LN-25X™
Fewer cables. Greater control.

PORTABLE INDUSTRIAL WIRE FEEDER

We understand the needs of those working hard in the field every single day. Whether you’re working on a large structure in a shipyard, or you’re 100 feet off of the ground, your safety and efficiency should never be jeopardized. The less you have to move, the more valuable you are. We believe good equipment should never limit your capabilities, and the LN-25X wire feeder with CrossLinc® and True Voltage Technology™ (TVT™) helps you get the job done with drastically less movement.

Processes
MIG, Flux-Cored

Applications
Construction, Pipe, Metal Fabrication, Shipbuilding, Rental Fleet

Input
16-110 VDC

Output
30130

Product Number
K4267-4 LN-25X w/TVT CE Model (Twistmate/Dinse, w/Flowmeter)
Features

- **Maxtrac® Wire Drive System**
  - Heavy-duty cast aluminum wire drive system provides reliable feeding and durability
- **CrossLinc® Technology** – Control output at a distance with no additional cables
- **True Voltage Technology™ (TVTT™)**
  - Voltage drop compensation. Get what you set
- **Tachometer feedback** ensures accurate wire feed speed
- **Trigger Interlock Switch** – Provides operator comfort for long welds
- **Replaceable and Flame Resistant Case** – Protects internal components, easy to replace
- **Potted PC Boards** – For moisture and corrosion protection
- **Split Wire Guide** — Reduces birdnesting and allows for easy cleaning no-fuss wire guide alignment
- **Bright digital meters** for easy viewing even in bright sunlight
- **Included Twistmate/Dinse style male connector** on input power cable
- **Optional Flowmeter** – for easy gas flow adjustment at the feeder
- **Weld Timers** – Pre-Flow, Post-Flow, and Burn Back
- **Adjustable Wire Run-In Speed** – for softer starting
- **Configurable for English or metric units**
- **Arc Hours Meter**

**Technology Spotlight**

1. **Brass to Brass Interchangeable Gun Bushings** options for most weld gun styles. Excellent electrical contact for consistent arc.
2. **Rigid Cast Aluminum Frame**
3. **Twist-Lock Drive Roll Hubs** toolless drive roll replacement
4. **Patented Dual Spring Pressure Arm** optimized for both soft and hard wires
5. **Patented Split Wire Guides** nothing to align, easy wire loading, easy to clean
6. **Separate Drive Gear** reduced force on the drive motor shaft for consistent feeding
7. **Patented Drive Rolls** Patented Dual Groove Drive Roll
CrossLinc w/True Voltage Technology (TVT) – Improve all aspects of your operation with CrossLinc Technology and TVT.

CrossLinc Technology Communicates Settings Directly Over The Weld Cables.
- No additional control cable is needed.
- Pre-set the desired voltage on the feeder.
- The feeder sends the signal to the CrossLinc enabled power source.
- The CrossLinc compatible power source puts out the desired voltage.
- The Activ8X receives the voltage and lets you know the actual voltage at the arc.

Safety
- Reduce jobsite clutter by removing cumbersome control cables.
- Eliminate unnecessary movement of personnel across the jobsite.
- No need to drag heavy control cables around the site.

Quality
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

Productivity
- Setup faster with fewer cable connections.
- Eliminate trips to the power source to make procedure adjustments.
- Minimize rework with easy settings adjustments.

As is common in many outdoor welding applications: (Structural steel, Shipbuilding, Offshore, etc.) the operator can be located hundreds of feet away from the power source. Long cables and multiple connections can create a difference in voltage (voltage drop) between the power source and the weld. In the example to the right, 24volts is set on the welding power source. Due to electrical resistance through long cables, only 20volts are actually available at the arc. This may result in a cold weld.

True Voltage Technology (TVT) sees this drop and gives you the true voltage you set by adjusting the power source to compensate for the voltage drop. In the example below, 24v is preset at the Activ8X wire feeder. TVT senses there is a 4 volt drop due to long weld cables and compensates by increasing the welder output to 28V. The result is the desired 24v available at the welding arc.
## MAXTRAC DRIVE ROLL & WIRE GUIDE KITS

<table>
<thead>
<tr>
<th>Description</th>
<th>Product No.</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Steel Wire Sizes</strong> <em>(includes stainless steel):</em></td>
<td></td>
</tr>
<tr>
<td>.023-.030 in (0.6-0.8 mm)</td>
<td>KPI696-030S</td>
</tr>
<tr>
<td>.035 in (0.9 mm)</td>
<td>KPI696-035S</td>
</tr>
<tr>
<td>.045 in (1.2 mm)</td>
<td>KPI696-045S</td>
</tr>
<tr>
<td>.052 in (1.4 mm)</td>
<td>KPI696-052S</td>
</tr>
<tr>
<td>.035, .045 in (0.9, 1.2 mm)</td>
<td>KPI696-1</td>
</tr>
<tr>
<td>.040 in (1.0 mm)</td>
<td>KPI696-2</td>
</tr>
<tr>
<td>1/16 in (1.6 mm)</td>
<td>KPI696-1/16S</td>
</tr>
<tr>
<td><strong>Cored Wire Sizes:</strong></td>
<td></td>
</tr>
<tr>
<td>.030-.035 in (0.8-0.9 mm)</td>
<td>KPI697-035C</td>
</tr>
<tr>
<td>.040-.045 in (1.0-1.2 mm)</td>
<td>KPI697-045C</td>
</tr>
<tr>
<td>.052 in (1.4 mm)</td>
<td>KPI697-052C</td>
</tr>
<tr>
<td>1/16 in (1.6 mm)</td>
<td>KPI697-1/16C</td>
</tr>
<tr>
<td><strong>Steel or Cored Wire Sizes:</strong></td>
<td></td>
</tr>
<tr>
<td>.068-.072 in (1.8 mm)</td>
<td>KPI697-068</td>
</tr>
<tr>
<td>5/64 in (2.0 mm)</td>
<td>KPI697-5/64</td>
</tr>
<tr>
<td>3/32 in (2.4 mm)</td>
<td>KPI697-3/32</td>
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<tr>
<td><strong>Aluminum Wire Sizes:</strong></td>
<td></td>
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<tr>
<td>.035 in (0.9 mm)</td>
<td>KPI695-035A</td>
</tr>
<tr>
<td>.040 in (1.0 mm)</td>
<td>KPI695-040A</td>
</tr>
<tr>
<td>3/64 in (1.2 mm)</td>
<td>KPI695-3/64A</td>
</tr>
<tr>
<td>1/16 in (1.6 mm)</td>
<td>KPI695-1/16A</td>
</tr>
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### REQUIRED ACCESSORIES

#### FEED PLATE GUN ADAPTERS

<table>
<thead>
<tr>
<th>K1500-1&lt;sup&gt;(1)&lt;/sup&gt;</th>
<th>K1500-2&lt;sup&gt;(1)&lt;/sup&gt;</th>
<th>K1500-3</th>
<th>K1500-4</th>
<th>K1500-5</th>
<th>K489-7</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Lincoln Electric</strong></td>
<td><strong>Tweco® #2 - #4</strong></td>
<td><strong>Miller® Guns</strong></td>
<td><strong>OXO® Guns</strong></td>
<td><strong>Fast-Mate™ / Euro Connector</strong></td>
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</tr>
<tr>
<td>Compatible gun connector kits:</td>
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</tr>
<tr>
<td>K466-1</td>
<td>K466-10</td>
<td>K466-7</td>
<td>K466-3</td>
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<td>K613-1</td>
<td>K466-2</td>
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<td>K613-6</td>
<td>K466-6</td>
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</tbody>
</table>

<sup>(1)</sup>Included in machine.  <sup>(2)</sup>Installed in machine.

#### WELD POWER CABLES

<table>
<thead>
<tr>
<th>Index</th>
<th>Description</th>
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<tbody>
<tr>
<td>K14166-1</td>
<td>Weld Power Cable, TM-TM, 70MM2-10M</td>
</tr>
<tr>
<td>K14166-2</td>
<td>Weld Power Cable, TM-TM, 70MM2-15M</td>
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<td>K14166-3</td>
<td>Weld Power Cable, TM-TM, 70MM2-5M</td>
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<td>K14166-4</td>
<td>Weld Power Cable, TM-TM, 70MM2-30M</td>
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<tr>
<td>K14167-1</td>
<td>Weld Power Cable, TM-TM, 95MM2-30M</td>
</tr>
<tr>
<td>K14167-2</td>
<td>Weld Power Cable, TM-TM, 95MM2-5M</td>
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<tr>
<td>K14167-3</td>
<td>Weld Power Cable, TM-TM, 95MM2-10M</td>
</tr>
<tr>
<td>K14167-4</td>
<td>Weld Power Cable, TM-TM, 95MM2-15M</td>
</tr>
</tbody>
</table>

## REMARKS

- Included in machine.
- Installed in machine.
RECOMMENDED POWER SOURCES

Look for the X

CrossLinc compatible feeders and power sources carry an X in their name, i.e. LN-25X, FLEXTEC® 350X. When paired together, CrossLinc communication will be established.

The LN-25X will also work with any CV power source as a simple, across the arc feeder, but without CrossLinc or TVT capabilities.
KEY CONTROLS

FRONT VIEW
1. Work Power Lead
2. Wire Feed Speed Control
3. Wire Feed Speed/Amp Display
4. Voltage Display
5. Hidden Setup Menu Access
6. Voltage Control
7. Gun Connection Block
8. 5-pin Gun Trigger Connector

BACK VIEW
9. Optional Flow Meter
10. Shielding Gas Inlet
11. Work Sense Lead
12. Electrode Lead (w/Dinse)

INSIDE VIEW
13. Cold Feed Switch
14. MAXTRAC Drive System
15. 2-Step / 4-Step Switch
16. Spool Retainer
17. Spindle Brake
K489-7  
Fast-Mate EURO Adapter

K2330-2  
Preflow, Postflow and Burnback Timer Kit

Weld Power Cable  
Twist Mate to Twist Mate
K4166-1 (70MM2-10M)  
K4166-2 (70MM2-15M)  
K4166-3 (70MM2-25M)  
K4166-4 (70MM2-30M)  
K4167-1 (95MM2-30M)  
K4167-2 (95MM2-50M)  
K4167-3 (95MM2-100M)  
K4167-4 (95MM2-150M)

LGS2 MIG/MAG TORCHES  
W10429-36-xM  
(x = 3, 4, 5 length in m)

K126-11 (15ft 062-332)  
K126-12 (15ft 1/16-5/64)

Steel Wire Drive Roll Kits
Includes: 2 V groove drive rolls and inner wire guide  
KP1696-030S .023-.030 (0.6-0.8MM)  
KP1696-035S .035 (0.9MM)  
KP1696-045S .045 (1.2MM)  
KP1696-052S .052 (1.4MM)  
KP1696-1/16S 1/16 (1.6MM)  
KP1696-1.035-.045 (0.9, 1.2MM)  
KP1696-2 .040 (1.0MM)

Cored Wire Drive Roll Kits
Includes: 2 knurled drive rolls and inner wire guide  
KP1697-035C .030-.035” (0.8-0.9MM)  
KP1697-045C .040-.045” (1.0-1.2MM)  
KP1697-052C .052” (1.4MM)  
KP1697-1/16C 1/16” (1.6MM)  
KP1697-068 .068-.072” (1.7-1.8MM)  
KP1697-5/64 5/64” (2.0MM)  
KP1697-3/32 3/32” (2.4MM)

Aluminum Wire Drive Roll Kits
Includes: 2 polished U groove drive rolls, outer wire guide and inner wire guide  
KP1695-035A .035” (0.9 MM)  
KP1695-040A .040” (1.0MM)  
KP1695-3/64A 3/64” (1.2MM)  
KP1695-1/16A 1/16” (1.6MM)

R-2013-027-IR & D-1319-010-IR  
KIT Quick Gas Connector
CUSTOMER ASSISTANCE POLICY

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.

PRODUCT SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Output Capacity/Current/Duty Cycle</th>
<th>Flow Meter</th>
<th>Input Power Connection</th>
<th>Wire Feed Speed Range ipm (m/min)</th>
<th>Wire Size Range – in. (mm)</th>
<th>Dimensions H x W x D in (mm)</th>
<th>Net Wt lb (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LN-25X w/ CrossLinc and TVT CE Model</td>
<td>K4267-4</td>
<td>15-115V DC</td>
<td>450A @ 60%</td>
<td>Yes</td>
<td>Twist Mate/Dinse</td>
<td>50-700 (1.3-178)</td>
<td>.023-.1/16 (0.6-1.6)</td>
<td>.030-.5/64 (0.9-2.0)</td>
<td>.035-.1/16 (0.9-1.6)</td>
</tr>
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