

Magnum[®] Semiautomatic Guns

Processes

MIG, Pulsed MIG, Flux-Cored

Product Number

Magnum[®] 100L
 Magnum[®] 250L
 Magnum[®] 200
 Magnum[®] 300
 Magnum[®] 400
 Magnum[®] 550

Amperage Rating @ 60% Duty Cycle ⁽¹⁾

100% CO₂ Shielding Gas
 Magnum[®] 100L: 100A
 Magnum[®] 250L: 250A
 Magnum[®] 200: 200A
 Magnum[®] 300: 300A
 Magnum[®] 400: 400A
 Magnum[®] 550: 600A

Wire Diameter Range in. (mm)

.025 - .045 (0.6 - 1.2)
 .025 - .045 (0.6 - 1.2)
 .025 - .045 (0.6 - 1.2)
 .025 - 5/64 (0.6 - 2.0)
 .025 - 5/64 (0.6 - 2.0)
 .035 - 1/8 (0.9 - 3.2)

⁽¹⁾ Magnum[®] 100L and 250L are 40% duty cycle.

Semiautomatic Gas-Shielded Guns

Magnum[®] guns for MIG or flux-cored welding feature our classic curved handle and are available in a number of amperage ranges for use in many applications.

FEATURES

- ▶ **One-piece modular trigger assembly** - Molded out of high heat resistant material to withstand head and spatter and ensure long life.
- ▶ **Gun tube design** - Armored with an electrically insulated metal jacket optimizing fine wire welding performance.
- ▶ **Abrasion-resistant, extruded rubber jacket** - Adds strength and long life to the cable.
- ▶ **Classic curved handle** - Lightweight and balanced, providing a comfortable grip to reduce fatigue.
- ▶ **Rotating gun tube and gun hanger clip** - Allow any number of hand positions to reduce fatigue or fit into tight spaces.

WHAT'S INCLUDED

- ▶ Contact Tip
- ▶ Gas Diffuser
- ▶ Gas Nozzle
- ▶ Insulator
- ▶ Cable Liner
- ▶ Gun Tube (60°)

GUN REQUIRES

- ▶ Gun Connector Kit

MAGNUM[®]

APPLICATIONS

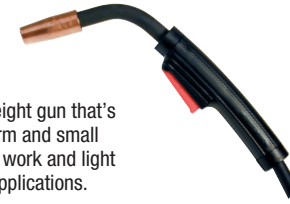
- ▶ Shop Production
- ▶ Maintenance and Repair
- ▶ Construction





Magnum® 100L Gun and Cable Assembly

Extremely small, lightweight gun that's great for most home, farm and small shop projects, autobody work and light maintenance or repair applications. Includes gun connector.



Magnum® 250L Gun and Cable Assembly

Recommended for medium duty job shop and production applications. Includes gun connector.



Magnum® 200 Gun and Cable Assembly

A small, lightweight gun intended for light job shop and fabrication applications. Best suited for welding on thin materials using .025-.030 in. (0.6-0.8 mm) wire.



Magnum® 300 Gun and Cable Assembly

This popular Magnum® gun is intended for most .035-.045 in. (0.9-1.1 mm) wire diameter applications in job shops, production or manufacturing.



Magnum® 400 Gun and Cable Assembly

The Magnum® 400 gun is built for operator comfort when welding with the greater heat levels generated by higher amperage applications. Select the Magnum® 400 gun for most .045-1/16 in. (1.2-1.6 mm) gas-shielded operations. Available in standard, dual schedule, dual procedure and short neck models.



Magnum® 550 Gun and Cable Assembly

Choose our 550 gun for heavy duty applications, including up to .052 in. and .062 in. (1.3 and 1.6 mm) MIG or 3/32-1/8 in. (2.4-3.2 mm) gas-shielded flux-cored applications.



GUN CONNECTOR KITS Gun Connector Kits are included with Fast-Mate™ Guns and Ready-Pak® Packages only.

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 200, 300 Open End, 400 Open End, Single Procedure
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8
	LF-72, LF-74 Series, LN-25 PRO	K466-10
	Power Feed® 10 and 25 series	K466-10
	POWER MIG® Series and Power Wave® C300	K466-6
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2
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



K466-1



K466-8

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 200 Fast-Mate™, 300 Fast-Mate™, and 400 Fast-Mate™, Single Procedure
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K489-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K489-1
	Power Feed® 10 and 25 series	K489-7
	POWER MIG® Series and Power Wave® C300	K489-8



K466-10



K489-7

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 400 Dual Procedure, Dual Schedule
	Power Feed® 10 and 25 series	K466-10

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 400 Fast-Mate™, Dual Procedure, Dual Schedule
Lincoln Electric®	Power Feed® 10 and 25 series	K489-7



K489-8

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 550 Open End
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K613-6
	Power Feed® 10 and 25 series	K613-7
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	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	K613-3



K613-6



K613-7

CABLE LINERS

MAGNUM® 100L {in. (mm)}		
ft. (m)	.035 (0.9) Aluminum ⁽¹⁾	.035-.045 (0.9-1.2)
15 (4.5)	KP1959-1	KP45-40-15



Magnum® 200 and 250L

Magnum® 300 and 400

MAGNUM® 200, 250L and 250SP {in. (mm)}				
ft. (m)	.025-.030 (0.6-0.8)	.030-.035 (0.8-0.9)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum ⁽¹⁾
15 (4.5)	KP42-25-15	KP42-3035-15	KP42-4045-15	KP44N-3545-15 ⁽¹⁾



Magnum® 550

MAGNUM® 300 and 400 {in. (mm)}						
ft. (m)	.025-.030 (0.6-0.8)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum ⁽¹⁾	.052-1/16 (1.3-1.6)	1/16-5/64 (1.6-2.0)	1/16 (1.6) Aluminum ⁽¹⁾
15 (4.5)	KP42-25-15	KP44-3545-15	KP44N-3545-15 ⁽¹⁾	KP44-116-15	KP44-564-15	KP44N-116-15 ⁽¹⁾
26 (7.9)	—	KP44-3545-25	—	KP44-116-25	KP44-564-25	—

MAGNUM® 550 {in. (mm)}						
ft. (m)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum ⁽¹⁾	.052-1/16 (1.3-1.6)	1/16 (1.6) Aluminum ⁽¹⁾	5/64-3/32 (2.0-2.4)	7/64-1/8 (2.8-3.2)
15 (4.5)	KP45-3545-15	KP45N-3545-15	KP45-116-15	KP45N-116-15 ⁽¹⁾	KP45H-332-15	KP45-18-15
25 (7.6)	KP45-3545-25	—	KP45-116-25	—	KP45H-332-25	KP45-18-25

⁽¹⁾ Recommended for aluminum wire welding. Recommended maximum cable length is 10 ft. (3.0 m).

GUN TUBES

GUN TUBES				
Use With These Magnum® Guns	Amperage Capacity	Angle		
		45°	60°	82°
Magnum® 100L	100 A		KP2038-1	
Magnum® 200	200 A		KP2028-1	
	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 250L	250 A	KP2041-1	KP2015-1 (Hard cover) KP2111-1 (Rubber cover)	
Magnum® 300 Magnum® 400	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 550	600 A		KP1951-1 (3 in. radius bend) KP1951-2 (5 in. radius bend)	



45° Gun Tube



60° Gun Tube



82° Gun Tube

CONTACT TIPS

CONTACT TIPS 100 A				
Wire Diameter in. (mm)	Standard		Tapered	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP11-25	KP11-25-B100	KP11T-25	—
0.030 (0.8)	KP11-30	KP11-30-B100	KP11T-30	—
0.035 (0.9)	KP11-35	KP11-35-B100	KP11T-35	—
0.035 (0.9) Aluminum	KP2078-1B1 ⁽¹⁾	—	—	—
0.045 (1.2)	KP11-45	KP11-45-B100	KP11T-45	—

⁽¹⁾ Recommended for aluminum wire welding.



CONTACT TIPS 200 A and 250 A								
Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 ⁽¹⁾	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 ⁽¹⁾	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 ⁽¹⁾	KP14A-364-B100 ⁽¹⁾	KP14AH-364 ⁽¹⁾	KP14AH-364-B100 ⁽¹⁾	—	—	KP2010-5B1 ⁽¹⁾	—

⁽¹⁾ Recommended for aluminum wire welding.

CONTACT TIPS 300 A and 400 A								
Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 ⁽¹⁾	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 ⁽¹⁾	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 ⁽¹⁾	KP14A-364-B100 ⁽¹⁾	KP14AH-364 ⁽¹⁾	KP14AH-364-B100 ⁽¹⁾	—	—	KP2010-5B1 ⁽¹⁾	—
0.052 (1.3)	KP14-52	KP14-52-B100	KP14H-52	KP14H-52-B100	KP14T-52	KP14T-52-B100	—	—
1/16 (1.6)	KP14-116	KP14-116-B100	KP14H-116	KP14H-116-B100	KP14T-116	—	—	—
5/64 (2.0)	KP14-564	—	KP14H-564	—	—	—	—	—

⁽¹⁾ Recommended for aluminum wire welding.

CONTACT TIPS 500 A		
Wire Diameter in. (mm)	Solid Wire, Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP15H-35	—
0.045 (1.2)	KP15H-45	—
0.052 (1.3)	KP15H-52	—
1/16 (1.6)	KP15H-116	—
5/64 (2.0)	KP15H-564	—
3/32 (2.4)	KP15H-332	—

CONTACT TIPS 600 A		
Wire Diameter in. (mm)	Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP16S-35	—
0.045 (1.2)	KP16S-45	—
0.052 (1.3)	KP16S-52	—
1/16 (1.6)	KP16S-116	KP16S-116-B100
5/64 (2.0)	KP16S-564	KP16S-564-B100
3/32 (2.4)	KP16S-332	KP16S-332-B100
7/64 (2.8)	KP16S-764	—
1/8 (3.2)	KP16S-18	—

GAS DIFFUSERS

GAS DIFFUSERS 100 A	
Pkg. Qty.	.025-.045 in. (0.6-1.2 mm)
1	KP35-50
25	—



100 A



200 A and 250 A



300 A and 400 A



600 A

GAS DIFFUSERS 200 A			
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
1	KP52-23	KP52FN	KP2051-1 ⁽²⁾ or KP52FN ⁽¹⁾
25	—	KP52FN-B25	KP2051-1B1 ⁽²⁾ or KP52FN-B25 ⁽¹⁾

GAS DIFFUSERS 250 A				
Nozzle	Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
For Adjustable Slip-On Nozzle	1	KP52-23	KP52	—
For Adjustable Slip-On Nozzle	25	—	KP52-B25	—
For Fixed Nozzle	1	KP2051-1	KP52FN	KP52FN
For Fixed Nozzle	25	—	KP52FN-B25	—
Specialty	1	KP2051-1	—	KP2051-1 ⁽³⁾
Specialty	25	—	—	KP2051-1B1

GAS DIFFUSERS 300 A and 400 A		
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-5/64 in. (0.9-2.0 mm)
1	KP2024-2 ⁽¹⁾	KP54A
25	—	KP54A-B25

⁽¹⁾ Use KP42-25-x liner with this diffuser when feeding .025-.030 in. wire.

GAS DIFFUSERS 600 A		
Pkg. Qty.	.035-1/16 in. (0.9-1.6 mm)	5/64-1/8 (2.0-3.2 mm)
1	KP56S-SW	KP56S-H
25	—	KP56S-H-B10

⁽¹⁾ Permits use of 300 and 400 amp fixed nozzles with 200 amp gun and cable.

⁽²⁾ Permits use of 100 amp contact tips with 200 amp gun and cable.

⁽³⁾ Permits use of 100 amp contact tips and nozzles with Magnum® 250L gun tube.

EXPENDABLE PARTS

GAS NOZZLES AND INSULATORS



Adjustable Slip-On Gas Nozzle



Coarse Thread Gas Nozzle



Insulator

GAS NOZZLES 100 A

Nozzle	Pkg. Qty.	.37 Nozzle Diameter	.50 Nozzle Diameter	.625 Nozzle Diameter
Fixed Flush	1	—	KP21-50-F	—
Fixed Recessed	1	KP21T-37	KP21T-50	KP21T-62
Gasless Nozzle	1	KP1939-1	—	—
Spot Nozzle	1	—	—	KP21-62-FAS

GAS NOZZLES 200 A

Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter
Adjustable Slip-On	1	KP22-37	KP22-50	KP22-62
Adjustable Slip-On	25	KP22-37-B25	KP22-50-B25	KP22-62-B25
Gasless Nozzle	1	KP1947-1	KP1947-1	KP1947-1
Spot Nozzle	1	KP21-62-FAS	KP21-62-FAS	KP21-62-FAS

GAS NOZZLES 300 A and 400 A

Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter	.75 Nozzle Diameter
Adjustable Slip-On	1	—	KP24A-50	KP24A-62	—
Adjustable Slip-On	25	—	KP24A-50-B25	KP24A-62-B25	—
Slip-On Recessed	1	KP24A-37-SS	KP24A-50-SS	KP24A-62-SS	—
Slip-On Recessed	25	—	—	KP24A-62-SS-B25	—
Coarse Thread/Tip Recessed 1/8 in.	1	—	—	KP24CT-62-S	KP24CT-75-S
Coarse Thread/Tip Recessed 1/8 in.	25	—	—	KP24CT-62-S-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	—	—	KP24CT-62-R	KP24CT-75-R
Coarse Thread/Tip Recessed 1/4 in.	25	—	—	KP24CT-62-R-B25	—
Fixed Recessed	1	KP23-37	KP23-50	KP23-62	KP23-75
Fixed Recessed	25	KP23-37-B25	KP23-50-B25	KP23-62-B25	—
Fixed Tapered	1	KP23T-37	—	—	—
Fixed Tapered	25	KP23T-37-B25	—	—	—
Fixed Heavy Duty	1	—	—	KP23H-62	—
Fixed Heavy Duty	25	—	—	KP23H-62-B25	—
Fixed Flush	1	—	KP23-50F	KP23-62F	—
Fixed Flush	25	—	KP23-50F-B25	KP23-62F-B25	—

GAS NOZZLES 600 A

Nozzle	Pkg. Qty.	.62 Nozzle Diameter	.75 Nozzle Diameter	.88 Nozzle Diameter
Coarse Thread/Tip Recessed 1/8 in.	1	KP26CT-62	KP26CT-75	—
Coarse Thread/Tip Recessed 1/8 in.	25	—	KP26CT-75-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	KP26CT-62-R	KP26CT-75-R	—
Self-Insulated/Tip Recessed 1/4 in.	1	—	KP26I-75	—

INSULATORS

Nozzle	Pkg. Qty.	200 Amp	300 and 400 Amp	600 Amp
Adjustable Slip-On	1	KP32	—	—
Adjustable Slip-On	25	KP32-B25	—	—
Adjustable Slip-On	1	—	KP34A	—
Adjustable Slip-On	25	—	KP34A-B25	—
Coarse Thread	1	—	KP34CT	—
Coarse Thread	25	—	KP34CT-B25	—
Coarse Thread	1	—	—	KP36CT
Coarse Thread	25	—	—	KP36CT-B25

PRODUCT SPECIFICATIONS

Gun Model	Gun Rating Amperage/Duty Cycle/Shielding Gas	Cable Length ft. (m)	Wire Diameter .025-.035 in. (0.6-0.9 mm)	Wire Diameter .035-.045 in. (0.9-1.2 mm)			Wire Diameter .052-1/16 in. (1.3-1.6 mm)			Wire Diameter 1/16-5/64 in. (1.6-2.0 mm)	
			Package	Gun Connector			Gun Connector			Gun Connector	
				Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™
Magnum® 100L	100A@40% CO ₂	10 (3.0)	K530-5, K530-6 ⁽¹⁾	K530-3 (FCAW-SS only)							
Magnum® 200	200A@60% CO ₂	10 (3.0) 15 (4.5)		K497-2 K497-1	K498-1	K497-21 ⁽³⁾					
Magnum® 250L	250A@40% CO ₂	12 (3.6) 15 (4.5)		K533-7 (Fixed Gas Nozzle) K533-3 (Adjustable Gas Nozzle)							
Magnum® 300	300A@60% CO ₂	10 (3.0) 15 (4.5)		K470-1 K470-2		K1802-1 ⁽²⁾	K470-4			K470-6	
Magnum® 400 STANDARD	400A@60% CO ₂	10 (3.0) 15 (4.5) 20 (6.1) 25 (7.6)		K471-1 K471-2 K471-10 K471-13	K479-2	K2286-1 ⁽²⁾ K471-21 ⁽³⁾	K471-4 K471-11 K471-14	K479-4	K471-22 ⁽³⁾	K471-6 K471-15	K479-6
Magnum® 400 DUAL SCHEDULE	400A@60% CO ₂	15 (4.5)						K575-2			
Magnum® 400 DUAL PROCEDURE	400A@60% CO ₂	15 (4.5)		K1722-2							
Magnum® 400 SHORT NECK	400A@40% CO ₂	15 (4.5)		K541-3							

⁽¹⁾ Includes 4-pin MS-type connection for trigger control. ⁽²⁾ Includes K466-1 Gun Connector Kit. ⁽³⁾ Includes K466-10 Gun Connector Kit.

Gun Model	Amperage Rating	Cable Length ft. (m)	Wire Diameter .052-1/16 in. (1.3-1.6 mm)	Wire Diameter 5/64-3/32 in. (2.0-2.4 mm)
			Gun Connector 600 A Open-End	Gun Connector 600 A Open-End
Magnum® 550	550A@60% CO ₂	15 (4.5)	K598-7	K598-11

CUSTOMER ASSISTANCE POLICY

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