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 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

WHAT’S INCLUDED

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

RECOMMENDED POWER SOURCES(1)

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

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

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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.

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**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.

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**Flowmeter with Control Valve**
- Regulate and monitor shielding gas flow at the feeder to compensate for long shielding gas hoses.

**Shielding Gas Input**
- Rugged, one piece solenoid includes a screen to filter dirt.

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**4/0 Electrode Lead**
- Rated for high amperage welding. Add connector of your choice.

**Five Pin ArcLink® Connector**
- Now with a patent pending Spin-Nut™ for easy connection of the cable.
### FEATURES

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

<table>
<thead>
<tr>
<th>Length ft. (m)</th>
<th>Product Description</th>
<th>Order Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>8 (2.5)</td>
<td>ArcLink® without weld cable</td>
<td>K1543-8</td>
</tr>
<tr>
<td>25 (7.6)</td>
<td>ArcLink® without weld cable</td>
<td>K1543-25</td>
</tr>
<tr>
<td>50 (15.2)</td>
<td>ArcLink® without weld cable</td>
<td>K1543-50</td>
</tr>
<tr>
<td>100 (30.4)</td>
<td>ArcLink® without weld cable</td>
<td>K1543-100</td>
</tr>
<tr>
<td>25 (7.6)</td>
<td>Heavy duty ArcLink® control cable</td>
<td>K2683-25</td>
</tr>
<tr>
<td>50 (15.2)</td>
<td>Heavy duty ArcLink® control cable</td>
<td>K2683-50</td>
</tr>
<tr>
<td>100 (30.4)</td>
<td>Heavy duty ArcLink® control cable</td>
<td>K2683-100</td>
</tr>
</tbody>
</table>

#### DRIVE ROLL & WIRE GUIDE KITS

<table>
<thead>
<tr>
<th>Description in. (mm)</th>
<th>Order Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.023-0.030 (0.6-0.8)</td>
<td>KP1696-030S</td>
</tr>
<tr>
<td>0.035 (0.9)</td>
<td>KP1696-035S</td>
</tr>
<tr>
<td>0.045 (1.2)</td>
<td>KP1696-045S</td>
</tr>
<tr>
<td>0.052 (1.4)</td>
<td>KP1696-052S</td>
</tr>
<tr>
<td>0.035, 0.045 (0.9, 1.2)</td>
<td>KP1696-1</td>
</tr>
<tr>
<td>0.040 (1.0)</td>
<td>KP1696-2</td>
</tr>
<tr>
<td>1/16 (1.6)</td>
<td>KP1696-1/16S</td>
</tr>
</tbody>
</table>

#### WELD POWER CABLES

<table>
<thead>
<tr>
<th>Length ft. (m)</th>
<th>Amperage</th>
<th>Duty Cycle</th>
<th>Size</th>
<th>Order Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 (3)</td>
<td>600</td>
<td>60%</td>
<td>3/0</td>
<td>K1842-10</td>
</tr>
<tr>
<td>35 (10.5)</td>
<td>600</td>
<td>60%</td>
<td>3/0</td>
<td>K1842-35</td>
</tr>
<tr>
<td>60 (18)</td>
<td>600</td>
<td>60%</td>
<td>3/0</td>
<td>K1842-60</td>
</tr>
<tr>
<td>110 (33.5)</td>
<td>600</td>
<td>60%</td>
<td>3/0</td>
<td>K1842-110</td>
</tr>
</tbody>
</table>

#### COAXIAL WELD POWER CABLES

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

Note: All sizes are lug to lug connection type.

#### FEED PLATE GUN ADAPTERS

<table>
<thead>
<tr>
<th>K1500-1</th>
<th>K1500-2</th>
<th>K1500-3</th>
<th>K1500-4</th>
<th>K1500-5</th>
<th>Magnum® PRO Fast-Mate™</th>
</tr>
</thead>
<tbody>
<tr>
<td>Lincoln Electric</td>
<td>Compatible gun connector kits</td>
<td>K466-1</td>
<td>K613-1</td>
<td>K613-6</td>
<td>K466-8</td>
</tr>
<tr>
<td>Tweco® #2 - #4</td>
<td>Compatible gun connector kits</td>
<td>K466-2</td>
<td>K613-2</td>
<td>K613-3</td>
<td>K466-6</td>
</tr>
<tr>
<td>Tweco #5</td>
<td>Compatible gun connector kit</td>
<td>K466-10</td>
<td>K613-7</td>
<td>K466-3</td>
<td>K613-7</td>
</tr>
<tr>
<td>Miller® guns</td>
<td>Compatible gun connector kits</td>
<td>K466-2</td>
<td>K613-2</td>
<td>K613-3</td>
<td>K466-6</td>
</tr>
<tr>
<td>OXO® guns</td>
<td>Compatible gun connector kits</td>
<td>K466-10</td>
<td>K613-7</td>
<td>K466-3</td>
<td>K613-7</td>
</tr>
</tbody>
</table>

Note: All sizes are lug to lug connection type.

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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 tume 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 3000 @ 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 K2930-6

- **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 CO2, 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 K568-1

- **Micro Wire Straightener**
  - Straightens 0.035-1/16 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 K2969-1

- **Portable Feeder Case-Plastic**
  - Replace a damaged case without replacing the entire unit. Order K2986-2

- **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)

- **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

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**PRODUCT SPECIFICATIONS**

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Rated Output Current/Duty Cycle</th>
<th>Gearing</th>
<th>Wire Feed Speed Range (ipm/min)</th>
<th>Wire Size Range (inches)</th>
<th>Net Weight (lbs.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Feed 25M Aluminum Case</td>
<td>K2536-4</td>
<td>40 VDC</td>
<td>500A/80%</td>
<td>Standard speed (factory setting)</td>
<td>GMAW: 50-800 (1.3 - 20.3)</td>
<td>0.023-1/16 (0.6-1.6)</td>
<td>14.5 x 8.5 x 23.5</td>
</tr>
<tr>
<td>Power Feed 25M Plastic Case</td>
<td>K2536-5</td>
<td></td>
<td></td>
<td></td>
<td>GMAW: 50-800 (1.3 - 20.3)</td>
<td>0.030-5/64 (0.8-2.0)</td>
<td></td>
</tr>
<tr>
<td>Power Feed 25M Plastic Case for Aluminum</td>
<td>K4191-1</td>
<td></td>
<td></td>
<td>Extra-torque</td>
<td>GMAW: 30-400 (0.8-10.2)</td>
<td>0.023-1/16 (0.6-1.6)</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>FCWA: 30-400 (0.8-10.2)</td>
<td>0.030-3/32 (0.8-2.4)</td>
<td></td>
</tr>
</tbody>
</table>


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