

# Magnum<sup>®</sup> PRO Fume Guns

## Processes

MIG, Pulsed-MIG, Flux-Cored

## Product Number

K2649-1 Magnum<sup>®</sup> PRO Fume 350

K2650-1 Magnum<sup>®</sup> PRO Fume 550

## Amperage Rating 100% Duty Cycle

K2649-1 CO<sub>2</sub>: 350 Mixed: 285  
K2650-1 CO<sub>2</sub>: 550 Mixed: 375

## Wire Diameter Range In. (mm)

.035 - 5/64 (0.9 - 2.0)  
.035 - 1/8 (0.9 - 3.2)

## Cable Length ft. (m)

15 (4.5)

## Semiautomatic Air-Cooled Fume Extraction Guns

Magnum<sup>®</sup> PRO fume guns are designed to stand up to high productivity fabrication and production environments. For high amperage semiautomatic welding where long hours of arc time are the norm, choose Magnum<sup>®</sup> PRO.

### FEATURES

- ▶ **All Guns Rated at 100% Duty Cycle**
- ▶ **Industrial Grade Construction**
  - High quality copper and aluminum parts ensure superior electrical contact and heat dissipation.
  - Four trigger leads are standard for fast field repair.
  - Patent-pending Anti-Seize™ tip and diffuser thread design reduces part fusing and seizing.
- ▶ **Lincoln Copper Plus™ Contact Tips** - Larger tip diameter and mass improves heat dissipation to increase tip life.
- ▶ **Comfort Grip™ Handle** - Barrel style allows more hand positions and a comfortable grip.
- ▶ **Innovative Strain Relief** - Swivels to take pressure off the operator's wrist, includes flexible bellows to make out-of-position work more comfortable and features Kevlar® sheathing to extend fume hose and gun cable life.
- ▶ **Shared Expendable Parts** - Both guns use the standard Magnum<sup>®</sup> PRO semiautomatic 550A gun tips, nozzles, and diffusers.



## MAGNUM<sup>®</sup> PRO

### WHAT'S INCLUDED

- ▶ Contact Tip
- ▶ 5/8 in. (16 mm) Slip-On Gas Nozzle
- ▶ Slip-On Diffuser
- ▶ FCAW Smoke Extractor Nozzle

### GUN REQUIRES

- ▶ Gun Connector Kit
- ▶ Gun Liner

### COMPATIBLE FUME FILTRATION SYSTEMS

- ▶ X-Tractor® 3A
- ▶ X-Tractor® 5A
- ▶ X-Tractor® 8A

\*Not suitable with Miniflex® type systems.

### APPLICATIONS

- ▶ Industrial Fabrication
- ▶ Heavy Equipment
- ▶ Shipbuilding

Web Update 02/11

Publication E12.02 | Issue Date 12/10  
© Lincoln Global, Inc. All Rights Reserved.

THE LINCOLN ELECTRIC COMPANY  
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.  
PH: +1.216-481-8100 • www.lincolnelectric.com

**LINCOLN<sup>®</sup>**  
**ELECTRIC**  
THE WELDING EXPERTS<sup>®</sup>

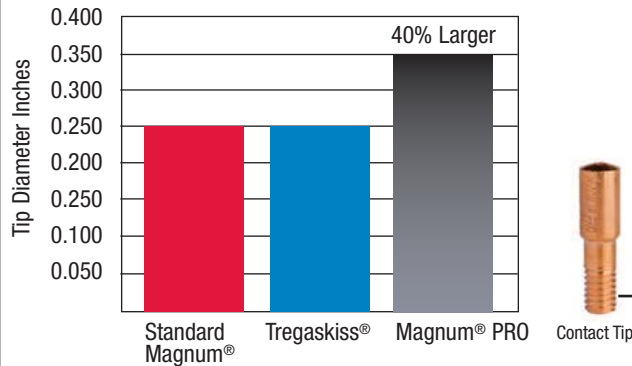
- Gun Tube**
  - Copper - High quality copper inner tube enhances electrical conductivity.
  - Positive-lock gun tube locking ring system allows for bottom trigger operation.
- Gun Handle**
  - Barrel style offers more grip positions.
- Strain Relief**
  - Swivels for wrist comfort.
  - Flexible Bellows makes long hour more comfortable for out-of-position work.
  - Kevlar® Sheathing extends the service life of the fume hose and gun cable assembly.
- Trigger**
  - Silver-plated contacts.
  - Positive contact trigger (not a micro-switch).
  - Trigger-Guard™ Prevents accidental triggering.
  - Locking trigger kit available.
- Contact Tip Technology**
  - Lincoln Copper Plus™ – More copper for better heat dissipation.
  - Anti-Seize™ thread design on contact tips and diffuser.
- Gun cable connection system**
  - Inner barbed connection securely fastens gun cable core tube to prevent gas leaks.
  - Re-usable barbed outer locking collar securely clamps the gun cable jacket.
  - Large electrical contact surface area between gun cable and gun body ensure long life.
  - Extra trigger leads allow fast, easy servicing.

LINCOLN COPPER PLUS™ CONTACT TIP TECHNOLOGY

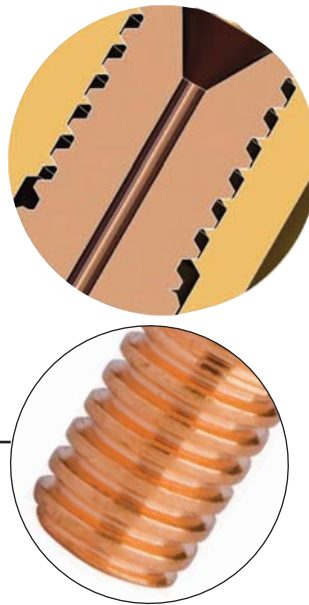
Tip Diameter

Lincoln Copper Plus™ Contact Tips  
Compare Magnum® PRO tips to Standard Magnum® and Tregaskiss®

Larger Diameter Means More Copper.  
The Result? Greater Heat Dissipation and Longer Life



Tregaskiss is a trademark of Tregaskiss, wholly owned subsidiary of Illinois Tool Works.



Patent-pending Anti-Seize™ Thread Design

Flattened thread profile increases the thread cross-section where heat typically concentrates and tips generally fail. The result is reduced melting, fusion and seizing and extended contact tip service life. Longer life and fewer tip changes reduce expendable part and labor costs while increasing arc time.

**STEP 1**  
**SELECT YOUR GUN**

- A** Select Your Amperage | **B** Select your Usage | **C** Select your Gas | **D** Select your Gun

<b>A</b> Amperage	250	300	350	400	450	500	550	600	650	700	750	800	850	
<b>B</b> Usage (Duty Cycle)	Up to 100%													
<b>C</b> Gas Type														<b>D</b> Recommended Gun
Mixed Gas CO <sub>2</sub>	[Blue bars indicating usage range from 250 to 550]													Magnum® PRO Fume 550 K2650-1
Mixed Gas CO <sub>2</sub>	[Blue bars indicating usage range from 250 to 350]													Magnum® PRO Fume 350 K2649-1

**STEP 2**  
**SELECT YOUR GUN CONNECTOR KIT**

<b>GUN CONNECTOR KIT</b>			
Manufacturer	Wire Feeder Model	Magnum® PRO Fume 350	Magnum® PRO Fume 550
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8	K613-6
	LF-72, LF-74 Series, LN-25 PRO	K466-10	K613-7 <sup>(1)</sup>
	Power Feed™ 10 and 25 series	K466-10	K613-7 <sup>(1)</sup>
	POWER MIG® Series and Power Wave® C300	K466-6	NA
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2	K613-2
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	K466-3	K613-3



K466-10 Shown

(1) K1500-3 Gun Receiver Bushing is required for Power Feed 10 series, LF series and LN-25 PRO wire feeders.

**STEP 3**  
**SELECT YOUR LINER**

<b>MAGNUM® PRO FUME 350</b> in. (mm)		
.035-.045 (0.9-1.2)	.052-1/16 (1.3-1.6)	1/16-5/64 (1.6-2.0)
KP44-3545-15	KP44-116-15	KP44-564-15

<b>MAGNUM® PRO FUME 550</b> in. (mm)			
.035-.045 (0.9-1.2)	.052-1/16 (1.3-1.6)	5/64-3/32 (2.0-2.4)	7/64-1/8 (2.8-3.2)
KP45-3545-15	KP45-116-15	KP45H-332-15	KP45-18-15

**EXPENDABLE PARTS**

**Magnum® PRO Fume 350 and 550**

Both 350 and 550 Fume Guns use Magnum® PRO 550 expendables.



Contact Tip for up to 550 A

<b>CONTACT TIPS 550 A</b>				
Wire Diameter in. (mm)	Standard	Standard	Extended Life	Extended Life
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP2745-035	KP2745-035-B100	KP2745-035R	KP2745-035R-B100
0.040 (1.0)	KP2745-040	KP2745-040-B100	NA	NA
0.045 (1.2)	KP2745-045	KP2745-045-B100	KP2745-045R	KP2745-045R-B100
0.052 (1.3)	KP2745-052	KP2745-052-B100	KP2745-052R	KP2745-052R-B100
1/16 (1.6)	KP2745-116	KP2745-116-B100	KP2745-116R	KP2745-116R-B100
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072-B100	KP2745-072R	KP2745-072R-B100
5/64 (2.0)	KP2745-564	KP2745-564-B100	KP2745-564R	KP2745-564R-B100
3/32 (2.4) <sup>(1)</sup>	KP2745-332	KP2745-332-B100	KP2745-332R	KP2745-332R-B100
7/64 (2.8) <sup>(1)</sup>	KP2745-764	KP2745-764-B100	KP2745-764R	KP2745-764R-B100
1/8 (3.2) <sup>(1)</sup>	KP2745-18	KP2745-18-B100	NA	NA

(1) 550 only

<b>GUN TUBE INSULATORS 550 A</b>	
Pkg Qty.	Part Number
1	KP2773-1
25	KP2773-1-B25



Gun Tube Insulator

<b>DIFFUSERS 550 A</b>		
Type		
Pkg Qty.	Thread on	Slip on
1	KP2747-1	KP2747-2
25	KP2747-1-B25	KP2747-2-B25



Gas Diffuser Slip-on



Gas Diffuser Thread-on

<b>GAS NOZZLE 550A</b>			
Nozzle Diameter (I.D.)			
Nozzle in. (mm)	Pkg. Qty.	0.625(5/8) in. (15.9 mm)	
		1/8 (3.2) Recess	1 25
Flush	1 25	KP2743-1-62F KP2743-1-62F-B25	
	1/8 (3.2) Stickout	1 25	KP2743-1-62S KP2743-1-62S-B25
1/8 (3.2) Recess	1 25	KP2743-2-62R KP2743-2-62R-B25	
	Flush	1 25	KP2743-2-62F KP2743-2-62F-B25
1/8 (3.2) Stickout		1 25	KP2743-2-62S KP2743-2-62S-B25



Nozzle Thread-on 1/8" Recessed

**OPTIONAL PARTS**

<b>TRIGGER KIT</b>	
Description	Part Number
Locking Trigger Kit	KP2870-1

<b>SMOKE EXTRACTOR NOZZLES MAGNUM® PRO</b>	
Nozzle	Part Number
GMAW Fume Extractor Nozzle	KP2871-1
FCAW Fume Extractor Nozzle	KP2872-1 (1)

(1) Standard with gun

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	Amperage Rating 100% Duty Cycle		Wire Diameter Range In. (mm)	Cable Length ft. (m)
		CO <sub>2</sub>	Mixed		
Magnum® PRO Fume 350	K2649-1	350	285	.035 - 5/64 (0.9 - 2.0)	15 (4.5)
Magnum® PRO Fume 550	K2650-1	550	375	.035 - 1/8 (0.9 - 3.2)	15 (4.5)

Under the OSHA Hexavalent Chromium Standard\* for all employers, ENGINEERING CONTROLS ARE REQUIRED TO BE IMPLEMENTED BY NO LATER THAN May 31, 2010 to reduce the permissible exposure limit for hexavalent chromium to less than 5 micrograms per cubic meter measured as an 8-hour time-weighted average.

\* Chromium (VI) 1910.1026 App A

[www.lincolnelectric.com/weld-fume-control](http://www.lincolnelectric.com/weld-fume-control)

The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

**CUSTOMER ASSISTANCE POLICY**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.

