

# Power Feed® 25M and 25M Aluminum

## Processes

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

## Product Number

K2536-4 Red Aluminum Case  
K2536-5 Plastic Case  
K4191-1 Plastic Case for Aluminum

## Input Power

40 VDC

## Rated Output Current/Duty Cycle

500A/60%

## Gearing

See Back

## Wire Speed Range

See Back

## Wire Feed Speed

See Back

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

35 lbs. (15.9 kg)  
14.5 x 8.5 x 23.5 in.  
(368 x 216 x 597 mm)

See back for complete specs

## Advanced process control. Rugged, portable design.

This compact shop or construction wire feeder is push-pull capable for premium aluminum welding. Featuring our MAXTRAC® drive system, full controls and procedural memory presets, the Power Feed® 25M is ready for advanced process welding on almost any application.

### FEATURES

- ▶ **Push-Pull Functionality** - Delivers premier aluminum performance by offering uniform feeding, as well as the ability to extend gun to feeder distance.
- ▶ **Internal Lighting** - Illuminates the wire drive for working in dark environments.
- ▶ **Internal Heating** - Maintains control of humidity by keeping consumables warmed and protected within the enclosed case.
- ▶ **Dual Procedure and Memory Buttons** - Allow you to set an A and B procedure to simplify 'on-the-fly' switching. Allows the operator to easily recall a waveform and specify the range of operation for the application.
- ▶ **Compact Case Design** - Fits through a 16 in. (406 mm) diameter or 12 x 18 in. (305 x 457 mm) opening. Ideal for construction and shipbuilding.

### APPLICATIONS

- ▶ Metal Fabrication
- ▶ Construction
- ▶ Shipbuilding



Red Aluminum Case  
K2536-4

Plastic Case  
K2536-5

Plastic Case for Aluminum  
K4191-1

### WHAT'S INCLUDED

- ▶ Flow Meter
- ▶ Gas Solenoid
- ▶ Gun Bushing
- ▶ Dual Procedure and Memory
- ▶ Electrode Pigtail

### RECOMMENDED POWER SOURCES<sup>(1)</sup>

- ▶ Power Wave® 355M
- ▶ Power Wave® 455M
- ▶ Power Wave® 455M/STT®
- ▶ Power Wave® 655R
- ▶ Power Wave® S350
- ▶ Power Wave® R350

<sup>(1)</sup> No Linc-Net™ support for older non-M series Power Wave® units

### INPUT



### OUTPUT

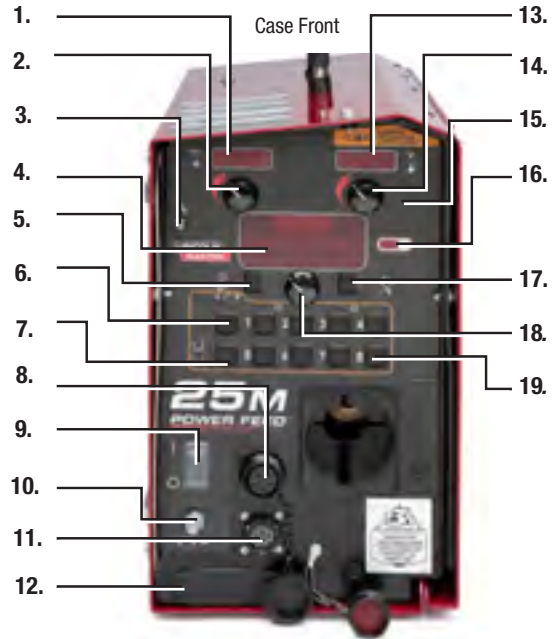


Two Year Extended  
Warranty Available in  
the U.S.A. and Canada



## KEY CONTROLS

1. **Left Display Window** - Shows wire feed speed or amperage.
2. **Continuous Wire Feed Speed (WFS) Amps Control** - Adjust WFS for MIG and flux-cored; adjust amps for stick or TIG.
3. **Status LED** - Shows a steady green when properly communicating to the power source.
4. **Main Display** - Shows detailed welding and diagnostic information.
5. **UltimArc™ Control** - Adjust arc characteristics to match individual preferences.
6. **Dual Procedure** - Toggle between two weld procedures while welding.
7. **2-Step/4-Step** - For trigger interlock capability.
8. **Five Pin Connector** - Trigger connector for a push-only gun.
9. **On/Off Power Switch** - Protected from the elements.
10. **3 Amp Circuit Breaker** - Protects the 12-pin accessories.
11. **Twelve Pin Universal Remote Control Receptacle** - For connecting remote output control or push-pull gun.
12. **Cover** - Covers location for optional water cooling line.
13. **Right Display Window** - Shows voltage or trim.
14. **Continuous Volts/Trim Control** - Adjust voltage for MIG and flux-cored; adjust arc length (trim) for Pulsed MIG.
15. **Thermal LED** - Lights when the drive overheats.
16. **Set-Up** - Lights when feeder is set-up.
17. **Advanced Process Options** - Control pre-weld and post-weld settings to optimize arc starts and stops.
18. **Weld Mode Search** - Search for an appropriate mode based on material, process, shielding gas and other parameters.
19. **Memory Presets** - Store up to 8 customized weld procedures.



1. **Flowmeter with Control Valve** - Regulate and monitor shielding gas flow at the feeder to compensate for long shielding gas hoses.
2. **Shielding Gas Input** - Rugged, one piece solenoid includes a screen to filter dirt.
3. **4/0 Electrode Lead** - Rated for high amperage welding. Add connector of your choice.
4. **Five Pin ArcLink® Connector** - Now with a patent pending Spin-Nut™ for easy connection of the cable.

### 1. Two Roll MAXTRAC® Wire Drive System

- Two gear driven rolls with patented groove design. No tools needed to remove rolls (Note: some rolls have grooves of different sizes).
- Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
- Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.

### 2. Gas Purge/Cold Feed Switch -

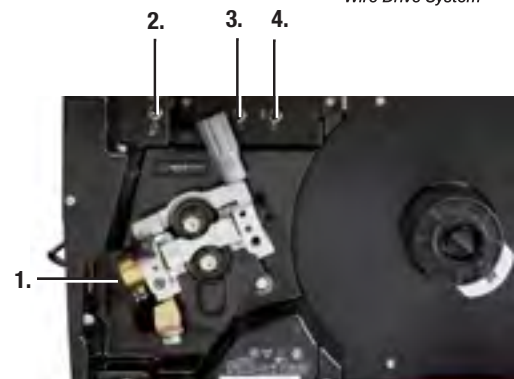
Clears shielding gas with cold feed electrode for safety.

### 3. Light Switch -

Turns on high intensity LED's to illuminate the inside of wire feeder.

### 4. Heater Switch -

The built-in heater warms the inside air to protect consumables from moisture.



## FEATURES

### ARCLINK®/LINC-NET™ CONTROL EXTENSION CABLES

Length ft. (m)	Product Description	Order Number
8 (2.5)	ArcLink® without weld cable	K1543-8
25 (7.6)	ArcLink® without weld cable	K1543-25
50 (15.2)	ArcLink® without weld cable	K1543-50
100 (30.4)	ArcLink® without weld cable	K1543-100
25 (7.6)	Heavy duty ArcLink® control cable	K2683-25
50 (15.2)	Heavy duty ArcLink® control cable	K2683-50
100 (30.4)	Heavy duty ArcLink® control cable	K2683-100

### WELD POWER CABLES

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
10 (3)	600	60%	3/0	K1842-10
35 (10.5)	600	60%	3/0	K1842-35
60 (18)	600	60%	3/0	K1842-60
110 (33.5)	600	60%	3/0	K1842-110

Note: All sizes are lug to lug connection type.

### COAXIAL WELD POWER CABLES<sup>(1)</sup>

Length ft. (m)	Amperage	Duty Cycle	Size	Order Number
25 (7.6)	350	60%	1/0	K1796-25
50 (15.2)	350	60%	1/0	K1796-50
75 (22.8)	300	60%	1/0	K1796-75
100 (30.4)	250 300	100% 60%	#1 1/0	K2593-100 K1796-100

<sup>(1)</sup> Recommended for STT® and pulse welding when using long distances between feeder and power source.

Note: All sizes are lug to lug connection type.

### DRIVE ROLL & WIRE GUIDE KITS

Description in. (mm)	Order Number
<b>Steel Wire Sizes (includes stainless steel):</b>	
0.023-0.030 (0.6-0.8)	KP1696-030S
0.035 (0.9)	KP1696-035S
0.045 (1.2)	KP1696-045S
0.052 (1.4)	KP1696-052S
0.035, 0.045 (0.9, 1.2)	KP1696-1
0.040 (1.0)	KP1696-2
1/16 (1.6)	KP1696-1/16S
<b>Cored Wire Sizes:</b>	
0.030-0.035 (0.8-0.9)	KP1697-035C
0.040-0.045 (1.0-1.2)	KP1697-045C
0.052 (1.4)	KP1697-052C
1/16 (1.6)	KP1697-1/16C
<b>Steel or Cored Wire Sizes:</b>	
0.068-0.072 (1.8)	KP1697-068
5/64 (2.0)	KP1697-5/64
3/32 (2.4)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
0.035 (0.9)	KP1695-035A
0.040 (1.0)	KP1695-040A
3/64 (1.2)	KP1695-3/64A
1/16 (1.6)	KP1695-1/16A

### FEED PLATE GUN ADAPTERS

K1500-1	K1500-2	K1500-3	K1500-4	K1500-5	Magnum® PRO Fast-Mate™
Lincoln Electric  Compatible gun connector kits K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4  Compatible gun connector kits K466-10 K466-2 K466-6	Tweco #5  Compatible gun connector kit K613-7 K613-2	Miller® guns  Compatible gun connector kits K466-3 K613-3	OXO® guns	Compatible gun connector kits K489-1 K489-2 K489-7 K489-8
					

Tweco® is a registered trademark of Victor Technologies.  
Miller® is a registered trademark of Miller Electric Mfg. Co.  
Oxo® is a registered trademark of Miller Electric Mfg. Co.

## RECOMMENDED ACCESSORIES



**Magnum® PRO GUNS**  
Choose Magnum® PRO GMAW/FCAW Barrel or Curve™ or fume models or select a K126™ PRO FCAW model for construction environments.  
**See publication E12.09**



**Cougar™ Pistol-Grip Air-Cooled Push-Pull Gun**  
Intended for those operators who prefer an upright pistol-grip design for aluminum welding fabrication or production. Features Sure-Grip™ handle, integrated strain relief and multi-turn potentiometer. Rated 300A @ 60% duty cycle w/Argon. Requires K2910-1 7-pin to 12-pin Adapter.  
**Order K2704-2** 25 ft. (7.6 m)  
**K2704-3** 50 ft. (15.2 m)



**Water Connection Kit**  
Includes fittings for use with water-cooled guns and Magnum® coolers. Kit provides for one gun.  
**Order K590-6**



**Push-Pull Gun Connection Kit**  
For push-pull guns. Includes push-pull gun receiver bushing, fittings, modified gas-bypass valve, valve removal tool and control cable extension assembly.  
**Order K2339-1**



**Deluxe Adjustable Gas Regulator & Hose Kit**  
Accommodates CO<sub>2</sub>, Argon, or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.  
**Order K586-1**



**Micro Wire Straightener**  
Straightens .035-1/16 in. (0.9-1.6 mm) wire for use with portable feeders.  
**Order K1733-4**



**ArcLink® "T" Connector Kit**  
For connecting multiple feeders to a single power source.  
**Order K2429-1**



**Portable Feeder Case-Plastic**  
Replace a damaged case without replacing the entire unit.  
**Order K2596-2**



**6-pin to 12-pin Adapter**  
Use for adapting existing 6-pin remote controls such as the K870, K857, and K963-3 to the new 12-pin connector.  
**Order K2909-1**



**7-pin to 12-pin Adapter**  
Use for connecting 7-pin push-pull guns such as the Python® Plus to the new 12-pin connector.  
**Order K2910-1**



**Remote Output Control with 12-pin Universal Connector**  
Consists of a control box with choice of two cable lengths. Permits remote adjustment of output.  
**Order K857-2** 25 ft. (7.6 m)

### TIG OPTIONS



**PTA-17 150 Amp Air-Cooled TIG Torch**  
**Order K1782-2** for 12.5 ft. (3.8 m) length, 2-cable  
**Order K1782-4** for 25 ft. (7.6 m) length, 2-cable



**PTA-26 200 Amp Air-Cooled TIG Torch**  
**Order K1783-2** for 12.5 ft. (3.8 m) length, 2-cable  
**Order K1783-4** for 25 ft. (7.6 m) length, 2-cable



**Foot Amptrol™ with 12-pin Universal Connector**  
Provides 25 ft. (7.6 m) of remote current control for TIG welding.  
**Order K870-2**



**Hand Amptrol™ with 12-pin Universal Connector**  
Provides 25 ft. (7.6 m) of remote current control for TIG welding.  
**Order K963-4**

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
						Solid	Cored		
Power Feed 25M Aluminum Case	K2536-4	40 VDC	500A/60%	Standard speed (factory setting)	GMAW: 50-800 (1.3 - 20.3)	0.023-1/16 (0.6-1.6)	0.030-5/64 (0.8-2.0)	14.5 x 8.5 x 23.5 (368 x 216 x 597)	35 (15.9)
Power Feed 25M Plastic Case	K2536-5				FCAW: 50-800 (1.3 - 20.3)				
Power Feed 25M Plastic Case for Aluminum	K4191-1			Extra-torque	GMAW: 30-400 (0.8-10.2)	0.023-1/16 (0.6-1.6)	0.030-3/32 (0.8-2.4)		

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.

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