc..) and monitor every detailed aspect of your welding process. This applies to single machine or all equipment that will be connected to the network. Collected information can be presented graphically online on any browser or exported to excel file to be stored locally.

**Features**

- Welding management: monitor each weld parameters on every machine.
- Online data collection: store your data in the cloud and access it through any browser.

- Diagnostics: machine status, alerts and errors, detailed hardware and software information.
- Software update and machine parameters setup accessible remotely or locally.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Data transfer</th>
<th>Conformance</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
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</thead>
<tbody>
<tr>
<td>LACI</td>
<td>K34130-1</td>
<td>Ethernet</td>
<td>EN60974-10:2007, RoHS</td>
<td>0.4</td>
<td>170 x 140 x 75</td>
</tr>
</tbody>
</table>
ACCESSORY KITS

**Cable kits (ground / electrode)**
with ground cable & electrode holder (clamp)
Item n°:

For Speedtec 180C/200C
- KIT-200A-25-3M
  (200A – 25 mm² – 3 m)

For DC400
- KIT-400A-70-5M
  (400A – 70 mm² – 5 m)

**Cable kits (ground)**
For V350-PRO & DC400
Item n°:

- GRD-400A-70-10M
  (400A – 70 mm² – 10 m)

- GRD-400A-70-15M
  (400A – 70 mm² – 15 m)

For Speedtec 180C & 200C
- K14010-1

**Interconnection cables**
Fast-mate (x2), gas hose, protection,
(2, 5, 10, 15, 20, 25 & 30 m)
Item n°:

For V350-PRO
- K10347-PG-xM (air cooled)
- K10347-PGW-xM (water cooled)

For Speedtec 405S & 505S
- K10349-PG-xM (air cooled)
- K10349-PGW-xM (water cooled)

**MIG GUNS**

**LINC GUN™ range**
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a “rotating ball joint” at the end of the gun grip.

**Air cooled guns**
- LGS 150G, 150A @ 60%
  K10429-15-xM 3 m, 4 m or 5 m
- LGS 250G, 200A @ 60%
  K10429-25-xM 3 m, 4 m or 5 m
- LGS 360G, 300A @ 60%
  K10429-36-xM 3 m, 4 m or 5 m

**Water cooled guns**
- LGS 505W, 450A @ 100%
  K10429-505-xM 3 m, 4 m or 5 m

**WATER COOLERS**

**COOL ARC® 46**
For Speedtec 405S & 505S
Item n°:
- K14105-1

**Coolant ACOROX**
(2x5 l)
Item n°:
- K10420-1

**UNDERCARRIAGE**
Rear-wheeled cart with front casters and single gas bottle platform. Convenient handles allow for easy cable storage. Small footprint fits through 762 mm door. For use with Flextec 350X/650X.
Item n°:
- K3059-4

**REMOTE CONTROLS**
1 potentiometer, 6-pins, 15 m
Item n°: K10095-1-15M

**Extension cable**
Item n°: K10398
ADVANCED-PROCESS WELDERS

A Wide Variety of Welding Waveforms for Every Application
Fast, Reliable Digital Communication
Multi-Process Welding on a Variety of Materials
## Advanced Process Welders

**Speedtec® 405SP, 505SP — Pulse**
High output, reliable industrial machine

**Invertec® STT® II**
Featuring Surface Tension Transfer® process

**Power Wave® C300**
Portable Flexibility

---

**Power Wave® S350 CE, S500 CE**
Pulsed perfection, Modular flexibility

**Power Wave® STT® Module**
Add STT® Process Capability

**Power Wave® Advanced Module**
Add STT, AC and TIG HF Process Capability

---

### Inverter Power Source

<table>
<thead>
<tr>
<th>MODE</th>
<th>POLARITY</th>
<th>OUTPUT RANGE [Amps]</th>
<th>VOLTAGE (V)</th>
<th>STICK</th>
<th>TIG</th>
<th>MIG</th>
<th>MIG STT</th>
<th>MIG Pulse</th>
<th>Flux-cored</th>
<th>Gouging</th>
<th>WAVEFORM CONTROL TECHNOLOGY®</th>
<th>ARC LINK® DIGITAL COMMUNICATIONS</th>
<th>WARRANTY (YEARS)</th>
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</thead>
<tbody>
<tr>
<td>Speedtec® 405SP</td>
<td>CC/CV DC</td>
<td>20-400</td>
<td>400</td>
<td>● ● ●</td>
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<td>■ ■</td>
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<tr>
<td>Speedtec® 505SP</td>
<td>C/CV DC</td>
<td>20-500</td>
<td>200/220/380/400/440</td>
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<tr>
<td>Invertec® STT® II</td>
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<td>230/400</td>
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<tr>
<td>Power Wave® C300</td>
<td>CC/CV AC/DC</td>
<td>5-500</td>
<td>230/380/415/460/575</td>
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<td>▲</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>▲</td>
<td>●</td>
<td>■ ■</td>
<td>■ ■</td>
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</tr>
<tr>
<td>Power Wave® S350</td>
<td>CC/CV AC/DC</td>
<td>5-350</td>
<td>40V DC</td>
<td>● ● ●</td>
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<td>■ ■</td>
<td>■ ■</td>
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</tr>
<tr>
<td>Power Wave® S500</td>
<td>CC/CV AC/DC</td>
<td>5-500</td>
<td></td>
<td>● ● ●</td>
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<td>●</td>
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</table>

### Advanced Module

<table>
<thead>
<tr>
<th>MODE</th>
<th>POLARITY</th>
<th>OUTPUT RANGE [Amps]</th>
<th>VOLTAGE (V)</th>
<th>STICK</th>
<th>AC/DC, Pulse, HF</th>
<th>MIG</th>
<th>MIG STT</th>
<th>MIG AC Pulse</th>
<th>Flux-cored</th>
<th>Gouging</th>
<th>WAVEFORM CONTROL TECHNOLOGY®</th>
<th>ARC LINK® DIGITAL COMMUNICATIONS</th>
<th>WARRANTY (YEARS)</th>
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<tbody>
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<td>Power Wave® STT® Module</td>
<td>STT DC</td>
<td>5-550</td>
<td>40V DC</td>
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<td>●</td>
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<td>5-350</td>
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<td>■ ■</td>
<td>■ ■</td>
<td>3</td>
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</tbody>
</table>

**KEY:**
- ● Excellent
- ● Good
- ▲ Possible
Speedtec® 405SP – Pulse
Speedtec® 505SP – Pulse
High output, reliable industrial machine

The Speedtec® range is the solution for Industrial Multi-process applications. With modular and compact design this welding set is easy to move around site. Transport is trouble free thanks to the lower weight of this new design. With the latest high frequency inverter technology, the arc is precisely controlled, many times faster than conventional analogue power sources. The electrical characteristics of the welding power can be changed by software in real time updates. A wide range of synergic programs are available as standard allowing simple yet precise control of welding parameters for the best results every time. The Speedtec® machines utilise the very latest power source technology for efficiency and lower energy consumption. Their advanced Inverter technology will save both time as well as energy. Driven by Lincoln Electric’s Green Initiative, we aim to reduce the costs to you as well as the environment.

These welding sets are available as 400A rated at 80% or 500A rated at 50% duty cycle (at 40°C). With the PF-46 wire feed unit the welding set can support the MIG processes with synergic programs for Steel, Stainless Steel, Aluminium and Flux cored wires. Lift TIG and Stick functions are available as standard.

Features
- Pulsed MIG process-great for low spatter, low heat input and out-of-position applications-makes virtually any operator a better welder!
- Premium welding behaviour on CV MIG & Stick welding.
- Variable inductance control.
- Synergic capability.
- Job control with limits secured by a password (PF-46).
- Continuous control of wire feed speed and voltage.
- Remote control on the gun (PF-46 & optional for PF-44).
- Pre-setting (PF-41 excl.) & Multi procedure (PF-46).

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage 50-60Hz</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Type [60% or Circuit Breaker Type 2]</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Speedtec® 405SP (Pulse)</td>
<td>K14117-2</td>
<td>400V/50 Hz</td>
<td>20-400A</td>
<td>400A/4W/80%</td>
<td>32A</td>
<td>30</td>
<td>175 x 300 x 635</td>
<td>IP23</td>
</tr>
<tr>
<td>Speedtec® 505SP (Pulse)</td>
<td>K14116-2</td>
<td>20-500A</td>
<td>500A/39V/50%</td>
<td>32A</td>
<td>30</td>
<td>175 x 300 x 635</td>
<td>IP23</td>
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</tbody>
</table>

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Input Power</th>
<th>Output Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
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<tbody>
<tr>
<td>PF-41</td>
<td>K14163-1</td>
<td>4</td>
<td>A/W</td>
<td>40V DC</td>
<td>500A@60%</td>
<td>1.0-22</td>
<td>0.8-1.6/1.0-1.6</td>
<td>17</td>
<td>17</td>
</tr>
<tr>
<td>PF-42</td>
<td>K14107-1</td>
<td>18</td>
<td>G</td>
<td>40V DC</td>
<td>500A@60%</td>
<td>1.0-22</td>
<td>0.8-1.6/1.0-1.6</td>
<td>18</td>
<td>18</td>
</tr>
<tr>
<td>PF-44</td>
<td>K14108-1</td>
<td>18.5</td>
<td>G</td>
<td>40V DC</td>
<td>500A@60%</td>
<td>1.0-22</td>
<td>0.8-1.6/1.0-1.6</td>
<td>18</td>
<td>18.5</td>
</tr>
</tbody>
</table>

www.lincolnelectriceurope.com
Invertec® STT® II
Featuring Surface Tension Transfer® process

The revolutionary STT® II power source combines high frequency inverter technology with advanced Waveform Control® to provide a better welding solution than traditional short arc MIG.

Features
- Controlled penetration and outstanding heat input control – ideal for welding joints with open root, gaps, or on thin material with no burnthrough.
- Reduced spatter and fumes – current is controlled to achieve optimal metal transfer.
- Various shielding gases – blends of Argon including Helium or 100% CO₂ with larger diameter wires.
- Good bead control and faster travel speeds – can replace TIG in many applications.
- Background and Tailout Current – accurately control fine and coarse heat input for reduced distortion and burnthrough as well as proper penetration.
- Adjustable Hot Start controls the heat at the start of the weld.
- Fully featured; the LF 33 features 2/4 stoke, burnback, gas purge, cold inch, run in.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage [50-60Hz]</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size [A (slow)]</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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<tbody>
<tr>
<td>STT II</td>
<td>K10429-3</td>
<td>200/220/380/400/440/5Ph</td>
<td>5-90 (peak)</td>
<td>225A/29/60%</td>
<td>200A/28/100%</td>
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<td>59</td>
<td>IP23 / H</td>
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<tr>
<td>STT II Package</td>
<td>PSTT2-1-A</td>
<td>200/220/380/400/440/5Ph</td>
<td>5-90 (peak)</td>
<td>225A/29/60%</td>
<td>200A/28/100%</td>
<td>12</td>
<td>59</td>
<td>IP23 / H</td>
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<tr>
<td>STT II</td>
<td>K10429-4</td>
<td>400V/3Ph</td>
<td>5-90 (peak)</td>
<td>225A/29/60%</td>
<td>200A/28/100%</td>
<td>12</td>
<td>59</td>
<td>IP23 / H</td>
</tr>
</tbody>
</table>

Power Wave® C300
Portable Flexibility

The Power Wave® C300 is a part of a modular concept offering many different configurations and allowing to adjust the machine to your welding application. All Power Waves® come complete with an Ethernet connection and free software. Free software updates available on www.powersoftware.com

Features
- Superb arc welding characteristics in Pulse, Pulse on-Pulse®, CV, Stick and TIG DC.
- A variety of materials are supported as standard: Steel, Stainless, Aluminium but also High Nickel and CuSi.
- RapidArc® for a higher travel speed and less Heat Input with steel and Stainless.
- PowerMode® reduces spatter and improves appearance even of low voltage applications on steel & stainless steel, also beneficial for high deposition on aluminium.
- S2F for premium Aluminium welding.
- Clearing Pulse providing a clean wire tip without a ball, ready to restart.
- Job control to store your settings and quick recall.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage [50-60Hz]</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Fuse Size [A (slow)]</th>
<th>Weight [kg]</th>
<th>Dimensions HxWxD (mm)</th>
<th>Protection/Insulation Class</th>
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</thead>
<tbody>
<tr>
<td>Power Wave® C300</td>
<td>K2865-1</td>
<td>230/400/575 (Ph) 230/400/575 (V)</td>
<td>5-300</td>
<td>300A/200/140%</td>
<td>4025</td>
<td>50.4</td>
<td>478 x 356 x 610</td>
<td>IP23 / H</td>
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</table>
Power Wave® S350 CE
Power Wave® S500 CE

Pulsed perfection, Modular flexibility

The Power Wave S350 and S500 are part of a new modular concept from Lincoln Electric; designed to offer a multitude of different set-up configurations, these machines can be tailored easily yet precisely to your welding application. The new platforms all communicate via Arclink allowing seamless connection with all of Lincoln’s digital Feeders from the PF-4X to PF-84. All Power Waves® come complete with an Ethernet connection. You can get access to the machine by using this connection and our free software. Updates are free of charge; our website powerwavesoftware.com contains the latest version of software including weld modes.

Features
- Superb arc welding characteristics in Pulse, Pulse on-Pulse®, CV, Stick and TIG DC.
- A variety of materials are supported; Steel, Stainless, Aluminium but also High Nickel and CuSi.
- RapidArc®, & Rapid X™ for a higher travel speed and less Heat Input with Steel and Stainless.
- PowerMode® reduces spatter and improves appearance even of low voltage applications on steel & stainless steel, also beneficial for high deposition on aluminium.
- S2F for premium Aluminium welding.
- Clearing Pulse providing a clean wire tip without a ball, ready to restart.
- STT module is available transforming the machine into a STTPulse welding machine.
- Water Cooled when combined with the COOL ARC® 50 water cooler.

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Input Power</th>
<th>Output Power</th>
<th>Wire Size Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
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</thead>
<tbody>
<tr>
<td>PF-41</td>
<td>K14163-1</td>
<td>4</td>
<td>A/W</td>
<td>40V DC</td>
<td>500A@60%</td>
<td>1.0-22</td>
<td>0.8-1.6</td>
<td>17</td>
<td>460 x 300 x 640</td>
</tr>
<tr>
<td>PF-42</td>
<td>K14107-1</td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>PF-44</td>
<td>K14108-1</td>
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<td></td>
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<td>18.5</td>
<td></td>
</tr>
<tr>
<td>PF-46</td>
<td>K14109-1</td>
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Technical Specifications of Wire Feeders

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<tr>
<th>Product</th>
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<td>PF-42</td>
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<td>18</td>
<td></td>
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<tr>
<td>PF-44</td>
<td>K14108-1</td>
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<td></td>
<td></td>
<td>18.5</td>
<td></td>
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<tr>
<td>PF-46</td>
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</tr>
</tbody>
</table>

www.lincolnelectriceurope.com
Power Wave® STT® Module
Power Wave® Advanced Module
Add STT® / AC and TIG HF Process Capability

Power Wave® STT® Module adds STT® (Surface Tension Transfer®) process capability to any compatible Power Wave® S-Series and R-Series power source to gain outstanding puddle control for critical sheet metal or pipe root pass welding standard. Power Wave® Advanced Module adds Power Wave® STT® Module adds STT® process capability to any compatible Power Wave® S-Series and R-Series power source to gain outstanding performance for aluminium welding. Advanced Module allows STT® process as well.

Features
- Exceptional Arc Control.
- UltimArc® – in synergic modes, it dynamically and simultaneously controls all heat input / arc parameters together. The result is easy procedure setting for the operator.
- Modular Design – allows easy connection and fast digital ArcLink® communication with compatible S-Series Power Wave® power sources, Power Feed® wire feeders and water coolers.
- Add STT® / AC and TIG capability without having to purchase a second power source.
- Feed® wire feeders and water coolers.
- S-Series Power Wave® power sources, Power digital ArcLink® communication with compatible (2.5, 5, 10, 15, 20, 25 & 30 m)
- Fast-mate (x2), gas hose, protection, & Power Wave Cable kits (ground)
- Item n°: For Power Wave LINC GUN range indulge in synergic modes, it dynamically and simultaneously controls all heat input / arc parameters together. The result is easy procedure setting for the operator.
- Item n°: For STT II
drive for automated welding operation. The kit allows DeviceNet™ connectivity to control the power source. Includes internal harness and 5-pin DeviceNet™ receptacle for connectivity to control the power source. Includes internal harness and 5-pin DeviceNet™ receptacle for controlling the power source directly below Lincoln S-Series Power Wave® models, without taking valuable floor space.
- Self-Protecting Circuits – the module will protect itself from the excessive transient voltages associated with highly inductive weld circuits.
- Compact Footprint – securely connects directly below Lincoln S-Series Power Wave® models, without taking valuable floor space.
- Self-Protecting Circuits – the module will protect itself from the excessive transient voltages associated with highly inductive weld circuits.
- Recommended Packages Include
  - PF-2X, 8X (Advanced Module)
  - Power Wave® Power source, input cable, work clamp and cable assembly + COOLARC® 50 for water cooled version
  - 5m-Interconnection cable, MIG gun, Tig torch (Advanced Module) and gas regulator
- Key Options Advanced Module
  - K14096-1
  - K14105-1

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Voltage</th>
<th>Rated Output</th>
<th>Weight [kg]</th>
<th>Dimensions [HxWxD (mm)]</th>
<th>Protection Class</th>
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</thead>
<tbody>
<tr>
<td>Power Wave® STT® Module</td>
<td>K2921-1</td>
<td>40V DC</td>
<td>500A/60%</td>
<td>21.3</td>
<td>292 x 353 x 630</td>
<td>IP23</td>
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<td>Power Wave Advanced Module</td>
<td>K2912-1</td>
<td>40V DC</td>
<td>350A/40%</td>
<td>32</td>
<td>292 x 353 x 630</td>
<td>IP23</td>
</tr>
</tbody>
</table>

MIG GUNS
LINCN Gun range
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a "rotating ball joint" at the end of the gun grip.

Air cooled guns
- LGS 150G, 150A @ 60% K10429-15-xM 3m, 4m or 5m
- LGS 250G, 200A @ 60% K10429-25-xM 3m, 4m or 5m
- LGS 360G, 300A @ 60% K10429-36-xM 3m, 4m or 5m

Water cooled guns
- LGS 505W, 450A @ 100% K10429-505-xM 3m, 4m or 5m

WATER COOLERS
COOL ARC® 50
For PW C300 / S350 / S500
Item n°: K14050-1

COOL ARC® 46
For Speedtec 405SP & 505SP
For V150-PRO & DC400
Item n°: K14105-1

COOLANT ACORAX
(2x5l)
Item n°: K10420-1

UNDERCARRIAGES
- Undercarriage with gas cylinder platform, delivered as a kit, for use with Power Wave Bottle platform. Convenient handles allow for easy operation.
- Undercarriage with gas cylinder platform, delivered as a kit, for use with PW 3530/500
Item n°: K14085-1

- Rear-wheel cart with front casters and single gas bottle platform. Convenient handles allow for easy operation.
- Rear-wheel cart with front casters and single gas bottle platform. Convenient handles allow for easy operation.
- Rear-wheel cart with front casters and single gas bottle platform. Convenient handles allow for easy operation.
POWER WAVE® SOFTWARE SOLUTIONS
Power Wave® Manager – CheckPoint™ – WeldScore™
– PowerWaveSoftware.com
Power Wave® Software Solutions

**Power Wave® Manager**
Control Your Process
- All the information and settings necessary for welding and procedure control.

**CheckPoint™**
Weld Data Anywhere
- Store your data in the cloud and access it on almost any device.

**WeldScore™**
Enhance Your Product Quality
- An integrated weld quality system that can assist quality assurance initiatives.

www.PowerWaveSoftware.com
Upgrade your Power Wave® Power Source Software for FREE
- Get access to the best welding solutions in the industry.

**Power Wave® Software allows you to:**
- Manage – Monitor welding projects across the world.
- Analyze – Review welding information in real time.
- Control Cost – Track and cost wire consumption.
- Process Control – Create unique names and set welding limits for each application.
- Adjust – Change welding variable limits.

**Power Wave® Software:**
- Increases productivity and product quality
- Reduces operational costs
- Costs you nothing!
- Is available in multiple languages

**Why use Power Wave® software solutions?**
- **Monitor operations remotely** – View real time information from any networked welding station in any plant.
- **Name memory settings using text fields** – Customize memory names with Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), or other pertinent information.
- **Store settings to be used at a later time** – Backup and Restore tools can save and restore all welding settings from previous jobs.
- **Install and configure CheckPoint™ right from the application.**
- **Analyze welding operations offline** – Snapshot and WeldView™ functionalities allow quick and easy diagnostics of welding equipment.
- **Evaluate your power source** – Check the calibration, welding cable condition and other operational settings from your computer.
Power Wave® Manager

System Status

Check the status of every component in your welding system.

Setup/Security Settings

View and easily adjust the information associated with your welding operation.

User Interface

Customize the name of your memory settings to match Welding Procedure Specification (WPS) or Procedure Qualification Record (PQR) number, or any other identifier, for easy retrieval at a later date.

Backup/Restore

Backup – save all the settings associated with a specific configuration to your hard drive.

Restore – open any previously saved configuration and those settings are uploaded to your welder.
CheckPoint™
Store your weld data in the cloud and access it on almost any device.

Benefits
- **No Software Hassles:** No software to buy, install or upgrade with the standard edition. Upgrades are automatic and instantaneous.
- **Easy to Activate:** Minimal or no IT investment required; just connect the welder to the internet and you are ready to go.
- **Easy to Use:** Log in anywhere at any time to view welder status and much more.
- **Mobile Device Compatibility:** View on Smart phones, tablets, laptops or desktops with any browser.
- **Graphical Interface:** View data in an intuitive dashboard view that provides a Pulse™ on your welding operations at a glance.
- **Security You Can Count On:** Your data is protected with physical security, encryption, user authentication and more.
- **Data Aggregation:** With a global view of all of your welding equipment, you can benchmark your facilities.
- **Exporting:** Export data and reports in various formats for offline analysis.

**Traceability Scanning:**
Use the CheckPoint™ mobile app to scan barcodes for operator, consumable ID and part serial numbers. All scans are correlated with the weld data transmitted by the welder. Includes Bluetooth integration for industrial barcode scanners.

**Simple System Management**
Determine who is authorized to view the data, analysis, documents and manuals specific to each welder through desktop and mobile devices.

**Cloud API:**
Using the industry standard protocol OData, CheckPoint™ delivers secure access to data by enterprise ERP systems, plant OEE systems, and maintenance applications.

**Alerts**
Receive email notifications based on equipment conditions and wire consumption.

**Production Monitoring**
View live status of each welder and weld details.

**Traceability**
Satisfy reporting requirements by capturing audit trail data.
CheckPoint™ Production Dashboard

View data for each station or entire facility in a user-friendly dashboard view. The Dashboard includes charts and graphs by day, week and other periods for a selection of user-determined criteria.

Data Aggregation

View a production summary of your entire welding operation. Roll up data from all welders or drill down to identify operational bottlenecks.

Weld Profiles

View key welder metrics such as WeldScore™, True Energy™, Wire Feed Speed, Current/Voltage and Wire Deposition organized by weld profile. Compare usage rates and time remaining for welding wire at each station.

Lincoln Electric Q-Cert™ Linkage

Use the mobile app to scan a Lincoln Q1 or Q2 consumable lot number and the lot number is correlated to the weld data. This direct link between the weld and the consumable certificate provides an automatic, retrievable record for corporate quality systems.
WeldScore™

Allows you to score each weld based on a trained sample of acceptable welds.

Great for:
- Expanding Quality Control Capabilities
- Trade School Monitoring, Grading and Final Examinations
- Critical Welds with Specific Quality Control Requirements
- Operator Testing and Certification Programs

Benefits
- WeldScore™ is a unique patent pending data monitoring system based on 30 to 50 internal control variables.
- Fundamentally different from data monitoring systems that only use voltage and amperage feedback.
- Higher detection reliability achieved with data collection speed of 120 kHz and embedded knowledge of the welding control system.
- Allows you to score each weld based on your trained definition of the acceptable conditions.
- Multi-parameter statistical analysis specifically designed for consistent and reliable results.

Acceptable Weld – Proper gas flow and coverage produces a good weld with no porosity.

Example-Low Gas Flow
Unacceptable Weld – Low gas flow results in obvious porosity.

Example-Shielding Gas Mix Change
Unacceptable Weld – Incorrect gas mix yields higher spatter levels.

Example-Low Gas Flow
Good Appearance / Internal Porosity – The weld appears good. However, a cross section of the weld reveals pin holes and hidden porosity under the surface due to low gas flow or gas coverage.

Example-Shielding Gas Mix Change
Good Appearance / Inadequate Penetration – The weld appearance is good with minimal spatter. However, a cross section of the weld reveals poor penetration due to an incorrect gas type.

WeldScore™ Example

Closely matches “trained” sample weld, resulting in a 99% score.
SEMI AUTOMATIC WIRE FEEDERS
Built Tough for Rough Environments
Reliable Feeding and Durability
Easy to Understand User Interface
### Semiautomatic Wire Feeders

#### Analog

<table>
<thead>
<tr>
<th>Features</th>
<th>Wire Feed Speed Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Warranty (years)</th>
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<td><strong>Linc Feed 22M</strong></td>
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<td>A</td>
<td>3</td>
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<td>0.8-1.6</td>
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<td>A/W</td>
<td>3</td>
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<td><strong>Linc Feed 24M PRO</strong></td>
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<td>1.0-2.4</td>
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#### Digital

<table>
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<tr>
<th>Features</th>
<th>Wire Feed Speed Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Warranty (years)</th>
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<tbody>
<tr>
<td><strong>Power Feed® 22</strong></td>
<td>1.0-22</td>
<td>0.8-2.4</td>
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<td>A/W</td>
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<td><strong>Power Feed® 26</strong></td>
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<td><strong>Power Feed® 41</strong></td>
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<td><strong>Power Feed® 42</strong></td>
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<tr>
<td><strong>Power Feed® 44</strong></td>
<td>1.0-20</td>
<td>0.8-1.6</td>
<td>3</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td><strong>Power Feed® 46</strong></td>
<td>1.0-20</td>
<td>0.8-1.6</td>
<td>3</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td><strong>Power Feed® 84</strong></td>
<td>2.0-30</td>
<td>0.6-1.6 (high speed)</td>
<td>3</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Power Feed® 84 Dual</strong></td>
<td>0.6-2.4 (low speed)</td>
<td>3</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Power Feed® 25M</strong></td>
<td>1.3-20.3</td>
<td>0.6-1.6</td>
<td>2</td>
<td>A</td>
<td>3</td>
</tr>
</tbody>
</table>

#### Field

<table>
<thead>
<tr>
<th>Features</th>
<th>Wire Feed Speed Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Warranty (years)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>LN-23 P</strong></td>
<td>0.76-6.7</td>
<td>-</td>
<td>1.7-2.0</td>
<td>A</td>
<td>3</td>
</tr>
<tr>
<td><strong>LN-25 Pro</strong></td>
<td>1.3-177</td>
<td>0.6-1.6</td>
<td>8.2-2.0</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td><strong>LN-25X</strong></td>
<td>1.3-177</td>
<td>0.6-1.6</td>
<td>8.2-2.0</td>
<td>3</td>
<td></td>
</tr>
</tbody>
</table>

**KEY:** ● Excellent  ● Good  ▲ Possible

---

Power Feed® 22, 26
- Portable construction digital wire feeders

Power Feed® 25M
- Premium feeders, portable design

Power Feed® 41, 42, 44, 46
- Designed to work with digital power sources

Power Feed® 84 Single & Dual
- Single and dual bench/boom wire feeders

LN-25 Pro & Dual Pro
- Full control with no control cables

LN-25X
- Built for the job
Features
• Continuous control of wire feed speed.
• Synergic control to support easy control by the welder
• Gas preflow improves the protection of the bead before arc ignition.

Technical Specifications of Wire Feeders

Linc Feed 322M, 24M & 24M PRO
Small, robust, flexible & complete

The LF-22M, LF-24M and LF-24M Pro are portable wire feeders with stabilised wire feed speed. They include a rugged 2 or 4 roll wire feed unit, featuring cold inch, gas purge and built-in burn back facility. They can be mounted on the power source with a swivelling, wheeled carriage.

The base unit features:
- Bright digital Volt and Ammeter (optional for LF22M).
- Delivered mounted on an undercarriage.
- Stabilised wire drive system for constant control of wire feed speed.
- Gas purge to strike the arc with full shielding.
- Cold inch control used to feed the wire into the torch.
- Trigger mode selection for standard 2-steps or interlocking 4-steps.
- Burnback preventing the wire sticking in the weld pool.
- Gas purge to strike the arc with full shielding.
- Cold inch control used to feed the wire into the torch.
- Stabilised wire drive system for constant control of wire feed speed.
- Delivered mounted on an undercarriage.
- Bright digital Volt and Ammeter (optional for LF22M).
- Run in to support perfect starting (except for LF22M) + for the LF24M PRO

Synergic control to support easy control by the welder
Gas preflow improves the protection of the bead before arc ignition.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Rated Output</th>
<th>Input Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions (HxWxD (mm))</th>
</tr>
</thead>
<tbody>
<tr>
<td>LF-22M</td>
<td>K14064-1</td>
<td>2</td>
<td>A</td>
<td>50A/60%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0-1.6</td>
<td>15</td>
<td>440 x 275 x 636</td>
</tr>
<tr>
<td>LF-24M</td>
<td>K14065-1W</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0-1.6</td>
<td>17</td>
<td>440 x 275 x 636</td>
</tr>
<tr>
<td>LF-24M PRO</td>
<td>K14066-1W</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0-1.6</td>
<td>17</td>
<td>440 x 275 x 636</td>
</tr>
</tbody>
</table>

Linc Feed 33S & 33
Small, robust, flexible & complete

The LF33S and 33 are wire feeders designed to withstand extreme environmental conditions. With these feeders, there is a focus on ruggedness construction, physical dimensions and ease of use. The result is an incredibly rugged, protective casing as standard complete with undercarriage for use under tough industrial conditions. The feeders are able to accept not only D300 (15 kg), but also small D200 (5 kg) wire spools, using solid or cored wire including Innershield. The entry level LF33 is equipped with 2/4-step, run-in, wire inch and gas purge. Two clear digital meters display the welding voltage and amperage.

Features
• Small, rugged and easy to handle feeder with bright digital voltage and ammeter.
• All drives are equipped with an excellent wire drive system with four large drive rolls and powerful motor.
• Electronic feedback system on the wire drive will guarantee consistent wire feed speed.

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Rated Output</th>
<th>Input Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions (HxWxD (mm))</th>
</tr>
</thead>
<tbody>
<tr>
<td>LF-33S</td>
<td>K14050-1</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0 – 2.4</td>
<td>12</td>
<td>350 x 195 x 510</td>
</tr>
<tr>
<td>LF-33</td>
<td>K14030-1</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0 – 2.4</td>
<td>17</td>
<td>460 x 270 x 636</td>
</tr>
<tr>
<td>LF-33S</td>
<td>K14050-1</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0 – 2.4</td>
<td>12</td>
<td>350 x 195 x 510</td>
</tr>
<tr>
<td>LF-33</td>
<td>K14030-1</td>
<td>4</td>
<td>A/W</td>
<td>60A/80%</td>
<td>1-20</td>
<td>0.8-1.6</td>
<td>1.0 – 2.4</td>
<td>17</td>
<td>460 x 270 x 636</td>
</tr>
</tbody>
</table>

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rev.: E-WF02-EN-27-12-17
Power Feed® 22, 26
Portable construction digital wire feeders

Power Feed® 22 and Power Feed® 26 are new semiautomatic portable construction and digital wire feeders which support all multi-process and advanced digital (ArcLink®) Lincoln Power Sources. These are ideal for field construction and fabrication, shipbuilding and pipeline applications. A Polycarbonate flame resistant case ensures that the Power Feed® 22 & Power Feed® 26 has a lightweight and compact design, allowing them to be carried to remote or difficult to reach welding applications.

Power Feed® 22 is equipped with bright digital meters (visible pre-setted and actual values), trim function, mode selector and main starting/lending functions. It has 8 programs with quick access: 4 fixed as a welding process (GMAW, FCAW-GS, SMAW, GTAW) plus 4 which can be changed and assigned to one of four user memories.

Top class Power Feed® 26 utilizes TFT colour display with intuitive icon language and variety of special functions. Enables connection of push-pull gun allows you great performance on aluminium. Power Feed® 26 combines all functions with USB connection, dual procedure, memory and limits.

Features
• Standard dual procedure allows operator to set different voltage and wire feed speeds and switch between the two.
• Tough Plastic Case: Polycarbonate flame resistant case ensures a lightweight and compact design, allowing them to be carried to remote or difficult to reach welding applications.
• Top class wire drive system: A new four-roll driven wire feeding system is easily accessible ensuring increased efficiency and providing reliability in feeding various types of wires especially with aluminium wires.
• Hardened and Construction Ready: Ideal for use for general fabrication, in shipyards, on-site or with long interconnection cables.
• User Interface: LED’s with bright digital meters for PF22 and TFT color with innovative icon language for easy operation for PF-26.
• Hot/Soft start Crater Run and all standard features (PF-26).
• Internal Lighting: High intensity LEDs illuminate the wire drive.
• Fully encapsulated case protects feeders’ components as well as the welding wire from external contaminates.

Technical Specifications Standard Wire Feeders

<table>
<thead>
<tr>
<th>Power Feed</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Input Power</th>
<th>Output Power</th>
<th>WFS Range (v/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PF-22</td>
<td>K14110-1</td>
<td>4</td>
<td>A/W</td>
<td>40A/DC</td>
<td>150A @ 50%</td>
<td>1.0-2.2</td>
<td>0.8-2.4</td>
<td>1.0-2.4</td>
<td>14.8 x 13.2 x 560</td>
</tr>
<tr>
<td>PF-26</td>
<td>K14138-1</td>
<td>4</td>
<td>A/W</td>
<td>40A/DC</td>
<td>150A @ 50%</td>
<td>1.0-2.2</td>
<td>0.8-2.4</td>
<td>1.0-2.4</td>
<td>14.8 x 13.2 x 560</td>
</tr>
</tbody>
</table>

Functions & Features

<table>
<thead>
<tr>
<th>Power Feed</th>
<th>User Interface</th>
<th>Graphic Display</th>
<th>Standard Controls</th>
<th>Meters Digital</th>
<th>Crater</th>
<th>Hot/Soft Start</th>
<th>Pre-settings</th>
<th>Synergic</th>
<th>Memory/ Limits</th>
<th>USB</th>
</tr>
</thead>
<tbody>
<tr>
<td>PF-22</td>
<td>U2-U6</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
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<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>PF-26</td>
<td>U2-U6</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
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<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
</tbody>
</table>
Power Feed® 41, 42, 44, 46

Designed to work with digital power sources

The Power Feed wire feeder range is designed to combine easy handling and control by the welder with perfect wire feeding. Depending on your application, the PF feeders are supplied as standard with a standard undercarriage but are available to be hung from a boom or placed on a special heavy-duty undercarriage to be used in tough industrial conditions.

The basic model PF-41 supports only CV MIG mode (5) but the rest of the range (PF-42/44/46) supports all modes installed on Multi-process or the advanced digital (ArcLink®) Lincoln power sources. The feeders are differentiated by User Interface (UI) and functions installed. The basic UI “U0” provides just control of Voltage and WFS where as the more advanced “U2” is equipped with bright digital meters, Trim function, mode selector and main starting/gending functions. The UI group “U4” & “U6” utilizes TFT colour display with intuitive icon language and variety of special functions. Top class feeder PF-46 with UI “U6” combines all functions with USB connection, Dual Procedure, Memory, Limits and also Light Switch inside the feeders which supports wire installation in dark, industrial conditions. All Power Feed 4X series can be optionally equipped with gas flow-meter, heavy duty undercarriage or lifting eye.

Features

- Small rugged and easy to handle feeders; with bright digital meters (PF-41 excl.).
- Utilises ArcLink® – the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration with the power source.
- Four roll drive system with powerful motor.
- Hot/Soft start Crater Run (PF-41 excl.) and all standard features.
- Easy-to-understand user interface panels make it easy to set weld parameters.
- Remote control on the gun (PF-46 & option for PF-44).
- Features push-pull capability for great performance on aluminium (PF-46 & option for PF-44).
- Equipped with wheels as standard.

Technical Specifications Standard Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll Cooling</th>
<th>Output Power</th>
<th>Input Power</th>
<th>WFS Range (Ohms)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>PF-41</td>
<td>K14163-1</td>
<td>4</td>
<td>A/W</td>
<td>500A@60%</td>
<td>40V DC</td>
<td>1.0-22</td>
<td>0.8-1.6</td>
<td>1.0-1.6</td>
</tr>
<tr>
<td>PF-42</td>
<td>K14107-1</td>
<td>18</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>11.5</td>
<td>460 x 300 x 640</td>
</tr>
<tr>
<td>PF-44</td>
<td>K14108-1</td>
<td>18.5</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>11.5</td>
<td>460 x 300 x 640</td>
</tr>
<tr>
<td>PF-46</td>
<td>K14109-1</td>
<td>18.5</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>11.5</td>
<td>460 x 300 x 640</td>
</tr>
</tbody>
</table>

Functions & Features

- Processes
  - MIG
  - Flux-Cored
  - Stick
  - TIG
  - Gouging

- Recommended Power Sources
  - Power Wave® 5350, 5500, 5700
  - Speedtec® 405S, 405SP, 505S, 505SP

Base Unit includes

- Drive rolls 1.0-1.2 mm Steel
- User Interface

Key Options

- K14121-1 User Interface U2
- K14122-1 User Interface U4
- K14123-1 User Interface U6
- K14124-1 Pendant box (12-pins)
- K14127-1 Cart, PF, HD
- K14128-1 Kit Lifting eye
- K14125-1 Kit 12-pin socket (F)
- K14126-1 Kit 6-pin socket (F)
- K23095-1 6-pin(F) to 12-pin(M)
- Adapter for Remote Control – 0.5 m
- K14111-1 Kit Gas flow meter
- K14129-1 Remote Control C-42 (2 pots)
- K10095-1-15M Remote control – 15 m
- K14091-1 Remote Control MIG 7 m
- K870 Foot Amptrol
- KP10519-8 Adapter TIG EURO
- K14131-1 ArcLink-T Flex
- K14132-1 Adapter 5-pin(M)/12-pin(F)
- KP14017-x Drive roll Kit range (4R)
- K14152-1 Lincoln Analog-Digital Interface
Power Feed® 84 Single & Dual
Single and dual bench/boom wire feeders

The Power Feed® 84 wire feeder is revolutionary in its ease of use and flexibility. Designe to maximize the capabilities of the Power Wave® S range, the combination of high tech power source and wire feeder, out perform traditional arc welding methods. The Power Feed® 84’s design allows the control box to be placed anywhere – near the work piece or on top of the power source. The Power Feed® 84 Dual is designed for shops that require welding flexibility and superior welding performance in one complete wire feeder package. Dual feeder allows two different types of wire on the feeder, allowing you to weld stainless or aluminum from one power source. Combine this wire feeder flexibility with one of Lincoln’s new Power Wave® power sources, and gain the capability to MIG weld, STT weld or Pulse weld with ease.

Features
- World-class arc performance on steel, stainless steel, aluminium and other materials.
- Waveform Control Technology® featuring patented processes such as Pulse-On-Pulse® (for a TIG-like bead appearance) and Power Mode® (for a stable arc at low current levels).
- Utilises ArcLink® – the leading digital communication protocol for welding, making it the best choice for seamless, time critical integration with the power source.
- Pulsed MIG process – great for low spatter, low heat input and out-of-position applications makes virtually any operator a better welder!
- Easy-to-understand user interface panel with large numeric displays make it easy to set weld parameters.
- Features push-pull capability for great performance on aluminium.

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Gearing</th>
<th>Input Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions (HxWxD) (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Feed® 25M (Aluminium case)</td>
<td>K2536-4</td>
<td>Standard Speed (factory setting)</td>
<td>40V DC</td>
<td>2.5-20.3</td>
<td>0.6-2.0</td>
<td>15.9</td>
<td>368 x 216 x 597</td>
<td></td>
</tr>
<tr>
<td>Power Feed® 25M (Plastic Case)</td>
<td>K2536-5</td>
<td>Extra Torque</td>
<td>40V DC</td>
<td>13-10.4</td>
<td>0.8-2.4</td>
<td>13.2</td>
<td>450 x 690 x 850</td>
<td></td>
</tr>
</tbody>
</table>

Power Feed® 25M
Premium Welding Solution with a Portable Design!

Lincoln Electric offers this full featured design in a robust package that can meet industry challenges. The lightweight construction, durable case, as well as the patented design of the MAXTRAC® wire drive system deliver the results you need.

Features
- Hardened and Construction Ready. Built tough for rough environments. From construction to shipbuilding, this design will meet your expectations. Packaged standard with either a durable aluminium or plastic case.
- Internal Lighting. High intensity LEDs illuminate the wire drive.
- Internal heating maintains control of humidity on your consumable by keeping the package warmed and protected in an enclosed case.

Mode Select Panel (MSP4) allows easy access to the Power Wave® library of waveforms. Advanced controls and set-up options are only a fingertip away!
- Dual Procedure and Memory Buttons allow you to set-up an A and B procedure to simplify “on-the-fly” switching!
LN-25 Pro & Pro Dual
Portable construction wire feeder

Built upon the tradition and success of the LN™-25, the new LN™-25 PRO is designed to be simple, reliable and easy to service. The LN™-25 PRO is ideal for field construction and fabrication, shipyards and rental companies. The MAXTRAC® wire drive enhances performance while the replacement case (and many other upgrade options) can be installed in less than five minutes. The LN™-25 PRO is available in 2 models: Standard & Dual Pro.

• The Standard model can be powered across the Arc the feeder utilises the Arc voltage to drive the feeder.
• The Dual Pro model features a voltage control knob for superior arc control, digital meters for increased monitoring, MIG-STT® capability and can be powered with either a control cable or across the arc.

Features
• Performance – all models: 2-Step/trigger interlock provides comfort for long welds sturdy and rugged spindle design with an incorporated brake.
• Performance – standard: analog voltmeter with polarity indicator LED automatically adjusts to welding polarity.
• Performance – dual power model: digital meters for accurate monitoring, display shows wire feed speed or amperage and welding voltage.
• Reliability: lightweight, impact and flame resistant polycarbonate case design keeps the internal components protected. Potted and traved PC board protects against moisture and corrosion. Reel locking mechanism eliminates spindle cross threading.
• Serviceability: case can be replaced in less than 5 minutes – eliminates downtime.

LN-25X with CrossLinc™ Technology
Full control with no control cables


Features
• Remotely controls preset voltage without a control cable.
• Trigger Interlock switch provides operator comfort over long welds.
• Arc Hour Meter for tracking maintenance and productivity.
• Digital Meters display voltage, current and wire feed speed.

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Input Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LN-25X</td>
<td>K2437-1</td>
<td>2</td>
<td>A</td>
<td>95-110V DC</td>
<td>1.3-127</td>
<td>0.6-1.6</td>
<td>18.37</td>
<td>381 x 221 x 599</td>
</tr>
<tr>
<td>LN-25X Pro</td>
<td>K2632-5</td>
<td>2</td>
<td>A</td>
<td>15-110V DC</td>
<td>1.3-127</td>
<td>0.6-1.6</td>
<td>18.37</td>
<td>381 x 221 x 599</td>
</tr>
<tr>
<td>LN-25X Pro Dual</td>
<td>K2634-8</td>
<td>2</td>
<td>A</td>
<td>15-110V DC or 24-42V AC</td>
<td>1.3-127</td>
<td>0.6-1.6</td>
<td>18.37</td>
<td>381 x 221 x 599</td>
</tr>
</tbody>
</table>

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LN 23P
Built for the job

The LN 23P semiautomatic wire feeder is able to handle the toughest work sites and is an excellent choice for pipe welding applications. It is portable, easy to setup and ideal for reaching difficult locations.

Features
• Weighs less than 23 kg including optional Magnum® Innershield® gun and 14 lb (6.3 kg) coil of electrode.
• Continuous wire feed speed control, voltage control and analog voltmeter are standard.
• Completely enclosed wire reel keeps the wire free of contaminants.
• Equipped with trigger interlock circuit to reduce operator fatigue.
• Gun-mounted two-position switch allows on-the-fly change to 83% of the preset wire feed speed.
• Electrode and control cable quickly connect to power source.
• One or two LN 23P wire feeders can be directly connected to recommended Lincoln power sources, but only one can be used at a time.

Technical Specifications of Wire Feeders

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Drive Roll</th>
<th>Cooling</th>
<th>Rated Output</th>
<th>Input Power</th>
<th>WFS Range (m/min)</th>
<th>Wire Size Range (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LN 23P</td>
<td>K316L-6</td>
<td>2</td>
<td>A/W</td>
<td>350A/60%</td>
<td>14-50V DC</td>
<td>0.76 – 6.7</td>
<td>1.7-2.0</td>
<td>12.3</td>
<td>521 x 229 x 483</td>
</tr>
</tbody>
</table>

WELDING HELMETS

Viking Welding Helmets

Built for demanding specifications. Lightweight, solar-powered Viking helmets come in many designs.

To choose one for yourself, see helmets section of this catalogue or visit our website: www.lincolnelectriceurope.com
**REMOTE PENDANTS**

**Foot Amptral™ Connector Kit**
Provides 7.6 m of remote output control for TIG welding (6-pin plug connection).
Item n°: K2320-1

**GAS SOLENOID AND BURNBACK KITS**

**Preflow, Postflow and Burnback Timer Kit**
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.
Item n°: K2330-2 for LN-25 PRO, LN-25 PRO Dual Power

**WATER CONNECTION KITS**

**Water Connection Kit**
Includes quick connect fittings on front and back of wire drive for use with water-cooled guns and coolers. Kit provides for one gun.
Item n°: K990-6

**STANDS AND UNDERCARRIAGES**

**Heavy Duty Wire Reel Stand**
For use with Lincoln 4.5-27.2 kg wire packages that use a 51 mm spindle. Hole in stand fits over lift bail.
Item n°: K1524-3

**Caster Kit – Light Duty**
Mounts to the Heavy Duty Wire Reel Stand. Allows easy movement of wire feeder.
Item n°: K1556-1

**Insulated Lift Bail**
Allows the entire wire feeder to be hung from a crane or hook. Use with Heavy Duty Wire Reel Stand.
Item n°: K1555-1

---

**CONTROL CABLES AND ADAPTERS**

<table>
<thead>
<tr>
<th>Description</th>
<th>Connection</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wire Feeder Control Cables</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Wire Feeder Control Cable</td>
<td>Male 14-pin to Female 8-pin</td>
<td>K10093-15M (for LN-23P)</td>
</tr>
<tr>
<td>Wire Feeder Control Cable</td>
<td>Fast-mate [D], gas hose, protection</td>
<td>K10347-xM (for LF)</td>
</tr>
<tr>
<td>Wire Feeder Control Cable</td>
<td>Fast-mate [D], gas hose, protection</td>
<td>K10370-xM (for LF)</td>
</tr>
</tbody>
</table>

| Extensions and Adapters | | |
| Wire Feeder Control Cable Extension | Male 14-pin to Female 14-pin | K1797-10 [3 m] |
| | | K1797-50 [5.2 m] |
| | | K1797-100 [10.4 m] |

| Adapter Cable for Control Cable to Terminal Strip of Power Source | Female 14-pin control cable to terminal strip | K1798 |

| ArcLink®/Linc-Net™ Control Cables | For Power Wave®/Power Feed® Systems | |
| ArcLink®/Linc-Net™ Control Cables | K1543-8 [2.5 m] |
| | K1543-25 [7.6 m] |
| | K1543-50 [15.2 m] |
| | K1543-100 [30.4 m] |

| Heavy Duty ArcLink®/Linc-Net™ Control Cables | For Power Wave®/Power Feed® Systems | |
| Heavy Duty ArcLink®/Linc-Net™ Control Cables | K2683-25 [7.6 m] |
| | K2683-50 [15.2 m] |
| | K2683-100 [30.4 m] |

| 14-pin Cables | For synchronizing Power Wave® AC/DC 1000® SD and connecting MAXsa™ Heads | |
| Submerged Arc Equipment | K1785-4 [1.2 m] |
| | K1785-8 [2.4 m] |
| | K1785-16 [4.9 m] |
| | K1785-25 [7.6 m] |
| | K1785-50 [15.2 m] |
| | K1785-100 [30.4 m] |
**SEMI-AUTOMATIC WIRE FEEDERS**

**WELD CABLES**

Coaxial Weld Power Cables  
Recommended for STT® and pulse welding when using long distances between feeder and power source.

<table>
<thead>
<tr>
<th>Item n°</th>
<th>Connection</th>
<th>Description</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>K1796-25</td>
<td>Twist-Mate™ to Lug</td>
<td>1/0, 350A, 60% duty cycle, 7.6 m</td>
<td>K1840-10</td>
</tr>
<tr>
<td>K1796-50</td>
<td>Twist-Mate™ to Lug</td>
<td>1/0, 350A, 60% duty cycle, 15.2 m</td>
<td>K1840-25</td>
</tr>
<tr>
<td>K1796-75</td>
<td>Twist-Mate™ to Lug</td>
<td>1/0, 350A, 60% duty cycle, 22.8 m</td>
<td>K1840-40</td>
</tr>
<tr>
<td>K1796-100</td>
<td>Twist-Mate™ to Lug</td>
<td>1/0, 350A, 60% duty cycle, 30.4 m</td>
<td>K1840-50</td>
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</table>

**WELD POWER CABLES**

<table>
<thead>
<tr>
<th>Connection</th>
<th>Description</th>
<th>Order No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Twist-Mate™ to Lug</td>
<td>1/0, 350A, 60% duty cycle, 3.0 m</td>
<td>K1840-10</td>
</tr>
<tr>
<td>Lug to Lug</td>
<td>3/0, 600A, 60% duty cycle, 3.0 m</td>
<td>K1842-10</td>
</tr>
<tr>
<td></td>
<td>3/0, 600A, 60% duty cycle, 10.6 m</td>
<td>K1842-35</td>
</tr>
<tr>
<td></td>
<td>3/0, 600A, 60% duty cycle, 18.2 m</td>
<td>K1842-60</td>
</tr>
<tr>
<td></td>
<td>4/0, 600A, 60% duty cycle, 33.5 m</td>
<td>K1842-110</td>
</tr>
</tbody>
</table>

 Twist-Mate™ to Twist-Mate™  
| 1/0, 350A, 60% duty cycle, 7.6 m | K1841-25 |
| 2/0, 300A, 60% duty cycle, 10 m | EXT-50-10M |

**MIG GUNS**

LINC GUN™ range  
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a “rotating ball joint” at the end of the gun grip.

**Air cooled guns**

- LGS 150G, 150A @ 60%  
  K10429-15-xM 3 m, 4 m or 5 m  
- LGS 250G, 200A @ 60%  
  K10429-25-xM 3 m, 4 m or 5 m  
- LGS 360G, 300A @ 60%  
  K10429-36-xM 3 m, 4 m or 5 m

**Water cooled guns**

- LGS 505W, 450A @ 100%  
  K10429-505-xM 3 m, 4 m or 5 m

**ADAPTERS AND PACKAGES**

**Twist Mate™ to Lug Adapter**  
For connection of lugged cable to Twist Mate™ connectors, 457 mm long.  
Item n°: K2176-1

**Twist Mate™ Cable Plug**  
For connecting welding cable to output terminal receptacles.  
Item n°: K852-70 for 50-70 mm² cable  
Item n°: K852-95 for 95 mm² cable.

**WIRE ADAPTERS, COVERS AND STRAIGHTENERS**

**200 mm O.D. Spool Adapter**  
Permits 200 mm O.D. spoons to be mounted on 51 mm O.D. spindles.  
Item n°: K468

**6 kg Innershield® Coil Adapter**  
Permits 6 kg Innershield® electrode coils to be mounted on 51 mm O.D. spindles.  
Item n°: K435

**10-14 kg Readi-Reel® Adapter**  
Adapts 10-14 kg Lincoln Electric Readi-Reels® of electrode to 51mm spindle.  
Item n°: K10159-1

**22.6-27.2 kg Coil Adapter**  
Adapts 22.6-27.2 kg coils of Lincoln Electric electrode to 51mm spindle.  
Item n°: K1054-1

**Plastic Wire Cover Kit**  
Plastic enclosure for 13.6-19.9 kg wire packages.  
Item n°: K1634-1

**Wire Straightener**  
Straightens wire for better, smoother feeding.  
Item n°: K1733-1

**Spindle Adapter for Readi-Reels® and Spools**  
51mm O.D. spindle for mounting Readi-Reels® and 51mm I.D. spoons up to 27.2 kg capacity to custom installations.  
Item n°: K162-1

**Polycarbonate Portable Feeder Case**  
Replace a damaged case without replacing the entire unit.  
Item n°: K2596-2

**Accessories**

**Air cooled guns**

- LGS 150G, 150A @ 60%  
  K10429-15-xM 3 m, 4 m or 5 m  
- LGS 250G, 200A @ 60%  
  K10429-25-xM 3 m, 4 m or 5 m  
- LGS 360G, 300A @ 60%  
  K10429-36-xM 3 m, 4 m or 5 m

**Water cooled guns**

- LGS 505W, 450A @ 100%  
  K10429-505-xM 3 m, 4 m or 5 m

**MIG GUNS**

LINC GUN™ range  
As standard these guns come with an ergonomic grip, springs on both sides of the cable, retractable pins and a “rotating ball joint” at the end of the gun grip.
### DRIVE ROLL AND GUIDE TUBE KITS

**POWER WAVE® C300, LN-25 PRO, LN-25 PRO Dual Power and LN 25X**

<table>
<thead>
<tr>
<th>Description</th>
<th>Product Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solid Wire (includes stainless steel)</td>
<td></td>
</tr>
<tr>
<td>0.6-0.8 mm</td>
<td>KP1696-030S</td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP1696-035S</td>
</tr>
<tr>
<td>0.9, 1.2 mm</td>
<td>KP1696-1</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP1696-2</td>
</tr>
<tr>
<td>1.2 mm</td>
<td>KP1696-045S</td>
</tr>
<tr>
<td>1.4 mm</td>
<td>KP1696-052S</td>
</tr>
<tr>
<td>1.6 mm</td>
<td>KP1696-1/6S</td>
</tr>
<tr>
<td>Cored Wire</td>
<td></td>
</tr>
<tr>
<td>0.9-1.1 mm</td>
<td>KP1697-035C</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP1697-045C</td>
</tr>
<tr>
<td>1.2 mm</td>
<td>KP1697-052C</td>
</tr>
<tr>
<td>1.4 mm</td>
<td>KP1697-068</td>
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<tr>
<td>2.0 mm</td>
<td>KP1697-6/64</td>
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<tr>
<td>2.4 mm</td>
<td>KP1697-3/32</td>
</tr>
<tr>
<td>Aluminium Wire</td>
<td></td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP1695-035A</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP1695-040A</td>
</tr>
<tr>
<td>1.2 mm</td>
<td>KP1695-3/64A</td>
</tr>
<tr>
<td>1.6 mm</td>
<td>KP1695-1/6A</td>
</tr>
<tr>
<td>Solid Wire (includes stainless steel)</td>
<td></td>
</tr>
<tr>
<td>0.6-0.8 mm</td>
<td>KP14016-0.8</td>
</tr>
<tr>
<td>0.8-1.0 mm</td>
<td>KP14016-1.0</td>
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<tr>
<td>1.0-1.2 mm</td>
<td>KP14016-1.2</td>
</tr>
<tr>
<td>Cored Wire</td>
<td></td>
</tr>
<tr>
<td>0.9-1.1 mm</td>
<td>KP14017-1.1R</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14017-1.6R</td>
</tr>
<tr>
<td>Aluminium Wire</td>
<td></td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP14017-1.2A</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14017-1.6A</td>
</tr>
</tbody>
</table>

**POWER WAVE® C300, LN-25 PRO, LN-25 PRO Dual Power and LN 25X**

<table>
<thead>
<tr>
<th>Description</th>
<th>Product Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solid Wire (includes stainless steel)</td>
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</tr>
<tr>
<td>0.6-0.8 mm</td>
<td>KP14017-0.8</td>
</tr>
<tr>
<td>0.8-1.0 mm</td>
<td>KP14017-1.0</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP14017-1.2</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14017-1.6</td>
</tr>
<tr>
<td>Cored Wire</td>
<td></td>
</tr>
<tr>
<td>0.9-1.1 mm</td>
<td>KP14017-1.1R</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14017-1.6R</td>
</tr>
<tr>
<td>1.6-2.4 mm</td>
<td>KP14017-2.4R</td>
</tr>
<tr>
<td>Aluminium Wire</td>
<td></td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP14017-1.2A</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14017-1.6A</td>
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**PF 22, PF 26**

<table>
<thead>
<tr>
<th>Description</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Solid Wire</td>
<td></td>
</tr>
<tr>
<td>0.6-0.8 mm</td>
<td>KP14150-V06/08</td>
</tr>
<tr>
<td>0.8-1.0 mm</td>
<td>KP14150-V08/10</td>
</tr>
<tr>
<td>0.9-1.1 mm</td>
<td>KP14150-V09/11</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP14150-V10/12</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14150-V12/16</td>
</tr>
<tr>
<td>1.4-2.0 mm</td>
<td>KP14150-V14/20</td>
</tr>
<tr>
<td>1.6-2.4 mm</td>
<td>KP14150-V16/24</td>
</tr>
<tr>
<td>Cored Steel Wire</td>
<td></td>
</tr>
<tr>
<td>0.9-1.1 mm</td>
<td>KP14150-V09/11R</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP14150-V10/12R</td>
</tr>
<tr>
<td>1.2-1.6 mm</td>
<td>KP14150-V12/16R</td>
</tr>
<tr>
<td>1.4-2.0 mm</td>
<td>KP14150-V14/20R</td>
</tr>
<tr>
<td>1.6-2.4 mm</td>
<td>KP14150-V16/24R</td>
</tr>
<tr>
<td>Aluminium Wire</td>
<td></td>
</tr>
<tr>
<td>0.6-0.8 mm</td>
<td>KP14150-U06/08A</td>
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<tr>
<td>0.8-1.0 mm</td>
<td>KP14150-U08/10A</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP14150-U10/12A</td>
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<td>1.2-1.6 mm</td>
<td>KP14150-U12/16A</td>
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<tr>
<td>1.6-2.4 mm</td>
<td>KP14150-U16/24A</td>
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</table>

### DRIVE ROLL AND WIRE GUIDE KITS

**LN-23P**

<table>
<thead>
<tr>
<th>Description</th>
<th>Product Number</th>
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</thead>
<tbody>
<tr>
<td>Solid Wire</td>
<td></td>
</tr>
<tr>
<td>0.6-0.9 mm</td>
<td>KP653-025S</td>
</tr>
<tr>
<td>0.8 mm</td>
<td>KP653-030S</td>
</tr>
<tr>
<td>0.9-1.0 mm</td>
<td>KP653-035S</td>
</tr>
<tr>
<td>1.2-1.4 mm</td>
<td>KP653-052S</td>
</tr>
<tr>
<td>Cored Wire</td>
<td></td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP653-035C</td>
</tr>
<tr>
<td>1.2-1.4 mm</td>
<td>KP653-052C</td>
</tr>
<tr>
<td>Cored or Solid Wire</td>
<td></td>
</tr>
<tr>
<td>1.6 mm</td>
<td>KP653-1/16</td>
</tr>
<tr>
<td>1.7-2.4 mm</td>
<td>KP653-3/32</td>
</tr>
<tr>
<td>2.4 mm</td>
<td>KP6505-3/32</td>
</tr>
<tr>
<td>1.0-1.2 mm</td>
<td>KP4017-1.2A</td>
</tr>
<tr>
<td>Hardfacing</td>
<td></td>
</tr>
<tr>
<td>2.8 mm</td>
<td>KP653-7/64H</td>
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**2-Roll Wire Drive Systems**

**NA-3S, NA-4, NA-5**

<table>
<thead>
<tr>
<th>Description</th>
<th>Product Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solid Wire</td>
<td></td>
</tr>
<tr>
<td>2.4-5.6 mm</td>
<td>KP1899-1</td>
</tr>
<tr>
<td>1.6, 2.0, 2.4 mm</td>
<td>KP1899-2</td>
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<tr>
<td>0.9, 1.2, 1.4 mm</td>
<td>KP1899-3</td>
</tr>
<tr>
<td>Cored Wire</td>
<td></td>
</tr>
<tr>
<td>1.0-1.4 mm</td>
<td>KP1899-4</td>
</tr>
<tr>
<td>Knurled Drive Roll</td>
<td></td>
</tr>
<tr>
<td>2.4-5.6 mm</td>
<td>KP1885-1</td>
</tr>
<tr>
<td>1.6-2.4 mm</td>
<td>KP1886-1</td>
</tr>
<tr>
<td>Outgoing Guide</td>
<td></td>
</tr>
<tr>
<td>2.4-5.6 mm</td>
<td>KP1963-1</td>
</tr>
<tr>
<td>Incoming Guide</td>
<td></td>
</tr>
<tr>
<td>2.4-5.6 mm</td>
<td>KP2116-2</td>
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</table>
SUBMERGED ARC EQUIPMENT
Ideal For Heavy Duty Hard Automation Applications
Maximum Control Over Welding Parameters
Designed To Deposit More Weld Metal At Fast Travel Speeds
## Submerged Arc Equipment

**Power Wave® AC/DC 1000® SD**
- Increased productivity, quality and flexibility

**Digital Wire Feeder**

**Cruiser® & Tandem Cruiser® Submerged Arc Welding Tractor**

**MAXsa™ 10 controller**
- ArcLink® – enabled Controller for Power Wave® AC/DC 1000® SD Systems

**MAXsa™ 22 Feed Head**
- Submerged Arc Hard Automation Wire Drive for Power Wave® AC/DC 1000® SD Systems

**MAXsa™ 19 controller**
- Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

**MAXsa™ 29 Feed Head**
- Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

### Digital Power Source

<table>
<thead>
<tr>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (Amps)</th>
<th>Voltage (V)</th>
<th>Process</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Wave® AC/DC 1000® SD</td>
<td>CC/CV</td>
<td>AC/DC</td>
<td>100-1000</td>
<td>380/400/460/500/575</td>
<td>●</td>
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</tbody>
</table>

### Analog Power Source

<table>
<thead>
<tr>
<th>Model</th>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (Amps)</th>
<th>Voltage (V)</th>
<th>Process</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>Idealarc® DC-1000</td>
<td>CC/CV</td>
<td>DC</td>
<td>150-1300</td>
<td>200/380/440</td>
<td>●</td>
<td>●</td>
</tr>
<tr>
<td>Idealarc® DC-1500</td>
<td>CC/CV</td>
<td>DC</td>
<td>200-1500</td>
<td>380/440</td>
<td>●</td>
<td>●</td>
</tr>
<tr>
<td>Idealarc® AC-1200</td>
<td>CC</td>
<td>AC</td>
<td>380/415/440/460</td>
<td>●</td>
<td>●</td>
<td>●</td>
</tr>
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</table>

### Digital Wire Feeder

<table>
<thead>
<tr>
<th>Model</th>
<th>WIRE FEED SPEED RANGE (m/min)</th>
<th>WIRE SIZE RANGE (mm)</th>
<th>PROCESS</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cruiser® &amp; Tandem Cruiser®</td>
<td>0.4-12.5</td>
<td>-</td>
<td>-</td>
<td>●</td>
</tr>
<tr>
<td>MAXsa™ 10 controller</td>
<td>-</td>
<td>1.6-5.6</td>
<td>-</td>
<td>●</td>
</tr>
<tr>
<td>MAXsa™ 22 Feed Head</td>
<td>0.25-12.7</td>
<td>-</td>
<td>-</td>
<td>●</td>
</tr>
<tr>
<td>MAXsa™ 19 controller</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>●</td>
</tr>
<tr>
<td>MAXsa™ 29 Feed Head</td>
<td>0.25-12.7</td>
<td>-</td>
<td>-</td>
<td>●</td>
</tr>
</tbody>
</table>

### Analog Wire Feeder

<table>
<thead>
<tr>
<th>Model</th>
<th>WIRE FEED SPEED RANGE (m/min)</th>
<th>WIRE SIZE RANGE (mm)</th>
<th>PROCESS</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>NA-3 Control &amp; Heads</td>
<td>0.6-15.2</td>
<td>0.9-5.6</td>
<td>11-4.0</td>
<td>●</td>
</tr>
<tr>
<td>NA-4 Control &amp; Heads</td>
<td>subject to arc voltage</td>
<td>1.6-5.6</td>
<td>-</td>
<td>●</td>
</tr>
<tr>
<td>NA-5 Control &amp; Heads</td>
<td>0.6-19.7</td>
<td>0.9-5.6</td>
<td>11-4.0</td>
<td>●</td>
</tr>
<tr>
<td>LT-7 Tractor</td>
<td>2.5-10.2</td>
<td>2.4-4.8</td>
<td>-</td>
<td>●</td>
</tr>
</tbody>
</table>
Power Wave® AC/DC 1000® SD

Increased productivity, quality and flexibility

Software-driven output delivers maximum control over the deposition rate and penetration in single or multi-arc environments.

Features

- 380-575 VAC, 50/60 Hz Voltage Input – offers the ability to be connected anywhere in the world.
- No hardware reconfiguration required with easy polarity switching – eliminates downtime.
- Easy to parallel machines or run multiple arcs.
- 3-Phase voltage Input – eliminates the imbalance associated with transformer-based AC welding machines.
- 95% power factor correction – enables connection of multiple machines on the same plant infrastructure for lower installation costs.
- Severe duty – can be stored outdoors. IP23 rated.
- ArcLink®, ethernet and DeviceNet™ communication – offers remote process monitoring, control and troubleshooting.
- True Energy™ – measures, calculates and displays instantaneous energy in the weld for critical heat input calculations.

- Production Monitoring™ 2.2 – track equipment usage, store weld data and configure limits to assist in welding efficiency analysis.
- Software based controls – can be upgraded as new features become available.
- iARC™ digital control – 90 times faster than the previous generation, delivering a responsive arc.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Output Range [A]</th>
<th>Rated Output</th>
<th>Input Current @ Rated Output</th>
<th>Weight [kg]</th>
<th>Dimensions [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Wave® AC/DC</td>
<td>K2803-1*</td>
<td>380/400/460/500/575/60 V/3/50/60</td>
<td>100-1000</td>
<td>100A/44V/100%</td>
<td>K2799/8/9/6/2/55</td>
<td>363</td>
<td>1250 x 488 x 1174</td>
</tr>
</tbody>
</table>

*IFilter is required to meet CE conducted emission requirements. The K2444-3 must be used with the K2803-1.

Cruiser® & Tandem Cruiser®

Submerged Arc Welding T ractor

The self-propelled, modular Cruiser™ and Tandem Cruiser™ travel carriages can deliver deposition rates up to 13 kg per arc, per hour for butt and fillet joints on lengthy plate welding applications common in bridge or barge decking, large tank fabrication or shipbuilding.

Features

- Reliable operation – strong, rigid and stiff, especially when you need it most:
  - Sturdy welded base frame.
  - Substantial steel mast stands up to daily construction site use.
  - Simple cast wheels – equipped with high temperature and slip resistant rubber tires.
  - Robust tube and clamp design – trouble-free feeding component mounting.
  - Adjustable extended length outriggers – make it easy to guide tractor movement.
- Advanced control pendant – removable, lightweight, impact resistant aluminium user interface can be used to save procedures, apply limits and lockouts for any and all controls.
- Multiple configurations – flexible system allows set up with or without a track and three- or four-wheel operation. Tandem model not recommended for three wheel operation.
- Advanced extended length outriggers for three or four-wheel operation.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Rated Output</th>
<th>Travel Speed [m/min]</th>
<th>Gear Box</th>
<th>Wire Feed Speed range [m/min]</th>
<th>Wire Size Range [mm]</th>
<th>Weight [kg]</th>
<th>Dimensions [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cruiser Tractor</td>
<td>K3048-2</td>
<td>40V DC</td>
<td>1000A / 100%</td>
<td>0.25-2.5</td>
<td>142:1</td>
<td>0.4-5.0</td>
<td>2.4-5.6</td>
<td>94</td>
<td>736 x 584 x 1134</td>
</tr>
<tr>
<td>Tandem Cruiser™ Tractor</td>
<td>K3088-1</td>
<td>40V DC</td>
<td>1000A / 100%</td>
<td>0.25-2.5</td>
<td>142:1</td>
<td>0.4-5.0</td>
<td>2.4-5.6</td>
<td>136</td>
<td>927 x 716 x 1054</td>
</tr>
</tbody>
</table>

10 Optional

www.lincolnelectriceurope.com

Digital Power Source

Processes:
- Submerged arc

Recommended Wire Feeders:
- K3048-2 Cruiser™ Tractor
- K3088-1 Tandem Cruiser™
- K2814-4 MAXsa® 10 Controller
- K2370-2 MA Xsa® 22 Feed Head

Key Options:
- K2444-3 CE Filter (Required option for UE).
- K1811-x Heavy Duty Process Sense Lead – 150/30 m
- K2603-x Heavy Duty ArcLink® Control Cable – 25/50/100 m
- K1785-x Control Cable (Heavy Duty) – 3.5/7/15/30 m
- K265 Concentric Flux Cone Assembly
- K2311 Contact Nozzle Assembly for 2.4, 3.2, 4.0 mm Wire
- K148A Positive Contact Nozzle Assembly for 2.4-3.2 mm Wire
- K148B Positive Contact Nozzle Assembly for 4.0-4.8 mm Wire

Digital Wire Feeder

Processes:
- Submerged arc

Unit Includes:
- Conduit Tubing, 1.5 m
- 4mm, 600 amp Contact Nozzle Assembly; 4mm. Contact Tip
- Nozzle Extension 127 mm
- Curved Nozzle Extension, 45°
- Nozzle Extension Insulator
- Flux Tubing and Hose Clamps
- Wire Reel Assembly
- Wheels for Track Operation
- Front and Rear Outriggers
- Enclosed Wire Reel (2 for Tandem)

Note: Does not include a control cable.

Key Options:
- K1733-5 Wire Straightener
- K396 Track Section
- K3070-1 Tiny Twin Kit

www.lincolnelectriceurope.com
MAXsa™ 10 controller

ArcLink® – enabled Controller for Power Wave® AC/DC 1000® SD Systems

The MAXsa® 10 controller offers a single monitoring and control point for the entire hard automation welding system. Operators have full control over AC and DC welding parameters and easy PLC interfacing to control fixture travel, timers and other system commands.

Features
• Severe duty ready – the controller is IP23 rated and ready for operation in harsh environments.
• Pendant box – mount the controller in the standard protective box or remove the pendant for hand-held operation. Extend hand-held operation from 1.2 m up to 30.5 m with an ArcLink® extension cable.
• Eight procedure memories – pre-set and save your optimal welding parameters for repeating applications and recall later for fast changeovers.
• User-friendly controls – clear digital display and controls make it easy to set weld modes, AC operation, strike/start/end options, travel stop/start, timers and other parameters.
• Limit control – apply operator procedure limits or lockout on any or all parameters.
• Waveform Control Technology® – allows the user to choose from a library of pre-programmed weld modes. Parameters for each mode can be adjusted within a limited range to achieve optimal balance between deposition rate and penetration.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>MAXsa™ 10</td>
<td>K2814-4</td>
<td>40V DC</td>
<td>11.3</td>
<td>381 x 259 x 102</td>
</tr>
</tbody>
</table>

MAXsa™ 22 Feed Head

Submerged Arc Hard Automation Wire Drive for Power Wave® AC/DC 1000® SD Systems

Designed specifically for hard automation applications, the MAXsa® 22 Wire Drive delivers accurate wire feeding of submerged arc wires. Based on Lincoln’s proven gearbox and extruded aluminium feedplate, the MAXsa® 22 model features a 32VDC permanent magnet, high torque motor that delivers plenty of torque to push up to 5.6 mm diameter solid wire. A top speed of up to 12.7 m/min can be achieved by changing the gear ratio.

Features
• Flexible configuration – can be used in single, tandem, Twinarc® or multiple arc applications.
• Closed loop speed control – facilitates full control over starting, running and stopping wire feed speed.
• IP23 rated – tested to withstand harsh environments.
• Standard conversion kits – used to change the speed ratio to match the requirements of your application.
• Multi-axis rotation – rotational feed head adjustment in two planes allows flexible, accurate setup for fixturing or arc locating. Additional positioning flexibility can be achieved with the optional horizontal and vertical lift adjuster.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Rated Output</th>
<th>Gear Box</th>
<th>Wire Feed Speed range (m/min)</th>
<th>Wire Size Range** Solid (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>MAXsa™ 22 Head</td>
<td>K2370-2</td>
<td>40V DC</td>
<td>1000A / 101%</td>
<td>142:1</td>
<td>0.4-5.0/0.4-12.7</td>
<td>2.4-5.6/1.6-2.2</td>
<td>36.3</td>
<td>305 x 355 x 254</td>
</tr>
</tbody>
</table>

**142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-2, K2312-2, or K2311-1)
MAXsa™ 19 Controller
Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

The MAXsa® 19 controller is specifically designed to relay wire feed commands to the MAXsa® 29 when a customer-supplied user interface is used in place of the MAXsa® 10 controller. Typically, this occurs in a variety of third party integrator solutions that include integration hardware like turning rolls, panel lines, seamers and pipe mills fixturing.

Features
• Compact size – makes it easy to position in custom integrator solutions.
• Fast digital communication – with the Power Wave® AC/DC 1000® SD via ArcLink® cable and to the wire drive via a 14-pin control cable.
• Standard I/O connector block – for start/stop, forward/reverse feed and shutdown input interfacing with external accessories.
• Standard status indicator – aids diagnostic system troubleshooting.
• IP23 rated – tested to withstand harsh environments.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>MAXsa™ 19</td>
<td>K2626-4</td>
<td>40V DC</td>
<td>3.2</td>
<td>229 x 267 x 76</td>
</tr>
</tbody>
</table>

MAXsa™ 29 Feed Head
Submerged Arc Systems for Integrators and Robotic Applications for Power Wave® AC/DC 1000® SD Systems

The compact MAXsa® 29 Feed Head is intended for integrator solutions, as well as the latest submerged arc robotic applications.

Features
• Closed loop speed control – facilitates full control over starting, running and stopping wire feed speed.
• 32V DC permanent magnet, high torque motor – delivers plenty of torque to push up to 5.6 mm diameter solid wire. Top speed of up to 12.7 m/min can be achieved by changing the gear ratio.
• IP23 rated – tested to withstand harsh environments.
• Standard conversion kits – used to change the speed ratio to match the requirements of your application.
• Standard adjustable wire straightener.
• Multi-axis rotation – rotational feed head adjustment in one plane allows flexible, accurate setup for fixturing.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Rated Output</th>
<th>Gear Box</th>
<th>Wire Feed Speed Range[1] (m/min)</th>
<th>Wire Size Range[2,3] Solid (mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>MAXsa™ 29 Head</td>
<td>K2392-2</td>
<td>40V DC</td>
<td>1000A / 100%</td>
<td>M2:1</td>
<td>0.4 - 9.0</td>
<td>1.3 - 12.7</td>
<td>3.5</td>
<td>330 x 406 x 254</td>
</tr>
</tbody>
</table>

[1] M2:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-2, K2372-2, or K281-1)
**Idealarc® DC-1000, Idealarc® DC-1500**

**Industrial DC Multi-process welders**

If an application requires pure welding power combined with multi-process power, then the Idealarc® DC-1000 with 1300 amps of smooth DC output is your best investment. Designed for Semi-automatic and automatic welding, the precise control of the Idealarc® DC-1000 provides superior MIG, flux-cored, submerged-arc welding and excellent air carbon arc gouging with up to 16.0 mm diameter carbons.

The Idealarc® DC-1500 is a multi-process DC arc welding power source for automatic welding applications. It produces outstanding arc characteristics on both constant voltage and constant current processes for great welding versatility from a single power source. A single range full output control potentiometer provides outstanding welding performance.

**Features (Idealarc® DC1000)**
- 500 amp output connections provide enhanced arc characteristics for low amperage flux-cored (FCAW) and MIG welding procedures.
- Single range control for precise output control and easy operation.
- Terminal strip and output studs for remote connections and cable.
- Low profile case allows installation of a work-bench and stacking up to 2 machines to conserve floor space.
- Removable side panels for easy access to internal parts.
- Line voltage compensation maintains weld consistency, even with line voltage changes of ±10%.
- Internal components, including windings, rectifiers and circuit boards, are coated to protect against the effects of moisture and corrosion.
- Seven-year warranty on power rectifier.

**Features (Idealarc® DC1500)**
- Full range output voltage control for easy operation and precise output control.
- Mode switch used to select the desired output characteristics for the process being used.
- Line voltage compensation for maintaining weld consistency, even with line voltage changes of ±10%.
- Fan cooled with electronic and thermostatic protection from current overload and excessive temperatures.
- Function lights build into the printed circuit boards speed diagnostics.
- Windings and rectifiers protected against moisture and corrosive environments.
- Removable side panels for easy access to internal parts.
- Recessed front panel protects operating controls.
- Terminal strip and output studs for remote connections and cable.
- Seven-year warranty on power rectifier.

---

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Current Range [A]</th>
<th>Rated Output</th>
<th>Input Current @ Rated Output</th>
<th>Weight [kg]</th>
<th>Dimensions HWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Idealarc® DC-1000</td>
<td>K1387-3</td>
<td>200/380/440/540/690/810Ph</td>
<td>150-1100</td>
<td>1250A/440V/70%</td>
<td>1400A/440V/60%</td>
<td>372</td>
<td>781 x 567 x 991</td>
</tr>
<tr>
<td>Idealarc® DC-1500</td>
<td>K1383-4</td>
<td>380/440/5Ph</td>
<td>200-1500</td>
<td>1500A/360V/100%</td>
<td>184</td>
<td>644</td>
<td>1493 x 566 x 965</td>
</tr>
</tbody>
</table>
**Idealarc® AC-1200**

**Automatic Submerged Arc Welding Power Source**

The AC1200 submerged arc power source is specifically designed for operation with Lincoln Electric’s NA-4 automatic wire feeder. It is a power source that you can count on day-in and day-out to provide proven performance.

**Features**

- Scott® connection taps standard for two AC welding heads operated in tandem.
- Rheostat adjusts the output settings while welding or at idle.
- Three output studs with overlapping ranges.
- ±10% input line voltage compensation for maintaining weld consistency.
- Thermostat protection from current overload and excessive temperatures.
- Terminal strip for remote control and wire connections and output studs for welding cables.
- Removable side panels for easy access to internal parts.
- Windings and rectifiers protected against moisture and corrosive environments.
- Seven-year warranty on power rectifier.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Input Current @ Rated Output</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
</table>

**Processes**

- Submerged arc

**Recommended Wire Feeders**

- NA-4

**Key Options**

- K10376 Adapter M14/Dinse(F)
**NA-3, NA-4 & NA-5 Control & Heads**

**Automatic Welding Systems**

Improve productivity with the NA-35, NA-4, or NA-5 automatic wire feeders. These systems have been specially designed to deposit more weld metal at faster travel speeds which eliminates bottlenecks and cuts costs.

**Features**
- Solid state controls allow precise control of welding procedures, striking characteristics, as well as bead size and shape.
- Easily adjusted for a wide range of processes, feed speeds and wire sizes.
- Compact units with excellent flexibility to fit into simple fixtures or the most complex automated production lines.
- Rugged construction minimizes downtime and maintenance costs.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Wire Feed Speed Range (m/min)</th>
<th>Wire Size Range (Solid mm)</th>
<th>Gear Box</th>
</tr>
</thead>
<tbody>
<tr>
<td>NA-35 Controller</td>
<td>K210-2</td>
<td>0.6-16.5</td>
<td>0.9-5.6</td>
<td></td>
<td>-</td>
</tr>
<tr>
<td>NA-4 Controller</td>
<td>K388-2</td>
<td>0.6-16.5*</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
<tr>
<td>NA-5 Controller</td>
<td>K396-2</td>
<td>0.6-10.8*</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
<tr>
<td>NA-35/NA-4 Head</td>
<td>K398A</td>
<td>0.6-7.4</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
<tr>
<td>NA-35F/NA-4F Head</td>
<td>K399A</td>
<td>0.6-7.4</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
<tr>
<td>NA-55 Head</td>
<td>K436A</td>
<td>0.6-10.7</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
<tr>
<td>NA-55F Head</td>
<td>K437A</td>
<td>0.6-10.8</td>
<td>2.4-5.6</td>
<td>142.1</td>
<td>95.1</td>
</tr>
</tbody>
</table>

**LT-7 Tractor**

**Submerged Arc Wire Feeder**

The LT-7 Tractor is a self-propelled mechanized wire feeder, designed for the submerged arc process with track system capabilities. It is self-guiding and easy to operate – only one operator is usually required.

**Features**
- Feeds 2.4-4.8 mm solid wires, from 2.5-10.2 m/min wire feed speed.
- Calibrated tractor drive adjusts travel speeds from 0.12-1.8 m/min.
- Vertical head lift adjuster for adjusting electrical stick-out from 12.7-1270 mm.
- Weld angle is up to 50° from vertical on either side; drag angle is up to 30° from vertical.
- Control box can be mounted either left or right, eliminating the need to return to the power source for routine procedure changes.
- Welds butts, horizontal fillet and lap joints to the left or right side of the tractor frame for convenience.

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Output Capacity</th>
<th>Wire Feed Speed Range (m/min)</th>
<th>Wire Size Range (Solid mm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LT-7 Track Model</td>
<td>K395-1</td>
<td>600A/700%</td>
<td>2.5-10.2</td>
<td>2.4-4.8</td>
<td>59</td>
<td>689X818X356</td>
</tr>
</tbody>
</table>
### Accessories

#### K29 - Vertical Lift Adjuster
- Provides 102 mm hand crank vertical adjustment of head position. Also includes up to 95.2 mm in-and-out horizontal adjustment with stops that can be preset for simple repetition of the same adjustment.

#### K219 - Automatic Flux Hopper Assembly
- For submerged arc welding. Includes electric flux valve.

#### K230 - Butt Seam Guide Kit
- Mount in place of the standard front wheel to ride in a V-groove or open 3.2-9.5 mm butt joint, keeping the wire in required alignment.

#### K231-1 - Submerged Arc Contact Nozzle Assembly
- For 2.0 through 4.8 mm wire electrode at currents generally below 600 amps. Outer flux cone gives full flux coverage with minimum consumption.

#### K232 - Horizontal Fillet and Lap Adapter Kit
- Includes a rear guide wheel, head tension spring and front guide wheel assembly on an adjustable arm which rides in the joint to maintain alignment and electrode angle. Kit includes separate front guide wheel assemblies for fillet and lap joints. Welds to the left or right of the tractor's center line.

#### K285 - Concentric Flux Cone Assembly
- For use with K148B, Positive Contact Nozzle Assembly. Provides concentric flux coverage around the electrode.

#### K299 - Wire Reel Assembly
- Includes wire reel for 22.7-27.2 kg coils, wire reel mounting and brake.

#### K3090-1 - Tube and Clamp Kit
- One 760 mm aluminum splined tube; two 380 mm aluminum splined tubes; one 760 mm steel tube; 8 clamp assemblies with keys; 2 outrigger assemblies; hardware.

#### K3089-1 - Cross Slide Assembly
- Includes: two slides with 100 mm of travel (1 cross slide assembly included with each tractor).

#### K3070-1 - Tiny Twin Kit for Cruiser™
- Includes a second spindle, drive rolls and 95:1 gears.

#### K3019-1 - Arc Tracker™
- Connect the Arc Tracker™ between any DC welding power source and the work clamp to access a wide array of data monitoring information regarding your welding arc, including True Energy™ and Production Monitoring™.

#### K3012-1 - Butt Joint Guide Kit
- Used to track the joint and guide the Tandem Cruiser™ for plate and deck applications.
ENGINE DRIVEN WELDERS
World’s Most Respected Products Among Pipe Welders
Built Tough for Extreme Environments
Strong Arc Gouging Capability
Engine Driven Welders

**Ranger® 305D**
300A DC diesel engine driven welder

**Vantage® 410 CE & Vantage® 500 CE**
Compact, multi-process, excellent value

---

### Cable Kits

#### Ground/Electrode

With ground cable & electrode holder (clamp)

- **KIT-300A-50-5M** (300A – 50 mm² – 5 m)
- **KIT-400A-70-5M** (400A – 70 mm² – 5 m)

#### Cable Kits

- **GRD-300A-50-5M** (300A – 50 mm² – 5 m)
- **GRD-300A-50-10M** (300A – 50 mm² – 10 m)
- **GRD-400A-70-10M** (400A – 70 mm² – 10 m)

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### Remote Controls

1 potentiometer, 6-pins, 15 m

- Item n°: K10095-1-15M

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### Undercarriages

#### Medium Two Wheel Trailer
For heavy duty road, off-road, plant and yard use. For Vantage.
- Item n°: K2636-1

#### Four-Wheeled Steerable Yard Trailer
For off-road, plant and yard use. Includes an automatically engaging drawbar lock when the drawbar is raised to the vertical position.
- For Vantage.
- Item n°: K2641-1

#### Undercarriage for site towing
For Ranger 305D
- Item n°: K10397-1

---

### Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.

- Item n°: K10405-1 for Ranger 305D
- K903-1 for Vantage

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**Output Modes**

<table>
<thead>
<tr>
<th>Commercial</th>
<th>Commercial</th>
<th>Commercial</th>
<th>Commercial</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ranger® 305D</td>
<td>Vantage® 410 CE</td>
<td>Vantage® 500 CE</td>
<td>Output Input Process</td>
</tr>
<tr>
<td>CC/CV DC</td>
<td>CC/CV DC</td>
<td>CC/CV DC</td>
<td>30-410 30-500 40-300 20-250 13200 14500</td>
</tr>
<tr>
<td>Pipe</td>
<td>Pipe</td>
<td>Pipe</td>
<td>Stick</td>
</tr>
<tr>
<td>20-305 40-300 20-250</td>
<td>20-305 40-300 20-250</td>
<td>20-305 40-300 20-250</td>
<td>8000</td>
</tr>
</tbody>
</table>

**KEY:** Excellent ● Good ▲ Possible
Ranger® 305D
300A DC diesel engine driven welder

The Ranger® 305 D CE is a powerful 300 amps DC multi-process diesel engine driven welder. It provides excellent arc characteristics in Stick (Conventional or Pipe), TIG, MIG or Arc Gouging. The Ranger is totally enclosed to protect the 45 litre fuel tank, water-cooled Kubota 18.8 HP D722 diesel engine. Delivering 8000 Continuous (8500 peak) watts of 115/230/400V AC generator power it is obvious this was designed for welding professionals with high demands.

Features
- Excellent DC multi-process welding for general purpose stick, downhill pipe [stick], TIG, cored-wire, MIG (100% CO₂ and mixed gas) and arc gouging with up to 4.8 mm carbons.
- Fully enclosed stainless steel case for equipment protection and low noise.
- Lincoln’s® Chopper Technology® provides easy starts, a smooth arc, low spatter and excellent bead appearance.
- A portable powerhouse-delivers 8,500 peak (8,000 continuous) watts of 115/230/400V 50Hz AC generator power. Enough power to run lights, tools, or pumps and weld all at the same time!
- Arc force control provides a soft or more forceful digging arc.
- Built-in “hot” start for easier starts and restrikes.
- Touch-Start DC TIG®—Lift tungsten to start the arc.
- Digital meters for amps and volts output make it easy to precisely set your procedures.
  Fuel gauge, engine protection light for oil pressure and engine temperature on top for monitoring engine performance.
- Lift TIG DC capability (SA).

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Current Range (A)</th>
<th>Rated Output</th>
<th>Type of Engine</th>
<th>Cylinders</th>
<th>Operation Speeds (rpm)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
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</thead>
<tbody>
<tr>
<td>Ranger® 305D</td>
<td>K2279-3</td>
<td>20-305 DC</td>
<td>250A/30V/100%</td>
<td>Kubota D722</td>
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<td>909 x 546 x 1327</td>
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<td>40-300 pipe welding</td>
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<td>Full load: 3000</td>
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<td></td>
<td></td>
<td>20-250 DC TIG</td>
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<td>Low idle: 2200</td>
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</table>
Vantage® 410 CE
Vantage® 500 CE

Compact, multi-process, excellent value

The Vantage® 410 CE and 500 CE are one of the most compact and powerful engine-driven welders / generators in the construction, pipe or rental fleet market today. They are also the most quiet with a smooth running 4-cylinder water-cooled diesel engines. Use these multi-process welders for Stick welding with a large variety of electrodes, lift TIG welding, CV welding with shielding gas or Innershield wires and arc gouge up to 8 mm carbons for Vantage 410 and 10 mm carbons for Vantage 500. You will value the superior arc performance delivered by exclusive Lincoln Chopper Technology. You will also appreciate VRD™ (Voltage Reduction Device™) which reduces OCV (open circuit voltage) in the CC-Stick weld mode for added safety.

Features
• Compact case with stainless steel enclosure.
• Arc gouging up to 8mm (V410) and 10mm (V500).
• Downhill pipe welding mode. Excellent for cellulosic electrodes.
• Built-in “Hot Start” for easier starts and restrikes.
• Plenty of AC 50 Hz generator power: 3-phase 400V / 1 phase 220V / 1 phase 115V.
• Reliable Four-Cylinder Engine, water cooled.
• Innovative Service Access.
• Stainless steel enclosure delivers added protection and durability.
• Low noise to fit with European norms.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Current Range (A)</th>
<th>Rated Output (A)</th>
<th>Type of Engine</th>
<th>Cylinders</th>
<th>Operation Speeds (rpm)</th>
<th>Weight (kg)</th>
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<td>30-410</td>
<td>390A/32V/100%</td>
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<td>Vantage® 500 CE</td>
<td>K2503-3</td>
<td>30-500</td>
<td>400A/36V/100%</td>
<td>Perkins 404D-22 TURBO Diesel</td>
<td>4</td>
<td>Full load: 1800 Low idle: 1500</td>
<td>586</td>
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</table>
PLASMA CUTTING SYSTEMS
Portable Cutting Power
High Travel Speeds
Great for Hobby, Farm, Autobody or Industrial Use
### Plasma Cutters

**Invertec® PC-210**
Portable cutting power up to 10 mm

**Tomahawk® 1025, Tomahawk® 1538**
High Performance Plasma Cutting

<table>
<thead>
<tr>
<th>Mode</th>
<th>Polarity</th>
<th>Output Range (Amp)</th>
<th>Cutting Thickness (mm)</th>
<th>Cut</th>
<th>Arc Gouge</th>
<th>Pierce</th>
<th>Warranty (years)</th>
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<tbody>
<tr>
<td>Inverter 1Ph</td>
<td>CC</td>
<td>10-25</td>
<td>10</td>
<td>⚫</td>
<td>⚫</td>
<td>⚫</td>
<td>2</td>
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<tr>
<td>Inverter 3Ph</td>
<td>CC</td>
<td>25-60</td>
<td>25</td>
<td>⚫</td>
<td>⚫</td>
<td>⚫</td>
<td>3</td>
</tr>
</tbody>
</table>

**CUTTING CIRCLES**

- Item n°: W0300699A

**UNDERCARRIAGES**

- 2-wheeled cart, delivered as a kit, for use with PC210 Item n°: W0200002

- 4-wheeled undercarriage with gas cylinder platform delivered as a kit, for use with Tomahawk®. Item n°: K2694-1

**AIR FILTER LAF1250**

Sub-micron filter for compressed air. It is designed to remove moisture, oils and sprays particles from air compressors, thus providing clean, free of oil and dry air. Item n°:

- W88X1456A
- W8800117R (filter cartridge)

**TORCHES**

- **Hand torches PC210**
  - PTH-C25A-C5L-3MR LC25, 3 m

- **Hand torches TH1025**
  - PTH-061A-CX-7M5A LC65, 7.5 m
  - PTH-061A-CX-7M15A LC65, 15 m

- **Automatic torches TH1025**
  - PTM-061A-CX-7M5A LC65M, 7.5 m
  - PTM-061A-CX-7M15A LC65M, 15 m

- **Hand torches TH1535**
  - PTH-101A-CX-7M5A LC105, 7.5 m
  - PTH-101A-CX-7M15A LC105, 15 m

- **Automatic torches TH1535**
  - PTM-101A-CX-7M5A LC105M, 7.5 m
  - PTM-101A-CX-7M15A LC105M, 15 m
Invertec® PC-210

Portable cutting power up to 10 mm

The Plasma PC-210 is the most flexible plasma cutting machine you could envisage. The unit arrives ready to go, able to cut fast and precisely. Powered from a standard 230V input supply, the machine is ideal for work on site. With the PC-210 cutting need no longer be a problem, forget the grinder, simply take the torch and cut in seconds. This inverter based machine is equipped with an integrated air compressor. This provides maximum flexibility without the need for a separate compressed air supply. And, with a weight of only 18.5 kg combined with its small size, this versatile machine can be used anywhere, anytime.

Features

• Flexible: only 230V input required.
• High performance: innovative advanced electrode and nozzle design.
• Robust: long life compressor.
• Portable: only 18.5 kg, small and compact.
• Different materials: mild steel, stainless steel, aluminium and many more.
• Concentrated plasma stream: less heat input, less distortion.

Technical Specifications

Product | Item Number | Primary Voltage (50-60Hz) | Rated Output | Cutting Capacity (mm) | Flow Rate | Inlet Pressure | Output Range [A] | Weight (kg) | Dimensions HxWxD (mm)
---|---|---|---|---|---|---|---|---|---
Invertec® PC210 | K12038-1 | 230V/1Ph | 25A/30V/15% 20A/22/25% 15A/26/30% | 10 | 80l/min/- 10% @5.0bar | 10-25 | 18.5 | 385 x 215 x 480

Processes

• Air plasma cutting
• Gouging

Unit Includes

• 2 m-input cable
• 3 m-hand cutting torch
• Ground clamp and cable
• Air connection kit
• Cutting torch consumables kit

Key Options

• W88X1456A Air Filter LAF1250
• W8800017R Filter Cartridge
• PTH-C25A-SL-3MR Plasma torch
• W0100699A Cutting circle
• W0200002 Undercarriage

Applications

• On site maintenance
• Service tasks
• Small construction sites
• General installations
• Air ducting installation [HVAC]
• Demolition work
• Rental

Using internal compressor: recommended up to 10 mm mild steel.
Can also be used with an external-compressor: recommended up to 10 mm mild steel.

www.lincolnelectriceurope.com
**Tomahawk® 1025**
**Tomahawk® 1538**

**High Performance Plasma Cutting**

The Tomahawk® 1025 and 1538 Plasma cutting machines are built to handle harsh environmental conditions using Lincoln tunnel technology to separate the PCB’s and sensitive parts from the contaminating cooling airflow. The improved mains voltage tolerances and robust metal case with large protective rubber corners also make these machines suitable for operation on site with a generator or within a workshop environment.

The Lincoln Tomahawk® concept for Plasma cutting focuses on three elements:

S – An innovative and patented striking system preserves the electrode tip and extends its lifetime.

P – Circular enhancements with improved radial airflow and innovative electrode/nozzle design concentrate the plasma stream.

L – The internally cooled electrode and torch head and electrode/nozzle design considerably increase their lifetime.

**Features**

- Starting: innovative advanced arc starting without HF.
- Performance: innovative advanced electrode and nozzle design.
- Longer lifetime: innovative advanced design increases lifetime of consumables.
- Faster: higher travel speeds and plate thickness.
- Flexible: multiple torch configurations.
- Different materials: mild steel, mtainless mtel, aluminium and many more.
- Concentrated plasma stream: less heat input, less distortion.

---

**Technical Specifications**

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Rated Output</th>
<th>Cutting Capacity (mm)</th>
<th>Flow Rate</th>
<th>Inlet Pressure</th>
<th>Output Range (A)</th>
<th>Weight (kg)</th>
<th>Dimensions HxWxD (mm)</th>
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<td>K12048-1</td>
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<td>60% / 40%</td>
<td>60 / 70%</td>
<td>25</td>
<td>180 / 180 / 180</td>
<td>50 / 60 / 50</td>
<td>22</td>
<td>389 x 247 x 489</td>
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<tr>
<td>Tomahawk® 1538</td>
<td>K12039-1</td>
<td>400V/3Ph</td>
<td>60% / 40%</td>
<td>60 / 70%</td>
<td>40</td>
<td>280 / 280 / 280</td>
<td>50 / 60 / 50</td>
<td>36</td>
<td>455 x 301 x 618</td>
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</table>

---

**Processes**

- Plasma air cutting
- Gouging

**Unit Includes**

- 2 m-input cable
- 3 m-hand cutting torch
- Ground clamp and cable
- Air connection kit
- Cutting torch consumables kit

**Key Options**

- K12049-1 Remote control (TH1538)
- W05X1086A Remote Control Kit
- W0300699A Cutting circle
- K2694-1 Undercarriage (TH 1025)
- W0801076A Air Filter LAF1250
- W080103R Filter Cartridge
TRAINING EQUIPMENT
Revolution in Welding Education
Anyone who interfaces with the manufacturing sector knows this cold, hard fact: we need more people, we need more investment in training and we need them now.

Consider this – more than 600,000 skilled positions are unfilled in the United States.

The manufacturing sector needs to improve its image in order to draw future workers to these skilled trades.

**THE QUESTION: HOW?**
**THE ANSWER: VIRTUAL REALITY WELDING**

More than 80 percent of U.S. employers report they have a moderate to severe shortage of skilled workers.

In a world where skilled labor shortages are rising, the investment and need to not only train but also attract and engage new skilled workers is at an all-time high.

Today’s youth — the future workforce — relies on the virtual world. This means the tactics to engage and interest them in learning the skills needed for future careers need to change.

Virtual reality welding is ideal as:
- An interactive, engaging teaching tool.
- An HR screening tool for testing applicants’ welding skills.
- A tool for refreshing the welding skillset and knowledge of an existing workforce.
The systems offer hands-on training that’s consistent with standard industry methodology and evaluation criteria in a fun “gaming” inspired environment, thanks to a speciallyequipped virtual reality welding helmet.

**VRTEX® welding training simulators:**
- Attract and engage students.
- Measure and record real-time results.
- Enhance welding training programs.
- Reduce energy consumption, waste and scrap.
- Provide tangible savings.
All the VRTEX® 360, VRTEX® Mobile and VRTEX® Engage™ systems have rich, vivid graphics and feature real-world welding and fume removal equipment.
ENGAGING. EXCITING. ENHANCING.

In today’s digital society, virtual training systems allow students of any age to try welding in a safe, virtual environment with realistic imagery and scenes, from a military base to a motorsports garage.

**VRTEX® simulators can be used at:**

- College fairs and recruitment events
- Open houses
- Trade shows
- Seminars

**VRTEX’s virtual environments are realistic...and fun.**

Students have access to the THEORY functionality which provides on-screen welding terminology and definitions to enhance additional comprehension.
INCREASED COMPREHENSION THROUGH INTERACTION

Virtual reality welding training doesn’t replace hands-on welding — it enhances it.

People will line up to try their hand at virtual welding and learn about what it takes to build a career as a skilled trades worker.

The VRTEX® system even replicates proper machine set-up. Before they can “weld”, students must enter the proper material type, process, gas flow and amperage / voltage / wire-feed speed into the system.

Connect a projector or large LCD display to the VRTEX® unit so an entire classroom can see what the welder sees under the helmet. This brings a sense of teamwork to the learning process and increases comprehension through interaction. Multiple views show accurate, real-time measurement of such key variables as contact tip to work distance, work angle, travel angle, travel speed and position.
Challenging out-of-position welding training becomes simple with VRTEX®. Students understand what they will see and what it will feel like before they ever pick up a real welding gun.
EFFECTIVE RESULTS EXPLAINED TO THE REAL WORLD

From a realistic welding puddle to accurate sounds and movements, what students learn virtually with VRTEX® seamlessly transfers into real-world, hands-on welding training.

Students move from a VRTEX® machine and into a real welding training booth feeling confident about set-up and welding procedures.

Efficient Virtual Learning = Reduced Costs, Improved Safety

Using VRTEX® as the first-line training method helps reduce waste and scrap, to create a cleaner training environment.

Students can practice repetitive welding without the time needed to tack plate and toss scrap. There’s no real coupon – only one that appears virtually – and quickly -with the press of a button.
VRTEX® 360
Engaging. Exciting. Enhancing

In today’s digital society, virtual training systems allow students of any age to try welding in a safe, virtual environment with realistic imagery and scenes, from a military base to a motorsports garage. VRTEX® simulators can be used at:
• college fairs and recruitment events,
• open houses,
• trade shows,
• seminars.

The systems offer hands-on training that’s consistent with standard industry methodology and evaluation criteria in a fun “gaming” inspired environment, thanks to a specially equipped virtual reality welding helmet. VRTEX® welding training systems:
• attract and engage students,
• measure and record real-time results,
• enhance welding training programs,
• reduce energy consumption, waste and scrap,
• provide tangible savings.

Features

• Full featured, advanced and scalable welding simulator.
• Rich, vivid graphics and feature real-world welding and fume removal equipment.
• Students have access to the THEORY functionality which provides on-screen welding terminology and definitions to enhance additional comprehension.
• Virtual reality welding training doesn’t replace hands-on welding – it enhances it.
• The VRTEX® system even replicates proper machine set-up. Before they can “weld”, students must enter the proper material type, process, gas flow and amperage / voltage / wire-feed speed into the system.
• Connect a projector or large LCD display to the VRTEX® unit so an entire classroom can see what the welder sees under the helmet.
• Multiple views show accurate, real-time measurement of such key variables as contact tip to work distance, work angle, travel angle, travel speed and position.

Additional Features

• Advanced Scoring Module (ASME/D1.1)
• AWS Bend Test
• GMAW Aluminium
• GMAW Stainless

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Input Current</th>
<th>Positions</th>
<th>Dimensions HxWxD (mm)</th>
<th>Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>VRTEX® 360 Std.</td>
<td>AD2433-1</td>
<td>115/230/1/50/60</td>
<td>4A @ 115, 2A @ 230</td>
<td>1G/PA, 2F/PB, 2G/PC, 3F/PG, 3G/PG, 4F/PD, 4G/PE</td>
<td>Machine: 1803 x 762 x 1270; Stand: 1191 x 590 x 1194</td>
<td>Machine: 163; Stand: 46</td>
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<tr>
<td>VRTEX® 360 Alt.</td>
<td>AD2433-2</td>
<td>115/230/1/50/60</td>
<td>4A @ 115, 2A @ 230</td>
<td>1G/PA, 2F/PB, 2G/PC, 3F/PG, 3G/PG, 4F/PD, 4G/PE</td>
<td>Machine: 1803 x 762 x 1270; Stand: 1191 x 590 x 1194</td>
<td>Machine: 163; Stand: 46</td>
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<tr>
<td>VRTEX® 360 Std. ONE-PAK**</td>
<td>AD2434-1</td>
<td>115/230/1/50/60</td>
<td>4A @ 115, 2A @ 230</td>
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<td>Machine: 1803 x 762 x 1270; Stand: 1191 x 590 x 1194</td>
<td>Machine: 163; Stand: 46</td>
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<tr>
<td>VRTEX® 360 Alt. ONE-PAK**</td>
<td>AD2434-2</td>
<td>115/230/1/50/60</td>
<td>4A @ 115, 2A @ 230</td>
<td>1G/PA, 2F/PB, 2G/PC, 3F/PG, 3G/PG, 4F/PD, 4G/PE</td>
<td>Machine: 1803 x 762 x 1270; Stand: 1191 x 590 x 1194</td>
<td>Machine: 163; Stand: 46</td>
</tr>
</tbody>
</table>

* ONE-PAK models include VRTEX 360 system + Upgrade 2, 3, 4 & 5 + K3205-1 + K4057-1 + K4057-2 + K4058-1 + K3206-1
The VRTEX® Mobile is a basic, entry level welding training system. It is designed to provide mobility in an easy to use and engaging welding training tool. The VRTEX® Mobile is ideal for initial, basic welding training, as a recruitment and engagement tool for educational and industry and for employment and screening for human resources or as an evaluation tool for instructors and educators to get a baseline on student knowledge.

**Features**
- Easily transported from classroom to classroom or to a recruitment event or open house. The VRTEX® Mobile can be ready to go in a matter of minutes.
- Touchscreen user interaction provides equipment and procedural set-up on an intuitive, resistive touchscreen. All screens mirror the VRTEX® 360, making transfer of interaction seamless between the systems.
- Universal gun handle allows to connect of a MIG/MAG gun attachment for GMAW and FCAW welding and an optional accessory for SMAW.
- Tabletop coupon stand easily attaches and stands on a standard table for welding and is taken apart for quick and simple storage inside the VRTEX® Mobile.
- Consumable and environmental savings
  - No welding consumables, wire or waste
  - Track savings with the Weldometer™.

**Additional Features**
- No software upgrade package

<table>
<thead>
<tr>
<th>Technical Specifications</th>
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</thead>
<tbody>
<tr>
<td><strong>Product</strong></td>
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<tr>
<td>VRTEX® Mobile Standard frequency</td>
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<tr>
<td>VRTEX® Mobile Alternate frequency</td>
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<tr>
<td></td>
</tr>
</tbody>
</table>
VRTEX® Engage™

Welding starts here

For some, the first step into the virtual learning environment can be a big one. Lincoln Electric makes that first step easier with VRTEX® Engage™. This standalone foundational system is designed to introduce students to the skilled trades – specifically arc welding. VRTEX Engage includes a touch screen monitor, welding gun, tracking device and a work surface. It’s all contained in a lightweight and portable carrying case that can be deployed in any setting – industrial, educational or elsewhere.

VRTEX Engage is a cost-effective tool designed to help educators train welders more efficiently and engage students to explore a career in welding. The system addresses introductory welding lessons, including safety, machine and process selection, welding procedure set up, welding theory and more. The road to educating a skilled welding workforce starts with one small step. Make that small step a giant leap with VRTEX Engage.

Features

• Learn Anywhere – sets up anywhere to introduce skilled trades to students who are ready to explore a possible career in welding or consider degree programs in engineering and related fields.

• Capable Education Tool – provides instant feedback and assessments on safety and correct welding procedure settings.

• One Small Step – provides an introductory environment that incorporates STEM features, exposure to welding safety, procedures and techniques.

• No Fees. No Waste – helps your program reduce overall operating costs, as there is NO waste – no use of steel, electrodes, wire, shielding gas. And, with VRTEX Engage, there is no licensing requirement and no annual fees.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Input Power</th>
<th>Input Current</th>
<th>Operating System</th>
<th>Processor / Memory</th>
<th>Hard Drive</th>
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<td>K4299-1</td>
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<td>1A @ 115, 0.5A @ 230</td>
<td>MS Windows® 7 Professional 32-bit</td>
<td>Intel® Core® i5 Quad / 4GB</td>
<td>128 GB Solid State Drive</td>
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</tr>
</tbody>
</table>

Processes

• GMAW
• FCAW-ES
• FCAW-SS
• SMAW

Components and Specifications

• MS Windows® 7 Professional 32-bit
• Intel® Core® i5 Quad Core processor
• 4GB DDR memory
• 128 GB Solid State Drive
• 2GB high-powered graphics card

Monitor

17” LCD monitor – resistive touch screen

Speakers

USB 2.0 powered speakers

VRTEX Welding Transfer Modes

Simulates short arc, spray and pulse

Language Support

English, French, German, Spanish, Turkish, Japanese, Chinese (Mandarin), Portuguese (Brazilian), Russian, Korean, Hindi and Arabic.

Item Number

• K4299-1 Standard Frequency
• K4299-2 Alternate Frequency 1
• K4299-3 Alternate Frequency 2
• K4299-4 Alternate Frequency 3
WELD FUME CONTROL
Reduces Welding Fume and Dust in The Workplace
Portable, Wall-Mounted or Shop-Wide Systems
Lincoln Electric offers a complete line of portable, stationary and engineered solutions for welding fume control – mobile, stationary, downdraft and engineered systems.

**Mobile**

Mobile welding fume extractors with filtration are lightweight and rugged and are designed for light to medium duty welding fume extraction. The portable, lightweight solution is for the removal and filtration of welding fumes. This solution is ideal for facilities that require welding fume extraction in multiple locations.

**Stationary**

Wall mounted, low vacuum systems are designed for extraction and filtration of welding fume. When used in conjunction with the LFA series of arms they provide welders with optimal motion and reach for their specific welding position(s) and work area. Ideal for a variety of facilities including maintenance departments, general fabrication and welding job shops, weld schools and industrial welding environments.

**Downdraft**

Lincoln Electric’s DownFlex® table are dual purpose work bench and extraction units, designed specifically for the removal of welding fume at the source. It can also be used to remove particulate and dust from metal grinding applications and light duty plasma arc cutting.
Mobile / Portable Units

Lightweight, rugged design, low vacuum/high volume filtration system designed for extraction and filtration of welding fume. Ideal for facilities that require welding fume extraction in multiple locations, including maintenance departments, general fabrication and job shops and industrial welding environments. Perfect choice for small shops or companies with few welding stations, yet lightweight and small enough to be easily carried to the welding area.

Portable Units

The Miniflex® is ideally used for:
- Contractors
- Maintenance Workers
- Small To Medium Fabrication Shops
- Home Hobbyists

Miniflex®

Portable Welding Fume Extractors

Miniflex® is a high vacuum system designed for the removal and filtration of welding fumes from light duty welding applications. The Miniflex® excels in performance and ease of handling. It can be completely disassembled in a matter of minutes for cleaning and maintenance. The convenient automatic start/stop function can extend the life of the motor brushes and reduces energy consumption, supplied as standard with:

- LongLife-H filter, filter surface 12 m²
- HEPA filter
- Aluminium prefilter
- Automatic start / stop
- Set of wheels
- Extraction hose 2.5 m
- 2 sets carbon brushes
- Capacity: 2 x 1000W
Mobile Units

The Mobiflex® is ideally used for:
• Small Manufacturing Facilities
• Schools / Training
• Fabrication
• Plant Maintenance & repair

Mobiflex®
Portable Welding Fume Extractors

The Mobiflex® 200-M, 300-E and 400-MS are low vacuum systems for welding fume extraction and filtration. Their size and mobility make them ideal for smaller manufacturing facilities that require light to medium duty welding fume extraction in variable locations.

Mobiflex® 100-NF Portable fan
Portable extraction fan with a free-blowing capacity of 2400 m³/h. Including 6 m mains cable and motor protection switch.

Technical Specifications
• Power Consumption – 0.75kW
• Capacity – Max. Approx. 1300 m³/h at the nozzle (with 5 m hose)
• Free-blowing Capacity – Max. 2400 m³/h
• Maximum Length of Configuration – up to 20 m
• Hose Diameter – Ø 160 mm

Applications
All welding processes in enclosed areas such as pipes, containers, tank trucks and ship hulls.

Mobiflex® 200-M
Mobile unit with 50 m² LongLife filter with filter pollution indicator, supplied with 5 m mains cable.

Technical Specifications
• Power Consumption – 0.75 kW
• Capacity – Max. Approx. 1250 m³/h at the hood
• Arm – Ø 203 mm with rotatable hood and throttle valve

Hose – Ø 203 mm
• Filter efficiency – up to 99%

Applications
• MIG/MAG solid wire < 700 kg/year
• MIG/MAG flux cored wire < 500 kg/year
• Rutile Electrodes < 500 kg/year
• Basic Electrodes < 500 kg/year
• Not suitable for oil treated metals

Mobiflex® 300-E
Mobile unit with 14.2 m² electrostatic filter (consisting of an ionizing cell and industrial collector) and metallic preimposed filter, supplied with 5 m mains cable.

Technical Specifications
• Power Consumption – 0.75 kW
• Capacity – Max. Approx. 1300 m³/h at the hood
• Arm – Ø 203 mm with rotatable hood and throttle valve

Hose – Ø 203 mm
• Filter efficiency – up to 99%

Applications
• MIG/MAG solid wire > 700 kg/year
• MIG/MAG flux cored wire > 500 kg/year
• Rutile Electrodes > 500 kg/year
• Basic Electrodes > 500 kg/year
• Not suitable for oil treated metals
• Dry, oil-free compressed air 4-5 bar connection required
Stationary Units

Wall mounted, low vacuum systems are designed for extraction and filtration of welding fume. When used in conjunction with the LFA series of arms they provide welders with optimal motion and reach for their specific welding position(s) and work area. Ideal for a variety of facilities including maintenance departments, general fabrication and welding job shops, weld schools and industrial welding environments.

The Statiflex® is ideally used for:
• General fabrication
• Job shops
• Welding schools
• Maintenance departments

Statiflex® 400-MS
The Statiflex 400-MS stationary, wall-mounted low vacuum system is intended for light to medium duty extraction and filtration of welding fume. The Statiflex is designed for facilities with fixed work stations and little available floor space. A self-cleaning filter is standard on the Statiflex 400-MS

Applications
• MIG/MAG solid wire > 700 kg/year
• MIG/MAG flux cored wire > 500 kg/year
• Rutile Electrodes > 500 kg/year
• Basic Electrodes > 500 kg/year
• Not suitable for oil treated metals.
• Dry, oil-free compressed air 4-5 bar connection required.

Statiflex 400-MS is to be connected to a CB control box.

Statiflex® 300-E
Industrial air cleaner with electrostatic filter. To be installed in ductwork or to be connected to extraction arm(s) with fan. Including oil collector. Possibility to install an oil drainer. Filters included: FIS and FCS; pre and final filters to be ordered separately. No fan included. Max. filter capacity: 2500 m³/h. Filter surface area: 14.2 m².

Applications
• Oil Treated Metals

Statiflex® 200-M
Stationary welding fume filter with disposable LongLife filter cartridge.

Filter surface area 50 m² with ExtraCoat treatment. Including filter pollution indicator. No voltage required.

Applications
• MIG/MAG solid wire < 700 kg/year
• MIG/MAG flux cored wire < 500 kg/year
• Rutile Electrodes < 500 kg/year
• Basic Electrodes < 500 kg/year
• Not suitable for oil treated metals

Statiflex® Wall-Mounted Welding Fume Extractors

The Statiflex® base units are stationary, wall-mounted low vacuum systems designed for light to medium duty extraction and filtration of welding fume.
Downdraft Tables

Lincoln Electric’s DownFlex® table are dual purpose work bench and extraction units, designed specifically for the removal of welding fume at the source. It can also be used to remove particulate and dust from metal grinding applications and light duty plasma arc cutting.

The DownFlex® downdraft table is ideally used for:
- Welding
- Plasma Cutting
- Grinding *(1)*

*(1)* Not suitable for grinding Aluminium, Magnesium, or other explosive materials

DownFlex®

Dual Purpose Workbench & Extraction Tables

The DownFlex® table is a compact table that can be placed in multiple locations around a welding shop. They combine a workbench and extraction unit designed specifically for the removal of welding fume. The DownFlex® tables can be used to remove particulate and dust from metal grinding applications, as well as fume and particulate from light duty plasma arc cutting.

DownFlex® 200-M
- Workbench with integrated extraction fan, 3-stage spark arrester and disposable filter cartridges.
- A Magnehelic gauge on the control panel indicates when the filter cartridges require replacement.
- For welding and grinding applications the downdraft table should be fitted with a backdraft kit for optimum division of the extraction capacity.
- Suitable for light to medium duty applications.

DownFlex® 400-MS
- Workbench with integrated extraction fan, 3-stage spark arrester and self-cleaning filter cartridges.
- The Magnehelic (pressure) gauge on the control panel indicates when the automatic filter cleaning systems needs to be switched on.
- The filter cartridges are cleaned from the inside by compressed airshots.
- For welding and grinding applications the downdraft table should be fitted with a backdraft kit for optimum division of the extraction capacity.
- Suitable for medium to heavy duty applications.

DownFlex® 400-MS/A
- Workbench with integrated extraction fan, 3-stage spark arrester and self-cleaning filter cartridges. The filter cartridges are cleaned automatically from the inside by compressed airshots.
- An integrated buzzer indicates when the filter cartridges need to be replaced.
- For welding and grinding applications the downdraft table should be fitted with a backdraft kit for optimum division of the extraction capacity.
- Suitable for heavy duty applications.

DownFlex® 100-NF
- Workbench, to be connected to an external extraction/filter system.
- Including backdraft kit and side panels. Extraction facility to be connected to air outlet on top of the backdraft panel.
- Contains no filters, but can be equipped with optional spark arresters to be mounted in the backdraft panel.
- Prepared for two optional dust containers

DownFlex® 400-MS
- Workbench with integrated extraction fan, 3-stage spark arrester and self-cleaning filter cartridges.
- The Magnehelic (pressure) gauge on the control panel indicates when the automatic filter cleaning systems needs to be switched on.
- The filter cartridges are cleaned from the inside by compressed airshots.
- For welding and grinding applications the downdraft table should be fitted with a backdraft kit for optimum division of the extraction capacity.
- Suitable for medium to heavy duty applications.

www.lincolnelectriceurope.com

rev.: E-WFEG5-EN-17-10-16
Modular Extraction Hood
An Innovative and Flexible Solution to Efficient Weld Fume Control

COMBINING INNOVATION AND SIMPLICITY, THE LINCOLN ELECTRIC MODULAR EXTRACTION HOOD PROVIDES A FLEXIBLE AND EFFICIENT OPTION FOR WELD FUME EXTRACTION IN A WORK ZONE WITH AUTOMATED EQUIPMENT.

The Modular Extraction Hood is an easy to install, customizable enclosure that helps provide a cleaner work environment for a variety of industrial processes. Designed and built to Lincoln’s rugged and dependable standards, these units are ideal for robotic and hard automation applications.

The Modular Extraction Hood is a reliable and practical solution to contain and extract welding, cutting, arc gouging and grinding fume from the work environment.

PROCESSES
The Modular Extraction Hood is appropriate for use with the following industrial welding and cutting processes: Stick, TIG, MIG, Flux-Cored, Plasma Cutting, Arc Gouging, Grinding9.

For applications in which a worker is inside the work zone, exhaust at the arc or a respirator may be necessary.
The Diluter™ System

Free standing general filtration system

The Diluter™ is a free-standing general filtration system that reduces the overall concentration of welding fume through continuous filtration and airflow. The product has been designed exclusively for extracting and filtering welding fume which is released during the most common welding fabrication processes. The system supplements the natural ventilation (draft) and/or forced ventilation (roof / wall fans) which may be present to reduce the overall concentration of welding fume in the workshop.

THE FOUR MAIN COMPONENTS:

1. Diluter™ Unit: Lincoln Electric’s unique Diluter™ air dispersion head re-circulates the cleaned air into the workspace by means of precisely controlled outlet nozzles.

2. Filter Unit: A stationary filter unit incorporating automatic pneumatic filter cleaning. Air is captured and cleaned in a 3-stage 150 m² filter system with an efficiency of 99.9%. The filter unit has an external compressed air connection and particulate is collected in a waste container that can be emptied easily.

3. Fan: Lincoln Electric utilizes a high-efficiency 10 Hp IE3 motor in combination with 50 Hz fan technology offering the same airflow as a traditional 60 Hz fan, but with less noise, less energy consumption and less required Hp.

4. Green-Drive™ Control System: Lincoln Electric’s Green-Drive Systems are on the cutting edge of fume technology control. Integrated controls continuously monitor system operation with a state-of-the-art pressure sensor and increase or decrease airflow to maintain the required performance levels. This results in energy savings of up to 50% and increased filter life of up to 30% over traditional on/off systems.

Benefits

- Cleaner work environment – Reduce dust and dirt in operator and surrounding work areas.
- Low cost installation – No ductwork required.
- Custom engineered to meet facility and application requirements.
- Easy installation – Position the unit on the floor, a platform or a mezzanine.
- Low noise level – Will not contribute to increased noise levels.

THE DILUTER TECHNICAL DATA

- Airflow: 6000 cfm
- Input Power: 380-480/3/50-60 Hz
- Maximum Fan Power Consumption: 10 HP (25 kW)
- Dimensions: H x W x D: 5245 x 1200 x 2438 mm
- Weight: 800 kg
- Maximum Noise Level: 68 dB(A) according to ISO 3746
- Throw of the air flow is adjustable from 15-50 m
- Operating Temperatures: Minimum: 5°C, Maximum: 45°C
- Drum Capacity: 100 liters
- Certification: System Controls-UL 508A, Fan Motor-UR, Frequency Inverter-UL
Push-Pull System

The solution for indoor air pollution in the industry

Extraction at source is impossible when welding large pieces of metalwork or when the welder needs to change his welding location frequently. In such cases, aerial extraction is the only way to tackle the layer of welding fumes. Lincoln developed the extremely effective push/pull-system especially for this purpose.

Lincoln’s push/pull-system consists of 4 components:

1. **Extraction (Pull)**: To move and extract the layer of particulate in a controlled direction, an extraction duct is designed according to your specific operation and facility layout. The extraction duct is provided with airflow grids.

2. **Filtration**: The extraction duct is connected to a self-cleaning filtration unit. As the particulate moves through the extraction duct, it is collected on the filter media which is periodically cleaned by an automated, pneumatic cleaning system.

3. **Fan**: The continuous extraction (pulling), filtration and re-circulation (pushing) process is generated by a fan unit specifically sized for the system and positioned downstream from the filtration unit. To significantly reduce the system’s noise level, the fan is mounted in a sound absorbing enclosure and powered and controlled by intelligent controls.

4. **Re-circulation (Push)**: Once the particulates have been filtered, the filtered air can be re-circulated. By re-circulating the air, energy cost savings, specifically in climate controlled environments, can be recognized.

**Benefits**

- **Cleaner work environment** – Reduce dust and dirt in operator and surrounding work areas.
- **Custom engineered to meet facility and application requirements**.
- **Easy installation** – Position the filter and fan unit on the floor, a platform or a mezzanine.
- **Low noise level** – Will not contribute to increased noise levels.

**PUSH/PULL SYSTEM SPECIFICATIONS:**

- **Airflow**: 6000 cfm
- **Input Power**: 380-480/3/50-60 Hz
- **Maximum Fan Power Consumption**: 10 HP (7.5 kW)
- **Dimensions**: H x W x D: 2865 x 1200 x 2438 mm
- **Ducting Height**: 4-6 m
- **Weight**: 620 kg, does not include ducting or in/outlet grids
- **Maximum Noise Level**: 68 dB(A) according to ISO 3746
- **Throw of the air flow** is adjustable from 5-23 m
- **Operating Temperatures**: Minimum: 20°C, Maximum: 45°C
- **Drum Capacity**: 100 liters
- **Certification**: System Controls-UL 508A, Fan Motor-UR, Frequency Inverter-UL
- **Cover Area**:
  - Minimum Length: 10 m
  - Maximum Length: 50 m
  - Minimum Width: 5 m
  - Maximum Width: 23 m

**Suitable solutions for all circumstances**

Some examples of push/pull-systems incorporating Lincoln’s SCS filter units and the FAN 120 fans are given below:

- U-shaped push/pull-system with 1 filter unit and 1 fan.
- Double-parallel push/pull-system with 2 filter units and fans.
- Composite system.
HARD AUTOMATION
Lincoln Electric offers solutions for HARD AUTOMATION systems which encompasses fixed automation and programmable automation products including automatic welding equipment, wire feeders, process controllers, positioners, workholding devices, welding consumables and bolt-on accessories.

Lincoln offers a full range of Pre-Engineered & Custom Products and Services:

- Welding Gantries
- Tank Welders
- Pipe Welders
- Column and Boom Systems
- Turntables and Positioners
- Welding Lathes
- Rollerbeds

**Power Sources**

Multi-process transformer and inverter Power Sources cover all requirements presented. User friendly designs allow a wide variety of weld procedures to produce consistent, quality welds.

**Column & Boom Manipulators**

The vibration free column and boom can be used for positioning the weld head for the automated welding of a variety of work pieces from small pipe to large tanks. Both longitudinal and circumferential welds can be easily automated using additional rollerbeds.

**Cross Slides**

Manually or automatically position the weld head to the weld joint independently from the positioning equipment.

**Cladding Systems**

Use our equipment and process know how for a wide variety of applications.

**Positioners**

Work-pieces can always be placed in the most convenient working position.

**Rollerbeds / Idlers**

Position the work piece with accuracy or rotation at a constant speed depending on the application.

Do you want to find out more about Hard Automation?

Go to our website!
Strip Cladding Processes

Introduction

Cladding is a fundamental process in the Fabrication industry and is applied across the whole spectrum of applications – from the nuclear, oil and gas industries to petrochemicals and steelmaking. Cladding is required on the process side of high pressure Critical Process Plant Equipment (CPE) to provide corrosion resistance against highly severe corrosive service fluid or to increase wear resistance of a component being subjected to heavy wear and tear applications e.g. continuous casting rollers in Steel mills. While CMn substrates, low alloy steels and other materials provide strength and other physical properties, cladding provides the desired corrosion and wear resistance. The result is extraordinary flexibility and cost savings.

There are many ways to apply this corrosion resistant layer – either by using roll-bonded or explosive bonded clad plates or by applying our more flexible weld cladding on a CMn or low alloy steel base material.

Cladding Processes

While most of the existing arc and electro slag welding processes can be utilized for weld cladding, strip cladding with submerged arc and electro slag welding process are the most attractive choices for applications that require large surface area coverage due to their substantially higher deposition and surface area coverage rates.

Welding Heads, Accessories and Controller

Cladding Head

- In-house designed cladding heads for wide range of strip widths (15 to 120 mm)
- Water-cooled and robust modular design
- Power cables can be added as required
- Easily oriented for desired welding direction
- Specifically designed for use in H-ESC* applications involving simultaneous feeding of strip, flux and hot wire

Hot Wire Feeding Mechanism

- For H-ESC*, multiple hot metal cored wires are fed to the molten weld pool to achieve final chemistry in single layer with increased productivity
- Hot wire feeding mechanism uses modified Idealarc® DC 1000 or Power Wave® AC/DC 1000 SD power sources.

Magnetic Steering Devices

- Neutralises effect of strong electromagnetic pull generated by high welding current, enabling weld bead to spread wider with smoother overlap and edge profile
- Digitally controlled magnetic steering devices for Electro Slag – Conventional and H-ESC* with strip size ≥ 60 mm
- Air-cooled, and field poles can be changed between North and South quickly
- Current range of up to 15A
Welding Power Sources and Strip Feeding Device

Lincoln Idealarc® DC 1000 and 1500 power sources along with NA-5 or NA-3 strip feeding head and controller are the most widely used combinations across the world for conventional strip cladding. Multiple power sources can easily be connected in parallel to generate welding currents of up to 3000 Amp or more. Set of modified new generation inverter-based Power Wave® AC/DC 1000 SD or Modified Idealarc® DC 1000 power sources are connected in parallel for H-ESC* applications in conjunction with ‘Hybrid 3D Z5’ control system. Same combinations can now as well be used for conventional strip cladding.

Features

• The most widely used power sources, controllers and strip feeders in the world.
• Can easily be combined in parallel to supply a current of 3 000 Amp or more.
• Energy saving while using Inverter based power sources.

Total Solution for Strip Cladding

The most important key to the success of Strip cladding process is to have the right combination of:
• Welding Consumables i.e. Strip, Flux and Wire (where applicable)
• Cladding Head
• Magnetic Steering Devices
• Welding Power Sources and Strip Feeding Device
• Hot Wire Feeding Mechanism
• Automatic Welding Control System
If even one of these key elements is absent, the process is likely to fail in achieving its desired output.
Lincoln Electric is the world leader, as it has top quality solutions and the desired expertise in all the above fields.
GUNS & TORCHES
Built for Operator Comfort
Robust Design
Consistent High Performance Arc
Lincoln Electric presents new TIG torches: Linc Torch Premium LTP

The Linc Torch Premium (LTP) range is enhancing our current range of TIG torches, providing better performance for the welder’s comfort. Designed to meet the challenges of a variety of applications in maintenance, fabrication or construction sites. New torches are offered in both air-cooled and water-cooled version. High quality components and modern design decide about the welding process efficiency and operator’s comfort.

Both LT and LTP torches are made in Europe, according to high quality standards. Their expendables are compatible with the international standard.

Four configurations

**Range Overview**

<table>
<thead>
<tr>
<th>Cooling</th>
<th>Size</th>
<th>Power rating DC-AC</th>
<th>Length (m)</th>
<th>LTP Ergo</th>
<th>LT Ergo</th>
<th>LTP Ergo Flex</th>
<th>LTP Valve Conn. 10-25</th>
<th>LTP Valve Conn. 35-50</th>
<th>LTP Lever</th>
<th>LT Lever</th>
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*“F” model torches feature a lever grip
*“V” model torches have a gas valve for use with power sources without built-in solenoid valve
*“X” model torches feature a flexible head for greater comfort and improved access to tight spaces
**STANDARD RANGE**
- LTP 17 G 4M Ergo: K10513-17-4
- LTP 17 G 8M Ergo: K10513-17-8
- LTP 17 G 4M Lever: K10513-17-4F

**PREMIUM RANGE**
- LTP 17 G 4M Ergo: K10529-17-4
- LTP 17 G 8M Ergo: K10529-17-8
- LTP 17 G 4M Valve Conn. 10-25: K10529-17-4V5
- LTP 17 G 4M Valve Conn. 35-50: K10529-17-4V
- LTP 17 G 8M Valve Conn. 35-50: K10529-17-8V
- LTP 17 G 8M Lever: K10529-17-8F

---

**140 A DC**
**100 A AC @ 35%**

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**Accessory Kits:**
- KP10516-11: Short & Long Cap, Collet & Collet Body 1.6mm & 2.4mm, Ceramic Nozzles 6.5mm & 11mm
- KP10516-12: Short & Long Cap, Collet & Collet Body 2.4mm & 3.2mm, Ceramic Nozzles 9.5mm & 12.5mm

All the expendables are sold in packs of 10 pcs. The part numbers in bold are the ones which are standard in the torch.
LTP 26 G / LT 26 G

PREMIUM RANGE

STANDARD RANGE

LT 26 G 4M Ergo K10519-26-4
LT 26 G 8M Ergo K10519-26-8
LT 26 G 4M Lever K10519-26-4F

LTP 26 G 4M Ergo K10529-26-4
LTP 26 G 8M Ergo K10529-26-8
LTP 26 G 4M Valve Conn. 35-50 K10529-26-4F

LTP 26 G 8M Ergo Flex K10529-26-8X
LTP 26 G 8M Valve Conn. 35-50 K10529-26-8F

LTP 26 G 8M Valve K10529-26-8V

Accessory Kits:

KP10516-11: Short & Long Cap, Collet & Collet Body 1.6mm & 2.4mm, Ceramic Nozzles 6.5mm & 11mm
KP10516-12: Short & Long Cap, Collet & Collet Body 2.4mm & 3.2mm, Ceramic Nozzles 9.5mm & 12.5mm

All the expendables are sold in packs of 10 pcs. The part numbers in bold are the ones which are standard in the torch.
GUNS AND TORCHES

LTP 20 W / LT 20 W

STANDARD RANGE
LT 20 W 4M Lever K10519-20-4F

PREMIUM RANGE
LTP 20 W 4M Ergo K10529-20-4
LTP 20 W 8M Ergo K10529-20-8
LTP 20 W 8M Lever K10529-20-8F

Water cooled

220A DC
165A AC @ 100%

Accessory Kits:

KP10516-10: Short & Long Cap, Collet & Collet Body 1.6mm & 2.4mm, Ceramic Nozzles 6.5mm & 11mm

All the expendables are sold in packs of 10 pcs.
The part numbers in bold are the ones which are standard in the torch.
### Accessory Kits:

- **KP10516-11**: Short & Long Cap, Collet & Collet Body 1.6mm & 2.4mm, Ceramic Nozzles 6.5mm & 11mm
- **KP10516-12**: Short & Long Cap, Collet & Collet Body 2.4mm & 3.2mm, Ceramic Nozzles 9.5mm & 12.5mm

All the expendables are sold in packs of 10 pcs. The part numbers in **bold** are the ones which are standard in the torch.
## Accessory Kits:

**KP10516-13**: Short & Long Cap, Collet & Collet Body 3.2mm & 4.0mm, Ceramic Nozzles 9.5mm & 12.5mm

All the expendables are sold in packs of 10 pcs.
The part numbers in **bold** are the ones which are standard in the torch.
## Technical Specifications

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<th>LT 18W</th>
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<td>L</td>
<td>L</td>
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<tr>
<td>Welding gas</td>
<td>Argon DIN 32 526/1</td>
<td>Argon DIN 32 526/1</td>
<td>Argon DIN 32 526/1</td>
<td>Argon DIN 32 526/1</td>
<td>Argon DIN 32 526/1</td>
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<tr>
<td>Gas flow rate (l/min)</td>
<td>7÷15</td>
<td>7÷20</td>
<td>7÷20</td>
<td>8÷22</td>
<td>8÷20</td>
<td>7÷18</td>
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<td></td>
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<tr>
<td>Cooling</td>
<td>Gas</td>
<td>Water</td>
<td>Water</td>
<td>Water</td>
<td>Gas</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Highest temperature cooling medium at entry hose package</td>
<td>-</td>
<td>60°C</td>
<td>50°C</td>
<td>60°C</td>
<td>60°C</td>
<td>50°C</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Minimum quantity of cooling flow (l/min)</td>
<td>-</td>
<td>1.0</td>
<td>0.9</td>
<td>1.0</td>
<td>1.0</td>
<td>0.7</td>
<td>-</td>
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</tr>
<tr>
<td>Lowest pressure of entry</td>
<td>-</td>
<td>2.5 bar</td>
<td>2.5 bar</td>
<td>2.5 bar</td>
<td>2.5 bar</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Highest pressure of entry</td>
<td>-</td>
<td>5.0 bar</td>
<td>3.5 bar</td>
<td>5.0 bar</td>
<td>5.0 bar</td>
<td>3.5 bar</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Net weight [kg] [4m] (*)</td>
<td>1.82/2.02</td>
<td>2.00/2.10</td>
<td>2.51</td>
<td>2.38/3.53</td>
<td>-</td>
<td>1.71</td>
<td>2.36</td>
<td>2.44/2.54</td>
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<tr>
<td>Net weight [kg] [8m] [**]</td>
<td>3.39/3.55</td>
<td>3.95</td>
<td>4.51</td>
<td>3.65</td>
<td>4.56</td>
<td>2.91</td>
<td>4.20/4.30</td>
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<tr>
<td>Net weight [kg] [12m]</td>
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<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>6.06</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

(*) Weight depends on the torch version

## Non-Radioactive Tungsten Electrodes

A complete range of tungsten electrodes is proposed as alternative to thoriated, offering superior welding characteristics and avoiding problems with radioactivity.

- Longer lifetime
- Smaller diameter with same welding currents
- Less grinding
- Faster starts
- Better arc stability

### Type

<table>
<thead>
<tr>
<th>TYPE</th>
<th>COLOUR</th>
<th>APPLICATION</th>
</tr>
</thead>
<tbody>
<tr>
<td>WP Pure</td>
<td>Green</td>
<td>Nickel, Bronze, Nickel Alloys, Aluminium, Aluminium Alloys, Magnesium, Magnesium Alloys</td>
</tr>
<tr>
<td>WR2 Blended Oxide</td>
<td>Turquoise</td>
<td>Aluminium, Steel, Stainless Steel, Copper and Brass applications</td>
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<tr>
<td>WLα15 Lanthanated</td>
<td>Gold</td>
<td>Aluminium, Aluminium Alloys, Stainless Steel, Copper, Bronze, Titanium</td>
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<tr>
<td>WCe20 Ceriated</td>
<td>Grey</td>
<td>Steel Carbon, Steel, Stainless Steel, Bronze, Copper, Titanium</td>
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</table>

### Two ranges:
- LT Standard
- LT Premium

### Four configurations:
- Ergo
- Ergo Flex
- Valve
- Lever

### Five sizes:
- 17
- 18
- 18 SC
- 20
- 26

---

**ITEM n°:**

<table>
<thead>
<tr>
<th>ITEM n°:</th>
<th>ITEM n°:</th>
<th>Diameter [mm]</th>
<th>Pack</th>
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<tr>
<td>2124905</td>
<td>2124058</td>
<td>1.0</td>
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<tr>
<td>2124916</td>
<td>2124069</td>
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<td>2124927</td>
<td>2124074</td>
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<td>2124938</td>
<td>2124080</td>
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<td>10</td>
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<tr>
<td>2124949</td>
<td>2124091</td>
<td>3.2</td>
<td>10</td>
</tr>
<tr>
<td>2124960</td>
<td>2124102</td>
<td>4.0</td>
<td>5</td>
</tr>
<tr>
<td>2124410</td>
<td>2124300</td>
<td>1.0</td>
<td>10</td>
</tr>
<tr>
<td>2124421</td>
<td>2124311</td>
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<tr>
<td>2124432</td>
<td>2124322</td>
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<td>10</td>
</tr>
<tr>
<td>2124443</td>
<td>2124333</td>
<td>2.4</td>
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<tr>
<td>2124454</td>
<td>2124344</td>
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<td>2124806</td>
<td>2105479</td>
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<td>2124817</td>
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<td>2124839</td>
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<td>2124850</td>
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<td>2124718</td>
<td>2103864</td>
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<tr>
<td>2124729</td>
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<td>10</td>
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<td>2124740</td>
<td>2103865</td>
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<td>10</td>
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<tr>
<td>2124751</td>
<td>2103866</td>
<td>3.2</td>
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<tr>
<td>2124762</td>
<td>2103867</td>
<td>4.0</td>
<td>5</td>
</tr>
</tbody>
</table>

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**rev.: E-ACC07-EN-17-10-16**
LINC GUN™
The ultimate MIG guns

- Complete range to support all your welding applications.
- High quality rugged product build according to Lincoln standards.
- Ergonomic hand grip for comfortable welding day in day out.
- Flexible "Ball Joint" for comfortable welding in any position.
- Two metal springs provide optimum cable protection (except LGS 150 G).
- Retractable pins for a consistently reliable connection provided as standard.
- Cable packages use a heat resistant cross link cable for heavy environmental conditions.
- Wearing parts following the industry standard CE IEC 60974-7.

### LGS 150 G

<table>
<thead>
<tr>
<th>Model</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>LGS 150 G 3M</td>
<td>K10429-15-3M</td>
<td>LGS 150 G 3M</td>
</tr>
<tr>
<td>LGS 150 G 4M</td>
<td>K10429-15-4M</td>
<td>LGS 150 G 4M</td>
</tr>
<tr>
<td>LGS 150 G 5M</td>
<td>K10429-15-5M</td>
<td>LGS 150 G 5M</td>
</tr>
</tbody>
</table>

**150A-180A**

- **Spring**: KP10400-1
- **Contact Tip**: KP10440-1 (M6x25)

<table>
<thead>
<tr>
<th>Part n.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.6 mm</td>
<td>KP10440-06</td>
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<tr>
<td>0.8 mm</td>
<td>KP10440-08</td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP10440-09</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10440-10</td>
</tr>
<tr>
<td>0.8 mm</td>
<td>KP10440-08C</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10440-10C</td>
</tr>
<tr>
<td>0.8 mm</td>
<td>KP10440-08A</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10440-10A</td>
</tr>
</tbody>
</table>

### LGS 250 G

<table>
<thead>
<tr>
<th>Model</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>LGS 250 G 3M</td>
<td>K10429-25-3M</td>
<td>LGS 250 G 3M</td>
</tr>
<tr>
<td>LGS 250 G 4M</td>
<td>K10429-25-4M</td>
<td>LGS 250 G 4M</td>
</tr>
<tr>
<td>LGS 250 G 5M</td>
<td>K10429-25-5M</td>
<td>LGS 250 G 5M</td>
</tr>
</tbody>
</table>

**200A-230A**

- **Spring**: KP10401-1
- **Tip Holder**: KP10455-8 (M6x35)
- **Contact Tip**: KP10441-1 (M6x28)

<table>
<thead>
<tr>
<th>Part n.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.8 mm</td>
<td>KP10441-08</td>
</tr>
<tr>
<td>0.9 mm</td>
<td>KP10441-09</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10441-10</td>
</tr>
<tr>
<td>1.2 mm</td>
<td>KP10441-12</td>
</tr>
<tr>
<td>0.8 mm</td>
<td>KP10441-08C</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10441-10C</td>
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<td>KP10441-12C</td>
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<tr>
<td>0.8 mm</td>
<td>KP10441-08A</td>
</tr>
<tr>
<td>1.0 mm</td>
<td>KP10441-10A</td>
</tr>
<tr>
<td>1.2 mm</td>
<td>KP10441-12A</td>
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</tbody>
</table>

**NOZZLE**

- KP10461-1 (Ø=12mm)
- KP10460-1 (Ø=16mm)
- KP10461-6 (Ø=5.5mm)
- KP10469-1 (Ø=16mm)
- KP10468 (Ø=6mm) for Innershield

**Contact Nozzle**

- KP10461-7 (Ø=11mm)
- KP10462-1 (Ø=14mm)
- KP10466-1 (Ø=11mm)
- KP10463-2 (Ø=18mm)

**Air cooled**

- 60% (10 min.)
- Mix: 150A CO₂ 180A
- Ø: 0.6-1.0

- 60% (10 min.)
- Mix: 200A CO₂ 230A
- Ø: 0.8-1.2

---

**STICK WELDERS**

**GUNS AND TORCHES**

**MIG Guns**

www.lincolnelectriceurope.com
**Guns and Torches**

**LGS 240 G**

- LGS 240 G 3M: K10429-24-3M
- LGS 240 G 4M: K10429-24-4M
- LGS 240 G 5M: K10429-24-5M

**220A-250A**

**GAS DIFFUSER**
- KP10404-WT
- KP10404-RD
- KP10404-CR (ceramic)

**TIP HOLDER**
- KP10455-1 (M6x26)
- KP10456-1 (M8x28)

**CONTACT TIP**
- KP10440-size (M6x25, M8x30)
- KP10461-3 (Ø=16mm), KP10461-8 (Ø=12mm), KP10463-3 (Ø=20mm)

<table>
<thead>
<tr>
<th>Part.n.</th>
<th>Ø</th>
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<tbody>
<tr>
<td>KP10440-08</td>
<td>0.8 mm</td>
<td>ECu</td>
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<tr>
<td>KP10440-09</td>
<td>0.9 mm</td>
<td>ECu</td>
</tr>
<tr>
<td>KP10440-10</td>
<td>1.0 mm</td>
<td>ECu</td>
</tr>
<tr>
<td>KP10440-12</td>
<td>1.2 mm</td>
<td>ECu</td>
</tr>
<tr>
<td>KP10440-08C</td>
<td>0.8 mm</td>
<td>CuCrZr</td>
</tr>
<tr>
<td>KP10440-10C</td>
<td>1.0 mm</td>
<td>CuCrZr</td>
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<td>KP10440-12C</td>
<td>1.2 mm</td>
<td>CuCrZr</td>
</tr>
<tr>
<td>KP10440-08A</td>
<td>0.8 mm</td>
<td>Al (Ecu)</td>
</tr>
<tr>
<td>KP10440-10A</td>
<td>1.0 mm</td>
<td>Al (Ecu)</td>
</tr>
<tr>
<td>KP10440-12A</td>
<td>1.2 mm</td>
<td>Al (Ecu)</td>
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</table>

**NOZZLE**
- KP10461-4 (Ø=12.5mm)
- KP10461-9 (Ø=10mm)
- KP10463-4 (Ø=17mm)

**LGS 360 G**

- LGS 360 G 3M: K10429-36-3M
- LGS 360 G 4M: K10429-36-4M
- LGS 360 G 5M: K10429-36-5M

**300A-330A**

**GAS DIFFUSER**
- KP10405-WT
- KP10405-CR (ceramic)

**TIP HOLDER**
- KP10456-1 (M6x28)

**CONTACT TIP**
- KP10445-size (M8x30)
- KP10460-3 (Ø=20mm)
- KP10463-3 (Ø=20mm)

<table>
<thead>
<tr>
<th>Part.n.</th>
<th>Ø</th>
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</thead>
<tbody>
<tr>
<td>KP10445-08</td>
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<td>ECu</td>
</tr>
<tr>
<td>KP10445-10</td>
<td>1.0 mm</td>
<td>ECu</td>
</tr>
<tr>
<td>KP10445-12</td>
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<td>KP10445-16</td>
<td>1.6 mm</td>
<td>ECu</td>
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<tr>
<td>KP10445-08C</td>
<td>0.8 mm</td>
<td>CuCrZr</td>
</tr>
<tr>
<td>KP10445-09C</td>
<td>0.9 mm</td>
<td>CuCrZr</td>
</tr>
<tr>
<td>KP10445-10C</td>
<td>1.0 mm</td>
<td>CuCrZr</td>
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<td>CuCrZr</td>
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<tr>
<td>KP10445-08A</td>
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<td>Al (Ecu)</td>
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<tr>
<td>KP10445-10A</td>
<td>1.0 mm</td>
<td>Al (Ecu)</td>
</tr>
<tr>
<td>KP10445-12A</td>
<td>1.2 mm</td>
<td>Al (Ecu)</td>
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<tr>
<td>KP10445-16A</td>
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<td>Al (Ecu)</td>
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Air cooled 60% (10 min.)
Mix: 220A CO₂ Ø 0.8-1.2

Air cooled 60% (10 min.)
Mix: 300A CO₂ Ø 0.8-1.6
LGS 505 W

LGS 505 W 3M K10429-505-3M
LGS 505 W 4M K10429-505-4M
LGS 505 W 5M K10429-505-5M

Water cooled
100% (10 min.)
Mix 350A
C0₂ 500A
Ø 0.8-1.6

NOZZLE
KP10461-5 (Ø=16mm)
KP10461-10 (Ø=14mm)
KP10460-5 (Ø=20mm)

TIP HOLDER
KP10456-6 [L=25] (HD)
KP10456-2 [L=25]

CONT. TIP
KP10445-size (M8x30)

CONTACT TIP
KP10445-[size] (M8x30)

GAS DIFFUSER
KP10408-WT

450A-500A

LGS 505 W

Water cooled
100% (10 min.)
Mix 450A
C0₂ 500A
Ø 0.8-1.6

GAS DIFFUSER
KP10408-BR

CONTACT TIP
KP10445-size (M8x30)

NOZZLE
KP10461-5 (Ø=16mm)

350A-400A

PP 405 WC [PREMIUM GUN]

PP 405 WC 5M K10443-PPW405-5M

Water cooled
100% (10 min.)
Mix 450A
C0₂ 500A
Ø 0.8-1.6

TIP HOLDER
KP10456-6 [L=25] (HD)
KP10456-2 [L=25]

NOZZLE
KP10461-5 (Ø=16mm)

K10456-2 (L=25)

Contact Tip
KP10445-size (M8x30)

GAS DIFFUSER
KP10408-BR

ECu
0.8 mm KP10445-08
1.0 mm KP10445-10
1.2 mm KP10445-12
1.6 mm KP10445-16

CuCrZr
0.8 mm KP10445-08C
0.9 mm KP10445-09C
1.0 mm KP10445-10C
1.2 mm KP10445-12C
1.6 mm KP10445-16C

Al (Scu)
0.8 mm KP10445-08A
1.0 mm KP10445-10A
1.2 mm KP10445-12A
1.6 mm KP10445-16A

MIG Guns

LGPPW 405 8M K10443-PPW405-8M

Water cooled
100% (10 min.)
Mix 350A
C0₂ 400A
Ø 0.8-1.6
Poti 1x10KΩ
Plug 12pins

GAS DIFFUSER
KP10408-BR

CONTACT TIP
KP10445-size (M8x30)

NOZZLE
KP10461-5 (Ø=16mm)
KP10461-10 (Ø=14mm)
KP10460-5 (Ø=20mm)
## Metal transfer (Short Arc STT® / Spray Arc / Pulse)

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<thead>
<tr>
<th></th>
<th>Short Arc STT®</th>
<th>Spray Arc</th>
<th>Pulse</th>
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<tbody>
<tr>
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<td>●●●●●●●</td>
<td>●●●●●●●</td>
<td>●●●●●●●</td>
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<td>LGS 250 G</td>
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<td>●●●●●●●</td>
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<td>LGS 360 G</td>
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<td>LGS 505 G</td>
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### Liners

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<th>FOR</th>
<th>TYPE</th>
<th>ITEM NUMBER</th>
<th>COLOUR</th>
<th>WIRE Ø</th>
<th>LGS 150 G</th>
<th>LGS 250 G</th>
<th>LGS 360 G</th>
<th>LGS 505 G</th>
<th>LGS 505W</th>
<th>PAG 35 WC</th>
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<td>Steel liner</td>
<td>KPI0410-length</td>
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<td>–</td>
<td>–</td>
<td>–</td>
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<td>●</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td></td>
<td>Steel liner, coated</td>
<td>KPI0413-length</td>
<td>blue</td>
<td>0.6-1.0</td>
<td>●</td>
<td>●</td>
<td>●</td>
<td>•</td>
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<td>–</td>
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</tr>
<tr>
<td></td>
<td>Steel liner, coated</td>
<td>KPI0414-length</td>
<td>red</td>
<td>0.8-1.2</td>
<td>○</td>
<td>●</td>
<td>●</td>
<td>•</td>
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</tr>
<tr>
<td></td>
<td>Steel liner, coated</td>
<td>KPI0415-length</td>
<td>yellow</td>
<td>1.2-1.6</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>○</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>ALU, CuSi</td>
<td>PTFE liner</td>
<td>KPI0422-length</td>
<td>blue</td>
<td>0.8-1.0</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td></td>
<td>PTFE liner</td>
<td>KPI0418-length</td>
<td>red</td>
<td>0.8-1.2</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td></td>
<td>PTFE liner</td>
<td>KPI0420-length</td>
<td>yellow</td>
<td>1.2-1.6</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>○</td>
<td>○</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td></td>
<td>Graphite liner</td>
<td>KPI0430-length</td>
<td>black</td>
<td>1.0-1.6</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>–</td>
<td>●</td>
</tr>
<tr>
<td></td>
<td>PTFE liner with copper spiral end</td>
<td>KPI0419-length</td>
<td>red</td>
<td>0.8-1.2</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>○</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>

**KEY:** ● Excellent  ○ Good

### Steel Solid (80%Ar/20%CO₂)
- 0.8: ●●●●●
- 1.0: ●●●●●
- 1.2: ●●●●●

### Steel Cored (80%Ar/20%CO₂)
- 0.8: ●●●●
- 1.0: ●●●●

### Stainless (98%Ar/2%CO₂)
- 0.8: ●●●●
- 1.0: ●●●●

### Aluminium (100% Ar)
- 1.0: ●●●
- 1.2: ●●●

Available in 3M-4M-5M lengths

(*) Available also in 8M length

(**) Available in 8M length only

● Standard in the gun
○ Option
STICK WELDERS
GUNS AND TORCHES

10/12 mm

**LC 25 (Hand)**
LC 25 Hand 3M  PTH-C25A-SL-3MR

- **Electrode**
  - W03X0893-75A
- **Gas Distributor**
  - W03X0893-5R
- **Tip**
  - W03X0893-76A (25A)
- **Shield Cup Body**
  - W03X0893-77A
- **Spacer**
  - W03X0893-78R

Air cooled
96 l/min@5.0 bar
25A@60%
10mm mild steel
12mm severance

**LC 65 (Hand)**
LC 65 Hand 75M  PTH-061A-CX-7M5A
LC 65 Hand 15M  PTH-061A-CX-15MA

- **Electrode**
  - W03X0893-25A (contact, stand off, shielded & gouging)
- **Gas Distributor**
  - W03X0893-50R
- **Tip**
  - W03X0893-39A (gouging)
- **Retaining Cap**
  - W03X0893-41A
- **Spacer**
  - W03X0893-14R
- **Shield Cap**
  - W03X0893-44A
- **Shielded**
  - W03X0893-48A
- **Gouging**
  - W03X0893-21A
- **Extended**
  - W03X0893-26A (40A)
  - W03X0893-27A (40A)
  - W03X0893-28A (50A)
  - W03X0893-29A (60A) (stand off)
  - W03X0893-33A (50A)
  - W03X0893-34A (60A) (shielded)
  - W03X0893-39A (gouging)
  - W03X0893-40A (40A)
  - W03X0893-44A (50A)
  - W03X0893-46A (60A) (extended)

Air cooled
130 l/min@5.0 bar
60A@60%
25mm mild steel
30mm severance

**LC 65M (Machine)**
LC 65M Machine 75M  PTM-061A-CX-7M5A
LC 65M Machine 15M  PTM-061A-CX-15MA

- **Electrode**
  - W03X0893-25A
- **Gas Distributor**
  - W03X0893-50R
- **Tip**
  - W03X0893-52A (40A)
  - W03X0893-53A (50A)
  - W03X0893-54A (60A)
- **Shield Cup Body**
  - W03X0893-43A
- **Shield Cap**
  - W03X0893-46A
- **Shielded**
  - W03X0893-48A
- **Gouging**
  - W03X0893-21A
- **Extended**
  - W03X0893-25A
  - W03X0893-33A (50A)
  - W03X0893-34A (60A) (extended)

Air cooled
130 l/min@5.0 bar
60A@60%
25mm mild steel
30mm severance

25/30 mm

**LC 25 (Hand)**
LC 25 Hand 3M  PTH-C25A-SL-3MR

- **Electrode**
  - W03X0893-75A
- **Gas Distributor**
  - W03X0893-5R
- **Tip**
  - W03X0893-76A (25A)
- **Shield Cup Body**
  - W03X0893-77A
- **Spacer**
  - W03X0893-78R

**LC 65 (Hand)**
LC 65 Hand 75M  PTH-061A-CX-7M5A
LC 65 Hand 15M  PTH-061A-CX-15MA

- **Electrode**
  - W03X0893-25A (contact, stand off, shielded & gouging)
- **Gas Distributor**
  - W03X0893-50R
- **Tip**
  - W03X0893-39A (gouging)
- **Retaining Cap**
  - W03X0893-41A
- **Spacer**
  - W03X0893-14R
- **Shield Cap**
  - W03X0893-44A
- **Shielded**
  - W03X0893-48A
- **Gouging**
  - W03X0893-21A
- **Extended**
  - W03X0893-26A (40A)
  - W03X0893-27A (40A)
  - W03X0893-28A (50A)
  - W03X0893-29A (60A) (stand off)
  - W03X0893-33A (50A)
  - W03X0893-34A (60A) (shielded)
  - W03X0893-39A (gouging)
  - W03X0893-40A (40A)
  - W03X0893-44A (50A)
  - W03X0893-46A (60A) (extended)

**LC 65M (Machine)**
LC 65M Machine 75M  PTM-061A-CX-7M5A
LC 65M Machine 15M  PTM-061A-CX-15MA

- **Electrode**
  - W03X0893-25A
- **Gas Distributor**
  - W03X0893-50R
- **Tip**
  - W03X0893-52A (40A)
  - W03X0893-53A (50A)
  - W03X0893-54A (60A)
- **Shield Cup Body**
  - W03X0893-43A
- **Shield Cap**
  - W03X0893-46A
- **Shielded**
  - W03X0893-48A
- **Gouging**
  - W03X0893-21A
- **Extended**
  - W03X0893-25A
  - W03X0893-33A (50A)
  - W03X0893-34A (60A) (extended)

Air cooled
130 l/min@5.0 bar
60A@60%
25mm mild steel
30mm severance
**GUNS AND TORCHES**

**Plasma Torches**

**LC 105 (Hand)**

<table>
<thead>
<tr>
<th>Model</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>LC 105 Hand 75M</td>
<td>PTH-101A-CX-75MA</td>
</tr>
<tr>
<td>LC 105 Hand 15M</td>
<td>PTH-101A-CX-15MA</td>
</tr>
</tbody>
</table>

**LC 105M (Machine)**

<table>
<thead>
<tr>
<th>Model</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>LC 105M Machine 75M</td>
<td>PTM-101A-CX-75MA</td>
</tr>
</tbody>
</table>

**Accessories**

**AIR FILTER LAF1250**

W88X4566A

**FILTER CARTRIDGE**

W8800117R

Sub-micron filter for compressed air. Designed to remove moisture, oils and sprays particles from air compressors, thus providing clean, free of oil and dry air.

- Better quality of the cut
- Longer life time of consumables
- Increases life time of the torch itself
- Compatible with any plasma cutting machine and torch
- Filter cartridge easily replaceable
- Useful also for different applications machines (spray painting, pneumatic tools, ...)

**CUTTING ATTACHMENT FOR LC25/65/105**

W0300699A

**40/45 mm**

**ELECTRODE**

W03X0893-60A (shielded)

W03X0893-57A (extended)

**GAS DISTRIBUTOR**

W03X0893-70R

**TIP**

W03X0893-61A (40A)

W03X0893-62A (60A)

W03X0893-63A (80A)

W03X0893-64A (100A) (shielded)

W03X0893-58A (40A)

W03X0893-59A (60A)

W03X0893-72A (80A)

W03X0893-73A (100A) (extended)

**SHIELD CUP BODY**

W03X0893-65A (gouging)

W03X0893-66A

**SHIELD CUP**

W03X0893-67A

**SHIELD CAP**

W03X0893-69A

**SHIELDED**

**GOUGING**

**EXTENDED**

**Air cooled**

280 l/min@5.5 bar

100A@60%

40mm mild steel

45mm severance

**Lincoln Electric Europe**

www.lincolnelectriceurope.com

rev: E-ACC18-EN-27-12-17
INNERSHIELD GUNS

Magnum® self-shielded flux-cored welding (FCAW-S) guns are rugged and reliable, while remaining lightweight, flexible and maneuverable. A number of models are offered for amperage ratings from 350 to 450 amps. Lincoln Electric Magnum® guns for Innershield® welding are a great choice.

- Heavy-duty gun trigger switch – For positive electrical contact and long life.
- Reinforced rubber jacket – Adds strength and long life to cable.
- Alternate gun tubes – Available for select guns to reach welds with limited accessibility.
- All guns are rated at 60% duty cycle.

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Rated Amperage</th>
<th>Wire diameter (mm)</th>
<th>Cable length (m)</th>
<th>Tube angle (°)</th>
</tr>
</thead>
<tbody>
<tr>
<td>K126-1</td>
<td>350</td>
<td>1.6-2.4</td>
<td>3</td>
<td>62</td>
</tr>
<tr>
<td>K126-2</td>
<td>350</td>
<td>1.6-2.4</td>
<td>4.5</td>
<td>62</td>
</tr>
<tr>
<td>K115-1</td>
<td>450</td>
<td>2.4-3.0</td>
<td>3</td>
<td>82</td>
</tr>
<tr>
<td>K115-2</td>
<td>450</td>
<td>2.4-3.0</td>
<td>4.5</td>
<td>82</td>
</tr>
<tr>
<td>K345-10</td>
<td>350</td>
<td>1.7-2.0</td>
<td>3</td>
<td>90</td>
</tr>
</tbody>
</table>

ROBOTIC GUNS

Magnum® PRO Robotic Guns

- Single Tool Center Point (TCP) – Changing between 350A and 550A expendables does not alter the robot TCP.
- Robust Cable System – Cables exceed industry standards by a factor of two in durability testing.
- Simplified Expendable Parts Selection – 350A and 550A rated consumables are interchangeable across all gun models.
- HexConnect™ Gun Bushing – Ensures better electrical conductivity through full face contact as opposed to rotating connections that have single line contact.
- Extended Reach – Mounting bracket is designed to optimize clearance for tough to reach welding applications.
- Retractable pins for a consistently reliable connection provided as standard.
- Cable packages use a heat resistant cross link cable for heavy environmental conditions.
- Wearing parts following the industry standard CE IEC 60974-7.

Autodrive SA Torch

Designed for welding aluminium parts robotically, AutoDrive SA is a high-performance aluminium servo torch solution to address the common problems with robotic aluminium welding.

Advantages

- Consistent wire feeding for robotic Aluminium welding.
- Touch-retract start technology to initiate each robotic weld with no spatter or burnback.
- Consistent arc start from start to finish.
- Delivers more than 250,000 starts and stops with a single contact tip.
- Decrease change overs 50%.
GUNS AND TORCHES

Gouging Torches

FLAIR 600 & 1600™
When continuity counts!

- 360° rotating torch – The torch can rotate 360° on the monocable. This results in a comfortable and better freedom of movement.
- Smooth finished body for perfect airflow – Manufactured with the greatest accuracy. The inner body is perfectly shaped which results in a perfect airflow, thus in a better cooling as well as a longer life time.
- Highly conductive extruded body and nozzle (non-casted) – Better conduction and less heat development and consequently a longer product lifetime.
- Thicker high heat resistant insulation – Longer product lifetime but also safer, more comfortable and more productive working conditions.
- Flexible monocable (2.5 meter) – provides more ergonomical, comfortable working conditions.

Gouging products and carbon electrodes

Gouging electrodes
available in a variety of diameters to meet most application needs. They are made of carbon and have a copper coating. The use of high-quality materials ensures a stable arc and a long electrode life.

<table>
<thead>
<tr>
<th>Item Number</th>
<th>Qty/box</th>
<th>Dimensions (mm)</th>
<th>Current (A)</th>
<th>Metal removal (g/cm)</th>
<th>Groove width (in)</th>
<th>Groove depth (in)</th>
<th>Cut depth (in)</th>
<th>Bore diameter (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>FL064016010-L</td>
<td>100 pcs</td>
<td>4.0x305</td>
<td>5/32x12</td>
<td>150-200</td>
<td>10</td>
<td>0.90</td>
<td>6-8</td>
<td>3.4</td>
</tr>
<tr>
<td>FL064016025-L</td>
<td>100 pcs</td>
<td>5.0x305</td>
<td>3/16x12</td>
<td>150-200</td>
<td>12</td>
<td>1.08</td>
<td>7-9</td>
<td>3-5</td>
</tr>
<tr>
<td>FL064016030-L</td>
<td>50 pcs</td>
<td>6.3x305</td>
<td>1/4x12</td>
<td>200-250</td>
<td>18</td>
<td>1.61</td>
<td>9-11</td>
<td>4-6</td>
</tr>
<tr>
<td>FL064016040-L</td>
<td>50 pcs</td>
<td>8.0x305</td>
<td>5/16x12</td>
<td>250-350</td>
<td>33</td>
<td>2.96</td>
<td>11-13</td>
<td>6-9</td>
</tr>
<tr>
<td>FL064016050-L</td>
<td>50 pcs</td>
<td>9.5x305</td>
<td>3/8x12</td>
<td>350-450</td>
<td>49</td>
<td>4.39</td>
<td>13-15</td>
<td>8-12</td>
</tr>
<tr>
<td>FL064016060-L</td>
<td>50 pcs</td>
<td>13.0x305</td>
<td>1/2x12</td>
<td>700-900</td>
<td>90</td>
<td>9.79</td>
<td>15-17</td>
<td>11-14</td>
</tr>
<tr>
<td>FL064016065-L</td>
<td>50 pcs</td>
<td>13.0x335</td>
<td>1/2x14</td>
<td>700-900</td>
<td>90</td>
<td>9.79</td>
<td>15-17</td>
<td>11-14</td>
</tr>
</tbody>
</table>

Flexible monocable (2.5 m)
Thanks to the use of neoprene outer sheet rubber and the air-cooled conductor, the Flair monocable is outstandingly flexible. This results in more freedom of movement and more comfort.

<table>
<thead>
<tr>
<th>Item Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>FL060280601-L</td>
<td>Monocable for Flair 600 (600A max), 2.5m</td>
</tr>
<tr>
<td>FL060281601-L</td>
<td>Monocable for Flair 1600 (1600A max), 2.5m</td>
</tr>
</tbody>
</table>
WELDING HELMETS
Variable Control for Shade, Sensitivity and Delay
Light Weight
A vision for better welds

Better clarity, less color

Now you can make a good view even better. Upgrading the VIKING 1840, 2450 and 3350 series with 4C™ technology allows the view screens on these helmets to reach a 1/1/1/1 optical clarity rating and the visibility is improved by reducing the lime green tint.

Wide-screen view

4C™ technology enables you to not only see better but also see more. The large viewing area gives you a full range of vision in relation to the welding area, which enhances operator control and improves weld quality.

Easy on the eyes

Improved visibility and less eye strain means greater comfort for the welder. This combined with an improved view of the weld puddle adds up to better welds.

4C™ Technology

1. Clarity – Optical clarity 1/1/1/1
2. Colour – Real Colour View
3. Carat – Light Weight ADF
4. Cut – Even Shade From Any Angle
Viking™ – 3350 Series
Defining A New Gold Standard in Welding Helmets

The VIKING 3350, our top-of-the-line helmet series, provides the best optical clarity available in a welding helmet today and the largest viewing area in its class. The 3350 Series offers a pivot style headgear designed for greater comfort and optimal fit.

Features
- Perfect 1/1/1/1 optical clarity rating (EN379)
- Continuously variable 5-13 shade with internal control
- Continuously variable sensitivity and delay
- Grind mode
- 95 x 85 mm view size: Largest in the VIKING line

Order
- K3034-3-CE Viking™ Helmet
- K3035-3-CE Viking™ Helmet
- K3100-3-CE Viking™ Helmet
- K3101-3-CE Viking™ Helmet

Defining A New Gold Standard in Welding Helmets

Viking™ – 2450 Series
The Ideal Choice for the Journeyman Fabricator

The VIKING 2450, the latest evolution in our intermediate line of auto-darkening helmet line, provides the best optical clarity. The 2450 Series offers an improved headgear for greater comfort and flexibility.

Features
- Perfect 1/1/1/1 optical clarity rating (EN379)
- Continuously variable 5-13 shade with internal control
- Continuously variable sensitivity and delay
- Grind mode
- 97 x 62 mm view size

Order
- K3028-3-CE Viking™ Helmet
- K3035-3-CE Viking™ Helmet

Viking™ – 1840 Series
Superior Optical Clarity

The VIKING 1840 provides operators with the best optical clarity available in a welding helmet today. External controls allow for quick and easy shade changes. The 1840 Series offers an improved headgear for greater comfort and optimal fit.

Features
- Perfect 1/1/1/1 optical clarity rating (EN379)
- Continuously variable 9-13 shade with external control
- Continuously variable sensitivity and delay
- Grind mode
- 96 x 47 mm view size

Order
- K3023-3-CE Viking™ Helmet
- K3024-3-CE Viking™ Helmet

www.lincolnelectriceurope.com
118
**Viking™ – 1740 Series**

**Make it Your Own: A Great Welding Helmet at a Great Price**

There’s no shortage of features on our 1740 series helmet. Available in glossy black finish. Decorate your helmet to reflect your own personal style with the complementary decal sheet.

**Features**
- 1/1/1/2 optical class (EN379)
- Continuously variable 9-13 shade with internal control
- Continuously variable sensitivity and delay
- Grind mode
- 96 x 42.5 mm view size
- Compact DINS 110 x 90 mm cartridge size
- 2 arc sensors
- Solar powered with 2 replaceable AAA alkaline batteries
- Magnifying “cheater” lens capable
- Extra cover lenses enclosed – (2) inside and (5) outside
- Complementary decal sheet to decorate the helmet

**Order**
- K3282-1-CE Viking™ Helmet 1740

---

**Linc Screen II**

**Light and Smart**

The Auto-darkening Linc Screen® II helmet is designed to combine safety with a variety of features ideal for Stick, TIG, MIG welding as well as plasma cutting. A large control located on the exterior of the helmet allows easy adjustment of the shade from 9 to 13 DIN. Equipped with two independent arc sensors. Solar cells – do not require batteries. Ideal for general purpose applications.

**Features**
- 1/2/1/2 optical class (EN379)
- Continuously variable 9-13 shade with external control
- 97 x 44 mm view size
- 2 arc sensors
- Solar powered, with non replaceable battery, no On/Off switch
- Lightweight – 496 g
- User-Friendly Design

**Order**
- K2953-1-CE Linc Screen II

---

**See clearly NOW**

**4C™ LENS TECHNOLOGY**

www.lincolnelectric-europe.com
## Linc Screen II Series

<table>
<thead>
<tr>
<th>Feature</th>
<th>Linc Screen II</th>
<th>1740 Series</th>
<th>1840 Series</th>
<th>2450 Series</th>
<th>3350 Series</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lens Switching Speed (sec)</td>
<td>1/10,000</td>
<td>1/25,000</td>
<td>1/25,000</td>
<td>1/25,000</td>
<td>1/25,000</td>
</tr>
<tr>
<td>Variable Shade/Control</td>
<td>9-13 External</td>
<td>9-13 Internal</td>
<td>9-13 External</td>
<td>5-13 Internal</td>
<td>5-13 Internal</td>
</tr>
<tr>
<td>Magnifying “Cheater”</td>
<td></td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Capable Lens</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Grind Mode Shade/Control</td>
<td></td>
<td>DIN4/Internal</td>
<td>DIN4/External</td>
<td>DIN3.5/Internal</td>
<td>DIN3.5/Internal</td>
</tr>
<tr>
<td>Light Sensitivity Control</td>
<td></td>
<td>Continuous</td>
<td>Continuous</td>
<td>Continuous</td>
<td>Continuous</td>
</tr>
<tr>
<td>Delay Control Dark to Light (sec)</td>
<td>0.70 Fixed</td>
<td>0.1-1 Fully Adjustable</td>
<td>0.1-1 Fully Adjustable</td>
<td>0.1-1 Fully Adjustable</td>
<td>0.1-1 Fully Adjustable</td>
</tr>
<tr>
<td>Arc Sensors</td>
<td>2</td>
<td>2</td>
<td>2</td>
<td>4</td>
<td>4</td>
</tr>
<tr>
<td>TIG Amp Rating</td>
<td>&gt; 10A AC/DC</td>
<td>&gt; 5A AC/DC</td>
<td>≥ 2A AC/DC</td>
<td>≥ 2A AC/DC</td>
<td>≥ 2A AC/DC</td>
</tr>
<tr>
<td>Cartridge Size (mm)</td>
<td>110x90</td>
<td>110x90</td>
<td>110x90</td>
<td>114x133</td>
<td>114x133</td>
</tr>
<tr>
<td>View Size (mm)</td>
<td>97x44</td>
<td>96 x 42.5</td>
<td>96x47</td>
<td>97x62</td>
<td>95x85</td>
</tr>
<tr>
<td>Temperature Range</td>
<td>Operating: -5°C to +55°C Storage: -20°C to +70°C</td>
<td>Operating: -10°C to +55°C Storage: -20°C to +70°C</td>
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<td>2 CR 2450 Batteries</td>
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# Replacement parts

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<th>1840 Series</th>
<th>2450 Series</th>
<th>3350 Series</th>
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VIKING™ PAPR 3350 WELDING HELMET
Powered Air Purifying Respirator
WELDING HELMETS

VIKING™ PAPR 3350

Clear The Air On Welding Safety

Where welding operations are concerned, safety is directly connected to air quality. When welding must be performed in enclosed or other areas where it is difficult to provide effective ventilation or otherwise control exposure to welding fume, the last line of defense is personal protective equipment for the individual operator. The VIKING™ PAPR (Powered Air Purifying Respirator) provides effective air-purification solution all-day long.

1/1/1/1 optical clarity

The VIKING™ PAPR is a complete system that purifies ambient air from the shop and delivers filtered, breathable air for as much as eight hours without interruption. The two-speed blower drives air through the hose to a VIKING™ 3350 helmet rated for a perfect 1/1/1/1 optical clarity. A patent pending adjustable baffling system inside the helmet directs air away from eyes to keep them from getting dry. The PAPR system has a respiratory protection class TH2 [EN 12941].

Proper ventilation may not always be an option in every welding environment. Bring fume protection and filtered air directly to the operator in difficult environments and keep it there all day with the PAPR.
Why VIKING™ PAPR 3350?

» **Lightweight and comfortable**
The blower weight is 998 g while the entire system weighs in at 2.8 kg, most of which is in the belt pack and hose and away from the head and shoulders. The low-profile blower in the belt unit allows unrestricted movement.

» **Lasts all day (and then some)**
Operators can work a full shift (or more) without interruption.

The PAPR comes with a standard eight-hour battery that outpaces the battery life of competing systems. Audible and vibrating alarms signal when the battery is low.

» **Two speeds, consistent delivery**
The PAPR system maintains a positive pressure at two speeds: 180 and 210 liters per minute. The system automatically adjusts fan speeds to keep airflow constant.

**Specifications of VIKING™ PAPR 3350**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Details</th>
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<tr>
<td><strong>Product Number</strong></td>
<td>K3930-2</td>
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<tr>
<td><strong>Size of Blower Assembly (W x T x D)</strong></td>
<td>203 x 191 x 76 mm</td>
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<td><strong>Weight of Blower (including battery, belt and filters)</strong></td>
<td>1.0 kg</td>
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<tr>
<td><strong>Air Flow</strong></td>
<td>Low Speed: 180+ lpm (6+ cfm)</td>
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<td></td>
<td>High Speed: 210+ lpm (7.4+ cfm)</td>
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<td><strong>Operating Temperature</strong></td>
<td>-5° to 55°C</td>
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<tr>
<td><strong>Battery Type</strong></td>
<td>Lithium Ion (Rechargeable)</td>
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<td><strong>Battery Charge Time</strong></td>
<td>Three hours</td>
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<td><strong>Battery Charges</strong></td>
<td>500 charges</td>
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<td><strong>Belt Size</strong></td>
<td>736 to 1321 mm (max. 1524 mm with belt extension accessory)</td>
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<td><strong>Respirator Approval</strong></td>
<td>EN12941-1998/A2 2008 – CLASS TH2P</td>
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<td><strong>Assigned Protection Factor</strong></td>
<td>TH2</td>
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<td><strong>Helmet Replacement Battery</strong></td>
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<td><strong>Battery Life</strong></td>
<td>8 Hours</td>
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<td><strong>Charge</strong></td>
<td>220 Volt Input</td>
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<td><strong>Alarms</strong></td>
<td>Audible and Vibrate</td>
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<td><strong>Head Gear</strong></td>
<td>FR Flame Retardant</td>
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<td><strong>Optical Class</strong></td>
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<td><strong>Lens Switching Speed (sec)</strong></td>
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<td><strong>Variable Shade/Control</strong></td>
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<td><strong>Magnifying “Cheater” Capable Lens</strong></td>
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<td><strong>Grind Mode Shade/Control</strong></td>
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<td><strong>Delay Control Dark to Light (sec)</strong></td>
<td>0.1-1.0 Fully Adjustable</td>
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<td><strong>Arc Sensors</strong></td>
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<tr>
<td><strong>TIG AMP Rating</strong></td>
<td>DC &gt; 2 Amp – AC &gt; 2 Amp</td>
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<td><strong>Helmet Compliance</strong></td>
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<td><strong>Cartridge Size</strong></td>
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<td><strong>View Size</strong></td>
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<td><strong>Blower Assembly</strong></td>
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<td><strong>ADF Helmet</strong></td>
<td>3 Year Warranty</td>
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**VIKING PAPR – Plenum**

Two air flow baffles allow users to adjust the air for maximum comfort and prevent drying of the eyes.

First baffle (Red) – controls ratio of air over forehead vs temples

Second baffle (Purple) – directs air closer or further from your face
WELDING HELMETS

What’s Included

- Blower Unit
- VIKING 3350 Black Helmet
- Head Cover
- Hose
- 2 Particulate Filters
- 736-1321 mm Padded Belt
- Shoulder Strap
- 220V Battery Charger
- Duffle Bag
- Rechargeable Battery
- Pre-Filter
- Spark Guard
- Hose Cover
- Extra helmet cover lenses: inside 2 pcs, outside 5 pcs
- Instruction Manual

Replacement parts

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<th>Item Number</th>
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<td>VIKING PAPR 3350 Helmet Assembly (PKG includes Headgear and Headcovering)</td>
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<td>Outside Cover Lens – 114 x 133 x 1 mm</td>
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<td>S27978-32</td>
<td>Outside Cover Lens Seal</td>
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<td>KP3045-3</td>
<td>3350 Auto-Darkening Filter</td>
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<td>KP3044-1</td>
<td>Inside Cover Lens – 94.7 x 89.7 x 1 mm</td>
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<td>Pre-filter</td>
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<td>KP3936-1</td>
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<td>Shoulder Strap Assembly</td>
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</table>
WELDING GEAR

Lincoln Electric offers personal protection clothing including welding helmets, gloves, jackets. Whether you weld for a living or you’re an occasional welder, we have the right welding safety gear for you.
**MIG/STICK WELDING GLOVES**

These welding gloves are constructed with heat and flame resistant split leather. Kevlar® stitching extends service life.

Conforms to EN12477 standards.

Size: One size fits all

Order: 2105730

<table>
<thead>
<tr>
<th>Size</th>
<th>Label Size</th>
<th>Hand Size</th>
<th>Measurement</th>
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<tbody>
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<td>S</td>
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<td>M</td>
<td>8</td>
<td>216</td>
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<tr>
<td>L</td>
<td>9</td>
<td>229</td>
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</tr>
<tr>
<td>XL</td>
<td>9 ½</td>
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</tbody>
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**TRADITIONAL MIG/STICK WELDING GLOVES**

These general purpose gloves are constructed with heat and flame resistant split cowhide for all types of welding. Inside, the gloves feature a 100% soft sweat absorbent cotton lining for added comfort and heat resistance. Kevlar® stitching and welted seams offer added durability and thumb pads in high wear areas extend the work life of the glove.

Conforms to EN12477 standards.

Size: One size fits all

Order: K2979-ALL-CE

**PREMIUM LEATHER MIG/STICK WELDING GLOVES**

Together, smooth high dexterity grain leather and durable side split cowhide deliver superior comfort and performance. A lined interior and padded palm maximize comfort. The dual lining system extends life in high wear areas. Kevlar® thread provides heat resistance and added seam strength. Forearm coverage is extended for extra spatter protection.

Conforms to EN12477 standards.

Size: M, L, XL

Order: K2980-M-CE, K2980-L-CE, K2980-XL-CE

**LEATHER TIG WELDING GLOVES**

Our supple goat skin leather provides the right fit, sensitive feel and durable construction that precise TIG welding demands. The straight thumb design features welted seams and tough Kevlar® stitching to extend service life.

Conforms to EN12477 standards.

Size: M, L, XL

Order: K2981-M-CE, K2981-L-CE, K2981-XL-CE

**FULL LEATHER STEELWORKER® GLOVES**

For fabrication work or light welding. Top grain cowhide leather delivers excellent fit and dexterity while the goat skin back allows the glove to breathe. The palm is padded for comfort and the hook and loop soft rubber tabbed wrist closure with non-constricting elastic band ensures a snug, comfortable fit.

Conforms to EN388 standards.

Size: S, M, L, XL

WELDING GEAR

Welding Apparel

**SHADOW™ GRAIN LEATHER-SLEEVED WELDING JACKET**

Choose our full grain leather sleeve model with a flame retardant 100% cotton chest for added comfort and dexterity when MIG or stick welding. The flip up collar is secured with adjustable hook and loop. The front panel is secured by snaps with an extra flap for full closure. Conforms to EN11611 standards.

<table>
<thead>
<tr>
<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
<th>Jacket Sleeve (cm)</th>
<th>Jacket Torso (cm)</th>
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</thead>
<tbody>
<tr>
<td>K2987-M-CE</td>
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<td>K2987-XL-CE</td>
<td>133</td>
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<td>K2987-2XL-CE</td>
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<td>K2987-3XL-CE</td>
<td>154</td>
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</table>

**HEAVY DUTY LEATHER WELDING JACKET**

Our heavy duty side split cowhide leather chest and sleeves provide superior protection for stick welding, while the flame retardant cloth back keeps you cool. As an added measure of spatter protection, the flip up collar is secured by hook and loop while the front jacket closure features a lined flap secured by a series of snaps. An inside pocket protects personal items. Conforms to EN11611 standards.

<table>
<thead>
<tr>
<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
<th>Jacket Sleeve (cm)</th>
<th>Jacket Torso (cm)</th>
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<tr>
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<td>K2989-XL-CE</td>
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<tr>
<td>K2989-3XL-CE</td>
<td>154</td>
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<td>96</td>
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</tbody>
</table>

**TRADITIONAL SPLIT LEATHER-SLEEVED WELDING JACKET**

Split cowhide sleeves resist spatter and add durability, while 9 oz. 100% flame retardant material on the chest and back keep you cool. This basic jacket features an inside pocket and adjustable snap sleeves. Conforms to EN11611 standards.

<table>
<thead>
<tr>
<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
<th>Jacket Sleeve (cm)</th>
<th>Jacket Torso (cm)</th>
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<td>K3106-2XL-CE</td>
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<tr>
<td>K3106-3XL-CE</td>
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<td>96</td>
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</tbody>
</table>

**TRADITIONAL FR CLOTH WELDING JACKET**

100% flame retardant material offers protection for light duty welding. An inside pocket stows personal items. Machine washable. Conforms to EN11611 standards.

<table>
<thead>
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<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
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<td>K2985-XL-CE</td>
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<td>86</td>
</tr>
<tr>
<td>K2985-2XL-CE</td>
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<td>91</td>
</tr>
<tr>
<td>K2985-3XL-CE</td>
<td>154</td>
<td>89</td>
<td>96</td>
</tr>
</tbody>
</table>
FR WELDING LAB COAT

Ideal for instructors, supervisors and occasional welders. The knee length black 255 gr. 100% flame retardant material coat offers protection for light duty welding. Two hip and one chest pocket stow chalk, grease pens or other items. Conforms to EN11611 standards.

<table>
<thead>
<tr>
<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
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<th>Jacket Torso (cm)</th>
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<td>K3112-XL-CE</td>
<td>133</td>
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</table>

BLACK FR SHIRT

Add protection with a 255 gr. 100% flame retardant material black shirt. This shirt features two chest pockets with flaps and a pencil holder slot.

<table>
<thead>
<tr>
<th>Part Number/Size</th>
<th>Chest Measurement (cm)</th>
<th>Jacket Sleeve (cm)</th>
<th>Jacket Torso (cm)</th>
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<tr>
<td>K3113-2XL-CE</td>
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<td>86</td>
<td>89</td>
</tr>
<tr>
<td>K3113-3XL-CE</td>
<td>142-147</td>
<td>89</td>
<td>91</td>
</tr>
</tbody>
</table>

SPLIT LEATHER WELDING APRON

Add to your welding jacket when additional protection is required or use for light welding over clothing. The apron features heavy split cowhide and an adjustable harness system for proper fit and weight displacement. Conforms to EN11611 standards.

Size: One size fits all.
Order: K3110-ALL-CE

SPLIT LEATHER WELDING SLEEVES

Slip on a pair of welding sleeves for added spatter and heat resistance. These black sleeves are entirely made with cow leather. Elastic cuffs at each end keep spatter out and hold the sleeves in position. Conforms to EN11611 standards.

Sleeve length: 53 cm
Order: K3111-ALL-CE

FR DOO RAG & FR WELDING BEANIE

Let your Lincoln Electric colours show! This premium doo rag, made of 255 gr. flame retardant material, features an athletic mesh lining for fast sweat evaporation. Machine washable. Conforms to EN11611 standards.

Size: One size fits all.
Order: K2993-ALL-CE

Protect your head with this authorized Lincoln Electric flame retardant beanie. Machine washable. Conforms to EN11611 standards.

Size: One size fits all.
Order: K2994-ALL-CE
LEATHER TROUSERS & FR TROUSERS

Heavy duty leather trousers
Made in split cow leather, metal current isolated snaps and FR cotton straps. Conforms to EN11611 standards.

FR trousers
Practical and comfortable trousers in cotton with flame retardant finish. Knees protection. Conforms to EN11611 standards.

<table>
<thead>
<tr>
<th>Part Number / Size</th>
<th>Length (cm)</th>
</tr>
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<tbody>
<tr>
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<td>KP10571-XL</td>
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<td>KP10571-2XL</td>
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Order Information

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<td>KP10570-2XL</td>
<td>123</td>
</tr>
<tr>
<td>KP10570-3XL</td>
<td>126</td>
</tr>
</tbody>
</table>

WELDING GEAR READY-PAK®

Everything a welding student or occasional welder needs to get started

Get a tough, abrasion resistant duffle bag filled with everything a welding student or occasional welder needs to get started in school or on the job. Conforms to EN11611, EN379, EN388, EN12477 standards.

- Lincoln® Industrial Duffle Bag
- VIKING™ Black 1840 Series Auto-Darkening Helmet
- Traditional FR Cloth Jacket [K2985]
- Traditional MIG/ Stick Welding Gloves
- Full Leather Steelworker® Gloves
- FR Doo Rag

Order:

- K3105-M-CE  Traditional Welding Gear READY-PAK® – medium
- K3105-L-CE  Traditional Welding Gear READY-PAK® – large
- K3105-XL-CE Traditional Welding Gear READY-PAK® – extra large
- K3105-2XL-CE Traditional Welding Gear READY-PAK® – 2X large
Hydroguard™ Bench Rod Ovens

Outstanding moisture resistance

HydroGuard™ Rod Ovens help protect stick electrodes from moisture pickup, a major contributor to weld cracking and porosity.

The Bench model holds up 159 kg of stick up to 450 mm in length, enough for multiple operators in almost any fabrication shop.

Features

- Distributes heat evenly throughout the interior and directs moisture to the adjustable vent at the top of the door.
- Regulate temperature from 38-288°C. Pilot light indicates active heating mode. Housing recesses controls for added protection.
- Remove shelves to use rod oven for pre- or post-weld heating of welded parts.
- Regulate interior moisture levels through an adjustable vent on the door.
- A horizontal surface added to the top provides a surface for taking notes, storing documentation or necessary tools.
- Records time and temperature to comply with certain code requirements.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage</th>
<th>Capacity</th>
<th>Chamber Size</th>
<th>Insulation</th>
<th>Temperature Range</th>
<th>Heating Element</th>
<th>Dimensions HxWxD (mm)</th>
<th>Net Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>HydroGuard™ Bench 350 Rod Oven</td>
<td>K2942-1</td>
<td>115/120 V/1Ph</td>
<td>169 kg up to 450 mm electrode</td>
<td>Dia. / Depth</td>
<td>457 x 483 mm</td>
<td>Fiberglass</td>
<td>38-288°C</td>
<td>Thermostat control with indicator light</td>
<td>749 x 572 x 572</td>
</tr>
<tr>
<td>HydroGuard™ Bench 350 Rod Oven</td>
<td>K2942-2</td>
<td>240/480 V/1Ph</td>
<td>169 kg up to 450 mm electrode</td>
<td>Dia. / Depth</td>
<td>457 x 483 mm</td>
<td>Fiberglass</td>
<td>38-288°C</td>
<td>Thermostat control with indicator light</td>
<td>749 x 572 x 572</td>
</tr>
</tbody>
</table>

* K2942-2 240/480 volt model is shipped without plug

* K3484-1 Thermometer Kit – allows monitoring of actual temperature ranging from 38-260°C. Certified accurate to ±12°C.
Hydroguard™ Portable Rod Ovens

Outstanding moisture resistance for improved weld quality

HydroGuard™ Portable Rod Ovens from Lincoln Electric help you protect your stick electrodes from moisture pickup, a major contributor to weld cracking and porosity.

Protect your rods and drive moisture away. Your welds depend on it.

Features

• Easy to transport to the job site.
• Makes it easy to extract your stick electrode.
• Preset 149°C temperature.
• Visually confirms operation.
• Removable, one-piece carrying handle.
• Efficiently maintains temperatures.
• Tough powder coat finish.
• Durable steel construction.

Technical Specifications

<table>
<thead>
<tr>
<th>Product</th>
<th>Item Number</th>
<th>Primary Voltage (50-60Hz)</th>
<th>Capacity</th>
<th>Chamber Size</th>
<th>Insulation</th>
<th>Temperature Range</th>
<th>Heating Element</th>
<th>Dimensions HxWxD (mm)</th>
<th>Net Weight (kg)</th>
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</thead>
<tbody>
<tr>
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<td>K2939-1</td>
<td>115/120 V/1Ph</td>
<td>4.5 kg</td>
<td>Dia. / Depth</td>
<td>7.3 x 50 cm</td>
<td>3.8 cm Fiberglass</td>
<td>Preset at 149°C</td>
<td>75 Watt Wire Wrapped</td>
<td>518 x 386 x 630</td>
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<tr>
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<td>K2939-2</td>
<td>230 V/1Ph</td>
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<td></td>
<td></td>
<td></td>
<td></td>
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</tbody>
</table>

Power On indicator light visually confirms operation.

Removable, one-piece carrying handle.
## ELECTRODE HOLDERS & GROUND CLAMPS

### GC1 150 / 200 / 300 / 600

<table>
<thead>
<tr>
<th>Clamp Item number</th>
<th>DC@35%</th>
<th>DC@60%</th>
<th>Cable Size (mm²)</th>
<th>Weight (g)</th>
<th>Norm</th>
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<tbody>
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<td>GC1-150</td>
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<td>GC1-200</td>
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<td>16-25</td>
<td>210</td>
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<tr>
<td>GC1-300</td>
<td>300</td>
<td>250</td>
<td>35-50</td>
<td>205</td>
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<td>GC1-600</td>
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### GC2 250 / 350 / 600

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<th>Cable Size (mm²)</th>
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<td>GC2-350</td>
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### GC3 200 / 300 / 500

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<th>Cable Size (mm²)</th>
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<tr>
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<td>25-35</td>
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<td>GC3-300</td>
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<td>50-70</td>
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### GC4 600 – GC5 600 / 800 / 600R

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<th>Weight (g)</th>
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<td>GC4-600</td>
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<td>GC5-600</td>
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<td>GC5-800</td>
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### EH1 300 / 500 – EH2 300 / 500

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<th>Electrode Holder Item number</th>
<th>DC@35%</th>
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<th>Max. electrode</th>
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<th>Weight (g)</th>
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<tr>
<td>EH2-300</td>
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<tr>
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### EH3 200 / 300 / 400

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<th>Norm</th>
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<td>2.5-4</td>
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<td>EH3-300</td>
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<td>4-6.3</td>
<td>50-70</td>
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<td>EH3-400</td>
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### EH4 300

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<tr>
<td>EH4-300</td>
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*www.lincolnelectriceurope.com*
## Carts & Undercarriages Overview

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
<th>Compatibility</th>
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<tbody>
<tr>
<td>K2694-1</td>
<td>4-wheeled undercarriage with gas cylinder platform delivered as a kit. For: Invertec 400SX</td>
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<tr>
<td>W0200002</td>
<td>2-wheeled cart, delivered as a kit. For: Invertec V205-TP and V205-TP</td>
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<tr>
<td>K3059-4</td>
<td>Rear-wheeled cart with front casters, single gas bottle platform and convenient handles. Small footprint fits through 762 mm door. Enables installation of two PF-4x feeders. For: PW S350/S500 and Flextec 350X/650X</td>
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<tr>
<td>K2636-1</td>
<td>Medium Two Wheel Trailer. For heavy duty road, off-road, plant and yard use. For: Vantage</td>
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<tr>
<td>K2641-1</td>
<td>Four-Wheeled Steerable Yard Trailer. For off-road, plant and yard use. Includes an automatically engaging drawbar lock. For: Vantage</td>
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**Other Accessories**

- Invertec® V205-S 2V
- Invertec® V205-S 2V
- Invertec® 400SX
- Invertec® V205-TP 2V
- Invertec® V270-TP
- Invertec® V270-TP 2V
- Invertec® 300TPX
- Invertec® 400TPX
- Aspect 300®
- Speedtec® 180C/200C
- Speedtec® 405SP
- Speedtec® 505S
- Power Wave® C300
- Power Wave® S350
- Power Wave® S500
- Power Feed® 41, 42, 44, 46
- Vantage® 410 CE
- Vantage® 500 CE
- Invertec® PC-210
- Tomahawk® 1025

See [Lincolnelectric Europe](https://www.lincolnelectriceurope.com) for more information.
**Recommended Current (A)** | **Cable size (mm²)** | **Cable length (m)** | **Electrode Holder** | **Ground Clamp** | **ITEM NUMBER**
---|---|---|---|---|---
200 | 25 | 3 | X | X | E/H-200A-25-3M
400 | 70 | 10 | X | X | E/H-400A-70-10M
400 | 70 | 5 | X | X | E/H-400A-70-5M
200 | 35 | 5 | X | X | GRD-200A-35-5M
200 | 35 | 10 | X | X | GRD-200A-35-10M
300 | 50 | 5 | X | X | GRD-300A-50-5M
300 | 50 | 10 | X | X | GRD-300A-50-10M
400 | 70 | 10 | X | X | GRD-400A-70-10M
400 | 70 | 16 | X | X | GRD-400A-70-15M
600 | 95 | 10 | X | X | GRD-600A-95-10M
120 | 10 | 5 | X | X | KIT-120A-10-5M
140 | 16 | 3 | X | X | KIT-140A-16-3M
140 | 25 | 5 | X | X | KIT-140A-25-5M
200 | 25 | 3 | X | X | KIT-200A-25-3M
200 | 35 | 5 | X | X | KIT-200A-35-5M
250 | 25 | 3 | X | X | KIT-250A-25-3M
250 | 35 | 5 | X | X | KIT-250A-35-5M
300 | 50 | 5 | X | X | KIT-300A-50-5M
400 | 70 | 5 | X | X | KIT-400A-70-5M

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**LINC SPRAY ECO**

**ANTISPATTER SPRAY**

Lincoln antispatter spray is formulated to avoid the adhesion of fused metal on the pieces to be weld or on the nozzle of the torch.

- Ecological
- CFC Free
- Water based

**Lincoln Antispatter**

- **Western Europe**
  - Item n°: KP10565-W
  - Packaging: can 400 ml
  - Conditioning: 12 cans/box

- **Eastern Europe**
  - Item n°: KP10565-E
  - Packaging: can 400 ml
  - Conditioning: 12 cans/box

**PRACTICAL**

- Ready to use (it’s a spray can)
- No silicone to be removed
- No need to clean it before painting

**SAFE**

- Not flammable
- Chlorinated solvent free
- Not toxic; not harmful; not irritant
- No need to clean it before painting

**ACOROX COOLANT**

Special anti-corrosive fluid for cooling systems of welding machines.

**FEATURES**

- Effective to -26°C
- Do not dilute

**Item n°:** K10420-1

- Packaging: can 5 liters
- Conditioning: 2 cans/box

---

**WELDING KITS**

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**ACOROX COOLANT**

---

**OTHER ACCESSORIES**

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**Chemicals**

---

**Special Anti-Corrosive Fluid for Cooling Systems of Welding Machines.**

**FEATURES**

- Effective to -26°C
- Do not dilute

**Item n°:** K10420-1

- Packaging: can 5 liters
- Conditioning: 2 cans/box
OTHER ACCESSORIES

BRUSHES

Stainless Steel Welding Wire Brush
3 x 7 Row
Item n°: KH580
Top Features
• Handy toothbrush style
• Light cleaning on stainless steel
• For confined or hard to reach areas
• Length: 20 cm
• Brush dim: 8x40 mm
Process: Stainless Steel & Titanium Welding

Stainless Steel Welding Wire Brush
2 x 9 Row
Item n°: KH581
Top Features
• Slight curve in the handle improves grip
• General light cleaning on stainless steel
• Length: 22 cm
• Brush dim: 10x66 mm
Process: Stainless Steel & Titanium Welding

Brass Welding Wire Brush
3 x 7 Row
Item n°: KH582
Top Features
• Compact toothbrush style
• Light cleaning on aluminium
• For confined or hard to reach areas
• Brass bristles are easy on aluminium surfaces
• Length: 20 cm
• Brush dim: 8x40 mm
Process: Aluminium Welding

Brass Welding Wire Brush
2 x 9 Row
Item n°: KH583
Top Features
• Curved handle improves grip
• General light cleaning on aluminium
• Brass bristles gently remove oxide layer on aluminium
• Length: 22 cm
• Brush dim: 10x66 mm
Process: Aluminium Welding

Carbon Steel Welding Wire Brush
3 x 19 Row
Item n°: KH584
Top Features
• Tempered steel bristle pattern
• Efficient general cleaning
• Length: 35 cm
• Brush dim: 18x163 mm
Process: Carbon Steel Welding

Carbon Steel Welding Wire Brush
4 x 16 Row
Item n°: KH585
Top Features
• Tempered steel bristles
• Make fast work of rust, mill scale and paint
• Length: 24 cm
• Brush dim: 20x125 mm
Process: Carbon Steel Welding

Stainless Steel Welding Wire Brush
3 x 19 Row
Item n°: KH586
Top Features
• General purpose
• Long life
• Efficient surface cleaning
• Length: 35 cm
• Brush dim: 18x163 mm
Process: Stainless Steel & Titanium Welding

Welding Brush Three Pack
Item n°: KH590
Top Features
• Compact toothbrush style set
• Easy to stow in your bag
• Perfect for small projects
Includes:
- brass bristle brush for aluminium,
- stainless bristle brush for stainless steel
- a nylon bristle brush
• Length: 18 cm
• Brush dim: 10x38 mm
Process: Carbon Steel Welding

Chipping Hammer
Item n°: KP10587-1
Top Features
• Shock reducing spring-type handle
• For cleaning flux and slag off metal
• Tough, forged-alloy steel head with vertical chisel on one hand, long tapered point on other
• Length: 24 cm
• Weight: 315 g

Inspection Mirror
Item n°: KP10587-2

PLIERS

FIX CO2 Pliers
size 1, for gas nozzles 12-15mm
Item n°: KP10520-1

size 2, for gas nozzles 15-18mm
Item n°: KP10520-2
## Gas Regulators

**Lincoln Branded**

### GAS REGULATORS

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<tr>
<th><strong>Cylinder connection thread</strong></th>
<th><strong>Outlet connection</strong></th>
<th><strong>Hose connection</strong></th>
<th><strong>Part Number</strong></th>
<th><strong>Description</strong></th>
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<td><strong>G4/”</strong></td>
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### Specifications

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<th><strong>FLOW (lpm)</strong></th>
<th><strong>SUPPLY PRESSURE GAUGE (bar)</strong></th>
<th><strong>FLOW GAUGE (lpm)</strong></th>
<th><strong>DELIVERY PRESSURE</strong> (bar)</th>
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* side inlet connection

**Flowgauge regulator**

- **LE601D-L** for light duty MIG/TIG application
- **LE250L** for all MIG/TIG application
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<th>Description</th>
<th>Part Number</th>
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**GAS REGULATORS**

**Compact single stage flowgauge regulator**

**Features**
- Maximum inlet pressure 230 bar
- 50 mm safety gauge
- Rear inlet connection (side inlet connection for Spain and Portugal)

**Applications**
- Light duty MIG/TIG welding

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**Flowgauge regulator**

**Features**
- Forged brass body for maximum strength
- Maximum inlet pressure 230 bar

**Applications**
- All MIG/TIG welding applications

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**Flowgauge regulator**

**Features**
- Forged brass body for maximum strength
- Maximum inlet pressure 230 bar

**Applications**
- All MIG/TIG welding applications

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**Electrically heated flowgauge regulator**

**Features**
- Forged brass body for maximum strength
- Maximum inlet pressure 230 bar

**Applications**
- All MIG/TIG welding applications

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**Two stage flowmeter regulator**

**Features**
- Forged Two Stage flowmeter regulator
- Forged brass body for maximum strength
- Cylinder gas supplied
- Inlet filter to protect against contamination
- Precise gas flow control
- Strong, resistant with good 360° visibility flowmeter made of polycarbonate
- Side entry

**Applications**
- All MIG/TIG welding applications

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**Inert gas guard**

**Features**
- To be connected between your existing flowmeter and hose.
- LE603 Inert Gas Guard is designed to save shielding gases in two ways:
  - by reducing the gas surge when a MIG gun or TIG torch is activated. As they are designed to reduce the pressure held in supply hose, gas waste is reduced when the gun or torch is triggered
  - by delivering a controlled flow rate
- Operators will typically set shielding gas flow rates higher than necessary for a welding operation. Once set by a supervisor, the Inert Gas Guard delivers the precise amount of flow for the operation, eliminating the needless waste of gas.
- Designed to eliminate the pressure surge at the beginning of each weld in MIG/TIG welding, maintains a constant flow and pressure with each weld, permits gas savings over 60%.
CrossLinc Technology™, now inside the New Flextec® 350X welders and LN-25X feeder

Now the Two of You Can Talk.
More Control. Fewer Cables.
CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric Europe is manufacturing and selling high quality welding equipment, consumables and cutting equipment. Our challenge is to meet the needs of the customer 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 responsibility, 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. 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.

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