

Tel: (+974) 443 54 298
www.boltsandtools.com

LINCOLN
ELECTRIC

Tel: (+974) 443 54 298
www.boltsandtools.com

Tel: (+974) 443 54 298
www.boltsandtools.com

Welding & Cutting Solutions

2016 Equipment Catalog

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Tel: (+974) 443 54 298
www.boltsandtools.com

Tel: (+974) 443 54 298
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Icons

Output Icons



For constant current stick and TIG processes



Alternating current welding output



Peak auxiliary power output



2-Roll Wire Feeder



Single phase input power



115 Volt AC Wire feeder input power



50 Hertz input power



Engine Driven: Diesel, Gas or LPG



For constant voltage MIG, flux-cored and subarc processes



Direct current welding output



Surge auxiliary power output



4-Roll Wire Feeder



Three phase input power



42 Volt AC Wire feeder input power



60 Hertz input power



115 V INPUT 230 V INPUT



For multiprocess constant current or constant voltage applications



Alternating or direct current welding output



Continuous auxiliary power output



Single or three phase input power



40 Volt DC Wire feeder input power



50/60 Hertz input power

Warranty Commitment



3 Year Warranty

You have a right to expect that the welding and cutting equipment, electrode and flux you purchase will be free of defects in workmanship and material. Standing behind the high quality of our products, Lincoln Electric's warranty commitment to its customers leads the industry in breadth and scope.

For example, our limited warranty extends to 7 Years on many of our main power rectifiers. With few exceptions, all industrial welders and power sources carry a full 3 Year Lincoln Electric warranty. Electrode, wire and flux are warranted for 1 full year, as are environmental systems.

Extended Warranty Available

If you choose, you can extend the duration of the Lincoln Electric warranty on your Lincoln Electric industrial welder and cutting machines by two years with the Lincoln Electric Extended Warranty. Available only in the United States and Canada. Visit our web site for more information.

Quality Systems

Choose welding suppliers wisely. . . look for third party certifications on the companies and products you select. In fact, some of your projects or customers may require it. Many Lincoln Electric manufacturing sites have been inspected and registered to the world's ISO standards. In fact, Lincoln Electric was the first welding manufacturer to be registered to the tough ISO 9001 and 14001 standards.

However, there's more. Equipment destined for harsh environments is often tested to IP21, IP23 and IP23S standards. Products intended for the Canadian market meet stringent CSA (Canadian Standards Association) standards. Electrode is tested to comply with AWS (American Welding Society) and often ASME Boiler Pressure codes, ABS (American Bureau of Shipping), CWB/CSA (Canadian Welding Bureau) and MIL qualifications. Certificates of Conformance are available at our web site.

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.



STICK WELDERS

| MODEL | OUTPUT | | | PROCESS | | | | INPUT | | FEATURES | | | | | | |
|-------------------|--------|----------|------------------------|---------|-------------|------------------|-----------|-------|-------|----------|---------------------------|-----------|-----------|--------|---------------------------------|-----------------|
| | Mode | Polarity | Current Range (Amps) | Stick | TIG Scratch | Touch Start TIG* | Arc Gouge | Phase | Hertz | Compact | 115/230 Volt Auto-Sensing | Hot Start | Arc Force | Meters | 7-yr Warranty (Power Rectifier) | Polarity Switch |
| COMMERCIAL | | | | | | | | | | | | | | | | |
| Invertac® V155-S | CC | DC | 5-155 DC | ● | | ● | | 1 | 50/60 | ● | ● | ● | ● | | | |
| AC225 | CC | AC | 40-225 AC | ● | | | | 1 | 50/60 | ● | | | | | | |
| AC/DC 225 | CC | AC/DC | 30-125 DC 40-225 AC | ● | ● | | | 1 | 50/60 | ● | | | | | | ● |
| INDUSTRIAL | | | | | | | | | | | | | | | | |
| Idealarc® 250 | CC | AC/DC | 40-250 DC 35-300 AC | ● | | | ● | 1 | 50/60 | | | | | | | ● |
| Invertac® V275-S | CC | DC | 5-275 DC | ● | | ● | ● | 1/3 | 50,60 | ● | | ● | ● | | | |
| Idealarc® R3R-400 | CC | DC | 60-500 DC | ● | ● | | ● | 3 | 60 | | | | ● | ● | ● | ● |
| Idealarc® R3R-500 | CC | DC | 75-625 DC | ● | ● | | ● | 3 | 60 | | | | ● | ● | ● | ● |

Invertec® V155-S

High-Performance Stick Welder In A Portable Package

- Two stick welding modes provide optimal welding performance for Soft (E7018) and Crisp (E6010) electrode applications
- Auto-Adaptive Arc Force minimizes spatter and electrode sticking in the puddle without compromising arc stability when stick welding
- Touch Start TIG® mode provides TIG welding capabilities in a stick machine
- Automatically connects to either 120V or 230V power



Processes

- Stick
- DC TIG

Output



Input



Literature

E2.141

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output ⁽¹⁾ | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|---------------------------------|--|---|--------------------------------|--|-----------------|
| Invertec® V155-S | K2605-1 | 120/1/50/60 | 75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG | 24.0A 33.8A 21.5A 28.8A | 5-155 Amps DC Max. OCV: 75V | 11.3 x 6.2 x 15.4 (288 x 158 x 392) | 14.7 (6.7) |
| | | 230/1/50/60 | 100A/24.0V/100% Stick 145A/25.8V/30% Stick 100A/14.0V/100% TIG 155A/16.2V/30% TIG | 21.0A 31.0A 14.1A 22.8A | | | |

⁽¹⁾Input amps on 60 Hz input.

AC225

Proven For Generations, Built To Last A Lifetime

- 40-225 amps AC output control allows for 3/16 in. [4.8 mm] diameter mild steel stick electrodes and 5/32 in. [4.0 mm] diameter of other electrode types.



Processes

- Stick

Output



Input



Literature

E2.30

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|---|------------------------------|------------------------------|--------------------------------------|-----------------|
| AC225 | K1170 | 230/1/60 | 225A/25V/20% ⁽¹⁾ | 50A | 40-225 Amps Max. OCV: 79V | 24 x 17.25 x 12 (610 x 438 x 305) | 109 (49.5) |

⁽¹⁾Except 75 amp setting which can be used continuously for 1 hour.

AC/DC 225

An Iconic AC/DC Stick Welder
That's Built To Last

- 225 amp AC output is enough for 3/16 in. (4.8 mm) diameter general purpose mild steel electrodes
- 125 amp DC output is enough for most 1/8 in. (3.2 mm) electrodes



Processes

- Stick

Output



Input



Literature

E2.60

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|---|------------------------------|--|--------------------------------------|-----------------|
| AC/DC 225 | K1297 | 230/1/60 | AC: 225A/25V/20% DC: 125A/25V/20% | AC: 50A DC: 36A | 40-225 Amps AC Max. OCV: 79V 30-125 Amps DC Max. OCV: 73V | 24 x 17.25 x 12 (610 x 438 x 305) | 124 (56.3) |

Idealarc® 250

Rugged. Reliable. Red.

- Up to 300 amps welding output in AC and 250 amps in DC polarity enables the operation of some 1/4 in. (6.4 mm) electrodes
- Suitable for use with a variety of stick electrode types, including low hydrogen, stainless steel, hardfacing, and cast iron
- Full-range continuous control provides precise command of heat input
- The K1053-9 Idealarc® 250 model features Power Factor Capacitors (PFC)



Processes

- Stick
- Gouging

Output



Input



Literature

E2.70

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|---------------------------------|---|------------------------------|--|-------------------------------------|-----------------|
| Idealarc® 250 w/PFC ⁽¹⁾ | K1053-9 | 208/230/460/1/60 | AC: 250A/30V/30% DC: 250A/30V/30% | 75/68/34A | 35-300 Amps AC Max. OCV: 72V 40-250 Amps DC Max. OCV: 70V | 27 x 19 x 21.5 (686 x 483 x 546) | 350 (159) |
| Base Model | K1053-8 | 230/460/575/1/60 | | 86/43/34A | | | |

⁽¹⁾PFC = Power Factor Capacitors

Invertec® V275-S

Cover All Your Bases

- Outstanding stick performance, including E6010 and E7018 and everything in between, for both whip and drag techniques
- Selectable Hot Start technology enables enhanced arc starting on thick and dirty material
- Full welding output regardless of input power



Processes

- Stick
- DC TIG
- Gouging

Output



Input



Literature

E2.161

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|--|--------------|---|-----------------|
| Invertec® V275-S Base Model or Base Model w/Tweco® Style Receptacles ⁰¹ | K2269-1 | 208/230/460/575/3/60 | 275A/31V/35% 250A/30V/60% 200A/28V/100% | 38/37/19/16A 34/33/17/14A 27/25/13/11A | 5-275A | 13.6 x 9.0 x 20.25 (345 x 229 x 514) | 54.5 (24.7) |
| | | 208/230/460/575/1/60 | 275A/29-31V/35% 250A/30V/60% 200A/28V/100% | 68/67/38/31A 63/62/33/27A 49/48/26/21A | | | |
| | K2269-3 | 220/380/400/ 415/440/3/50 | 250A/30V/35% 200A/28V/100% | 32/20/19/18/17A 25/15/15/14/13A | | | |
| | | 220/380/400/ 415/440/1/50 | | 63/42/40/38/36A 48/32/30/29/27A | | | |

⁰¹With Tweco®-style output connectors. Tweco® is a registered trademark of Victor Technologies International, Inc.

Idealarc® R3R-400

Heavy-Duty Stick Welding For The Long Haul

- Polarity switch, voltmeter and ammeter (analog)
- Ideal for hardfacing applications
- Seven-year transformer warranty
- Wide operating range of 60-500 amps and exceptionally smooth arc with mild steel, low hydrogen and stainless steel electrodes
- Arc gouge using up to 5/16 in. (7.9 mm) diameter carbon electrode
- Stackable case design conserves floor space



Processes

- Stick
- DC TIG
- Gouging

Output



Input



Literature

E2.100

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------|----------------|---------------------------------|---|------------------------------|--------------------------|---------------------------------------|-----------------|
| Idealarc® R3R-400 ⁰¹ | K1285-16 | 230/460/3/60 | 400A/36V/60% | 74/37A | 60-500A Max. OCV: 67V | 27.5 x 22.3 x 32 (699 x 566 x 813) | 402 (183) |

⁰¹50 Hertz models available.

Idealarc® R3R-500

More Amps For Heavy-Duty Stick Welding and Gouging

- Arc gouge with the R3R-500 using up to 3/8 in. (9.5 mm) diameter carbon electrode
- Polarity switch, voltmeter and ammeter (analog)
- Substantial amperage range at 72-625 amps for use on thicker materials
- Seven-year transformer warranty
- Stackable case design conserves floor space



Processes

- Stick
- DC TIG
- Gouging

Output



Input



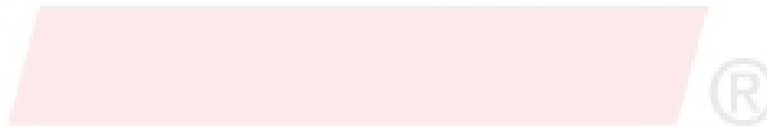
Literature

E2.100

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------|----------------|---------------------------------|---|------------------------------|--------------------------|---------------------------------------|-----------------|
| Idealarc® R3R-500 ⁰¹ | K1286-16 | 230/460/3/60 | 500A/40V/60% | 88/44A | 72-625A Max. OCV: 67V | 27.5 x 22.3 x 32 (699 x 566 x 813) | 446 (203) |
| | K1286-25 | 230/460/575/3/60 | | | | | |

⁰¹50 Hertz models available.

BOLTS AND TOOLS



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V155-S

Base Model (K2605-1)

- Stick electrode holder, cable and Twist Mate™ plug
- Work cable and clamp with Twist Mate plug
- Fully adjustable shoulder strap
- 120/230V input cord, 6.6 ft. (2 m) with a 120V 15 Amp plug
- Extra 120V 20 Amp plug

AC 225

Base Model (K1170)

- Insulated electrode holder and cable
- Heavy duty work clamp and cable
- Helpful Welder's Guide
- Input Cable with integrated plug

AC/DC 225

Base Model (K1297)

- Insulated electrode holder and cable
- Heavy duty work clamp and cable
- Helpful Welder's Guide
- Input Cable with integrated plug



Shown:
Invertec® V155-S



Shown:
AC 225



Shown:
AC/DC 225



Accessories

| Product Name | Product No. | Invertec® V155-S | | AC225 | | AC/DC 225 | | Idealarc® 250 | | Invertec® V275-S | | Idealarc® R3R-400 | | Idealarc® R3R-500 | | |
|--|---------------|------------------|------------|------------|------------------|------------|------------|---------------|---------------------|------------------|------------|-------------------|------------|-------------------|---|---|
| | | Base Model | Base Model | Base Model | Base Model w/PFC | Base Model | Base Model | Base Model | Base Model w/Tweco® | Base Model | Base Model | Base Model | Base Model | Base Model | | |
| | | K2605-1 | K1170 | K1297 | K1053-9 | K1053-8 | K2269-1 | K2269-3 | K1285-16 | K1286-16 | K1286-25 | | | | | |
| GENERAL | | | | | | | | | | | | | | | | |
| Wheel Kit | K761 | | • | • | | | | | | | | | | | | |
| Undercarriage | K866 | | | | • | • | | | | | | | | | | |
| Welding Cart with 80 cu. ft. (2.27 m ³) bottle capacity | K2275-1 | • | | | | | | | | | | | | | | |
| Twist Mate™ Cable Plug for 6-4 Cable | K852-25 | • | | | | | | | | | | | | | | |
| Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm ² Cable | K852-70 | | | | | | • | • | | | | | | | | |
| Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm ² Cable | K852-95 | | | | | | • | • | | | | | | | | |
| Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm ² Cable | K1759-70 | | | | | | • | • | | | | | | | | |
| Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm ² Cable | K1759-95 | | | | | | • | • | | | | | | | | |
| Tweco® Style Cam-Lock Adapter Plug | K2946-1 | | | | | | • | • | | | | | | | | |
| Arc Tracker™ | K3019-1 | | | | • | • | • | • | • | • | • | • | • | • | • | • |
| Undercarriage – Hand moving | K841 | | | | | | | | | | | • | • | • | • | • |
| Work Lead Package, 15 ft. (4.6 m) 4/0 Cable | K2149-1 | | | | | | | | | | | • | • | • | • | • |
| Weld Fume Control System | See Fume Sec. | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • |
| STICK | | | | | | | | | | | | | | | | |
| Accessory Kit, 150 Amp | K875 | | | | • | • | • | • | | | | | | | | |
| Accessory Kit, 400 Amp | K704 | | | | • | • | • | • | • | • | • | • | • | • | • | • |
| Stick Electrode Holder, Work Clamp, Cable & Twist Mate™ Set | K2394-1 | | | | | | • | • | | | | | | | | |
| Remote Output Control, 6-pin, 25 ft. (7.6 m) | K857 | | | | | | • | • | • | • | • | • | • | • | • | • |
| Remote Output Control, 6-pin, 100 ft. (30 m) | K857-1 | | | | | | • | • | • | • | • | • | • | • | • | • |
| TIG | | | | | | | | | | | | | | | | |
| Pro-Torch™ TIG Torches | See Guns Sec. | | | | | | | | | | | • | • | • | | |
| PTA-17V Flex Head Gas Vavle TIG Torch w/Ultra-Flex™ Cable, 12.5 ft. (3.8 m), 1 pc. | K1782-13 | • | | | | | | | | | | | | | | |
| Small Twist Mate™ Torch Adapter (with separate gas) | K960-2 | • | | | | | | | | | | | | | | |
| Parts Kit for PTA-17 Series Torches | KP508 | • | | | | | | | | | | | | | | |
| Deluxe Adjustable Gas Regulator & Hose Kit | K586-1 | • | | | | | | | | | | • | • | • | | |
| TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled) | K2265-1 | | | | | | • | • | | | | | | | | |
| Twist Mate™ Torch Adapter (with separate gas) | K960-1 | | | | | | • | • | | | | | | | | |
| Foor Amptrol™ | K870 | | | | | | • | • | • | • | • | • | • | • | • | • |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | | | | | | • | • | • | • | • | • | • | • | • | • |
| TIG Module | K930-2 | | | | | | | | | | | • | • | • | | |
| Docking Kit | K939-1 | | | | | | | | | | | • | • | • | | |
| Contractor Kit | K938-1 | | | | | | | | | | | • | • | • | | |
| Control Cable, 9-pin to 6-pin and 115V plug | K936-3 | | | | | | | | | | | • | • | • | | |
| Control Cable Extension, 45 ft. (13.7 m) | K937-45 | | | | | | | | | | | • | • | • | | |

• Optional

Accessories

| Product Name | Product No. | Invertec® V155-S | | AC225 | | AC/DC 225 | | Idealarc® 250 | | Invertec® V275-S | | Idealarc® R3R-400 | | Idealarc® R3R-500 | |
|---------------------------------|-------------|------------------|------------|------------|------------------|------------|------------|---------------|---------------------|------------------|------------|-------------------|------------|-------------------|--|
| | | Base Model | Base Model | Base Model | Base Model w/PFC | Base Model | Base Model | Base Model | Base Model w/Tweco® | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | K2605-1 | K1170 | K1297 | K1053-9 | K1053-8 | K2269-1 | K2269-3 | K1285-16 | K1286-16 | K1286-25 | | | | |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | | | |
| Invertec® V155-S | X2605 | • | | | | | | | | | | | | | |
| AC225 | X1170 | | • | | | | | | | | | | | | |
| AC/DC 225 | X1297 | | | • | | | | | | | | | | | |
| Idealarc® 250 | X1053 | | | | • | • | | | | | | | | | |
| Invertec® V275-S | X2269 | | | | | | • | • | | | | | | | |
| Idealarc® R3R-400 | X1285 | | | | | | | | | • | | | | | |
| Idealarc® R3R-500 | X1286 | | | | | | | | | | • | | • | | |



• Optional



TIG WELDERS

| MODEL | OUTPUT | | | PROCESS | | | INPUT | | | FEATURES | | | | | |
|----------------------------------|--------|----------|--------------------------|---------|------------------------------|----------------------------------|-------|-----------|--------------|-----------------------------|---------------------------|-------------------------|------------------------|------------------|------------------------------------|
| | Mode | Polarity | TIG Current Range (Amps) | Stick | Touch Start TIG [®] | TIG High-Freq [™] Start | Phase | Hertz | Auto Sensing | Micro-Start [™] II | Auto-Balance [®] | Adjustable AC Frequency | Ready-Pak [®] | TIG Pulse | Adjustable AC Balance [®] |
| RECTIFIER TECHNOLOGY | | | | | | | | | | | | | | | |
| Precision TIG [®] 225 | CC | AC/DC | 5-230 | ● | | ● | 1 | 60, 50/60 | | | ● | | ● | ● | ● |
| Precision TIG [®] 275 | CC | AC/DC | 2-340 | ● | ● | ● | 1 | 60, 50/60 | | | ● | | ● | ● ⁽³⁾ | ● |
| Precision TIG [®] 375 | CC | AC/DC | 2-420 | ● | ● | ● | 1 | 60, 50/60 | | | ● | | ● | ● | ● |
| INVERTER TECHNOLOGY | | | | | | | | | | | | | | | |
| Invertex [®] V155-S | CC | DC | 5-155 | ● | ● | | 1 | 50/60 | ● | | | | ● | ● | |
| Invertex [®] V160-T | CC | DC | 5-160 | ● | ● | ● | 1 | 50/60 | ● | | | | | ● | |
| Square Wave [®] TIG 200 | CC | AC/DC | 10-200 ⁽¹⁾ | ● | | ● | 1 | 60 | ● | | | ● | | ● | ● |
| Aspect [®] 375 | CC | AC/DC | 2-375 ⁽²⁾ | ● | ● | ● | 1/3 | 60 | ● | | | ● | ● | ● | ● |

Invertec® V155-S

Best-in-Class TIG and Stick Performance

- Touch Start TIG® mode provides TIG welding capabilities in a stick machine
- Two stick welding modes provide optimal welding performance for Soft (E7018) and Crisp (E6010) electrode applications
- Auto-Adaptive Arc Force minimizes spatter and electrode sticking in the puddle without compromising arc stability when stick welding
- Automatically connects to 120V or 230V service



Processes

- Stick
- DC TIG

Output



Input



Literature

E2.141

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output ⁽¹⁾ | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------------|----------------|---------------------------------|--|---|--------------------------------|--|---------------------------------|
| Invertec® V155-S [Ready-Pak® Pkg.] | K2606-1 | 120/1/50/60 | 75A/23.0V/100% Stick 100A/24.0V/30% Stick 105A/14.2V/100% TIG 130A/15.2V/30% TIG | 24.0A 33.8A 21.5A 28.8A | 5-155 Amps DC Max. OCV: 75V | 11.3 x 6.2 x 15.4 (288 x 158 x 392) (machine only) | 14.7 (6.7) (machine only) |
| | | 230/1/50/60 | 100A/24.0V/100% Stick 145A/25.8V/30% Stick 100A/14.0V/100% TIG 155A/16.2V/30% TIG | 21.0A 31.0A 14.1A 22.8A | | | |

⁽¹⁾Input amps on 60 Hz input.

Invertec® V160-T

High Performance TIG Welding In A Compact Design

- High-frequency TIG starting makes it easy to establish an arc under a variety of conditions
- Built in pulsing functions help minimize heat input on thin materials, and provide for a faster freezing weld puddle for uphill welding on curved surfaces such as process piping
- Ideally suited for maintenance operations and other external field operations
- Automatically connects to 120V or 230V service



Processes

- Stick
- DC TIG

Output



Input



Literature

E3.105

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|-----------------------------------|--|------------------------------|--------------------------------|----------------------------------|-----------------|
| Invertec® V160-T | K1845-1 | 115/1/50/60 20A Branch Circuit | 90A/14.6V/100% TIG 60A/22.4V/100% Stick | 20A | 5-160 Amps DC Max. OCV: 48V | 13 x 8 x 17 (330 x 203 x 432) | 24 (10.8) |
| | | 115/1/50/60 30A Branch Circuit | 110A/14.4V/100% TIG 80A/23.2V/100% Stick | 25A | | | |
| | | 230/1/50/60 30A Branch Circuit | 130A/15.2V/100% TIG 130A/25.2V/100% Stick | 20A | | | |

Square Wave® TIG 200

200 Amp AC/DC TIG and Stick Welding Power Source

- Simple user interface makes machine setup easy
- Available features like pulse mode help make you a better TIG welder, faster
- High frequency starting for aluminum welding
- Built-in settings for more cleaning action or wider or tighter arc configurations for aluminum welding
- TIG welding for critical welds where precision and bead appearance are important
- Bonus of stick welding capability for outdoor work or thicker materials
- Plugs into a standard 120V or 230V circuit
- Portable and convenient to use – only 46 lb (21 kg)



Processes

- Stick
- AC/DC TIG

Output



Input



Literature

E3.38.1

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------|----------------|---------------------------------|---|------------------------------|--------------------------------|---|-----------------|
| Square Wave® TIG 200 | K5126-1 | 120/1/60 | TIG: 125A/25% TIG: 100A/40% TIG: 85A/60% Stick: 75A/20% Stick: 65A/60% | 21 17 14 19 16 | TIG: 10-125A Stick: 10-90A | 14 x 10.75 x 19.25 (358 x 282 x 502) | 46 (21) |
| | | 230/1/60 | TIG: 200A/25% TIG: 160A/40% TIG: 130A/60% Stick: 170A/20% Stick: 100A/60% | 22 17 13 25 13 | TIG: 10-200A Stick: 10-170A | | |

* 120V AC TIG 110A/25%

Precision TIG® 225

Versatile TIG and Stick Welder

- Easy-to-use operator interface – select mode, polarity and weld
- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum
- Take full control: Adjust cleaning action or penetration on aluminum. Enable the TIG pulser to minimize distortion from excessive heat input
- Offers outstanding stick welding capabilities
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.37

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|---------------------------------|--|--|---|---|-----------------|
| Precision TIG® 225 Ready-Pak® Pkg. | K2535-1 | 208/230/1/60 | 130A/40% 110A/60% | 40% Duty Cycle: 61/55 60% Duty Cycle: 52/47 | 5-230 Amps AC 5-230 Amps DC Max. OCV: 75V | 20.7 x 14.5 x 25.6 (526 x 368 x 650) | 212 (96) |
| Ready-Pak® w/Cart Pkg. | K2535-2 | | | | | 31.2 x 19.8 x 38 (794 x 503 x 966) | 258 (117) |
| Base Model | K2533-2 | 460/575/1/60 | | 40% Duty Cycle: 28/22 60% Duty Cycle: 23/19 | | 20.7 x 14.5 x 25.6 (526 x 368 x 650) | 192 (87) |
| | K2534-1 | 380/400-415/1/50/60 | | 40% Duty Cycle: 33/32 60% Duty Cycle: 28/27 | | | |

Precision TIG® 275

A TIG Welding Workhorse

- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum. Or, take full control to adjust cleaning or penetration.
- Delivers the widest output range in its class from 2-340 amps
- Upgrade with the optional Advanced Pulse Control panel to enable better control over heat input, resulting in less distortion on thin metals
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.42

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|--|---|---------------------------------------|-----------------|
| Precision TIG® 275 Ready-Pak® w/Cart Pkg. | K2618-1 | 208/230/460/1/60 | 275A/40% 225A/60% | 40% Duty Cycle: 104/94/47A 60% Duty Cycle: 86/78/39 | DC: 2-340A AC: 2-340A Max. OCV: 75V | 49.7 x 28 x 41 (1262 x 711 x 1041) | 641 (291) |
| Base Model | K2619-1 | | | | | 31 x 22 x 26 (787 x 559 x 660) | 397 (180) |
| | K2619-2 | 460/575/1/60 | | 40% Duty Cycle: 47/38A 60% Duty Cycle: 39/31 | | | |
| | K2620-1 | 220-230/380-400/ 415/1/50/60 | | 40% Duty Cycle: 95/55/50A 60% Duty Cycle: 80/46/42 | | | |

Precision TIG® 375

Precision Welding, Maximum Range TIG Welder

- Tackle either end of the material thickness spectrum with the widest operating range in its class from 2 to 420 amps
- AC Auto-Balance® automatically adjusts for the optimal mix of cleaning and penetration when welding aluminum. Or, take full control to adjust cleaning or penetration.
- Standard pulse functions enable better control over heat input, resulting in less distortion on thin metals
- Experience enhanced starting, optimal arc stability, and precise crater fills with Micro-Start™ II technology



Processes

- Stick
- TIG

Output



Input



Literature

E3.51

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|--|---|---------------------------------------|-----------------|
| Precision TIG® 375 Ready-Pak® w/Cart Pkg. | K2624-1 | 208/230/460/1/60 | 375A/40% 350A/60% | 40% Duty Cycle w/PFC: 112/102/51A 60% Duty Cycle: 102/92/46 | DC: 2-420A AC: 2-420A Max. OCV: 80V | 49.7 x 28 x 41 (1262 x 711 x 1041) | 751 (341) |
| Base Model | K2622-1 | | | | | 31 x 22 x 26 (787 x 559 x 660) | 507 (230) |
| | K2622-2 | 230/460/575/1/60 | | 40% Duty Cycle w/PFC: 102/51/41A 60% Duty Cycle: 92/46/37 | | | |
| | K2623-1 | 220-230/380-400/ 415/1/50/60 | | 40% Duty Cycle w/PFC: 119/69/63A 60% Duty Cycle: 110/64/59 | | | |

Aspect® 375

Advanced TIG Technology Made Simple

- Effortless arc control for the smoothest welds
- AC Auto-Balance® makes it simple by automatically providing the optimal mix of cleaning and penetration on aluminum
- Intellistart™ Technology provides soft starts on thin materials for minimal distortion and hotter starts on thick materials
- Customize when you need it: Manage AC frequency, balance and offset to modify arc profile, cleaning action or penetration



Processes

- AC/DC TIG
- Stick

Output



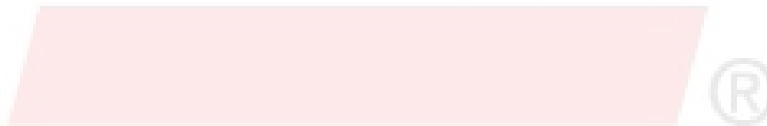
Input



Literature

E3.117

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------|----------------|---------------------------------|--|--|--------------------|---------------------------------------|-----------------|
| Aspect® 375 Base Model | K3945-1 | 200-600/1/3/50/60 | 3 Phase: 330A/40% 300A/60% | 3 Phase: 60% Duty Cycle: 29/26/15/12/10 40% Duty Cycle: 27/24/14/11/9 | 3-Phase: 2-375A | 21 x 11.8 x 25.5 [533 x 300 x 648] | 105 [47.6] |
| Ready-Pak® Pkg. | K3946-2 | | 1 Phase: 240A/40% 225A/60% | 1 Phase: 60% Duty Cycle: 34/31/NA/NA/NA 40% Duty Cycle: 32/29/NA/NA/NA | 1-Phase: 2-250A | 47 x 23 x 45 [1194 x 584 x 1143] | 290 [132] |



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V155-S

TIG Ready-Pak® Welding Package (K2606-1)

- Invertec® V155-S (K2605-1)
- Stick electrode holder & cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Work clamp & cable, 10 ft. (3.0 m) with Twist Mate™ plug
- Fully adjustable shoulder strap
- 120/230V input cord [6.6 ft. (2 m)] with a 120V 15 Amp plug
- Extra 120V 20 Amp plug
- Gas Regulator & Hose (3000369)
- PTA-17V TIG torch w/Ultra-Flex™ cable and Twist Mate™ adapter
- PTA-17 TIG Accessory Kit (KP508)
- Easy-Store/Easy-Carry Suitcase

Invertec® V160-T

Base Model (K1845-1)

- 115V Input cord (10 ft.) and plug (NEMA 5-15P)
- 20 Amp Plug (NEMA 5-20P)
- Twist Mate® Torch Adapter for PTA-9 or -17 one-piece torch
- Fully adjustable shoulder strap
- Work Clamp & Cable, 10 ft., (3.0 m)

Square Wave™ TIG 200

Base Model (K5126-1)

- PTA-17 Series 150A Air-Cooled TIG Torch with Flexible Head and Ultra-Flex™ Cable Assembly
- Foot Amptrol™
- Regulator/Flowmeter with Gas Hose
- Stick Electrode Holder
- Ground Clamp
- 120/230V Input Cords

Precision TIG® 225

Base Model (K2533-1)

- Torch Parts Storage Compartment
- Torch Hanger
- 10 ft. (3.0 m) Work Cable & Clamp
- Removable Lift Eye
- 9 ft. (2.7 m) Input Power Cord with NEMA 6-50P Plug
- NEMA 6-50R Receptacle
- TIG Procedure Guide
- GTAW (TIG) Handbook

Ready-Pak® Package (K2535-1)

- Everything Listed Above (K2533-2)
- PTA-17 One-Piece TIG Torch
- Gas Regulator & Hose (3000369)
- Foot Amptrol™
- Long Back Cap
- Work Clamp and Cable, 10 ft. (3.0 m)

Ready-Pak w/Cart Package (K2535-2)

- Everything Listed Above (K2535-1)
- Understorage Cart



Shown:
Invertec® V155-S
Ready-Pak® Pkg.



Shown:
Precision TIG® 225
Ready-Pak® w/Cart Pkg.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Precision TIG® 275

Ready-Pak® w/Cart Package (K2618-1)

- Precision TIG® 275 (K2619-1)
- Under-Cooler Cart
- Foot Amptrol™
- Harris® Gas Flowmeter Regulator & 10 ft. (3.0 m) Hose Kit (3100338)
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- Parts Kit
- Water Hose (2 included)
- 15 ft. (4.5 m) 2/0 Work Cable/Clamp
- PTA-9 or -17 Torch Adapter

Precision TIG® 375

Ready-Pak® w/Cart Package (K2624-1)

- Precision TIG® 375 (K2622-1)
- Under-Cooler Cart
- Foot Amptrol™
- Harris® Gas Flowmeter Regulator & 10 ft. (3.0 m) Hose Kit (3100338)
- PTW-20 Pro-Torch™ TIG Torch
- Zippered Torch Cover
- Parts Kit
- Water Hose (2 included)
- 15 ft. (4.5 m) 2/0 Work Cable/Clamp
- Adapter for optional PTA-9 or -17 Torch, 3/8 in. (9.5 mm)

Aspect® 375

Ready-Pak® Package (K3946-2)

- Cool Arc® 47 Water Cooling System (K3950-1)
- TIG Welding Cart (K3949-1)
- 20H-320-25R 320 Amp Water Cooled TIG Torch (K4168-2)
- Twist Mate® Torch Cable Adaptor (K1622-5)
- TIG Torch Parts Kit (KP510)
- Foot Amptrol with 25 ft. (7.6m) Cable Assembly (K870)
- 15 ft. (4.5m) Work Lead Assembly (K1803-3)
- Gas Regulator With Hose (3100211)
- Low Conductivity Coolant (KP4159-1)



Shown:
Precision TIG® 275
Ready-Pak® w/Cart Pkg.



Shown:
Precision TIG® 375
Ready-Pak® w/Cart Pkg.



Shown:
Aspect® 375 Ready-Pak®

Accessories

| Product Name | Product No. | Inverterc® V155-S | Inverterc® V160-T | Square Wave TIG 200 | Precision TIG® 225 | Precision TIG® 275 | Precision TIG® 375 | Aspect® 375 |
|---|---------------|-------------------|-------------------|---------------------|--------------------|--------------------|--------------------|-------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| GENERAL | | | | | | | | |
| Undercarriage | K964-1 | | | | | | | |
| Undercarriage | K1869-1 | | | | | • | • | • |
| Understorage Cart | K2348-1 | | | | • | | | |
| Dual Cylinder Cart | K2617-1 | | | | • | | | |
| Inverter Cart | K3949-1 | | | | | | | • |
| Welding Cart (80 cu ft. bottle capacity) | K2275-1 | • | • | | | | | |
| Utility Cart (150 cu ft. bottle capacity) | K520 | | • | • | | | | |
| Small Canvas Cover | K2377-1 | | • | • | | | | |
| Medium Canvas Cover | K2378-1 | | | | • | | | |
| Advanced Control Panel | K2621-1 | | | | | • | • | |
| Work Clamp & Cable Assembly | K2150-1 | | | | | • | • | • |
| Twist Mate™ Plug for 6-4 Cable | K852-25 | • | | | | | | |
| Weld Fume Control System | See Fume Sec. | • | • | • | • | • | • | • |
| STICK | | | | | | | | |
| Stick Electrode Holder & Cable | K2374-1 | | | | • | | | |
| Stick Electrode Holder, Work Clamp, Cable & Twist Mate Set | K2394-1 | | • | • | | | | |
| Accessory Kit, 150 Amp | K875 | | | | | • | • | |
| Accessory Kit, 400 Amp | K704 | | | | | • | • | • |
| Remote Output Control, 25 ft (7.6 m) | K857 | | | | | • | • | • |
| Remote Output Control, 100 ft (3.0 m) | K857-1 | | | | | • | • | • |
| TIG | | | | | | | | |
| Wireless Foot Pedal & Receiver | K4217-1 | • | • | | • | • | • | • |
| Replacement Wireless Pedal Transmitter | K4218-1 | • | • | | • | • | • | • |
| Replacement Wireless Receiver | K4219-1 | • | • | | • | • | • | • |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | | • | • | • | • | • | • |
| Foot Amptrol™ with 25 ft (7.6 m) cable assembly | K870 | | • | • | • | • | • | • |
| Arc Start Switch | K814 | | • | • | • | • | • | • |
| PTA-9, PTW-20, 20-250-25R and 20H-320-25R Gas Lens Parts Kit | KP2414-1 | • | • | • | • | • | • | • |
| PTA-9 -17 One Cable Torch Adapter | K2166-3 | | | | | • | • | • |
| PTA-9, -17, -26 Two Cable Torch Adapter | K2166-2 | | | | | • | • | • |
| PTA-26 One Cable Torch Adapter | K2166-1 | | | | | • | • | • |
| PTA-9 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc | K1781-1 | • | • | • | • | • | • | • |
| PTA-9F Flex Head w/ Ultra-Flex Cable TIG Torch Package, 12.5 ft (3.8 m), 1 pc | K1781-9 | • | • | • | • | • | • | • |

Accessories

| Product Name | Product No. | Inverterc® V155-S | Inverterc® V160-T | Square Wave TIG 200 | Precision TIG® 225 | Precision TIG® 275 | Precision TIG® 375 | Aspect® 375 | | |
|--|-------------|-------------------|-------------------|---------------------|--------------------|--------------------|--------------------|-------------|---------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | | | |
| TIG, CON'T. | | K2606-1 | K1845-1 | K5126-1 | K2533-1 | K2619-1 | K2619-2 | K2622-1 | K2622-2 | K3945-1 |
| PTA-17 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc | K1782-1 | • | • | • | • | • | • | • | • | • |
| PTA-17 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 1 pc | K1782-3 | • | • | • | • | • | • | • | • | • |
| PTA-17 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 2 pc | K1782-4 | | | | | • | • | • | • | |
| PTA-17 Pro-Torch™ TIG Torch, 150 amp, 12.5 ft (3.8 m), 1 pc | K1782-12 | • | • | • | • | • | • | • | • | • |
| PTA-17FV Flex Head Gas Valve Pro-Torch™ TIG Torch w/Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc | K1782-13 | • | • | • | • | • | • | • | • | • |
| PTA-17F Ready-Pak®, 150 amp air-cooled TIG Torch w/Flex Head & Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc, and Twist-Mate™ adapter. Includes #7 nozzle, 1/16 in. (1.6 mm) and 3/32 (2.4 mm) collets & bodies, and E3® tungsten | K1782-14 | • | • | • | • | • | • | • | • | • |
| PTA-17F Pro-Torch™ TIG Torch, 150 amp air-cooled w/Flex Head and Ultra-Flex™ Cable, 12.5 ft (3.8 m), 1 pc | K1782-15 | • | • | • | • | • | • | • | • | • |
| PTA-26 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 1 pc | K1783-1 | | | • | • | • | • | • | • | • |
| PTA-26 200 Amp Air-Cooled TIG torch w/1 pc 25 ft (7.6 m) cable | K1783-3 | | | • | • | • | • | • | • | • |
| PTA-26 200 Amp Air-Cooled TIG torch w/2 pc 25 ft (7.6 m) cable | K1783-4 | | | | | • | • | • | • | |
| PTW-18 350 Amp Water-Cooled TIG torch with 12.5 ft (3.8 m) cable assembly | K1784-1 | | | | • | • | • | • | • | • |
| PTW-18 350 Amp Water-Cooled TIG torch w/3 pc. 25 ft (7.6 m) cable | K1784-2 | | | | • | • | • | • | • | • |
| PTW-20 Pro-Torch™ TIG Torch, 12.5 ft (3.8 m), 3 pc braided | K1784-3 | | • | • | • | • | • | • | • | • |
| PTW-20 Pro-Torch™ TIG Torch, 25 ft (7.6 m), 3 pc braided | K1784-4 | | • | • | • | • | • | • | • | • |
| 20H-320-25R 320 Amp Water Cooled TIG Torch, 3 pc. 25 ft. (7.6 m) covered cable | K4168-2 | | | | • | • | • | • | • | • |
| Parts Kit For PTA-9 Series Torches | KP507 | • | • | • | • | • | • | • | • | • |
| Parts Kit For PTA-17 Series Torches | KP508 | • | • | • | • | • | • | • | • | • |
| Parts Kit For PTW-18 and PTA-26 Series Torches | KP509 | | • | • | • | • | • | • | • | • |
| Parts Kit for 20-250-25R, 20H-320-25R, and PTW-20 TIG Torches | KP510 | | • | • | • | • | • | • | • | • |
| TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled) | K2266-1 | | • | • | • | | | | | |
| TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled) | K2267-1 | | • | • | • | | | | | |
| Harris® Ar/CO2 Flowmeter/Regulator with 10 ft (3.0 m) Gas Hose Kit | 3100211 | | • | • | • | • | • | • | • | • |
| Zippered Torch Cable Cover, 10 ft (3.0 m) | K918-1 | • | • | • | • | • | • | • | • | • |
| Zippered Torch Cable Cover, 22 ft (6.7 m) | K918-2 | • | • | • | • | • | • | • | • | • |
| Zippered Torch Cable Cover, Heavy Duty, 22 ft (6.7 m) | K918-4 | • | • | • | • | • | • | • | • | • |
| Small Twist Mate™ TIG Torch Adapter (w/separate gas) | K960-2 | • | | | | | | | | |
| Twist Mate™ Torch Adapter, PTA-9 and -17 | K1622-1 | | • | • | • | | | | | • |
| Twist Mate™ Torch Adapter, PTA-26 | K1622-3 | | • | • | • | | | | | • |
| Twist Mate™ Torch Adapter, Water-Cooled (for use with Cool Arc® 40) | K1622-4 | | • | • | • | | | | | |
| Twist Mate™ Torch Adapter, Water-Cooled (for use with Cool Arc® 47) | K1622-5 | | | | | | | | | • |



MIG: WIRE FEEDER/WELDERS

| MODEL | OUTPUT | | | | PROCESS | | | | | INPUT | | FEATURES | | | | | | | |
|----------------------------|------------------------------|----------------------------------|-------------------------------|-------------------------------|---------|------------|------------|-------|------------------|-------|-------|----------|--------------------|------------------------|------------------|-------------------|-----------------|-----------------------------|---------------------|
| | Current Range (Amps) | Wire Feed Speed Range ipm (m/mm) | Solid Wire Size Range in (mm) | Cored Wire Size Range in (mm) | MIG | MIG Pulsed | Flux-Cored | Stick | Touch Start TIG® | Phase | Hertz | Portable | Consumable Storage | Meters/Digital Display | Synergic Control | Spool Gun Capable | Push-Pull Model | Diamond Control™ Technology | Chopper Technology® |
| 120 VOLT INPUT | | | | | | | | | | | | | | | | | | | |
| Power MIG® 140C | 30-140 | 50-500 (1.3-12.7) | 0.023-0.035 (0.6-0.9) | 0.030-0.035 (0.8-0.9) | ● | | ● | | | 1 | 60 | ● | | | | ● | | ● | |
| 120/230 VOLT INPUT | | | | | | | | | | | | | | | | | | | |
| Power MIG® 180 Dual | 120V: 30-140 230V: 30-180 | 50-500 (1.3-12.7) | 0.023-0.035 (0.6-0.9) | 0.030-0.045 (0.8-1.2) | ● | | ● | | | 1 | 60 | ● | | | | ● | | ● | |
| Power MIG® 210 MP | 120V: 20-140 230V: 20-220 | 50-500 (1.3-12.7) | 0.023-0.035 (0.6-0.9) | 0.030-0.045 (0.8-1.2) | ● | | ● | ● | ● | 1 | 60 | ● | ● | ● | | ● | | | |
| 208-230 VOLT INPUT | | | | | | | | | | | | | | | | | | | |
| Power MIG® 180C | 30-180 | 50-500 (1.3-12.7) | 0.025-0.035 (0.6-0.9) | 0.030-0.045 (0.8-1.2) | ● | | ● | | | 1 | 60 | ● | | | | ● | | ● | |
| Power MIG® 216 | 30-250 | 50-700 (1.3-17.7) | 0.023-0.045 (0.6-1.2) | 0.030-0.045 (0.8-1.2) | ● | | ● | | | 1 | 50/60 | | ● | | | ● | | ● | |
| Power MIG® 256 | 30-300 | 50-700 (1.3-17.7) | 0.023-0.045 (0.6-1.2) | 0.030-0.045 (0.8-1.2) | ● | | ● | | | 1 | 60 | | ● | ● | | ● | | ● | |
| Power MIG® 350MP | 5-350 | 50-700 (1.3-17.7) | 0.023-0.045 (0.6-1.2) | 0.030-0.045 (0.8-1.2) | ● | ● | ● | ● | ● | 1 | 50/60 | | ● | ● | ● | ● | ● | ● | ● |

POWER MIG® 140C

MIG Welding Made Simple

- 120-volt input enables you to plug in at home for repair projects or auto body work
- Consistent wire feeding through MAXTRAC® dual gear-driven drive roll system
- PC boards are fully encapsulated and additionally protected by a framed tray for maximum circuit protection
- Reliable wire delivery and extended tip life with Magnum® PRO gun and Copper Plus™ contact tips



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.23

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|---------------------------------|--|------------------------------|--------------|-----------------------------|-------------------------------------|-----------------|
| POWER MIG® 140C | K2471-2 | 120/1/60 | 90A/19.5V/20% | 20A | 30-140A | 50-500 (1.3-12.7) | 14 x 10.15 x 18.6 (357 x 258 x 472) | 58 (26.3) |



POWER MIG® 180C

The Professional's Choice.™

- 230-volt input power to tackle jobs big and small
- Consistent wire feeding through dual gear-driven drive rolls
- Encapsulated PC boards for optimal circuit protection



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.24

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|---------------------------------|--|------------------------------|--------------|-----------------------------------|-------------------------------------|-----------------|
| POWER MIG® 180C | K2473-2 | 208/230/1/60 | 130A/17V/30% 130A/20V/30% | 20A | 30-180A | 50-500 (1.3-12.7) Max. OCV: 34 | 14 x 10.15 x 18.6 (357 x 258 x 472) | 66 (30) |

POWER MIG® 180 Dual

The Best of Both Worlds

- Choose 120-volt or 230-volt input power for light materials or thicker metals
- Consistent wire feeding through dual gear-driven drive rolls
- Encapsulated PC boards for optimal circuit protection
- Spool gun ready



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.28

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------|----------------|---------------------------------|--|------------------------------|--------------|-----------------------------|-------------------------------------|-----------------|
| POWER MIG® 180 Dual | K3018-2 | 120/1/60 | 120V: 90A/19.5V/20% | 20A | 30-140A | 50-500 (1.3-12.7) | 14 x 10.15 x 18.6 (357 x 258 x 472) | 68 (31) |
| | | 208/230/1/60 | 208V: 130A/17.6V/30% 230V: 130A/20V/30% | | 30-180A | | | |

POWER MIG® 210 MP

Versatile, Rugged & Simple To Use

- Lightweight and portable – just 40 lbs. (18 kg)
- Ready. Set. Weld® – intuitive push-and-turn digital controls make setup a breeze
- 210 Amps – the power to tackle any job



Processes

- MIG
- Flux-Cored
- DC Stick
- DC TIG

Output



Input



Literature

E7.50

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|---------------------------------|--|------------------------------|--------------------------------------|-----------------------------|-----------------------------------|-----------------|
| POWER MIG® 210 MP | K3963-1 | 120/1/60 230/1/60 | 120V: 100A/19.0V/40% 230V: 200A/24V/25% | 15A 14.7A | 120V: 20-140A DC Max. OCV: 56V | 50-500 (1.3-12.7) | 14 x 10.75 x 19 (356 x 273 x 483) | 40 (18) |
| Aluminum One-Pak® | K4195-1 | | | | 230V: 20-220A DC Max. OCV: 56V | | | |
| TIG One-Pak® | K4195-2 | | | | | | | |

POWER MIG® 216

Best Wire Delivery from Spool to Spark

- Simple dual knob controls are ideal for sheet metal and autobody
- Fast and easy setup (no tools required) means less time prepping and more time welding
- Delivers a smooth arc and minimal spatter in any position
- Spool gun ready with Magnum® PRO 100 SG; spool gun capable with other models



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.52

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------|----------------|---------------------------------|--|--|--------------|-----------------------------|---|-----------------|
| POWER MIG® 216 | K2816-2 | 208/230/1/60 220/1/50 | 170A/24V DC/60% 216A/22V DC/30% | 208V: 33A @ 170A/24V DC/60% 208V: 40A @ 216A/22V DC/30% 230V: 30A @ 170A/24V DC/60% 230V: 36A @ 216A/22V DC/30% | 30-250A | 50-700 (1.6-17.8) | 32.6 x 19.2 x 40.0 (828 x 488 x 1,016) | 206.5 (93.7) |

POWER MIG® 256

POWER MIG® with Precision Control

- Ideal for light industrial and maintenance work
- Weld up to 3/4 in. (19.1 mm) mild steel with self-shield flux-cored wire
- Digital meters help dial in exact settings and timer functions deliver additional weld control
- Spool gun ready for our premium Magnum® 250LX



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E7.55

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|---------------------------------|--|------------------------------|--------------|-----------------------------|---|-----------------|
| POWER MIG® 256 | K3068-1 | 208/230/1/60 | 250A/26V/40% | 56/52A ⁽¹⁾ | 30-300A | 50-700 (1.3-17.7) | 31.8 x 18.9 x 38.8 (808 x 480 x 985) | 220 (100) |
| | K3068-2 | 230/460/575/1/60 | | 50/24/19A | | | | |
| One-Pak® w/Spool Gun | K3069-1 | 208/230/1/60 | | 56/52A ⁽¹⁾ | | | | |

⁽¹⁾Input current is at the rated output with the 115V auxiliary receptacle also drawing 15 amps.

POWER MIG® 350MP

The Professional's Choice!™ –
Multi-Process Welder

- Weld stick, TIG and MIG with one multi-process machine
- Up to three ways to feed aluminum, including push gun, spool gun or push-pull gun, depending on frequency of use and budget
- Capable of advanced pulse processes to control heat input and penetration in the weld
- Consistent wire feeding through the all-metal MAXTRAC® dual gear-driven drive roll system



Processes

- Stick
- TIG
- MIG
- Pulsed
- Flux-Cored

Output



Input



Literature

E7.57

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Wire Feed Speed ipm (m/min) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|------------------------------|----------------------------|-----------------------------|---|-----------------|
| POWER MIG® 350MP | K2403-2 | 208/230/460/575/1/50/60 | 300A/32V/60% ⁽¹⁾ | 72/62/31/25A | 5-350A DC Max. OCV: 67V | 50-700 (1.3-17.7) | 31.8 x 18.9 x 38.8 (808 x 480 x 985) | 255 (116) |
| Aluminum One-Pak® Pkg. for Trailer Mfg./General Fab. | K4023-1 | | | | | | | |
| Aluminum One-Pak® Pkg. for Auto Body Repair | K4023-2 | | | | | | | |

⁽¹⁾40% on 208V input. Ratings based on 60 Hz operation.

POWER MIG[®] 210 MP

multi-process welder



3 PROCESSES ■ 2 INPUT VOLTAGES ■ 210 AMPS
ONE POWERFUL MACHINE



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

POWER MIG® 140C

Base Model (K2471-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

POWER MIG® 180C

Base Model (K2473-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

POWER MIG® 180 Dual

Base Model (K3018-2)

- Magnum® PRO 100L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- 120V and 230V Input Cables
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD

POWER MIG® 210 MP

Base Model (K3963-1)

- Magnum® PRO 175L Gun, 10 ft. (3.0m)
- Gun Cable Liner (pre-installed in gun)
- Gas and Gasless Nozzles
- 0.025 in. (0.6mm) Contact Tips (Qty. 3)
- 0.035 in. (0.9mm) Contact Tips (Qty. 3)
- 0.025-0.030 in. (0.6-0.8 mm) MIG Drive roll
- 0.035 in. (0.9mm) MIG Drive Roll
- 0.030-0.045 in. (0.8-1.2mm) Knurled Drive Roll
- 0.025-0.035 in. (0.6-0.9 mm) Wire Guide
- 0.045 in. (1.2 mm) Wire Guide
- 120V and 230V Input Cables
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose
- Spindle Adapter, 8 in. (203 mm) Dia. Spools
- 2 lb. (0.90 kg) Spool of SuperArc® L-56° Mild Steel MIG Wire
- 1 lb. (0.45 kg) Spool of Innershield® NR®-211-MP
- Learn-To-Use DVD



Shown:
POWER MIG® 210 MP
Base Model with
Standard Accessories



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

POWER MIG® 216

Base Model (K2816-2)

- Magnum® PRO 250L Gun, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- 230V Input Power Cable
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

POWER MIG® 256

Base Model (K3068-1, K3068-2)

- Magnum® PRO 250L Gun, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- 230V Input Power Cable
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

One-Pak® Package (K3069-1)

- Everything listed with base model
- Magnum® 250LX Spool Gun
- Dual Cylinder Mounting Kit
- Extra Gas Regulator

POWER MIG® 350MP

Base Model (K2403-2)

- Magnum® PRO Curve 300, 15 ft. (4.5 m)
- Gun Cable Liner (pre-installed in gun)
- Drive Rolls and Guide for Steel
- 230V Input Power Cable
- Work Clamp and Cable, 10 ft. (3.0 m)
- Adjustable Gas Regulator & Hose

Aluminum One-Pak® Package for Trailer Manufacturing/General Fab (K4023-1)

- Everything listed with base model
- Magnum® PRO AL gun G225A, 7-pin, 25 ft. (7.6 m)
- Aluminum Drive Roll Kit, 3/64 in. (1.2 mm)
- SuperGlaze® 5356 TM™ 3/64 in. (1.2 mm), 16 lb. (7.3 kg.) Spool

Aluminum One-Pak® Package for Auto Body Repair (K4023-2)

- Everything listed with base model
- Magnum® PRO AL gun G225A, 7-pin, 25 ft. (7.6 m)
- Aluminum Drive Roll Kit, 3/64 in. (1.2 mm)
- SuperGlaze® 5554 3/64 in. (1.2 mm), 16 lb. (7.3 kg.) Spool



Shown:
POWER MIG® 256
One-Pak® Package



Shown:
POWER MIG® 350 MP
One-Pak® Package

Accessories

| Product Name | Product No. | POWER MIG® 140C | POWER MIG® 180C | POWER MIG® 180 Dual | POWER MIG® 210 MP | POWER MIG® 216 | POWER MIG® 256 | POWER MIG® 350MP | |
|---|--------------|-----------------|-----------------|---------------------|-------------------|----------------|----------------|------------------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | K2471-2 | K2473-1 | K3018-2 | K3963-1 | K2816-2 | K3068-1 | K3068-2 | K2403-2 |
| GENERAL | | | | | | | | | |
| Welding Cart (80 cu. ft. bottle capacity) | K2275-1 | • | • | • | • | | | | |
| Utility Cart (150 cu. ft. bottle capacity) | K520 | • | • | • | • | | | | |
| Canvas Cover | K2377-1 | • | • | • | • | | | | |
| Canvas Cover | K2378-1 | | | | | • | • | • | • |
| Spot Timer Kit | K2525-1 | • | • | • | | | | | |
| Accessory Bag | K3071-1 | • | • | • | • | | | | |
| Connector Kit – POWER MIG® | K466-6 | | | | | • | • | • | |
| 8 in. (203.2 mm) O.D. Spool Adapter | K468 | | | | | • | • | • | |
| Dual Cylinder Mounting Kit | K1702-1 | | | | | • | • | • | • |
| Drive Roll, 0.025-0.030 in. (0.6-0.8 mm) Smooth | KP2529-1 | • | • | • | • | | | | |
| Drive Roll, 0.035 in. (0.9 mm) Smooth | KP2529-2 | • | • | • | • | | | | |
| Drive Roll, 0.030-0.045 in. (0.8-1.1 mm) Knurled | KP2529-3 | • | • | • | • | | | | |
| Inner Wire Guide, 0.025-0.035 in. (0.6-0.9 mm) Steel | KP2531-1 | • | • | • | • | | | | |
| Inner Wire Guide, 0.045 in. (1.1 mm) Steel | KP2531-2 | • | • | • | • | | | | |
| Drive Roll Kit, 0.023-0.030 in. (0.6-0.8 mm) Solid Wire | KP1696-030S | | | | | • | • | • | • |
| Drive Roll Kit, 0.035 in. (0.9 mm) Solid Wire | KP1696-035S | | | | | • | • | • | • |
| Drive Roll Kit, 0.035 and 0.045 in. (0.9 and 1.1 mm) Solid Wire | KP1696-1 | | | | | • | • | • | • |
| Drive Roll Kit, 0.040 in. (1.0 mm) Solid Wire | KP1696-2 | | | | | • | • | • | • |
| Drive Roll Kit, 0.045 in. (1.1 mm) Solid Wire | KP1696-045S | | | | | • | • | • | • |
| Drive Roll Kit, 0.030-.035 in. (0.8-0.9 mm) Cored Wire | KP1697-035C | | | | | • | • | • | • |
| Drive Roll Kit, 0.040-0.045 in. | KP1697-045C | | | | | • | • | • | • |
| Drive Roll Kit, 0.035 in. (0.9 mm) Aluminum Wire | KP1695-035A | | | | | | | | • |
| Drive Roll Kit, 3/64 in. (1.2 mm) Aluminum Wire | KP1695-3/64A | | | | | • | • | • | • |
| Weld Fume Control System | — | • | • | • | • | • | • | • | • |
| STICK | | | | | | | | | |
| Accessory Kit, 150 Amp | K875 | | | | | | | | • |
| TIG | | | | | | | | | |
| Pro-Torch™ TIG Torches | See Gun Sec. | | | | • | | | | • |
| Parts Kit For PTA-17 Series Torches | KP508 | | | | • | | | | • |
| Parts Kit For PTW-18 and -26 Series Torches | KP509 | | | | | | | | • |
| Foot Amptrol™ | K870 | | | | • | | | | • |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | | | | • | | | | • |
| POWER MIG® 210 MP TIG Amptrol® Adaptor Kit | K4104-1 | | | | • | | | | |
| Arc Start Switch | K814 | | | | | | | | • |
| Cut Length Consumables | See C110 | | | | • | | | | • |

• Optional

Accessories

| Product Name | Product No. | | | | | | | | |
|--|-------------|-----------------|-----------------|---------------------|-------------------|----------------|----------------|------------------|------------|
| | | K2471-2 | K2473-1 | K3018-2 | K3963-1 | K2816-2 | K3068-1 | K3068-2 | K2403-2 |
| | | POWER MIG® 140C | POWER MIG® 180C | POWER MIG® 180 Dual | POWER MIG® 210 MP | POWER MIG® 216 | POWER MIG® 256 | POWER MIG® 350MP | |
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| WIRE FEEDER / GUNS | | | | | | | | | |
| Magnum® PRO AL G225A Air-Cooled Push-Pull Guns | | | | | | | | | |
| 7-pin, 15 ft. (4.5 m) | K3356-1 | | | | | | | | • |
| 7-pin, 25 ft. (7.6 m) | K3356-2 | | | | | | | | • |
| 7-pin, 35 ft. (10.6 m) | K3356-3 | | | | | | | | • |
| 7-pin, 50 ft. (15.2 m) | K3356-4 | | | | | | | | • |
| Magnum® PRO AL G450W Water-Cooled Push-Pull Guns | | | | | | | | | |
| 7-pin, 15 ft. (4.5 m) | K3358-1 | | | | | | | | • |
| 7-pin, 25 ft. (7.6 m) | K3358-2 | | | | | | | | • |
| 7-pin, 35 ft. (10.6 m) | K3358-3 | | | | | | | | • |
| 7-pin, 50 ft. (15.2 m) | K3358-4 | | | | | | | | • |
| Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 25 ft. (7.6 m) | K2704-2 | | | | | | | | • |
| Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 50 ft. (15.2 m) | K2704-3 | | | | | | | | • |
| SPOOL GUN | | | | | | | | | |
| Magnum® PRO 100SG Spool Gun | K3269-1 | • | • | • | • | • | | | |
| Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m) | K487-25 | | | | | • | • | • | |
| Magnum® SG Spool Gun Control Cable Adapter | K2445-1 | | | | | | • | • | |
| Magnum® 250LX™ Spool Gun | K2490-1 | | | | | • | • | • | • |
| Adapter Kit for Magnum® SG or Magnum® 250LX™ Spool Gun | K2703-1 | | | | | • | | | |
| Control Cable Extension, 25 ft. (7.6 m) | K2519-1 | | | | | | • | • | • |
| Spool Gun Holder | K1738-1 | | | | | | | | • |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | |
| POWER MIG® 140C | X2471 | • | | | | | | | |
| POWER MIG® 180C | X2473 | | • | | | | | | |
| POWER MIG® 180 Dual | X3018 | | | • | | | | | |
| POWER MIG® 210 MP | X3963 | | | | • | | | | |
| POWER MIG® 216 | X2816 | | | | | • | | | |
| POWER MIG® 256 | X3068 | | | | | | • | • | |
| POWER MIG® 350MP | X2403 | | | | | | | | • |

• Optional

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MIG & FCAW: INDUSTRIAL WELDERS

| MODEL | OUTPUT | | | PROCESS | | | INPUT | | FEATURES | | | |
|------------------------|--------|----------|----------------------|---------|------------|---------------|-------------|-------|----------|-----------------|-----------|-------------------------------------|
| | Mode | Polarity | Current Range (Amps) | MIG | Flux-Cored | Submerged Arc | Arc Gouging | Phase | Hertz | Digital Display | Stackable | 7-yr. Warranty (on Power Rectifier) |
| 300 AMPS | | | | | | | | | | | | |
| Idealarc® CV305 | CV | DC | 50-400 | ● | ● | | | 1 | 60 | • | • | • |
| 400 AMPS | | | | | | | | | | | | |
| Idealarc CV400 | CV | DC | 60-500 | ● | ● | | ● | 1 | 60 | | • | • |

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KEY: ● Excellent ● Good ● Optional

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Idealarc® CV305

Dependable High Output Wire Welding

- Digital Ammeter/Voltsmeter – view voltage presets and current during welding
- Easy access Twist Mate™ connections on the front of the machine
- Two output connectors allow you to connect to high or low inductance for optimal arc control



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E4.22

| Product Name | Product Number | Input Power Voltage/Phase/Hz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|------------------------------|---|------------------------------|------------------|--|-----------------|
| Idealarc® CV305 Base Models | K2400-1 | 208/230/460/3/60 | 315A/32.6V/100% | 52/48/24A | 50-400A 7-34V | 24.6 x 19.5 x 27.0 (625 x 495 x 686) | 300 (136) |
| | K2400-2 | 230/460/575/3/60 | | 48/24/19A | | | |
| Ready-Pak® Pkg w/LF-72 Wire Feeder | K2395-2 | 208/230/460/3/60 | | 52/48/24A | | 47.7 x 25.5 x 33.0 (1212 x 648 x 838) | 423 (192) |

50 Hertz models available.

Idealarc® CV400

Dependable High Output Wire Welding

- Connect wire feeders via either 14-pin MS-type or terminal strip
- 115V and 42V wire feeder auxiliary power with circuit breaker protection



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E4.30

| Product Name | Product Number | Input Power Voltage/Phase/Hz | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|-------------------------|------------------------------|---|------------------------------|-------------------|--|-----------------|
| Idealarc® CV400 Base Models | K1346-22 ⁽¹⁾ | 230/460/575/3/60 | 400A/36V/100% 450A/38V/60% | 77/39/31A 80/40/32A | 60-500A 12-42V | 27.5 x 22.2 x 32 (699 x 564 x 813) | 383 (174) |
| | K1346-13 | 230/460/3/60 | | 77/39A 80/40A | | | |
| Ready-Pak® Pkg w/LF-72 Wire Feeder | K2439-2 | | | | | 42.8 x 22.2 x 32 (1087 x 564 x 813) | 475 (215) |
| Ready-Pak® Pkg w/LF-74 Wire Feeder | K2496-2 | | | | | | |

⁽¹⁾Made to order.

50 Hertz models available.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Idealarc® CV305

Ready-Pak® Package (K2395-2)

- CV305 Power Source (K2400-1)
- LF-72 Bench Model, Standard Duty Wire Feeder
- Standard Wire Reel Stand
- Work & Wire Feeder Weld Cable Package, includes 15 ft (4.5 m) Work Cable, 10 ft (3.0 m) Electrode Cable and Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire

Idealarc® CV400

CV400/LF-72 Ready-Pak® Package (K2439-2)

- CV400 Power Source (K1346-13)
- LF-72 Bench Model, Heavy Duty Wire Feeder
- Heavy Duty Wire Reel Stand
- Weld Power Cable, 10 ft. (3.0 m), Qty. 2
- Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire

CV400/LF-74 Ready-Pak® Package (K2496-2)

- CV400 Power Source (K1346-13)
- LF-74 Bench Model, Heavy Duty Wire Feeder
- Heavy Duty Wire Reel Stand
- Weld Power Cable, 10 ft. (3.0 m), Qty. 2
- Work Clamp
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.5 m) with 0.035-0.045 in. (0.9-1.1 mm) liner
- Control Cable, 10 ft. (3.0 m)
- 0.035-0.045 in. (0.9-1.1 mm) Drive Roll and Guide Tube Kit for Solid Wire



Shown:
 Idealarc® CV400/LF72
 Ready-Pak®

Accessories

| Product Name | Product No. | Idealarc® CV305 | | Idealarc® CV400 | |
|--|---------------------|-----------------|------------|-----------------|------------|
| | | Base Model | Base Model | Base Model | Base Model |
| | | KZ400-1 | KZ400-2 | K1346-22 | K1346-13 |
| GENERAL | | | | | |
| Remote Output Control, 25 ft. (7.6 m) | K857 | • | • | • | • |
| Remote Output Control, 100 ft. (30 m) | K857-1 | • | • | • | • |
| Remote Control Cable Adapter (required for use of K857 and K857-1) | K864 | • | • | • | • |
| Twist Mate™ Cable Plug for 1/0-2/0 (50-70 mm ²) cable | K852-70 | • | • | | |
| Twist Mate™ Cable Plug for 2/0-3/0 (70-95 mm ²) cable | K852-95 | • | • | | |
| Jumper Plug Kit | K484 ⁽¹⁾ | • | • | • | • |
| Undercarriage – Hand moving | K874 | • | • | | |
| Undercarriage – Hand moving | K841 | | | • | • |
| Arc Tracker™ | K3019-1 | • | • | • | • |
| Weld Fume Control System | – | • | • | • | • |
| WIRE FEEDER | | | | | |
| LF-72, LF-74, LN-25 PRO | – | • | • | • | • |
| LN-8, LN-9, LN-10, DH-10, LN-25 PRO Dual Power, FlexFeed™ 74 HT, Activ8™ | – | | | • | • |



⁽¹⁾Made to order.

• Optional



MULTI-PROCESS WELDERS®

| MODEL | OUTPUT | | Current Range (Amps) | PROCESS | | | | | | INPUT | | FEATURES | | |
|-------------------------------|--------|----------|----------------------|---------|-----|-----|-----------|------------|---------------|-----------|-------|----------|-----------|---------|
| | Mode | Polarity | | Stick | TIG | MIG | MIG Pulse | Flux-Cored | Submerged Arc | Arc Gouge | Phase | Hertz | Stackable | Modular |
| INVERTER TECHNOLOGY | | | | | | | | | | | | | | |
| Invertec® V350 PRO | CC/CV | DC | 5-425 | ● | ● | ● | ○ | ● | ● | 1/3 | 50/60 | | | |
| FLEXTEC® 350X | CC/CV | DC | 5-500 | ● | ● | ● | | ● | | 3 | 50/60 | | ● | |
| FLEXTEC® 500 | CC/CV | DC | 5-500 | ● | ● | ● | | ● | ● | 3 | 50/60 | | ● | |
| FLEXTEC® 500P | CC/CV | DC | 10-500 | ● | ● | ● | | ● | ● | 3 | 50/60 | | ● | |
| AlumaFab® | CC/CV | DC | 5-500 | | | ● | ● | | | 3 | 50/60 | | ● | |
| FLEXTEC® 650 | CC/CV | DC | 10-815 | ● | ● | ● | | ● | ● | 3 | 50/60 | | | |
| PERFORMANCE MONITORING | | | | | | | | | | | | | | |
| Arc Tracker® | CC/CV | DC | — | ● | ● | ● | ● | ● | ● | 1 | 50/60 | | | |
| RECTIFIER TECHNOLOGY | | | | | | | | | | | | | | |
| Idealarc® DC400 | CC/CV | DC | 60-500 | ● | ● | ● | | ● | ● | 3 | 60 | | ● | ● |
| Idealarc® DC600 | CC/CV | DC | 70-850 | ● | ● | ● | | ● | ● | 3 | 60 | | ● | ● |

Invertec® V350 PRO

Multi-Purpose Welder with Multiple Models

- Highly portable at less than 90 lb. (41 kg)
- Greater flexibility for input power for any environment or location
- All input voltages and frequencies are both single- and three-phase rated; no derating necessary on single-phase



Processes

- Stick
- DC TIG
- MIG
- Pulsed MIG (Advanced Process Panel only)
- Flux-Cored
- Gouging

Output



Input



Literature

E5.91

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---|--|---|-------------------------------|---|-----------------|
| Invertec® V350 PRO Construction | K1728-5 | 200-208/230/ 380-415/460/575/ 1/3/50/60 | 350A/34V/60% 300A/32V/100% | 3-Ph: 50/42/28-26/23/18 1-Ph: 94/85/54/42/37 | 5-425A Max. OCV: 80V DC | 14.8 x 13.3 x 27.9 (376 x 338 x 709) | 81 36.7 |
| Factory | K1728-6 | | | | | | |
| V350 PRO/LF-72 Ready-Pak® Pkg. | K2437-2 | | | | | 55.2 x 28.5 x 55.5 (1403 x 724 x 1410) | 370 (168) |
| Advanced Process | K1728-7 | 208/230/415/460/ 575/1/3/50/60 | | 3-Ph: 41-39/36/23-22/19/16 1-Ph: 76/69/41/36/31 | | | |
| Factory (Tweco®) | K1728-13 | | | | | | |
| CE Model | K1728-12 | 200-220/380-400/ 415-440/1/3/50/60 | 3-Ph: 350A/34V/60% 1-Ph: 320A/33V/60% 3-Ph: 300A/32V/100% 1-Ph: 275A/31V/100% | 3-Ph: 48/28-27/26-24 1-Ph: 82/55-50/48-45 3-Ph: 41-37/28-22/22-21 1-Ph: 64/44-43/38-35 | | 14.8 x 13.3 x 27.9 (376 x 338 x 709) | 86.5 (37.4) |

FLEXTEC® 350X

A Rugged Multi-Process Power Source for Maximum Flexibility

- Simple operator panel minimizes setup time
- Reliable components designed to run cool for long life in high temperature environments
- Flexible enough to work with across-the-arc, analog, digital or CrossLinc™ wire feeders
- Embedded CrossLinc™ Technology enables remote procedure setting at the feeder to save time and improve weld quality



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------------|----------------|---------------------------------|--|------------------------------|-----------------------------|-----------------------------------|-----------------|
| FLEXTEC® 350X Standard | K4272-1 | 380/460/575/3/50/60 | 300A/32V/100% 350A/34V/60% | 26/23/18 | 5-425A Max OCV 80V DC | 17 x 13 x 23 (477 x 356 x 673) | 82 (37.2) |
| Construction | K4271-1 | | | | | | 77 (34.6) |

Idealarc® DC400

Multiple Processes, Rugged Design

- Arc force control adjusts for a soft arc or a forceful driving arc in the stick/TIG mode
- Arc control adjustment changes the pinch effect of the arc to control spatter, fluidity and bead shape in the MIG/Flux-cored mode
- Voltage line compensation helps maintain weld consistency



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.20

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|---|------------------------------|-------------------|---|-----------------|
| Idealarc® DC400 w/115V Duplex GFCI | K1308-25 | 230/460/575/3/60 | 400A/36V/100% 450A/38V/60% 500A/40V/50% | 3-Ph: 78/39A | 60-500A 12-42V | 27.5 x 22.3 x 33.1 (698 x 566 x 840) | 473 (215) |
| w/Multi-Process Switch | K1308-12 | 230/460/3/60 | | | | | |

FLEXTEC® 500

It Doesn't Get Much Simpler Than Flextec®

- Streamlined operator panel minimizes set up time
- Components designed to run cool for long life in high temperature environments
- Compatible with a variety of wire feeders - analog, digital and across-the-arc
- Premium multi-process arc characteristics for wire stick and DC TIG processes



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|---------------------------------|--|------------------------------|--------------|---------------------------------------|-----------------|
| FLEXTEC® 500 Base Model | K4091-1 | 380/460/575/3/50/60 | 500A/40V/60% 450A/38V/100% | 39/31/31 33/27/27 | 5-500A | 18.8 x 14 x 26.5 (477 x 356 x 673) | 120 (54) |
| w/Flex Feed™ 74 HT Ready-Pak® Pkg. | K4093-1 | | | | | | 352 (159.7) |
| w/LF-72 Ready-Pak® Pkg. | K4094-1 | | | | | | 347 (157.4) |
| w/LF-74 Ready-Pak® Pkg. | K4095-1 | | | | | | 347 (157.4) |
| One-Pak® Pkg. | K4096-1 | | | | | | 180 (81.6) |

FLEXTEC® 500P

FLEXible Technology™

- Inverter-based technology saves energy
- Small footprint and light weight improves portability in shipyards, construction sites and other large work areas that require operator mobility
- IP23 enclosure ensures protection against inclement weather and other harsh environments



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------------|----------------|---------------------------------|--|------------------------------------|--------------|---------------------------------------|-----------------|
| FLEXTEC® 500P Base Model | K4092-1 | 380/460/575/3/50/60 | 500A/40V/60% 450A/38V/100% | 3-Ph: 39/31/31A 3-Ph: 33/27/27A | 5-500A | 18.8 x 14 x 26.5 (477 x 356 x 673) | 120 (54) |
| w/Power Feed® 84 Ready-Pak® Pkg. | K4097-1 | | | | | | |

AlumaFab®

The New Industry Standard for Aluminum Welding

- Inverter-based technology saves energy
- Fully dedicated aluminum power source based on the FLEXTEC® 500P
- IP23 enclosure ensures protection against inclement weather and other harsh environments



Processes

- MIG
- Pulse MIG
- CC Pulse

Output



Input



Literature

E5.93b

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------------|-------------------------------|---------------------------------|--|---|--------------|--------------------------------------|-----------------|
| AlumaFab® Base Model | K4189-1 | 460/575/3/60 | GMAW (CV): 450A/36.5V/100% | 3-Ph: 60% Duty Cycle: 39 3-Ph: 100% Duty Cycle: 33 | 5-500A | 188 x 14 x 26.5 (477 x 356 x 673) | 120 (54.4) |
| Air-Cooled One-Pak® | K4186-1 | | | | | | |
| | K4186-3 | GMAW-P (CV): 450A/36.5V/100% | 536 (24.3) | | | | |
| | K4186-4 | | | GMAW-P (CV): 500A/39V/60% | 635.2 (288) | | |
| Air-Cooled Ready-Pak® | K4186-2 | | | | | | |
| Water-Cooled One-Pak® | K4187-1 K4187-3 K4187-4 | | | | | | |
| Water-Cooled Ready-Pak® | K4187-2 | | | | | | |

Idealarc® DC600

Idealarc® with Submerged Arc Capacity

- Full range output voltage control provides easy operation and precise control
- Voltage Reduction Device™ (VRD®) reduces open circuit voltage for an additional level of safety
- Circuitry protected against moisture and corrosive environments



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.40

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|-----------------------|---------------------------------|--|------------------------------|--|---------------------------------------|-----------------|
| Idealarc® DC600 w/Multi-Process Switch | K1288-18 | 230/460/3/60 | 600A/44V/100% 680A/44V/60% | 3-Ph: 108/54A | CV: 70-850A, 13-44V CC: 90-850A, 24-42V | 30.7 x 22.2 x 38 (781 x 565 x 965) | 522 (237) |
| w/Meters | K1288-17 | | | | | | |
| | K1288-22 | 230/460/575/3/60 | | 3-Ph: 108/54A/43.2A | | | |
| w/VRD® | K1288-28 ⁰ | | | | | | |

⁰Made to order. **Note** » 50 Hertz models also available.

Arc Tracker®

Monitor Weld and Operator Performance

- Advanced digital controls sample the welding arc at extremely high speeds
- Simple plug-and-play design enables you to connect to any DC welding circuit, attach voltage leads and immediately monitor arc performance
- Easily calibrated for use in factory quality systems



Processes

- DC Arc Welding Circuits Only (10-1000A @ 100% Duty Cycle)
- Any DC Polarity Welding Process
- Any DC Welding Power Source

Output



Input



Literature

E5.99

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|--------------------|---------------------------------|---|------------------------------|--------------|----------------------------------|-----------------|
| Arc Tracker™ | K3019-1 (US/Int'l) | 120-230/1/50/60 | NEMA EW1: 1,000/44/100% DC IEC 60974-1: 1,000/44/100% DC | 0.8A @ 120V AC | — | 12 x 9 x 15 (305 x 220 x 645) | 20 (9.0) |

FLEXTEC® 650

Simple Operation, More Gouging Power

- Fast arc response means smoother arc action and more consistent bead appearance
- Enhanced portability: up to 50% lighter and smaller than competing machines
- Includes 115 volt auxiliary power input for grinders, lights and tools



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---------------------------------|--|--|--------------|---|---------------------------------|
| FLEXTEC® 650 Base Model | K3060-3 | 380/460/575/3/50/60 | 650/44/100% 750/44/60% | 3-Phase: 100% Duty Cycle: 57/47/38A | 10-815A | 21.8 x 16.1 x 29.3 (554 x 409 x 584) (machine only) | 165 (74.8) (machine only) |
| w/LF-72 Heavy Duty Wire Feeder Ready-Pak® Pkg. w/Cart | K3145-1 | | Desert Duty Rated: 600A/44V/100%/55°C 650A/44V/50%/55°C 750A/44V/30%/55°C | | | | |
| w/LF-74 Heavy Duty Wire Feeder Ready-Pak® Pkg. w/Cart | K3146-1 | | | | | | |
| w/LF-74 Standard Duty Wire Feeder One-Pak® Pkg. | K3147-1 | | | | | | |
| w/LN-10 Bench Model Wire Feeder One-Pak® Pkg. | K3158-1 | | | | | | |

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® V350 PRO

Ready-Pak® Package [K2437-2]

- V350 PRO Factory Model [K1728-6]
- LF-72 Heavy Duty Wire Feeder [K2327-6]
- Magnum® PRO 350 Gun & Cable Assembly, 15 ft. (4.6 m)
- Work & Wire Feeder 2/0 Welding Cable Package, 10 ft. (3.0 m)
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [310021]
- Inverter and Wire Feeder Cart [K1764-1]

FLEXTEC® 350X

Construction One-Pak® Package [K4278-1]

- FLEXTEC® Construction Model [K4271-1]
- LN-25X [K4267-1]
- Drive Roll and Wire Guide Kit 0.045 (1.1 mm) Cored
- Magnum® PRO Curve™ 300 Gun & Cable Ready-Pak, 15 ft (4.5 m)

FLEXTEC® 500

FLEXTEC® 500/LF-72 One-Pak® Package [K4096-1]

- FLEXTEC® 500 [K4091-1]
- LF-72 Bench Model, Standard Duty [K2327-5]
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [310021]

FLEXTEC® 500/Flex Feed™ 74 HT

Ready-Pak® Package [K4093-1]

- FLEXTEC® 500 [K4091-1]
- Flex Feed™ 74 HT [K3883-13]
- Magnum® PRO Curve™ 400 Gun & Cable Assembly
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [310021]
- Inverter and Wire Feeder Cart [K3059-2]
- Inverter Cart Mounting Bracket Kit
- Flextec® 500/500P Locking Foot Kit

FLEXTEC® 500/LF-72 Ready-Pak® Package [K4094-1]

- FLEXTEC® 500 [K4091-1]
- LF-72 Bench Model, Heavy Duty [K2327-7]
- Magnum® PRO Curve™ 400 Gun & Cable Assembly
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [310021]
- Inverter and Wire Feeder Cart [K3059-2]
- Flextec® 500/500P Locking Foot Kit

FLEXTEC® 500/LF-74 Ready-Pak® Package [K4094-1]

- FLEXTEC® 500 [K4091-1]
- LF-74 Bench Model, Heavy Duty [K2426-5]
- Magnum® PRO Curve™ 400 Gun & Cable Assembly
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit [310021]
- Inverter and Wire Feeder Cart [K3059-2]
- Flextec® 500/500P Locking Foot Kit



Shown:
Invertec® V350 PRO
Ready-Pak® Pkg.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

AlumaFab®⁽¹⁾

Air-Cooled One-Pak® Package [K4186-1]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/15 ft (4.5 m) Cable

Air-Cooled One-Pak® Package [K4186-3]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/35 ft (10.6 m) Cable

Air-Cooled One-Pak® Package [K4186-4]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/50 ft (15.2 m) Cable

Air-Cooled Ready-Pak® Package [K4186-2]

- AlumaFab Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft (7.6 m) Cable

Water-Cooled One-Pak® Package [K4187-1]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/15 ft (4.5 m) Cable

Water-Cooled One-Pak® Package [K4187-3]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/35 ft (10.6 m) Cable

Water-Cooled One-Pak® Package [K4187-4]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/50 ft (15.2 m) Cable

Water-Cooled Ready-Pak® Package [K4187-2]

- AlumaFab® Multi-Process Welder [K4189-1]
- Power Feed® 25M Semi-Automatic Wire Feeder [K4191-1]
- CoolArc® 55 Aluminum Water Cooler
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/25 ft (7.6 m) Cable



Shown:
AlumaFab® Water-Cooled
Ready-Pak® Pkg.

⁽¹⁾ AlumaFab Air-Cooled Ready-Pak and One-Paks Include: Drive Roll Kits, Diffusers, Nozzles, Tips, Liners, Work Lead Package, Base Mounting Assembly and Arclink® Control Cable.
Alumafab Water-Cooled Ready-Pak And One-Paks Include: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package, Base Mounting Assembly and Arclink® Control Cable.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

FLEXTEC® 500P

**FLEXTEC® 500P/Power Feed® 84
Ready-Pak® Pkg. (K4097-1)**

- FLEXTEC® 500P
- Power Feed® 84, Heavy Duty
- Magnum® PRO Curve™ 400 Gun and Cable Assembly
- Control Cable
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit (3100211)
- Inverter and Wire Feeder Cart
- Base Mounting Assembly

Arc Tracker™

Base Model (K3019-1)

- Detachable input cord 6 ft. (1.8 m) with NEMA 5-15P plug and an IEC 60320 plug receptacle.
- Polarity specific arc voltage remote sense leads 15 ft. (4.6 m) (Qty. 2)

FLEXTEC® 650

FLEXTEC® 650/LF-74 One-Pak® Pkg. (K3147-1)

- FLEXTEC® 650 (K3060-3)
- LF-74 Bench Model, Heavy Duty (K2426-7)
- Drive Roll and Guide Kit
- Magnum® PRO Curve™ 400 Gun
- Gun Connector Kit
- Gun Liner
- Weld Power Cable, 10 ft. (3.0 m)
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit (3100211)

FLEXTEC® 650/LF-74 Ready-Pak® Pkg. (K3146-1)

- Includes everything listed above (K3147-1)
- Inverter and Wire Feeder Cart

FLEXTEC® 650/LN-10 One-Pak® Pkg. (K3158-1)

- FLEXTEC® 650 (K3060-3)
- LN-10 Bench Model, Heavy Duty (K1559-3)
- Drive Roll and Guide Kit
- Magnum® PRO Curve™ 400 Gun
- Gun Connector Kit
- Gun Liner
- Weld Power Cable, 10 ft. (3.0 m)
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit (3100211)

FLEXTEC® 650/LF-72 Ready-Pak® Pkg. (K3145-1)

- FLEXTEC® 650 (K3060-3)
- LF-72 Bench Model, Heavy Duty (K2327-7)
 - Heavy Duty Wire Reel Stand
 - Drive Roll and Wire Guide Kit, 0.035-0.045 in. (0.9-1.1 mm)
 - Control Cable 10 ft. (3.0 m)
- Magnum® PRO Curve™ 400 Gun
- Inverter and Wire Feeder Cart
- 3/0 Welding Cable
- Work Lead Package
- Harris® Gas Regulator/Flowmeter and 10 ft. (3.0 m) Hose Kit (3100211)



Shown:
Inverter® FLEXTEC® 650/LF-74
Ready-Pak® Pkg.

Accessories

| Product Name | Product No. | Invertec® V350 PRO | | | | FLEXTEC® 350X | | Idealarc® DC400 | | FLEXTEC® 500 | Alumafab® | FLEXTEC® 500P | Idealarc® DL600 | | | FLEXTEC® 650 | Arc Tracker® | |
|---|----------------------|-------------------------|--------------------|-------------------------|--------------------------|---------------------|-------------------------|-------------------|-----------------------------------|--------------|------------|---------------|-----------------------------------|---------------------|---------------------|-------------------|--------------|------------|
| | | Base Model Construction | Base Model Factory | Base Model Adv. Process | Base Model Tweco Factory | Base Model Standard | Base Model Construction | Base Model w/IGFD | Base Model w/Multi-Process Switch | Base Model | Base Model | Base Model | Base Model w/Multi-Process Switch | Base Model w/Meters | Base Model w/Meters | Base Model w/VRD® | Base Model | Base Model |
| | | K1728-5 | K1728-6 | K1728-7 | K1728-13 | K4272-1 | K4271-1 | K1308-25 | K1308-12 | K4091-1 | K4189-1 | K4092-1 | K1288-18 | K1288-17 | K1288-22 | K1288-28 | K3060-3 | K3019-1 |
| GENERAL | | | | | | | | | | | | | | | | | | |
| Advanced Process Panel | K1763-1 | • | • | | | | | | | | | | | | | | | |
| Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m) | K586-1 | • | • | • | • | | | | | | | | | | | | • | |
| Work and Wire Feeder 2/0 Weld Cable Package, 10 ft. (3.0 m) | K1803-1 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable | K852-70 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable | K852-95 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable | K1759-70 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable | K1759-95 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ to Lug Cable Adapter | K2176-1 | • | • | • | • | | | | | | | | | | | | | |
| Tweco® Style Cam-Lock Adapter Plug | K2946-1 | • | • | • | • | | | | | | | | | | | | | |
| Inverter and Wire Feeder Cart | K1764-1 | • | • | • | • | | | | | | | | | | | | | |
| Inverter and Wire Feeder Cart ⁽¹⁾ | K3059-2 | | | | | • | • | | | • | • | • | | | | | • | |
| Dual Cylinder Inverter and Wire Feeder Cart ⁽¹⁾ | K3059-3 | | | | | | | | | • | • | • | | | | | • | |
| Dual Cylinder Mounting Kit | K1702-1 | • | • | • | • | | | | | | | | | | | | | |
| Undercarriage – Hand moving | K841 | | | | | | | • | • | | | | | | | | | |
| Undercarriage – Hand moving | K842 | | | | | | | | | | | • | • | • | • | | | |
| All-Terrain Undercarriage | K1737-1 | | | | | | | | | | | • | • | • | • | | | |
| Universal Adapter Plug ⁽²⁾ | K867 | • | • | • | • | | | | | | | | | | | | | |
| Work Lead Package | K2149-1 | | | | | | | • | • | • | • | • | • | • | • | • | • | • |
| Paralleling Kit (codes above 10500) ⁽³⁾ | K1611 ⁽²⁾ | | | | | | | | | | | • | • | • | | | | |
| Paralleling Kit (codes below 10500) ⁽³⁾ | K1897-1 | | | | | | | | | | | • | • | • | | | | |
| Arc Tracker™ | K3019-1 | • | • | • | • | | | • | • | • | • | • | • | • | • | • | • | • |
| Flextec® 350 Locking Foot Kit | K4424-1 | | | | | • | • | | | | | | | | | | | |
| Base Mounting Kit | K3056-1 | | | | | | | | | • | | • | | | | | | |
| Base Mounting Assembly | K3056-2 | | | | | | | | | • | • | • | | | | | | |
| Multi-Process Switch ⁽¹⁾ | K3091-1 | | | | | • | • | | | • | | • | | | | | • | |
| Multi-Process Switch | K804-1 | | | | | | | • | • | | | • | • | • | • | | | |
| Flextec CE Filter Kit (380-575V AC) | K4420-1 | | | | | • | • | | | | | | | | | | | |
| Flextec CE Filter Kit (380-575V AC) | K3975-1 | | | | | | | | | • | | • | | | | | | |
| Flextec CE Filter Kit (380-575V AC) | K3129-2 | | | | | | | | | | | | | | | | • | |
| Weld Fume Control System | — | • | • | • | • | | | • | • | • | • | • | • | • | • | • | • | • |

⁽¹⁾Requires K3056-1 Base Mounting Kit ⁽²⁾Made to order ⁽³⁾Cannot be used with VRD® models

• Optional

Accessories

| Product Name | Product No. | Invertec® V350 PRO | | | | FLEXTEC® 350X | | Idealarc® DC400 | | FLEXTEC® 500 | Alumafab® | FLEXTEC® 500P | Idealarc® DL600 | | | | FLEXTEC® 650 | Arc Tracter® |
|---|-------------|-------------------------|--------------------|-------------------------|-------------------------|---------------------|-------------------------|-------------------|-----------------------------------|--------------|------------|---------------|-----------------------------------|---------------------|---------------------|-------------------|--------------|--------------|
| | | Base Model Construction | Base Model Factory | Base Model Adv. Process | Base Model Twoo Factory | Base Model Standard | Base Model Construction | Base Model w/GFCI | Base Model w/Multi-Process Switch | Base Model | Base Model | Base Model | Base Model w/Multi-Process Switch | Base Model w/Meters | Base Model w/Meters | Base Model w/VRD® | Base Model | Base Model |
| | | K1728-5 | K1728-6 | K1728-7 | K1728-13 | K4272-1 | K4271-1 | K1308-25 | K1308-12 | K4091-1 | K4189-1 | K4092-1 | K1288-18 | K1288-17 | K1288-22 | K1288-28 | K3060-3 | K3019-1 |
| STICK | | | | | | | | | | | | | | | | | | |
| Accessory Kit, 400 Amp | K704 | • | • | • | • | | | • | • | | | | • | • | • | • | | |
| Remote Output Control, 25 ft. (7.6 m) | K857 | • | • | • | • | • | • | • | • | | | | • | • | • | • | • | |
| Remote Output Control, 100 ft. (30.5 m) | K857-1 | • | • | • | • | • | • | • | • | | | | • | • | • | • | • | |
| Remote Output Control, 25 ft. (7.6 m) | K857-2 | | | | | • | • | | | • | | • | | | | | • | |
| Remote Control Cable Adapter | K864 | • | • | • | • | | | • | • | | | | • | • | • | • | | |
| TIG | | | | | | | | | | | | | | | | | | |
| TIG Module | K930-2 | • | • | • | • | | | • | • | | | | • | • | • | • | | |
| Control Cable (9-pin to 14-pin) | K936-1 | • | • | • | • | | | • | • | | | | • | • | • | • | | |
| Control Cable (9-pin to 115V plug) | K936-4 | • | • | • | • | | | | | | | | | | | | | |
| 12-pin to 6-pin Adapter | K2909-1 | | | | | • | • | | | • | | • | | | | | | |
| Control Cable Extension, 45 ft. (13.7 m) | K937-45 | | | | | | | • | • | | | | • | • | • | • | | |
| Adapter Cable – Male 14-pin Control Cable to Terminal Strip | K1798 | | | | | | | • | • | | | | • | • | • | • | | |
| Remote Control Cable Adapter | K864 | | | | | | | • | • | | | | | | | | | |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | • | • | • | • | • | • | • | • | • | | • | • | • | • | • | • | • |
| Foot Amptrol™ with 6-pin Connector | K870 | • | • | • | • | • | • | • | • | • | | • | • | • | • | • | • | • |
| Foot Amptrol™ with 12-pin Connector | K870-2 | | | | | | | | | • | | | | | | | | |
| Wireless Foot Pedal | K4217-1 | | | | | • | • | | | • | | | | | | | • | |
| Amptrol™ Adapter Kit | K843(1) | | | | | | | • | • | | | | • | • | • | • | | |
| Arc Start™ Switch | K814 | • | • | • | • | | | | | | | | | | | | • | |
| Invertec® TIG Solenoid Kit | K1762-2 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Torch Adapter, PTA-9, -17 | K1622-1 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Torch Adapter, PTA-26 | K1622-3 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Torch Adapter, Water-Cooled | K1622-4 | • | • | • | • | | | | | | | | | | | | | |
| Twist Mate™ Torch Adapter (with separate gas) | K960-1 | • | • | • | • | | | | | | | | | | | | | |
| TIG-Mate™ 17V TIG Torch Starter Kit (air-cooled) | K2265-1 | • | • | • | • | | | | | | | | | | | | | |
| TIG-Mate™ 17 TIG Torch Starter Kit (air-cooled) | K2266-1 | • | • | • | • | | | | | | | | | | | | | |
| TIG-Mate™ 20 TIG Torch Starter Kit (water-cooled) | K2267-1 | • | • | • | • | | | | | | | | | | | | | |
| Docking Kit | K939-1 | | | | | | | • | • | | | • | • | • | • | • | | |
| Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.2 m) | K586-1 | | | | | | | • | • | | | • | • | • | • | • | | |
| MIG | | | | | | | | | | | | | | | | | | |
| Magnum® PRO AL G225A Push/Pull Air-Cooled Push-Pull Gun, 12 pin, 25 ft. (7.6 m) | K3355-2 | | | | | | | | | | • | | | | | | | |
| Magnum® PRO AL G450W Push/Pull Water-Cooled Push-Pull Gun, 12 pin, 25 ft. (7.6 m) | K3357-2 | | | | | | | | | | • | | | | | | | |

• Optional

Accessories

| Product Name | Product No. | Invertec® V350 PRO | | FLEXTEC® 350X | | Idealarc® DC400 | | FLEXTEC® 500 | | AlumaFab® | | FLEXTEC® 500P | | Idealarc® DC600 | | FLEXTEC® 650 | | Arc Tracter® | | |
|--|-------------|-------------------------|--------------------|-------------------------|--------------------------|---------------------|-------------------------|-------------------|-----------------------------------|------------|------------|---------------|-----------------------------------|---------------------|---------------------|-------------------|------------|--------------|------------|------------|
| | | Base Model Construction | Base Model Factory | Base Model Adv. Process | Base Model Tweco Factory | Base Model Standard | Base Model Construction | Base Model w/GFCI | Base Model w/Multi-Process Switch | Base Model | Base Model | Base Model | Base Model w/Multi-Process Switch | Base Model w/Meters | Base Model w/Meters | Base Model w/VRD® | Base Model | Base Model | Base Model | Base Model |
| | | K1728-5 | K1728-6 | K1728-7 | K1728-13 | K4272-1 | K4271-1 | K1308-25 | K1308-12 | K4091-1 | K4189-1 | K4092-1 | K1288-18 | K1288-17 | K1288-22 | K1288-28 | K3060-3 | K3019-1 | | |
| WIRE FEEDERS | | | | | | | | | | | | | | | | | | | | |
| Flex Feed™ 74 HT, FlexFeed™ 84, LF-72, LF-74, LN-10, DH-10, LN-25 PRO, LN-25 PRO Dual Power, LN-25 Pipe, Activ8™ | — | • | • | • | • | • | • | • | • | • | | • | • | • | • | • | • | • | • | • |
| LN-8, LN-9 | — | | | | | | | • | • | | | • | • | • | • | • | • | • | • | • |
| NA Series | — | | | | | | | | | | | | | | | | | • | • | |
| LT-7 | — | | | | | | | | | | | • | • | • | • | • | • | • | • | • |
| LN-25X | — | | | | | • | • | | | | | | | | | | | | | |
| LN-23P | — | | | | | | | • | • | • | | • | | | | | | • | • | |
| Power Feed® 84, Power Feed® 25M | — | | | | | | | | | | | • | | | | | | | | |
| Power Feed® 25M Aluminum | — | | | | | | | | | | • | | | | | | | | | |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | | | | | | | | |
| Invertec® V350-PRO | X1728 | • | • | • | • | | | | | | | | | | | | | | | |
| FLEXTEC® 350X | X4272 | | | | | • | • | | | | | | | | | | | | | |
| Idealarc® DC400 | X1308 | | | | | | | • | • | | | | | | | | | | | |
| FLEXTEC® 500 | X4091 | | | | | | | | | • | | | | | | | | | | |
| AlumaFab® | X4189 | | | | | | | | | | • | | | | | | | | | |
| FLEXTEC® 500P | X4092 | | | | | | | | | | | • | | | | | | | | |
| Idealarc® DC600 | X1288 | | | | | | | | | | | • | • | • | • | | | | | |
| FLEXTEC® 650 | X3060 | | | | | | | | | | | | | | | | • | | | |

• Optional

ADVANCED PROCESS WELDERS

| MODEL | OUTPUT | | | PROCESS | | | | | | | | | INPUT | | FEATURES | | | |
|------------------------------------|--------|----------|----------------------------|---------|-----|-----------|-----|----------|-------------|--------|--------|------------|-----------|-------|----------|-----------------------------|--------------------------------|---------------------|
| | Mode | Polarity | Current Range (Amps) | Stick | TIG | AC/DC TIG | MIG | MIG STT® | Tandem MIG® | AC MIG | Pulsed | Flux-Cored | Arc Gouge | Phase | Hertz | Waveform Control Technology | ArkLink® Digital Communication | Inverter Efficiency |
| STT® PROCESS | | | | | | | | | | | | | | | | | | |
| Invertec® STT® II | STT® | DC | 0-450 PEAK 0-125 BKGRND | | | | | ● | | | | | | 3 | 50/60 | ● | | ● |
| Power Wave® Advanced Module | CC/CV | AC/DC | NA | | | ● | ● | | ● | | | | | NA | NA | | | |
| Power Wave® STT® Module | STT® | DC | NA | | | | | ● | | | | | | NA | NA | ● | ● | ● |
| MULTI-PROCESS POWER WAVE® | | | | | | | | | | | | | | | | | | |
| Power Wave® C300 | CC/CV | DC | 5-300 | ● | ● | | ● | | | | ● | ● | | 1,3 | 50/60 | ● | ● | ● |
| Power Wave® S350 | CC/CV | DC | 5-350 | ● | ● | | ● | ○ | | | ● | ● | ● | 1,3 | 50/60 | ● | ● | ● |
| Power Wave® S500 | CC/CV | DC | 5-550 | ● | ● | | ● | ○ | ● | | ● | ● | ● | 1,3 | 50/60 | ● | ● | ● |
| Power Wave® S700 | CC/CV | DC | 20-900 | ● | ● | | ● | | ○ | | ● | ● | ● | 3 | 50/60 | ● | ● | ● |

Invertec® STT® II

Excellent Penetration, Higher Productivity

- Minimal spatter; can replace TIG welding in the root pass
- Controlled low heat input results in reduced distortion on thin materials
- Tremendous shielding gas flexibility (either low-cost 100 % CO₂ or Argon/CO₂ blends)



Processes
 · MIG-STT*

Output

Input

Literature
 E4.52

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|---|--|------------------------------|--|---|-----------------|
| Invertec® STT® II | K1525-1 | 208/230/460/3/60 | 225A/29V/60% 200A/28V/100% | 32/30/16A | CURRENT Peak: 0-450A Background: 0-125A Max OCV: 85V | 23.2 x 13.2 x 24.4 (589 x 336 x 620) | 117 (53) |
| | K1526-1 | 200-208/220-230/ 380-415/440-460/3/50/60 | | 33/30/15/17/16A | | | |
| | K1526-2 | 200/208/380/400/ 415/3/50/60 | | 36/34/20/19/18A | | | |

Power Wave® C300

Power and Wire Combined

- Welding output remains constant throughout the entire input voltage range
- CheckPoint™ technology enables you to track usage, store weld data, configure fault limits and more
- Ideal for educational settings and light to medium fabrication shops



Processes
 · Stick
 · DC TIG
 · Pulsed DC TIG
 · MIG
 · Pulsed MIG
 · Flux-Cored

Output

Input

Literature
 E5.100

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|--|--|---|---|---------------------------------------|-----------------|
| Power Wave® C300 ⁽¹⁾ Base Model | K2675-2 | 3-Ph 50/60: 208/220-230/380/415/460/575 | 300A/29V/40% 250/27V/100% | 3-Ph/40% Duty Cycle: 30/28/16/14/11A | 5-300A DC | 18.8 x 14 x 24.8 (478 x 356 x 630) | 100 (47.6) |
| Steel Ready-Pak® Pkg. | K2774-2 | 1-Ph 50/60: 208/220-230 | | 1-Ph/40% Duty Cycle: 53/48/29A | WFS: 50-700 ipm (1.27-17.8 m/min) | 33 x 20 x 42 (838 x 508 x 1067) | 180 (81.6) |
| Educational Ready-Pak® Pkg. | K2774-4 | | | | | | |

⁽¹⁾Wire Size Range, in.(mm) : Solid - 0.023-0.045 [0.6-1.2] ; Cored - 0.035-0.045 [0.9-1.2]

Power Wave® S350

Portable, Versatile, Powerful

- Equipped with a complete portfolio of high-performance wave forms, providing flexibility to tackle any welding application
- Comes standard with Power Wave Manager software tools, simplifying welding setup and operation
- CheckPoint™ production monitoring software allows you to track equipment usage, store weld data, configure fault limits and more
- Compact and durable case is IP23-rated to withstand harsh environments



- Processes**
- Stick
 - DC TIG
 - Pulsed DC TIG
 - MIG
 - Pulsed MIG
 - Flux-Cored



Literature
E5.110

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|-----------------------------------|--|--|-----------------------|---|-----------------|
| Power Wave® S350 Base Model | K2823-3 | 208/230/380-415/460/575/1/3/50/60 | GMAW: 350A/31.5V/40% ⁽¹⁾ 300A/29V/100% | 3-Ph/40% Duty Cycle: 39/35/19/17/14A | 5-350A ⁽³⁾ | 20.40 x 14 x 24.80 (518 x 356 x 630) | 85 (38.6) |
| Ready-Pak® Pkg. (Steel) | K3005-3 | | SMAW: 325A/33V/40% ⁽¹⁾ 250A/30V/100% | 3-Ph/100% Duty Cycle: 31/28/15/14/11A | | 52 x 39 x 26 (1321 x 991 x 660) | 450 (204.1) |
| | | | GTAW-DC: 350A/24V/40% 300A/22V/100% | 1-Ph/40% Duty Cycle: 60/67 ⁽²⁾ /na/na/na | | | |
| | | | | 1-Ph/100% Duty Cycle: 60/53/na/na/na | | | |

⁽¹⁾230 Volt/1 Phase inputs, the peak rating is at 30% duty cycle, except for GTAW. ⁽²⁾Based on the U.S. National Electrical Code. ⁽³⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

Power Wave® S350 Aluminum

Connectivity Enabled

- Power Wave software options allow for collection of productivity metrics, weld quality and reporting
- Access advanced processes such as Pulse-on-Pulse® and Power Mode® to customize the aluminum welding experience for your application



- Processes**
- Aluminum Only
 - MIG
 - Pulsed MIG
 - CC Pulse
 - Pulse-on-Pulse



Literature
E5.93b

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|--|-----------------------------------|--|--|-----------------------|---|-----------------|
| Power Wave® S350 Aluminum Base Model | K4188-1 | 208/230/380-415/460/575/1/3/50/60 | GMAW: 350A/31.5V/40% ⁽¹⁾ 300A/29V/100% | 3-Ph/40% Duty Cycle: 39/35/19/17/14A | 5-350A ⁽³⁾ | 20.40 x 14 x 24.80 (518 x 356 x 630) | 85 (38.6) |
| Air-Cooled One-Pak® Package | K4184-1 K4184-3 K4184-4 | | SMAW: 325A/33V/40% ⁽¹⁾ 250A/30V/100% | 3-Ph/100% Duty Cycle: 31/28/15/14/11A | | 52 x 39 x 26 (1321 x 991 x 660) | |
| Air-Cooled One-Pak® Package with Advanced Module Aluminum | K4184-5 | | GTAW-DC: 350A/24V/40% 300A/22V/100% | 1-Ph/40% Duty Cycle: 60/67 ⁽²⁾ /na/na/na | | | |
| Air-Cooled Ready-Pak® Package | K4184-2 | | | 1-Ph/100% Duty Cycle: 60/53/na/na/na | | | 450 (204.1) |
| Water-Cooled One-Pak® Package | K4185-1 K4185-2 K4185-3 K4185-4 | | | | | | |

⁽¹⁾230 Volt/1 Phase inputs, the peak rating is at 30% duty cycle, except for GTAW. ⁽²⁾Based on the U.S. National Electrical Code. ⁽³⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

Power Wave® S500

Multi-Process Power and Versatility

- Equipped with a complete portfolio of high-performance wave forms, providing flexibility to tackle any welding application
- Comes standard with Power Wave Manager™ software tools, simplifying welding setup and operation
- CheckPoint™ production monitoring software allows you to track equipment usage, store weld data, configure fault limits and more
- Compact and durable case is IP23-rated to withstand harsh environments



Processes

- Stick
- DC TIG
- Pulsed DC TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E5.115

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|-------------------------------------|--|--|--------------|---|-----------------|
| Power Wave® S500 Base Model | K2904-2 | 208/230/380-415/ 460/575/3/50/60 | GMAW: 550A/41.5V/40% 450A/36.5V/100% | 3-Ph/40% Duty Cycle: 81/73/41/37/29A | 5-550A | 22.5 x 14 x 24.8 (571 x 355 x 630) | 150 (68) |
| w/Power Feed® 84 Ready-Pak® Pkg. | K3187-2 | | SMAW: 550A/42V/40% 450A/38V/100% | 3-Ph/100% Duty Cycle: 60/54/31/27/21A | | 51.7 x 34.4 x 53.4 (1313 x 874 x 1356) | 376 (171) |
| w/Power Feed® 84 One-Pak® Pkg. | K3186-2 | | GTAW-DC: 550A/32V/40% 450A/38V/100% | | | — | — |

Power Wave® S700

High Output Power for Automated Environments

- Intended for high amperage, high duty cycle semiautomatic, mechanized or robotic applications in the heavy equipment, transportation and other industries
- Add AutoDrive® 19 Tandem modules to access waveform modes specifically designed for Synchronized Tandem MIG
- True Energy™ capability provides easy, accurate heat input calculations



Processes

- Stick
- TIG
- MIG
- Pulsed MIG
- Flux-Cored
- Tandem MIG*
- Carbon Arc Gouging

Output



Input



Literature

E5.120

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------|------------------------|-------------------------------------|--|--------------------------------|--------------|---|-----------------|
| Power Wave® S700 | K3279-1 ⁽¹⁾ | 380-415/440-460/500/ 575/3/50/60 | 700/44/100% (900A/44/60%) | 55/46/42/38A (74/60/56/49A) | 20-900A | 30.1 x 19.1 x 36.7 (765 x 485 x 932) | 385 (175) |

⁽¹⁾Internal filter is required to meet CE conducted emission requirements. K2444-4 CE Filter must be used with K3279-1.

Power Wave® STT® Module

Add STT® for Exceptional Arc Control

- Add STT® (Surface Tension Transfer®) process capability to any S-Series Power Wave for enhanced puddle and burnthrough control
- Hi-frequency starting for TIG welding capability
- Improve performance on thin metal or critical pipe root pass welding applications
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models



Processes

- GMAW-STT®

Output



Input



Literature

E5.190

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------|------------------------|---------------------------------|--|------------------------------|--------------|---------------------------------------|-----------------|
| Power Wave® STT® Module | K2902-2 US/Int'l Model | 40V DC | 100% Duty Cycle ⁽¹⁾ : 450A | n/a | n/a | 11.5 x 14 x 24.8 (292 x 356 x 630) | 47 (21.3) |
| | K2921-1 CE Model | | 60% Duty Cycle ⁽¹⁾ : 500A 40% Duty Cycle ⁽¹⁾ : 550A Peak (Max) ⁽¹⁾ : 750A | | | | |

⁽¹⁾Dependent on host welding power source output.

Power Wave® Advanced Module

Expand Your Welding Capabilities

- Adds AC waveform control for Pulsed MIG, and Gas Tungsten Arc (TIG) Welding
- Hi-frequency starting for TIG welding capability
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models
- Includes STT process capability, making this module ideal for automotive, pipe and thin metal applications



Processes

- GMAW-STT®
- SMAW
- GMAW
- GMAW-P
- GTAW

Output



Input



Literature

E5.191

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|---------------------------------|---|------------------------------|--------------|-------------------------------------|-----------------|
| Power Wave® Advanced Module | K2912-2 | 40V DC | 100% Duty Cycle ⁽¹⁾ : 300A @ 32V 40% Duty Cycle ⁽¹⁾ : 350A @ 34V Peak (Max) ⁽¹⁾ : 600A | n/a | n/a | 11.5 x 14 x 25 (292 x 356 x 635) | 70.5 (32) |

⁽¹⁾Host welding power source will be limited to these outputs.

Power Wave® Advanced Module Aluminum

Expand Your Welding Capabilities

- Adds AC Pulsed MIG and AC TIG with hi-frequency starting for Aluminum
- Modular design allows easy connection and fast digital communication with compatible Power Wave® models



Processes

- GMAW
- GMAW-P
- GTAW

Output



Input



Literature

E5.191

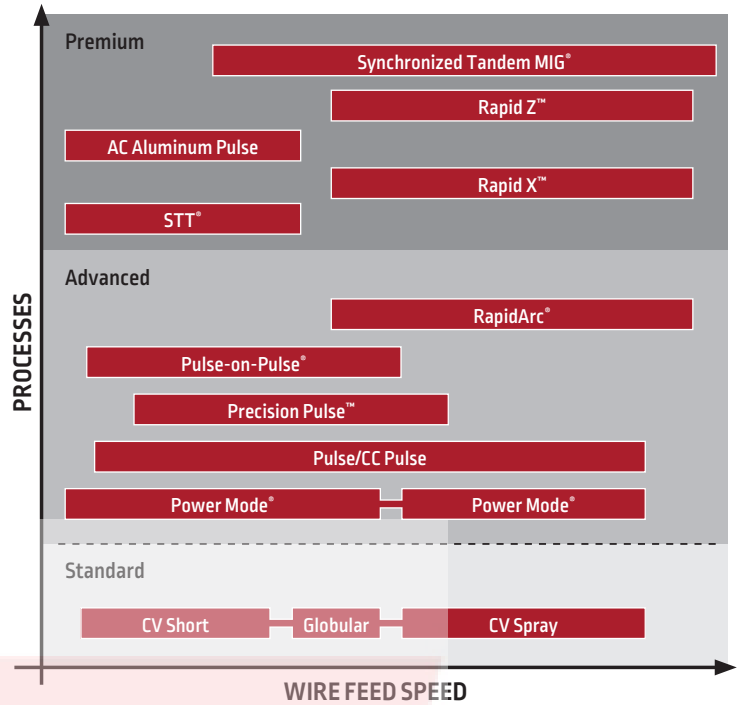
| Product Name | Product Number | Input Power Voltage/Phase/Hz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|------------------------------|---|------------------------------|--------------|-------------------------------------|-----------------|
| Power Wave® Advanced Module Aluminum | K4192-1 | 40V DC | 100% Duty Cycle ⁽¹⁾ : 300A @ 32V 40% Duty Cycle ⁽¹⁾ : 350A @ 34V Peak (Max) ⁽¹⁾ : 600A | n/a | n/a | 11.5 x 14 x 25 (292 x 356 x 635) | 70.5 (32) |

⁽¹⁾Host welding power source will be limited to these outputs.



LINCOLN ELECTRIC Advanced MIG (GMAW) Processes

Your local Lincoln Electric distributor and Lincoln Electric Technical Sales Representative, backed by our Applications Engineering Department, can help you select the advanced process and equipment that can improve your results. Request a demo to see how we can help reduce costs, enhance quality or increase productivity in your operations.



| | | | |
|--------------------------------------|--|--|--|
| Synchronized Tandem MIG [®] | Steel » Synchronized Tandem MIG [®] overcomes deposition rate limitations of a single wire by using two wires and specific waveforms. The result is deposition rates nearly double rates possible with a single wire as well as faster travel speeds. | Power Wave [®] S700 Power Wave [®] S500 Power Wave [®] S350 | Power Wave [®] R500 Power Wave [®] R350 |
| Rapid Z™ | Zinc » Rapid Z™ is a process designed to increase stability and travel speeds, while reducing spatter and internal porosity on Zinc coated materials. | Power Wave [®] S500 w/Advanced Module Power Wave [®] S350 w/Advanced Module Power Wave [®] R500 w/Advanced Module Power Wave [®] R350 w/Advanced Module | |
| AC Aluminum Pulse | Aluminum » With the help of the Power Wave [®] Advanced Module, GMAW aluminum welding results can be improved over traditional DC positive aluminum MIG welding. By switching the polarity of the arc, heat input is reduced and deposition rates are enhanced. | Power Wave [®] S500 w/Advanced Module Power Wave [®] S350 w/Advanced Module Power Wave [®] S350 Aluminum with Advanced Module Aluminum | |
| Rapid X™ | Steel & Stainless » Rapid X™ is a premium MIG pulse mode designed to deliver higher travels speeds and extremely low spatter levels with a short arc length. | Power Wave [®] S500 w/STT [®] Module Power Wave [®] S350 w/STT [®] Module Power Wave [®] R500 w/STT [®] Module Power Wave [®] R350 w/STT [®] Module | |
| STT [®] | Steel, Stainless & High Nickel » This precision MIG mode delivers premium and consistent root pass results on pipe with low reject rates and excellent gap bridging capabilities. STT [®] can also be used to reduce spatter and control heat input on sheet metal applications. | Power Wave [®] S350 w/Digital STT [®] Power Wave [®] R350 w/Digital STT [®] Invertec [®] STT [®] II Power Wave [®] 455M/STT [®] | |
| RapidArc [®] | Steel & Stainless » RapidArc [®] is an accelerated MIG pulse mode with a short arc length compared to pulse and CV-spray for high travel speed applications. | Power Wave [®] C300 Power Wave [®] S700 | |
| Pulse-on-Pulse [®] | Aluminum » This arc modulation MIG pulse mode can deliver a TIG (GTAW)-like bead appearance. | Power Wave [®] S500 Power Wave [®] S350 | |
| Precision Pulse™ | Steel & Stainless » This enhanced MIG pulse mode features a tight, focused arc for fast vertical up welding and outstanding out-of-position puddle control. | Power Wave [®] S350 Aluminum Power Wave [®] R500 | |
| Pulse | Steel, Stainless, Aluminum & more » Traditional MIG pulse mode uses a pulse for the metal transfer, which avoids a short and allows for a wide operating range, characterized by low to high wire feed speed, many different materials and virtually no spatter. | Power Wave [®] R350 Power Wave [®] 455M Power Wave [®] i400 | |
| Power Mode [®] | Steel, Stainless & Aluminum » This enhanced MIG mode can deliver excellent arc stability with reduced spatter at high travels speeds, resulting from an extended short arc range at higher wire feed speed procedures. It also yields a tight and stable arc in spray transfer. | | |
| CV | Steel, Stainless & Aluminum » CV is the conventional mode for MIG welding. This general purpose MIG welding mode uses constant voltage for short arc, globular and spray transfer. | Any CV MIG-Ready Power Source | |

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Invertec® STT® II

Base Models [K1525-1, K1526-1, K1526-2]

- STT® II Sense Lead Kit, 25 ft. (7.6 m)

Power Wave® C300

Base Model [K2675-2]

- Drive Roll Kit, 0.035/0.045 in. (0.9/1.2 mm)
- Input Cord, 10 ft. (3.0 m)
- Work Lead & Clamp, 10 ft. (3.0 m)

Steel Ready-Pak® Package [K2774-2]

- Everything listed above for Base Model
- Power Wave® C300 Undercarriage
- Magnum® PRO Curve™ 300 Gun Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)

Educational Ready-Pak® Package [K2774-4]

- Everything listed above [K2774-2]
- TIG Torch Twist Mate™ to Stud Adapter Cable with 2 ft. (0.61 m) Gas Hose
- PTA-17 Pro-Torch™ TIG Torch
- Twist Mate™ Torch Adapter
- Parts Kits for PTA-17 Series Torches
- Foot Amptrol™
- Stick Electrode Holder and Cable

Power Wave® S350

Base Model [K2823-3]

- Input Power Cord, 10 ft. (3.0 m)

Steel Ready-Pak® Package [K3005-3]

- Power Wave® S350 [K2823-3]
- Power Feed® 84 Bench Model [K4164-1]
- 0.035 in. (0.9 mm) and 0.040-0.045 in. (1.0-1.1 mm) Drive Roll & Wire Guide Kits
- Magnum® PRO Curve™ 400 Gun Pkg., 15 ft. (4.5 m)
- Work & Wire Feeder Power Cables Pkg.
- Inverter and Wire Feeder Cart
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)

Power Wave® S350 Aluminum⁽¹⁾

Air-Cooled One-Pak® Package [K4184-1]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/15 ft. (4.5 m) Cable

Air-Cooled One-Pak® Package [K4184-3]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/35 ft. (10.6 m) Cable

Air-Cooled One-Pak® Package [K4184-4]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/50 ft. (15.2 m) Cable

Air-Cooled One-Pak® Package [K4184-5]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft. (7.6 m) Cable
- Power Wave Advanced Module Aluminum [K4192-1]

Water-Cooled One-Pak® Package [K4185-1]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/15 ft. (4.5 m) Cable

Water-Cooled One-Pak® Package [K4185-2]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/25 ft. (7.6 m) Cable



Shown:
Power Wave® C300
Educational Ready-Pak® Pkg.



Shown:
Power Wave® S350 Aluminum
Ready-Pak® Pkg.

⁽¹⁾Power Wave S350 Aluminum Air-Cooled Ready-Pak and One-Paks include the following accessories:

Drive Roll Kits, Diffusers, Nozzles, Tips, Liners, Work Lead Package. (K4184-5 Advanced Module One-Pak also includes: Foot Pedal, TIG Torch and TIG Kit).

Power Wave S350 Aluminum Water-Cooled One-Paks include the following accessories: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Power Wave® S350 Aluminum⁽¹⁾, con't.

Water-Cooled One-Pak® Package [K4185-3]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/35 ft. (10.6 m) Cable

Water-Cooled One-Pak® Package [K4185-4]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Cool Arc® 55 Water Cooler Aluminum
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G450W Push/Pull Water-Cooled Gun w/50 ft. (15.2 m) Cable

Air-Cooled Ready-Pak® Package [K4184-2]

- Power Wave® S350 Aluminum [K4188-1]
- Power Feed® 25M [K4191-1]
- Inverter and Wire Feeder Cart
- Magnum® PRO AL G225A Push/Pull Air-Cooled Gun w/25 ft. (7.6 m) Cable

Power Wave® S500

Power Feed® 84 One-Pak® Package [K3186-2]

- Power Wave® S500 [K2904-2]
- Power Feed® 84 Bench Model [K4164-1]
- Magnum® PRO Curve 400 Gun Pkg., 15 ft. (4.5 m)
- 0.040-0.045 (1.0-1.1 mm) Drive Roll & Wire Guide Kit
- Work Lead Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)

Power Feed® 84 Ready-Pak® Package [K3187-2]

- Everything listed above [K3186-2]
- Inverter & Wire Feeder Cart

Power Wave® STT® Module

U.S./International Base Model [K2902-2]

- Power Source Output Pigtail Adapter Cable [Tweco®-style]
- Remote Voltage Sense Lead, 25 ft. (3.7 m)

Power Wave® Advanced Module

Base Model [K2912-2]

- Power Source Output Pigtail Adapter Cable [Tweco®-style]
- 25 ft. (7.6 m) Remote Voltage Sense Lead
- ArcLink® Output Receptacle
- Differential Input and Output [Sync Tandem Output]
- Shielding Gas Input

Power Wave® Advanced Module Aluminum

Base Model [K4192-1]

- Power Source Output Pigtail Adapter Cable [Tweco®-style]
- 25 ft. (7.6 m) Remote Voltage Sense Lead
- ArcLink® Output Receptacle
- Differential Input and Output [Sync Tandem Output]
- Shielding Gas Input

⁽¹⁾Power Wave S350 Aluminum Air-Cooled Ready-Pak and One-Paks include the following accessories:

Drive Roll Kits, Diffusors, Nozzles, Tips, Liners, Work Lead Package. [K4184-5 Advanced Module One-Pak also includes: Foot Pedal, TIG Torch and TIG Kit].

Power Wave S350 Aluminum Water-Cooled One-Paks include the following accessories: Drive Roll Kits, Coolant, Tips, Liners, Work Lead Package.

Accessories

| Product Name | Product No. | Invertec STT® II | Power Wave® C300 | Power Wave® S350 | Power Wave® S350 Aluminum | Power Wave® S500 | Power Wave® S700 |
|---|-------------|------------------|------------------|------------------|---------------------------|------------------|------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| | | K2629-1 | K2675-2 | K2823-3 | K4188-1 | K2904-2 | K3297-1 |
| GENERAL | | | | | | | |
| Canvas Cover | K2378-1 | | • | | | | |
| Understorage Cart | K2734-2 | | • | | | | |
| Inverter and Wire Feeder Cart | K1764-1 | • | | | | | |
| Inverter and Wire Feeder Cart | K3059-2 | | | • | • | • | |
| Dual Cylinder Inverter and Wire Feeder Cart | K3059-3 | | | • | | • | |
| 12-pin to 6-pin Adapter Cable | K2909-1 | | • | • | | • | |
| 12-pin to 7-pin Adapter Cable | K2910-1 | | • | | | | |
| Cool Arc® 40 Water Cooler 115/150/60 | K1813-1 | | | | | | |
| Cool Arc® 55 | K3086-1 | | | • | | • | • |
| Cool Arc® 55 S | K3086-2 | | | • | | • | • |
| Cool Arc® 55 Aluminum | K4190-1 | | | | • | | |
| S-Series User Interface Kit | K3001-2 | | | • | | • | |
| Power Wave® STT® Module | K2902-2 | | | • | | • | |
| 115V Auxiliary Power Kit | K2829-1 | | | • | | | |
| DeviceNet™ Kit | K2827-1 | | | • | | • | |
| CE Filter | K2444-4 | | | | | | • |
| Tweco®-Style Adapter Plug | K2946-1 | | | • | | | |
| Sense Lead Kit, 25 ft. (7.6 m) | K940-25 | • | • | • | • | • | • |
| Sense Lead Kit, 75 ft. (22.9 m) | K940-75 | • | • | • | • | • | • |
| Heavy Duty Process Sense Lead, 50 ft. (15.2 m) | K1811-50 | • | | • | • | • | • |
| Heavy Duty Process Sense Lead, 100 ft. (30.5 m) | K1811-100 | • | | • | • | • | • |
| Work Lead Package | K2149-1 | | | | | • | • |
| Coaxial Weld Power Cable (350A), 25 ft. (7.6 m) | K1796-25 | • | | | | • | • |
| Coaxial Weld Power Cable (350A), 50 ft. (15.2 m) | K1796-50 | • | | | | • | • |
| Coaxial Weld Power Cable (300A), 75 ft. (22.9 m) | K1796-75 | • | | | | • | • |
| Coaxial Weld Power Cable (300A), 100 ft. (30.5 m) | K1796-100 | • | | | | • | • |
| Coaxial Weld Power Cable (#1, Lug to Lug), 100 ft. (30.5 m) | K2593-100 | • | | | | • | • |
| Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm² cable | K852-70 | • | | | | | |
| Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm² cable | K852-95 | • | | | | | |
| Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm² cable | K1759-70 | • | | | | | |
| Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm² cable | K1759-95 | • | | | | | |
| Twist Mate™ to Lug Cable Adapter | K2176-1 | • | | | | | |
| Weld Fume Control System | — | • | • | • | • | • | • |

• Optional

Accessories

| Product Name | Product No. | Invertec STT® II | Power Wave® C300 | Power Wave® S350 | Power Wave® S350 Aluminum | Power Wave® S500 | Power Wave® S700 |
|--|--------------|------------------|------------------|------------------|---------------------------|------------------|------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| | | K2629-1 | K2675-2 | K2823-3 | K4188-1 | K2904-2 | K3297-1 |
| STICK | | | | | | | |
| TIG Torches, see E.12.150 or Guns and Torches section pg. 147-163 | - | | • | | | | |
| Foot Amptrol™ 12-pin | K870-2 | | • | • | • | • | |
| Hand Amptrol™ 12-pin | K963-4 | | • | • | | • | |
| TIG Torch Twist Mate™ to Stud Adapter Cable, 2 ft. (0.61 m) Gas Hose | K2505-3 | | • | | | | |
| Twist-Mate™ Torch Adapter, Water-Cooled | K1622-4 | | | | | | |
| Tweco® Air-Cooled Adapter | K1622-6 | | | • | | | |
| Tweco®-Style Cam Lock Adapter, 26 Series Torches | K960-3 | | | • | | | |
| Tweco®-Style Cam Lock Adapter, 17 Series Torches | K960-4 | | | • | | | |
| WIRE FEEDER | | | | | | | |
| Fast-Mate™ Adapter | K489-8 | | • | | | | |
| Drive Roll Kit 0.035 in. (0.9 mm) Aluminum | KP1695-035A | | • | | | | |
| Drive Roll Kit 3/64 in. (1.2 mm) Aluminum | KP1695-3/64A | | • | | | | |
| Power Feed® 25M, Power Feed® 84 | - | | | • | | • | • |
| Power Feed® 25M Aluminum, Power Wave® Advanced Module Aluminum | - | | | | • | | |
| LN-25 PRO Dual Power | - | • | | | | | |
| Work and Wire Feeder Weld Cable Package with Tweco®-Style Plugs | K1803-2 | | | • | • | | |
| AutoDrive® 19 Controller | K3004-2 | | | • | | • | • |
| AutoDrive® 19 Tandem Controller | K3171-1 | | | | | • | • |
| AutoDrive® SA | K4129-1 | | | • | • | • | • |
| Power Wave® STT® Module (US/International) | K2902-2 | | | • | | • | |
| Power Wave® STT® Module (CE) | K2921-1 | | | • | | • | |
| Power Wave® Advanced Module | K2912-2 | | | • | | • | |
| Power Wave® Advanced Module Aluminum | K4192-1 | | | • | • | | |
| Water Cooler Hoses (CGA to CGA) | K1859-2 | | • | • | • | • | • |
| Water Connection Kit | K590-6 | | | | | | • |

• Optional

Accessories

| Product Name | Product No. | Invertec STT® II | Power Wave® C300 | Power Wave® S350 | Power Wave® S350 Aluminum | Power Wave® S500 | Power Wave® S700 |
|--|-------------|------------------|------------------|------------------|---------------------------|------------------|------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| | | K2629-1 | K2675-2 | K2823-3 | K4188-1 | K2904-2 | K3297-1 |
| MIG | | | | | | | |
| Magnum® PRO AL G225A Air-Cooled Push-Pull Guns | | | | | | | |
| 12-pin, 15 ft. (4.5 m) | K3355-1 | | • | • | | • | |
| 12-pin, 25 ft. (7.6 m) | K3355-2 | | • | • | • | • | |
| 12-pin, 35 ft. (10.6 m) | K3355-3 | | • | • | | • | |
| 12-pin, 50 ft. (15.2 m) | K3355-4 | | • | • | | • | |
| 7-pin, 15 ft. (4.5 m) | K3356-1 | | • | • | | • | |
| 7-pin, 25 ft. (7.6 m) | K3356-2 | | • | • | | • | |
| 7-pin, 35 ft. (10.6 m) | K3356-3 | | • | • | | • | |
| 7-pin, 50 ft. (15.2 m) | K3356-4 | | • | • | | • | |
| Magnum® PRO AL G450W Water-Cooled Push-Pull Guns | | | | | | | |
| 12-pin, 15 ft. (4.5 m) | K3357-1 | | | • | | • | • |
| 12-pin, 25 ft. (7.6 m) | K3357-2 | | | • | • | • | • |
| 12-pin, 35 ft. (10.6 m) | K3357-3 | | | • | | • | • |
| 12-pin, 50 ft. (15.2 m) | K3357-4 | | | • | | • | • |
| 7-pin, 15 ft. (4.5 m) | K3358-1 | | • | | | | |
| 7-pin, 25 ft. (7.6 m) | K3358-2 | | • | | | | |
| 7-pin, 35 ft. (10.6 m) | K3358-3 | | • | | | | |
| 7-pin, 50 ft. (15.2 m) | K3358-4 | | • | | | | |
| Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 25 ft. (7.6 m) | K2704-2 | | • | | | | |
| Cougar™ Air-Cooled Push-Pull Gun, 7-pin, 50 ft. (15.2 m) | K2704-3 | | • | | | | |
| SPOOL GUN | | | | | | | |
| Magnum® 250LX™ Spool Gun | K2490-1 | | • | | | | |
| Magnum® 250LX™ Spool Gun Control Cable Extension, 25 ft. (7.6 m) | K2519-1 | | • | | | | |
| 2-YEAR EXTENDED WARRANTY | | | | | | | |
| Invertec® STT® II | X1525 | • | | | | | |
| Power Wave® C300 | X2675 | | • | | | | |
| Power Wave® S350 | X2823 | | | • | | | |
| Power Wave® S350 Aluminum | X4188 | | | | • | | |
| Power Wave® 455M | X2202 | | | | | | |
| Power Wave® 455M/STT® | X2203 | | | | | | |
| Power Wave® S500 | X2904 | | | | | • | |
| Power Wave® S700 | X3279 | | | | | | • |

• Optional



MULTI-OPERATOR WELDING SYSTEMS

| MODEL | PROCESS | | | | | | | | | INPUT | | FEATURES | | | |
|---------------------------|---------|----------|----------------------|-------|-----|-----|--------|------------|-----------|-------|-------|------------------|------------------|-----------------------|------------|
| | Mode | Polarity | Current Range (Amps) | Stick | TIG | MIG | Pulsed | Flux-Cored | Arc Gouge | Phase | Hertz | DC+ Welding Only | Touch-Start TIG* | One Disconnect Switch | IP23 Rated |
| MULTI-ARC SYSTEM | | | | | | | | | | | | | | | |
| Multi-Weld™ 350 | CC/CV | DC+ only | 30-350 | ● | ● | ● | | ● | ● | NA | NA | • | | | |
| RACK SYSTEMS | | | | | | | | | | | | | | | |
| Invertec® V275-S | CC | DC | 5-275 | ● | ● | | | | ● | 3 | 50,60 | | • | • | |
| Invertec® V350 PRO | CC/CV | DC | 5-425 | | ● | ● | | ● | ● | 3 | 50/60 | | • | • | |
| FLEXTEC™ 350X | CC/CV | DC | 5-425 | ● | ● | ● | | ● | | 3 | 50/60 | • | • | • | • |
| FLEXTEC™ 500 | CC/CV | DC | 5-500 | ● | ● | ● | | ● | ● | 3 | 50/60 | • | • | • | • |
| FLEXTEC™ 650 | CC/CV | DC | 10-815 | ● | ● | ● | | ● | ● | 3 | 50/60 | | • | | • |

Multi-Weld™ 350

More Arcs, Less Hassle

- Promotes safety by reducing the number of high-voltage input power connections
- High-efficiency design uses less than half the power of other grid systems
- Capable of continuous operation at 350 amps



Processes (DC+ only)

- Stick
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.302

| Product Name | Product Number | Input Power ⁽¹⁾ Voltage/Phase/Hertz | Rated Output: Current/ Voltage/Duty Cycle ⁽²⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|---|---|---------------------------------|---------------------------------------|---------------------------------------|--------------------|
| Multi-Weld™ 350 | K1735-1 | 80V DC | 350A/34V/100% [DC+ only output] | 165A | 15-40V 30-350A Max. OCV: 78V | 11.6 x 10 x 21.5 (295 x 254 x 546) | 59 (27) |

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

Inverterc® V275-S Inverter Racks

Compact, Efficient and Weather-Resistant

- Basic DC stick, DC TIG and gouging capability
- Available 4 and 8 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- Gouging

Output



Input



Literature

E5.92

| Product Name | Product Number | Input Power ⁽¹⁾ Voltage/Phase/Hertz | Rated Output: Current/ Voltage/Duty Cycle ⁽²⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------------|----------------|---|---|---------------------------------|--------------|---------------------------------------|--------------------|
| Inverterc® V275-S 4-Pack Rack | K2666-1 | 208/230/460/575/3/60 | 275A/31V/35% | 96/89/46/39A | 5-275A | 60 x 38 x 33.5 (1524 x 965 x 851) | 520 (236) |
| | | 220/380/400/415/440/3/50 | 250A/30V/35% | 89/53/53/50/46A | | | |
| 8-Pack Rack | K2666-2 | 208/230/460/575/3/60 | 275A/31V/35% | 161/149/77/65A | | 60 x 59 x 33.5 (1524 x 1499 x 851) | 986 (447) |
| | | 220/380/400/415/440/3/50 | 250A/30V/35% | 149/89/89/83/77A | | | |

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

Inverterec® V350 PRO Inverter Racks

Multi-Purpose, Multi-Process

- Handles DC stick, DC TIG, MIG, flux-cored and gouging
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.92

| Product Name | Product Number | Input Power ⁽¹⁾ Voltage/Phase/Hertz | Rated Output: Current/ Voltage/Duty Cycle ⁽²⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---|---|---------------------------------|--------------|---|--------------------|
| Inverterec® V350 PRO 4-Pack Rack | K2667-1 | 208/230/380-415/460/ 575/3/50/60 | 350A/34V/60% | 138/128/78/67/57A | 5-425A | 60 x 44.5 x 33.5 (1524 x 1130 x 851) | 796 (361) |
| 6-Pack Rack | K2667-2 | | | 185/171/104/90/76A | | 60 x 59 x 33.5 (1524 x 1499 x 851) | 1039 (471) |

⁽¹⁾Fused for 380/460/575/3/50/60V AC operation. For 230 or 208V AC operation, primary fuses must be changed.

⁽²⁾Based on a 10 minute period. Output is for each individual machine.

FLEXTEC® 350X Inverter Racks

Simple, Reliable. Flexible.

- Ready for DC stick, DC TIG, MIG and flux-cored welding
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/ Voltage/Duty Cycle ⁽¹⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|------------------------------------|---|---------------------------------|--------------|--|--------------------|
| FLEXTEC® 350X Standard Model 4-Pack Rack | K4280-1 | 380/460/575/3/50/60 | 350A/34V/60% 300A/32V/100% | 75/68/68A | 5-425A | 67.25 x 37.5 x 33 (1784 x 952 x 838) | 500 (227) |
| Standard Model 6-Pack Rack | K4281-1 | | | 100/90/90A | | 70.25 x 49.5 x 33 (1784 x 1257 x 838) | 650 (295) |
| Construction Model 4-Pack Rack | K4276-1 | | | 75/68/68A | | 67.25 x 37.5 x 33 (1784 x 952 x 838) | 488 (221) |
| Construction Model 6-Pack Rack | K4277-1 | | | 100/90/90A | | 70.25 x 49.5 x 33 (1784 x 1257 x 838) | 632 (287) |

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.



FLEXTEC® 500 Inverter Racks

Faster Setup, More Arc Time

- Ready for DC stick, DC TIG, MIG and flux-cored welding and arc gouging
- Available 4 and 6 pack configurations
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle ⁽¹⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------|----------------|---------------------------------|---|------------------------------|--------------|--|-----------------|
| FLEXTEC® 500 4-Pack Rack | K4098-1 | 380/460/575/3/50/60 | 500A/40V/60% 450A/38V/100% | 103/75/61A | 5-500A | 67.25 x 37.5 x 33 (1784 x 952 x 838) | 800 (363) |
| 6-Pack Rack | K4099-1 | | | 138/100/81A | | 70.25 x 49.5 x 33 (1784 x 1257 x 838) | 1100 (499) |

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.

FLEXTEC® 650 Inverter Racks

Simple Operation, Advanced Gouging Power

- Handles DC stick, DC TIG, MIG, Flux-Cored and Gouging
- Available 4 pack configuration
- Power sources connect to one easy outgoing power drop with a common disconnect switch
- Individual fuses provide overcurrent protection for each power source
- Two overhead lift eyes, standard fork lift slots and optional casters provide easy maneuverability



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E5.97

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle ⁽¹⁾ | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------|----------------|---------------------------------|---|------------------------------|--------------|--|-----------------|
| FLEXTEC® 650 4-Pack Rack | K3144-1 | 380/460/575/3/50/60 | 650A/44V/100% 750A/44V/60% | 202/167/105A | 10-815A | 67.7 x 37.5 x 33 (1719 x 952 x 838) | 2112 (958) |

⁽¹⁾Based on a 10 minute period. Output is for each individual machine.

Accessories

| Product Name | Product No. | Multi-Weld™ 350 | | Invertec® V275-S | | Invertec® V350 PRO | | FLEXTEC® 350X | | | FLEXTEC® 500 | | FLEXTEC® 650 |
|---|-------------|-----------------|-------------|------------------|-------------|--------------------|----------------------|----------------------|--------------------------|--------------------------|--------------|-------------|--------------|
| | | Base Model | 4-Pack Rack | 8-Pack Rack | 4-Pack Rack | 6-Pack Rack | 4-Pack Rack Standard | 6-Pack Rack Standard | 4-Pack Rack Construction | 6-Pack Rack Construction | 4-Pack Rack | 6-Pack Rack | 4-Pack Rack |
| | | K1735-1 | K2666-1 | K2666-2 | K2667-1 | K2667-2 | K4280-1 | K4281-1 | K4276-1 | K4277-1 | K4098-1 | K4099-1 | K3144-1 |
| GENERAL | | | | | | | | | | | | | |
| Distribution Box | K1736-1 | • | | | | | | | | | | | |
| Twist Mate™ Cable Plug for 1/0-2/0, 50-70 mm ² cable | K852-70 | • | • | • | • | • | • | • | • | • | • | • | • |
| Twist Mate™ Cable Plug for 2/0-3/0, 70-95 mm ² cable | K852-95 | • | • | • | • | • | • | • | • | • | • | • | • |
| Twist Mate™ Receptacle for 1/0-2/0, 50-70 mm ² cable | K1759-70 | • | • | • | • | • | • | • | • | • | • | • | • |
| Twist Mate™ Receptacle for 2/0-3/0, 70-95 mm ² cable | K1759-95 | • | • | • | • | • | • | • | • | • | • | • | • |
| Tweco® Style Cam-Lock Adapter Plug | K2946-1 | • | • | • | • | • | • | • | • | • | • | • | • |
| Remote Output Control, 25 ft. (7.6 m) | K857 | • | | | | | | | | | | | • |
| Remote Output Control, 100 ft. (30 m) | K857-1 | • | | | | | | | | | | | • |
| Caster Kit | K2665-1 | • | • | • | • | • | • | • | • | • | • | • | • |
| Weld Fume Control System | — | • | • | • | • | • | • | • | • | • | • | • | • |
| POWER SOURCE | | | | | | | | | | | | | |
| Idealarc® DC1000 | K1386-3 | • | | | | | | | | | | | |
| Idealarc® DC1500 | K1275 | • | | | | | | | | | | | |
| SAE-500® | K1278-11 | • | | | | | | | | | | | |
| Vantage® 500 | K2405-2 | • | | | | | | | | | | | |
| WIRE FEEDER | | | | | | | | | | | | | |
| LN-25 PRO Wire Feeders | — | | | | | | • | • | • | • | | | |
| LN-25X Wire Feeders | — | • | • | • | • | • | • | • | • | • | • | • | • |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | |
| Multi-Weld™ 350 | X1735 | • | | | | | | | | | | | |



ENGINE DRIVES: COMMERCIAL

| MODEL | OUTPUT | | PROCESS | | | | | | | | FEATURES | | | | | | | | | | | |
|---|-----------|-----------|--|---|-------|------|----------------------|------------------------------|--------|-----|------------|-------------------|--------------------|---------------------------------|------------|---------------|---------------------|----------------|--------------------|-------------------|-----------|----------------|
| | Mode | Polarity | Current Range (Amps) | AC Generator Power ⁽¹⁾ (watts) | Stick | Pipe | DC TIG Scratch Start | Touch Start TIG [®] | AC TIG | MIG | Flux-Cored | Arc Gouge in (mm) | Reactor Technology | Chopper Technology [®] | Tube Frame | Enclosed Case | Electric Fuel Gauge | Remote Capable | Downhill Pipe Mode | Arc Force Control | Hot Start | Digital Meters |
| GASOLINE | | | | | | | | | | | | | | | | | | | | | | |
| Bulldog[®] 5500 | CC | AC | 70-140 AC | 5,500 S 4,000 C | ● | | | | | | | ● | | ● | | | | | | | | |
| Outback[®] 145 | CC | DC | 50-145 DC | 4,750 P 4,250 C | ● | | | | | | | ● | | ● | | | | | | | | |
| Outback[®] 185 | CC | DC | 50-185 DC | 5,700 P 5,200 C | ● | | | | | | | ● | | ● | | | | | | | | |
| Ranger[®] 225 | CC/ CV | DC | 50-225 DC | 10,500 P 9,000 C | ● | | ● | | | ● | ● | ● | 5/32 (4.0) | ● | | ● | | | | | | |
| Ranger[®] 250 GXT | CC/ CV | AC/ DC | 50-250 DC 50-250 AC | 11,000 P 10,000 C | ● | | ● | | ● | ● | ● | ● | 3/16 (4.8) | ● | | ● | ● | ● | | | | |
| Ranger[®] 305G and Ranger[®] 305 EFI | CC/ CV | DC | 20-305 DC 40-300 DC Pipe 20-250 DC TIG | 10,500 P 9,500 C | ● | ● | ● | | ● | ● | ● | ● | 3/16 (4.8) | ● | | ● | ● | ● | ● | ● | ● | ● |
| LIQUID PROPANE GAS | | | | | | | | | | | | | | | | | | | | | | |
| Ranger[®] 305 LPG | CC/ CV | DC | 20-300 DC 40-300 DC Pipe 20-250 DC TIG | 10,000 P 9,000 C | ● | ● | ● | | ● | ● | ● | ● | 3/16 (4.8) | ● | | ● | ● | ● | ● | ● | ● | ● |
| DIESEL | | | | | | | | | | | | | | | | | | | | | | |
| Ranger[®] 305 D | CC/ CV | DC | 20-305 DC 40-300 DC Pipe 20-250 DC TIG | 10,000 P 9,500 C | ● | ● | ● | | ● | ● | ● | ● | 3/16 (4.8) | ● | | ● | ● | ● | ● | ● | ● | ● |

Bulldog® 5500

The Stick Welder's Best Friend –
Engine-Driven Welder

- AC welding with up to 1/8 in. (3.2 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 5,500 watts of surge AC generator power



Processes

- Stick

Output



Input



Literature

E6.32

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------|----------------|--|---|---------------|-----------|------------------|---|-----------------|
| Bulldog® 5500 | K2708-2 | 125A AC/20V/30% 100A AC/25V/60% | 70-140A AC 5,500 W surge 4,000 W continuous | Kohler® CH395 | 1 | 9.5 @ 3600 | 25.6 x 21.8 x 31.5 (651 x 553 x 800) | 198 (90) |

Outback® 145

Built for The Great Outdoors

- DC welding with up to 1/8 in. (3.2 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 4,750 watts of peak AC generator power



Processes

- Stick

Output



Input



Literature

E6.65

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|--|--|---------------|-----------|------------------|---|-----------------|
| Outback® 145 | K2707-2 | 80A DC/25V/100% 100A DC/25V/60% 125A DC25V/30% | 50-145A DC 4,750 W peak 4,250 W continuous | Kohler® CH395 | 1 | 9.5 @ 3600 | 25.6 x 21.8 x 31.5 (651 x 553 x 800) | 234 (106) |

Outback® 185

Unleash the Power

- All engine controls on the front panel
- DC welding with up to 5/32 in. (4.0 mm) stick electrode
- Low-Lift™ grab bars provide leverage for lifting on and off truck beds
- Rugged tube frame for sturdy protection
- 5,700 watts of peak AC generator power



Processes

- Stick

Output



Input



Literature

E6.70

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|--|--|---------------|-----------|------------------|---|-----------------|
| Outback® 185 | K2706-2 | 100A DC/25V/100% 130A DC/25V/60% 150A DC/25V/20% | 50-185A DC 5,700 W peak 5,200 W continuous | Kohler® CH440 | 1 | 14 @ 3600 | 25.6 x 21.8 x 31.5 (651 x 553 x 800) | 295 (134) |



Ranger® 225

Arm Yourself with The Right Welder For The Job

- Totally enclosed case protects the engine and limits noise
- Up to 225 amps of smooth DC welding output
- 10,500 watts of peak AC generator power
- 12 gallon (45 L) tank for extended run times



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.89

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|--|--|----------------------------|-----------|------------------|---|-----------------|
| Ranger® 225 | K2857-1 | 225A DC CC/25V/40% 210A DC CC/25V/100% 200A DC CV/20V/100% | 50-225A DC 15-25V CV 10,500 W peak 9,000 W continuous | Kohler® OHV Command® CH23S | 2 | 23 @ 3600 | 29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920) | 514 (233) |

Ranger® 250 GXT

Extra Power, Extra Performance

- AC/DC multi-process welding output
- 12 gallon fuel tank for long run times
- Plenty of AC generator power
- Choice of painted, stainless steel or new White Tail™ Camo case panels



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.96

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---|--|--|-----------|------------------|---|-----------------|
| Ranger® 250 GXT | K2382-4 | 250A AC/DC CC/25V/100% 250A DC CV/25V/100% | 50-250A AC/DC 14-28V CV 11,000 W peak 10,000 W continuous | Kohler® OHV Command CH730 (Electric Fuel Pump) | 2 | 23 @ 3600 | 29.9 x 21.5 x 42.3 [759 x 546 x 1073] To top of exhaust tube: 36.2 [920] | 602 [273] |
| w/ Stainless Steel Roof, Case Sides and Engine Doors | K2382-5 | | | | | | | |
| w/ White Tail Camo™ | K2382-7 | | | | | | | |

Ranger® 305 G

An Engine-Driven Welder for All Seasons

- This portable powerhouse is designed for use with gas-powered equipment fleets
- Equipped with digital weld meters to accurately monitor welding output
- 12 gallon (45 L) tank for extended run times
- 10,500 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.117

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------|----------------|--|--|--|-----------|------------------|---|-----------------|
| Ranger® 305 G Base Model | K1726-5 | 305A DC CC/29V/100% 300A DC CV/29V/100% | 20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 10,500 W peak 9,500 W continuous | Kohler® OHV Command® CH730 Gas Electric Fuel Pump | 2 | 23 @ 3600 | 29.9 x 21.5 x 42.3 [759 x 546 x 1074] To top of exhaust tube: 36.2 [920] | 510 [231] |
| One-Pak® Pkg. | K2353-2 | | | | | | — | — |

Ranger® 305 G EFI

Fuel-Efficient Engine-Driven Welder/Generator

- Equipped with digital weld meters to accurately monitor welding output
- 12 gallon [45 L] tank for extended run times
- Electric fuel pump helps avoid vapor lock during high-altitude operation
- Choose the Ranger 305 G EFI (electronic fuel injection) for easier starts in cold weather and lower fuel consumption, with no choke starting required
- 12,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.117

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|--|--|--|-----------|------------------|---|-----------------|
| Ranger® 305 G EFI | K3928-1 | 305A DC CC/29V/100% 300A DC CV/29V/100% | 20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 12,000 W peak 9,500 W continuous | Kohler® OHV Command® ECH740 Gas Electric Fuel Pump Electric Fuel Injection | 2 | 25 @ 3600 | 29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920) | 510 (231) |

Ranger® 305 LPG

Engine-Driven Low Emission Welder/Generator

- Choose the Ranger 305 LPG for those environments where gasoline and diesel emissions are not acceptable
- Top-of-the-line Kohler® overhead valve (OHV) 25 HP Command® LPG engine
- Digital weld meters monitor actual welding output
- 10,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.119

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|--|--|--------------------------------|-----------|------------------|---|-----------------|
| Ranger® 305 LPG Base Model | K2937-1 | 300A DC CC/25V/100% 300A DC CV/25V/100% | 20-300A DC 40-300A Pipe 20-250A DC TIG 14-29V CV 10,000 W peak 9,000 W continuous | Kohler® OHV Command® CH730 LPG | 2 | 25 @ 3600 | 29.9 x 21.5 x 42.3 (759 x 546 x 1074) To top of exhaust tube: 36.2 (920) | 480 (218) |
| One-Pak® Pkg. | K2944-1 | | | | | | — | — |

Ranger® 305 D

Diesel Power, Expanded Capabilities – Engine-Driven Welder/Generator

- Choose the Ranger 305 D for extended fuel efficiency and compatibility with diesel-powered fleets.
- Meets all EPA Tier 4 requirements
- Digital weld meters to monitor actual welding output
- Arc force control for a soft or more forceful digging arc
- 10,000 watts of peak AC generator power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.118

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | # of Cyl. | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------|----------------|--|---|---|-----------|------------------|---|-----------------|
| Ranger® 305 D Base Model | K1727-4 | 305A DC CC/29V/100% 300A DC CV/29V/100% | 20-305A DC 40-300A Pipe 20-250A DC TIG 14-29V 10,000 W peak 9,500 W continuous | Kubota® D722 Diesel EPA Tier 4 Final | 3 | 18.8 @ 3600 | 29.9 x 21.5 x 50.3 (759 x 546 x 1327) To top of exhaust tube: 35.8 (909) | 698 (317) |
| One-Pak® Pkg. | K2352-5 | | | | | | – | – |





STAND OUT BY BLENDING IN

NEW! White Tail Camo™ Ranger® 250 GXT Order K2382-7

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Ranger® 305 G

One-Pak® Package (K2353-2)

- Ranger® 305 G
- LN-25 Ironworker® Wire Feeder
- K126™ PRO 350 Amp Innershield® Gun
- Accessory Kit, 400 Amp
- 5/64 in. (2.0 mm) Innershield® NR®-233, 25 lb. (11.3 kg) Spool

Ranger® 305 LPG

One-Pak® Package (K2944-1)

- Ranger® 305 LPG
- Factory Undercarriage
- Welding Gas Cylinder/LPG Tank Holder
- LPG Tank Strap
- Accessory Kit, 400 Amp
- 1/8 in. (3.2 mm) Excalibur® 7018 MR Stick Electrode, Six 10 lb. (4.5 kg) Easy Open Cans

Ranger® 305 D

One-Pak® Package (K2352-5)

- Ranger® 305 D
- LN-25 Ironworker® Wire Feeder
- K126™ PRO 350 Amp Innershield® Gun
- Accessory Kit, 400 Amp
- 5/64 in. (2.0 mm) Innershield® NR®-233, 25 lb. (11.3 kg) Spool



Shown:
Ranger® 305 G
One-Pak®



Shown:
Ranger® 305 LPG
One-Pak®



Shown:
Ranger® 305 D
One-Pak®



Accessories

| Product Name | Product No. | Bulldog® 5500 | Outback® 145 | Outback® 185 | Rangerr® 225 | Rangerr® 250 GXT | | Rangerr® 305 G | Rangerr® 305 G EFI | Rangerr® 305 LPG | Rangerr® 305 D | |
|--|-------------|---------------|--------------|--------------|--------------|------------------|------------------------|------------------|--------------------|------------------|----------------|------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model (Stainless) | Base Model (Cam) | Base Model | Base Model | Base Model | Base Model |
| | | K2708-2 | K2707-2 | K2706-2 | K2857-1 | K2382-4 | K2382-5 | K2382-7 | K1726-5 | K3928-1 | K2937-1 | K1727-4 |
| GENERAL | | | | | | | | | | | | |
| Accessory Kit, 150 Amp | K875 | • | • | • | | | | | | | | |
| Undercarriage | K2722-1 | • | • | • | | | | | | | | |
| All-Terrain Undercarriage | K1737-1 | | | | • | • | • | • | • | • | | |
| Factory Undercarriage | K1770-1 | | | | • | | | | • | • | • | |
| Lift Bail Kit | K2819-1 | • | • | • | | | | | | | | |
| Canvas Cover | K2804-1 | • | • | • | | | | | | | | |
| Canvas Cover | K886-2 | | | | • | • | • | • | • | • | • | |
| Power Plug Kit, 20 amp | K802N | | | | • | • | • | • | • | • | • | • |
| Full-KVA Power Plug (1-phase) | T12153-9 | | | | • | • | • | • | • | • | • | • |
| GFCI Receptacle Kit, 120V, 20 Amp (2 required) | K1690-1 | • | • | • | • | • | • | • | • | • | | |
| Spark Arrestor Kit | K1898-1 | | | | • | • | • | • | • | • | | |
| Spark Arrestor Kit | K2793-1 | | | • | | | | | | | | |
| Welding Gas Cylinder/LPG Tank Holder | K1745-1 | | | | • | • | • | • | • | • | • | |
| LPG Tank Strap (requires K1745-1) | K2361-1 | | | | | | | | | | • | |
| Small 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch | K2635-1 | | | | • | • | • | • | • | • | • | • |
| Fender and Light Kit | K2639-1 | | | | • | • | • | • | • | • | • | • |
| Cable Rack | K2640-1 | | | | • | • | • | • | • | • | • | • |
| Polarity/Multi-Process Switch | K2642-1 | | | | | | | • | • | • | • | • |
| Docking Kit | K2663-1 | | | | | | | • | • | • | • | • |
| STICK | | | | | | | | | | | | |
| Accessory Kit, 400 Amp | K704 | | | | • | • | • | • | • | • | • | • |
| Accessory Kit, 150 Amp | K875 | | | | • | • | • | • | | | • | • |
| Remote Output Control, 25 ft (7.6 m) | K857 | | | | | • | • | • | • | • | • | • |
| Remote Output Control, 100 ft (30.5 m) | K857-1 | | | | | • | • | • | • | • | • | • |
| Remote Output Control with 120V AC, 100 ft (30.5 m), 20 amp capacity | K2627-2 | | | | | • | • | • | • | • | • | • |
| TIG | | | | | | | | | | | | |
| Pro-Torch™ TIG Torch PTA-26, 25 ft (7.6 m), 2 pc | K1783-4 | | | | | • | • | • | | | | |
| Pro-Torch™ TIG Torch PTA-26V, 25 ft (7.6 m), 2 pc | K1783-9 | | | | • | | | | • | • | • | • |
| Parts Kit For PTW-18 and PTA-26 Series Torches | KP509 | | | | • | • | • | • | • | • | • | • |
| Control Cable (9-pin to 6-pin and 115V plug) | K936-3 | | | | | • | • | • | | | | |
| Control Cable Extension, 45 ft (13.7 m) | K937-45 | | | | | • | • | • | | | | |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | | | | | • | • | • | • | • | • | • |
| Foot Amptrol™ | K870 | | | | | • | • | • | • | • | • | • |
| Contact Kit | K938-1 | | | | | • | • | • | | | | |
| Docking Kit | K939-1 | | | | | • | • | • | | | | |
| Full-KVA Adapter Kit (1-phase) | K1816-1 | | | | • | • | • | • | • | • | • | • |

• Optional

Accessories

| Product Name | Product No. | Bulldog® 5500 | Outback® 145 | Outback® 185 | Rangerr® 225 | Rangerr® 250 GXT | | Rangerr® 305 G | Rangerr® 305 G EFI | Rangerr® 305 LPG | Rangerr® 305 D | |
|--|---------------|---------------|--------------|--------------|--------------|------------------|------------------------|------------------|--------------------|------------------|----------------|------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model (Stainless) | Base Model (Cam) | Base Model | Base Model | Base Model | Base Model |
| | | K2708-2 | K2707-2 | K2706-2 | K2857-1 | K2382-4 | K2382-5 | K2382-7 | K1726-5 | K3928-1 | K2937-1 | K1727-4 |
| TIG, CON'T. | | | | | | | | | | | | |
| Square Wave™ TIG 175 | K1478-5 | | | | • | | | | • | • | • | • |
| TIG Module | K930-2 | | | | | • | • | • | | | | |
| WIRE FEEDER | | | | | | | | | | | | |
| K126™ PRO FCAW-SS Gun, 15 ft (4.6 m), 0.062-5/64 in (1.6-2.0 mm) | K126-12 | | | | • | • | • | • | • | • | • | • |
| Drive Roll Kit, 5/64 in (2.0 mm) Cored/Solid | KP1697-5/64 | | | | | • | • | • | | | | |
| Drive Roll Kit, 0.068-0.072 in (1.7-1.8 mm) Solid/Cored Wire | KP1697-068 | | | | • | • | • | • | • | • | • | • |
| Magnum® PRO 350 Ready-Pak®, 15 ft (4.6 mm), 0.035-5/64 in (0.9-2.0 mm). (Includes K466-10 Connector Kit) | K2652-2-10-45 | | | | • | | | | • | • | • | • |
| Drive Roll Kit, 0.035 in and 0.045 in (0.9 and 1.1 mm) Solid Wire | KP1696-1 | | | | • | • | • | • | • | • | • | • |
| POWER MIG® 140C | K2471-2 | • | • | • | | | | | | | | |
| POWER MIG® 180C | K2473-2 | • | • | • | • | • | • | • | • | • | • | • |
| LN-25 PRO Wire Feeder | K2613-5 | | | | • | • | • | • | | | | |
| LN-25 Ironworker® Wire Feeder | K2614-9 | | | | | | | | • | • | • | • |
| SPOOL GUN | | | | | | | | | | | | |
| Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft. (7.6 m) | K487-25 | | | | | | | | • | • | • | • |
| SG Control Module | K488 | | | | | | | | • | • | • | • |
| Control Module Input Cable, 14-pin MS-type & Lug, 10 ft. (3.0 m) | K691-10 | | | | | | | | • | • | • | • |
| Magnum® PRO 100SG Spool Gun (requires POWER MIG® 140C) | K3269-1 | • | | | | | | | | | | |
| Magnum® PRO 100SG Spool Gun (requires POWER MIG® 140C or 180C) | K3269-1 | | • | • | | | | | | | | |
| Magnum® PRO 100SG Spool Gun (requires POWER MIG® 180C) | K3269-1 | | | | • | • | • | • | • | • | • | • |
| PLASMA CUTTING | | | | | | | | | | | | |
| Tomahawk® 375 Air | K2806-1 | | | • | | | | | | | | |
| Tomahawk® 1000 | K2808-1 | | | | • | • | • | • | • | • | • | • |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | |
| Bulldog® 5500 | X2708 | • | | | | | | | | | | |
| Outback® 145 | X2707 | | • | | | | | | | | | |
| Outback® 185 | X2706 | | | • | | | | | | | | |
| Ranger® 225 | X2857 | | | | • | | | | | | | |
| Ranger® 250 GXT | X2382 | | | | | • | • | • | | | | |
| Ranger® 305 G | X1726 | | | | | | | | • | | | |
| Ranger® 305 G EFI | X3928 | | | | | | | | | • | | |
| Ranger® 305 LPG | X2937 | | | | | | | | | | • | |
| Ranger® 305 D | X1727 | | | | | | | | | | | • |

• Optional

ENGINE DRIVES: INDUSTRIAL

| MODEL | | | OUTPUT | | PROCESS | | | | | | | FEATURES | | | | | | | |
|----------------------------------|-----------|----------|--|--|---------|------|----------------------|------------------|--------|-----|-----------------|-------------------|-------------------|---------------------|----------------------|------------------------|-------------|----------------------------------|----------------|
| | Mode | Polarity | Current Range (Amps) | AC Generator Power (watts) C = Continuous P = Peak | Stick | Pipe | DC TIG Scratch Start | Touch Start TIG* | AC TIG | MIG | Flux-Cored | Arc Gouge in (mm) | Pure DC Generator | Chopper Technology® | Stainless Steel Case | Corrosive Environments | Weld Meters | Voltage Reduction Device™ (VRD™) | Air Compressor |
| 200-400 AMP MODELS | | | | | | | | | | | | | | | | | | | |
| Classic® 300 HE | CC | DC | 40-350 DC | 1-Phase: 3,000 C | ● | ● | ● | | ○ | ○ | ● 3/16 (4.8) | ● | | | | | | | |
| SAE-300° HE | CC | DC | 50-390 DC | 1-Phase: 3,000 C | ● | ● | ● | | ○ | ○ | ● 1/4 (6.3) | ● | | | | | | | |
| Classic® 300 MP | CC/ CV | DC | 40-350 DC | 1-Phase: 3,000 C | ● | ● | ● | | ○ | ○ | ● 3/16 (4.8) | ● | | | | | | | |
| SAE-300° MP | CC/ CV | DC | 40-350 DC | 1-Phase: 3,000 C | ● | ● | ● | | ○ | ○ | ● 1/4 (6.3) | ● | | | | | | | |
| Cross Country™ 300 | CC/ CV | DC | 40-300 DC Pipe 20-250 DC TIG | 3-Phase: 12,500 P / 11,000 C 1-Phase: 11,500 P / 10,000 C | ● | ● | ● | ● | ○ | ○ | ● 1/4 (6.3) | ● | ● | ● | | | ● | ● | |
| Vantage® 300 | CC/ CV | DC | 30-400 DC 40-300 DC Pipe 20-250 DC TIG | 3-Phase: 12,500 P / 11,000 C 1-Phase: 11,500 P / 10,000 C | ● | ● | ● | ● | ○ | ○ | ● 1/4 (6.3) | ● | ● | ● | | | ● | ● | |
| Vantage® 400 | CC/ CV | DC | 30-500 DC 40-300 DC Pipe 20-250 DC TIG | 3-Phase: 12,500 P / 11,000 C 1-Phase: 11,500 P / 10,000 C | ● | ● | ● | ● | ○ | ○ | ● 5/16 (8.0) | ● | ● | ● | | | ● | ● | |
| 500-700 AMP MODELS | | | | | | | | | | | | | | | | | | | |
| SAE-500° | CC | DC | 80-575 DC | 1-Phase: 3,000 C | ● | ● | ○ | | | | ○ 3/8 (9.5) | ● | | | | | | | |
| SAE-500° Severe Duty | CC | DC | 80-575 DC | 1-Phase: 3,000 C | ● | ● | ○ | | | | ○ 3/8 (9.5) | ● | | | ● | | | | |
| Vantage® 500 Compact Case | CC/ CV | DC | 30-525 DC 40-300 DC Pipe 20-250 DC TIG | 3-Phase: 22,000 P / 20,000 C 1-Phase: 13,000 P / 12,000 C | ● | ● | ● | ● | ○ | ○ | ● 3/8 (9.5) | ● | ● | ● | | | ● | ● | |
| Vantage® 520 SD | CC/ CV | DC | 30-520 CC/CV 20-250 TIG | 3-Phase: 17,000 C 1-Phase: 11,000 C | ● | ● | ● | ● | ○ | ○ | ● 5/16 (8.0) | ● | ● | ● | | | ● | ● | |
| Vantage® 600 SD | CC/ CV | DC | 30-600 CC/CV 20-350 TIG | 3-Phase: 20,000 C 1-Phase: 12,000 C | ● | ● | ● | ● | ○ | ○ | ● 3/8 (9.5) | ● | ● | ● | | | ● | ● | |
| Air Vantage® 600 SD | CC/ CV | DC | 30-600 CC/CV 20-350 TIG | 3-Phase: 20,000 C 1-Phase: 12,000 C | ● | ● | ● | ● | ○ | ○ | ● 3/8 (9.5) | ● | ● | ● | | | ● | ● | ● |
| Air Vantage® 650 | CC/ CV | DC | 30-700 DC 40-300 DC Pipe 20-250 DC TIG | 3-Phase: 20,000 C 1-Phase: 12,000 C | ● | ● | ● | ● | ○ | ○ | ● 1/2 (12.7) | ● | ● | ● | | | ● | ● | ● |
| Dual Vantage® 700 ⁽¹⁾ | CC/ CV | DC | 30-700 CC/CV 20-250 DC TIG | 3-Phase: 20,000 C 1-Phase: 12,000 C | ● | ● | ● | ● | ○ | ○ | ● 1/2 (12.7) | ● | ● | ● | | | ● | ● | |

Classic® 300 HE

Fuel Efficiency in Pipeline and Construction Welding

- All-copper windings enhance arc stability for a smooth, high-performance arc
- Five current ranges with overlap for stick welding and other processes where slope control is desired. Fine tuning within each range
- EPA Tier 4 rating on Kubota® D1503 diesel engine



Processes

- Stick
- TIG
- MIG⁽¹⁾
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.156

⁽¹⁾ With Wire Feed Module.
Rated 300 amps, 35 volts at 60% duty cycle.

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|--|----------------------------|---------------------------------|------------------|------------------|---------------------------------------|-----------------|
| Classic® 300 HE Base Model | K3198-1 | 250A/30V/100% 300A/32V/50% | 40-350A DC | Kubota® D1503 Diesel EPA Tier 4 | 3 | 24.7 @ 1800 | 37.1 x 24.3 x 62.8 (943 x 616 x 1594) | 1371 (622) |
| One-Pak® Pkg. | K2386-5 | | 1 Ph/AC Power: 3,000 watts | | | | To top of exhaust tube: 45.5 (1156) | — |
| Ready-Pak® Pkg. | K2387-5 | | | | | | | — |

SAE-300® HE

Dual Control for Pipeline Welding

- Current controls allow for sharper arc on root and hot passes, or softer arc on pipe welding with low-hydrogen electrode
- All-copper windings enhance arc stability for a smooth, high-performance arc
- Perkins® or Kubota® engines offer fuel savings compared to previous models



Processes

- Stick
- TIG
- MIG⁽¹⁾
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.162

⁽¹⁾ With Wire Feed Module.
Rated 300 amps, 35 volts at 60% duty cycle.

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------------|----------------|--|----------------------------|---|------------------|------------------|---------------------------------------|-----------------|
| SAE-300® HE Base Model (Kubota®) | K3201-1 | 250A/30V/100% 300A/32V/60% | 50-390A DC | Kubota® D1503 Diesel EPA Tier 4 | 3 | 24.7 @ 1800 | 37.1 x 24.3 x 62.8 (943 x 616 x 1594) | 1432 (649) |
| Base Model w/Wire Feed Module | K3201-2 | | 1 Ph/AC Power: 3,000 watts | | | | To top of exhaust tube: 45.5 (1156) | — |
| One-Pak® Pkg. | K3956-5 | | | | | | | — |
| Ready-Pak® Pkg. | K3959-5 | | | | | | | — |
| SAE-300® HE Base Model (Perkins®) | K3202-1 | | | Perkins® 403F-15T Turbo-Charged Diesel EPA Tier 4 | | | | 1419 (644) |
| One-Pak® Pkg. | K3957-5 | | | | | | | — |
| Ready-Pak® Pkg. | K3960-5 | | | | | | | — |

Classic® 300 MP

Excellent for Pipelines, Construction and Maintenance.

- Pure DC generator design enables precise control
- All copper windings enhance arc stability for a super-smooth, high-performance arc
- Custom ARC® current adjustment allows for fine tuning of heat input at the arc



Processes

- Stick
- TIG
- MIG⁽¹⁾
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.157

⁽¹⁾ With Wire Feed Module.

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------|----------------|--|---|--|------------------|------------------|--|-----------------|
| Classic 300 MP Base Model | K4263-1 | 250A/30V/100% 300A/32V/60% | 40-350A DC 1 Ph/AC Power: 3,000 watts | Perkins® 403F-15T Diesel EPA Tier 4 | 3 | 24.7 @ 1800 | 37.1 x 24.3 x 62.8 (943 x 616 x 1594) | 1,364 (619) |

SAE-300® MP

Quality. Efficiency. Endurance.

- Pure DC generator ensures smooth, stable arc
- Dual continuous current control allows coarse tuning, fine tuning and everything in between
- Larger fuel tank allows for longer run times, improved efficiency and greater cost savings



Processes

- Stick
- Flux-Cored
- MIG
- TIG

Output



Input



Literature

E6.163

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------|-----------------|--|--|--|------------------|------------------|--|-----------------|
| SAE-300® MP Base Model | K4089-1 | 250A DC/30V/100% 300A DC/32V/60% | 50-390A 1 Ph/AC Power: 3,000 watts | Perkins® 403F-15T Diesel EPA Tier 4 | 3 | 24.7 @ 1800 | 37.1 x 24.3 x 62.8 (943 x 616 x 1594) | 1419 (644) |
| One-Pak® Pkg. | K4089-1-One-Pak | | | | | | | — |
| Ready-Pak® Pkg. 1 | K4089-1-RP1 | | | | | | | — |
| Ready-Pak® Pkg. 2 | K4089-1-RP2 | | | | | | | — |
| Ready-Pak® Pkg. 3 | K4089-1-RP3 | | | | | | | — |

Cross Country™ 300

Purpose-Built For Pipe Welding

- Compact and portable: lighter weight and smaller footprint for easy transport
- Dual continuous controls help you tune the arc for the pipe, pass, position, conditions and more
- Supports DC, stick, wire and TIG processes, and easily connects to Lincoln Electric wire feeders



Processes

- Stick
- Flux-Cored
- MIG
- TIG

Output



Input



Literature

E6.170

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------------------|----------------|--|--|---|------------------|------------------|--|-----------------|
| Cross Country™ 300 Base Model | K4166-1 | 300A/32V/100% 350A/28V/100% | 40-300A CC/CV 20-250A TIG 3 Ph/AC Power: 11,000 watts 1 Ph/AC Power: 10,000 watts | Kubota® V1505 Liquid-Cooled EPA Tier 4 Final Compliant | 4 | 22 @ 1800 | 31.9 x 25.3 x 56 (810 x 643 x 1422) | 1034 (469) |

Vantage® 300

Quiet, Compact, Multi-Process Construction, Pipe and Rental Welder/Generator

- Five process modes, including arc gouging with up to 1/4 in. (2.4 mm) carbons
- Plenty of AC Generator Power
- Delivers great arc starts and a smooth arc for stick, TIG or wire welding



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.206

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------------|----------------|--|--|--|------------------|------------------|--|-----------------|
| Vantage® 300 Base Model | K2409-4 | 300A/32V/100% 350A/28V/100% | 30-400A DC 40-300A Pipe 20-250A DC TIG 14-32V CV | Kubota® V1505 Diesel EPA Tier 4 | 4 | 22 @ 1800 | 35.9 x 25.3 x 60 (913 x 642 x 1524) | 1035 (469) |
| One-Pak® Pkg. | K2452-5 | | | | | | To top of exhaust tube: 44.3 (1124) | — |
| Ready-Pak® Pkg. | K2453-5 | | 3 Ph/AC Power: 12.5 kW p, 11 kW c 1 Ph/AC Power: 11.5 kW p, 10 kW c | | | | | — |

Vantage® 400

Multi-Process Welding with Extra Power

- Five process modes, including arc gouging with up to 5/16 in. (8.0 mm) carbons
- Plenty of AC Generator Power



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.210

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------|----------------|--|--|--|------------------|------------------|--|-----------------|
| Vantage® 400 Base Model | K2410-7 | 400A/36V/100% 450A/32V/100% | 30-500A DC 40-300A Pipe 20-250A DC TIG 14-36V CV | Perkins® 404D-22 Diesel EPA Tier 4i Flex | 4 | 32.7 @ 1800 | 35.9 x 25.3 x 60 (913 x 642 x 1524) | 1230 (559) |
| One-Pak® Pkg. | K2508-7 | | | | | | To top of exhaust tube: 46.6 (1184) | — |
| Ready-Pak® Pkg. | K2509-7 | | 3 Ph/AC Power: 19 kW p, 17 kW c 1 Ph/AC Power: 12 kW p, 11 kW c | | | | | — |

SAE-500®

Built for High Amperage Stick Jobs

- Rugged construction protects internal components in rough environments
- Large diameter stick welding and arc gouging up to 3/8 in. (9.5 mm) carbon
- Ideal for multiple arc applications with the Multi-Weld™ 350 system



Processes

- Stick
- TIG
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.182

⁽¹⁾ With CV Adapter. Rated at 400 amps, 35 volts at 60% duty cycle.

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------|----------------|--|---|--|------------------|------------------|--|-----------------|
| SAE-500® Base Model | K4053-1 | 400A /40V/100% 500A/40V/60% | 80-575A DC 1 Ph/AC Power: 3,000 watts | Deutz® TD2.9L4 Diesel EPA Tier 4 Final Compliant | 4 | 64 @ 1800 | 45.8 x 28 x 83 (1164 x 711 x 2109) To top of exhaust tube: 54.3 (1379) | 2111 (957.5) |

SAE-500® Severe Duty™

Take Stick to The Extreme

- Designed to withstand offshore salt spray and other corrosive environments with all-copper coils, a coated radiator and wire connections and sealed switches
- Stainless steel and hot-dip galvanized case and internal sheet metal
- Spark arrestor and engine air intake shutdown per Mineral Management Services Code
- Remote control included



Processes

- Stick
- TIG
- Flux-Cored⁽¹⁾
- Gouging

Output



Input



Literature

E6.184

⁽¹⁾ With CV Adapter. Rated at 400 amps, 35 volts at 60% duty cycle. (Not available with upgrades for severe duty environments.)

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------------|----------------|--|---|--|------------------|------------------|--|-----------------|
| SAE-500® Severe Duty™ Base Model | K3955-1 | 400A/40V/100% 500A/40V/60% | 80-575A DC 1 Ph/AC Power: 3,000 watts | Deutz® TD2.9L4 Diesel EPA Tier 4 Final Compliant | 4 | 64 @ 1800 | 45.8 x 28 x 83 (1164 x 711 x 2109) To top of exhaust tube: 54.3 (1379) | 2111 (957.5) |

Vantage® 500 Compact Case

Truck Mounting is Easy

- Designed for truck mounting where space and weight capacity are limited
- 500 amps @ 100% duty cycle and 20,000 watts of AC generator power
- Multi-process capability, including CC-stick, pipe, CV-wire, DC Touch Start TIG® and arc gouging
- Stainless steel enclosure for corrosion resistant protection and durability
- Arc gouging with up to 3/8 in. (9.5 mm) carbons



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.214

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------------------|----------------|--|--|--|------------------|------------------|---|-----------------|
| Vantage® 500 Compact Case Base Model | K2686-2 | 500A/40V/100% 525A/38V/60% | 30-525A DC 40-300A Pipe 20-250A DC TIG 14-40V CV | Perkins® 404D-22T Turbo Diesel EPA Tier 4i | 4 | 45 @ 1850 | 35.9 x 25.3 x 60.0 (913 x 642 x 1524) To top of exhaust tube: 46.6 (1184) | 1290 (586) |
| One-Pak® Pkg. | K3244-3 | | | | | | | — |
| Ready-Pak® Pkg. | K2728-3 | | 3 Ph/AC Power: 20 kW continuous 1 Ph/AC Power: 12 kW continuous | | | | | — |

Vantage® 520 SD

A Superior Arc With A Superior Engine

- Multi-purpose engine driven welder for rugged outdoor work
- Ideal for 400-amp, 36-volt 100% duty cycle welding
- Arc Gouges with up to 5/16 in. (8.0 mm) carbon electrodes



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|---|------------------------------------|--|------------------|------------------|--|-----------------|
| Vantage® 520 SD Base Model | K4107-1 | @ 104° F (40° C): 400A/36V/100% 450A/32V/100% 520A/30V/60% | 30-520A CC/CV 20-250A TIG | Deutz® D2.9L4 Naturally Aspirated Diesel Engine EPA Tier 4 Final Compliant | 4 | 34.8 @ 1800 | 39.1 x 28.4 x 65.1 (994 x 721 x 1654) | 1526 (692) |
| One-Pak® Pkg. | K4173-1 | | | | | | | — |
| Ready-Pak® Pkg. 1 | K4138-1 | | | | | | | — |
| Ready-Pak® Pkg. 3 | K4138-12 | | 1 Ph/AC Power: 11 kW continuous | | | | | — |
| Ready-Pak® Pkg. 6 | K4138-129 | | | | | | | — |

Vantage® 600 SD

A Superior Arc With A Superior Engine

- Upgraded for Tier 4 Final compliance
- Ideal for 575-amp, 43-volt 100% duty cycle welding
- Arc Gouges with up to 3/8 in. (9.5 mm) carbon electrodes



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|--|--------------------------------|---|------------------|------------------|--|-----------------|
| Vantage® 600 SD Base Model | K3239-1 | @ 104° F (40° C): 575A/43V/100% 600A/40V/60% | 30-600A CC/CV 20-350A TIG | Deutz® Turbo Charged TD2.9L4 Diesel EPA Tier 4 Final Compliant | 4 | 64 @ 1800 | 42 x 32.9 x 69 (1067 x 836 x 1753) | 1662 (753) |
| One-Pak® Pkg. | K3245-5 | | | | | | | — |
| Ready-Pak® Pkg. 1 | K4136-1 | | 3 Ph/AC Power: 20,000 watts | | | | To top of exhaust tube: 50.8 (1290) | — |
| Ready-Pak® Pkg. 3 | K4136-12 | | | | | | | — |
| Ready-Pak® Pkg. 6 | K4136-129 | | 1 Ph/AC Power: 12,000 watts | | | | | — |

Air Vantage® 600 SD

A Superior Arc With A Superior Engine

- Belt-driven compressor with separate gauges to monitor compressor hours and pressure
- Less wiring and fewer connections means less downtime for maintenance and repair
- Cleanest diesel power available, with 90% reduction in particulate and nitrous oxide emissions



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.219B

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------------|----------------|--|---------------------------------|---|------------------|------------------|--|-----------------|
| Air Vantage® 600 SD Base Model | K3242-1 | @ 104° F [40° C]: 575A/43V/100% 600A/40V/60% | 30-600A CC/CV 20-230A TIG | Deutz® Turbo Charged TD2.9L4 Diesel EPA Tier 4 Final Compliant | 4 | 64 @ 1800 | 42 x 32.9 x 69 (1067 x 836 x 1753) | 1737 (787) |
| One-Pak® Pkg. | K3958-5 | | | | | | To top of exhaust tube: 50.8 (1290) | — |
| Ready-Pak® Pkg. 1 | K4137-1 | | 3 Ph/AC Power: 20,000 watts | | | | | — |
| Ready-Pak® Pkg. 3 | K4137-12 | | 1 Ph/AC Power: 12,000 watts | | | | | — |
| Ready-Pak® Pkg. 6 | K4137-129 | | Compressor: 60 SCFM, 100 PSI | | | | | — |

Air Vantage® 650

Three in One – Welder, Generator and Air Compressor

- Multi-process welding and separate arc gouge mode which maximizes output with up to 1/2 in. (12.7 mm) carbon rods
- Up to 20,000 watts of continuous AC generator power to operate plasma cutters, pumps, inverter welders and grinders
- Reliable 4 cylinder 1800 RPM Cummins® turbocharged diesel engine



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Gouging

Output



Input



Literature

E6.240

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|---|--|---|------------------|------------------|--|-----------------|
| Air Vantage® 650 Base Model | K2961-1 | 600A/44V/100% 650A/40V/60% 700A/38V/40% | 30-700A DC 40-300A Pipe 20-250A DC TIG 14-44V CV 90-700A Gouge | Cummins® B3.3T Turbo-Charged Diesel EPA Tier 4i | 4 | 69 @ 1860 | 36.9 x 28.5 x 77.0 (931 x 724 x 1956) | 2018 (915) |
| One-Pak® Pkg. | K3142-3 | | | | | | To top of exhaust tube: 45.2 (1149) | — |
| Ready-Pak® Pkg. | K3143-3 | | 3 Ph/AC Power: 20,000 watts | | | | | — |
| | | | 1 Ph/AC Power: 12,000 watts | | | | | |
| | | | Compressor: 60 SCFM, 100 PSI | | | | | |

Dual Vantage® 700

The Power of Two!

- Work Twice as Fast – Two Arcs (up to 350 amps each) are Better Than One
- Arc Gouging Workhorse – Gouge Up to 1/2 in. (12.7 mm) carbon electrodes
- Protection from the Elements – Standard stainless steel roof, side panels and engine-access door



Processes

- Stick
- Flux-Cored
- MIG
- TIG
- Arc Gouging

Output



Input



Literature

E6.240.3

| Product Name | Product Number | Rated Output: Current/Voltage/Duty Cycle | Output Range | Engine | No. of Cylinders | HP & Speed (rpm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------------------|-----------------|---|---|--|------------------|------------------|--|--------------------------|
| Dual Vantage® 700 Base Model | K3996-2 | Single Mode: 600A/44V/100% 650A/40V/60% 700A/38V/40% | Single Mode: 30-700A CC/CV 20-250A DC TIG | Cummins® B3.3T Turbo-Charged Diesel | 4 | 69 @ 1860 | 36.9 x 28.5 x 77.0 (937 x 724 x 1956) | 2095 (950) approx. |
| One-Pak® Pkg. | K3996-2-One-Pak | Dual Mode (each side): 300A/32V/100% 325A/33V/60% 350A/34V/40% | Dual Mode: 30-400A CC/CV 20-250A DC TIG | EPA Tier 4i | | | To top of exhaust tube: 45.2 (1149) | — |
| Ready-Pak® Pkg. 1 | K3996-2-RP1 | | | | | | | — |
| Ready-Pak® Pkg. 3 | K3996-2-RP3 | | 3 Ph/AC Power: 20,000 watts | | | | | — |
| Ready-Pak® Pkg. 5 | K3996-2-RP5 | | 1 Ph/AC Power: 12,000 watts | | | | | — |



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Classic® 300 HE

One-Pak® Package [K2386-5]

- Classic® 300 HE
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [K2387-5]

- Includes everything above [K2386-5]

SAE-300® HE

One-Pak® Package [Kubota®] [K3956-5]

- SAE-300® HE w/o Wire Feed Module [K3201-1]
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [Kubota®] [K3959-5]

- Includes everything above [K3956-5]

One-Pak® Package [Perkins®] [K3957-5]

- SAE-300® HE w/o Wire Feed Module [K3201-1]
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

SAE-300® HE, con't.

Ready-Pak® Package [Perkins®] [K3960-5]

- Includes everything above [K3957-5]

SAE-300® MP

Ready-Pak® Package 2 [K4089-1-RP2]

- SAE-300® MP [K4089-1]
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch

Ready-Pak® Package 3 [K4089-1-RP3]

- Includes everything above [K4089-1-RP2]
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 1 [K4089-1-RP1]

- Includes everything above [K4089-1-RP3]
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- Work Cable 2/0, 50 ft. (15.2 m)
- 300A Electrode Holder
- 300A Work Clamp
- Cable Connectors, Qty. 2

One-Pak® Package [K4089-1-One-Pak]

- Includes everything above [K4089-1-RP1]



Shown:
Classic® 300 HE
One-Pak® Package



Shown:
SAE-300® HE
Ready-Pak® Package

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Vantage® 300

One-Pak® Package [K2452-5]

- Vantage® 300
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [K2453-5]

- Includes everything above [K2452-5]

Vantage® 400

One-Pak® Package [Perkins®] [K2508-7]

- Vantage® 400
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 400A Electrode Holder
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- 500A Work Clamp
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [Perkins®] [K2509-7]

- Includes everything above [K2508-7]

Vantage® 500 Compact Case

One-Pak® Package [Perkins®] [K3244-4]

- Vantage® 500
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 300A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- 300A Work Clamp
- Work Cable 2/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [Perkins®] [K2728-4]

- Includes everything above [K3244-4]

Vantage® 520 SD

Ready-Pak® Package 3 [K4138-12]

- Vantage® 520 SD [K4107-1]
- Medium 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 [K4138-129]

- Includes everything above [K4138-12]
- LoJack® Device

Ready-Pak® Package 1 [K4138-129]

- Includes everything in Package 3 [K4138-12]
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package [K4173-1]

- Includes everything in Package 1 [K4138-1]



Shown:
Classic® 300 HE
One-Pak® Package



Shown:
SAE-300® HE
Ready-Pak® Package



Shown:
Vantage® 400
Ready-Pak® Package



Shown:
Vantage® 500
Compact Case
One-Pak® Package

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Vantage® 600 SD

Ready-Pak® Package 3 [K4136-12]

- Vantage® 600 SD [K3239-1]
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 [K4136-129]

- Includes everything above [K4136-12]
- LoJack® Device

Ready-Pak® Package 1 [K4136-1]

- Includes everything in Package 3 [K4136-12]
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package [K3245-5]

- Includes everything above [K4136-1]

Air Vantage® 600 SD

Ready-Pak® Package 3 [K4137-12]

- Air Vantage® 600 SD [K3242-1]
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 6 [K4137-129]

- Includes everything above [K4137-12]
- LoJack® Device

Ready-Pak® Package 1 [K4137-1]

- Includes everything in Package 3 [K4137-12]
- Electrode Cable 3/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 3/0, 10 ft. (3.0 m)
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors, qty. 2
- 400A Electrode Holder
- 500A Work Clamp

One-Pak® Package [K3958-5]

- Includes everything above [K4137-1]

Air Vantage® 650

One-Pak® Package [K3142-3]

- Air Vantage® 650
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack
- 400A Electrode Holder
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, two 10 ft. (3.0 m)
- 500A Work Clamp
- Work Cable 3/0, 50 ft. (15.2 m)
- Cable Connectors

Ready-Pak® Package [K3143-3]

- Includes everything above [K3142-3]

Dual Vantage® 700

Ready-Pak® Package 3 [K3996-2-RP3]

- Dual Vantage® 700 [K3996-2]
- Large 2-Wheel Road Trailer & Duo-Hitch® Ball/Eye Hitch
- Fender and Light Kit
- Cable Rack

Ready-Pak® Package 1 [K3996-2-RP1]

- Includes everything above [K3996-2-RP3]
- Electrode Cable 2/0, two 50 ft. (15.2 m) lengths
- Electrode Cable 2/0, 10 ft. (3.0 m)
- Cable Connectors, Qty. 2
- 400A Electrode Holder
- Work/Power Lead ackage

Ready-Pak® Package 5 [K3996-2-RP5]

- Includes everything above [K3996-2-RP1]
- LoJack® Device

One-Pak® Package [K3996-2-One-Pak]

- Includes everything in Package 1 [K3996-2-RP1]



Shown:
Air Vantage® 650
Ready-Pak® Package



Shown:
Dual Vantage® 700
Ready-Pak® Package

Accessories

| Product Name | Product No. | Classic® 300 HE | | SAE-300® HE | | Classic® 300 MP | | SAE-300® MP | | Cross Country™ 300 | | Vantage® 300 | | Vantage® 400 | | SAE-500® | | SAE-500® Severe Duty™ | | Vantage® 500 Compact Case | | Vantage® 520 SD | | Vantage® 600 SD | | Air Vantage® 600 SD | | Air Vantage® 650 | | Dual Vantage® 700 | |
|---|---------------|-----------------|---------------------|---------------------|----------------------|-----------------|------------|-------------|------------|--------------------|---------------------|----------------------|------------|---------------------|----------------------|------------|------------|-----------------------|------------|---------------------------|------------|-----------------|------------|-----------------|------------|---------------------|------------|------------------|------------|-------------------|--|
| | | Base Model | Base Model (Kubota) | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| STICK | | K3198-1 | K3201-1 | K3201-2 (WF Module) | K3202-1 | K4263-1 | K4089-1 | K4166-1 | K2409-4 | K2711-2 | K2410-4 | K4053-1 | K3955-1 | K2686-2 | K4107-1 | K3239-1 | K3242-1 | K2961-1 | K3996-2 | | | | | | | | | | | | |
| Accessory Kit, 400 Amp | K704 | • | • | • | • | • | • | | • | • | • | • | • | • | | | | | | | | | | | | | | | | | |
| Remote Output Control, 25 ft (7.6 m), 6-pin connector | K857 | | | | | | | | • | • | • | | | • | • | • | • | • | | | | | | | | | | | | | |
| Remote Output Control, 100 ft (30 m), 6-pin connector | K857-1 | | | | | • | • | • | • | • | • | | | • | • | • | • | • | | | | | | | | | | | | | |
| Remote Output Control, 25 ft (7.6 m), 12-pin connector | K857-2 | | | | | | | | | | | | | • | • | • | • | • | | | | | | | | | | | | | |
| Remote Control Kit, 100 ft (30.5 m) | K924-4 | • | • | • | • | • | | | | | | • | ○ | | | | | | | | | | | | | | | | | | |
| Remote Output Control w/120V AC, 100 ft (30.5 m), 20 amp capacity | K2627-2 | | | | | | | • | • | • | • | | | • | • | • | • | • | | | | | | | | | | | | | |
| TIG | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Pro-Torch™ TIG Torch PTA-26V, 25 ft (7.6 m), 2 pc | K1783-9 | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | | | | | | | | | | | | | |
| Parts Kit For PTW-18 and PTA-26 Series Torches | KP509 | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | | | | | | | | | | | | | |
| Control Cable (9-pin to 115V plug) | K936-4 | • | • | • | • | • | • | | | | | • | • | | | | | | | | | | | | | | | | | | |
| Control Cable Extension, 45 ft (13.7 m) | K937-45 | • | • | • | • | • | • | | | | | • | • | | | | | | | | | | | | | | | | | | |
| Arc Start™ Switch | K814 | • | • | • | • | • | • | | | | | • | • | | | | | | | | | | | | | | | | | | |
| Contact Kit | K938-1 | • | • | • | • | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Foot Amptrol™ | K870 | | | | | • | • | • | • | • | • | | | • | • | • | • | • | | | | | | | | | | | | | |
| Hand Amptrol™ (Rotary Track Style) | K963-3 | | | | | • | • | • | • | • | • | | | • | • | • | • | • | | | | | | | | | | | | | |
| TIG Module | K930-2 | • | • | • | • | • | • | | | | | • | • | | | | | | | | | | | | | | | | | | |
| Square Wave™ TIG 175 | K1478-5 | | | | | | | | • | • | • | | | • | | | | | | | | | | | | | | | | | |
| Invertec® V205-T AC/DC One-Pak® | K2350-2 | | | | | | | | • | • | • | | | • | | | | | | | | | | | | | | | | | |
| MULTI-PROCESS | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Invertec® V350 PRO Multi-Process Welder (Construction Model) | K1728-5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| WIRE FEEDER | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Wire Feed Module | K3964-1 | • | • | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Remote Control Kit, 100 ft (30.5 m) | K2464-1 | • | • | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| K126™ PRO Innershield® Gun, .062-3/32, 15 ft (4.6 m) | K126-11 | | | | | | | | • | | | | | | | | | | | | | | | | | | | | | | |
| K126™ PRO Innershield® Gun, 1/16-5/64, 15 ft (4.6 m) | K126-12 | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | | | | | | | | | | | | | |
| Magnum® PRO 350 Ready-Pak®, 15 ft (4.6 m), 0.035-5/64 in. (0.9-2.0 mm) (Includes K466-10 Connector Kit) | K2652-2-10-45 | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | | | | | | | | | | | | | |

○ Included ● Optional

Accessories

| Product Name | Product No. | | | | | | | | | | | | | | | | | | |
|--|-------------|-----------------|---------------------|---------------------|----------------------|--------------------|--------------|--------------|------------|-----------------------|---------------------------|-----------------|-----------------|---------------------|------------------|-------------------|------------|---------|---------|
| | | Classic® 300 HE | SAE-300® HE | Classic® 300 MP | SAE-300® MP | Cross Country™ 300 | Vantage® 300 | Vantage® 400 | SAE-500® | SAE-500® Severe Duty™ | Vantage® 500 Compact Case | Vantage® 520 SD | Vantage® 600 SD | Air Vantage® 600 SD | Air Vantage® 650 | Dual Vantage® 700 | | | |
| | | Base Model | Base Model (Kubota) | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | | |
| | | K3198-1 | K3201-1 | K3201-2 (WF Module) | K3202-1 | K4263-1 | K4089-1 | K4166-1 | K2409-4 | K2711-2 | K2410-4 | K4053-1 | K3955-1 | K2686-2 | K4107-1 | K3239-1 | K3242-1 | K2961-1 | K3996-2 |
| WIRE FEEDER, CON'T | | | | | | | | | | | | | | | | | | | |
| Gun Receiver Bushing for Lincoln Electric Guns | K1500-1 | | | | | | | • | | | | | | | | | | | |
| Gun Receiver Bushing for Tweco® #2 - #4 Guns | K1500-2 | | | | | | | • | | | | | | | | | | | |
| Drive Roll Kit, 0.068-0.072 in. (1.7-1.8 mm) Cored/Solid | KP1697-068 | • | • | • | • | • | • | | • | • | • | • | • | • | • | • | • | • | |
| Drive Roll Kit, 0.035 in. and 0.045 in. (0.9 and 1.1 mm) Solid | KP1696-1 | • | • | • | • | • | • | | • | • | • | • | • | | | | | • | |
| CV Adapter (with MS-Type connection, local/remote switch) | K385-2 | | | | | | | | | | | • | • | | | | | | |
| Heavy Duty ArcLink® Control Cable, 25 ft (7.6 m) | K2683-25 | | | | | | | | | | | | | • | • | • | | | |
| Heavy Duty ArcLink® Control Cable, 50 ft (15.0 m) | K2683-50 | | | | | | | | | | | | | • | • | • | | | |
| Heavy Duty ArcLink® Control Cable, 100 ft (30.5 m) | K2683-100 | | | | | | | | | | | | | • | • | • | | | |
| Work and Wire Feeder 2/0 Weld Package | K1803-2 | | | | | | | • | | | | | | | | | | | |
| Tweco® Style Cam-Lock Adapter Plug for Work and Electrode Cables | K2946-1 | | | | | | | • | | | | | | | | | | | |
| Electrode Cable 2/0, 50 ft (15.0 m) | K2485-2 | | | | | | | • | | | | | | | | | | | |
| Electrode Cable 3/0, 50 ft (15.0 m) | K2485-3 | | | | | | | • | | | | | | | | | | | |
| LN-8 Pipe Wire Feeder | K297 | | | | | | | | | | | | | | | • | • | • | • |
| LN-25 Pipe Wire Feeder | K2614-5 | | • | • | • | • | • | • | | | | | | | | | | | |
| LN-25 Ironworker® Wire Feeder | K2614-9 | • | | | | | | | • | • | • | • | • | • | • | • | • | • | • |
| Power Feed® 25M Wire Feeder, Aluminum Case | K2536-8 | | | | | | | | | | | | | | • | • | • | | |
| Power Feed® 25M Wire Feeder, Plastic Case | K2536-5 | | | | | | | | | | | | | | • | • | • | | |
| SPOOL GUN | | | | | | | | | | | | | | | | | | | |
| Magnum® SG Spool Gun, Air-Cooled, w/Remote, 25 ft (7.6 m) | K487-25 | • | • | • | • | • | • | | • | • | • | | | • | • | • | • | • | • |
| SG Control Module | K488 | • | • | • | • | • | • | | • | • | • | | | • | • | • | • | • | • |
| Control Module Input Cable, 14-pin MS-type & Lug, 10 ft (3.0 m) | K691-10 | • | • | • | • | • | • | | • | • | • | | | • | • | • | • | • | • |
| PLASMA CUTTING | | | | | | | | | | | | | | | | | | | |
| Tomahawk® 1000 | K2808-1 | | | | | | | | • | • | • | | | • | | | | • | • |

• Optional

Accessories

| Product Name | Product NO. | | | | | | | | | | | | | | | | | | |
|---------------------------------|-------------|-----------------|---------------------|---------------------|----------------------|--------------------|--------------|--------------|------------|-----------------------|---------------------------|-----------------|-----------------|---------------------|------------------|-------------------|------------|---------|---------|
| | | Classic® 300 HE | SAE-300® HE | Classic® 300 MP | SAE-300® MP | Cross Country™ 300 | Vantage® 300 | Vantage® 400 | SAE-500® | SAE-500® Severe Duty™ | Vantage® 500 Compact Case | Vantage® 520 SD | Vantage® 600 SD | Air Vantage® 600 SD | Air Vantage® 650 | Dual Vantage® 700 | | | |
| | | Base Model | Base Model (Kubota) | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model (Kubota) | Base Model (Perkins) | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | | |
| | | K3198-1 | K3201-1 | K3201-2 (WF Module) | K3202-1 | K4263-1 | K4089-1 | K4166-1 | K2409-4 | K2711-2 | K2410-4 | K4053-1 | K3955-1 | K2686-2 | K4107-1 | K3239-1 | K3242-1 | K2961-1 | K3996-2 |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | | | | | | | |
| Classic® 300 HE | X3198 | • | | | | | | | | | | | | | | | | | |
| SAE-300® HE (Kubota) | X3201 | | • | • | | | | | | | | | | | | | | | |
| SAE-300® HE (Perkins) | X3202 | | | | • | | | | | | | | | | | | | | |
| Classic® 300 MP | X4263 | | | | | • | | | | | | | | | | | | | |
| SAE-300® MP | X4089 | | | | | | • | | | | | | | | | | | | |
| Cross Country™ 300 | X4166 | | | | | | | • | | | | | | | | | | | |
| Vantage® 300 | X2409 | | | | | | | | • | | | | | | | | | | |
| Vantage® 400 (Kubota) | X2711 | | | | | | | | | • | | | | | | | | | |
| Vantage® 400 (Perkins) | X2410 | | | | | | | | | | • | | | | | | | | |
| SAE-500® | X1278 | | | | | | | | | | | • | | | | | | | |
| SAE-500® Severe Duty | X1278 | | | | | | | | | | | | • | | | | | | |
| Vantage® 500 Compact Case | X2686 | | | | | | | | | | | | | • | | | | | |
| Vantage® 520 SD | X4107 | | | | | | | | | | | | | | • | | | | |
| Vantage® 600 SD | X3239 | | | | | | | | | | | | | | | • | | | |
| Air Vantage® 600 SD | X3242 | | | | | | | | | | | | | | | | • | | |
| Air Vantage® 650 | X2961 | | | | | | | | | | | | | | | | | • | |
| Dual Vantage® 700 | X3996 | | | | | | | | | | | | | | | | | | • |

• Optional



SEMIAUTOMATIC WIRE FEEDERS

| MODEL | OUTPUT | | | PROCESS | | | | FEATURES | | | | |
|---|--|---|---|---------|------------|----------|------------|---------------|----------------------------|--------------|--------------|-----------------|
| | Wire Feed Speed Range ipm (m/min) High Speed Low Speed | Solid Wire Size Range: in (mm) High Speed Low Speed | Cored Wire Size Range: in (mm) High Speed Low Speed | MIG | Pulsed MIG | MIG-STT® | Flux-Cored | Submerged Arc | MAXTRAC® Wire Drive System | 2-Roll Drive | 4-Roll Drive | Digital Display |
| BENCH AND BOOM MODELS ANALOG | | | | | | | | | | | | |
| LF-72 | 50-800 (1.3-20.3) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | | ● | | ● | ● | | |
| LF-74 | 100-800 (2.5-20.3) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | | ● | | ● | | ● | |
| LN-8 | 50-600 (1.3-15.2) | 0.040-3/32 (1.0-2.4) | 0.045-0.120 (1.2-3.0) | ● | | | ● | ● | | ● | | |
| LN-9 | 50-600 (1.3-15.2) | 0.040-3/32 (1.0-2.4) | 0.045-0.120 (1.2-3.0) | ● | | | ● | ● | | ● | | ● |
| FlexFeed™ 74 HT | 50-700 (1.3-12.7) | 0.025-3/32 (0.6-2.4) | 0.035-0.120 (0.9-3.0) | ● | | | ● | ● | ● | | ● | ● |
| ARCLINK® | | | | | | | | | | | | |
| Power Feed® 84 and Power Feed® 84 Dual ⁽¹⁾ | 50-700 (1.3-19.0) 50-500 (1.3-12.7) | 0.025-1/16 (0.6-1.6) 0.025-3/32 (0.6-2.4) | 0.035-5/64 (0.9-2.0) 0.035-0.120 (0.9-3.0) | ● | ● | ● | ● | | ● | | ● | ● |
| FIELD MODELS ANALOG | | | | | | | | | | | | |
| Activ8™ | 50-800 (1.3-20.3) | 0.023-0.052 (0.6-1.3) | 0.035-5/64 (0.9-2.0) | ● | ● | | ● | | ● | ● | | |
| LN-23P | 30-170 (0.76-4.3) | 0.023-0.052 (0.6-1.3) | 0.068-5/64 (1.7-2.0) | | | | ● | | | ● | | |
| LN-25 PRO Standard | 50-700 (1.3-17.7) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | | ● | | ● | ● | | |
| LN-25 PRO Extra Torque | 50-400 (1.3-10.1) | 0.023-1/16 (0.6-1.6) | 0.030-3/32 (0.8-2.4) | ● | ● | | ● | | ● | ● | | |
| LN-25 PRO Dual Power | 50-700 (1.3-17.7) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | ● | ● | | ● | ● | | ● |
| LN-25 Pipe | 50-700 (1.3-17.7) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | | ● | | ● | ● | | ● |
| LN-25 Ironworker® | 50-700 (1.3-17.7) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | ● | | ● | | ● | ● | | ● |
| LN-25X w/CrossLinc™ Technology | 50-700 (1.3-17.7) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) | ● | | | ● | | ● | ● | | ● |
| ARCLINK® | | | | | | | | | | | | |
| Power Feed® 25M | 50-800 (1.3-20.3) 30-400 (0.76-10.1) | 0.023-1/16 (0.6-1.6) | 0.030-5/64 (0.8-2.0) 0.030-3/32 (0.8-2.4) | ● | ● | ● | ● | | ● | ● | | ● |
| Power Feed® 25M Aluminum | 50-800 (1.3-20.3) 30-400 (0.76-10.1) | 0.023-1/16 (0.6-1.6) | — | ● | ● | | | | ● | ● | | ● |

Activ8®

Get Tough and Get Moving

- Small size and weight makes it easy to fit through ship manways and move around job sites
- Compatible with compact 8 in (203 mm) wire spools
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.61

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------|----------------|---------------------------------|--|-------------------------------------|-------------------------------|-------------------------------------|-----------------|
| Activ8® Base Model | K2999-1 | 15-110V DC | 330A/60% | 50-800 (1.3-20.3) | GMAW: 0.23-0.52 (0.6-1.3) | 11.8 x 7.6 x 19.8 (298 x 193 x 503) | 27 (12.2) |
| One-Pak® Pkg. | K3289-1 | | | | FCAW: 0.035-5/64 (0.9-2.0) | | |

LN-23P

Tough. Proven. Reliable.

- Equipped with trigger interlock circuit to reduce operator fatigue
- Gun-mounted two-position switch allows on-the-fly change to 83% of the preset wire feed speed
- Completely enclosed wire reel keeps the wire free of contaminants
- Ideal for self-shielded flux-cored welding on pipelines and other extreme worksites



Processes

- Flux-Cored

Output



Input



Literature

E8.90

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|--|-------------------------------------|-------------------------|---------------------------------|-----------------|
| LN-23P | K316L-7 | 14-50V DC (90V DC Max. OCV) | 350A/60% | 30-170 (0.8-4.3) | 0.068-5/64 (1.7-2.0) | 20.5 x 9 x 19 (520 x 230 x 480) | 27 (12.3) |

LN-25 PRO Standard

Simplicity and Reliability

- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------------|----------------|---------------------------------|--|-------------------------------------|---|--------------------------------------|-----------------|
| LN-25 PRO ⁽¹⁾ Standard | K2613-5 | 15-110V DC | 450A/60% | 50-700 (1.3-17.7) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

⁽¹⁾Includes a Flow Meter

LN-25 PRO Extra Torque

For Larger Wire Diameters on Thicker Material

- Extra Torque model allows up to 3/32 in. (2.4 mm) wire diameter welding
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------------|----------------|---------------------------------|--|-------------------------------------|---|--------------------------------------|-----------------|
| LN-25 PRO ⁽¹⁾ Extra Torque | K2613-7 | 15-110V DC | 450A/60% | 30-400 (0.8-10.1) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

⁽¹⁾Includes a Flow Meter

LN-25 PRO Dual Power

Extend Your Process Capabilities

- Dual Power model features across-the-arc and control cable power and includes remote control capability and digital display for amps and wire feed speed
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Standard CC/CV switch, trigger interlock and flow meter
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- MIG-STT®
- Pulsed
- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

⁽²⁾Control Cable

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|-------------------------------------|---|--------------------------------------|-----------------|
| LN-25 PRO ⁽¹⁾ Dual Power | K2614-6 | 15-110V DC or 24-42V AC | 450A/60% | 50-700 (1.3-17.7) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

⁽¹⁾Includes a Flow Meter

LN-25 Pipe

Ready for Innershield® Pipe Welding

- This specialized version includes a 14 lb. (6.4 kg) coil adapter, 5/64 in. (2.0 mm) drive rolls and guide tubes, has the WFS range preset to Low and does not include a flowmeter
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- Flux-Cored

Output



Input



Literature

E8.101

⁽¹⁾Across-the-Arc

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|--|-------------------------------------|---|--------------------------------------|-----------------|
| LN-25 Pipe | K2614-5 | 15-110V DC | 450A/60% | 50-700 (1.3-17.7) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

LN-25 Ironworker®

Pro Features. Faster Feed.

- The Ironworker version includes 5/64 in. (2.0 mm) drive rolls and guide tubes, has the WFS range preset to High and does not include a flowmeter
- Dual range wire feed speed delivers greater precision at low-end wire feed speeds
- Tough plastic case molded from impact-resistant flame-retardant material
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- Flux-Cored

Output



Input



Literature

E8.101

¹⁾ Across-the-Arc

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range: imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|---------------------------------|--|------------------------------------|---|-----------------------------------|-----------------|
| LN-25 Ironworker® | K2614-9 | 15-110V DC | 450A/60% | 50-700 (1.3-17.7) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

LN-25X with CrossLinc™ Technology

Full Control. Fewer Cables.

- Reduce job site clutter and eliminate unnecessary movement of personnel around the site
- Full voltage control at the feeder results in the correct settings for every weld and allows the operator to accurately compensate for voltage drop across long cable runs
- Set up faster and eliminate trips to the power source to make adjustments
- Fully encapsulated and environmentally protected electronics



Processes

- MIG
- Flux-Cored

Output



Input



Literature

E8.107.1

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range: imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------------|----------------|---------------------------------|--|------------------------------------|---|-----------------------------------|-----------------|
| LN-25X with CrossLinc™ Technology | K4267-1 | 15-110V DC | 450A/60% | 50-700 (1.3-17.7) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) ALUMINUM: 0.035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 37 (16) |

Power Feed® 25M

Advanced Process Control.
Portable Design.

- Mode select panel enables easy access to the Power Wave® library of waveforms
- Internal LED lighting illuminates the wire drive, while internal heating controls humidity around the welding wire
- Dual procedure and user memory presets allow the operator to set A/B procedures and easily recall custom welding modes for common applications
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

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

Output



Input



Literature

E8.271

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Duty Cycle/Gearing | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------------|----------------|---------------------------------|---|--|--|--|-----------------|
| Power Feed® 25M Aluminum Case | K2536-8 | 40V DC | 500A/60% GEARING: Standard Speed (factory setting) | SOLID: 50-800 (1.3-20.3) CORED: 50-800 (1.3-20.3) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) | 14.5 x 8.5 x 23.5 (368 x 216 x 597) | 35 (15.9) |
| Plastic Case | K2536-5 | | 500A/60% GEARING: Extra Torque | SOLID: 30-400 (0.8-10.2) CORED: 30-400 (0.8-10.2) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4) | | |

Power Feed® 25M Aluminum

Advanced Aluminum Control.

- Push-pull capability maximizes performance on aluminum by ensuring uniform feeding
- Mode select panel enables easy access to the Power Wave® library of aluminum waveforms
- Internal LED lighting illuminates the wire drive, while internal heating controls humidity around the welding wire
- Dual procedure and user memory presets allow the operator to set A/B procedures
- Optimize gas delivery for aluminum process
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

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

Output



Input



Literature

E8.271

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Duty Cycle/Gearing | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------------|----------------|---------------------------------|---|--|--|--|-----------------|
| Power Feed® 25M Aluminum | K4191-1 | 40V DC | 500A/60% GEARING: Standard Speed (factory setting) | SOLID: 50-800 (1.3-20.3) CORED: 50-800 (1.3-20.3) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) | 14.5 x 8.5 x 23.5 (368 x 216 x 597) | 35 (15.9) |
| | | | 500A/60% GEARING: Extra Torque | SOLID: 30-400 (0.8-10.2) CORED: 30-400 (0.8-10.2) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-3/32 (0.8-2.4) | | |

LF-72

Wire Feed Consistency

- Two roll industrial shop wire feeder available in multiple configurations for boom or bench mounting
- Brass-to-brass gun connections for better electrical conductivity that results in better arc performance
- Calibrated wire feed speed dial ensures precise and accurate settings
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E8.11

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range: imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|------------------------------------|--|---|-----------------|
| LF-72 Base Model (w/o gun or cable) | K2327-8 | 24-42V AC 50/60 Hz 9 Amps | 500A/60% | 50-800 (1.3-20.3) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) | 11.1 x 10.2 x 12.9 (282 x 259 x 328) | 24 (11) |
| Bench Model Standard Duty | K2327-9 | | | | | 12.6 x 10.9 x 22.5 (320 x 277 x 574) | 52 (24) |
| Bench Model Heavy Duty | K2327-6 | | | | | 15.3 x 13.0 x 27.7 (389 x 330 x 704) | 69 (31) |
| Bench Model Heavy Duty (w/o gun) | K2327-7 | | | | | 15.3 x 13.0 x 27.7 (389 x 330 x 704) | 63 (29) |

LF-74

Four Roll Feeding for Longer Runs

- Four roll industrial shop wire feeder recommended for larger diameter wires, longer gun cables or long boom conduits
- Brass-to-brass gun connections for better electrical conductivity that results in better arc performance
- Calibrated wire feed speed dial ensures precise and accurate settings
- Cast aluminum MAXTRAC® Wire Drive enables quick tool-less drive roll changes and smooth, steady wire feeding



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E8.11

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range: imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|---------------------------------|--|------------------------------------|--|---|-----------------|
| LF-74 Base Model | K2426-6 | 24-42V AC 50/60 Hz 9 Amps | 600A/60% | 50-800 (1.3-20.3) | SOLID: 0.023-1/16 (0.6-1.6) CORED: 0.030-5/64 (0.8-2.0) | 11.1 x 10.2 x 12.9 (282 x 259 x 328) | 27 (12) |
| Bench Model Heavy Duty | K2426-7 | | | | | 15.3 x 13.0 x 27.7 (389 x 330 x 704) | 63 (29) |

LN-8

Reliable Wire Feeding in any Environment

- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|--|-------------------------------------|--|---------------------------------------|-----------------|
| LN-8 | K297 | 115V AC 50/60 Hz | 600A/60% | 50-600 (1.3-15.2) | SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 (2.8) | 10.9 x 9.8 x 9.6 (277 x 248 x 244) | 36 (16.3) |

LN-9

Semiautomatic Feed for Larger Wire

- LN-9 includes a digital meter that can be set to display voltage or wire feed speed
- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|--|-------------------------------------|--|---|-----------------|
| LN-9 | K357-1 | 115V AC 50/60 Hz | 600A/60% | 50-600 (1.3-15.2) | SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 (2.8) | 11.5 x 11.3 x 11.5 (292 x 287 x 292) | 42 (19) |

Flex Feed® 74 HT

High-Torque, High Performance

- Select models include contactors to electrically isolate the gouging stud
- 2-step trigger interlock enhances operator comfort for longer welds
- Feed plate can be located on either right or left side of the weld drive housing for easy integration into any work center



Processes

- MIG
- Flux-Cored
- Hand-Held SAW
- Gouging (CCAG) - with gouging option installed

Output



Input



Literature

E8.203

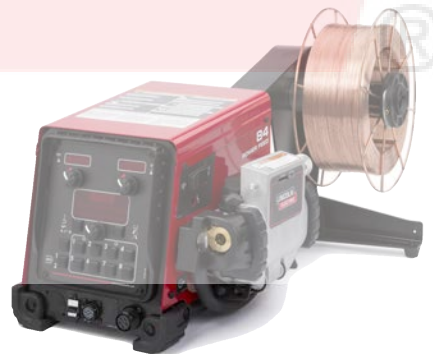
| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------|----------------|---------------------------------|--|---|---|--|-----------------|
| Flex Feed™ 74 HT MIG Package | K3883-5 | 24-42V AC 50/60 Hz | 600A/60% (wire drive only) | 20 TOOTH ⁽¹⁾ : 50-500 (1.3-12.7) | SOLID: 0.025-3/32 (0.6-2.4) 0.025-1/16 (0.6-1.6) | 13.3 x 15.5 x 23.6 (338 x 394 x 599) wire drive only | 47 (21) |
| Advanced MIG Package | K4163-1 | | 500A/60% (wire drive w/gouging kit) | 30 TOOTH : 50-700 (1.3-19.0) | CORED: 0.035-0.120 (0.9-3.0) 0.035-5/64 (0.9-2.0) | 25.2 x 15.5 x 27.9 (640 x 394 x 709) | 55 (25) |
| Structural Steel Package | K3883-13 | | 600A/30% (gouging stud) | | | | 63 (29) |
| Heavy Fab One-Pak® Pkg. | K3883-15 | | | | | | 75 (34) |

⁽¹⁾Installed from factory

Power Feed® 84

Advanced Multi-Process Digital Control

- Includes eight user memories for complete WPS recall and a USB port to transfer memory data
- Feed plate (Power Feed® 84) can be located on either right or left side of the wire drive housing for easy integration into any work environment
- Advanced interface includes Auto-Settings to simplify process set up
- ArcLink® digital communications protocol enables fast, advanced communication with any ArcLink®-enabled welding power source



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging (CCAG)

Output



Input



Literature

E8.268

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------------|----------------|---------------------------------|--|---|---|---|-----------------|
| Power Feed® 84 Single Bench Model | K4164-1 | 40V DC | 600A/60% (wire drive only) | 20 TOOTH ⁽¹⁾ : 50-750 (1.3-19.0) | SOLID ⁽²⁾ : 0.025-3/32 (0.6-2.4) | 25.2 x 15.5 x 27.9 (640 x 394 x 709) single wire drive only | 62 (28.1) |
| | | | 500A/60% (wire drive w/gouging kit) | 30 TOOTH : 50-1200 (1.3-30.4) | CORED ⁽²⁾ : 0.035-0.120 (0.9-3.0) | | |
| | | | 600A/30% (gouging stud) | | | | |

⁽¹⁾Installed from factory. ⁽²⁾Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear

Power Feed® 84 Dual

Advanced Multi-Process Digital Control

- Includes eight user memories (16 for Dual) for complete WPS recall and a USB port to transfer memory data
- Feed plate (Power Feed® 84) can be located on either right or left side of the wire drive housing for easy integration into any work environment
- Advanced interface includes Auto-Settings to simplify process set up
- ArcLink® digital communications protocol enables fast, advanced communication with any ArcLink®-enabled welding power source



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Stick
- TIG
- Gouging (CCAG)

Output



Input



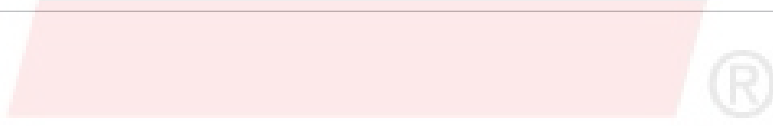
Literature

E8.268

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Wire Feed Speed Range : imp (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|---|--|---|---|-----------------|
| Power Feed® 84 Dual Bench Model | K3330-5 | 40V DC | 600A/60% (w/o PowerPath™ contactors) 500A/60% (wire drive w/gouging kit) | 20 TOOTH ⁽¹⁾ : 50-750 (1.3-19.0) 30 TOOTH : 50-1200 (1.3-30.4) | SOLID ⁽²⁾ : 0.025-3/32 (0.6-2.4) CORED ⁽²⁾ : 0.035-0.120 (0.9-3.0) | 25.2 x 22.5 x 30.6 (640 x 572 x 777) dual wire drive only | 64 (29.0) |

⁽¹⁾Installed from factory

⁽²⁾Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear



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See pages 36 and 95 for product information.



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What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Activ8®

Required Accessories for all models

- Weld Power Cable
- Coaxial Weld Power Cable
- Drive Roll and Wire Guide Kit

Base Model (K2999-1)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- Gun Bushing

One-Pak® Package (K3289-1)

- Magnum® PRO Curve™ 300 Ready-Pak®

LN-23P

Required Accessories for all models

- Magnum® Self-Shielded Gun and Cable Assembly
- Adapter Kit (K350) for Terminal Strip Connection
- Adapter Kit (K350-1) for 14-pin MS-Type Connection

Base Model (K316L-7)

- Control Cable, 25 ft. (7.6 m)
- 1/0 Electrode Cable, 25 ft. (7.6 m)
- Drive Rolls and Guide Tubes, 3/32 in. (2.4 mm)

LN-25 PRO Standard

Base Model (K2613-5)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 PRO Extra Torque

Base Model (K2613-7)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 PRO Dual Power

Base Model (K2614-6)

- Internal Contactor
- Gas Solenoid
- Flow Meter
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)

LN-25 Pipe

Base Model (K2614-5)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-400 ipm)
- 14 lb. Innershield® coil adapter

LN-25 Ironworker®

Base Model (K2614-9)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-700 ipm)

LN-25X with CrossLinc™ Technology

Base Model (K4267-1)

- Internal Contactor
- Gas Solenoid
- Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- 2 Gun Bushings (K1500-2 installed; K1500-1 loose)
- 5/64 in. (2.0 mm) cored wire drive rolls and guide kit
- Variable WFS range set at factory to low (50-700 ipm)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Power Feed® 25M

Base Model, Aluminum Case (K2536-8)

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

Base Model, Plastic Case (K2536-5)

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

Power Feed® 25M Aluminum

Base Model (K4191-1)

- Electrode Pigtail
- Mode Select Panel
- Push-Pull Gun Connector
- Remote Control Connector
- Gun Receiver Bushing
- Standard & Extra Torque Gearing

LF-72

Required Accessories for all models

- Weld Power Cable

Base Model w/o Gun or Cable (K2327-8)

- 0.035/0.045 in. (0.9/1.1 mm) Drive Rolls & Cable

Bench Model, Standard Duty (K2327-9)

- Magnum® PRO 350 Gun & Cable, 15 ft. (4.6 m)
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Standard Duty Wire Reel Stand
- 44 lb. (20 kg) Wire Package, Max.

Bench Model, Heavy Duty (No Gun) (K2327-7)

- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

Bench Model, Heavy Duty (K2327-6)

- Magnum® PRO 350 Gun & Cable, 15 ft. (4.6 m)
- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Roll & Guide Kit
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

LF-74

Required Accessories for all models

- Weld Power Cable

Base Model (K2426-6)

- Control Cable
- 0.035/0.045 in. (0.9/1.1 mm) Solid Wire Drive Rolls & Guide Kit

Bench Model, Heavy Duty (K2426-7)

- Everything listed above
- Heavy Duty Wire Reel Stand
- 60 lb. (27.2 kg) Wire Package, Max.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

LN-8

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LN-9

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

Flex Feed™ 74 HT

Required Accessories for all models

- Drive Roll Kits
- Control Cable
- Weld Power Cable

MIG Package Model [K3883-5]

- Basic User Interface
- Standard Duty Reel Stand
- Control Cable

Advanced MIG Package Model [K4163-1]

- Digital User Interface
- Heavy Duty Reel Stand
- Control Cable
- Lift Bail

Structural Steel Package Model [K3883-13]

- Basic User Interface
- Heavy Duty Reel Stand
- Control Cable
- Gouge Kit
- Lift Bail

Heavy Fab One-Pak® Package [K3883-15]

- Everything listed above [K3883-13]
- Magnum® PRO Curve™ 300 Gun

Power Feed™ 84

Required Accessories for all models

- Drive Roll Kits
- Control Cable

Single Bench Model [K4164-1]

- Single Wire Drive
- Heavy Duty Wire Reel Stand
- USB
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 8 ft. (2.4 m)
- Hardwired Control Cable, 10 ft. (3.0 m)

Power Feed™ 84 Dual

Required Accessories for all models

- Drive Roll Kits
- Control Cable

Dual Bench Model [K3330-5]

- Dual Wire Drive
- Heavy Duty Wire Reel Stand
- USB
- Contactors
- #2-#4 Gun Adapter
- 30-tooth Pinion Gear
- Control Cable, 8 ft. (2.4 m)
- Hardwired Control Cable, 10 ft. (3.0 m)



Accessories

| Product Name | Product No. | Activ8® | LN-23P | LN-25 PRO Standard | LN-25 PRO Extra Torque | LN-25 PRO Dual Power | LN-25 Pipe | LN-25 Ironworker® | LN-25X w/ CrossLinc™ Technology | Power Feed™ 25M | Power Feed™ 25M Aluminum |
|---|-------------|------------|------------|--------------------|------------------------|----------------------|------------|-------------------|---------------------------------|-----------------------|--------------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model Alum. Case | Base Model Plastic case |
| REQUIRED (see charts in Accessories Section) | | | | | | | | | | | |
| Weld Power Cables | — | • | | • | • | • | • | • | • | • | • |
| Coaxial Weld Power Cables | — | • | | | | | | | | • | • |
| Drive Roll and Wire Guide Kits | — | • | | • | • | • | • | • | • | • | • |
| Drive Roll and Guide Tube Kits | — | | | | | | | | | | |
| Control Cables and Adapters | — | | | • | • | • | • | • | • | | |
| Push-Pull Guns | — | | | | | | | | | • | • |
| ArcLink®/Linc-Net™ Control Cables | — | | | | | | | | | • | • |
| 350A FCAW-SS Gun, 10 ft. (3.0 m), 0.068-5/64 in. (1.7-2.0 mm) | K345-10 | • | | | | | | | | | |
| GENERAL | | | | | | | | | | | |
| Gun Receiver Bushing | K1500-1 | • | | • | • | • | • | • | • | • | • |
| Gun Receiver Bushing | K1500-2 | • | | • | • | • | • | • | • | • | • |
| Magnum® 550 Gun Adapter | K1500-3 | • | | • | • | • | • | • | • | • | • |
| Miller® Gun Receiver Bushing | K1500-4 | • | | • | • | • | • | • | • | • | • |
| OXO® Gun Receiver Bushing | K1500-5 | • | | • | • | • | • | • | • | • | • |
| Dual Schedule Fast-Mate Adapter™ 10 Series | K489-7 | • | | • | • | • | • | • | • | • | • |
| Plastic Case | K3061-1 | • | | | | | | | | | |
| Work and Wire Feeder 2/0 Weld Cable, 10 ft. (3.0 m) Package | K1803-1 | • | | | | | | | | | |
| Twist Mate™ Cable Plug, For 2/0-3/0, 70-95 mm² cable | K852-95 | • | | • | • | • | • | • | • | | |
| Tweco®-Style Adapter Plug | K2946-1 | • | | | | | | | | | |
| Jumper Plug Kit | K484 | • | | • | • | • | • | • | • | | |
| GC-300 Work Clamp | K910-1 | • | | | | | | | | | |
| GC-500 Work Clamp | K910-2 | • | | | | | | | | | |
| Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m) | K586-1 | • | | | | | | | | • | • |
| Wire Feed Speed Meter Kit (LN-8) | K261 | | | | | | | | | | |
| Portable Digital Wire Feed Speed Meter | K283 | • | | | | | | | | | |
| Incoming Bushing for Lincoln® Conduit, 0.025-1/16 in. (0.6-1.6 mm) wire | K1546-1 | | | | | | | | | | |
| Incoming Bushing for Lincoln® Conduit, 1/16-1/8 in. (1.6-3.2 mm) wire | K1546-2 | • | | | | | | | | | |
| Inlet Bushing, quick connect style | K3929-1 | | | | | | | | | | |
| Flow Meter Kit | K3156-1 | • | | | | | | | | | |
| LN-23P Adapter Kit, For Terminal Strip Connection | K350 | | • | | | | | | | | |
| LN-23P Adapter Kit, For 14-pin Connection | K350-1 | | • | | | | | | | | |
| Adapter for Competitive Power Sources | K2335-1 | | | • | • | • | • | • | • | | |
| Preflow, Postflow and Burnback Timer Kit | K2330-2 | | | • | • | • | • | • | • | | |
| 14 lb. (6.4 kg) Innershield Coil Adapter | K435 | | | • | • | • | • | • | • | | |
| 8 in. (203.2 mm) O.D. Spool Adapter | K468 | | | • | • | • | • | • | • | | |

• Required • Optional

Accessories

| Product Name | Product No. | Activ8™ | LN-23P | LN-25 PRO Standard | LN-25 PRO Extra Torque | LN-25 PRO Dual Power | LN-25 Pipe | LN-25 Ironworker® | LN-25X w/ CrossLinc™ Technology | Power Feed® 25M | Power Feed® 25M Aluminum | |
|---|-------------|--------------------|--------------------|--------------------|------------------------|----------------------|--------------------|--------------------|---------------------------------|-------------------------------|---------------------------------|--------------------|
| | | Base Model K2999-1 | Base Model K316L-7 | Base Model K2613-5 | Base Model K2613-7 | Base Model K2614-6 | Base Model K2614-5 | Base Model K2614-9 | Base Model K4267-1 | Base Model Alum. Case K2536-8 | Base Model Plastic case K2536-5 | Base Model K4191-1 |
| GENERAL, CON'T. | | | | | | | | | | | | |
| Replacement Case Kit - Polycarbonate | K2596-2 | | | • | • | • | • | • | • | • | • | |
| Micro Wire Straightener | K1733-4 | | | • | • | • | • | • | • | • | | |
| 12-Pin to 6-Pin Adapter Cable | K2909-1 | | | | | | | | | • | • | |
| 12-Pin to 7-Pin Adapter Cable | K2910-1 | | | | | | | | | • | • | |
| ArLink® "T" Cable Connector | K2429-1 | | | | | | | | | • | • | |
| Remote Output Control (12-Pin), 25 ft. (7.6 m) | K857-2 | | | | | | | | | • | • | |
| Water Connection Kit | K590-6 | | | | | | | | | • | • | |
| Shielding Gas Filter | KP3103-1 | | | | | | | | | | | |
| Shield Gas Flow Sensor | K3338-1 | | | | | | | | | | | |
| Quick Connect Conduit Inlet Bushing | K3929-1 | | | | | | | | | | | |
| Push-Pull Gun Adapter Kit | K2339-1 | | | | | | | | | • | • | |
| TIG | | | | | | | | | | | | |
| PTA-17 Pro-Torch™ TIG Torch, 12.5 ft. (3.8 m), 2 pc | K1782-2 | | | | | | | | | • | • | |
| PTA-17 Pro-Torch™ TIG Torch, 25 ft. (7.6 m), 2pc | K1782-4 | | | | | | | | | • | • | |
| PTA-26 Pro-Torch™ TIG Torch, 12.5 ft. (3.8 m), 2pc | K1783-2 | | | | | | | | | • | • | |
| PTA-26 Pro-Torch™ TIG Torch, 25 ft. (7.6 m), 2pc | K1783-4 | | | | | | | | | • | • | |
| Foot Amptrol®, 12-Pin | K870-2 | | | | | | | | | • | • | |
| Hand Amptrol®, 12-Pin | K963-4 | | | | | | | | | • | • | |
| POWER SOURCES | | | | | | | | | | | | |
| CV400, Invertec® STT® II, Multi-Process welders (CC/CV), Engine Driven Welders | — | • | | | | | | | | | | |
| MIG Welders (CV), Multi-Process Welders (CC/CV), Engine Driven Welders | — | | • | | | | | | | | | |
| Power Wave® S350, S350 Aluminum, S500, 455M, 455M/STT®, R350, R500, 655R, AlumaFab® | — | | | | | | | | | • | • | |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | |
| Activ8™ | X2999 | • | | | | | | | | | | |
| LN-23P | X0316 | | • | | | | | | | | | |
| LN-25 PRO Standard | X2613 | | | • | | | | | | | | |
| LN-25 PRO Extra Torque | X2613 | | | | • | | | | | | | |
| LN-25 PRO Dual Power | X2614 | | | | | • | | | | | | |
| LN-25 Pipe | X2614 | | | | | | • | | | | | |
| LN-25 Ironworker® | X2614 | | | | | | | • | | | | |
| LN-25X | X4267 | | | | | | | | • | | | |
| Power Feed® 25M | X2536 | | | | | | | | | • | • | |
| Power Feed® 25M Aluminum | X2536 | | | | | | | | | | • | |

• Optional

Accessories

| Product Name | Product No. | LF-72 Wire Feeder | | LF-74 Wire Feeder | | LN-8 Wire Feeder | LN-9 Wire Feeder | FlexFeed™ 74HT | | Power Feed™ 84 | Power Feed™ 84 Dual | | | | |
|--|-------------|-------------------|------------|-------------------|------------|------------------|------------------|----------------|------------|----------------|---------------------|----------|----------|---------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | | | | |
| | | K2327-8 | K2327-9 | K2327-6 | K2327-7 | K2426-6 | K2426-7 | K297 | K357-1 | K3883-5 | K4163-1 | K3883-13 | K3883-15 | K4164-1 | K3330-5 |
| REQUIRED (see charts in Accessories Section) | | | | | | | | | | | | | | | |
| Weld Power Cables | — | • | • | • | • | • | • | • | • | • | • | • | • | • | • |
| Coaxial Weld Power Cables | — | | | | | | | | | | | | | | |
| Drive Roll and Wire Guide Kits | — | • | • | • | • | • | • | | | | | | | • | • |
| Drive Roll and Guide Tube Kits | — | | | | | | | • | • | • | • | • | • | | |
| Control Cables and Adapters | — | • | • | • | • | • | • | • | • | • | • | • | • | • | • |
| GENERAL | | | | | | | | | | | | | | | |
| Gun Receiver Bushing | K1500-1 | • | • | • | • | • | • | | | | | | | | |
| Gun Receiver Bushing | K1500-2 | • | • | • | • | • | • | | | | | | | | |
| Magnum® 550 Gun Adapter | K1500-3 | • | • | • | • | • | • | | | | | | | | |
| Miller® Gun Receiver Bushing | K1500-4 | • | • | • | • | • | • | | | | | | | | |
| OXO® Gun Receiver Bushing | K1500-5 | • | • | • | • | • | • | | | | | | | | |
| Dual Schedule Fast-Mate Adapter™ 10 Series | K489-7 | • | • | • | • | • | • | | | | | | | | |
| Deluxe Adjustable Gas Regulator & Hose Kit, 4.3 ft. (1.3 m) | K586-1 | • | • | • | • | • | • | | | | | | | | |
| Wire Feed Speed Meter Kit (LN-8) | K261 | | | | | | | • | • | | | | | | |
| Portable Digital Wire Feed Speed Meter | K283 | | | | | | | • | • | • | • | • | • | • | • |
| Incoming Bushing for Lincoln® Conduit, 0.025-1/16 in. (0.6-1.6 mm) wire | K1546-1 | • | • | • | • | • | • | | | • | • | • | • | • | • |
| Incoming Bushing for Lincoln® Conduit, 1/16-1/8 in. (1.6-3.2 mm) wire | K1546-2 | • | • | • | • | • | • | | | • | • | • | • | • | • |
| Inlet Bushing, quick connect style | K3929-1 | | | | | | | | | • | • | • | • | | |
| Adapter for Competitive Power Sources | K2335-1 | • | • | • | • | • | • | | | | | | | | |
| Burnback Kit | K202 | | | | | | | • | • | | | | | | |
| Postflow and Burnback Timer Kit | K2330-1 | • | • | • | • | • | • | | | | | | | | |
| Preflow, Postflow and Burnback Timer Kit | K2330-2 | | | | | | | | | | | | | | |
| 14 lb. (6.4 kg) Innershield Coil Adapter | K435 | | • | • | • | | • | • | • | | | | | | |
| 8 in. (203.2 mm) O.D. Spool Adapter | K468 | | • | • | • | | • | • | • | | | | | | |
| Remote Voltage Control Kit | K2329-1 | • | • | • | • | • | • | | | | | | | | |
| Spindle Kit, 2 Inch (50.8 mm) Hub | K162-1 | • | • | • | • | • | • | | | | | | | | |
| Harris® Argon/CO2 Flowmeter Regulator & Hose Kit, 10 ft. (3.0 m) | 3100211 | • | • | • | • | • | • | | | | | | | | |
| Adapter Cable, Male 14-pin Control Cable to Terminal Strip | K1798 | • | • | • | • | • | • | | | | | | | | |
| 42 Volt Transformer Kit | K1520-1 | • | • | • | • | • | • | | | • | • | • | • | | |
| Standard Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max. | K2328-1 | • | | | | • | | | | | | | | | |
| Standard Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max. | K3342-1 | | | | | | | | | • | • | • | • | • | • |
| Heavy Duty Wire Reel Stand, 60 lbs. (27.2 kg) spools, max. | K1524-3 | • | | | | • | | • | • | | | | | | |
| Heavy Duty Wire Reel Stand, 44 lbs. (20 kg) spools, max. & up to 60 lbs. (27.2 kg) coils. (includes K3341-1 Lift Bail) | K3343-1 | | | | | | | | | • | • | • | • | • | • |

• Optional

Accessories

| Product Name | Product No. | LF-72 Wire Feeder | | | | LF-74 Wire Feeder | | LN-8 Wire Feeder | LN-9 Wire Feeder | FlexFeed™ 74 HT | | | Power Feed™ 84 | Power Feed™ 84 Dual | |
|--|-------------|-------------------|------------|------------|------------|-------------------|------------|------------------|------------------|-----------------|------------|------------|----------------|---------------------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | K2327-8 | K2327-9 | K2327-6 | K2327-7 | K2426-6 | K2426-7 | K297 | K357-1 | K3883-5 | K4163-1 | K3883-13 | K3883-15 | K4164-1 | K3330-5 |
| GENERAL, CON'T. | | | | | | | | | | | | | | | |
| Undercarriage | K163 | | • | • | • | | • | • | • | | | | | | |
| Plastic Wire Cover, 30-40 lbs. (13.6-18.1 kg) | K1634-1 | | • | • | • | | • | • | • | | | | | | |
| Plastic Wire Cover, up to 60 lbs. (27.2 kg) | K1634-2 | | | • | • | | • | • | • | | | | | | |
| Spool Cover, 30-40 lbs. (13.6-18.1 kg) spools | K1634-4 | | | | | | | | | • | • | • | • | • | • |
| Spool Cover, 50-60 lbs. (22.7-27.2 kg) coils | K3340-1 | | | | | | | | | • | • | • | • | • | • |
| Insulated Lift Bail, 60 lbs. (27.2 kg) spools, max. | K1555-1 | | | • | • | | • | • | • | | | | | | |
| Lift Bail | K3341-1 | | | | | | | | | • | • | • | • | • | • |
| Light Duty Caster Kit | K1556-1 | | | • | • | | • | • | • | | | | | | |
| Swivel Platform | K1557-1 | | | • | • | | • | • | • | | | | | | |
| 22-30 lb. (10-13.6 kg) Readi-Reel® Adapter | K363P | | | | | | | • | • | | | | | | |
| 50-60 lb. (22.7-27.2 kg) Coil Adapter, 2 in. (50.8 mm) spindle | K1504-1 | | | • | • | | • | • | • | • | • | • | • | | |
| Gas Solenoid Kit (for codes above 9131) | K425 | | | | | | | • | • | | | | | | |
| Wire Reel and Flux Tank Assembly | K305 | | | | | | | • | • | | | | | | |
| Mechanized Hand Travel Unit | K110 | | | | | | | • | • | | | | | | |
| Squirtmobile® Power Pack, 50 ft. (15.2 m) | K161-50 | | | | | | | • | • | | | | | | |
| Wire Straightener | K1733-1 | | | | | | | | | • | • | • | • | • | • |
| Water Connection Kit | K590-6 | | | | | | | | | • | • | • | • | • | • |
| Shielding Gas Filter | KP3103-1 | | | | | | | | | • | • | • | • | • | • |
| Shield Gas Flow Sensor | K3338-1 | | | | | | | | | | | | | • | • |
| Quick Connect Conduit Inlet Bushing | K3929-1 | | | | | | | | | | | | | • | • |
| POWER SOURCES | | | | | | | | | | | | | | | |
| MIG Welders [CV], Multi-Process Welders [CC/CV] | — | • | • | • | • | • | • | | | | | | | | |
| Multi-Process Welders [CC/CV] (excludes Invertec® V350 PRO and Flextec™ 450) | — | | | | | | | • | • | | | | | | |
| Multi-Process Welders [CC/CV] | — | | | | | | | | | • | • | • | • | | |
| Power Wave® models | — | | | | | | | | | | | | | • | • |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | | | |
| LF-72 Wire Feeder | X2327 | • | • | • | • | | | | | | | | | | |
| LF-74 Wire Feeder | X2426 | | | | | • | • | | | | | | | | |
| LN-8 Wire Feeder | X0297 | | | | | | | • | | | | | | | |
| LN-9 Wire Feeder | X0357 | | | | | | | | • | | | | | | |
| FlexFeed™ 74 HT | X3883 | | | | | | | | | • | • | • | • | | |
| Power Feed™ 84 | X3328 | | | | | | | | | | | | | • | |
| Power Feed™ 84 Dual | X3330 | | | | | | | | | | | | | | • |

• Optional

SUBMERGED ARC and AUTOMATIC EQUIPMENT

| WIRE FEEDER MODEL | OUTPUT | | | | PROCESS | | | INPUT | FEATURES | | | | | | | | | |
|---|----------------------------|-----------------------------------|--------------------------------|--------------------------------|---------|------------|---------------|------------|---------------|--------------|-----------------|----------|------------------------------|--------------------------------|-----------------------|-----------|-------------------------------------|---|
| | Power Source Required | Wire Feed Speed Range ipm (m/min) | Solid Wire Size Range: in (mm) | Cored Wire Size Range: in (mm) | MIG | Flux-Cored | Submerged Arc | Power | 2-Roll Drive | 4-Roll Drive | Digital Display | | | | | | | |
| SEMI-AUTOMATIC WIRE FEEDERS | | | | | | | | | | | | | | | | | | |
| LN-8 and LN-9 | DC600 | 50-800 (1.3-20.3) | 0.040-3/32 (1.0-2.4) | 0.045-.120 (1.1-3.0) | | ● | ● | 115VAC | | | | | | | | | | |
| MECHANIZED WIRE FEEDERS | | | | | | | | | | | | | | | | | | |
| LT-7 Tractor | DC600, DC1000 | 100-400 (2.5-10.2) | 3/32-3/16 (2.4-4.8) | 3/32-3/16 (2.4-4.8) | | | ● | 115VAC | | | | | | | | | | |
| Cruiser™ and Tandem Cruiser™ | Power Wave® AC/DC 1000® SD | 15-500 (0.4-12.5) | 1/16-7/32 (1.6-5.6) | — | | | ● | 40VAC | • | • | • | | | | | | | |
| AUTOMATIC WIRE FEEDERS | | | | | | | | | | | | | | | | | | |
| NA-3 Control and Heads | DC600, DC1000, DC1500 | 25-600 (0.6-15.2) | 0.035-7/32 (0.9-5.6) | 0.045-5/32 (1.1-4.0) | ● | ● | ● | 115VAC | | | | | | | | | | |
| NA-4 Control and Heads | AC1200 | subject to arc voltage used | 1/16-7/32 (1.6-5.6) | — | | | ● | 115VAC | | | | | | | | | | |
| NA-5 Control and Heads | DC600, DC1000, DC1500 | 25-775 (0.6-19.7) | 0.035-7/32 (0.9-5.6) | 0.045-5/32 (1.1-4.0) | ● | ● | ● | 115VAC | | | • | | | | | | | |
| MAXsa® 10 Controller and MAXsa® 22 Feed Head | Power Wave® AC/DC 1000® SD | 10-500 (0.25-12.7) | 1/16-7/32 (1.6-5.6) | — | | | ● | 40VAC | • | • | • | | | | | | | |
| MAXsa® 19 Controller and MAXsa® 29 Feed Head | Power Wave® AC/DC 1000® SD | 10-500 (0.25-12.7) | 1/16-7/32 (1.6-5.6) | — | | | ● | 40VAC | • | • | • | | | | | | | |
| WELDER MODEL | OUTPUT | | | PROCESS | | | | | | INPUT | | FEATURES | | | | | | |
| | Mode | Polarity | Current Range (Amps) | Stick | TIG | MIG | Pulsed | Flux-Cored | Submerged Arc | Arc Gouge | Phase | Hertz | Waveform Control Technology® | ArkLink® Digital Communication | Production Monitoring | Stackable | 7-yr. Warranty (on Power Rectifier) | |
| ANALOG | | | | | | | | | | | | | | | | | | |
| Idealarc® DC600 | CC/CV | DC | 70-680 | ● | ● | ● | | ● | ● | ● | 3 | 60 | | | | | • | • |
| Idealarc® DC1000 | CC/CV | DC | 150-1300 | | | | | ● | ● | ● | 3 | 60 | | | | | • | • |
| Idealarc® DC1500 | CC/CV | DC | 200-1500 | | | | | ● | ● | ● | 3 | 60 | | | | | | • |
| Idealarc® AC1200 | CC/CV | AC | 200-1500 | | | | | ● | | | 1 | 60 | | | | | | • |
| DIGITAL | | | | | | | | | | | | | | | | | | |
| Power Wave® AC/DC 1000® SD | CC/CV | AC/DC | 100-1000 | | | | | | ● | | 3 | 50/60 | • | • | • | | | |

LN-8

Reliable Wire Feed in any Environment

- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

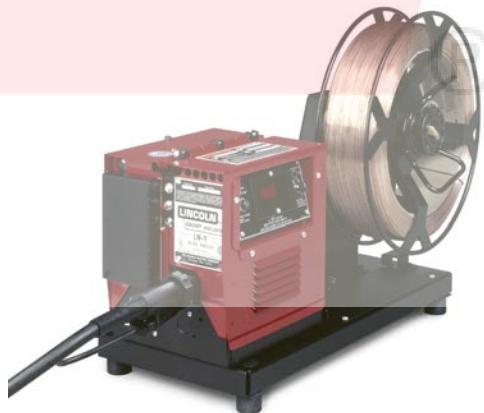
E8.30

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm [m/min] | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|--|---------------------------------------|-----------------|
| LN-8 Wire Feeder Base Model | K297 | 115V AC 50/60 HZ | 600A/60% | NA | 50-600 (1.3-15.2) | SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 [2.8] | 10.9 x 9.8 x 9.6 (277 x 248 x 244) | 36 (16.2) |

LN-9

Semiautomatic Feed for Larger Wire

- Standard digital meter can be set for volts, inches per minute or meters per minute
- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures
- Rugged and durable design ensures long operating life and years of trouble-free wire feeding
- Enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to the drive rolls



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E8.30

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm [m/min] | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|--|---|-----------------|
| LN-9 Wire Feeder Base Model | K357-1 | 115V AC 50/60 HZ | 600A/60% | NA | 50-600 (1.3-15.2) | SOLID: 0.040-3/32 (1.0-2.4) CORED: 0.045-0.120 (1.2-3.0) HARDFACING: 7/64 [2.8] | 11.5 x 11.3 x 11.5 (292 x 287 x 292) | 42 (19) |

LT-7 Tractor

Track Greater Submerged Arc Productivity

- Calibrated tractor drive travels 6 to 70 ipm (12.7-127.0 m/min)
- Vertical head lift adjuster for adjusting electrical stick-out from 1/2 to 5 inches
- Control box can be mounted on either left or right, eliminating the need to return to the power source for routine procedure changes
- Welds horizontal fillets, lap and butt joints to the left or right side of the tractor frame for convenience



Processes

- Submerged Arc

Output



Input



Literature

E9.70

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------------|----------------|----------------------|--|---------|------------------------------------|----------------------------------|-------------------------------------|-----------------|
| LT-7 Tractor Base Model | K227-1 | 115V AC 50/60 Hz | 600A/100% 1100A/100% (w/water cooling) | NA | 100-400 (2.5-10.2) | SOLID: 3/32-3/16 (2.4-4.8) | 27.5 x 33 x 14 (698 x 838 x 356) | 120 (54) |
| Track Model | K395-2 | | | | | | | 130 (59) |

Cruiser™ Tractor

Rigid, Configurable and Quick

- For butt and fillet joints on plate welding common in bridge or barge decking, tank fabrication or shipbuilding
- Set up with or without a track and three or four wheel operation
- Strong, rigid and stiff where you need it most – frame, mast, clamps, wheels and outriggers
- Deposition rates up to 30 lbs (13.6 kg) per hour



Processes

- Submerged Arc

Output



Input



Literature

E9.170

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|----------------------|----------------------------------|---------------------|------------------------------------|----------------------------------|-----------------------------------|-----------------|
| Cruiser™ Tractor ⁽¹⁾ Base Model | K3048-2 | 40V DC | 1000A/100% | 142:1 | 15-200 (0.4-5.0) | SOLID: 3/32-7/32 (2.4-5.6) | 29 x 23 x 36 (736 x 584 x 914) | 207 (94) |
| | | | | 95:1 ⁽²⁾ | 15-300 (0.4-7.6) | 1/16-1/8 (1.6-3.2) | | |
| | | | | 57:1 ⁽²⁾ | 50-500 (1.3-12.7) | 1/16-3/32 (1.6-2.4) | | |

⁽¹⁾Travel Speed, in/min. (m/min) : 10-100 (0.25-2.5) ⁽²⁾Optional Gearing

Tandem Cruiser™ Tractor

Double the Deposition

- Deposition rates up to 30 lbs (13.6 kg) per hour per arc for greater productivity on thick materials
- For butt and fillet joints on plate welding common in bridge or barge decking, tank fabrication or shipbuilding
- Set up with or without a track and three or four wheel operation
- Strong, rigid and stiff where you need it most – frame, mast, clamps, wheels and outriggers



Processes

- Submerged Arc

Output



Input



Literature

E9.170

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|----------------------|----------------------------------|---------------------|------------------------------------|----------------------------------|---|-----------------|
| Cruiser™ Tractor ⁽¹⁾ Tandem Model | K3083-1 | 40V DC | 1000A/100% | 142:1 | 15-200 (0.4-5.0) | SOLID: 3/32-7/32 (2.4-5.6) | 36.5 x 45.5 x 41.5 (927 x 1156 x 1054) | 300 (136) |
| | | | | 95:1 ⁽²⁾ | 15-300 (0.4-7.6) | 1/16-1/8 (1.6-3.2) | | |
| | | | | 57:1 ⁽²⁾ | 50-500 (1.3-12.7) | 1/16-3/32 (1.6-2.4) | | |

⁽¹⁾Travel Speed, in/min. (m/min) : 10-100 (0.25-2.5) ⁽²⁾Optional Gearing

NA-3S Controller

DC Submerged Arc Control

- Delivers arc sensing or constant wire feed speed control with hot or cold starting for use with either constant current or constant voltage DC power sources
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-----------------------------------|-------------------|-----------------|
| NA-3S Controller | K210-3 | NA | NA | NA | 25-650 (0.6-16.5) | SOLID: 0.035-7/32 (0.9-5.6) | NA | NA |

NA-4 Controller

Battle Arc Blow with AC Multiple Arc Welding

- Delivers arc sensing control with hot or cold starting for use with constant current AC power sources for submerged arc welding, including AC-AC tandem arc and AC-AC-AC triple arc systems and single electrode submerged arc when arc blow limits the DC welding current and travel speeds
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-----------------------------------|-------------------|-----------------|
| NA-4 Controller | K388-3 | NA | NA | NA | 25-650 (0.6-16.5) ⁽¹⁾ | SOLID: 0.035-7/32 (0.9-5.6) | NA | NA |

⁽¹⁾Subject to arc voltage used



NA-3S/NA-4 and NA-3SF/NA-4F Feed Heads

Deposit More. Travel Faster.

- Handles wide range of wire diameters and produces a wide wire feed speed range
- Proven, rugged construction minimizes downtime and maintenance costs



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.10

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-----------------------------------|-------------------|-----------------|
| NA-3S/NA-4 Head | K208A | NA | NA | NA | 15-290 (0.4-7.4) ⁽¹⁾ | SOLID: 3/32-7/32 (2.4-5.6) | NA | NA |
| NA-3SF/NA-4F Head | K209A-1 | | | | | SOLID: 0.035-3/32 (0.9-2.4) | | |
| NA-3S/NA-4 Head | K208B | | | | 22-425 (0.6-10.8) ⁽¹⁾ | SOLID: 0.035-3/32 (0.9-2.4) | | |
| NA-3SF/NA-4F Head | K209B-1 | | | | | | | |

⁽¹⁾Subject to arc voltage used

NA-5 Controller

Precise Mechanized Automation Control

- Digital display monitors preset or actual wire feed speed and voltage
- Includes timer controls for burnback, wire react time and weld cycle stop
- Includes travel and Inch Up/Inch Down controls to aid set up
- Start and stop the welding cycle with the push of a button



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.30

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-----------------------------------|-------------------|-----------------|
| NA-5 Controller | K356-3 | NA | NA | NA | 25-775 [0.6-19.7] | SOLID: 0.035-7/32 [0.9-5.6] | NA | NA |



NA-5S and NA-5SF Feed Head

Superior Mechanized Submerged Arc Wire Feeding

- Choose with or without control box, wire reel, brake and flux hopper
- Handles wide range of wire diameters and produces a wide wire feed speed range
- Proven, rugged construction minimizes downtime and maintenance costs



Processes

- Flux-Cored
- Submerged Arc

Output



Input



Literature

E9.30

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|----------------------|----------------------------------|---------|------------------------------------|----------------------------------|-------------------|-----------------|
| NA-5S Head | K346A | NA | NA | NA | 15-290 [0.4-7.4] | SOLID: 3/32-7/32 [2.4-5.6] | NA | NA |
| NA-5SF Head | K347A-1 | | | | | | | |
| NA-5S Head | K346B | | | | 22-425 [0.6-10.8] | SOLID: 1/16-3/32 [1.6-2.4] | | |
| NA-5SF Head | K347B-1 | | | | | | | |

MAXsa® 10 Controller

Severe Duty. Digital Ready.

- Waveform Control Technology® enables the user to choose from a library of pre-programmed modes
- Eight procedure memories enable the user to pre-set and save optimal welding parameters
- Hand-held pendant allows operation from 4-100 ft (1.2-30.5 m) with an ArcLink® extension cable
- IP23 rated for operation in harsh environments
- Easy PLC interfacing to control fixture travel, timers and other system commands



Processes

- Submerged Arc

Output



Input



Literature

E9.181

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-------------------------|----------------------------------|-----------------|
| MAXsa® 10 Controller | K2814-3 | 40V DC | NA | NA | NA | NA | 15 x 13 x 4 (381 x 259 x 102) | 25 (11.3) |

MAXsa® 22 Feed Head

Drive Large Diameter Submerged Arc Wires

- Rotational feed head adjustment in two planes allows flexible, accurate setup for fixturing or arc locating. Optional horizontal and vertical lift adjuster enables additional positioning flexibility
- Can be used in single, tandem, Twinarc® or multiple arc applications
- IP23 rated for harsh environments



Processes

- Submerged Arc

Output



Input



Literature

E9.181

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|----------------------|----------------------------------|----------------------|------------------------------------|----------------------------------|-----------------------------------|-----------------|
| MAXsa® 22 Feed Head (includes Flux Hopper) | K2370-3 | 40V DC | 1000A/100% | 142:1 ⁽⁰⁾ | 15-200 (0.4-5.0) | SOLID: 3/32-7/32 (2.4-5.6) | 12 x 14 x 10 (305 x 355 x 254) | 80 (36.3) |
| | | | | 95:1 | 15-300 (0.4-7.6) | 1/16-1/8 (1.6-3.2) | | |
| | | | | 57:1 | 50-500 (1.3-12.7) | 1/16-3/32 (1.6-2.4) | | |

⁽⁰⁾142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-3, K2312-3, or K2311-1)

MAXsa® 19 Controller

Integrator-Ready Submerged Arc Control

- Specifically designed to relay wire feed commands to the MAXsa® 29 feed head when a customer-supplied user interface is used in integrator-driven applications
- I/O connector block for start/stop, forward/reverse feed and shutdown input interfacing with external accessories
- Status indicator aids diagnostic system troubleshooting
- IP23 rated to withstand harsh environments



Processes

- Submerged Arc

Output



Input



Literature

E9.181

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------|----------------|----------------------|----------------------------------|---------|------------------------------------|-------------------------|----------------------------------|-----------------|
| MAXsa® 19 Controller | K2626-4 | 40V DC | NA | NA | NA | NA | 9 x 10.5 x 3 (229 x 267 x 76) | 7 (3.2) |

MAXsa® 29 Feed Head

Ready for Integrator and Robotic Automation

- Intended for integrator and robotic submerged arc applications using the Power Wave® AC/DC 1000® SD power source.
- Closed loop speed control enables full control over starting, running and stopping wire feed speed
- Multi-axis rotational feed head adjustment in one plane allows flexible, accurate setup for fixturing
- IP23 rated to withstand harsh environments
- For use in single, tandem, Twinarc® or multiple arc applications



Processes

- Submerged Arc

Output



Input



Literature

E9.181

| Product Name | Product Number | Input Power: Voltage | Rated Output: Current/Duty Cycle | Gearing | Wire Feed Speed Range: ipm (m/min) | Wire Size Range in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------|----------------|----------------------|----------------------------------|----------------------|------------------------------------|----------------------------------|-----------------------------------|-----------------|
| MAXsa® 29 Feed Head | K2312-3 | 40V DC | 1000A/100% | 142:1 ⁽¹⁾ | 15-200 [0.4-5.0] | SOLID: 3/32-7/32 [2.4-5.6] | 13 x 16 x 10 (330 x 406 x 254) | 35 (15.9) |
| | | | | 95:1 | 15-300 [0.4-7.6] | 1/16-1/8 (1.6-3.2) | | |
| | | | | 57:1 | 50-500 [1.3-12.7] | 1/16-3/32 (1.6-2.4) | | |

⁽¹⁾142:1 gear box is standard. Conversion Kit supplied for conversion to 95:1 with Wire Drive (K2370-3, K2312-3, or K2311-1)

Idealarc® DC600

Idealarc® with Submerged Arc Capacity

- Full range output voltage control provides easy operation and precise control
- Voltage Reduction Device™ (VRD®) reduces open circuit voltage for an additional level of safety (specify VRD® model)
- Circuitry protected against moisture and corrosive environments
- Seven-year warranty on power rectifier



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.40

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---------------------------------|--|------------------------------|--|---------------------------------------|-----------------|
| Idealarc® DC600 ⁽¹⁾ Base Models | K1288-22 | 230/460/575/3/60 | 600A/44V/100% 680A/44V/60% | 108/54/43.2A | CV: 70-850A 13-44V CC: 90-850A 24-42V | 30.7 x 22.2 x 38 (781 x 565 x 965) | 522 (237) |
| | K1288-17 | 230/460/3/60 | | 108/54A | | | |
| w/Multi-Process Switch | K1288-18 | | | | | | |

⁽¹⁾50 Hertz models also available

Idealarc® DC1000

Rugged Constructon. Simple Controls.

- Full range output control provides easy operation and precise arc control
- Terminal strip and output studs accommodate remote connections and cable
- Low profile case allows installation of a workbench and for stacking up to two machines to conserve floor space
- Internal components are coated to protect against moisture and corrosion; removable side panels allow easy access to internal parts
- Seven-year warranty on power rectifier



Processes

- Stick
- DC TIG
- MIG
- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.50

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|---------------------------------|--|------------------------------|---------------------|---------------------------------------|-----------------|
| Idealarc® DC1000 ⁽¹⁾ Base Models | K1386-3 | 230/460/3/60 | 1000A/44V/100% | 193/96.5A | 16-46V 150-1300A | 30.7 x 22.5 x 39 (781 x 572 x 991) | 821 (372) |
| | K1386-4 | 575/3/60 | | 77.2A | | | |

⁽¹⁾50 Hertz models also available

Idealarc® DC1500

Plenty of Power for Mechanized Automation

- Mode switch selects the desired output characteristics for the process being used
- Internal components protected against moisture and corrosive environments
- Terminal strip and output studs allow for remote connections and cable
- Produces outstanding arc characteristics on both constant voltage and constant current processes
- Seven-year warranty on power rectifier



Processes

- Flux-Cored
- Submerged Arc
- Gouging

Output



Input



Literature

E5.60

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---------------------------------|--|------------------------------|---------------------|--|-----------------|
| Idealarc® DC1500 ⁽¹⁾ Base Model | K1275 | 460/3/60 | 1500A/44V/100% 1500A/60V/100% | 184A | 200-1500A 20-60V | 57.2 x 22.3 x 38 (1453 x 566 x 965) | 1420 (644) |

⁽¹⁾50 Hertz models also available



Idealarc® AC1200

AC Large Wire Diameter Welding

- Controls adjust output settings while welding or at idle
- Internal components protected against moisture and corrosive environments
- Includes Scott® connection taps for two AC welding heads operating in tandem
- Specifically designed for submerged arc welding with the NA-4 wire feeder and control on AC-AC tandem arc and AC-AC-AC triple arc systems and single electrode submerged arc when arc blow limits the DC welding current and travel speeds
- Three output studs with overlapping ranges
- Seven-year warranty on power rectifier



Processes

- Submerged Arc

Output



Input



Literature

E5.70

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|---|--|------------------------------|---|--------------------------------------|-----------------|
| Idealarc® AC1200 | K3140-2 | 380/415/440/460 ⁽²⁾ / 1/50/60 | 1200A/44V/100% | 230/201/190/182A | 50/60 HZ: 240-1500A 30-44V 60 HZ: 200-1500A 28-44V | 62.2 x 22 x 38 (1580 x 559 x 965) | 1636 (742) |

Power Wave® AC/DC 1000® SD

Speed. Quality. Efficiency.

- Software-based controls allow for upgrading options as new features become available
- Eliminate downtime. Easy polarity switching requires no hardware reconfiguration
- 3-phase voltage input eliminates the imbalance associated with transformer-based AC welding machines



Processes

- DC+ Submerged Arc
- DC- Submerged Arc
- Balanced AC Submerged Arc
- Variable AC Submerged Arcc

Output



Input

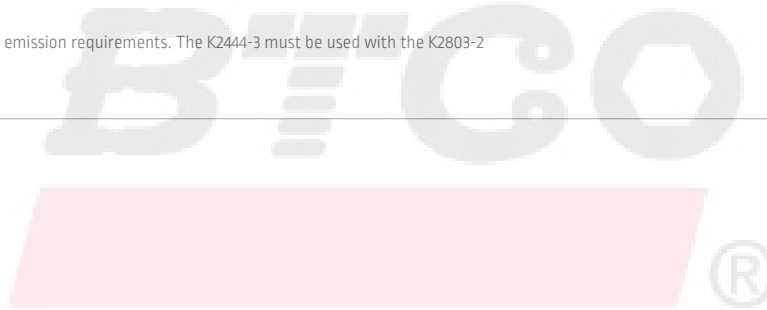


Literature

E9.181

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---------------------------------|--|------------------------------|--------------|--|-----------------|
| Power Wave® AC/DC 1000® SD ⁽¹⁾ | K2803-2 | 380/400/460/500/575/3/50/60 | 1000A/44V/100% | 82/79/69/62/55A | 100-1000A | 49.2 x 19.2 x 46.2 (1250 x 488 x 1174) | 800 (363) |

⁽¹⁾Filter is required to meet CE conducted emission requirements. The K2444-3 must be used with the K2803-2



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

LN-8

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LN-9

Required Accessories for all models

- Drive Roll Kit
- Control Cable
- Control Extension Cable
- Weld Power Cable

LT-7 Tractor

Required Accessories for all models

- Nozzle Assembly
- Weld Power Cable

Base Model (K227-1)

- Control Cable, 25 ft. (7.6 m)

Cruiser™ and Tandem Cruiser™ Tractor

Required Accessories for all models

- ArcLink® Control Cable
- Track Section

Base Model (K3048-2, K3083-1)

- Conduit Tubing, 5 ft. (1.5 m)
- 5/32 in. (4.0 mm), 600 Amp Contact Nozzle Assembly;
5/32 in. (4.0 mm) Contact Tip
- Nozzle Extension, 5 in. (127 mm)
- Curved Nozzle Extension, 45°
- Nozzle Extension Insulator
- Flux Tubing and Hose Clamps
- Wire Reel Assembly
- Wheels for Track Operation
- Front and Rear Outriggers
- Enclosed Wire Reel (2 for Tandem)
(NOTE: Does not include a Control Cable)
- Wire Straightener (2 for Tandem)

NA-3 and NA-4 Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

NA-5 Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

MAXsa® Controllers & Feed Heads

Required Accessories for all models

- Nozzle Assembly
- Control Cable and Adapter
- Weld Power Cable
- Power Source
- Wire Reel(s) and Mounting
- Drive Roll and Guide Tube Kit

Accessories

| Product Name | Product No. | LN-8 Wire Feeder | | LN-9 Wire Feeder | | LT-7 Tractor | | Cruiser™ Tractor | | Tandem Cruiser™ Tractor | | NA-3 Controls & Heads | | NA-4 Controls & Heads | | NA-5 Controls & Heads | | MAXsa® Controllers and Feed Heads | | Idealarc® DC600 | | Idealarc® DC1000 | | Idealarc® DC1500 | | Idealarc® AC1200 | | Power Wave® AC/DC 1000® SD | |
|---|-------------|------------------|------------|------------------|------------|--------------|------------|------------------|------------|-------------------------|------------|-----------------------|------------|-----------------------|------------|-----------------------|------------|-----------------------------------|------------|-----------------|------------|------------------|------------|------------------|------------|------------------|------------|----------------------------|------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| GENERAL | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Submerged Arc Gun and Cable Assemblies ⁽¹⁾ | — | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Drive Roll and Guide Tube Kits ⁽¹⁾ | — | • | • | | | | | | | • | • | • | | | | | | | | | | | | | | | | | |
| Control Cables and Adapters ⁽¹⁾ | — | • | • | • | • | | | | | • | • | • | | | | | | | | | | | | | | | | | • |
| Weld Power Cables ⁽¹⁾ | — | • | • | • | • | | | | | • | • | • | | | | | | | | | | | | | | | | | |
| Contact Nozzle Assembly for 3/32, 1/8 and 5/32 in. (2.4, 3.2 and 4.0 mm) Wire | K231-1 | | | • | • | | | | | • | • | • | | | | | | | | | | | | | | | | | |
| Positive Contact Nozzle Assembly for 3/32-1/8 in. (2.4-3.2 mm) Wire | K148A | | | • | • | | | | | • | • | • | | | | | | | | | | | | | | | | | |
| Positive Contact Nozzle Assembly for 5/32-3/16 in. (4.0-4.8 mm) Wire | K148B | | | • | • | | | | | • | • | • | | | | | | | | | | | | | | | | | |
| Wire Reel and Flux Tank Assembly | K305 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Heavy Duty Process Sense Lead, 50 ft. (15.2 m) | K1811-50 | | | | | | | | | | | | | | | | | | | | | | | | | | | | • |
| Heavy Duty Process Sense Lead, 100 ft. (30.5 m) | K1811-100 | | | | | | | | | | | | | | | | | | | | | | | | | | | | • |
| Robotic Cable Adapter, 14-Pin to 22-Pin, 18 in. (457 mm) | K1805 | | | | | | | | | | | | | | | | | | | | | | | | | | | | • |
| Heavy Duty Wire Reel Stand | K1524-3 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Insulated Lift Bail | K1555-1 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Light Duty Caster Kit | K1556-1 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Swivel Platform | K1557-1 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 50-60 lb. (22.4-27.2 kg) Coil Adapter, 2 in. (50.8 mm) spindle | K1504-1 | • | • | | | | • | • | | | | | | | | | | | | | | | | | | | | | |
| Plastic Wire Cover - up to 60 lbs. (27.2 kg) | K1634-2 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Wire Feed Speed Meter Kit (LN-8) | K261 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Burnback Kit | K202 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Undercarriage | K163 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Mechanized Hand Travel Unit | K110 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Squirtmobile® Power Pack, 50 ft. (15.2 m) | K161-50 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Portable Digital Wire Feed Speed Meter | K283 | • | • | | | | | | | | | | | | | | | | | | | | | | | | | | |
| LT-7 Drive Roll 052-1/16 (2 required) | KP2268-1 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| LT-7 Drive Roll 068-3/32 (2 required) | KP2268-2 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| LT-7 Drive Roll 3/32-3/16 (2 required) | KP2268-3 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| LT-7 Drive Roll 045-052 (2 required) | KP2268-4 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Drive Roll Center 5/64-3/32 Tiny Twin | KP1890-1 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Drive Roll Side 5/64-3/32 Tiny Twin | KP1890-2 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Guide Tube Assembly 068-3/16 Incoming | KP1984-1 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Guide Tube 3/32-3/16 Outgoing | KP1985-1 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Guide Tube Outgoing Tiny Twinarc® | KP1986-1 | | | • | • | | | | | | | | | | | | | | | | | | | | | | | | |
| Guide Tube Incoming Tiny Twin Tractor | KP2127-1 | | | • | • | | | | | • | • | | | | | | | | | | | | | | | | | | |

⁽¹⁾See charts in Accessories Section for more details

• Required • Optional

Accessories

| Product Name | Product No. | LN-8 Wire Feeder | LN-9 Wire Feeder | LT-7 Tractor | Cruiser™ Tractor | Tandem Cruiser™ Tractor | NA-3 Controls & Heads | NA-4 Controls & Heads | NA-5 Controls & Heads | MAXsa™ Controllers and Feed Heads | Idealarc® DC600 | Idealarc® DC1000 | Idealarc® DC1500 | Idealarc® AC1200 | Power Wave® AC/DC1000™ SD | |
|---|-------------|------------------|------------------|--------------|------------------|-------------------------|-----------------------|-----------------------|-----------------------|-----------------------------------|-----------------|------------------|------------------|------------------|---------------------------|------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| Weld Power Cable, Lug to Lug 4/0, 600A, 60%, 110 ft. (33.5 m) | K1842-110 | | | | | | | | | | | | | | | |
| Severe Duty Contact Tip, 3/32 in. (2.4 mm) | KP1962-3B1 | | | | | | • | • | | | | | | | | |
| Severe Duty Contact Tip, 1/8 in. (3.2 mm) | KP1962-1B1 | | | | | | • | • | | | | | | | | |
| Severe Duty Contact Tip, 5/32 in. (4.0 mm) | KP1962-4B1 | | | | | | • | • | | | | | | | | |
| Severe Duty Contact Tip, 3/16 in. (4.8 mm) | KP1962-2B1 | | | | | | • | • | | | | | | | | |
| Severe Duty Contact Tip, 7/32 in. (5.6 mm) | KP1962-5B1 | | | | | | • | • | | | | | | | | |
| Extended Life Contact Tip, 3/32 in. (2.4 mm) | KP3162-3B1 | | | | | | • | • | • | | | | | | | |
| Extended Life Contact Tip, 1/8 in. (3.2 mm) | KP3162-1B1 | | | | | | • | • | • | | | | | | | |
| Extended Life Contact Tip, 5/32 in. (4.0 mm) | KP3162-4B1 | | | | | | • | • | • | | | | | | | |
| Extended Life Contact Tip, 3/16 in. (4.8 mm) | KP3162-2B1 | | | | | | • | • | • | | | | | | | |
| Extended Life Contact Tip, 7/32 in. (5.6 mm) | KP3162-5B1 | | | | | | • | • | • | | | | | | | |
| Tiny Twinarc® Assembly for 1/16 in. (1.6 mm) Wire | K129-1/16 | | | | | | • | • | • | • | | | | | | |
| Tiny Twinarc® Assembly for 5/64 in. (2.0 mm) Wire | K129-5/64 | | | | | | • | • | • | • | | | | | | |
| Tiny Twinarc® Assembly for 3/32 in. (2.4 mm) Wire | K129-3/32 | | | | | | • | • | • | • | | | | | | |
| Submerged Arc Twinarc® Nozzle for 5/64, 3/32 and 1/8 in. (2.0, 2.4 and 3.2 mm) Wire | K225 | | | | | | • | • | • | • | | | | | | |
| Tandem Arc Framework Assembly | K387 | | | | | | • | • | • | • | | | | | | |
| Tandem Arc Wire Reels and Mountings | K390 | | | | | | • | • | • | • | | | | | | |
| Flux Hopper Assembly | K389 | | | | | | • | • | • | • | | | | | | |
| Control to Head Cable Extension, 46 ft. (14.0 m) | K338-46 | | | | | | | | | | | | | | | |
| Control to Head Cable Extension, 26 ft. (7.9 m) | K335-26 | | | | | | | | | | | | | | | |
| Solenoid Kit | K223 | | | | | | | | • | | | | | | | |
| Spindle Kit, 2 in. (50.8 mm) Hub | K162-1 | | | | | | | | • | • | | | | | | |
| Start or Crater Module | K334 | | | | | | | | • | | | | | | | |
| Weld Timer Module - max time 9.99 sec. | K337-10 | | | | | | | | • | | | | | | | |
| Remote Interface Module | K336 | | | | | | | | • | | | | | | | |
| Automatic Flux Hopper Assembly | K219 | | | | | | | | • | • | | | | | | |
| Mounting Bracket for TC-3 | K2462-1 | | | | | | | | • | | | | | | | |
| Multi-Process Switch | K804-1 | | | | | | | | | | • | • | • | | | |
| Arc Tracker™ | K3019-1 | | | | | | | | | | • | • | • | • | • | |
| Paralleling Kit* | K1897-1 | | | | | | | | | | • | • | • | • | • | |
| Paralleling Kit* | K1611-1 | | | | | | | | | | • | • | • | • | • | |
| All-Terrain Undercarriage | K1737-1 | | | | | | | | | | • | • | • | • | • | |
| Undercarriage - Hand moving | K842 | | | | | | | | | | • | • | • | • | • | |
| Factory Undercarriage | K1770-1 | | | | | | | | | | | • | • | • | • | |
| 42 Volt Transformer Kit | K1520-1 | | | | | | | | | | | • | • | • | • | |

NOTE » *On Idealarc DC600, cannot be used with VRD models.

• Optional

Accessories

| Product Name | Product No. | LN-8 Wire Feeder | LN-9 Wire Feeder | LT-7 Tractor | Cruiser™ Tractor | Tandem Cruiser™ Tractor | NA-3 Controls & Heads | NA-4 Controls & Heads | NA-5 Controls & Heads | MAXsa® Controllers and Feed Heads | Idealarc® DC600 | Idealarc® DC1000 | Idealarc® DC1500 | Idealarc® AC1200 | Power Wave® AC/DC 1000® SD | | | | |
|--------------|-------------|------------------|------------------|--------------|------------------|-------------------------|-----------------------|-----------------------|-----------------------|-----------------------------------|------------------|------------------|------------------|------------------|----------------------------|------------|-------|---------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | | | |
| | | K297 | K357-1 | K227-1 | K395-2 | K3048-2 | K3083-1 | Various model Hs | Various model Hs | Various model Hs | Various model Hs | K1288-22 | K1288-17 | K1288-18 | K1386-3 | K1386-4 | K1275 | K3140-2 | K2803-2 |

GENERAL, CONT.

| | | | | | | | | | | | | | | | | | | | | |
|--|---------|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Remote Output Control, 25 ft., (7.6 m) | K857 | | | | | | | | | | | | | | | | | | | |
| Remote Output Control, 100 ft., (30.5 m) | K857-1 | | | | | | | | | | | | | | | | | | | |
| Amptrol™ Adapter Kit | K843 | | | | | | | | | | | | | | | | | | | |
| Adapter Cable, Male 14-pin Control Cable to Terminal Strip | K1798 | | | | | | | | | | | | | | | | | | | |
| Paralleling Kit | K1900-1 | | | | | | | | | | | | | | | | | | | |
| CE Filter | K2444-3 | | | | | | | | | | | | | | | | | | | |
| Weld Fume Control System | — | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • |

WIRE FEEDERS

| | | | | | | | | | | | | | | | | | | | | |
|-------------------------|---|--|--|--|--|--|--|--|--|--|---|---|---|---|---|---|--|--|---|---|
| LN-8 | — | | | | | | | | | | • | • | • | | | | | | | |
| LN-9 | — | | | | | | | | | | • | • | • | • | • | | | | | |
| LT-7 | — | | | | | | | | | | • | • | • | • | • | • | | | | |
| Cruiser™ Tractor | — | | | | | | | | | | | | | | | | | | | • |
| Tandem Cruiser™ Tractor | — | | | | | | | | | | | | | | | | | | | • |
| NA-3S | — | | | | | | | | | | • | • | • | • | • | • | | | | |
| NA-4 | — | | | | | | | | | | | | | | | | | | • | |
| NA-5 | — | | | | | | | | | | • | • | • | • | • | • | | | | |
| MAXsa® Controllers | — | | | | | | | | | | | | | | | | | | | • |

POWER SOURCES

| | | | | | | | | | | | | | | | | | | | | |
|----------------------------|---|--|--|--|--|---|---|--|--|--|---|--|--|--|--|--|--|--|--|--|
| Idealarc® DC600 | — | | | | | | | | | | | | | | | | | | | |
| Idealarc® DC1000 | — | | | | | | | | | | | | | | | | | | | |
| Idealarc® DC1500 | — | | | | | | | | | | | | | | | | | | | |
| Idealarc® AC1200 | — | | | | | | | | | | | | | | | | | | | |
| Power Wave® AC/DC 1000® SD | — | | | | | • | • | | | | • | | | | | | | | | |

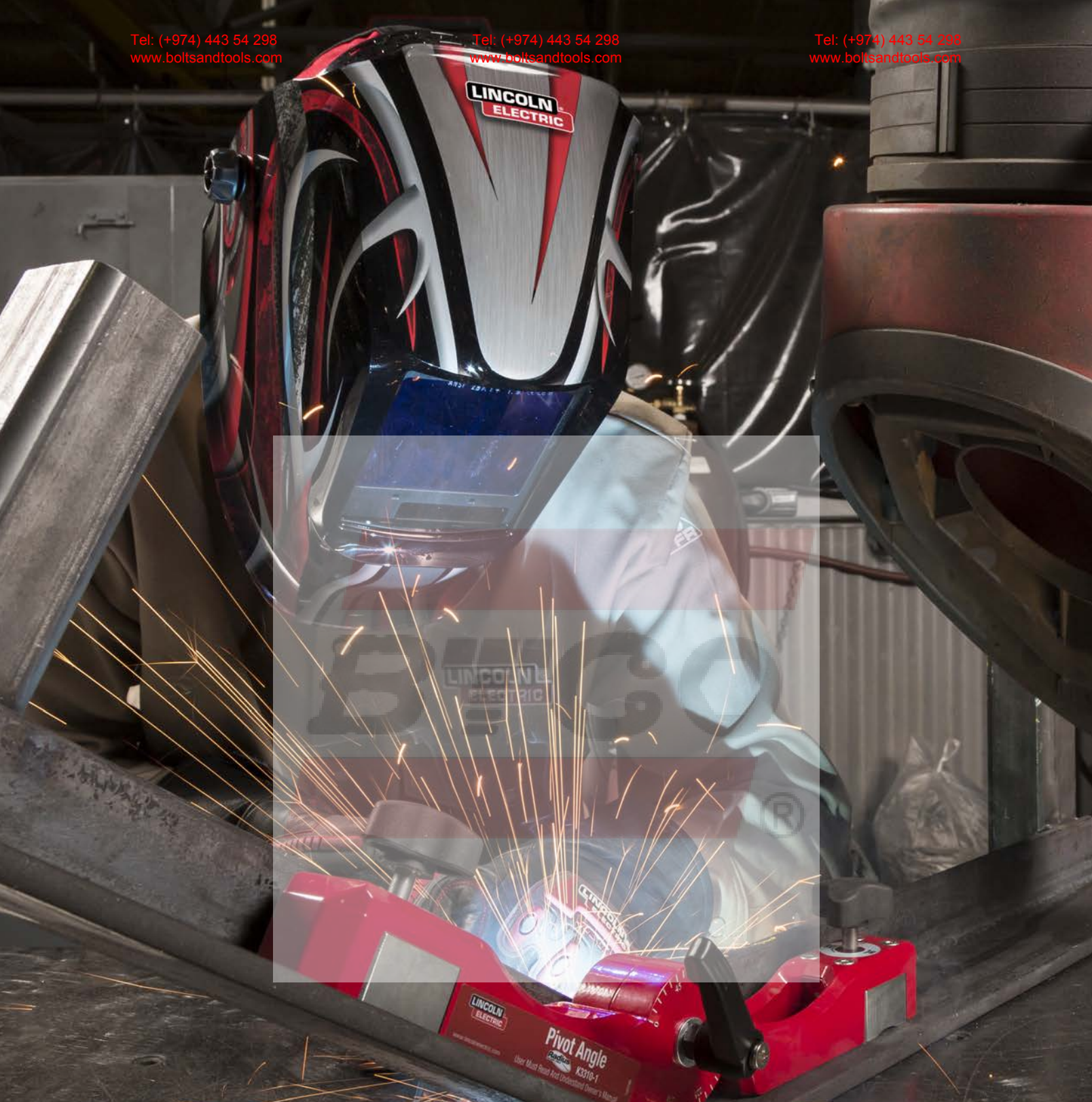
2-YEAR EXTENDED WARRANTY

| | | | | | | | | | | | | | | | | | | | | |
|--------------------------------|-------|---|---|---|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| LN-8 Submerged Arc Wire Feeder | X0297 | • | | | | | | | | | | | | | | | | | | |
| LN-9 Submerged Arc Wire Feeder | X0357 | | • | | | | | | | | | | | | | | | | | |
| LT-7 Tractor | X0227 | | | • | | | | | | | | | | | | | | | | |
| LT-7 Tractor Track Model | X0395 | | | | • | | | | | | | | | | | | | | | |
| NA-3 Controls | X0210 | | | | | | | | | | | | | | | | | | | |
| NA-4 Control | X0388 | | | | | | | | | | | | | | | | | | | |
| NA-3S/NA-4 Head | X0208 | | | | | | | | | | | | | | | | | | | |
| NA-3SF/NA-4 Head | X0209 | | | | | | | | | | | | | | | | | | | |
| NA-5 Control | X0356 | | | | | | | | | | | | | | | | | | | |
| NA-5S Head | X0346 | | | | | | | | | | | | | | | | | | | |
| NA-5SF Head | X3047 | | | | | | | | | | | | | | | | | | | |
| Idealarc® DC600 | X1288 | | | | | | | | | | | | | | | | | | | |
| Idealarc® DC1000 | X1386 | | | | | | | | | | | | | | | | | | | |
| Idealarc® DC1500 | X1245 | | | | | | | | | | | | | | | | | | | |
| Idealarc® AC1200 | X3140 | | | | | | | | | | | | | | | | | | | |
| Power Wave® AC/DC 1000® SD | X2803 | | | | | | | | | | | | | | | | | | | |

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WELDING GEAR

VIKING™ HELMETS » 3350 Series · 2450 Series · 2450D Series · 1840 Series · 1740 Series · Industrial Passive™ · PAPP ·

RED LINE® APPAREL » Welding Gear Ready-Paks® · Gloves · Jackets/Apron/Coat/Shirts/Sleeves · Caps/Doo Rags/Beanies · Safety Glasses/Goggles/Face Shield

RADIUS® TOOLS » Magnetic Fixtures & Hand Lifters · Brushes · Chipping Hammers · Welpers® · Welding Pliers · Rod Ovens · Curtains/Blankets

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VIKING™ 3350 Series

Defining a New Standard in Welding Helmets

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Largest viewing area in the VIKING™ line
- For the customer who refuses to compromise
- Superior comfort with the pivot style headgear
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3034-3 Black
- K4181-3 Foose Imposter™
- K4412-3 White Tail Camo™
- K4034-3 Code Red®
- K3372-3 Jessi vs. The Robot™
- K4158-3 Zombie™
- K3175-3 All American®
- K3248-3 Twisted Metal®
- K3039-3 Terracuda®
- K3100-3 Motorhead®
- K3101-3 Mojo®
- K3255-3 Polar Arc®

Literature

E14.501

| Product Name | Lens Switching Speed | Variable Shade/Control | Battery Replacement Type | Magnifying “Cheater” Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge/View Size in (mm) | Temp. Range °C (°F) | Net Wt. oz (g) |
|---------------------|----------------------|------------------------|-------------------------------------|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------------------|--|---|----------------|
| VIKING™ 3350 | 1/25,000 seconds | 5-13 / Internal | CR2450 Replaceable Battery (Qty. 1) | Yes | 3.5/Internal | Continuous | 0.1-1.0 Fully Adjustable | 4 | AC: > 2 Amp DC: > 2 Amp | Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.74 x 3.34 (95 x 85) | Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158) | 21 (595) |

VIKING™ 2450 Series

The Ideal Choice for the Journeyman Fabricator

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Fastest switching speed in its class
- Up to 28% larger viewing area versus competitive helmets
- Designed for long hours of comfortable wear with the new pivot style headgear
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3028-3 Black
- K4411-3 White Tail Camo™
- K3029-3 Heavy Metal®
- K3035-3 Street Rod®
- K3174-3 All American®
- K3099-3 Graveyard Shift®

Literature

E14.501

| Product Name | Lens Switching Speed | Variable Shade/Control | Battery Replacement Type | Magnifying “Cheater” Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge/View Size in (mm) | Temp. Range °C (°F) | Net Wt. oz (g) |
|---------------------|----------------------|------------------------|-------------------------------------|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------------------|--|---|----------------|
| VIKING™ 2450 | 1/25,000 seconds | 5-13 / Internal | CR2450 Replaceable Battery (Qty. 2) | Yes | 3.5/Internal | Continuous | 0.1-1.0 Fully Adjustable | 4 | AC: > 2 amp DC: > 2 amp | Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.82 x 2.44 (97 x 62) | Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158) | 21 (595) |

VIKING™ 2450D

Are You Ready to Go Digital?

- 4C™ Lens Technology
- Digital push-button operator interface
- Welding, Cutting and Grind Modes
- Fastest switching speed in its class
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3230-3 Black

Literature

E14.501

| Product Name | Lens Switching Speed | Variable Shade/Control | Battery Replacement Type | Magnifying "Cheater" Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge/View Size in (mm) | Temp. Range °C (°F) | Net Wt. oz (g) |
|----------------------|----------------------|------------------------|-------------------------------------|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------------------|--|---|----------------|
| VIKING™ 2450D | 1/25,000 seconds | 4-13 / Internal | CR2450 Replaceable Battery (Qty. 2) | Yes | 4 / Internal | Digital Display Control | 0.1-1.0 Fully Adjustable | 4 | AC: > 2 amp DC: > 2 amp | Cartridge US: 5.25 x 4.50 (133 x 114) View: 3.82 x 2.44 (97 x 62) | Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158) | 21 (595) |

VIKING™ 1840 Series

Superior Optical Clarity at a Superior Price

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- 16% larger viewing area than its competitor
- New pivot style head gear
- Convenient external shade control
- Lightweight and compact
- Hard hat and magnifying “cheater” lens capable
- 3 Year Warranty



Processes

- All

Order Number

- K3023-3 Black
- K3173-3 All American™
- K4175-3 Aztec™

Literature

E14.501

| Product Name | Lens Switching Speed | Variable Shade/Control | Battery Replacement Type | Magnifying "Cheater" Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge/View Size in (mm) | Temp. Range °C (°F) | Net Wt. oz (g) |
|---------------------|----------------------|------------------------|---|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------------------|---|---|----------------|
| VIKING™ 1840 | 1/25,000 seconds | 9-13 / Internal | CR2450 Replaceable Lithium Battery (Qty. 1) | Yes | 3.5/Internal | Continuous | 0.1-1.0 Fully Adjustable | 2 | AC: > 5 amp DC: > 3 amp | Cartridge DINS: 4.33 x 3.54 (110 x 90) View: 3.78 x 1.85 (96 x 47) | Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158) | 18.8 (533) |

VIKING™ 1740

Make it Your Own:
A Great Welding Helmet at a Great Price

- User replaceable batteries
- Lightweight and compact
- Continuously variable 9-13 shade, sensitivity and delay
- Hard hat and magnifying "cheater" lens capable
- 2 Year Warranty



Processes

- All

Order Number

- K3282-1 Black

Literature

MC13-124

| Product Name | Lens Switching Speed | Variable Shade/Control | Magnifying "Cheater" Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge Size in (mm) | View Size in (mm) | Temp. Range °C (°F) | Net Wt. oz (g) |
|---------------------|----------------------|------------------------|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------|------------------------------|-------------------------|---|----------------|
| VIKING™ 1740 | 1/25,000 seconds | 9-13 / Internal | Yes | 4/Internal | Variable | 0.1-1.0 Fully Adjustable | 2 | AC/DC: ≥ 5 Amp | DINS: 4.33 x 3.54 (110 x 90) | 3.78 x 1.67 (96 x 42.5) | Operating: -10 to +55 (14 to 131) Storage: -20 to +70 (-4 to +158) | 18.6 (528) |



Industrial Passive™

Low Cost, Low-Tech,
High-Value Protection

- Fixed Shade 11
- 2 Year Warranty
- Ratchet headgear
- Meets ANSI Z87.1 and CSA Z94.3 Standards
- An affordable option for students
- Hard hat and magnifying "cheater" lens capable



Processes

- All

Order Number

- K3371-1 Industrial Passive

Literature

E14.507

PAPR™ Series Helmet

Comfort, Performance And Efficiency

- Lightweight and comfortable
- Battery run time is a minimum of 8 hours, outpacing competing systems
- Audible and vibrating alarms notify user of low air flow or low battery



Processes

- All

Order Number

- K9390-1

Literature

- E14.744

| Product Name | Lens Switching Speed | Variable Shade/Control | Magnifying "Cheater" Capable Lens | Grind Mode Shade/Control | Light Sensitivity Control | Delay Control Dark to Light (seconds) | Arc Sensors | TIG Amp Rating | Cartridge Size in (mm) | View Size in (mm) | Temp. Range °C [°F] | Net Wt. lb (kg) |
|--------------|----------------------|------------------------|-----------------------------------|--------------------------|---------------------------|---------------------------------------|-------------|----------------------------|-----------------------------|-----------------------|--|----------------------------|
| PAPR™ Series | 1/25,000 seconds | 5-13 / Internal | Yes | 3.5/Internal | Continuous | 0.1-1.0 Fully Adjustable | 4 | AC: > 2 Amp DC: > 2 Amp | US: 5.25 x 4.50 (133 x 114) | 3.74 x 3.34 (95 x 85) | Operating: -5 to +55 (23 to 131) Storage: -20 to +70 (-4 to +158) | 6.19 (2.8) (Entire system) |

Premium Welding Gear Ready-Pak®

Get All The Welding Gear You Need

- Complete with top grade personal protective equipment
- Long lasting quality
- Comfortable and stylish



Order Number

- K3236-M
- K3236-L
- K3236-XL
- K3236-2XL

Literature

- MC12-81

Jessi Combs Women's Welding Gear Ready-Pak®

Get all the Women's Welding Gear You Need

- Jacket and gloves are sized and tailored for women
- Features Jessi Combs Women's Shadow™ FR Welding Jacket and Jessi vs. the Robot™ VIKING™ 3350 Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

K3238-XS
K3238-S
K3238-M
K3238-L
K3238-XL

K3096-1

Replacement Lincoln® Industrial Duffel Bag

Literature

MC13-174

Traditional Welding Gear Ready-Pak®

All the Welding Gear a Student or Occasional Welder Needs to Get Started

- Features Traditional FR Cloth Jacket and VIKING™ 1840 Black Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

K3105-M
K3015-L
K3105-XL
K3105-2XL
K3105-3XL

K3096-1

Replacement Lincoln® Industrial Duffel Bag

Literature

MC11-76

Standard Welding Gear Ready-Pak®

Get all the Welding Gear You Need

- Features Traditional Khaki FR Cloth Jacket and Industrial Passive Shade 11 Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

K4416-M
K4416-L
K4416-XL
K4416-2XL
K4416-3XL

K3096-1

Replacement Lincoln® Industrial Duffel Bag

Literature

E14.743

Roll Cage™ Welding Rigging Gloves

Dual Purpose, Complete Protection

- Silicone knuckles protect fingers and back of the hand from impact and injury
- Extended cuffs protect the wrists and forearms from heat and sparks
- Palm padding reinforces high wear areas



Order Number

K3109-S
 K3109-M
 K3109-L
 K3109-XL
 K3109-2XL

Literature

MC13-133

Premium Leather MIG/Stick Welding Gloves

Crafted for Every-Day Duty

- Designed for optimal dexterity and durability
- Superior comfort, durability and dexterity
- Flame retardant foam lining provides heat resistance



Order Number

K2980-M
 K2980-L
 K2980-XL

Traditional MIG/Stick Welding Gloves

Built to Protect, Built to Last

- One size fits all
- Designed for comfort and durability



Order Number

K2979-ALL

Leather TIG Welding Gloves

Precision Fit for Precision Welding

- Optimal fit and dexterity for TIG welding applications
- Heat-resistant gauntlet for wrist protection



Order Number

K2981-M
 K2981-L
 K2981-XL

Heat-Resistant Welding Gloves

Be Cool, Be Comfortable

- Reflects 95% of radiant heat
- Aluminized rayon backing
- Unlined palm for increased control and reduced fatigue



Order Number

K2982-L
 K2982-XL

Full Leather Steelworker™ Gloves

Deliver Fit and Flexibility

- Designed for light welding or metalworking
- Strong all-leather construction
- Hook-and-loop wrist closure ensures a snug fit



Order Number

K2977-S
 K2977-M
 K2977-L
 K2977-XL
 K2977-2XL

Shadow™ Grain Leather-Sleeved Jacket

Protection, Comfort and Freedom

- For MIG or stick welding
- Flip up collar and extra front panel flap provide full closure
- Spatter guard lining
- Quality craftsmanship



Order Number

K2987-M
K2987-L
K2987-XL
K2987-XXL
K2987-XXXL

Shadow™ Split Leather-Sleeved Jacket

Quality, Durability, Protection, Comfort: The
Ideal Jacket for MIG or Stick

- Split cowhide sleeves and cool FR material on the chest
- Ideal for stick and MIG welding
- Flip up collar and a lined flap on the back close for extra protection
- Two horizontal hip pockets with secured flaps



Order Number

K2986-M
K2986-L
K2986-XL
K2986-XXL
K2986-XXXL
K2986-5XL

Heavy-Duty Leather Welding Jacket

Protection for the Tough Jobs

- Heavy-duty split cowhide leather chest and sleeves provide superior protection
- FR cloth back keeps you cool
- Ideal for heavy stick and MIG welding
- Flip up collar, extra front flap for full closure and spatter guard lining



Order Number

K2989-M
K2989-L
K2989-XL
K2989-XXL
K2989-XXXL

Traditional Split Leather-Sleeved Jacket

Minimum Weight, Maximum Durability

- Split cowhide sleeves resist spatter and wear and lightweight FR cloth keeps you cool
- Inside pocket and adjustable snap sleeves
- Good protection, economically priced



Order Number

K3106-M
K3106-L
K3106-XL
K3106-2XL
K3106-3XL

Traditional FR Cloth Jacket – Khaki

The Ideal Light Duty Welding Jacket

- Crafted from 100% flame-retardant material
- Provides maximum protection
- Adjustable dual snap sleeves and convenient inside pocket



Order Number

K3317-M
K3317-L
K3317-XL
K3317-2XL
K3317-3XL

Traditional FR Cloth Jacket – Black

The Ideal Light Duty Welding Jacket

- Crafted from 100% flame-retardant material
- Provides maximum protection
- Adjustable dual snap sleeves and convenient inside pocket



Order Number

K2985-M
K2985-L
K2985-XL
K2985-XXL
K2985-XXXL

Split-Leather Welding Apron

Provides an Extra Layer of Protection

- Heavy-duty split cowhide construction
- Harness system adjusts to any size and weight
- Great addition for any welding jacket or shirt



Order Number

K3110-ALL

FR Welding Lab Coat

All-Purpose Protection

- 9 oz. 100% flame retardant material
- Knee length offers extended protection for light-duty welding
- Ideal for instructors, supervisors and occasional welders



Order Number

K3112-M
K3112-L
K3112-XL

FR Welding Shirt – Khaki

Safety and Comfort in a Single Shirt

- Ideal for light-duty welding
- Durable enough for daily use
- Adjustable dual-snap sleeves
- Features a single pocket with flap and pencil holder



Order Number

- K3382-M
- K3382-L
- K3382-XL
- K3382-2XL

FR Welding Shirt – Black

Safety and Comfort in a Single Shirt

- Ideal for light-duty welding
- Durable enough for daily use
- Adjustable dual-snap sleeves
- Features two chest pockets with flaps and a pencil holder slot



Order Number

- K3113-M
- K3113-L
- K3113-XL
- K3113-2XL
- K3113-3XL

Split-Leather FR Welding Sleeves

Stay Protected, Stay Cool

- Durable, flame-retardant material adds spatter and heat resistance
- Split leather panels in high wear areas



Order Number

- K3111-ALL

Custom Embroidery Available!

Get custom Red Line™ apparel for your school or shop, or personalize it just for you.

- Add custom single or multi-color logos to Red Line™ FR cloth jackets, welding shirts or lab coats
- Order at: www.lincolnelectric.logoshop.com



FR Doo Rag

Do the Lincoln Rag

- 100% flame retardant material
- Mesh lining for fast sweat evaporation
- Machine washable



Order Number
K2993-ALL

All-American™ Doo Rag

American Headgear

- 100% cotton
- Mesh lining for fast sweat evaporation
- Machine washable



Order Number
K3204-ALL

All-American™ Welding Cap

Stars and Stripes and Sparks

- 100% cotton
- Cushioned insert provided comfort and absorbs sweat
- Flat-stitched seams for superior comfort
- Machine washable



Order Number
K3203-ALL

FR Welding Beanie

Top Off with Lincoln Electric

- Machine washable
- Flame-retardant



Order Number
K2994-L
K2994-XL

Padded Safety Glasses

Padded Safety Glasses are
Easy on the Eyes

- Comfortable, non-slip strap material
- 360° foam liner keeps dust out and enhances comfort
- For long hours of comfort



• • • • •
Meets Requirements

- ANSI Z87.1
- CSA Z94.3

• • • • •
Order Number

K3119-1

Face Shield

Full Frontal Protection

- Large, impact-resistant shield wraps around entire face
- Ideal for grinding, polishing, deburring and other operations



• • • • •
Meets Requirements

- ANSI Z87.1
- CSA Z94.3

• • • • •
Order Number

K3120-1
KP3164-1 (Lens only)

Shade 5 Cutting and Grinding Goggles

Shades of Protection

- For plasma and oxyfuel cutting operations
- 100% surface seal keeps sparks, spatter, particles, sand, dirt and heat away from your eyes



• • • • •
Meets Requirements

- ANSI Z87.1

• • • • •
Order Number

K3118-1

Shade 3 Cutting and Grinding Goggles

Shades of Protection

- For chipping, grinding and machining operations.
- 100% surface seal keeps sparks, spatter, particles, sand, dirt and heat away from your eyes



• • • • •
Meets Requirements

- CSA Z94.3
- ANSI Z87.1

• • • • •
Order Number

K3118-2

Finish Line™ Clear Safety Glasses

Safe, Sleek and Stylish

- Comfortable flexible nosepiece and adjustable temple tips
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2966-1

Women's Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

- Sized 10% smaller than our similar models
- Light weight makes these models easy to wear
- Anti-fog and anti-scratch coating



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K3250-S
 K3250-M

Lincoln® Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

- Light weight makes these models easy to wear
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2965-1

Traditional Lincoln® Clear Safety Glasses

Traditional Safety Glasses

- Frameless clear lens
- Light weight makes these models easy to wear
- Inexpensive and ideal for student, team or bulk purchase



Meets Requirements

- ANSI Z87.1+

Order Number

K3104-1

Lincoln® Cover2® Clear Safety Glasses

Protect Your Eyes and Your Glasses

- Worn over your own prescription glasses
- Ratcheting adjustable-length temples
- Integrated brow guard and side shields offer added impact protection
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2968-1

Bifocal Clear Safety Glasses

See Safety More Clearly

- Full eye coverage
- Slip resistant temples



Meets Requirements

- ANSI Z87.1

Order Number

K3117-100 1.0 Diopter
 K3117-150 1.5 Diopter
 K3117-200 2.0 Diopter
 K3117-250 2.5 Diopter

Finish Line™ Outdoor Safety Glasses

Keep Your Eye on the Finish Line

- Comfortable flexible nosepiece and adjustable temple tips
- Special anti-fog coating reduces lens fogging
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2970-1

Lincoln® Starlite® Outdoor Safety Glasses

Safe, Sleek and Stylish

- Silver mirror coating added to the lens for protection from the sun
- Frameless lens provides a wide field of vision
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2969-1

I-Beam™ Red Outdoor Safety Glasses

Sturdy Protection

- Durable impact protection
- Flexible nosepiece and temple tips add comfort
- Silver mirror lens
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2972-1

I-Beam™ Black Outdoor Safety Glasses

Sturdy Protection

- Durable impact protection
- Flexible nosepiece and temple tips add comfort
- Red mirror lens
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2971-1

Lincoln® Starlite® IR 5 Safety Glasses

Infra-Red Shielding

- Shade 5 infra-red protection intended for cutting and grinding
- Unitary frameless style provides a wide field of vision
- Blocks 99.9% of UV-A,B, & C Radiation



Meets Requirements

- ANSI Z87.1+
- CSA Z94.3

Order Number

K2967-1

Jessi vs. The Robot™ Auto-Darkening Welding Helmet

VIKING™ 3350 Series

- 4C™ Lens Technology
- Perfect 1/1/1 optical clarity rating (EN379)
- Largest viewing area in the VIKING™ line
- For the customer who refuses to compromise
- Superior comfort with the pivot style headgear



Processes

- All

Order Number

K3372-3

Literature

E14.502

Jessi Combs Women's Shadow™ Welding Jacket

A Jacket Designed with Women in Mind

- Split cowhide sleeves with cooling FR cloth front and back
- Flip up collar, adjustable snap sleeves and snap cinch waist
- Two horizontal flap pockets
- Ideal for MIG or stick welding



Order Number

K3114-XS

K3114-S

K3114-M

K3114-L

K3114-XL

Literature

MC12-107

Jessi Combs MIG/Stick Welding Gloves

Not Your Brother's Welding Gloves

- Designed and sized for women's hands
- Durable split cowhide and cotton lining
- Long-lasting work life



Order Number

K3232-S

K3232-M

Literature

MC12-107

Jessi Combs Women's Steelworker™ Gloves

For Her: A Glove For The Multi-Tasker

- Sized for women's hands
- Top grain cowhide ensures durability and maximizes dexterity
- For fabrication or light welding
- All leather construction



Order Number

K3231-XS

K3231-S

K3231-M

Literature

MC12-107

Women's Starlite® Clear Safety Glasses

Safe, Sleek and Stylish

See page 137



JESSI COMBS
 Metal fabricator,
 TV personality and
 fastest woman land
 speed record holder.

Pivot Angle Magnetic Fixture

Tacking Welds Just Got Easier

- Designed for repetitive work at uncommon angles
- Convenient single lock handle makes it fast and easy to select an angle



Order Number

• K3310-1

Literature

E14.800

Multi Angle Fixture

Tacking Welds Just Got Easier

- Set up in seconds
- Magnet technology allows for complete on/off control and precise positioning
- Easy to position on flat or round stock



Order Number

• K3309-1

Literature

E14.800

Mini Multi Angle Fixture

Tacking Welds Just Got Easier

- Designed for small steel parts
- Pipe notch for use on round stock
- No batteries or electricity required



Order Number

• K3318-1

Literature

E14.800

Manual Hand Lifter

Get a Handle on Steel

- For small part lifting and sheet dragging
- Work faster and more efficiently with fewer injuries
- No batteries or electricity required



Order Number

• K3311-1

Literature

E14.800

Electric Hand Lifter

Battery Powered Steel Handling

- No cords to clutter the workplace
- For small part handling and removing parts from burn tables
- Battery power light blinks when battery needs recharging
- 60 lb (27.2 kg) lifting force



Order Number

• K3312-1

Literature

E14.800

Stainless Steel & Aluminum Welding

3 X 7 Row Stainless Steel Wire Brush

This handy toothbrush style is just right for light cleaning on stainless steel in confined or hard to reach areas.

2 X 9 Row Stainless Steel Wire Brush

A slight curve in the handle improves grip. Choose for general light cleaning on stainless steel.

3 X 19 Row Stainless Steel Wire Brush

This general purpose brush is intended for long life and efficient surface cleaning on stainless steel.



Length, in. (mm)

- 7.5 (191) (3x7 Brush)
- 8.5 (216) (2x9 Brush)
- 13.75 (349) (3x19 Brush)

Order Number

- K3179-1 (3x7 Brush)
- K3180-1 (2x9 Brush)
- K3181-1 (3x19 Brush)

Alloy Welding

3 X 7 Row Brass Wire Brush for Aluminum

This compact toothbrush style can be used for light cleaning on aluminum in confined or hard to reach areas. Brass bristles are easy on aluminum surfaces.

2 X 9 Row Brass Wire Brush for Aluminum

The slightly curved handle improves grip for general light cleaning on aluminum. Brass bristles gently remove oxide layer on aluminum.



Length, in. (mm)

- 7.5 (191) (3x7 Brush)
- 8.5 (216) (2x9 Brush)

Order Number

- K3182-1 (3x7 Brush)
- K3183-1 (2x9 Brush)

Carbon Steel Welding

3 X 19 Row Carbon Steel Wire Brush

Select this popular tempered steel bristle pattern for efficient general cleaning on carbon steels.

4 X 16 Row Carbon Steel Wire Brush

Tempered steel bristles make fast work of rust, mill scale and paint on carbon steels. Comfortable curved handle.



Length, in. (mm)

- 13.75 (349) (3x19 Brush)
- 9.5 (241) (4x16 Brush)

Order Number

- K3184-1 (3x19 Brush)
- K3185-1 (4x16 Brush)

Combination Packs

Wire Brush Three Pack

This compact toothbrush style set is easy to stow in your bag and perfect for small projects. Includes brass bristle brush for aluminum, stainless bristle brush for stainless steel and a nylon bristle brush for general cleaning on carbon steel.



Length, in. (mm)

- 7.5 (191)

Order Number

- K3189-1

Chipping Hammer

Tackle Dirt and Slag Head-On

- Shock reducing spiral handle with hook
- Head includes spike and flat sides



Processes

- Stick
- Flux-Cored

Order Number

K4022-1

Literature

E14.742

Welper®

Multi-Use MIG Tool

- Designed for MIG welding operations with eight functions in a single pair of pliers
- Spring loaded for easy opening and closing
- Comfortable handle
- Chrome vanadium steel



Processes

- MIG
- Flux-Cored

Order Number

K4014-2

Literature

E14.740

Welding Pliers

Single Tool, Multiple Functions

- Up to six functions
- Spring loaded for easy opening and closing
- Heat treated for durability



Processes

- MIG

Order Number

K4014-1

Literature

E14.741

Welding Curtain, 6 x 6 ft. (1.8 x 1.8 m)

Bring the Curtain Down on Sparks
and Spatter

- Intended to be hung vertically
- Rated for temperatures up to 1022°F (550°C)
- Protects workers from injury and parts and equipment from damage



Meets Requirements

- FM approved for ANSI/FM 4950

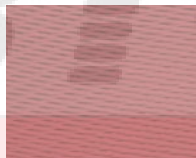
Order Number

K3252-1

Welding Blanket, 6 x 6 ft. (1.8 x 1.8 m)

We've Got You Covered

- Intended to be used horizontally
- Rated for temperatures up to 1,022°F (550°C)
- Protects workers from injury and parts and equipment from damage
- Easy to position in any shop



Meets Requirements

- FM approved for ANSI/FM 4950

Order Number

K3253-1

High Temperature Welding Blanket, 6 x 6 ft. (1.8 x 1.8 m)

Keep the Heat Off

- Intended to be used horizontally
- Rated for temperatures up to 2012°F (1,100°C)
- Protects workers from injury and parts and equipment from damage
- Easy to position in any shop



Meets Requirements

- FM approved for ANSI/FM 4950

Order Number

K3254-1

HYDROGUARD™ Rod Canister

Easy to Carry. Easy to Protect.

- Protect and carry 10 lb. (4.5 kg) of stick electrode up to 14 in. (355.6 mm) in length
- Rubber seal makes the container moisture-resistant



Processes
• Stick

Order Number
K3166-1
K3167-1 (strap)

HYDROGUARD™ Portable Welding Rod Oven

Outstanding Moisture Resistance for Improved Weld Quality

- Transport a maximum of 10 lb. (4.5 kg) of up to 18 in. (457.2 mm) electrode
- Maintains electrodes at a constant 300°F (149°C) temperature
- Power-On light to visually confirm operation



Processes
• Stick

Output
Preset at 300°F (149°C)

Input



Order Number
K2939-1 (115V)
K2939-2 (230V)

Literature
E14.701

HYDROGUARD™ Bench Rod Oven

Outstanding Moisture Resistance for Improved Weld Quality

- Circular Shape Directs Airflow
- Adjustable Thermostat
- Flexible Interior Configuration
- Variable Moisture Vent
- Handy Shelf
- Data Logger Capable



Processes
• Stick Electrode
• MIG Wire

Output
100-550°F
(38-288°C)

Input



Order Number
K2942-1 (120V)
K2942-2 (240/480V)
K3148-1 (Thermometer Kit)

Literature
E14.702

NOTE » Date Logger Capable

Specifications Chart » VIKING™ PAPR™ 3350 Helmet

| PAPR (Powered Air-Purifying Respirator) Specifications | |
|--|--|
| Size of Blower Assembly (W x T x D) | 8 x 7.5 x 3 in. (203 x 191 x 76 mm) |
| Weight of Blower (including battery, belt and filters) | 2.20 lb. (1.0 kg) |
| Air Flow | Low Speed: 180+ lpm (6+ cfm) High Speed: 210+ lpm (7.4+ cfm) |
| Operating Temperature | 23° to 131°F (-5° to 55°C) |
| Battery Type | Lithium Ion (Rechargeable) |
| Battery Charge Time | Three hours |
| Battery Charges | 500 charges |
| Belt Size ⁽¹⁾ | 29 to 52 in. (736 to 1321 mm) |
| Respirator Approval ⁽²⁾ | NIOSH 42 cfr 84 Approved Powered Air-Purifying Respirator (PAPR) |
| Assigned Protection Factor ⁽³⁾ | 25 |
| Helmet Replacement Battery | CR 2450 |
| Battery Life | 8 Hours |
| Charge | 115 Volt Input |
| Alarms | Audible and Vibrate |
| Head Gear | FR Flame Retardant |
| Optical Class | 1/1/1 (per EN 379) |
| Lens Switching Speed (sec) | 1/25,000 |
| Variable Shade/Control | 5-13 Internal |
| Magnifying "Cheater" Capable Lens | Yes |
| Grind Mode Shade/Control | 3.5 Internal |
| Light Sensitivity Control | Continuous |
| Delay Control Dark to Light (sec) | 0.1 -1.0 Fully Adjustable |
| Arc Sensors | 4 |
| TIG AMP Rating | DC > 2 Amp AC > 2 Amp |
| Helmet Compliance | ANSI Z87.1-2010, CSA Z94.3, CE |
| Cartridge Size | US 5.25 x 4.50 in. (133 x 114 mm) |
| View Size | 3.7 x 3.34 in. (95 x 85mm) |
| Blower Assembly | 1 Year Warranty |
| ADF Helmet | 3 Year Warranty |

⁽¹⁾ Belt size maximum of 60 in. (1524 mm) with belt extension accessory.

⁽²⁾ Refer to NIOSH respirator approval label for system configuration.

⁽³⁾ APF=25 for loose fitting Powered Air-Purifying Respiratory according to OSHA 3352-02 2009, when the employer implements a continuing, effective respirator program in compliance with the Respiratory Protection Standard (29 CFR 1910).

Specifications Chart

Welding Gloves

HAND SIZING FOR GLOVES (measure the width of the hand as shown) 

| Product Name | Product Number | Mens Gloves – in (cm) | | | | | Womens Gloves – in (cm) | | |
|--|----------------|-----------------------|--------------------|-------------------|---------------------|-----------------------|-------------------------|-------------------|--------------------|
| | | Small 8.0 [20] | Medium 8.5 [22] | Large 9.0 [23] | X Large 9.5 [24] | 2X Large 10.0 [25] | X Small 7.0 [18] | Small 7.5 [19] | Medium 8.0 [20] |
| Roll Cage™ Welding Rigging Gloves | K3109-xx | • | • | • | • | • | | | |
| Premium Leather MIG/Stick Welding Gloves | K2980-xx | | • | • | • | | | | |
| Traditional MIG/Stick welding Gloves | K2979-xx | • | • | • | • | • | | | |
| Full Leather Steelworker® Gloves | K2977-xx | • | • | • | • | • | | | |
| Leather TIG Welding Gloves | K2981-xx | | • | • | • | | | | |
| Heat-Resistant Welding Gloves | K2982-xx | | | • | • | | | | |
| Jessi Combs Women's MIG/Stick Welding Gloves | K3232-xx | | | | | | | • | • |
| Jessi Combs Women's Steelworker™ Gloves | K3231-xx | | | | | | • | • | • |



Specifications Chart

Welding Apparel

| Part No./ Size | Chest Measurement in (cm) | Sleeve Length in (cm) | Torso Size in (cm) | Coat Length in (cm) |
|----------------|---------------------------|-----------------------|--------------------|---------------------|
|----------------|---------------------------|-----------------------|--------------------|---------------------|

Shadow™ Grain Leather-Sleeved Jacket

| | | | | |
|-----------|-----------------|---------|---------|--|
| K2987-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K2987-L | 44-46 (112-117) | 32 (81) | 31 (79) | |
| K2987-XL | 48-50 (122-127) | 33 (84) | 32 (81) | |
| K2987-2XL | 52-54 (132-137) | 34 (86) | 33 (84) | |
| K2987-3XL | 56-58 (142-147) | 35 (89) | 34 (86) | |

Shadow™ Split Leather-Sleeved Jacket

| | | | | |
|-----------|-----------------|---------|---------|--|
| K2986-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K2986-L | 44-46 (112-117) | 32 (81) | 31 (79) | |
| K2986-XL | 48-50 (122-127) | 33 (84) | 32 (81) | |
| K2986-2XL | 52-54 (132-137) | 34 (86) | 33 (84) | |
| K2986-3XL | 56-58 (142-147) | 35 (89) | 34 (86) | |
| K2986-5XL | 60-66 (152-168) | 35 (89) | 34 (86) | |

Heavy Duty Leather Welding Jacket

| | | | | |
|-----------|-----------------|---------|---------|--|
| K2989-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K2989-L | 44-46 (112-117) | 32 (81) | 31 (79) | |
| K2989-XL | 48-50 (122-127) | 33 (84) | 32 (81) | |
| K2989-2XL | 52-54 (132-137) | 34 (86) | 33 (84) | |
| K2989-3XL | 56-58 (142-147) | 35 (89) | 34 (86) | |

Traditional Split Leather-Sleeved Jacket

| | | | | |
|-----------|-----------------|---------|---------|--|
| K3106-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K3106-L | 44-46 (112-117) | 32 (81) | 30 (76) | |
| K3106-XL | 48-50 (122-127) | 33 (84) | 30 (76) | |
| K3106-2XL | 52-54 (132-137) | 34 (86) | 30 (76) | |
| K3106-3XL | 56-58 (142-147) | 35 (89) | 30 (76) | |

Traditional FR Cloth Jacket

Khaki

| | | | | |
|-----------|-----------------|---------|---------|--|
| K3317-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K3317-L | 44-46 (112-117) | 32 (81) | 30 (76) | |
| K3317-XL | 48-50 (122-127) | 33 (84) | 30 (76) | |
| K3317-2XL | 52-54 (132-137) | 34 (86) | 30 (76) | |
| K3317-3XL | 56-58 (142-147) | 35 (89) | 30 (76) | |

Black

| | | | | |
|-----------|-----------------|---------|---------|--|
| K2985-M | 40-42 (102-107) | 31 (79) | 30 (76) | |
| K2985-L | 44-46 (112-117) | 32 (81) | 30 (76) | |
| K2985-XL | 48-50 (122-127) | 33 (84) | 30 (76) | |
| K2985-2XL | 52-54 (132-137) | 34 (86) | 30 (76) | |
| K2985-3XL | 56-58 (142-147) | 35 (89) | 30 (76) | |

| Part No./ Size | Chest Measurement in (cm) | Sleeve Length in (cm) | Torso Size in (cm) | Coat Length in (cm) |
|----------------|---------------------------|-----------------------|--------------------|---------------------|
|----------------|---------------------------|-----------------------|--------------------|---------------------|

Split Leather Welding Apron

| | | | | |
|-----------|-------------------|--|--|--|
| K3110-ALL | One Size Fits All | | | |
|-----------|-------------------|--|--|--|

FR Welding Lab Coat

| | | | | |
|----------|-----------------|---------|--|----------|
| K3112-M | 40-42 (102-107) | 31 (79) | | 45 (114) |
| K3112-L | 44-46 (112-117) | 32 (81) | | 45 (114) |
| K3112-XL | 48-50 (122-127) | 33 (84) | | 45 (114) |

FR Welding Shirt

Khaki

| | | | | |
|-----------|-----------------|---------|---------|--|
| K3382-M | 40-42 (102-107) | 32 (81) | 32 (81) | |
| K3382-L | 44-46 (112-117) | 33 (84) | 33 (84) | |
| K3382-XL | 48-50 (122-127) | 34 (86) | 34 (86) | |
| K3382-2XL | 52-54 (132-137) | 35 (89) | 35 (89) | |

Black

| | | | | |
|-----------|-----------------|---------|---------|--|
| K3113-M | 40-42 (102-107) | 32 (81) | 32 (81) | |
| K3113-L | 44-46 (112-117) | 33 (84) | 33 (84) | |
| K3113-XL | 48-50 (122-127) | 34 (86) | 34 (86) | |
| K3113-2XL | 52-54 (132-137) | 35 (89) | 35 (89) | |
| K3113-3XL | 56-58 (142-147) | 36 (91) | 36 (91) | |

Split Leather FR Welding Sleeves

| | | | | |
|-----------|--|---------|--|--|
| K3111-ALL | | 21 (53) | | |
|-----------|--|---------|--|--|

| Part No./ Size | Bust Size in (cm) | Sleeve Length in (cm) | Torso Size in (cm) | Waist Size in (cm) |
|----------------|-------------------|-----------------------|--------------------|--------------------|
|----------------|-------------------|-----------------------|--------------------|--------------------|

Jessi Combs Women's Shadow™ Split Leather-Sleeved Jacket

| | | | | |
|----------|-----------------|---------|---------|----------------|
| K3114-XS | 32-36 (81-91) | 28 (71) | 27 (68) | 28-32 (71-81) |
| K3114-S | 36-39 (91-99) | 28 (71) | 27 (68) | 32-34 (81-86) |
| K3114-M | 39-41 (99-104) | 29 (74) | 27 (68) | 34-36 (86-91) |
| K3114-L | 41-43 (104-109) | 30 (76) | 27 (68) | 36-38 (91-96) |
| K3114-XL | 43-46 (109-117) | 31 (79) | 27 (68) | 38-42 (96-107) |

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Welding Gear Ready-Pak® Packages

Premium Welding Gear Ready-Pak®

- Lincoln® Industrial Duffle Bag
- VIKING™ Black 3350 Series Auto-Darkening Helmet
- Shadow™ Split Leather-Sleeved Jacket
- Premium Leather MIG/Stick Welding Gloves
- Full Leather Steelworker™ Gloves
- Finish Line™ Clear Safety Glasses
- Split Leather FR Welding Sleeves
- FR Doo Rag

Traditional Welding Gear Ready-Pak®

- Lincoln® Industrial Duffle Bag
- VIKING™ Black 1840 Series Auto-Darkening Helmet
- Traditional FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Full Leather Steelworker™ Gloves
- Lincoln® Starlite® Clear Safety Glasses
- FR Doo Rag

Jessi Combs Women's Welding Gear Ready-Pak®

- Lincoln® Industrial Duffle Bag
- VIKING™ Jessi vs. The Robot™ 3350 Series Auto-Darkening Helmet
- Jessi Combs Women's Shadow™ FR Welding Jacket
- Jessi Combs MIG/Stick Welding Gloves
- Jessi Combs Steelworker™ Gloves
- Women's Starlite® Clear Safety Glasses
- FR Doo Rag

Standard Welding Gear Ready-Pak®

- Lincoln® Industrial Duffle Bag
- Industrial Passive Welding Helmet
- Traditional Khaki FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Lincoln® Startlite® Clear Safety Glasses
- FR Doo Rag
- Spring Handle Chipping Hammer
- Radius™ Welding Pliers
- Radius 3 x19 Carbon Steel Wire Brush

VIKING™ PAPR 3350 Welding Helmet

Includes

- Blower Unit
- VIKING™ 3350 Black Helmet
- Head Cover
- Hose
- 2 Particulate Filters
- 29-52 in. (736.6-1,320.8 mm) Padded Belt
- Shoulder Strap
- 120V Battery Charger
- Duffle Bag
- Rechargeable Battery
- Pre-Filter
- Spark Guard
- Hose Cover
- Extra helmet cover lenses:
 - Inside quantity, 2
 - Outside quantity, 5
- Instruction Manual



Shown:
Standard Welding Gear
Ready-Pak®



Shown:
VIKING™ PAPR
Welding Helmet

Accessories » Welding Helmets

| Product Name | Dimensions | Package Quantity | Product Number | 700G Series | 750S Series | VIKING™ 1740 Series | VIKING™ 1840 Series | VIKING™ 2450 Series | VIKING™ 2450D Series | VIKING™ 3350 Series |
|--|---|------------------|----------------|-------------|-------------|---------------------|---------------------|---------------------|----------------------|---------------------|
| 1740 ADF Cartridge | DIN 110 X 90 | 1 | KP3284-1 | | | • | | | | |
| 700G/1840 ADF Cartridge | DINS 110 X 90 | 1 | KP2853-3 | • | | | • | | | |
| 2450 Series ADF Cartridge | STD 4 X 5 | 1 | KP2932-3 | | | | | • | | |
| 2450D Series ADF Cartridge | STD 4 X 5 | 1 | KP3243-3 | | | | | | • | |
| 3350 Series ADF Cartridge | STD 4 X 5 | 1 | KP3045-3 | | | | | | | • |
| 750S Series ADF Cartridge | STD 4 X 5 | 1 | KP2899-1 | | • | | | | | |
| Inside Clear Cover Lens | 96 x 51.6 x 1.0 mm [3.78 x 2.03 x .04 in] | 5 | KP2897-1 | • | • | | • | | | |
| Outside Clear Cover Lens | 114 x 133 x 1.0 mm [4.5 x 5.25 x .04 in] | 5 | KP2898-1 | | • | | | • | • | • |
| Outside Clear Cover Lens | 112 x 91.3 x 1.5 mm [4.41 x 3.59 x .06 in] | 5 | KP2913-1 | • | | | | | | |
| Inside Clear Cover Lens | 98.5 x 66.5 x 1.0 mm [3.88 x 2.62 x .04 in] | 5 | KP2931-1 | | | | | • | • | |
| Outside Clear Cover Lens | 114 x 100 x 1.5 mm [4.5 x 3.94 x .06 in] | 5 | KP3043-1 | | | • | • | | | |
| 3350 Inside Clear Cover Lens | 94.7 x 89.7 x 1.0 mm [3.73 x 3.53 x .04 in] | 5 | KP3044-1 | | | | | | | • |
| 1740 Inside Clear Cover Lens Kit | 95.9 x 47.2 x 1.00 mm | 5 | KP3283-1 | | | • | | | | |
| Cheater Lens 1.00 Mag | 2 x 4.25 Frame, 1.0 Mag | 1 | KP3046-100 | • | | • | • | • | • | • |
| Cheater Lens 1.25 Mag | 2 x 4.25 Frame, 1.25 Mag | 1 | KP3046-125 | • | | • | • | • | • | • |
| Cheater Lens 1.50 Mag | 2 x 4.25 Frame, 1.5 Mag | 1 | KP3046-150 | • | | • | • | • | • | • |
| Cheater Lens 1.75 Mag | 2 x 4.25 Frame, 1.75 Mag | 1 | KP3046-175 | • | | • | • | • | • | • |
| Cheater Lens 2.00 Mag | 2 x 4.25 Frame, 2.0 Mag | 1 | KP3046-200 | • | | • | • | • | • | • |
| Cheater Lens 2.25 Mag | 2 x 4.25 Frame, 2.25 Mag | 1 | KP3046-225 | • | | • | • | • | • | • |
| Cheater Lens 2.50 Mag | 2 x 4.25 Frame, 2.5 Mag | 1 | KP3046-250 | • | | • | • | • | • | • |
| Sweatband | N/A | 2 | KP2930-1 | • | • | • | • | • | • | • |
| Sweatband | N/A | 2 | KP2854-1 | • | • | | | | | |
| Headgear w/Sweatband | N/A | 1 | KP2929-1 | | | • | • | • | • | • |
| Headgear w/Sweatband | N/A | 1 | KP2851-1 | • | • | | | | | |
| Hard Hat Adapter | N/A | 1 | KP3047-1 | | | • | • | • | • | • |
| Black Replacement Shell | N/A | 1 | S27978-54 | | | | • | | | |
| Outside Cover Lens Seal | N/A | 1 | S27978-58 | | | • | • | | | |
| ADF Holder | N/A | 1 | S27978-55 | | | • | • | | | |
| Black Replacement Shell | N/A | 1 | S27978-31 | | | | | • | • | • |
| Outside Cover Lens Seal | N/A | 1 | S27978-32 | | • | | | • | • | • |
| ADF Holder | N/A | 1 | S27978-33 | | | | | • | • | • |
| Black Replacement Shell (matte finish) | N/A | 1 | S27978-95 | | | • | | | | |
| VIKING™ Pivot Headgear Kit | N/A | 1 | KP3908-1 | | | | • | • | • | • |

• Optional

Replacement Parts » VIKING™ PAPR™ 3350 Helmet

| Product Name | Dimensions | Package Qty. | Product Number |
|--|--------------------------|--------------|----------------|
| VIKING™ PAPR 3350 Helmet Assembly (PKG includes Headgear and Headcovering) | N/A | 1 | K3930-1 |
| Outside Cover Lens | 5.25 x 4.5 in | 5 | KP2898-1 |
| Outside Cover Lens Seal | N/A | 1 | S27978-32 |
| 3350 Auto-Darkening Lens | N/A | 1 | KP3045-2 |
| Inside Cover Lens | 3.53 x 3.73 in | 5 | KP3044-1 |
| Lens Holder | N/A | 1 | S27978-33 |
| Headgear (including plenum and sweatband) | N/A | 1 | KP3942-1 |
| Sweatband | N/A | 2 | KP3943-1 |
| Headcovering (w/hook and loop attachment) | N/A | 1 | KP3940-1 |
| Blower Assembly (PKG includes filter cover assembly) | N/A | 1 | KP3944-1 |
| Battery Pack-Standard | N/A | 1 | KP3937-1 |
| HE Filter Assembly | N/A | 2 | KP3934-2 |
| HE Filter Assembly | N/A | 6 | KP3934-6 |
| Pre-filter | N/A | 6 | KP3935-1 |
| Spark Screen | N/A | 1 | KP3936-1 |
| Battery Charger | N/A | 1 | KP3932-1 |
| PAPR Belt Assembly | N/A | 1 | KP5123-1 |
| Shoulder Strap Assembly | N/A | 1 | KP5124-1 |
| Belt Extension (extends belt to 60 in.) | N/A | 1 | KP3939-1 |
| Hose Assembly with Cover | N/A | 1 | KP5122-1 |
| Cheater Lens 1.00 MAG | 2 X 4.25 FRAME, 1.0 MAG | 1 | KP3046-100 |
| Cheater Lens 1.25 MAG | 2 X 4.25 FRAME, 1.25 MAG | 1 | KP3046-125 |
| Cheater Lens 1.50 MAG | 2 X 4.25 FRAME, 1.5 MAG | 1 | KP3046-150 |
| Cheater Lens 1.75 MAG | 2 X 4.25 FRAME, 1.75 MAG | 1 | KP3046-175 |
| Cheater Lens 2.00 MAG | 2 X 4.25 FRAME, 2.0 MAG | 1 | KP3046-200 |
| Cheater Lens 2.25 MAG | 2 X 4.25 FRAME, 2.25 MAG | 1 | KP3046-225 |
| Cheater Lens 2.50 MAG | 2 X 4.25 FRAME, 2.5 MAG | 1 | KP3046-250 |
| Duffle Bag | N/A | 1 | K3096-1 |

Tel: (+974) 443 54 298
www.boltsandtools.com

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www.boltsandtools.com

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GUNS AND TORCHES

MAGNUM® PRO GUNS » L-Series · Curve™ Series · Barrel Series · Fume Extraction · Innershield® · Robotic · Spool Guns · Push-Pull

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Magnum® PRO 100L Gun and Cable Assembly

Light and Compact

- Ideal for most home, farm and small shop projects, auto body work and light maintenance or repair applications
- Copper Plus® contact tips extend tip life to lower overall operational costs
- Lightweight curved handle provides a comfortable grip that keeps your hand cool during long welds
- Integrated gun connector is designed for POWER MIG® wire feeder/welders



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 140C
- POWER MIG® 180C
- POWER MIG® 180 Dual

Literature

E12.31

| Product Name | Product Number | Cable Length ft (m) | Rated Current (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|------------------|----------------|---------------------|----------------------|------------------------------------|-----------------------------|
| Magnum® PRO 100L | K3080-1 | 10 (3.0) | 100 | 40% | 0.025-0.045 [0.6-1.1] |

Magnum® PRO 175L Gun and Cable Assembly

Compact and Powerful

- Ideal for most home, farm and small shop projects, as well as auto body work and light maintenance and repair applications
- Copper Plus® contact tips extend tip life to lower overall operational costs
- Lightweight curved handle provides a comfortable grip that keeps your hand cool during long welds
- Integrated gun connector is designed for Lincoln Electric POWER MIG® wire feeder/welders



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 210 MP

Literature

E12.33

| Product Name | Product Number | Cable Length ft (m) | Rated Current (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|------------------|----------------|---------------------|----------------------|------------------------------------|-----------------------------|
| Magnum® PRO 175L | K4076-1 | 10 (3.0) | 175 | 40% | 0.025-0.045 [0.6-1.1] |

Magnum® PRO 250L Gun and Cable Assembly

Medium Duty MIG Welding Gun

- With sufficient amperage for bigger jobs, the Magnum® PRO 250L is recommended for medium-duty job shop and production applications
- High-quality copper expendable parts ensure superior electrical contact and heat dissipation
- Chrome plated gun tube for enhanced durability
- Integrated gun connector is designed for POWER MIG® wire feeder/welders



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Standard On:

- POWER MIG® 216
- POWER MIG® 256

Literature

E12.32

| Product Name | Product Number | Cable Length ft (m) | Rated Current (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|------------------|----------------|---------------------|----------------------|------------------------------------|-----------------------------|
| Magnum® PRO 250L | K3081-2 | 15 (4.5) | 250 | 40% | 0.025-0.045 [0.6-1.1] |

Magnum® PRO Curve™ 200 Series

Compact Industrial Grade Construction

- Two finger trigger for increased operator comfort
- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|-----------------------------------|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Curve™ 200 Series | K2950-1 | 10 (3.0) | 200/150 | 60% | 0.025-3/64 (0.6-1.2) |
| | K2950-2 | 15 (4.5) | | | |
| Ready-Pak® Package ⁽¹⁾ | K2950-2-10-45 | 15 (4.5) | 200/150 | 60% | 0.025-3/64 (0.6-1.2) |

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

Magnum® PRO Curve™ 300 Series

A Step Up on the Curve

- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Dual trigger leads for faster repairs and less downtime
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|---------------------------------|-------------------------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Curve™ 300 Series | K2951-1 | 10 (3.0) | 300/200 | 60% | 0.025-5/64 (0.6-2.0) |
| | K2951-2 | 15 (4.5) | | | |
| | K2951-3 | 20 (6.1) | | | |
| | K2951-4 | 25 (7.6) | | | |
| Dual Procedure (Switch Control) | K3130-1 | 10 (3.0) | 300/200 | 60% | 0.025-5/64 (0.6-2.0) |
| | K3130-2 | 15 (4.5) | | | |
| | K3130-3 | 20 (6.1) | | | |
| | K3130-4 | 25 (7.6) | | | |
| Dual Schedule (Trigger Control) | K3092-1 | 10 (3.0) | 300/200 | 60% | 0.025-5/64 (0.6-2.0) |
| | K3092-2 | 15 (4.5) | | | |
| | K3092-3 | 20 (6.1) | | | |
| | K3092-4 | 25 (7.6) | | | |
| Ready Pak® Package | K2951-2-6-45 ⁽¹⁾ | 15 (4.5) | 300/200 | 60% | 0.025-5/64 (0.6-2.0) |
| | K2951-2-10-45 ⁽²⁾ | | | | |
| | K2951-2-10-116 ⁽³⁾ | | | | |

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-6 Connector Kit.

⁽²⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

⁽³⁾Includes 0.052-1/16 in. (1.3-1.6 mm) liner and K466-10 Connector Kit

Magnum® PRO Curve™ 400 Series

Get in Front of the Curve

- Lightweight curved handle provides a comfortable grip
- Rotating gun tube reduces fatigue and allows the gun to fit into tight spaces
- Dual trigger leads for faster repairs and less downtime
- Integrated strain relief for extended service life
- Copper Plus® contact tips feature a larger tip diameter and mass to improve heat dissipation and increase tip life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.05

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|-----------------------------------|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Curve™ 400 Series | K2952-1 | 10 (3.0) | 400/400 @ 50% DC | 60% | 0.025-5/64 (0.6-2.0) |
| | K2952-2 | 15 (4.5) | | | |
| | K2952-3 | 20 (6.1) | | | |
| | K2952-4 | 25 (7.6) | | | |
| Dual Procedure (Switch Control) | K3098-1 | 10 (3.0) | 400/400 @ 50% DC | 60% | 0.025-5/64 (0.6-2.0) |
| | K3098-2 | 15 (4.5) | | | |
| | K3098-3 | 20 (6.1) | | | |
| | K3098-4 | 25 (7.6) | | | |
| Dual Schedule (Trigger Control) | K3093-1 | 10 (3.0) | 400/400 @ 50% DC | 60% | 0.025-5/64 (0.6-2.0) |
| | K3093-2 | 15 (4.5) | | | |
| | K3093-3 | 20 (6.1) | | | |
| | K3093-4 | 25 (7.6) | | | |
| Short Neck | K3055-1 | 10 (3.0) | 400/400 @ 50% DC | 60% | 0.025-5/64 (0.6-2.0) |
| | K3055-2 | 15 (4.5) | | | |
| | K3055-3 | 20 (6.1) | | | |
| | K3055-4 | 25 (7.6) | | | |
| Ready-Pak® Package ⁽¹⁾ | K2952-2-10-45 | 15 (4.5) | 400/400 @ 50% DC | 60% | 0.025-5/64 (0.6-2.0) |

⁽¹⁾Includes 0.035-0.045 in. (0.9-1.2 mm) liner and K466-10 Connector Kit.

Magnum® PRO Barrel 250 Gun

Compact Industrial Grade Construction

- Built for extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Four standard trigger leads
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

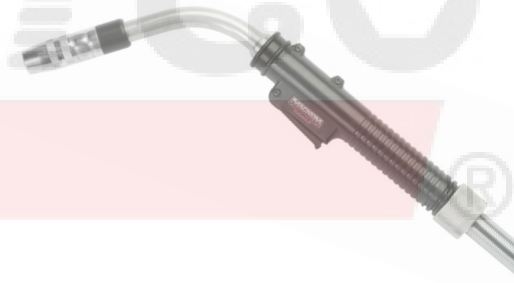
| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|-----------------------------------|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Barrel 250 Gun | K2651-1 | 10 (3.0) | 250/250 | 100% | 0.035-5/64 (0.9-2.0) |
| | K2651-2 | 15 (4.5) | | | |
| | K2651-3 | 20 (6.1) | | | |
| | K2651-4 | 25 (7.6) | | | |
| Ready-Pak® Package ⁽¹⁾ | K2651-2-6-45 | 15 (4.5) | 250/250 | 100% | 0.035-0.045 (0.9-1.2) |

⁽¹⁾Includes 0.035-0.045 liner and K466-6 connector kit

Magnum® PRO Barrel 350 Gun

Step up to More Applications

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|-----------------------------------|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Barrel 350 Gun | K2652-1 | 10 (3.0) | 350/285 | 100% | 0.035-5/64 (0.9-2.0) |
| | K2652-2 | 15 (4.5) | | | |
| | K2652-3 | 20 (6.1) | | | |
| | K2652-4 | 25 (7.6) | | | |
| Dual Procedure (Switch Control) | K3131-1 | 10 (3.0) | 350/285 | 100% | 0.035-5/64 (0.9-2.0) |
| | K3131-2 | 15 (4.5) | | | |
| | K3131-3 | 20 (6.1) | | | |
| | K3131-4 | 25 (7.6) | | | |
| Dual Schedule (Trigger Control) | K3132-1 | 10 (3.0) | 350/285 | 100% | 0.035-5/64 (0.9-2.0) |
| | K3132-2 | 15 (4.5) | | | |
| | K3132-3 | 20 (6.1) | | | |
| | K3132-4 | 25 (7.6) | | | |
| Ready-Pak® Package ⁽¹⁾ | K2652-2-10-45 | 15 (4.5) | 350/285 | 100% | 0.035-0.045 (0.9-1.2) |

⁽¹⁾Includes 0.035-0.045 liner and K466-10 connector kit

Magnum® PRO Barrel 450 Gun

Tackle Just About Any MIG
 or Flux-Cored Job

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed [Amps] | Duty Cycle [100% CO ₂] | Wire Diameter Range in [mm] |
|-----------------------------------|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Barrel 450 Gun | K2653-1 | 10 (3.0) | 450/325 | 100% | 0.035-5/64 (0.9-2.0) |
| | K2653-2 | 15 (4.5) | | | |
| | K2653-3 | 20 (6.1) | | | |
| | K2653-4 | 25 (7.6) | | | |
| Dual Procedure (Switch Control) | K3133-1 | 10 (3.0) | 450/325 | 100% | 0.035-5/64 (0.9-2.0) |
| | K3133-2 | 15 (4.5) | | | |
| | K3133-3 | 20 (6.1) | | | |
| | K3133-4 | 25 (7.6) | | | |
| Dual Schedule (Trigger Control) | K3134-1 | 10 (3.0) | 450/325 | 100% | 0.035-5/64 (0.9-2.0) |
| | K3134-2 | 15 (4.5) | | | |
| | K3134-3 | 20 (6.1) | | | |
| | K3134-4 | 25 (7.6) | | | |
| Ready-Pak® Package ⁽¹⁾ | K2653-2-10-45 | 15 (4.5) | 450/325 | 100% | 0.035-0.045 (0.9-1.2) |

⁽¹⁾Includes 0.035-0.045 liner and K466-10 connector kit

Magnum® PRO Barrel 550 Gun

Designed for High Amperage Welding

- Built for high amperage extreme environment welding where heat-resistance and fast serviceability are key
- Rated at 100% duty cycle
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Available Dual Procedure (switch control) and Dual Schedule (trigger control) models



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.01

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|--|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Barrel 550 Gun | K2655-1 | 10 (3.0) | 550/375 | 100% | 0.035-1/8 (0.9-3.2) |
| | K2655-2 | 15 (4.5) | | | |
| | K2655-3 | 20 (6.1) | | | |
| | K2655-4 | 25 (7.6) | | | |
| Dual Procedure (Switch Control) | K3135-1 | 10 (3.0) | 550/375 | 100% | 0.035-1/8 (0.9-3.2) |
| | K3135-2 | 15 (4.5) | | | |
| | K3135-3 | 20 (6.1) | | | |
| | K3135-4 | 25 (7.6) | | | |
| Dual Schedule (Trigger Control) | K3136-1 | 10 (3.0) | 550/375 | 100% | 0.035-1/8 (0.9-3.2) |
| | K3136-2 | 15 (4.5) | | | |
| | K3136-3 | 20 (6.1) | | | |
| | K3136-4 | 25 (7.6) | | | |

Magnum® Welding Guns

Classic Gas-Shielded Guns

- Comfortable curved handle design
- Available in a number of amperage ranges and gun cable lengths
- Rotating gun tube and gun hanger clip
- Rated at 60% duty cycle



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.10

| Product Name | Cut Length ft (m) | Wire Diameter, in (mm) | | | | | | | | | 1/16-5/64 [1.6-2.0] | | |
|--------------|-------------------|------------------------|------------|---------|-----------------------|------------|---------|----------------------|------------|---------|---------------------|------------|---------|
| | | 0.025-0.035 [0.6-0.9] | | | 0.035-0.045 [0.9-1.2] | | | 0.052-1/16 [1.3-1.6] | | | Open-End | Fast-Mate™ | Package |
| | | Open-End | Fast-Mate™ | Package | Open-End | Fast-Mate™ | Package | Open-End | Fast-Mate™ | Package | | | |

Magnum® Guns Series

| | | | | | | | | | | | | | |
|--------------------|----------|--|--|-----------------------|--------|--|-----------------------|--------|------------------------|--------|--------|------------------------|--|
| 100L | 10 [3.0] | | | K530-5 | | | K530-3 (FCAW-SS only) | | | | | | |
| | | | | K530-6 ⁽¹⁾ | | | | | | | | | |
| 200 | 10 [3.0] | | | K497-2 | | | | | | | | | |
| | 15 [4.5] | | | K497-1 | K498-1 | K497-2 ⁽²⁾ | | | | | | | |
| 300 | 10 [3.0] | | | K470-1 | | | | | | | | | |
| | 15 [4.5] | | | K470-2 | | K1802-1 ⁽²⁾ | K470-4 | | | | K470-6 | | |
| 400 Standard | 10 [3.0] | | | K471-1 | | | | | | | | | |
| | 15 [4.5] | | | K471-2 | K479-2 | K2286-1 ⁽²⁾ K471-21 ⁽³⁾ | K471-4 | K479-4 | K471-22 ⁽³⁾ | K471-6 | K479-6 | | |
| | 20 [6.1] | | | K471-10 | | | K471-11 | | | | | | |
| | 25 [7.6] | | | K471-13 | | | K471-14 | | | 471-15 | | | |
| 400 Dual Schedule | 15 [4.5] | | | | | | | K575-2 | | | | | |
| 400 Dual Procedure | 15 [4.5] | | | K1722-2 | | | | | | | | | |
| 400 Short Neck | 15 [4.5] | | | K541-3 | | | | | | | | | |
| 450WC | 15 [4.5] | | | | | | | | K684-12 ⁽⁴⁾ | | | K684-12 ⁽⁴⁾ | |
| 550 | 15 [4.5] | | | | | | | K598-7 | | | | K598-11 ⁽⁵⁾ | |

Magnum 100L » ⁽¹⁾Includes 4-pin MS-Type connection for trigger control

Magnum 200 » ⁽²⁾Includes K466-1 Connector Kit

Magnum 300 » ⁽³⁾Includes K466-10 Connector Kit

Magnum 400 Standard » ⁽²⁾Includes K466-1 Connector Kit ⁽³⁾Includes K466-10 Connector Kit

Magnum 450WC » ⁽⁴⁾0.035-1/16 in. (0.9-1.6 mm) Solid Wire, 0.045-5/64 in. (1.2-2.0 mm) Flux-Cored Wire

Magnum 550 » ⁽⁵⁾600A Open End 5/64-3/32 in. (2.0-2.4 mm) Solid Wire

Magnum® PRO Fume Guns

Production-Ready Source Fume Extraction

- Rated at 100% duty cycle
- Innovative strain relief swivels to take pressure off the operator's wrist
- Four standard trigger leads
- Anti-Seize™ tip and diffuser and Copper Plus® contact tips improve heat dissipation and increase part service life
- Select the more compact 350 amp model or the high amperage 550 amp model for thicker materials



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.02

| Product Name | Product Number | Cable Length ft (m) | Rated Current CO ₂ / Mixed (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|---|----------------|---------------------|--|------------------------------------|-----------------------------|
| Magnum® PRO Fume Gun 350 ⁽¹⁾ | K2649-1 | 15 (4.5) | 350/285 | 100% | 0.035-5/64 (0.9-2.0) |
| Magnum® PRO Fume Gun 550 ⁽¹⁾ | K2650-1 | 15 (4.5) | 550/375 | 100% | 0.035-1/8 (0.9-3.2) |

⁽¹⁾Recommended with X-Tractor 3A, 5A, and 8A. See Weld Fume Control Section for other Fume Extraction attachments and accessories.

K126™ PRO

The Leader in Construction Welding Guns

- Replaceable liner
- Interchangeable gun connectors expand compatibility with a wide range of feeders
- Integrated trigger leads in coaxial cable resists job site abrasion
- Stainless steel gun tube jacket and plated steel strain relief resist spatter and extend life
- Available with a variety of reverse and non-reverse gun tube jackets



Processes

- Flux-Cored Self-Shielded

Literature

E12.111

| Product Name | Product Number | Cable Length ft (m) | Rated Current (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) | Connector |
|--------------|----------------|---------------------|----------------------|------------------------------------|-----------------------------|-----------|
| K-126™ PRO | K126-10 | 10 (3.0) | 350 | 60% | 0.035-0.120 (0.9-3.0) | K613-6 |
| | K126-11 | 15 (4.5) | | | | K613-6 |
| | K126-12 | 15 (4.5) | | | | K466-10 |
| | K126-13 | 15 (4.5) | | | | K466-1 |

Innershield® Guns

Classic Flux-Cored Self-Shielded Guns

- A number of models are offered for amperage ratings from 350 to 600 amps
- Rated at 60% duty cycle



Processes

- Flux-Cored Self-Shielded

Literature

E12.110

| Product Name | Rated Current @ 60% Duty Cycle | Length ft (m) | Feeding Capability – Wire Diameter, in (mm) | | | | | | | Tube Angle |
|----------------|--------------------------------|---------------|---|------------|-------------|-------------|------------|------------|------------|------------|
| | | | 0.062 [1.6] | 1/16 [1.6] | 0.068 [1.7] | 0.072 [1.8] | 5/64 [2.0] | 3/32 [2.4] | 7/64 [2.8] | |
| K126-1 Classic | 350A | 10 [3.0] | • | • | • | • | • | • | | 62° |
| K126-2 Classic | | 15 [4.5] | • | • | • | • | • | | | |
| K345-10 | | 10 [3.0] | | | | | | | | 90° |
| K115-1 | 450A | 10 [3.0] | | | | | | | • | 82° |
| K115-2 | | 15 [4.5] | | | | | | | • | |
| K115-3 | | 10 [3.0] | | | | | | | • | |
| K115-4 | | 15 [4.5] | | | | | | | • | |
| K115-8 | | 15 [4.5] | | | | | | | • | 45° |
| K115-10 | | 15 [4.5] | | | | | | | • | |
| K116-2 | | 600A | 15 [4.5] | | | | | | | • |

Submerged Arc Guns

For Hand-held Submerged Arc Applications

- Suitable for 5/64 and 3/32 in. (2.0 and 2.4 mm) wire diameters
- Ideal for submerged arc short welds or seams with poor fit up best address by an operator
- Rated 600 amps



Processes

- Submerged Arc

Literature

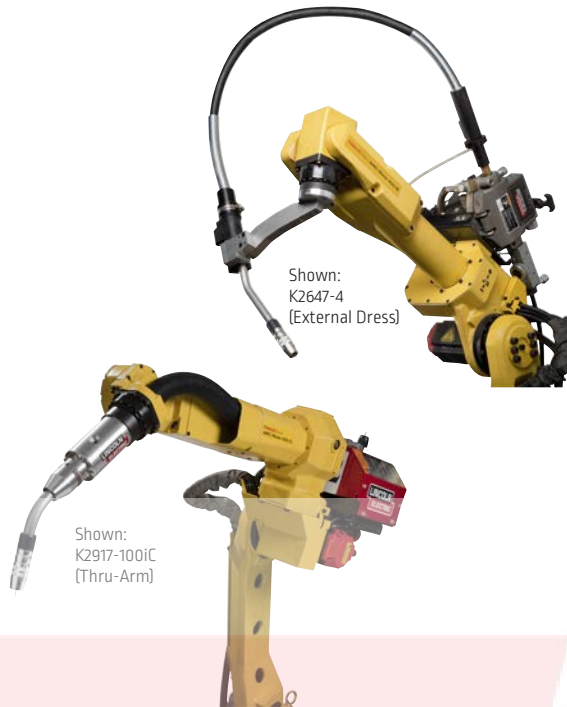
lincolnelectric.com

| Product Name | Product Number | Rated Current (amps) | Wire Diameter Range in (mm) | Cable Length ft (m) |
|------------------------------|----------------|----------------------|-----------------------------|---------------------|
| Submerged Arc Gun | K113-1 | 600 | 5/64 [2.0] | 15 [4.5] |
| | K113-2 | 600 | 3/32 [2.4] | 15 [4.5] |
| Mechanized Submerged Arc Gun | K114 | 600 | 5/64-3/32 [2.0-2.4] | 15 [4.5] |

Magnum® PRO Robotic

External Dress and Thru-Arm Torches

- Single Tool Center Point (TCP) makes changing between 350A and 550A torch expendable parts easy
- Cables exceed industry standards by a factor of two in durability testing
- 350A and 550A rated consumables are interchangeable across all gun models
- HexConnect™ full face contact gun bushing ensures better electrical conductivity
- Extended reach mounting bracket optimizes clearance for tough-to-reach welding applications



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.03

| Product Name | Product Number | Cable Length ft (m) | Rated Current (Amps) | Duty Cycle (100% CO ₂) | Wire Diameter Range in (mm) |
|--|------------------|--|----------------------|------------------------------------|-----------------------------|
| EXTERNAL DRESS GUN (AIR-COOLED) | | | | | |
| Magnum® PRO Robotic 550 | K2647-4 | 4 (1.2) | 550 | 100% | 0.035-5/64 (0.9-2.0) |
| | K2647-5L | 5.5 (1.7) | | | |
| | K2647-8 | 8 (2.4) | | | |
| | K2647-11 | 11 (3.3) | | | |
| THRU-ARM GUN (AIR-COOLED) | | | | | |
| Magnum® PRO Robotic 550 | K3353-100iC | Predetermined length per robotic arm selection | 550 | 100% [®] | 0.035-5/64 (0.9-2.0) |
| Fanuc® 100iC Ready-Pak® | K3359-100iC | | | | |
| w/Air Blast® | K3359-100iCA | | | | |
| w/Wire Brake | K3359-100iCW | | | | |
| Fanuc® 120iC Ready-Pak® | K3359-120iC | | | | |
| w/Air Blast | K3359-120iCA | | | | |
| w/Wire Brake | K3359-120iCW | | | | |
| Fanuc® 100iC/6L Ready-Pak® | K3359-100iC/6L | | | | |
| w/Air Blast | K3359-100iC/6LA | | | | |
| w/Wire Brake | K3359-100iC/6LW | | | | |
| Fanuc® 120iC/10L Ready-Pak® | K3359-120iC/10L | | | | |
| w/Air Blast | K3359-120iC/10LA | | | | |
| w/Wire Brake | K3359-120iC/10LW | | | | |

NOTE » All trademarks and requested trademarks are property of their respective owners.

Magnum® PRO 100SG Spool Gun

Precise Feeding Performance

- Lightweight and easy to use
- Ergonomic grip and balanced design
- Excellent trigger feedback, even through a welding glove
- No bulky adapter module required
- Premium Magnum® PRO expendable gun parts improve heat dissipation and extend life



Processes

- MIG

Literature

E12.20

| Product Name | Product Number | Length ft (m) | Wire Size Range in (mm) | Rated Current/ Duty Cycle | Machine | Adapter |
|-------------------|----------------|---------------|-------------------------|---------------------------|--|---------|
| Magnum® PRO 100SG | K3269-1 | 10 (3.0) | 0.030-0.035 (0.8-0.9) | 130A/30% | POWER MIG® 140C POWER MIG® 180C POWER MIG® 180 Dual POWER MIG® 210 MP POWER MIG® 216 | None |

Magnum® SG Spool Gun

Full-Control Wire Feeding

- Large handle and trigger for easy use with gloved hands
- Clear spool gun drive cover makes it easy to check the wire drive path
- Rugged nozzle designed to withstand harsh industrial environments
- 250 amp rating and generous 25 ft (7.5 m) gun cable



Processes

- MIG

Literature

E12.22

| Product Name | Product Number | Length ft (m) | Wire Size Range in (mm) | Rated Current/ Duty Cycle | Machine | Adapter |
|----------------------|----------------|---------------|-------------------------|---------------------------|----------------|---------|
| Magnum® SG Spool Gun | K487-25 | 25 (7.5) | .025-3/64 (0.6-1.2) | 250A/60% | POWER MIG® 216 | K2703-1 |
| | | | | | POWER MIG® 256 | K2445-1 |

Magnum® 250LX™ Spool Gun

Professional Grade Durability and Performance

- Adjust wire speed remotely at the gun for fewer trips back to the power source
- Adjustment-free spool brake automatically prevents wire tangles
- 280 amp rating and generous 25 ft (7.5 m) gun cable
- Tool-less drive tension makes fine adjustment easy



Processes

- MIG
- Pulsed

Literature

E12.25

| Product Name | Product Number | Length ft (m) | Wire Size Range in (mm) | Rated Current/ Duty Cycle | Machine | Adapter |
|--------------------------|----------------|---------------|-------------------------|---|------------------|---------|
| Magnum® 250LX™ Spool Gun | K2490-1 | 25 (7.5) | .025-3/64 (0.6-1.2) | CO ₂ : 300A/60% Ar : 280A/60% Ar : 200A/100% | POWER MIG® 216 | None |
| | | | | | POWER MIG® 256 | None |
| | | | | | POWER MIG® 350MP | K2703-1 |
| | | | | | Power Wave® C300 | K2910-1 |



Cougar™ Pistol-Grip Air-Cooled Push-Pull Guns

Comfortable Grip. Industrial Performance.

- Fatigue-reducing design is intended for operators who prefer an upright pistol-grip
- Premium Magnum® PRO expendable gun parts improve heat dissipation and extend life
- Tool-less Drive Roll Changes – Our slip-fit dual-groove drive rolls install without tools and feature a D-contour to prevent unwanted spinning



Processes

- MIG
- Pulsed MIG
- Flux-Cored

Literature

E12.16

| Product Name | Product Number | Current Rated Current 100% Argon | Wire Diameter Range in (mm) | Cable Length ft (m) |
|-------------------------------------|----------------|----------------------------------|-----------------------------|---------------------|
| Cougar™ Pistol-Grip Air-Cooled Guns | K2704-2 | 300A @ 60% Duty Cycle | 0.035-1/16 (0.9-1.6) | 25 (7.6) |
| | K2704-3 | | | 50 (15.2) |

Magnum® PRO AL Air-Cooled Push-Pull Guns

Superior Features. Superior Feeding for Aluminum.

- Just remove a single set screw to easily remove the Quick-Change™ liner
- Uses Magnum® PRO expendables common with all of our other Magnum® PRO MIG guns
- Recessed adjustment dial is located at the bottom of the handle to prevent a change while welding
- EZ-Lock™ system allows you to change or rotate barrels anytime



Processes

- MIG
- Pulsed MIG

Output



Input



Literature

E12.14

| Product Name | Product Number | Current Rated Current 100% Argon | Wire Diameter Range in (mm) | Cable Length ft (m) |
|---|----------------|----------------------------------|-----------------------------|---------------------|
| Magnum® PRO AL G225A Air-Cooled Guns | | | | |
| 12-pin | K3355-1 | 225A @ 60% Duty Cycle | 0.035-1/16 (0.9-1.6) | 15 (4.6) |
| | K3355-2 | | | 25 (7.6) |
| | K3355-3 | | | 35 (10.7) |
| | K3355-4 | | | 50 (15.2) |
| 7-pin | K3356-1 | 225A @ 60% Duty Cycle | 0.035-1/16 (0.9-1.6) | 15 (4.6) |
| | K3356-2 | | | 25 (7.6) |
| | K3356-3 | | | 35 (10.7) |
| | K3356-4 | | | 50 (15.2) |

Magnum® PRO AL Water-Cooled Push-Pull Guns

Superior Features. Superior Feeding for Aluminum.

- Just remove a single set screw to easily remove the Quick-Change™ liner
- Uses Magnum® PRO expendables common with all of our other Magnum® PRO MIG guns
- Recessed adjustment dial is located at the bottom of the handle to prevent a change while welding
- EZ-Lock™ system allows you to change or rotate barrels anytime



Processes

- MIG
- Pulsed MIG

Output



Input



Literature

E12.14

| Product Name | Product Number | Current Rated Current 100% Argon | Wire Diameter Range in (mm) | Cable Length ft (m) |
|---|----------------|----------------------------------|-----------------------------|---------------------|
| Magnum® PRO AL G450W Water-Cooled Guns | | | | |
| 12-pin | K3357-1 | 450A @ 60% Duty Cycle | 0.035-1/16 (0.9-1.6) | 15 (4.6) |
| | K3357-2 | | | 25 (7.6) |
| | K3357-3 | | | 35 (10.7) |
| | K3357-4 | | | 50 (15.2) |
| 7-pin | K3358-1 | 450A @ 60% Duty Cycle | 0.035-1/16 (0.9-1.6) | 15 (4.6) |
| | K3358-2 | | | 25 (7.6) |
| | K3358-3 | | | 35 (10.7) |
| | K3358-4 | | | 50 (15.2) |

PTA-9 Series

Compact Low-Amperage Air-Cooled Torch

- Great choice for low amperage applications
- Available as a basic fixed head torch or also with Ultra-Flex cable for added maneuverability
- Rated 125 amps at 60% duty cycle



Processes

- TIG

Literature

E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in [mm] | Length ft (m) | Number of Cables |
|-------------------------------|------------------------|---------------|------------------------|---------------|------------------|
| Air-Cooled TIG Torches | | | | | |
| PTA-9 | K1781-1 | 125A @ 60% | 0.020-1/8 (0.5-3.2) | 12.5 (3.8) | 1 |
| | K1781-3 | | | 25.0 (7.6) | |
| PTA-9F Ultra-Flex™ | K1781-9 ⁽¹⁾ | 125A @ 60% | 0.020-1/8 (0.5-3.2) | 12.5 (3.8) | 1 |

⁽¹⁾Pre-configured package with K1622-1 Twist-Mate adapter and 1/16 in. (1.6 mm) gas lens collet body, collet and gas lens installed

PTA-17 Series

Your Go-To Air-Cooled TIG Torch

- Industrial TIG torch commonly used for a great number of applications
- Available in basic fixed head, flexible head, valve, flex head with valve, and fixed head with Ultraflex™ cable models
- Rated 150 amps at 60% duty cycle



Processes

- TIG

Literature

E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in [mm] | Length ft (m) | Number of Cables |
|--|----------------|---------------|------------------------|---------------|------------------|
| Air-Cooled TIG Torches | | | | | |
| PTA-17 | K1782-1 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 12.5 (3.8) | 1 |
| | K1782-2 | | | 12.5 (3.8) | 2 |
| | K1782-3 | | | 25.0 (7.6) | 1 |
| | K1782-4 | | | 25.0 (7.6) | 2 |
| PTA-17F | K1782-10 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 25.0 (7.6) | 1 |
| PTA-17FV | K1782-13 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 12.5 (3.8) | 1 |
| | K1782-11 | | | 25.0 (7.6) | 1 |
| PTA-17V | K1782-6 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 12.5 (3.8) | 1 |
| | K1782-7 | | | 12.5 (3.8) | 2 |
| | K1782-8 | | | 25.0 (7.6) | 1 |
| | K1782-9 | | | 25.0 (7.6) | 2 |
| PTA-17 Ultra-Flex™ | K1782-12 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 12.5 (3.8) | 1 |
| PTA-17F Ultra-Flex™ | K1782-15 | 150A @ 60% | 0.020-5/32 (0.5-4.0) | 12.5 (3.8) | 1 |
| PTA-17F Ultra-Flex™ Ready-Pak ⁽²⁾ | K1782-14 | | | | |

⁽¹⁾PTA-17 TIG Torch Ready-Pak[®] Includes: 150 Amp Air-Cooled Torch Package with Flexible Head and 12.5 ft. (3.8 m) Ultra-Flex™ Cable Assembly with Twist-Mate™ Adapter. Includes: #7 Nozzle, 1/16 in. (1.6 mm) and 3/32 in. (2.4 mm) Collets, Collet Bodies and E3[®] Tungsten

PTA-26 Series

High Amperage Air-Cooled TIG Torch

- High amperage air-cooled industrial TIG torch typically used for thicker materials
- Available in basic fixed head, flexible head, valve, and flex head with valve models



Processes
· TIG

Literature
E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in (mm) | Length ft (m) | Number of Cables |
|-------------------------------|----------------|---------------|------------------------|---------------|------------------|
| Air-Cooled TIG Torches | | | | | |
| PTA-26 | K1783-1 | 200A @ 60% | 0.020-5/32 [0.5-4.0] | 12.5 (3.8) | 1 |
| | K1783-2 | | | 12.5 (3.8) | 2 |
| | K1783-3 | | | 25.0 (7.6) | 1 |
| | K1783-4 | | | 25.0 (7.6) | 2 |
| PTA-26F | K1783-10 | 200A @ 60% | 0.020-5/32 [0.5-4.0] | 25.0 (7.6) | 1 |
| PTA-26FV | K1783-11 | 200A @ 60% | 0.020-5/32 [0.5-4.0] | 12.5 (3.8) | 1 |
| | | | | 25.0 (7.6) | 1 |
| PTA-26V | K1783-7 | 200A @ 60% | 0.020-5/32 [0.5-4.0] | 12.5 (3.8) | 2 |
| | K1783-8 | | | 25.0 (7.6) | 1 |
| | K1783-9 | | | 25.0 (7.6) | 2 |

PTW-20

Premium Water-Cooled TIG Torch for Most Applications

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control



Processes
· TIG

Literature
E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in (mm) | Length ft (m) | Number of Cables |
|---------------------------------|----------------|---------------|------------------------|---------------|------------------|
| Water-Cooled TIG Torches | | | | | |
| PTW-20 | K1784-3 | 250A @ 100% | 0.020-1/8 [0.5-3.2] | 12.5 (3.8) | 3 |
| | K1784-4 | | | 25.0 (7.6) | |

PTW-18

Premium High Amperage Water-Cooled TIG Torch

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control



Processes
· TIG

Literature
E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in (mm) | Length ft (m) | Number of Cables |
|---------------------------------|----------------|---------------|------------------------|---------------|------------------|
| Water-Cooled TIG Torches | | | | | |
| PTW-18 | K1784-1 | 350A @ 100% | 0.020-5/32 [0.5-4.0] | 12.5 (3.8) | 3 |
| | K1784-2 | | | 25.0 (7.6) | |

20H-320-25R

Premium High Amperage Water-Cooled TIG Torch Package

- Rugged high amperage TIG torch intended for industrial production environments
- Comfortable knurled handle provides a non-slip sure grip for precise control
- 320 Amps of capacity through industry standard 20 series front end torch design
- Includes premium cable cover



- **Processes**
- TIG
- **Literature**
- E12.150

| Product Name | Product Number | Rated Current | Tungsten Range in (mm) | Length ft (m) | Number of Cables |
|--------------|----------------|---------------|------------------------|---------------|------------------|
| 20H-320-25R | K4168-2 | 320A @ 100% | 0.020-1/8 (0.5-3.2) | 25 (7.6) | 3 |



Specifications Chart

Pro-Torch™ TIG Torches Adapters

| Model | Adapter Product No. |
|--|---------------------------------|
| For Precision TIG® 275 and 375 Power Sources | |
| PTA-26, 26V, 26F, 26FV (one-piece power cable) | K2166-1 |
| PTA-9, 9F, 17F, 17V, 17FV (one-piece power cable) | K2166-3 |
| PTA-17V, -26V (one-piece power cable) | K2166-2 |
| PTW-18, 20 and 20H-320 | None required |
| For Power Sources with 1/2 in Output Terminals (including TIG Module) | |
| PTW-18, 20 and 20H-320 | K2505-2, K1622-4 |
| PTA-26, 26F, 26V, 26FV (one-piece cable) | K2505-2, K1622-3 |
| PTA-9 (one-piece cable) | K2505-2, K1622-1 |
| PTA-17V, 26V (two-piece cable) | None required |
| For Square Wave® TIG 175, Precision TIG® 225, Invertec® V160-T, Aspect® 375 and Power Sources with Twist Mate™ Receptacle (with Gas Pass Through) | |
| PTA-9, -9F, 17, 17F, 17V, 17FV (one-piece cable) | K1622-1 |
| PTW-18, 20 and 20H-320 | K1622-4, K1622-5 ⁽¹⁾ |
| PTA-26, 26V, 26F, 26FV (one-piece cable) | K1622-3 |
| For Invertec® V155-S and Power Sources with Small Twist Mate™ Receptacle and Separate Gas | |
| PTW-18, 20, 20H-320 | K1622-6 |
| PTA-17V, 17VF (one-piece cable) | K960-4 |
| PTA-26V, 26FV (one-piece cable) | K960-3 |
| For Power MIG® 210 MP and Power Sources with Twist Mate™ Receptacle and Separate Gas | |
| PTA-17V, 17FV (one-piece cable) | K960-1 |

(1) Recommended for the Aspect® 375



CUTTING SYSTEMS

HAND-HELD PLASMA CUTTING SYSTEMS » Tomahawk® 375 Air · Tomahawk® 625 · Tomahawk® 1000

CNC PLATE CUTTING SYSTEMS » Tomahawk® 625 · Tomahawk® 1000 · Growth Series™ · Classic Series™ · Torchmate® Series™ · Spirit® II High Definition Plasma Cutting Power Sources · Burny® Shape Cutting Controllers · High Performance Plasma Consumables · Software and Accessories

CNC TUBE & PIPE CUTTING SYSTEMS » Masterpipe™ Mini Profiler · MasterPipe™ Profiler · MPM Pipe Cutting Machine · Master Tube Cutter · Vernon® Abrasive Saw

ROBOTIC CNC STRUCTURAL STEEL PLASMA CUTTING SYSTEM » PythonX®

Tomahawk® 375 Air

Plasma Cutting with Built-In Air

- Rated for up to 3/8 in. (9.5 mm) max cuts
- Internal air compressor enables operation in environments where external compressed air is not available
- Extremely portable at only 40 lbs. (18 kg)
- Touch Start™ system delivers reliable plasma arc initiation without high frequency
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc



Processes

- Plasma Cutting

Output



Input



Literature

E11.100

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Air Pressure Required | Air Flow Rate | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|---------------------------------|--|------------------------------------|--------------|-----------------------------|--|--|-----------------|
| Tomahawk® 375 Air | K2806-1 | 208/230/1/60 | 13A @ 85.2V 100% 18A @ 87.2V 60% 25A @ 90V 35% | 21.7A Pilot Current: 17A | 10-25A | 80-110 PSI (6.0-7.5 Bar) | 70 psi @ 125-200 SCFH 5 Bar @ 80L/min | 15.2 x 8.5 x 18.9 (385 x 215 x 480) | 40 (18) |



Tomahawk® 625

Plasma Cutting that Gets Around

- Rated for up to 5/8 in. (15.9 mm) max cuts
- Efficient electrode and nozzle design save money in the long run
- Compatible with Lincoln Electric Ranger® or Vantage® engine drives
- Touch Start™ system delivers reliable plasma arc initiation without high frequency
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc
- CNC cutting compatible - machine torch available



Processes

- Plasma Cutting

Output



Input



Literature

E11.200

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Air Pressure Required | Air Flow Rate | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------------|----------------|---------------------------------|--|------------------------------------|--------------|-----------------------------|--|--|-----------------|
| Tomahawk® 625 w/Hand Torch | K2807-1 | 208/230/1/50/60 | 24A @ 89.6V 100% 29A @ 91.8V 60% 40A @ 96.0V 35% | 36.8A Pilot Current: 17A | 10-40A | 80-110 PSI (6.0-7.5 Bar) | 70 psi @ 125-200 SCFH 5 Bar @ 80L/min | 15.2 x 8.5 x 18.9 (385 x 215 x 480) | 34 (15.4) |
| w/Machine Torch | K2807-2 | | | | | | | | |

Tomahawk® 1000

Plasma Cutting for Production Capacity

- Rated for up to 1 in. (25.4 mm) max cuts
- Touch Start™ system assures reliable arc initiation without generating disruptive high-frequency radio waves
- Front panel purge control makes it easy to set the air flow rate without initiating the plasma arc
- CNC cutting compatible - machine torch available



Processes

- Plasma Cutting

Output



Input



Literature

E11.300

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | Air Pressure Required | Air Flow Rate | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------------|----------------|---------------------------------------|--|--------------------------------------|--------------|-----------------------------|--|--|-----------------|
| Tomahawk® 1000 w/Hand Torch | K2808-1 | 208/230/380-415/ 460/575/1/3/50/60 | 3-Ph / 50% Duty Cycle: 24.6/21.1/11.4/9.3/7.6 | 37.8 (Max.) Pilot Current: 20A | 20-60A | 87-109 PSI (6.0-7.5 Bar) | 80 psi @ 275 SCFH 5.5 Bar @ 130L/min. | 15.2 x 8.5 x 22.1 (385 x 215 x 561) | 62 (28.1) |
| Mechanized | K2808-2 | 208-575/1/3/50/60 | 3-Ph / 100% Duty Cycle: 17.4/14.9/7.3/6.6/5.4 | | | | | | |
| | | | 1-Ph / 50% Duty Cycle: 26.7/24.3/NA/NA/NA | | | | | | |
| | | | 1-Ph / 100% Duty Cycle: 37.8/34.3/NA/NA/NA | | | | | | |

Growth Series™ 2x2™

Expandable Entry Level CNC Cutting

- A three-axis machine with four 390 oz. in. stepper motors
- Includes Torchmate® Visual Machine Designer™ software
- Cut speeds at up to 175 ipm (4.5 m/min)
- Use the image software and tooling you already have
- Educational and Ready-Pak® packages available
- Unlimited FREE technical support



Processes

- Plasma Cutting

Output

- 175 ipm

Input



Literature

torchmate.com

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power amps/volts ⁽²⁾ | Traverse Speed ⁽³⁾ ipm (m/min) | Cut Speed ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|----------------------------------|------------------------------------|---------------------------------------|---|-----------------------|----------------------------|------------------------------------|--------------------------|
| Growth Series™ 2X2™ Table | 2 x 2 (0.61 x 0.61) | 5/110 | up to 175 (4.5) | up to 175 (4.5) | Approx. 0.0006 (0.02) | 36.205 x 36.705 (919.6 x 932.3) | Approx. 100 (45.4) |

⁽¹⁾Machine can be re-indexed to cut materials larger than size indicated. ⁽²⁾220 volt models available for international customers. ⁽³⁾Software upgrade available.

Growth Series™ 2x4™

A Step Up In CNC Cutting Area

- All the features of the 2x2, but with additional cutting table space
- Designed for CNC plasma cutting, routing, drilling, milling and engraving
- Generic mounting plate enables the mounting of tool holders for plasma cutting, routing, glue applications, vinyl cutting and more
- Unlimited FREE technical support



Processes

- Plasma Cutting

Output

- 175 ipm

Input



Literature

torchmate.com

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power ⁽²⁾ amps/volts | Traverse Speed ⁽³⁾ ipm (m/min) | Cut Speed ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|--------------------------------------|---------------------------------------|--|--|--------------------------|-------------------------------|-------------------------------------|------------------------|
| Growth Series™ 2X4™ Table | 2 x 4 (0.61 x 1.2) | 5/110 | up to 175 (4.5) | up to 175 (4.5) | Approx. 0.0006 (0.02) | 36.205 x 60.705 (919.6 x 1542) | Approx. 150 (68) |

⁽¹⁾Machine can be re-indexed to cut materials larger than size indicated. ⁽²⁾220 volt models available for international customers. ⁽³⁾Software upgrade available.

Growth Series™ 4x4™

Keep Pace with the Expansion of Your Cutting Needs

- Ideal for small metal shops, sheet metal fabricators, technical schools and the racing industry
- Design and cut small, intricate parts to large and thicker parts like chassis and suspension components
- Software enables repeatable processes; make multiple copies of the same part with a single click
- Unlimited FREE technical support



Processes

- Plasma Cutting

Output

- 175 ipm

Input



Literature

torchmate.com

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power ⁽²⁾ amps/volts | Traverse Speed ⁽³⁾ ipm (m/min) | Cut Speed ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|--------------------------------------|---------------------------------------|--|--|--------------------------|-------------------------------|-------------------------------------|--------------------------|
| Growth Series™ 4X4™ Table | 4 x 4 (1.2 x 1.2) | 5/110 | up to 175 (4.5) | up to 175 (4.5) | Approx. 0.0006 (0.02) | 60 x 60.25 (1524 x 1530.4) | Approx. 175 (79.4) |

⁽¹⁾Machine can be re-indexed to cut materials larger than size indicated. ⁽²⁾220 volt models available for international customers. ⁽³⁾Software upgrade available.

Torchmate® Classic™ Series

CNC Cutting Table Kits

- Include electronics, drive motors and gears, cables, driver software, slides, gear boxes, rack and all brackets and fasteners
- Torchmate® Classic enables the assembly of the cutting table and rail system without welding (Bolt Together Kit) or by welding and assembling locally purchased materials (Gantry Kit)



Processes

- Plasma Cutting

Output

- Up to 300 ipm w/Stepper Motors
- Up to 150 ipm w/Servo Motors

Input



Literature

torchmate.com

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power amps/volts | Traverse Speed ipm (m/min) | Cut Speed ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|------------------------------|---------------------------------------|---------------------------|-------------------------------|--------------------------|-------------------------------|---|--------------------|
| Classic Series™ 4X8 Table | 4 x 8 (1.2 x 2.4) | 120V AC @ 7.5A max | up to 1060 (27) | up to 500 (12.7) | 0.00005 (1.27) | 83.625 x 121 x 63 (2124.1 x 3073 x 1600.2) | 1200 (544.3) |
| 5X10 Table | 5 x 10 (1.5 x 3.0) | | | | | 95.625 x 145 x 63 (2428.9 x 3683 x 1600.2) | 1500 (680.4) |

⁽¹⁾2-Tool configuration, 3-Tool limits cutting area on gantry axis.



Torchmate® X Series

Heavy Duty Cutting Table Systems

- Available as a turn-key system or as a gantry kit requiring locally sourced rails and welding to lower total cost
- Cutting area from 5 x 10 ft (1.5 x 3 m) to 12 x 42 ft (3.7 x 12.8 m)
- Unlimited FREE technical support



Processes

- Plasma Cutting
- Oxyfuel Cutting
- Plasma Marking

Input



Literature

torchmate.com

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power ⁽²⁾ amps/volts | Traverse Speed ⁽²⁾ ipm (m/min) | Cut Speed ⁽²⁾⁽³⁾ ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|--------------------------------|---------------------------------------|--|--|--|-------------------------------|--------------------------------------|------------------------------|
| TM X Series™ TMX 5X10 Table | 5 x 10 (1.5 x 3.0) | 15A/110V | up to 500 (12.7) | up to 500 (12.7) | 0.000000 (0.00000) | 92.2 x 154.4 (2,341.9 x 3,921.8) | Approx. 4200 (190.5) |
| TMX-HD 6X10 Table | 6 x 10 (1.8 x 3.0) Single tool | 10A/220V 20A/110V | up to 550 (13.97) | up to 550 (13.97) | | 104.2 x 154.4 (2,646.7 x 3,921.8) | Approx. 4600 (2,086.5) |

⁽¹⁾With specific Tool Set (some restrictions apply). ⁽²⁾Multiple control platforms. ⁽³⁾Cut speeds dependant on process.

Torchmate® TMX PRO

Industrial Grade Cutting

- Includes Burny® Shape Cutting Controller with UltraSharp® bolt hole technology, motion control engine, 15 in. (381 mm) touchscreen, multi-tasking and remote diagnostics, a Spirit® II 400 plasma cutting power source, integrated water table and more
- Gantry features heavy wall, precision-planed structural steel and drive components, including a ball screw-driven tool carriage, for smooth, vibration free movement
- Table features dual motors, a hardened helical gear rack and self-cleaning hardened rails



Processes

- Plasma Cutting
- Oxyfuel Cutting
- Plasma Marking

Input



Literature

torchmate.com/products

| Product Name | Cutting Area ⁽¹⁾ ft (m) | Input Power amps/volts | Traverse Speed ⁽²⁾ ipm (m/min) | Cut Speed ^{(2)(b)} ipm (m/min) | Machine Resolution in (µm) | Machine Size (footprint) in (mm) | Net Wt. lb (kg) |
|-------------------------------|---------------------------------------|---------------------------|--|--|-------------------------------|--------------------------------------|------------------------------|
| TMX PRO TMX-PRO 6X10 Table | 6 x 10 [1.8 x 3.0] All tools | 10A/220V | up to 1000 [25.4] | up to 1000 [25.4] | 0.000000 [0.000000] | 131.2 x 178.5 [3,332.5 x 4,533.9] | Approx. 8200 [3,719.5] |

⁽¹⁾With specific Tool Set (some restrictions apply). ⁽²⁾Multiple control platforms. ^(b)Cut speeds dependant on process.

High-Definition Plasma Cutting Systems

Precise Cuts for Downstream-Ready Production

- Spirit® II series plasma cutting power sources provide exceptional pierce, cut and marking capabilities with high definition edge quality of 2 degrees or less of cut edge bevel



Processes

- Plasma Cutting
- Plasma Marking

Output



Input



Literature

- E15.16 (Spirit® II 150)
- E15.15 (Spirit® II 275)
- E15.14 (Spirit® II 400)

| Product Name | Product Number | Input Power: Volts/Amps | Rated Output ⁽¹⁾ : Current/Duty Cycle | Mild Steel Production Capacity, in (mm) | Max. Thickness, in (mm) (edge start w/dross) | Gas Supply: Plasma/ Shield/Marking | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------|----------------|----------------------------|---|--|---|---------------------------------------|---|--------------------|
| Spirit® II 150 | See Literature | 208 | 150A DC @ 100% | 1.25 [32.0] | 1.5 [38.0] | O ₂ / O ₂ / Ar | 38.4 x 29.0 x 43.2 (975 x 737 x 1097) | 953 (432) |
| w/ built in INOVA® | | 220 240 380 400 | | | | O ₂ / Air / Ar | | |
| Spirit® II 275 | See Literature | 415 | 275A DC @ 100% | 1.5 [38.0] | 2.5 [65.0] | Air / Air / Ar | 38.4 x 29.0 x 43.2 (975 x 737 x 1097) | 1270 (576) |
| w/ built in INOVA® | | 440 480 600 | | | | Air / N ₂ / Ar | | |
| Spirit® II 400 | | 400A DC @ 100% | | | | 2.0 [50.0] | | |
| w/ built in INOVA® | | | | | | | 39.9 x 34.2 x 49.5 (1013 x 869 x 1257) | 1922 (872) |

⁽¹⁾@ 104°F [40°C] ⁽²⁾H17=50% N₂, 32.5% Ar, 17.5% H₂

Burny® Shape Cutting Controllers

Advanced Motion Control

- Phantom® II and Phantom® ST II shape cutting controllers feature an intuitive touchscreen display and the ability to control 2 plasma stations, 6 oxyfuel stations, 1 marker and multiple auxiliary functions



Processes

- Plasma Cutting
- Plasma Marking

Output



Input



Literature

- E15.45 (Phantom® II)
- E15.46 (Phantom® ST II)



Software and Accessories for CNC Cutting Systems

Programs and Peripheral Equipment to Augment and Enhance Your Cutting Processes

- Torch height control, oxyfuel accessories, plate marking systems, appropriate computers and torch holders
- Training is available at our site or yours to be sure your team understands how to operate and maintain your system
- New AccuMove™ 2 driver software makes fast work of part set up, and our compatibility with a number of CAD-CAM programs allow accurate file imports



Literature

torchmate.com

MASTERPIPE™ Mini Profiler

Economical CNC Pipe Cutting Solution

- Two-axis pipe cutting and profiling with outside diameter of 2-8 in. (51-203 mm) and length up to 25 ft (7.6 m) and 1000 lbs (454 kg) weight.
- One button moves the torch carriage so material can be safely loaded, positioned for cutting and unloaded
- Modular design allows you to start with a five foot bed and add five foot extensions up to 25 feet (7.6 m)
- Optional Arc Voltage Height Control provides consistent plasma cut quality and arc length for cleaner cuts on tube and pipe that may be out of round



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

vernontool.com

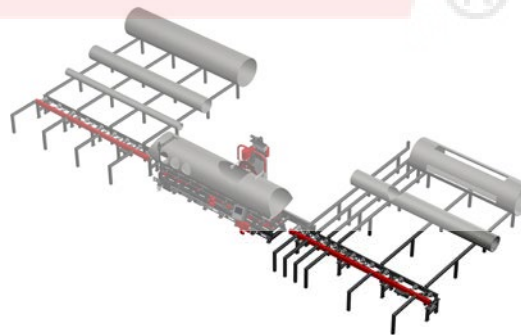
| Product Name | Input Power Voltage/Phase/Hertz | Pipe Capacity: Diameter, in (mm) | Pipe Capacity: Weight, lb (kg) | Cutting Speed ⁽¹⁾ ipm (m/min) | H x W x D ft (m) | Net Wt. lb (kg) |
|---|---------------------------------|----------------------------------|--------------------------------|---|--|----------------------------|
| MASTERPIPE™ Mini Profiler Base 5 ft. Section | 120/1/60 | OD: 1.0-8.0 (25.4-203.2) | 1000 (453.59) max. | 200 (5.1) max. (depending on cutting tool) | 52 x 28 x 92 (15.85 x 8.53 x 28.04) | 1000 (453.6) |
| Base 5 ft. Expansion | | (recommended production) | 700 lb/ft (317.5 kg/m) | | 37 x 23 x 63 (11.28 x 7.01 x 19.20) | Dependent on Configuration |

⁽¹⁾Dependent on system configuration and material being cut.

MPM Pipe Cutting Machine

Simple, Accurate Cuts Every Time

- Ideal for process and power piping, mechanical and HVAC contracting, shipbuilding, offshore, structural pipe trusses and pressure vessel fabrication
- Servo-driven systems engage for loading/unloading, support and rotate pipe during cutting, position the torch for precise profiling and compensate for out-of-round pipe
- Reusable part-cutting programs are created at the machine, remote PC or from popular 3D pipe modeling programs
- Unlike chucking machines, the MPM fully supports the pipe and remnant offering safe, simple operation and more efficient material handling.



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

vernontool.com

| Product Name | Input Power Voltage/Phase/Hertz | Pipe Capacity: Diameter, in (mm) | Pipe Capacity: Weight, lb (kg) | Cutting Speed ⁽¹⁾ ipm (m/min) | H x W x D ft (m) | Net Wt. lb (kg) |
|----------------------|---------------------------------|----------------------------------|--------------------------------|--|------------------------------------|-----------------|
| MASTERPIPE™ Profiler | 120/1/60 | OD: 1.0-12 in. | 600 (272.2) max. | 200 (5.1) max. | 6 x 12 x 4 (1.83 x 3.66 x 1.22) | 2500 (1134) |
| | | Length up to: 40 ft (12.2 m) | 50 lb/ft max (22.7 kg/m) | | | |

⁽¹⁾Dependent on system configuration and material being cut.

MASTERTUBE™ Plasma Profiler MTC

High Performance Square, Rectangular and Round Pipe and Tube Cutting

- Ideal for space frames, handrails, safety guards, recreational structures and automotive aftermarket components
- Plasma cutting system offers immediate ignition and excellent cut quality on carbon, stainless and non-ferrous materials
- Programming and operation are simple with the WinMPM™ software, using menus and simple graphical icons to make saddle miter, multiple intersection and centerline offset cuts as well as circular and rectangular holes



Processes

- Plasma Cutting
- Oxyfuel Cutting

Input



Literature

vernontool.com

BIG

VERNON Abrasive Saw

Speed, Simplicity, Quality

- Abrasive wheels cut and bevel all types of materials from 2-24 in. (50.8-609.6 mm)
- Ideal for pipe and supply warehouses, mechanical contractors, HVAC fabricators and other industries
- Integrated pipe conveyors permit one person to load and unload pipe from either direction, improving safety and lowering cycle times
- Yields a "machined"-like uncontaminated surface ready for immediate fit-up and welding



Processes

- Abrasive Cutting

Input



Literature

vernontool.com

PythonX® II

Robotic CNC Plasma Cutting System for Structural Steel Fabrication

- Replaces drill line, bandsaw, angle line, plate/bar line, coping machine, marking machine, burning machine
- Makes all cuts and features in one pass
- Cut floorspace, time and investment by 80% compared to the 7 conventional processes it replaces



Processes

- Plasma Cutting

Output



Input



Literature

pythonx.com



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Tomahawk® 375 Air

Base Model (K2806-1)

- Internal air compressor (external air connection also standard)
- LC25 Torch with 10 ft. (3.0 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Shoulder strap
- Input power cord

Tomahawk® 625

Base Model (K2807-1, K2807-2)

- LC40 Hand Torch, 20 ft. (6.0 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Shoulder strap
- Input power cord

Tomahawk® 1000

Hand Torch Base Model (K2808-1)

- LC65 Hand Torch with 25 ft. (7.5 m) cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Input power cord

Mechanized Base Model (K2808-2)

- LC65M Machine Torch with 25 ft. (7.5 m) lead
- CNC Interface Cable
- Air regulator and pressure gauge
- Internal water separator
- Work clamp and cable
- Spare consumables
- Input power cord

Torchmate® Growth Series 2X2™

Base Model

- Three axis machine (2 x-axis drives and motors, 1 y-axis drive and motor and 1 z-axis drive and motor)
- 390 oz. motors
- Torchmate Visual Machine Designer™ software
- Relay to turn on and off your plasma torch or other closed circuit tool
- Integrated height control

Torchmate® Growth Series 2X4™

Base Model

- Three axis machine (2 x-axis drives and motors, 1 y-axis drive and motor and 1 z-axis drive and motor)
- 390 oz. motors
- Torchmate Visual Machine Designer™ Software
- Relay to turn on and off your plasma torch or other closed circuit tool

Torchmate® Growth Series 4X4™

Base Model

- Three-axis motorized system (2 x-axis drives and motors, 1 y-axis drive and motor and 1 z-axis drive and motor)
- 390 oz. motors
- Torchmate Visual Machine Designer™ Software
- Growth Series™ 4X4™ water table option available (perfect for dust and airborne particulate control)

Accessories » Tomahawk® Plasma Cutting Systems

| Product Name | Product No. | Tomahawk® 375 Air | | Tomahawk® 625 | | Tomahawk® 1000 | |
|--|-------------|-------------------|-----------------------|--------------------------|-----------------------|-----------------------|--|
| | | Base Model | Base Model Hand Torch | Base Model Machine Torch | Base Model Hand Torch | Base Model Mechanized | |
| EXPENDABLE PARTS – STANDARD CUTTING | | | | | | | |
| Electrode (LC25) | KP2842-1 | • | | | | | |
| Nozzle, 25A (LC25) | KP2842-2 | • | | | | | |
| Retaining Cap (LC25) | KP2842-3 | • | | | | | |
| Swirl Ring (LC25, LC40) | KP2842-4 | • | | | | | |
| Spacer (LC25) | KP2842-5 | • | | | | | |
| Electrode (LC40) | KP2843-1 | | • | • | | | |
| Nozzle, 40A (LC40) | KP2843-2 | | • | • | | | |
| Swirl Ring (LC25, LC40) | KP2842-4 | | • | • | | | |
| Retaining Cap (LC40) | KP2843-5 | | • | • | | | |
| Spacer (LC40, LC65) | KP2843-10 | | • | • | • | • | |
| Electrode (LC65) | KP2844-1 | | | | • | • | |
| Nozzle, 40A (LC65) | KP2844-2 | | | | • | • | |
| Nozzle, 50A (LC65) | KP2844-3 | | | | • | • | |
| Nozzle, 60A (LC65) | KP2844-4 | | | | • | • | |
| Retaining Cap, 40, 60A (LC65) | KP2844-9 | | | | • | • | |
| Shield, 40, 60A (LC65M) | KP2844-13 | | | | • | • | |
| Swirl Ring, 40A, 50A, 60A (LC65) | KP2844-14 | | | | • | • | |
| EXPENDABLE PARTS – CONTACT CUTTING | | | | | | | |
| Nozzle (Direct Contact), 25A (LC40) | KP2843-9 | | • | • | | | |
| Nozzle (Direct Contact), 40A (LC40) | KP2843-3 | | • | • | | | |
| Swirl Ring, 40A, 50A, 60A (LC65) | KP2844-14 | | | | • | • | |
| Nozzle (Direct Contact), 40A (LC65) | KP2844-5 | | | | • | • | |
| Retaining Cap, 40, 60A (LC65) | KP2844-9 | | | | • | • | |
| Nozzle (Shielded Contact), 50A (LC65) | KP2844-6 | | | | • | • | |
| Nozzle (Shielded Contact), 60A (LC65) | KP2844-7 | | | | • | • | |
| Retaining Cap (Shielded Contact) (LC65) | KP2844-10 | | | | • | • | |
| Shield, 50A, 60A (LC65) | KP2844-11 | | | | • | • | |

| Product Name | Product No. | Tomahawk® 375 Air | | Tomahawk® 625 | | Tomahawk® 1000 | |
|--|-------------|-------------------|-----------------------|--------------------------|-----------------------|-----------------------|--|
| | | Base Model | Base Model Hand Torch | Base Model Machine Torch | Base Model Hand Torch | Base Model Mechanized | |
| EXPENDABLE PARTS – GOUGING | | | | | | | |
| Nozzle (Gouging) (LC40) | KP2843-4 | | • | • | | | |
| Retaining Cap (Gouging) (LC40) | KP2843-6 | | • | • | | | |
| Gouge Shield (LC40) | KP2843-8 | | • | • | | | |
| Swirl Ring, 40A, 50A, 60A (LC65) | KP2844-14 | | | | • | • | |
| Nozzle (Gouging) (LC65) | KP2844-8 | | | | • | • | |
| Retaining Cap (Shielded Contact) (LC65) | KP2844-10 | | | | • | • | |
| Gouge Shield (LC65) | KP2844-12 | | | | • | • | |
| GENERAL | | | | | | | |
| Plasma Circle Cutting Guide Kit | K2886-1 | • | • | • | • | • | |
| Canvas Cover | K2377-1 | • | • | • | • | • | |
| Accessory Bag | K3071-1 | • | • | • | • | • | |
| LC25 Handheld Plasma Torch, 10 ft. (3.0 m) | K2846-1 | • | | | | | |
| LC40 Handheld Plasma Torch, 20 ft. (6.1 m) | K2847-1 | | • | • | | | |
| LC40 Machine Plasma Torch, 20 ft. (6.1 m) | K2847-2 | | • | • | | | |
| Torchmate® 2X2™ CNC Prototyping System/ Tomahawk® 625 One-Pak® | K3128-1 | | • | • | | | |
| LC65 Handheld Plasma Torch, 25 ft. (7.5 m) | K2848-1 | | | | • | • | |
| LC65 Handheld Plasma Torch, 50 ft. (15 m) | K2848-2 | | | | • | • | |
| LC65M Machine Plasma Torch, 25 ft. (7.5 m) | K2848-3 | | | | • | • | |

• Optional

Accessories » Spirit® II Plasma Cutting Power Sources

| Product Name | Product No. | | | |
|---|-------------|-----------------------|-----------------------|-----------------------|
| | | See Lit. for K-number | See Lit. for K-number | See Lit. for K-number |
| | | Base Model | Base Model | Base Model |
| | | Spirit® II150 | Spirit® II275 | Spirit® II400 |
| EXPENDABLE PARTS – SHIELD CAP | | | | |
| Shield Cap, 30A (Mild Steel, Aluminum) | BK277145 | • | • | • |
| Shield Cap, 50A (Mild Steel) | BK277115 | • | • | • |
| Shield Cap, 50A (Aluminum), 70A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum) | BK277150 | • | • | • |
| Shield Cap, 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277286 | • | • | • |
| Shield Cap, 150A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277117 | • | • | • |
| Shield Cap, 30A (Stainless Steel-Air) | BK277144 | • | • | • |
| Shield Cap, 50A (Stainless Steel-Air) | BK277149 | • | • | • |
| Shield Cap, 100A (Stainless Steel-H17) | BK277146 | • | • | • |
| Shield Cap, 150A (Stainless Steel-H17) | BK277298 | • | • | • |
| EXPENDABLE PARTS – INNER RETAINING CAP | | | | |
| Inner Retaining Cap, 30A-70A (Mild Steel, Aluminum), 70A (Stainless Steel-Air) | BK277153 | • | • | • |
| Inner Retaining Cap, 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277151 | • | • | • |
| Inner Retaining Cap, 150A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277152 | • | • | • |
| Inner Retaining Cap, 150A (Stainless Steel-H17), 200A/275A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum) | BK277266 | • | • | • |
| Inner Retaining Cap, 30A/50A (Stainless Steel-Air) | BK277110 | • | • | • |
| EXPENDABLE PARTS – NOZZLE | | | | |
| Nozzle, 30A (Mild Steel, Aluminum) | BK277120 | • | • | • |
| Nozzle, 50A (Mild Steel, Aluminum) | BK277122 | • | • | • |
| Nozzle, 70A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277125 | • | • | • |
| Nozzle, 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277284 | • | • | • |
| Nozzle, 150A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277293 | • | • | • |
| Nozzle (for Silver), 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK279484 | • | • | • |
| Nozzle (for Silver), 150A (Mild Steel, Stainless Steel-Air, Aluminum) | BK279493 | • | • | • |
| Nozzle, 30A (Stainless Steel-Air) Stainless Steel (Air) | BK277121 | • | • | • |
| Nozzle, 50A (Stainless Steel-Air) Stainless Steel (Air) | BK277123 | • | • | • |
| Nozzle, 70A (Stainless Steel-H17) Stainless Steel (H17) | BK277124 | • | • | • |
| Nozzle, 100A (Stainless Steel-H17) Stainless Steel (H17) | BK277126 | • | • | • |
| Nozzle, 150A (Stainless Steel-H17) Stainless Steel (H17) | BK277297 | • | • | • |
| EXPENDABLE PARTS – SWIRL RING | | | | |
| Swirl Ring, 30A (Aluminum), 30A/50A (Mild Steel), 70A (Stainless Steel-H17) | BK277140 | • | • | • |
| Swirl Ring, 50A/70A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277142 | • | • | • |
| Swirl Ring, 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK277283 | • | • | • |
| Swirl Ring (for Silver), 100A (Mild Steel, Stainless Steel-Air, Aluminum) | BK279483 | • | • | • |
| Swirl Ring (for Silver), 150A (Mild Steel, Stainless Steel-Air, Aluminum) | BK279439 | • | • | • |
| Swirl Ring, 150A (Mild Steel, Stainless Steel-Air, Stainless Steel-H17, Aluminum), 260A (Stainless Steel-H17) | BK277139 | • | • | • |
| Swirl Ring, 30A (Stainless Steel-Air) Stainless Steel (Air) | BK277138 | • | • | • |
| Swirl Ring, 100A (Stainless Steel-H17) Stainless Steel (H17) | BK277141 | • | • | • |

WIRE DELIVERY

DISPENSING EQUIPMENT » Infinity Pak® • Hoods • Drum Cover • Wire Level Gauge • Reel Dispensing Equipment • Motorized Dispensing Equipment • Wire Feed Assist

CONDUIT » Weld Wire Conduit • Conduit Connectors • Conduit Hangers, Clamps, Sleeves • Wire Straighteners

ROBOTIC TORCH MAINTENANCE » Power Ream®

DRUM, REEL & BOX HANDLING EQUIPMENT

Hoods and Accessories for Drums and Boxes

Coverage for Consumables

- Tough polyethylene construction for long shop life
- Dual windows for easy operator access
- Available for round, square and octagon-shaped packages



Processes

- MIG
- Flux-Cored

Drum and Box Covers

Bulk Wire Wrap

- Tough, fire-resistant PVC construction
- Provides effective protection of fiber or cardboard drums located near the weld cell
- Available for round, square and octagon-shaped bulk wire packages



Processes

- MIG
- Flux-Cored

Wire Level Gauge

Keep an Eye on Wire Supply

- Detects level of wire remaining in the drum or box
- Wire level displayed visually with color and percentage scale
- Useable with 500 lb. (227 kg) or 1000 lb. (453 kg) package



Processes

- MIG
- Flux-Cored

Infinity Pak® Dispensing System

Continuous Wire, Continuous Welding

- Butt welding and flash removal process take only seconds
- Configurations for every environment, including 2-station, 4-station and wall mount
- ASTM certified and the bulk package is 100% recyclable
- Use with a variety of Lincoln Electric SuperArc® wire alloys



Processes

- MIG

Output



Input



Literature

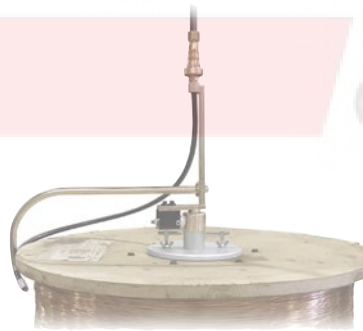
E9.71

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Air Pressure and Flow | Input Current @ Rated Output | Input Current | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------------------------|----------------|---------------------------------|-----------------------------|------------------------------|---------------|------------------------------------|-----------------|
| Infinity Pak® Butt Welder | K3924-1 | 110V 5 Amps | — | — | — | 42 x 20 x 24 (1067 x 208 x 610) | 100 (43.4) |
| Butt Welder and Docking Station | K3921-1 | | | | | — | — |
| With 2 Stations | K3926-1 | | | | | | |
| With 4 Stations | K3927-1 | | | | | | |
| Wall Mount | K4106-1 | | | | | | |

Dispensing Equipment for Bulk Reels

The Reel Deal

- Universal base plate design fits wood or plastic reels with 1-5/16 in. (33 mm) or 5 in. (127 mm) center arbors
- Twin locking cams secure base plate to reel for stability
- Smooth acceleration and deceleration of feed arm



Processes

- MIG
- Flux-Cored

Motorized Dispensing System for Stems and Wood Reels

Power Your Wire Dispensing System

- Motorized wire dispensing system designed for larger wire sizes
- Helps to eliminate common bulk wire challenges such as wire flip, flux-cored wire splitting, excessive tip wear, pulsating and burn back
- Compatible with bulk systems weighing up to 2,200 lbs. (1000 kg)



Processes

- Submerged Arc
- Flux-cored

Input



Wire Feed Assist

Extra Drive for Your Wire Feed

- Reduces pulling force required from feed motor
- Enables longer conduit runs
- Adjustable torque setting prevents bird nesting
- For .035-1/8 in. (0.9-3.2 mm) wire diameters



Processes

- MIG
- Flux-Cored

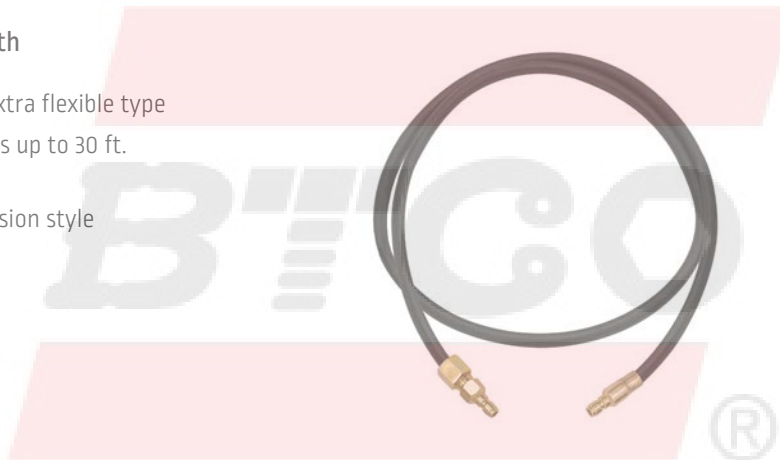
Input

Compressed Shop Air

Weld Wire Conduit

Wire Delivery at any Length

- Choose from polymer or extra flexible type
- Available in pre-cut lengths up to 30 ft. (9.1 m) or in bulk
- Self-threading or compression style connectors available



Processes

- MIG
- Flux-cored
- Submerged Arc

Conduit Connectors

Make the Welding Connection

- Variety of types and sizes available
- Rounded internal shoulders for smooth wire feeding
- Union kits and bulkhead connector



Processes

- MIG
- Flux-cored
- Submerged Arc

Conduit Hangers, Clamps, Sleeves

Wire Support

- Hanger prevents excessive sag in conduit to existing structures
- Sleeves protect conduit from operating environment
- Use clamps to secure conduit to existing structures



Processes

- MIG
- Flux-cored
- Submerged Arc

Wire Straighteners

Get It Straight

- Straighten or recast all types of wires
- Lightweight, yet rugged
- Equipped with locating calibration on face of unit and fine adjustment scale on tension knob



Processes

- MIG
- Flux-cored
- Submerged Arc

Power Ream® Torch Maintenance System

Eliminate Torch Spatter

- Removes and reduces spatter accumulation on robotic torches for improved welding performance
- Simple push-button "No Error" programming technique
- Only reamer to offer an automatic retry feature



Processes

- MIG

Input



Product Number

K2391-1 (Base Model)

Literature

E10.110

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Air Pressure and Flow | Input Current @ Rated Output | Input Current | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|-----------------------------|------------------------------|---------------|---|-----------------|
| Power REAM® | K2391-1 | 24V DC | 80 PSI 15 SCFM | 1100 rpm 0.65 HP | 0.50A DC | with reservoir 24.9 x 8.9 x 13.2 (633 x 228 x 337) without reservoir 19.5 x 8.9 x 13.2 (495 x 228 x 337) | 62 (28) |

Drum, Reel and Box Handling Equipment

Containers on the Move

- Dollies available for drum or boxes with up to 1000 lb (453 kg) capacity
- Staging carts available for drums or reels with up to 1000 lb (453 kg) capacity
- Variety of lifters for chimeless and chimed drums



Processes

- MIG
- Flux-cored

Wire Delivery Accessories

Additional Tools

- Draw gauge accurately measures the draw weight of welding wire pulling through conduit in English or metric at the touch of a button
- Nozzle cleaning tool removes spatter; choice of five sizes
- Conduit cutter trims all diameters of polymer conduit with ease



Processes

- MIG
- Flux-cored
- Submerged Arc

Accessories

| Product Name | Product No. | Infinity Pak® with 2 Stations | Infinity Pak® with 4 Stations | Infinity Pak® Wall Mount |
|--|-------------|-------------------------------|-------------------------------|--------------------------|
| GENERAL | | | | |
| Wire Sizer with 0.035 in (0.9 mm) dies | K3910-1 | • | • | • |
| Wire Sizer replacement dies for 0.035 in (0.9 mm) wire | K3911-1 | • | • | • |
| Wire Sizer with 0.045 in (1.2 mm) dies | K3913-1 | • | • | • |
| Wire Sizer replacement dies for 0.045 in (1.2 mm) wire | K3912-1 | • | • | • |
| Wire Sizer with 0.052 in (1.3 mm) dies | K3914-1 | • | • | • |
| Wire Sizer replacement dies for 0.052 in (1.3 mm) wire | K3915-1 | • | • | • |
| Wire Sizer with 0.062 in (1.6 mm) dies | K3917-1 | • | • | • |
| Wire Sizer replacement dies for 0.062 in (1.6 mm) wire | K3918-1 | • | • | • |
| Wire Sizer with 0.078 in (2.0 mm) dies | K3919-1 | • | • | • |
| Wire Sizer replacement dies for 0.078 in (2.0 mm) wire | K3920-1 | • | • | • |
| Butt welder and docking station combination | K3921-1 | • | • | • |
| Butt welder (110V) portable | K3924-1 | • | • | • |
| Hood Cover | K3997-1 | • | • | • |

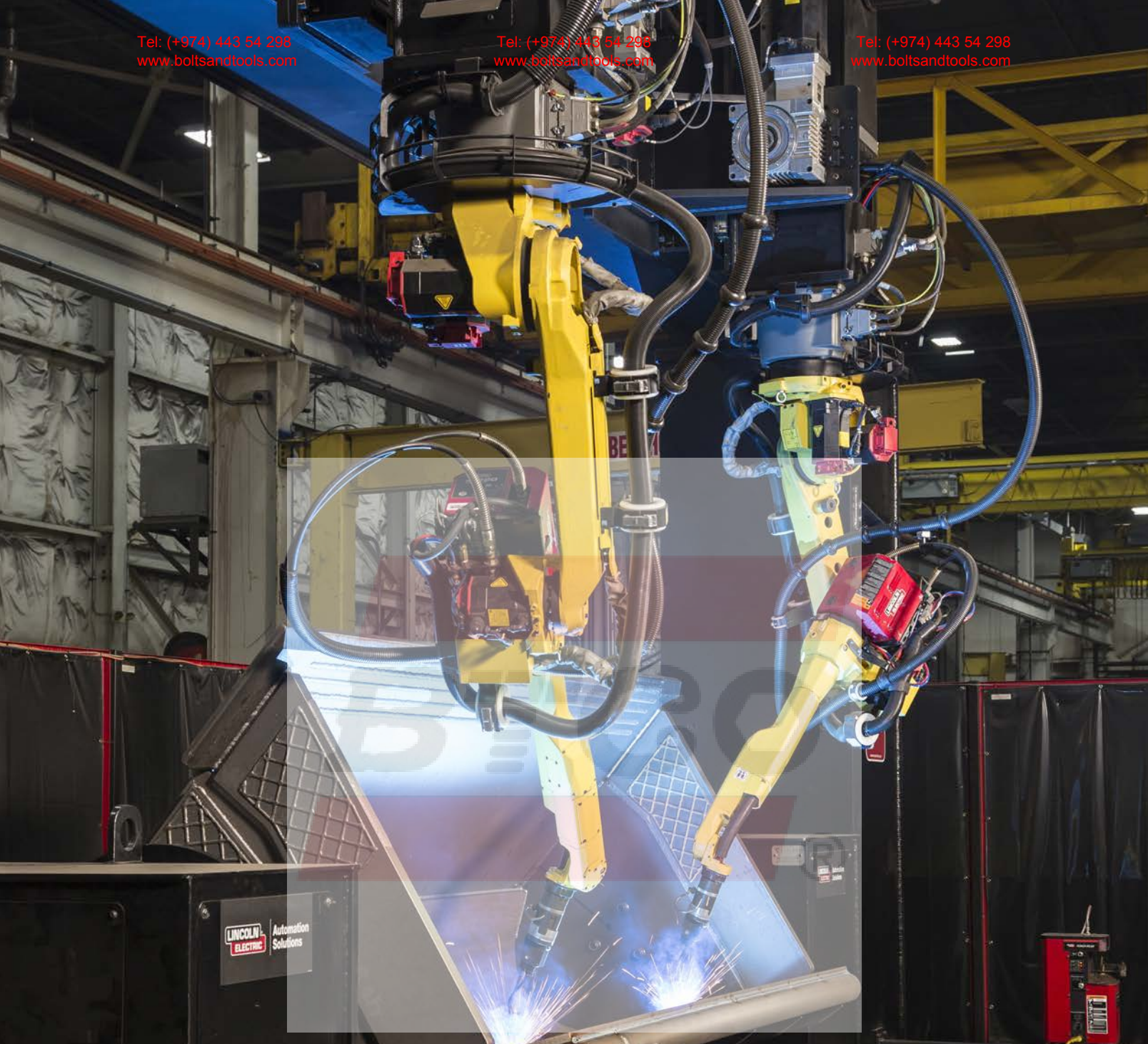


• Optional

Tel: (+974) 443 54 298
www.boltsandtools.com

Tel: (+974) 443 54 298
www.boltsandtools.com

Tel: (+974) 443 54 298
www.boltsandtools.com



AUTOMATION SOLUTIONS

ROBOTIC WELDING AUTOMATION » Pre-Engineered Systems · Custom Systems

ROBOTIC EQUIPMENT » Power Wave® Power Sources and AutoDrive® Feeders

ORBITAL WELDING SYSTEM » Orbital MIG · Orbital TIG

HORIZONTAL/VERTICAL AXIS SYSTEMS » Seam Tracker™ Systems · Motorized Slide Systems · Manual Slide Systems · Oscillators · Torch Height Controllers · Mechanized Automation

ADVANCED AUTOMATION SOLUTIONS » Laser Processing · Robotic Integration · System Integration · Fixturing and Tooling · Positioning Equipment · Tube Bending and Fabricating Systems · Press Automation · Pre- & Post-Hydroforming and Structural Frame Automation

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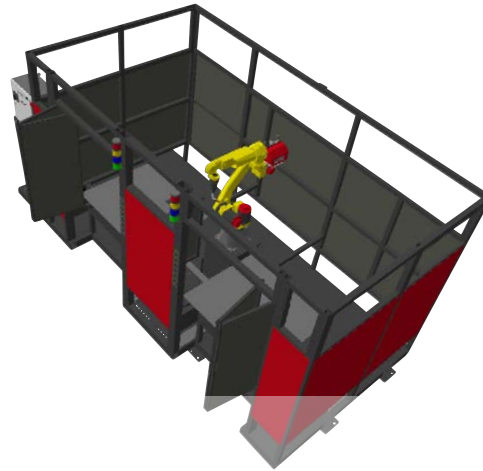
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Fixed Table Systems

Workpiece is Fixed on Table and Does Not Require Part Rotation or Repositioning

- Single-zone systems enable the robot to work unassisted in a single environment
- Dual-zone systems enable the robot to weld on one side while the operator handles parts on the other
- Dual fixed table systems include one table for the robot and one for the operator
- Include all required operator safety equipment. Variety of options, including vision, seam tracking, fume systems and other accessories



Processes

- MIG
- Flux-Cored

Output



Input



Literature

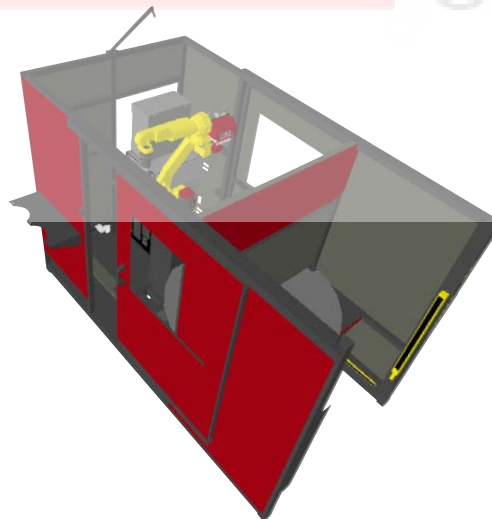
MC10-146



Turntable Systems

Workpiece is Replaced for Applications that Require Part Rotation or Repositioning

- Manual turntable systems provide best turntable positioning value for simple small or medium-sized parts
- Powered horizontal turntable systems increase throughput
- Dual zone/horizontal turntable systems allow the operator to load during welding
- Include all required operator safety equipment. Variety of options, including vision, seam tracking, fume systems and other accessories



Processes

- MIG
- Flux-Cored

Output



Input



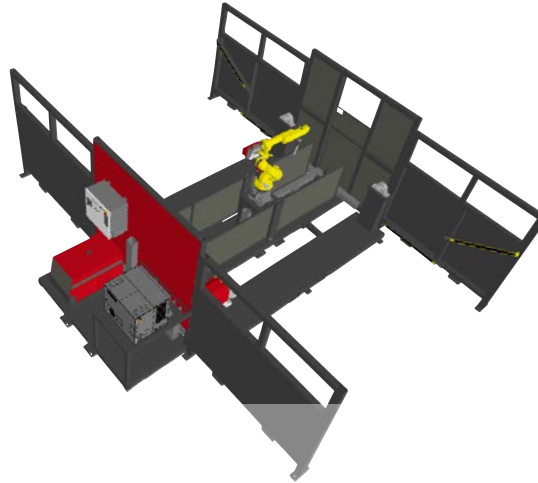
Literature

MC10-146

Positioning Systems

Re-Orient the Part Using a Variety of Positioning Options

- Dual headstock/ fixed table systems for small, medium or large-sized parts
- Select a dual headstock/triple axis system for large part manipulation
- Dual zone configurations deliver maximum throughput and productivity
- Include all required operator safety equipment. Variety of options, including vision, seam tracking, fume systems and other accessories



Processes

- MIG
- Flux-Cored

Output



Input



Literature

MC10-146

Custom Engineered Automation Systems

Engineered for Your Application

- Complete robotic system integration for pressure vessel, transportation, heavy equipment and energy and other applications
- In-plant startup and assistance
- Operator training and 24-hour hotline assistance
- Sample part welding and robotic applications evaluation



Processes

- MIG
- Flux-Cored
- TIG
- Pulsed TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

MC10-146

Robotic Welding Power Sources

Power Wave® Welding Power Sources Specifically Designed For Robotic Systems

- Built-in wire feeder control
- ArcLink® communication protocol communicates with robotic arm controller
- Standard suite of software solutions, including CheckPoint™ and Power Wave® Manager
- High-performance pulse wave forms, including RapidArc®, Precision Pulse™, Pulse-on-Pulse™ and others
- Flexibility to add or connect modules, fume control, water coolers, computers or other accessories



Processes

- Stick
- TIG
- Pulsed TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E10.13
(Power Wave® R350)

E10.14
(Power Wave® R500)

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|---|--|---|-----------------------|---|-----------------|
| Power Wave® R350 | K3022-2 | 208/230/380-415/460/ 575/1/3/50/60 | GMAW: 350/31.5V/40% ⁽²⁾ 300A/29V/100% SMAW: 325A/24V/40% ⁽²⁾ 250A/30V/100% GTAW-DC: 350A/24V/40% 300A/22V/100% | 3-Ph/40% Duty Cycle: 37/21/18/15 3 Ph/100% Duty Cycle: 31/28/15/14/11 1 Ph/40% Duty Cycle: 60 ⁽¹⁾ /67 ⁽²⁾ /NA/NA/NA 1 Ph/100% Duty Cycle: 60/53/NA/NA/NA | 5-350A ⁽¹⁾ | 20.4 x 14.0 x 24.8 (518 x 356 x 630) | 85 (38.6) |
| Power Wave® i400 | K2669-1 | 200-208/230/308-415/460/ 575/3/50/60 [308-415/3/50/60 w/CE Filter Kit Installed] | 350A/31.5V/100% 400A/34V/60% 420A/35V/40% | 40/37/21/18/15A 50/45/26/23/18A 54/49/28/25/20A | 5-420A 10-37V | 22.7 x 24.4 x 21.5 (577 x 620 x 546) | 209 (95) |
| Power Wave® R500 | K3169-2 | 208/230/380-415/460/ 575/3/50/60 | GMAW: 550A/41.5V/40% 450A/36.5V/100% SMAW: 550A/42V/40% 450A/38V/100% GTAW-DC: 550A/32V/40% 450A/28V/100% | 3-Ph/40% Duty Cycle: 80/73/41/37/29A 3-Ph/100% Duty Cycle: 60/54/30/27/21A | 5-550A ⁽³⁾ | 22.5 x 14 x 24.8 (571 x 355 x 630) | 150 (68) |
| AutoDrive® 19 | K3004-2 | 40V DC/1.0A | NA | NA | NA | 8.8 x 10.4 x 3.1 (224 x 264 x 80) | 7 (3.2) |
| AutoDrive® 19 Tandem | K3171-1 | | | | | | |

⁽¹⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

⁽²⁾On 230 Volt/1-Phase inputs, the peak rating is at a duty cycle of 30%, except for GTAW processes.

⁽³⁾On 208 Volt inputs, the maximum output is limited to 300 amps.

Robotic Welding Wire Feeders

Optimized for Robotics, Extremely Compact and Lightweight

- AutoDrive® S, steel servo torch solution with touch-retract starting technology, provides precise arc starts for a consistent bead profile and minimal post-weld clean-up
- AutoDrive® SA, high-performance aluminum servo torch solution with touch-retract start technology, initiates each robotic aluminum weld with no spatter or burnback
- Select the 4R220 for feeding larger diameter wires, or pulling through long conduits
- MAXTRAC® wire drives feature precision cast components, tool-less drive roll changes, and brass-to-brass gun connections
- Available modules relay wire feed commands from an appropriate, non-robotic Power Wave® power source to any AutoDrive® robotic wire feeder



Processes

- MIG
- Pulsed MIG
- MIG-STT®
- Flux-Cored
- Metal-Cored

Output



Input



Literature

- E10.17 [AutoDrive® S]⁽¹⁾
- E10.16 [AutoDrive® SA]
- E10.12 [AutoDrive® 4R100 and 4R220]
- E10.15 [Power Feed® 10R]

⁽¹⁾The AutoDrive® S is compatible only with Magnum® PRO products.

| Product Name | Product Number | Wire Speed Range in/min (m/min) | Wire Size Range – Solid in (mm) | Wire Size Range – Cored in (mm) | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|---|--|---|--|-----------------|
| AutoDrive® S | K4303-1 | 30-800 (0.8-20.3) | 0.035-0.045 (0.9-1.2) | NA | 7.0 x 7.5 x 10.8 (177.8 x 190.5 x 274.3) | 14.5 (6.58) |
| AutoDrive® SA | K4129-1 | 30-800 (0.8-20.3) | 0.035-1/16 (0.9-1.6) (Aluminum only) | NA | 10.8 x 7.5 x 7.0 (274.3 x 190.5 x 177.8) | 14.5 (6.58) |
| AutoDrive® 4R100 | K3002-2 | 50-800 (1.3-20.3) | 0.023-0.045 (0.6-1.2) | 0.035-0.045 (0.9-1.2) | 8.4 x 7.5 x 8.1 (213 x 191 x 231) | 13.2 (6.0) |
| AutoDrive® 4R220 | K2685-3 | 30-1200 (0.8-30.5) | 0.023-1/16 (0.6-1.6) | 0.035-5/64 (0.9-2.0) | 10.43 x 10.07 x 9.92 (265 x 256 x 252) | 20.9 (9.5) |
| Power Feed® 10R | K1780-3 | 50-800 (1.3-20.3) 75-1200 (2.0-30.5) | 0.025-3/32 (0.6-2.4) 0.025-1/16 (0.6-1.6) | 0.035-0.120 (0.9-3.0) 0.035-5/64 (0.9-2.0) | 8.9 x 12.0 x 9.9 (226 x 306 x 251) | 22.4 (10.2) |

Orbital MIG Welding System

Quality Assurance for Orbital MIG Welds

- New track ring design allows the operator to install or remove the track in seconds
- Ergonomic hand-held pendant with icon-based interface and full-color screen simplifies the control and monitoring of weld activity in direct sunlight or dark environments
- Tool-less torch adjustments allow the operator to choose any position on three axes, with in/out, up/down and circumferential adjustment



Processes

- MIG

Output



Input



Literature

E9.621

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---|--|------------------------------|--|-----------------|
| APEX[®] 3000 Controller | K52102-1 | 40V DC +120V AC from Power Wave [®] | 24V 9A | 5.0A AC 9.0A DC | 7.35 x 13.85 x 24.4 (186.7 x 351.8 x 619.8) | 13.6 (6.2) |
| Pendant | K52113-1 | 40V DC | N/A | 250MA | 11.33 x 7.80 x 2.71 (287.8 x 198.1 x 68.8) | 2.65 (1.2) |
| Cabinet | K52114-1 | N/A | N/A | N/A | 58 x 31 x 29.5 (1473.2 x 787.4 x 749.3) | 212 (96.2) |

| Product Name | Product Number | Input Power Voltage | Travel Speed ipm (m/min) | Wire Feed Speed ipm (m/min) | Net Wt. lb (kg) |
|--|----------------|---------------------|--|-----------------------------|-----------------|
| HELIX[®] M85 Weld Head | K52101-1 | 24V DC | 0.1 min. – 120 max. (0.003 min. – 3.048 max.) | 50-1200 (127-3048) | 25 (11.3) |

Orbital TIG Welding System

For Critical Welds in Demanding Environments

- Complete system includes controllers, heads, rings and welding power source
- Extreme precision for root pass welding; no slag, no inclusions
- Handheld pendant enables user-friendly interface
- Quickly release and reposition the head on the ring
- Gear-driven track resists wear, eliminates slippage and ensures quality and consistency



Processes

- TIG

Input



Literature

- E9.600 (APEX® 2100 Orbital Controller)
- E9.610 (HELIX® T55 Weld Head and Track Ring)

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------------------|----------------|---------------------------------|--|------------------------------|---|-----------------|
| APEX® 2100 Controller | K52073-1 | 115/1/50/60 | N/A | 50/60 Hz: 5.0A @ 115V | 34.5 x 9.5 x 26.25 (876.3 x 241.3 x 668) | 78 (35.4) |
| Pendant | K52074-1 | N/A | N/A | 1.0A | 11.5 x 8 x 3.75 (292.1 x 203.2 x 96.5) | 6.0 (2.7) |
| Cabinet | K52075-1 | N/A | N/A | N/A | 49 x 27.4 x 29 (1244 x 699 x 736.6) | 175 (79.4) |

| Product Name | Product Number | Input Power Voltage | Travel Speed ipm (m/min) | Wire Feed Speed ipm (m/min) | Net Wt. lb (kg) |
|-----------------------------|----------------|---------------------|--|-----------------------------|-----------------|
| HELIX® T55 Weld Head | K52002-1 | 25V DC | 1 min. – 20 max. (0.0254 min. – 0.508 max.) | 0.1-130 (0.00254-3.302) | 57 (25.9) |

Seam Tracker™ Systems

Automated Tactile Joint Tracking

- Deliver precise automated weld joint tracking for submerged arc, MIG and flux-cored arc welding
- Ideal for repetitive welding applications
- Depending on application, can be recommended over manual and semiautomatic welding to improve quality and consistency while reducing operational costs



Processes

- Submerged Arc
- MIG
- Flux-Cored

Input



Literature

E10.412

| Product Name | Product Number | Load Capacity lb (kg) | Input Power Voltage/Phase/Hertz | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|--|---------------------------------|--|--|
| Seam Tracker™ Standard Control Package for CS250 and CS450 (Control, Pendant and Cables) | K52016-1 | 250 lb (113 kg) @ 12 in (305 mm) from faceplate 450 lb (204 kg) @ 24 in (610 mm) from faceplate | 120/230/1/50/60 | 5x5 in (127x127 mm) 10x10 in (254x254 mm) | CS250: 5x5 = 105 lb (48 kg) 10x10 = 118 lb (54 kg) CS450: 5x5 = 162 lb (74 kg) 10x10 = 178 lb (81 kg) |
| Seam Tracker™ Standard Control Package for CS40 (Control, Pendant and Cables) | K52057-1 | 40 lb (18 kg) @ 6 in (152 mm) from faceplate | | 3x3 in (76x76 mm) 6x6 in (152x152 mm) | 3x3 = 79 lb (36 kg) 6x6 = 90 lb (41 kg) |
| Seam Tracker™ Standard Control Unit | K52020-1 | N/A | | N/A | 33 (15) |
| Seam Tracker™ Advanced Programming Control Package for CS250 and CS450 (Control, Pendant and Cables) | K52017-1 | 250 lb (113 kg) @ 12 in (305 mm) from faceplate 450 lb (204 kg) @ 24 in (610 mm) from faceplate | | 5x5 in (127x127 mm) 10x10 in (254x254 mm) | CS250: 5x5 = 105 lb (48 kg) 10x10 = 118 lb (54 kg) CS450: 5x5 = 162 lb (74 kg) 10x10 = 178 lb (81 kg) |
| Seam Tracker™ Advanced Programming Control Package for CS40 (Control, Pendant and Cables) | K52058-1 | 40 lb (18 kg) @ 6 in (152 mm) from faceplate | | 3x3 in (76x76 mm) 6x6 in (152x152 mm) | 3x3 = 79 lb (36 kg) 6x6 = 90 lb (41 kg) |
| Seam Tracker™ Advanced Programming Control Unit | K52021-1 | N/A | | N/A | 33 (15) |

Motorized Slide Systems

Positioning Made Easy

- Enable horizontal and vertical axis positioning for submerged arc, MIG and flux-cored arc welding
- Intuitive joystick pendant enables manual control
- Less operator fatigue and error compared to hand-crank operated manual slides



Processes

- Submerged Arc
- MIG
- Flux-Cored

Input



Literature

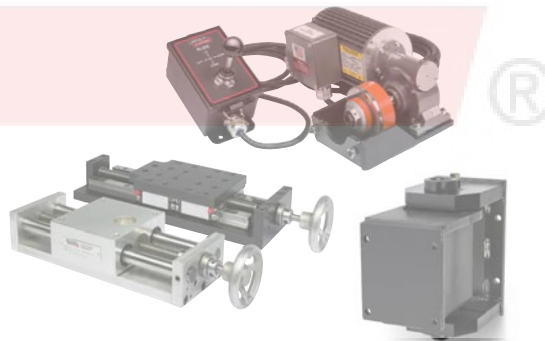
E10.411

| Product Name | Product Number | Standard Stroke Lengths: in (mm) | Load Capacity in (mm) | Input Power Voltage/Phase/Hz | Tracking Accuracy in (mm) | Travel Speed ipm (m/min) | Tracking Controls | Net Wt. lb (kg) |
|--------------------------------------|----------------|----------------------------------|-------------------------------------|------------------------------|---------------------------|--------------------------|---|-----------------|
| MS40 Motorized Slide System One-Pak | K52006-0303 | 3x3 (76x76) | 40 (18) @ 6 (152) from faceplate | 120/230/1/50/60 | 0.005 (0.127) | 24 (0.61) max | Independent horizontal and vertical adjustment speeds | 47 (21) |
| | K52006-0606 | 6x6 (152x152) | | | | | | 49 (22) |
| MS250 Motorized Slide System One-Pak | K52009-0505 | 5x5 (127x127) | 250 (113) @ 12 (305) from faceplate | | | 32 (0.81) max | | 88 (40) |
| | K52009-1010 | 10x10 (254x254) | | | | | | 102 (46) |
| MS450 Motorized Slide System One-Pak | K52012-0505 | 5x5 (127x127) | 450 (204) @ 24 (610) from faceplate | | | 17 (0.43) max | | 119 (54) |
| | K52012-1010 | 10x10 (254x254) | | | | | | 151 (68) |

Manual Slide Systems

Mechanized Automation

- Enable proper alignment of the torch to the weld area
- Ideal for fine horizontal and vertical adjustments to the torch
- Mount on manipulators, side beams, or other torch articulation equipment



Processes

- MIG
- Flux-Cored
- Submerged Arc

Literature

E10.410

| Description | Product Number | Load Capacity lb (kg) @ in (mm) | Ship Weight lb (kg) | A in (mm) | B in (mm) | C in (mm) | D in (mm) | E in (mm) | F in (mm) | G in (mm) | H in (mm) |
|---|----------------------|---------------------------------|---------------------|-------------|---------------------------|--------------|-------------|--------------|-------------|-------------|---------------|
| 6 in (152 mm) Manual Slide | AD2408-1 | 200 (91) @ 6 (152) | 34 (15) | 5-1/2 (140) | 14-1/2 (368) | 3 (76) | 4 (102) | 5/16 (8) | 3-1/2 (89) | 5-1/2 (140) | - |
| 6 in (152 mm) Manual Slide with Power motion* | AD2408-1 AD2408-3 | 200 (91) @ 6 (152) | 64 (29) | 5-1/2 (140) | 14-1/2 (368) | 3 (76) | 6-1/4 (159) | 5/16 (8) | 8-7/8 (225) | 5-1/2 (140) | 10-3/16 (259) |
| 6 in (152 mm) Manual Slide | AD2408-2 | 750 (340) @ 12 (305) | 39 (18) | 5-1/2 (140) | 10-9/16 (268) Plus Stroke | 3 (76) | 4 (102) | 3/16 (5) | 3-1/2 (89) | 8 (203) | - |
| 6 in (152 mm) Manual Slide with Power motion* | AD2408-2 AD2408-3 | 750 (340) @ 12 (305) | 55 (25) | 5-1/2 (140) | 10-9/16 (268) Plus Stroke | 3 (76) | 6-1/4 (159) | 3/16 (5) | 8-7/8 (225) | 8 (203) | 10-3/16 (259) |
| 180° Head Swivel | AD2409-3 | 500 (227) @ 12 (305) | 60 (27) | 180° | 5-1/2 (140) | 11-1/4 (286) | 10 (254) | 10-1/2 (267) | 4-5/8 (117) | 4-5/8 (117) | - |

Oscillators, Torch Height Controllers, and Other Devices

Mechanized Automation Control

- Weld Oscillator System: An economical solution for automated MIG and submerged arc welding
- AVC-5: Arc voltage control system that uses a control and drive unit to maintain precise TIG and plasma arc length in automated systems
- DWF-4: Digital wire feed that provides exact wire input for high-precision welding applications
- DirectArc™: Welding arc control that uses a controller and water-cooled probe mounted at the torch to provide complete control of the TIG arc



Processes

- Varies by component

Input



Literature

www.arcproducts.com

BIGO

Mechanized Automation Rolls, Stands and Positioners

Supporting Your Fabrication Needs

- Heavy duty positioning equipment can be used by pipe mills, pipe and structural fabricators and other industries to assure proper placement and alignment for welding, cutting and other operations.
- Choose from turning and idle rolls, welding positioners pipe support stands manual and power slides and jaw chucks for positioners
- Payload capacities can reach up to 30,000 lbs (13,608 kg), depending on positioning solution



Processes

- MIG
- Flux-Cored
- Submerged Arc

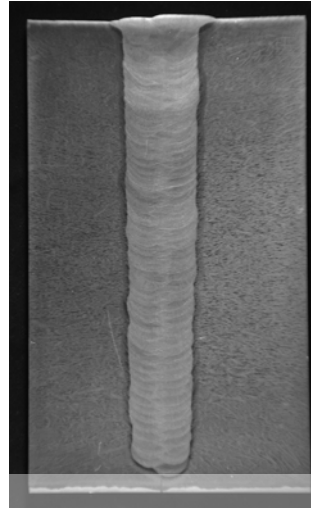
Literature

E10.460
Manipulators
E10.440
Turning and Idle Rolls
E10.430
Welding Positioners
E10.420
Pipe Support Stands
E10.400
Jaw Chucks for Positioners

Narrow Gap Welding Process Equipment

Spend Less Time on Heavy Plate

- This submerged arc multi-layer welding process lays two passes per layer for weld and prep time savings on heavy plate
- Recommended for flat or circumferential weld on steel plate 2 to 13.8 in. thick (51-350 mm)
- Uniform side wall penetration, low parent metal dilution and low heat input
- High quality weld results without turning the plate



Processes

- Submerged Arc

Output



Input



Literature

MC09-109

FLEX LASE® Systems

High Speed Multi-Purpose Laser Processing

- FLEX LASE® systems are used for automotive or heavy equipment power train components, and by appliance, HVAC, medical, nuclear, lithium ion battery manufacturers and more
- FLEX LASE® PRO systems are used for processing and etching thin or special materials with high speed and accuracy
- FLEX WELD™ systems are intended for use on for tailored welded blanks, or can incorporate a scanner system for paint and coating removal or EPS edge prep systems for laser butt welding



Processes

- Welding
- Cutting
- Marking
- Cladding
- Etching
- Scribing
- Heat Treating

Robotic Integration

Higher Productivity, Improved Efficiency

- Welding, cutting, material handling and other functions
- Integrate with all major robot manufacturers, including ABB®, FANUC®, Kuka®, Yaskawa®, Motoman and others
- Engineered solutions with robots (new or redeployed), fixturing, tooling and safety systems



Processes

- MIG
- Flux-Cored
- Resistance or Spot Welding
- Deburring
- Material Handling

System Integration

We Do It All – Turn Key Engineered and Automation Solutions

- Concept, design, fabrication and machining, assembly, programming and installation
- 3D modeling from customer supplied part geometry
- Finite element analysis optimizes line engineering designs, resolves time and resource issues and reduces lead times
- Complete machine shop and dedicated tool building group, produces precision-machined components
- Master line control and third party equipment integration



Processes

- Welding
- Cutting
- Piercing
- Bending
- Marking
- Material Handling
- Other

Fixturing and Tooling Solutions

Positioning for Precision

- Automated tooling for simple clamping fixtures to complex part designs
- Quick change fixture solutions for minor part feature changes, subassembly changes or full robotic fixture change out
- Full line of pneumatic clamping and retraction devices
- Designed to meet all production and tolerance requirements in automotive, recreational vehicles, general industry, furniture and more
- Specialized systems for assembly and inspection
- Weld fixtures interface tooling and sensors with PLCs to control and sequence pneumatic clamps, slides and other components



Processes

- Arc Welding
- Resistance Welding
- Laser Weld Fixturing
- Material Handling
- End-of-Arm Tooling
- Other

Positioning Equipment

Optimize Part Placement

- Complete engineering from concept and simulation to FMEA and cycle time output studies
- Extensive manufacturing experience and capabilities
- Complete controls design including integration with additional systems



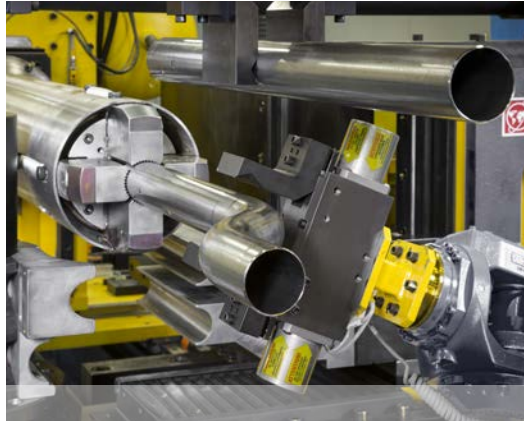
Processes

- Arc Welding
- Resistance Welding
- Laser Weld Fixturing
- Material Handling
- End-of-Arm Tooling
- Other

Tube Bending and Fabricating Systems

Flexible Automated Process Integration

- High productivity, quick-change CNC-based solutions range from fully automated to manually tended bending systems
- Stand-alone workstations and cells can be customized to fit any application
- We provide system upgrades, reconfigurations, program edits/updates and tooling changes for integration of new model or product
- Full servo / all electric systems
- L-R-A data programming, high speed parts handling and complete process integration



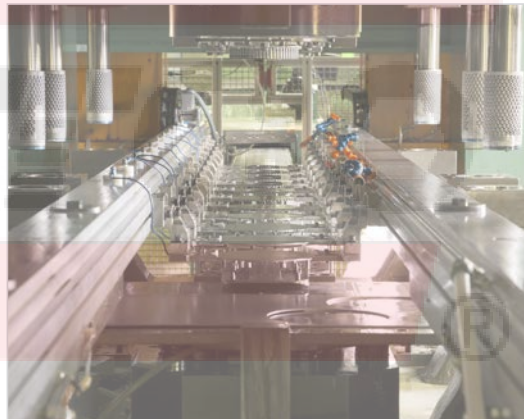
Processes

- Tube Debundling
- Weld Seam Detection
- CNC Bending
- Flattening, Trimming, Piercing, Forming
- Poka-yoke Test and Inspection

Press Automation Systems

Increased Capability and Flexibility

- Modular, fully programmable servo-based transfer systems can be added to any new or existing mechanical, hydraulic or servo press design
- Multiple mounting configurations available including traditional 'through the window' and 'front & back'
- Custom-designed transfer solutions
- Fully integrated solutions include automated blank destacking systems, high speed blank stacking systems along with press loading and unloading systems and press-to-press automation systems
- Transfer tooling solutions



Tubular Hydroform and Structural Frame Automation Systems

A System-Wide Integrated Approach

- System control diagnostics, along with the integration of existing or redeployed process stations
- End-of-line inspection, marking, racking and parts handling
- Complete system integration services
- Vintage system reconfiguration and relocation services and complete system integration services, including third party equipment integration



Processes

- Weld Seam Detection
- Tube Entry Modules
- CNC Bending
- Robotic Integration
- Mechanical Trim, Shear and Pierce Stations
- Laser Cutting

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Orbital TIG Welding System

Ready-Pak® Package with Power Wave® S500 (K52003-1)

- Power Wave® S500 (AP version)
- APEX® 2100 Controller
- APEX® 2100 Pendant
- APEX® 2100 Pendant cable
- APEX® Cabinet
- CoolArc® 55

One-Pak® Package with Power Wave® S500 (K52082-1)

- Everything listed above
- HELIX® T55 (HELIX® Track Ring not included – select track ring size to complete system)

Orbital MIG Welding System

Ready-Pak® Package with Power Wave® S350 (K52103-1)

- HELIX® M85 Weld Head
- APEX® 3000 Control Module
- APEX® 3000 Control Pendant
- AutoDrive® 4R220 Wire Feeder with Spool Mount
- Power Wave® S350
- Mechanized Torch 550A, 15 ft. (4.6 m)
- APEX® 3000 AP System Cart
- HELIX® Control Cable, 25 ft. (7.6 m)
- Pendant Control Cable
- Wire Drive Cable 14-pin, 25 ft. (7.6 m)
- Linc-Net® Cable Assembly 5-pin, 8 ft.

Ready-Pak® Package with Power Wave® S500 (K52103-2)

- HELIX® M85 Weld Head
- APEX® 3000 Control Module
- APEX® 3000 Control Pendant
- AutoDrive® 4R220 Wire Feeder with Spool Mount
- Power Wave® S500
- Mechanized Torch 550A, 15 ft. (4.6 m)
- APEX® 3000 AP System Cart
- HELIX® Control Cable, 25 ft. (7.6 m)
- Pendant Control Cable
- Wire Drive Cable 14-pin, 25 ft. (7.6 m)
- Linc-Net® Cable Assembly 5-pin, 8 ft.

MS40 Motorized Slide System

3x3 (76x76) One-Pak® Package (K52006-0303)

- CS40 Cross Slide 3x3 (76x76)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable

6x6 (152x152) One-Pak® Package (K52006-0606)

- CS40 Cross Slide 6x6 (152x152)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable

MS250 Motorized Slide System

5x5 (127x127) One-Pak® Package (K52009-0505)

- CS250 Cross Slide 5x5 (127x127)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable
- Cross Slide Drive Cable Assembly for CS250 & CS450, 10 ft (3 m)

10x10 (254x254) One-Pak® Package (K52009-1010)

- CS250 Cross Slide 10x10 (254x254)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable
- Cross Slide Drive Cable Assembly for CS250 & CS450, 10 ft (3 m)

MS450 Motorized Slide System

5x5 (127x127) One-Pak® Package (K52012-0505)

- CS450 Cross Slide 5x5 (127x127)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable
- Cross Slide Drive Cable Assembly for CS250 & CS450, 10 ft (3 m)

10x10 (254x254) One-Pak® Package (K52012-1010)

- CS450 Cross Slide 10x10 (254x254)
- MS Control Unit
- MS Control Pendant, 10 ft (3 m) Cable
- Cross Slide Drive Cable Assembly for CS250 & CS450, 10 ft (3 m)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

ST40 Standard System

3x3 (76x76) One-Pak® Package (K52004-0303)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- CS40 Cross Slide 3x3 (76x76)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

6x6 (152x152) One-Pak® Package (K52004-0606)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- CS40 Cross Slide 6x6 (152x152)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST250 Standard System

5x5 (127x127) One-Pak® Package (K52007-0505)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS250 Cross Slide 5x5 (127x127)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST250 Standard System, con't.

10x10 (254x254) One-Pak® Package (K52007-1010)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS250 Cross Slide 10x10 (254x254)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST450 Standard System

5x5 (127x127) One-Pak® Package (K52010-0505)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS450 Cross Slide 5x5 (127x127)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

10x10 (254x254) One-Pak® Package (K52010-1010)

- Standard Control
- Standard Pendant w/10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS450 Cross Slide 10x10 (254x254)
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

ST40 Advanced Programming Control System

3x3 [76x76] One-Pak® Package with APC (K52005-0303)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- CS40 Cross Slide 3x3 [76x76]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

6x6 [152x152] One-Pak® Package with APC (K52005-0606)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- CS40 Cross Slide 6x6 [152x152]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST250 Advanced Programming Control System

5x5 [127x127] One-Pak® Package with APC (K52008-0505)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS250 Cross Slide 5x5 [127x127]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST250 Advanced Programming Control System, con't.

10x10 [254x254] One-Pak® Package with APC (K52008-1010)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS250 Cross Slide 10x10 [254x254]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

ST450 Advanced Programming Control System

5x5 [127x127] One-Pak® Package with APC (K52011-0505)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS450 Cross Slide 5x5 [127x127]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

10x10 [254x254] One-Pak® Package with APC (K52011-1010)

- Advanced Programming Control
- Advanced Process Pendant w/ 10 ft (3 m) Cable
- 4 ft (1.2 m) Cable
- 10 ft (3 m) Cable
- CS450 Cross Slide 10x10 [254x254]
- Seam Sensor Assembly
- Five Axis Probe Bracket
- Weld Torch Mounting Kit
- Sensor Insulator
- Seam Sensor Tip PT012, 1/8 in. (3.2 mm)

Accessories » Robotic Welding Systems

| Product Name | Product No. | Robotic Welding Systems | | | | | | | | | | | | |
|---|-------------|-------------------------|------------|------------------------------|---------------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|---------------------------|--------------------------|-----------------------------|
| | | Custom | Base Model | Power Wave [®] S350 | Power Wave [®] S350 Aluminum | Power Wave [®] R350 | Power Wave [®] i400 | Power Wave [®] S500 | Power Wave [®] R500 | AutoDrive [®] 4R100 | AutoDrive [®] 4R220 | AutoDrive [®] SA | AutoDrive [®] S | Power Feed [®] 10R |
| GENERAL | | | | | | | | | | | | | | |
| Control Cables and Adapters | — | | | | | | • | | | | • | • | • | • |
| Drive Roll and Wire Guide Kits | — | | | | | | | | | | • | • | • | • |
| Power REAM [®] Torch Maintenance Center | K2391-1 | • | | | | | | | | | | | | |
| Reaming Bit, 1/2 in. (12.7 mm) with Washer | KP2435-1 | • | | | | | | | | | | | | |
| Reaming Bit, 5/8 in. (15.9 mm) with Washer | KP2435-3 | • | | | | | | | | | | | | |
| Reaming Bit, 3/4 in. (19.1 mm) with Washer | KP2435-5 | • | | | | | | | | | | | | |
| Anti-Spatter Fluid, 1 gallon (3.8 L) | KP2457-1 | • | | | | | | | | | | | | |
| Power REAM [®] Robotic Cable, 20 ft. (6.1 m) | K2433-1 | • | | | | | | | | | | | | |
| Remote Power REAM [®] Reservoir Kit | K2434-1 | • | | | | | | | | | | | | |
| DeviceNet [™] Kit | K2827-2 | | • | • | • | • | • | • | • | | | | | |
| Sense Lead Kit, 25 ft. (7.6 m) | K940-25 | | • | • | • | • | • | • | • | | | | | |
| Sense Lead Kit, 75 ft. (22.9 m) | K940-75 | | • | • | • | • | • | • | • | | | | | |
| Inverter Chassis | K2673-1 | | | | | | • | | | | | | | |
| Integration Kit | K2677-2 | | | | | | • | | | | | | | |
| CE Filter | K2670-1 | | | | | | • | | | | | | | |
| Cool Arc [®] 40 Water Cooler 115/150/60 | K1813-1 | | | | | | • | | | | | | | |
| Cool Arc [®] 55 | K3086-1 | | | | | | | | • | | | | | |
| Cool Arc [®] 55 Aluminum | K4190-1 | | | • | | | | | | | | • | | |
| DeviceNet [™] Interface Module | K2206-1 | | | | | | | | • | | | | | |
| Ethernet/DeviceNet [™] Interface Module | K2207-2 | | | | | | | | | | | | | |
| Dual Cylinder Platform Undercarriage | K1570-1 | | | | | | | | | | | | | |
| User Interface Kit | K3001-2 | | • | • | • | • | • | • | | | | | | |
| Wire Straightener | K1733-1 | | | | | | | | | • | • | | | |
| Incoming Bushing for Lincoln Conduit, 0.025-1/16 in. (0.64-1.6 mm) wire | K1546-1 | | | | | | | | | • | • | | | |
| Incoming Bushing for Lincoln Conduit, 1/16-1/8 in. (1.6-3.2 mm) wire | K1546-2 | | | | | | | | | • | • | | | |
| Water Connection Kit | K590-7 | | | | | | | | | • | • | | | • |
| Robotic Cable Adapter, 22-pin to 14-pin, 10 ft. (3.0 m) | K1804-1 | | | | | | | | | | | | | • |
| Robotic Cable Adapter, 22-pin to 14-pin, 18 in. (0.46 m) | K1804-2 | | | | | | | | | | | | | • |
| Robotic Cable Adapter, 14-pin to 22-pin, 18 in. (0.46 m) | K1805-1 | | | | | | | | | | | | | • |
| Weld Fume Control System | — | • | | | • | • | | • | • | • | • | • | • | • |

• Optional

Accessories » Robotic Welding Systems, con't.

| Product Name | Product No. | Robotic Welding Systems | | | | | | | | | | | |
|--------------------------------------|-------------|-------------------------|------------------|---------------------------|------------------|------------------|------------------|------------------|------------------|------------------|---------------|--------------|-----------------|
| | | Custom | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | | Power Wave® S350 | Power Wave® S350 Aluminum | Power Wave® R350 | Power Wave® i400 | Power Wave® S500 | Power Wave® R500 | AutoDrive® 4R100 | AutoDrive® 4R220 | AutoDrive® SA | AutoDrive® S | Power Feed® 10R |
| WIRE FEEDER | | | | | | | | | | | | | |
| AutoDrive® 4R220 | K2685-3 | | | | • | • | | • | | | | | |
| AutoDrive® 4R100 | K3002-2 | | | | • | • | | • | | | | | |
| AutoDrive® 19 Controller | K3004-2 | | • | • | | | • | | | | | | |
| AutoDrive® 19 Tandem Controller | K3171-1 | | | | | • | | | | | | | |
| AutoDrive® SA | K4129-1 | | • | • | • | • | • | • | | | | | |
| AutoDrive® S | K4303-1 | | • | • | • | • | • | • | | | | | |
| Power Feed® 10R | K1780-3 | | | | • | • | | • | | | | | |
| POWER SOURCE | | | | | | | | | | | | | |
| Power Wave® STT® Module | K2902-2 | | • | | • | | • | • | | | • | • | |
| Power Wave® Advanced Module | K2912-2 | | • | | • | | • | • | | | • | • | |
| Power Wave® Advanced Module Aluminum | K4192-1 | | | • | | | | | | | • | • | |
| Power Wave® i400 | K2669-1 | | | | | | | | • | • | • | • | • |
| Power Wave® S350 | K2823-3 | | | | | | | | | | • | • | |
| Power Wave® S350 Aluminum | K4188-1 | | | | | | | | | | • | • | |
| Power Wave® S500 | K2904-1 | | | | | | | | | | • | • | |
| Power Wave® R350 | K3022-2 | | | | | | | | • | • | • | • | • |
| Power Wave® R500 | K3169-2 | | | | | | | | • | • | • | • | • |
| 2-YEAR EXTENDED WARRANTY | | | | | | | | | | | | | |
| Robotic Welding Systems | — | • | | | | | | | | | | | |
| Power Wave® R350 | X3022 | | | • | | | | | | | | | |
| Power Wave® i400 | X2669 | | | | | • | | | | | | | |
| Power Wave® R500 | X3169 | | | | | | | • | | | | | |
| AutoDrive® 4R100 | X3002 | | | | | | | | • | | | | |
| AutoDrive® 4R220 | X2685 | | | | | | | | | • | | | |
| AutoDrive® SA | X4129 | | | | | | | | | | • | | |
| AutoDrive® S | X4303 | | | | | | | | | | | • | |
| Power Feed® 10R | X1780 | | | | | | | | | | | | • |

• Optional

Accessories » Mechanized Automation

| Product Name | Product No. | Welding Positioners and Manipulators |
|--|-------------|--------------------------------------|
| POSITIONER | | |
| Spring Loaded Copper Grounding Shoe 600 PT | AD2404-1 | • |
| Footswitch Forward/Stop/Reverse | AD2404-2 | • |
| Footswitch Variable Speed Control | AD2404-3 | • |
| Positioner Linear Weld Speed Controller | AD2404-4 | • |
| Digital Tachometer | AD2404-5 | • |
| Control Cable 25 ft (7.6 m) | AD2404-6 | • |
| MANIPULATOR | | |
| Single Axis Slide Power Kit | AD2408-3 | • |
| Single Wire SAW Mounting Kit | AD2409-1 | • |
| Tandem SAW Mounting Kit | AD2409-2 | • |
| 180° Head Swivel | AD2409-3 | • |
| BASE | | |
| Stand Alone Base (8x8) | AD1340-72 | • |
| Stand Alone Base (11x11) | AD1340-143 | • |
| SUPPORT PLATFORM | | |
| Manipulator Column Support Platform Standard | AD2410-14 | • |
| Manipulator Column Support Platform Oversized Tandem Arc | AD2410-6 | • |
| TRAVEL CAR | | |
| Manipulator Travel Car I (11x11) | AD2410-3 | • |
| Manipulator Travel Car II (8x8) | AD1340-40 | • |
| CAR TRACK | | |
| Travel Car Track I (11x11) | AD2410-4 | • |
| Travel Car Track II (8x8) | AD1340-42 | • |
| TRAVEL CAR ACCESSORIES | | |
| Spring Loaded Copper Grounding Shoe 1000A | AD1340-37 | • |
| Over Travel Limit Switch | AD1340-35 | • |
| Digital Tachometer Speed Indicator | AD1340-51 | • |
| Track Wiper Brushes | AD1340-36 | • |

• Optional

Accessories » Orbital Systems

| Product Name | Product No. | APEX™ 2100 Orbital TIG Welding System | APEX™ 3000 Orbital MIG Welding System | HELIX™ C450 Weld Head | HELIX™ C663 Weld Head |
|--|-------------|---------------------------------------|---------------------------------------|-----------------------|-----------------------|
| WELD HEADS | | | | | |
| HELIX® T55 Weld Head | K52002-1 | • | | | |
| HELIX® M85 Weld Head | K52101-1 | | • | | |
| HELIX® C450 Orbital Weld Head | K52095-1 | | | • | |
| HELIX C663 Weld Head with onboard feeder | K52092-1 | | | | • |
| HELIX® C663 Orbital Weld Head | K52092-2 | | | | • |
| TRACK RINGS AND SHOE EXTENSIONS | | | | | |
| HELIX® Track Ring, 8 in. (203.2 mm) [2 pieces, 6 shoes] | K52000-8 | • | • | | |
| HELIX® Track Ring, 10 in. (254 mm) [2 pieces, 6 shoes] | K52000-10 | • | • | | |
| HELIX® Track Ring, 12 in. (304.8 mm) [2 pieces, 6 shoes] | K52000-12 | • | • | | |
| HELIX® Track Ring, 14 in. (355.6 mm) [2 pieces, 6 shoes] | K52000-14 | • | • | | |
| HELIX® Track Ring, 16 in. (406.4 mm) [2 pieces, 6 shoes] | K52000-16 | • | • | | |
| HELIX® Track Ring, 18 in. (457.2 mm) [2 pieces, 6 shoes] | K52000-18 | • | • | | |
| HELIX® Track Ring, 20 in. (508 mm) [2 pieces, 6 shoes] | K52000-20 | • | • | | |
| HELIX® Track Ring, 22 in. (558.8 mm) [2 pieces, 6 shoes] | K52000-22 | • | • | | |
| HELIX® Track Ring, 24 in. (609.6 mm) [2 pieces, 8 shoes] | K52000-24 | • | • | | |
| HELIX® Track Ring, 28 in. (711.2 mm) [2 pieces, 8 shoes] | K52000-28 | • | • | | |
| HELIX® Track Ring, 32 in. (812.8 mm) [2 pieces, 8 shoes] | K52000-32 | • | • | | |
| HELIX® Track Ring, 36 in. (914.4 mm) [4 pieces, 12 shoes] | K52000-36 | • | • | | |
| HELIX® Track Ring, 40 in. (1016 mm) [4 pieces, 12 shoes] | K52000-40 | • | • | | |
| HELIX® Track Ring, 44 in. (1117.6 mm) [4 pieces, 12 shoes] | K52000-44 | • | • | | |
| HELIX® Track Ring, 48 in. (1219.2 mm) [4 pieces, 12 shoes] | K52000-48 | • | • | | |
| HELIX® Track Ring, 52 in. (1320.8 mm) [4 pieces, 12 shoes] | K52000-52 | • | • | | |
| HELIX® Track Ring, 56 in. (1422.4 mm) [4 pieces, 12 shoes] | K52000-56 | • | • | | |
| HELIX® Track Ring, 60 in. (1524 mm) [4 pieces, 12 shoes] | K52000-60 | • | • | | |
| HELIX® Track Ring, 64 in. (1625.6 mm) [4 pieces, 12 shoes] | K52000-64 | • | • | | |
| HELIX® Shoe Extension 0.5 in. (12.7 mm) | K52060-05 | • | • | | |
| HELIX® Shoe Extension 1.0 in. (25.4 mm) | K52060-10 | • | • | | |
| HELIX® Shoe Extension 2.0 in. (50.8 mm) | K52060-20 | • | • | | |
| HELIX® Shoe Extension 3.0 in. (76.2 mm) | K52060-30 | • | • | | |
| HELIX® Single Shoes | KP52081-1 | • | • | | |
| C450 Clamp Shoe 4.5 in. (114.3 mm) | K52096-450 | | | • | |
| C450 Clamp Shoe 4.0 in. (101.6 mm) | K52096-400 | | | • | |
| C450 Clamp Shoe 3.5 in. (88.9 mm) | K52096-350 | | | • | |
| C450 Clamp Shoe 2.875 in. (73.0 mm) | K52096-288 | | | • | |
| C450 Clamp Shoe 2.375 in. (60.3 mm) | K52096-238 | | | • | |
| C450 Clamp Shoe 1.9 in. (48.3 mm) | K52096-190 | | | • | |
| C450 Clamp Shoe 1.66 in. (42.2 mm) | K52096-166 | | | • | |
| C450 Clamp Shoe 1.315 in. (33.4 mm) | K52096-132 | | | • | |
| C450 Clamp Shoe Special Size | K52096-000 | | | • | |

• Optional

Accessories » Orbital Systems

| Product Name | Product No. | APEX™ 2100 Orbital TIG Welding System | APEX™ 3000 Orbital MIG Welding System | HELIX™ C450 Weld Head | HELIX™ C663 Weld Head |
|--|--------------|---------------------------------------|---------------------------------------|-----------------------|-----------------------|
| TRACK RINGS AND SHOE EXTENSIONS , CON'T. | | | | | |
| C663 Clamp Shoe 6.625 in (168.3 mm) | K52093-663 | | | | • |
| C663 Clamp Shoe 5.563 in (141.3 mm) | K52093-556 | | | | • |
| C663 Clamp Shoe 4.5 in (114.3 mm) | K52093-450 | | | | • |
| C663 Clamp Shoe 4.0 in (101.6 mm) | K52093-400 | | | | • |
| C663 Clamp Shoe 3.5 in (88.9 mm) | K52093-350 | | | | • |
| C663 Clamp Shoe 2.875 in (73.0 mm) | K52093-288 | | | | • |
| C663 Clamp Shoe 2.375 in (60.3 mm) | K52093-238 | | | | • |
| C663 Clamp Shoe 1.9 in (48.3 mm) | K52093-190 | | | | • |
| C663 Clamp Shoe Special Size | K52093-000 | | | | • |
| DRIVE ROLLS | | | | | |
| HELIX® Drive Rolls, 0.030 in. (0.8 mm) Wire Size | KP52079-030 | • | | • | • |
| HELIX® Drive Rolls, 0.035 in. (0.9 mm) Wire Size | KP52079-035 | • | | • | • |
| HELIX® Drive Rolls, 0.040 in. (1.0 mm) Wire Size | KP52079-040 | • | | • | • |
| HELIX® Drive Rolls, 0.045 in. (1.1 mm) Wire Size | KP52079-045 | • | | • | • |
| Onboard Feeder Drive Roll Kit .030 in. (0.8 mm) | KP52094-030 | | | | • |
| Onboard Feeder Drive Roll Kit .035 in. (0.9 mm) | KP52094-035 | | | | • |
| Onboard Feeder Drive Roll Kit .040 in. (1.0 mm) | KP52094-040 | | | | • |
| Onboard Feeder Drive Roll Kit .045 in. (1.1 mm) | KP52094-045 | | | | • |
| WIRE LINERS AND GUIDES | | | | | |
| WF20S Suitcase Feeder 2-10 lb. (0.9-4.5 kg) Capacity | K52097-1 | | | • | • |
| WF20B Bench Feeder 10.0-44.0 lb. (4.5-20.0 kg) | K52097-2 | | | • | • |
| HELIX® C Series Wire Guide Tip .030-.035 in. (0.8-0.9 mm) | KP52100-035 | | | • | • |
| HELIX® C Series Wire Guide Tip .040-.045 in. (1.0-1.1 mm) | KP52100-045 | | | • | • |
| HELIX® C Series Wire Liner | KP52109-1 | | | • | • |
| HELIX® Wire Liner, Standard Length | KP52077-1 | • | | | |
| HELIX® Wire Liner, Extended Length | KP52077-2 | • | | | |
| HELIX® Wire Guide, 0.035 in. (0.9 mm) Wire Size | KP52078-035 | • | | | |
| HELIX® Wire Guide, 0.045 in. (1.1 mm) Wire Size | KP52078-045 | • | | | |
| HELIX® Inlet / Outlet Guide, 0.035 in. (0.9 mm) Wire Size | KP52080-035 | • | | • | • |
| HELIX® Inlet / Outlet Guide, 0.045 in. (1.1 mm) Wire Size | KP52080-045 | • | | • | • |
| HELIX® Inlet / Outlet Guide, 0.035 in. (0.9 mm) Wire Size | KP52115-035 | | | • | • |
| HELIX® Inlet / Outlet Guide, 0.045 in. (1.1 mm) Wire Size | KP52115-045 | | | • | • |
| Wire Liner 0.030-0.035 in. (0.8-0.9 mm) | KP42-3035-15 | | | • | • |
| Wire Liner 0.040-0.045 in. (1.0-1.1 mm) | KP42-4045-15 | | | • | • |
| Wire Liner 0.030-0.045 in. (0.8-1.1 mm) [xx = size in feet, 15 ft. (4.6 m) or 25 ft. (7.6 m)] | KP45-3545-xx | • | | | |
| Wire Liner 0.052-1/16 in. (1.3-1.6 mm) [xx = size in feet, 15 ft. (4.6 m) or 25 ft. (7.6 m)] | KP45-116-xx | • | | | |
| Wire Liner 5/64-3/32 in. (2.0-2.4 mm) [xx = size in feet, 15 ft. (4.6 m) or 25 ft. (7.6 m)] | KP45H-332-xx | • | | | |

• Optional

Accessories » Orbital Systems

| Product Name | Product No. | APEX™ 2100 Orbital TIG Welding System | APEX™ 3000 Orbital MIG Welding System | HELIX™ C450 Weld Head | HELIX™ C663 Weld Head |
|---|-------------|---------------------------------------|---------------------------------------|-----------------------|-----------------------|
| WIRE LINERS AND GUIDES, CON'T. | | | | | |
| Onboard Feeder Inlet/Outlet Guide Set, 0.030-0.035 in. (0.8-0.9 mm) | KP52099-035 | | | | • |
| Onboard Feeder Inlet/Outlet Guide Set, 0.040-0.045 in. (1.0-1.1 mm) | KP52099-045 | | | | • |
| Onboard Feeder Wire Liner, 0.023-0.035 in. (0.6-0.9 mm) | KP52109-035 | | | | • |
| Onboard Feeder Wire Liner, 0.035-0.045 in. (0.8-1.1 mm) | KP52109-045 | | | | • |
| HELIX C663 Onboard Wire Feed Removal Kit | K52118-1 | | | | • |
| HELIX C663 Onboard Wire Feed Upgrade Kit | K52117-1 | | | | • |
| GENERAL | | | | | |
| Pyrex® Cup (short) | KP52062-1 | • | | | |
| 1/8 (3.2 mm) Tungsten Adaptor | KP52063-1 | • | | | |
| 5/32 (4.0 mm) Tungsten Adaptor | KP52069-1 | • | | | |
| Collet Body | KP52064-1 | • | | | |
| 1/8 (3.2 mm) Collet | KP52065-1 | • | | | |
| 5/32 (4.0 mm) Collet | KP52070-1 | • | | | |
| 1/8 (3.2 mm) Tungsten | KP52066-1 | • | | | |
| 5/32 (4.0 mm) Tungsten | KP52071-1 | • | | | |
| Back Cap Long | KP52067-1 | • | | | |
| Back Cap Medium | KP52068-1 | • | | | |
| HELIX C Series External Wire Feed Cable Extension, 10 ft. (3.0 m) | KP52124-1 | | | • | • |
| HELIX® Cable/Hose Extension, 25 ft. (7.6 m) | K52072-25 | • | | • | • |
| HELIX® Cable/Hose Extension, 50 ft. (15.2 m) | K52072-50 | • | | • | • |
| HELIX® Cable/Hose Extension, 75 ft. (22.9 m) | K52072-75 | • | | • | • |
| HELIX C Series Low Profile Back Cap | KP52110-1 | | | • | • |
| HELIX C Series External Wire Feed Cable Extension | K52124-1 | | | • | • |
| HELIX C Series Power Water Hose | KP52125-1 | | | • | • |
| HELIX C Series Water Hose | KP52126-1 | | | • | • |
| HELIX C Series Gas Hose | KP52127-1 | | | • | • |
| HELIX C Series Cable/Hose Main Cover | KP52128-1 | | | • | • |
| HELIX C Series Cable/Hose Hi Temp Cover | KP52129-1 | | | • | • |
| 1/8 in. (3.2 mm) Collet | KP2029-5B1 | | | • | • |
| 3/32 in. (2.4 mm) Collet | KP2029-4B1 | | | • | • |
| 1/16 in. (1.6 mm) Collet | KP2029-3B1 | | | • | • |

• Optional

Accessories » Orbital Systems

| Product Name | Product No. | APEX™ 2100 Orbital TIG Welding System | APEX™ 3000 Orbital MIG Welding System | HELIX® C450 Weld Head | HELIX® C663 Weld Head |
|---|--------------|---------------------------------------|---------------------------------------|-----------------------|-----------------------|
| GENERAL, CON'T. | | | | | |
| Back Cap Short | KP2035-1B1 | | | • | • |
| Back Cap Medium | KP2035-2B1 | | | • | • |
| Back Cap Long | KP2035-4B1 | | | • | • |
| Mechanized Torch 550A, 25 ft. (7.6 m) | K52106-25 | • | | | |
| Mechanized Torch 550A, 15 ft. (4.6 m) | K52106-15 | • | | | |
| HELIX® Control Cable [xx = Length in 25 ft. (7.6 m) increments] | K52107-xx | • | | | |
| Spatter Shield | KP52112-1 | • | | | |
| Oscillation Cover Kit | KP52135-1 | • | | | |
| Torch Height Belt | KP52136-1 | • | | | |
| Oscillation Belt | KP52137-1 | • | | | |
| Diffuser | KP2747-1 | • | | | |
| Replacement Nozzle, 1/8 in. (3.2 mm), recessed | KP2743-1-62R | • | | | |
| Replacement Nozzle, 1/8 in. (3.2 mm), stick out | KP2743-1-62S | • | | | |
| Helix C663 Cable/Hose Assy | K52120-1 | | | | • |
| Helix C663 Control Cable | K52121-1 | | | | • |
| HELIX C450 Cable/Hose Assembly | KP52122-1 | | | • | |
| HELIX C450 Control Cable | KP52123-1 | | | • | |



• Optional

WELD FUME CONTROL

| MODEL | FILTER | | PROCESS | | | | INPUT Volts/Phase/Hertz | FEATURES | | | | |
|-----------------------------------|----------------|---|---------|-----|-----|------------|----------------------------|----------|-------------------|------------------------|-------------------|-----------------|
| | System | Size: ft ² (m ²) | Stick | TIG | MIG | Flux-Cored | | Mobile | Start/Stop Sensor | Filter Indicator Gauge | Single Arm System | Dual Arm System |
| PORTABLE | | | | | | | | | | | | |
| Miniflex [®] | Disposable | 130 (12) | ● | ● | ● | ● | 115/1/60 230/1/60 | ● | ● | | ● | |
| X-Tractor [®] 1GC | Self-Cleaning | 30 (2.8) | ● | ● | ● | ● | 120/1/50/60 220/1/50/60 | ● | ● | | ● | |
| Mobiflex [®] 100-NF | Non-Filtration | — | ● | ● | ● | ● | 115/1/50/60 | ● | | | | |
| MOBILE | | | | | | | | | | | | |
| Mobiflex [®] 200-M | Disposable | 538 (50) | ● | ● | ● | ● | 115/1/60 | ● | | ● | ● | |
| Mobiflex [®] 400-MS | Self-Cleaning | 325 (30) | ● | ● | ● | ● | 115/1/60 | ● | | ● | ● | |
| STATIONARY | | | | | | | | | | | | |
| X-Tractor [®] 3A, 5A, 8A | Self-Cleaning | up to 108 (10) | ● | ● | ● | ● | 230/3/60 460/3/60 | | | | | |
| StatiFlex [®] 200-M | Disposable | 538 (50) | ● | ● | ● | ● | — | | | ● | ● | ● |
| StatiFlex [®] 400-MS | Self-Cleaning | 325 (30) | ● | ● | ● | ● | — | | | ● | ● | |
| DownFlex [®] 100-NF | Non-Filtration | — | ● | ● | ● | ● | — | | | | | |
| DownFlex [®] 200-M | Disposable | 560 (52) | ● | ● | ● | ● | 208/230/460/3/60 | | | ● | | |
| DownFlex [®] 400-MS/A | Disposable | 560 (52) | ● | ● | ● | ● | 208/230/460/3/60 | | | ● | ● | |

ROBOTIC » Formed Extraction Hood

ENGINEERED SYSTEMS » The Circulator™ • Push/Pull Systems • High and Low Vacuum Central Systems • StatiFlex[®] Filter Banks • Modular Extraction Hood

FIRE SAFETY » Guardian™ Fire Safety Solutions

Miniflex®

Industry-Leading Portability and Ease of Use

- High vacuum system designed for confined and other hard-to-reach spaces
- Automatic stop/start capability triggered by welding current
- Early warning system alerts you when 80% of the carbon brushes have been consumed



Shown with optional EN-20 Nozzle

Processes

- Stick (light duty)
- TIG
- MIG
- Flux-Cored (light duty)

Input



Literature

MC12-73

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft ² (m ²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------|----------------|---------------------------------|------------------------------|---|-----------------|-----------------------------|-----------------|
| Miniflex® | K3972-1 | 115/1/60 | 14.6A | Five-Stage Filtration System | H: 135 L: 94 | 28.75 x 16.5 (730 x 420) | 38 (17.2) |
| | K3973-1 | 230/1/60 | 7.4A max. | | | | |



X-Tractor® 1GC

Move It Where You Need It

- Intended for light duty welding in small shops, maintenance applications and for home/hobby projects
- Rotary air jet filter cleaning system
- Quiet operation at <74 dBA
- Automatic Stop/Start provides extraction only when needed



Shown with optional Nozzle

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

E13.17

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft ² (m ²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------|----------------|---------------------------------|------------------------------|---|--------------|---|-----------------|
| X-Tractor® 1GC | K652-1 | 120/1/50/60 | 15A | 30.1 (2.8) | N/A | 13.4 x 26.8 x 15.8 (340 x 680 x 400) | 45 (20.4) |
| | K652-2 | 220/1/50/60 | 9A | | | | |

Mobiflex® 100-NF

Basic Unfiltered Extraction

- Ideal for construction sites or applications where fume removal does not require filtration
- Weighs only 37.5 lbs. (17 kg)
- Low 69 dBA noise level
- Maximum 32 ft. (9.7 m) reach distance with Hood and Hose Set and Extension Hose Set



Shown with optional Nozzle

Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

E13.42

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft² (m²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|---------------------------------|------------------------------|------------------------------------|--------------|---|-----------------|
| Mobiflex® 100-NF | K1666-1 | 115/1/50/60 | 10A | No Filtration, Exhaust Only | 765 | 23.1 x 18.9 x 18.9 (587 x 480 x 480) | 37.5 (17) |

Mobiflex® 200-M

Fume Doesn't Stand A Chance

- Filter status indicator monitors the amount of particulate in the filter cartridge to alert the user for filter maintenance or replacement
- Generous airflow (735 CFM with LFA 3.1/4.1 extraction arm) and large filter capacity [538 ft² (50 m²)]
- Choose from a variety of arms or select a hose/hood set



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

E13.12

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft² (m²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------|----------------|---------------------------------|------------------------------|--|--------------|------------------------------------|-----------------|
| Mobiflex® 200-M | K1653-2 | 115/1/60 | 12A | Cellulose 538 (50) | 735 | 36 x 32 x 48 (900 x 810 x 1210) | 181 (82) |
| | K2497-2 | 230/1/50 | 9A | | | | |
| | K1653-3 | 115/1/60 | 12A | High-Efficiency Cellulose-Polyester 538 (50) | | | |

Mobiflex® 400-MS

Mobile Self-Cleaning Fume Extraction System

- RotaPulse® automatic cleaning system simplifies filter maintenance
- Filter status indicator monitors amount of particulate in filter cartridge to alert for maintenance or replacement
- Generous airflow (735 CFM with LFA 3.1/4.1 extraction arm) and large filter capacity [325 ft² (30 m²)]
- Choose from a variety of arms or select a hose/hood set



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Input



Literature

E13.12

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft² (m²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|------------------|----------------|---------------------------------|------------------------------|--|--------------|----------------------------------|-----------------|
| Mobiflex® 400-MS | K1741-1 | 115/1/60 | 12A | Cellulose 325 (30) | 735 | 40 x 32 x 48 (1020 x 810 x 1210) | 212 (96) |
| | K2497-4 | 230/1/50 | 9A | | | | |
| | K1741-2 | 115/1/60 | 12A | High-Efficiency Cellulose-Polyester 325 (30) | | | |

X-Tractor® Stationary Systems

Heavy Duty Multi-Arc Fume Extraction

- These high vacuum, low volume systems are engineered to provide suction for multiple nozzles and fume guns
- An integrated automatic filter cleaning system simplifies maintenance
- Select the X-Tractor® 3A for 1 nozzle and up to 3 fume guns, the 5A for 3 nozzles and up to 5 fume guns and the 8A for 5 nozzles and up to 8 fume guns



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Grinding⁽¹⁾

Input



Literature

MC14-44

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft² (m²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|---------------|----------------|---------------------------------|------------------------------|------------------------------------|--------------|--|-----------------|
| X-Tractor® 3A | K3965-1 | 230/3/60 | 14A | 30.1 (2.8) | 165 | 29.1 x 16.9 x 43.3 (740 x 430 x 1100) | 192 (87) |
| | K3965-2 | 460/3/60 | 6.5A | | | | |
| X-Tractor® 5A | K3966-1 | 230/3/60 | 20A | 53.82 (5) | 285 | 33.1 x 28.0 x 55.1 (840 x 710 x 1400) | 242 (110) |
| | K3966-2 | 460/3/60 | 10A | | | | |
| X-Tractor® 8A | K3967-1 | 230/3/60 | 40A | 107.64 (10) | 475 | 43.3 x 28.0 x 55.1 (1100 x 710 x 1400) | 375 (170) |
| | K3967-2 | 460/3/60 | 21A | | | | |

Statiflex® 200-M

Convenient Wall-Mounted System

- Intended for facilities with fixed work stations and little available floor space
- Designed for light to medium fume extraction and filtration
- Generous airflow up to 735 CFM with LFA 3.1 or 4.1 extraction arms and SF2400 fan
- Large filter capacity [538 ft² (50 m²)] increases efficiency, filter life and reduces operational costs



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

MC13-96

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft ² (m ²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------|----------------|---------------------------------|------------------------------|---|--------------|--------------------------------|-----------------|
| Statiflex® 200-M Single Arm | K1654-1 | N/A | N/A | Cellulose 538 (50) | 735 | 36 x 32 x 28 (900 x 810 x 730) | 66 (30) |
| | K1654-3 | | | High Efficiency Cellulose-Polyester 538 (50) | | | |
| Dual Arm | K1654-2 | | | Cellulose 538 (50) | | | |

Statiflex® 400-MS

Self-Cleaning Wall-Mounted System

- RotoPulse® automatic cleaning system simplifies filter maintenance
- Intended for facilities with fixed work stations and little available floor space
- Designed for light to medium fume extraction and filtration
- Generous airflow up to 735 CFM with LFA 3.1 or 4.1 extraction arms and SF2400 fan
- Large filter capacity at 323 ft² (30 m²)



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

MC13-96

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft ² (m ²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|-------------------|----------------|---------------------------------|------------------------------|---|--------------|---------------------------------|-----------------|
| Statiflex® 400-MS | K1742-1 | N/A | N/A | Cellulose 325 (30) | 735 | 45 x 28 x 26 (1140 x 720 x 660) | 88 (40) |
| | K1742-2 | | | High Efficiency Cellulose-Polyester 325 (30) | | | 97 (44) |

DownFlex® Tables

All in One Workbench and Extraction System

- DownFlex® 200-M and 400-MS/A models feature strong back and down draft extraction capacity, 3 stage spark arrestor and sizable 560 ft² (52 m²) of filter media
- The 100-NF model is designed for fabricators that prefer to add their own extraction system to the downdraft table



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Input⁽²⁾



Literature

MC13-38

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

⁽²⁾ 200-M and 400-MS/A only.

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | Filter Type/ Filter Size, ft ² (m ²) | Air Flow CFM | H x W x D in (mm) | Net Wt. lb (kg) |
|--------------------|----------------|---------------------------------|------------------------------|---|--------------|---|-----------------|
| DownFlex® 100-NF | K2751-1 | N/A | N/A | No Filtration | N/A | 58.9 x 53.8 x 35.9 (1496 x 1366 x 911) | 330 (150) |
| DownFlex® 200-M | K2751-2 | 208/230/460/3/60 | 11/10/5A | Cellulose-Polyester Fiber Filter 560 (52) | N/A | 60.8 x 54.3 x 39.4 (1544 x 1380 x 1005) | 540 (245) |
| DownFlex® 400-MS/A | K2751-3 | 208/230/460/3/60 | 11/10/5A | Cellulose-Polyester Fiber Filter 560 (52) | N/A | 36.2 x 54.3 x 39.4 (1544 x 1380 x 1005) | 562 (255) |

Fume Extraction Arms

Built with the Welder in Mind

- Ultra-light dent and scratch-resistant material
- 360 degree rotatable hood
- Advanced spring-balanced internal mechanism holds the position you set



Processes

- Stick
- TIG
- MIG
- Flux-Cored

Literature

MC13-173

| Product Name | Product Number | Use With | Arm Length ft (m) | CFM with SF 2400 Fan (with no filtration) | H x W in (mm) | Net Wt. lb (kg) |
|-------------------------------|----------------|-------------------------|---------------------------------|---|--------------------------------|-----------------|
| LFA 3.1 | K2633-1 | Mobiflex ⁽¹⁾ | 10 (3.1) | 760 | 8 x 118 (208 x 3000) | 33 (15) |
| | K1655-1 | Statiflex® | | | | |
| LFA 3.1 (w/Lamp & Arc sensor) | K2633-2 | Mobiflex ⁽¹⁾ | 10 (3.1) | 760 | 8 x 118 (208 x 3000) | 35 (16) |
| LFA 4.1 | K2633-3 | Mobiflex ⁽¹⁾ | 13 (4.1) | 760 | 8 x 157 (208 x 4000) | 37.5 (17) |
| | K1655-2 | Statiflex® | | | | |
| LFA 4.1 (w/Lamp & Arc sensor) | K2633-4 | Mobiflex ⁽¹⁾ | 13 (4.1) | 760 | 8 x 157 (208 x 4000) | 39.5 (18) |
| LFA 4.1-LC (Low Ceiling) | K1655-6 | Statiflex® | 13 (4.1) | 760 | 8 x 157 (208 x 4000) | 33 (15) |
| LFA 2.0 | K1655-5 | Statiflex® | 6.5 (2.0) | 760 | 8 x 85 (208 x 2160) | 33 (15) |
| LTA 2.0 | K1655-3 | Statiflex® | Retracts from 3.0-4.5 (1.0-1.5) | 780 | 8 x 39.5-55 (208 x 1000-1400) | 15.4 (7) |
| LTA 2.0-CW | K1655-7 | Statiflex® | Retracts from 5.0-8.2 (1.5-2.5) | 780 | 8 x 62-100.5 (208 x 1575-2553) | 59.5 (27) |

⁽¹⁾For use with K1653-(2,3) and K1741-(1,2) only. K2497-(2,4) base units use K1655-(1,2) extraction arms.

Modular Extraction Hood

Modular. Effective. Multi-Process.

- Engineered to contain and extract welding, cutting, arc gouging and grinding fume from the work environment
- Perimeter pull technology maximizes fume extraction effectiveness at lower airflow rates
- Modular aluminum construction enables easy assembly, cleaning and service



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Arc Gouging
- Grinding⁽¹⁾

Product Number

See page 211 for various sizes

Literature

MC12-05

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

| Product Name | Product Number/Sizes | Recommended Extraction Capacity | Recommended Air Velocity in Connected Duct |
|-------------------------|---|--|--|
| Modular Extraction Hood | See end of section for full list of product numbers and sizes | 290-474 CFM per square meter of hood (27-44 CFM per square foot of hood) | 3,000 ft/min |



Formed Extraction Hood

Your Fume Solution for Robotic Systems

- The ideal solution for welding fume extraction on robotic cells
- Designed and sized to fit Lincoln Electric pre-engineered robotic cells
- Incorporate a modular Statiflex® self-cleaning filter bank into the hood design for filtration of welding fume



Shown: System 20 with Fume Hood

Processes

- TIG
- MIG
- Flux-Cored
- Metal-Cored

Product Number

See Literature for various sizes

Literature

MC12-05

Statiflex® Filter Bank

High Efficiency Industrial Fume Extraction and Filtering

- Ideal for filtering fume and particulate generated by welding, cutting, arc gouging and grinding
- Multi-flow technology disperses incoming air evenly throughout the filter bank, resulting in longer filter life
- Self-cleaning pulse amplifier technology creates a uniform, high-energy pulse of compressed air to clean the filters
- Available in 2-48 filter versions



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Arc Gouging
- Grinding⁽¹⁾

Input



Product Number

See Literature for various sizes

Literature

MC12-05

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

| Product Name | Filter Type | Fan Sizes HP |
|---|----------------------------------|--------------|
| Statiflex® Filter Banks (2 to 48 cartridges) | MERV 16 or MERV 11 Rated Filters | 1.5-100 |

The Circulator®

Make a Cleaner Work Environment

- Free-standing general filtration system for weld fume control; ideal for manufacturing and fabrication facilities, and offers an economical alternative to a push/pull system
- Intended to supplement an existing source extraction system as well as natural draft/forced ventilation to reduce overall concentration of welding fume, dust and dirt in operator areas
- Green Drive™ control system reduces energy costs and increases filter life by continually monitoring operation and automatically adjusting airflow to maintain optimal performance levels



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Metal-Cored

Literature

MC11-37

Push/Pull Systems

Improve General Workplace Air Quality

- Remove fume and metal particulate layer from the air of your metalworking facility before it settles back to the floor
- Ideal for environments where workers are in spaces where effective source capture is difficult
- Effective when fabricating large weldments and when the welder needs to frequently change positions



Push/Pull System installed at Elgin Sweeper Company

Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Metal-Cored

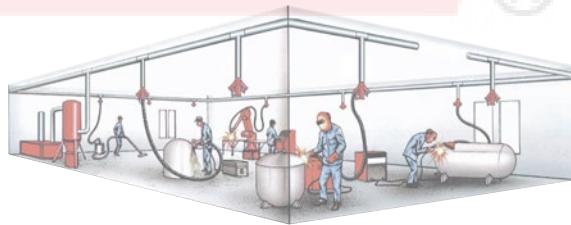
Literature

MC11-106

High Vacuum Central Systems

Compact Multi-Station Source Extraction

- A cost effective choice that uses a central turbine and filter to supply suction throughout the plant
- Uses smaller ductwork and less cubic feet per minute
- Header ducts are frequently one size throughout the entire system



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Literature

MC11-107

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

Low Vacuum Central Systems

Low Noise Multi-Station Source Extraction

- Low-vacuum, high-volume exhaust systems for source capture applications
- Ideal for addressing welding fume removal in educational environments and manufacturing plants that require multiple station drops
- Easy arm positioning, low noise levels
- Optional automatic On/Off control reduces energy costs



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Literature

MC11-107

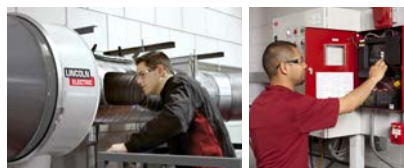
⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.



Guardian™ Fire Safety Solutions

Prevention, Detection, Suppression

- Prevent fire before it happens with a Spark Guardian™ spark arrestor and an Oil Guardian™ limestone feeder to keep spatter and dust from reaching the combustible filter or dustbin debris
- Detect fire early with the Guardian Control™ detection panel to reduce damage to your filter system if combustion occurs
- Suppress fire with a Flame Guardian™ aerosol generator inside the filter bank to quickly extinguish a fire



Processes

- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Grinding⁽¹⁾

Product Number

See page 211 for various sizes

Literature

MC12-20

⁽¹⁾ Not suitable for use when grinding Aluminum, Magnesium or other explosive materials.

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Miniflex®

Base Model (K3972-1, K3973-1)

- 9 ft. (2.7 m) cord (AWG 14) with 15 amp plug (NEMA 5-15)
- 8 ft. length x 1.75 in. O.D. (2.4 m x 44.5 mm) extraction hose
- LongLife-H main filter
- HEPA filter
- 2 spare sets of carbon brushes and seals for motors

X-Tractor® 1GC

Base Model (K652-1, K652-2)

- Hose-to-Hose Adapter, 1.75-2.0 in. (44.5-50.8 mm)
- Hose-to-Hose Adapter, 1.75-1.5 in. (44.5-38.1 mm)
- 16 ft. long x 1.75 in. diameter (5 m x 44.5 mm) flexible hose
- 2 spare sets of carbon brushes for motors
- Filter cartridge
- 12 ft. (3.6 m) power cord

Mobiflex® 100-NF

Required Accessories

- Hose and Hood Set, 16 ft. (4.9 m)
- Exhaust or Extension Hose Set, 16 ft. (4.9 m)

Base Model (K1666-1)

- Exhaust Fan Unit
- Carrying Handle
- Sturdy Base/Stand

Mobiflex® 200-M and Mobiflex® 400-MS

Required Accessories

- Extraction Arm
- Hose and Hood Kit

Base Model (200-M: K1653-2, K2497-2, K1653-3; 400-MS: K1741-1, K2497-4, K1741-2)

- Filter
- Plastic housing
- 8 in. (203 mm) Flexible Hose
- 19 ft. (6 m) 115 VAC Input Power Cord
- Transformer Relay Kit

X-Tractor® 3A, 5A and 8A

Base Model (3A: K3965-1, K3965-2; 5A: 3966-1, K3966-2; 8A: K3967-1, K3967-2)

- Filter Cartridge
- Automatic Filter Cleaning System
- Internal Compressed Air Regulator
- Automatic Operation Connection
- Starter/Overload Switch

Statiflex® 200-M Single Arm

Required Accessories

- Extraction Arm
- Stationary Fan
- Overload Switch or Lamp Kit with Sensor
- Wall Mounting Brackets

Base Model (K1654-1, K1654-3)

- Filter
- Filter Housing
- Hose
- 2 Hose Cleaners
- Rubber Seal
- Mounting Bracket

What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Statiflex® 200-M Dual Arm

Required Accessories

- Extraction Arm, Qty. 2
- Stationary Fan, Qty. 2
- Overload Switch or Lamp Kit with Sensor (Qty 2)
- Wall Mounting Brackets

Base Model (K1654-2)

- Filter
- Filter Housing
- 2 Hoses
- 4 Hose Clamps
- 2 Rubber Seals
- 2 Non-Return Valves
- 2 Reducers
- 2 Adapters
- Mounting Bracket

Statiflex® 400-MS Single Arm

Required Accessories

- Extraction Arm
- Stationary Fan
- Overload Switch or Lamp Kit with Sensor
- Wall Mounting Brackets

Base Model (K1742-1, K1742-2)

- Filter
- Filter Housing
- Particulate Collection Bin
- Pre-Filter Box
- 2 Hoses
- 4 Hose Clamps
- 2 Rubber Seals
- 2 Mounting Brackets
- Control Cable for Filter Cleaning

DownFlex® 100-NF, DownFlex® 200-M and DownFlex® 400-MS/A

Base Model (100-NF: K2751-1; 200-M: K2751-2; 400-MS/A: K2751-3)

- Sturdy Welding Table
- Backdraft Panel
- Side Panels
- Filters & Controls (not on 100-NF)

Statiflex® Filter Banks

Base Model

- Filter Bank
- Filters
- Fan
- Cleaning Controls
- Dust Drum



Accessories

| Product Name | Product No. | Miniflex® | | X-Tractor® 16C | | Mobiflex® 100-NF | | Mobiflex® 200-M | | Mobiflex® 400-MS | | X-Tractor® 3A | | X-Tractor® 5A | | X-Tractor® 8A | | |
|---|-------------|------------|------------|----------------|------------|------------------|------------|-----------------|------------|------------------|------------|---------------|------------|---------------|------------|---------------|------------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | K3972-1 | K3973-1 | K652-1 | K652-2 | K1666-1 | K1653-2 | K1653-3 | K2497-2 | K1741-1 | K1741-2 | K2497-4 | K3965-1 | K3965-2 | K3966-1 | K3966-2 | K3967-1 | K3967-2 |
| REQUIRED | | | | | | | | | | | | | | | | | | |
| Hose and Hood Set, 16 ft. (4.9 m) | K1668-1 | | | | | ● | | | | | | | | | | | | |
| Exhaust or Extension Hose Set, 16 ft. (4.9 m) | K1668-2 | | | | | ● | | | | | | | | | | | | |
| Hose and Hood Kit | K1668-3 | | | | | | ● | ● | ● | ● | ● | ● | | | | | | |
| LFA 3.1 10 ft. (3.0 m) Extraction Arm | K2633-1 | | | | | | ● | ● | | ● | ● | | | | | | | |
| LFA 4.1 13 ft. (4.0 m) Extraction Arm | K2633-3 | | | | | | ● | ● | | ● | ● | | | | | | | |
| LFA 3.1 10 ft. (3.0 m) Extraction Arm | K1655-1 | | | | | | | | ● | | | ● | | | | | | |
| LFA 4.1 13 ft. (4.0 m) Extraction Arm | K1655-2 | | | | | | | | ● | | | ● | | | | | | |
| GENERAL | | | | | | | | | | | | | | | | | | |
| EN 20 Nozzle | K2389-5 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| EN 40 Nozzle | K2389-6 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| SHM-300 Suction Head for Manual Welding, 12 in. (300 mm) | K639-1 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| SHM-400 Suction Head for Manual Welding, 16 in. (400 mm) | K639-2 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| SHM-500 Suction Head for Manual Welding, 20 in. (500 mm) | K639-3 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| SHMS Low Noise Suction Nozzle | K639-4 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| SHFA Flat Suction Head with Flexible Arm | K639-5 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| UNM Suction Head for Heavy Smoke | K639-6 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| NKT Nozzle Kit, 1 in. x 8 ft. Hose (25.4 mm x 2.4 m), 1.75 in. (44.5 mm) Hose Adapter | K2389-3 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| NKC Nozzle Kit, 1 in. x 8 ft. Hose (25.4 mm x 2.4 m), 1.75 in. (44.5 mm) Hose Adapter | K2389-4 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| Extraction Hose, 1.75 in. x 16 ft. (44.5 mm x 4.9 m) | K2389-8 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| Extraction Hose, 1.75 in. x 8 ft. (44.5 mm x 2.4 m) | K2389-9 | ● | ● | ● | ● | | | | | | | | ● | ● | ● | ● | ● | ● |
| Hose-to-Hose Adapter, 1.75 x 1.75 in. (44.5 x 44.5 mm) | K2389-10 | ● | ● | ● | ● | | | | | | | | | | | | | |
| Hose Connection Outlet | K2389-2 | ● | ● | | | | | | | | | | | | | | | |
| Activated Carbon Filter | K2389-1 | ● | ● | | | | | | | | | | | | | | | |
| Wall Mounting Bracket | K2389-7 | ● | ● | | | | | | | | | | | | | | | |
| Connection Kit, X-Tractor® 3A | K3968-1 | | | | | | | | | | | | ● | ● | | | | |
| Connection Kit, X-Tractor® 5A/8A | K3969-1 | | | | | | | | | | | | | | ● | ● | ● | ● |

● Required ● Optional

Accessories

| Product Name | Product No. | Miniflex® | | X-Tractor® 16C | | Mobiflex® 100-NF | | Mobiflex® 200-M | | Mobiflex® 400-MS | | X-Tractor® 3A | | X-Tractor® 5A | | X-Tractor® 8A | | |
|--|-------------|------------|------------|----------------|------------|------------------|------------|-----------------|------------|------------------|------------|---------------|------------|---------------|------------|---------------|------------|---------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | |
| | | K3972-1 | K3973-1 | K652-1 | K652-2 | K1666-1 | K1653-2 | K1653-3 | K2497-2 | K1741-1 | K1741-2 | K2497-4 | K3965-1 | K3965-2 | K3966-1 | K3966-2 | K3967-1 | K3967-2 |
| GENERAL, CON'T. | | | | | | | | | | | | | | | | | | |
| LongLife-H Filter | KP2390-1 | • | • | | | | | | | | | | | | | | | |
| HEPA Filter | KP2390-2 | • | • | | | | | | | | | | | | | | | |
| Pre-filter | KP2390-3 | • | • | | | | | | | | | | | | | | | |
| Gun Mounted Nozzle Kit (OT-25) | K639-20 | | | • | • | | | | | | | | • | • | • | • | • | • |
| Filter Cartridge for X-Tractor® | KP2069-1 | | | • | • | | | | | | | | • | • | | | | |
| LFA 3.1 10 ft. (3.0 m) Extraction Arm with Lamp/Arc Sensor | K2633-2 | | | | | | • | • | | • | • | | | | | | | |
| LFA 4.1 13 ft. (4.0 m) Extraction Arm with Lamp/Arc Sensor | K2633-4 | | | | | | • | • | | • | • | | | | | | | |
| Starter Overload Switch for 230V | K1494-3 | | | | | | • | • | • | • | • | • | | | | | | |
| Cellulose Filter | K1673-1 | | | | | | • | • | • | • | • | | | | | | | |
| High Efficiency Cellulose/Polyester Filter | K1673-3 | | | | | | • | • | • | • | • | | | | | | | |
| Activated Carbon Filter | K1852-1 | | | | | | • | • | • | • | • | | | | | | | |
| Cellulose Filter | K1673-2 | | | | | | | | | • | • | • | | | | | | |
| High Efficiency Cellulose/Polyester Filter | K1673-4 | | | | | | | | | • | • | • | | | | | | |
| Filter, X-Tractor® 5A, 3G, 4G | KP2061-1 | | | | | | | | | | | | | | • | • | | |
| Filter, X-Tractor® 8A | KP3984-1 | | | | | | | | | | | | | | | | • | • |

• Required • Optional

Accessories

| Product Name | Product No. | Statiflex® 200-M | | | Statiflex® 400-MS | | DownFlex® 100-NF | DownFlex® 200-M | DownFlex® 400-MS/A |
|--|-------------|------------------|------------|------------|-------------------|------------|------------------|-----------------|--------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| | | K1654-1 | K1654-2 | K1654-3 | K1742-1 | K1742-2 | K2751-1 | K2751-2 | K2751-3 |
| REQUIRED FOR STATIFLEX® 200-M SINGLE AND DUAL ARM AND STATIFLEX® 400-MS SINGLE ARM⁽¹⁾⁽²⁾ | | | | | | | | | |
| Extraction Arms [Category 2] | | | | | | | | | |
| LTA 2.0 Telescopic Extraction Arm | K1655-3 | • | • | • | • | • | | | |
| LFA 2.0 6.5 ft. (2.0 m) Extraction Arm | K1655-5 | • | • | • | • | • | | | |
| LFA 3.1 10 ft. (3.0 m) Extraction Arm | K1655-1 | • | • | • | • | • | | | |
| LFA 4.1 13 ft. (4.0 m) Extraction Arm | K1655-2 | • | • | • | • | • | | | |
| LFA 4.1-LC Low Ceiling 13 ft. (4.0 m) Extraction Arm | K1655-6 | • | • | • | • | • | | | |
| LTA 2.0-CW Telescopic Extration Arm | K1655-7 | • | • | • | • | • | | | |
| Standard System [Category 3A] – Requires fan, starting control and mounting brackets | | | | | | | | | |
| SF 2400 Stationary Fan (1 HP) | K1656-1 | • | • | • | • | • | | | |
| Starter Overload Switch for 115V | K1494-2 | • | • | • | • | • | | | |
| Starter Overload Switch for 230V | K1494-3 | • | • | • | • | • | | | |
| Lamp Kit with Arc Sensor for Wall Mounted Arms | K1669-4 | • | • | • | • | • | | | |
| SF 2400 Wall Mounting Bracket (use with LFA 3.1, 4.1 and 4.1-LC) | K1657-1 | • | • | • | • | • | | | |
| SF 2400 Wall Mounting Bracket (use with LTA 2.0 and LFA 2.0) | K1657-2 | • | • | • | • | • | | | |
| Extension Crane System [Category 3B] – Requires fan, starting control and extension crane | | | | | | | | | |
| SF 4200 Stationary Fan (2 HP) | K1656-4 | • | • | • | • | • | | | |
| Starter/Overload Switch for SF 4200 Fan | K1494-10 | • | • | • | • | • | | | |
| Lamp with Arc Sensor for SF 4200 Fan | K1669-10 | • | • | • | • | • | | | |
| EC 2 Extension Crane, 7 ft. (2.1 m) | K1671-1 | • | • | • | • | • | | | |
| EC 4 Extension Crane, 14 ft. (4.3 m) | K1671-2 | • | • | • | • | • | | | |
| Feeder Hanging Rail, 7 ft. (2.2 m) | K1672-1 | • | • | • | • | • | | | |

• Required • Optional

Statiflex 200-M Single and Dual Arm and Statiflex 400-MS Single Arm » ⁽¹⁾For a Single Arm Package, choose one item from Category 2, and one item each from Systems 3A or 3B. For a Dual Arm Package, choose two items from Category 2, and two items each from systems 3A or 3B.

Statiflex 400-MS Single Arm » ⁽²⁾Requires Lamp/Arc Sensor Kit to operate Statiflex 400-MS Self-Cleaning Controls.

Accessories

| Product Name | Product No. | Statiflex® 200-M | | | Statiflex® 400-MS | | DownFlex® 100-NF | DownFlex® 200-M | DownFlex® 400-MS/A |
|---|-------------|------------------|------------|------------|-------------------|------------|------------------|-----------------|--------------------|
| | | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model | Base Model |
| | | K1654-1 | K1654-2 | K1654-3 | K1742-1 | K1742-2 | K2751-1 | K2751-2 | K2751-3 |
| GENERAL | | | | | | | | | |
| 230V Conversion Kit for SF 2400 Fan | K1750-1 | • | • | • | • | • | | | |
| Cellulose Filter | K1673-1 | • | • | • | | | | | |
| High Efficiency Cellulose/Polyester Filter | K1673-3 | • | • | • | | | | | |
| Activated Carbon Filter | K1852-1 | • | • | • | | | | | |
| Air Exhaust Silencer | K1534-2 | • | • | • | • | • | | | |
| Non-Return Valve | K1743-2 | | • | | | | | | |
| Cellulose Filter | K1673-2 | | | | • | • | | | |
| High Efficiency Cellulose/Polyester Filter | K1673-4 | | | | • | • | | | |
| Central System Connection Kit | K2752-10 | | | | | | • | | |
| Dust Container | K2752-11 | | | | | | • | | |
| Pre-Spark Arrestors (qty. 2) | KP4052-1 | | | | | | | • | • |
| Spark Arrestors (qty. 2) | K2752-12 | | | | | | • | • | • |
| Plasma Cutting Work Grid (max. 50A) | K2752-2 | | | | | | • | • | • |
| Working Light Kit | K2752-3 | | | | | | • | • | • |
| Mounting Kit for Bench Vise | K2752-8 | | | | | | • | • | • |
| Current Activated Start/Stop Sensor (400-MS/A only) | K2752-4 | | | | | | | | • |
| Motion Activated Start/Stop Sensor (400-MS/A only) | K2752-5 | | | | | | | | • |
| Wheel Kit (max. load 330 lb./149.7 kg) | K2752-6 | | | | | | | • | • |
| Silencer/Outlet Duct | K2752-7 | | | | | | | • | • |
| Dust Tray Lid | K2752-9 | | | | | | | • | • |
| LongLife Filter | K2752-13 | | | | | | | • | • |
| HEPA Filter Kit | K2752-1 | | | | | | | • | • |
| HEPA Filter for K2752-1 | K2752-14 | | | | | | | • | • |

• Optional

Accessories

Modular Extraction Hood

| Hood Size, ft [m] | Product Number | Modular Extraction Hood Size, ft [m] | Product Number |
|---------------------------|----------------|--|----------------|
| 3.28 x 4.92 [1.0 x 1.5] | AD1234-80 | 13.12 x 8.20 [4.0 x 2.5] | AD1234-116 |
| 3.28 x 6.56 [1.0 x 2.0] | AD1234-81 | 13.12 x 9.84 [4.0 x 3.0] | AD1234-117 |
| 3.28 x 8.20 [1.0 x 2.5] | AD1234-82 | 13.12 x 11.48 [4.0 x 3.5] | AD1234-118 |
| 3.28 x 9.84 [1.0 x 3.0] | AD1234-83 | 13.12 x 13.12 [4.0 x 4.0] | AD1234-119 |
| 3.28 x 11.48 [1.0 x 3.5] | AD1234-84 | 13.12 x 14.76 [4.0 x 4.5] | AD1234-120 |
| 3.28 x 13.12 [1.0 x 4.0] | AD1234-85 | 13.12 x 16.40 [4.0 x 5.0] | AD1234-121 |
| 4.92 x 4.92 [1.5 x 1.5] | AD1234-86 | 13.12 x 18.04 [4.0 x 5.5] | AD1234-122 |
| 4.92 x 8.20 [1.5 x 2.5] | AD1234-87 | 14.76 x 8.20 [4.5 x 2.5] | AD1234-123 |
| 4.92 x 9.84 [1.5 x 3.0] | AD1234-88 | 14.76 x 14.76 [4.5 x 4.5] | AD1234-124 |
| 4.92 x 11.48 [1.5 x 3.5] | AD1234-89 | 16.40 x 8.20 [5.0 x 2.5] | AD1234-125 |
| 4.92 x 13.12 [1.5 x 4.0] | AD1234-90 | 16.40 x 9.84 [5.0 x 3.0] | AD1234-126 |
| 6.56 x 4.92 [2.0 x 1.5] | AD1234-91 | 16.40 x 14.76 [5.0 x 4.5] | AD1234-127 |
| 6.56 x 6.56 [2.0 x 2.0] | AD1234-92 | 16.40 x 16.40 [5.0 x 5.0] | AD1234-128 |
| 6.56 x 8.20 [2.0 x 2.5] | AD1234-93 | 18.04 x 8.20 [5.5 x 2.5] | AD1234-129 |
| 6.56 x 9.84 [2.0 x 3.0] | AD1234-94 | 18.04 x 9.84 [5.5 x 3.0] | AD1234-130 |
| 6.56 x 11.48 [2.0 x 3.5] | AD1234-95 | 18.04 x 11.48 [5.5 x 3.5] | AD1234-131 |
| 6.56 x 13.12 [2.0 x 4.0] | AD1234-96 | 18.04 x 14.76 [5.5 x 4.5] | AD1234-132 |
| 3.28 x 14.76 [1.0 x 4.5] | AD1234-98 | 18.04 x 16.40 [5.5 x 5.0] | AD1234-133 |
| 3.28 x 16.40 [1.0 x 5.0] | AD1234-99 | 18.04 x 18.04 [5.5 x 5.5] | AD1234-134 |
| 3.28 x 18.04 [1.0 x 5.5] | AD1234-100 | GENERAL | |
| 4.92 x 14.76 [1.5 x 4.5] | AD1234-101 | Light Kit | S28058-24 |
| 4.92 x 16.40 [1.5 x 5.0] | AD1234-102 | Leg, 6.56 ft (2.0 m) | S28058-25 |
| 4.92 x 18.04 [1.5 x 5.5] | AD1234-103 | Leg, 8.2 ft (2.5 m) | S28058-26 |
| 6.56 x 14.76 [2.0 x 4.5] | AD1234-104 | Leg, 9.84 ft (3.0 m) | S28058-27 |
| 6.56 x 16.40 [2.0 x 5.0] | AD1234-105 | Leg, 11.48 ft (3.5 m) | S28058-52 |
| 6.56 x 18.04 [2.0 x 5.5] | AD1234-106 | Leg Mounting Kit | S28058-28 |
| 8.20 x 8.20 [2.5 x 2.5] | AD1234-107 | Curtain Bracket Kit | S28058-22 |
| 9.84 x 8.20 [3.0 x 2.5] | AD1234-108 | Semi-transparent (red), Curtain Strip: 82 ft (25 m) Roll | S28058-53 |
| 9.84 x 9.84 [3.0 x 3.0] | AD1234-109 | Non-transparent (green), Curtain Strip: 82 ft (25 m) Roll | S28058-59 |
| 9.84 x 14.76 [3.0 x 4.5] | AD1234-110 | | |
| 11.48 x 8.20 [3.5 x 2.5] | AD1234-111 | | |
| 11.48 x 9.84 [3.5 x 3.0] | AD1234-112 | | |
| 11.48 x 11.48 [3.5 x 3.5] | AD1234-113 | | |
| 11.48 x 14.76 [3.5 x 4.5] | AD1234-114 | | |
| 11.48 x 16.40 [3.5 x 5.0] | AD1234-115 | | |

Guardian™ Fire Safety Solutions

| Product Name | Product Number |
|---|----------------|
| GENERAL | |
| Spark Guardian™ 10 | AD1387-4 |
| Spark Guardian™ 16 | AD1387-5 |
| Spark Guardian™ 20 | AD1387-6 |
| Oil Guardian™ 480/3/60 | AD1387-23 |
| Guardian™ Control | AD1387-29 |
| Aerosol Canisters, Flame Guardian™ 200 | AD1387-57 |
| Aerosol Canisters, Flame Guardian™ 500 | AD1387-58 |
| Smoke Detector T600 | S29287-55 |
| Smoke Detector T1500 | S29287-56 |
| Heat Detector Set | AD1387-25 |
| Spark Detector Set | AD1387-27 |
| Solenoid Valve | AD1387-54 |
| SLIDING VALVES | |
| Sliding Valve, 10 in (254 mm) | AD1387-49 |
| Sliding Valve, 12 in (305 mm) | AD1387-50 |
| Sliding Valve, 16 in (406 mm) | AD1387-51 |
| Sliding Valve, 20 in (508 mm) | AD1387-52 |
| Sliding Valve, 24 in (610 mm) | AD1387-53 |
| GENERATORS | |
| FS200 | AD1387-55 |
| FS500 | AD1387-56 |

• Optional



TRAINING SOLUTIONS

| MODEL | JOINT CONFIGURATIONS | | | | | POSITIONS | | | | | | STAND | PROCESS | | | | INPUT | | | | | | | |
|-----------------------------------|----------------------|---------|--------------|---------------------------------|-------------------------|-----------|----|----|----|----|----|-------|---------|----|----|--------------|----------|------|------|---------|---------|-------|---------|---------|
| | Flat Plate | T-Joint | Groove Joint | 6 in. Diameter Schedule 40 Pipe | 2 in. Diameter XXS Pipe | 1G | 2F | 2G | 3F | 3G | 4F | | 4G | 5G | 6G | All Position | Tabletop | SMAW | GMAW | FCAW-GS | FCAW-SS | Phase | Hertz | Voltage |
| Welding Education Trainers | | | | | | | | | | | | | | | | | | | | | | | | |
| VRTEX® Engage | • | • | • | | | • | • | • | | | | | | | | • | • | • | • | • | 1 | 50/60 | 115/230 | |
| VRTEX® Mobile | • | • | • | | | • | • | • | • | • | | | | | | • | • | • | • | • | 1 | 50/60 | 115/230 | |
| VRTEX® 360 | • | • | • | • | • | • | • | • | • | • | • | • | • | • | • | | • | • | • | • | • | 1 | 50/60 | 115/230 |
| REALWELD® | • | • | • | | | • | • | • | • | • | | | • | | | | • | • | • | • | • | 1 | 50/60 | 120/240 |

WELDING EQUIPMENT » Power Wave® 300 Ready-Pak® Package · Education Cell 2.0 · Welding Booth · Welding Gear

CUTTING EQUIPMENT » CNC Plasma Cutting 2x2 and 4x4 Tables

VRTEX® 360

Virtual Reality Arc Welding Trainer

- Full-featured and expandable, with Extensions™ updates for environments, joints, languages, instructor aids and more
- Supports many out-of-position welds, tee, flat plate, groove, 6 in. (152.4 mm) diameter schedule 40 pipe, 2 in. (50.8 mm) diameter XXS pipe and lap joint (with upgrade 5)
- Loaded with instructor and student aids, performance tracking of several technique parameters and USB port for remote grading, review and functionality
- Includes GMAW welding gun and retractable SMAW stinger devices



Processes Simulated

- SMAW: 6010, 6013 and 7018
- GMAW: Short Arc, Spray, Pulse & STT* (pipe only)
- FCAW: Gas-Shielded and Self-Shielded

One-Pak® Packages include VRTEX 360 system, upgrades 2, 3, 4, 5 curriculum, project-based lessons for student and instructor

Input



Literature

MC09-98

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | H x W x D in (mm) | Net Wt. lb (kg) |
|-----------------------------------|----------------|---------------------------------|------------------------------|---|-----------------------|
| VRTEX™ 360 Standard Frequency | AD2433-1 | 115/230/1/50/60 | 4A@115 2A@230 | Machine: 66 x 30 x 42 (1677 x 762 x 1067) | Machine: 315 (143) |
| Standard Frequency One-Pak® Pkg. | AD2434-1 | | | | |
| Alternate Frequency | AD2433-2 | | | | |
| Alternate Frequency One-Pak® Pkg. | AD2434-2 | | | | |

VRTEX® Mobile

Virtual Reality Arc Welding Trainer

- Basic to Intermediate Trainer
- Ideal for basic training, recruitment and engagement activities in education or industry
- Easily transported
- Supports tee, flat plate and groove joint welding
- Standard replay and demo modes



Processes Simulated

- GMAW: Short arc, spray and pulse
- FCAW: Gas-shielded and Self-shielded
- SMAW

Input



Literature

MC12-93

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Input Current @ Rated Output | H x W x D in (mm) | Net Wt. lb (kg) |
|---|----------------|---------------------------------|------------------------------|---|-----------------------------------|
| VRTEX™ Mobile Standard Frequency One-Pak® | AD2436-1 | 115/230/1/50/60 | 4A@115 2A@230 | Machine: 32.5 x 19.5 x 38.5 (826 x 496 x 978) | Machine & Stand: 125 (56.7) |
| Alternate Frequency One-Pak® | AD2436-2 | | | Coupon Stand w/Arm 17 x 12 x 14 (431 x 305 x 356) | Monitor: 20 (9.0) |
| | | | | Monitor: 14.4 x 15.4 x 8.0 (366 x 392 x 204) | Crate: 155 lbs (70.3 kg) |
| | | | | Crate: 42.5 x 24 x 48 (1080 x 610 x 1220) | |

REALWELD®

Weld Training Solution

- Provides real-world welding experience with immediate, objective and data-driven instant feedback
- The system scores the welding performance on critical welding motions for GMAW, SMAW and FCAW processes
- Clone the technique of a master welder and train others to achieve similar results
- Great for training and new hire screening
- Ideal for blended training using a mix of virtual training in the classroom and actual monitored welding in the booth



Shown:
AD2438-2 REALWELD One-Pak® Pkg.

Processes

- GMAW: Short arc, spray and pulse
- FCAW: Gas-shielded and Self-shielded
- SMAW

Input



Literature

MC15-99

| Product Name | Product Number | Input Power Voltage/Phase/Hertz | Operating System | Processor/Memory | Hard Drive | Ports (qty) – USB 2.0/Ethernet | H x W x D in (mm) | Net Wt. lb (kg) |
|----------------------|----------------|---------------------------------|---------------------|--------------------|------------------------|--------------------------------|--|------------------------|
| REALWELD® Base Model | AD2438-1 | 120/240/1/50/60 | Windows® 7 (32 bit) | Intel® Core i3/4GB | High performance 320GB | 3/1 | Lowered: 76.5 x 36 x 36 (1943 x 914 x 914) | Crate: 410 (186) |
| One-Pak® Pkg. | AD2438-2 | | | | | | Raised: 100 x 36 x 36 (2540 x 914 x 914) | 548 (250.6) |

VRTEX® Extensions, Lessons and Curriculum

Expand Your Training Program

- Periodic VRTEX® 360 Extensions™ upgrades add functionality, welding base materials, joints and instructor capabilities
- Project-Based Lessons documents, including instructor keys, are designed to education common core standards and American Welding Society SENSE standards
- Curriculum provide best practices for blending traditional and virtual welding, classroom videos and more



Processes

- Stick
- MIG
- Flux-Cored

Product Number

K3205-1
K3206-1
K4057-1
K4057-2
K4058-1

Literature

lincolnelectric.com

Power Wave® C300 Education Ready-Pak® Package

Multi-Process Student-Ready Welding Package

- Includes everything you need to get started to teach wire, TIG and stick welding
- Power Wave® C300 features an internal wire feeder and an output range of 5-300 amps
- Efficient, power saving inverter platform
- CheckPoint™ monitoring tool allows instructors to analyze weld data
- PowerConnect™ Technology automatically adjusts to 200-600V, 50 or 60 Hz input power



Processes

- Stick
- DC TIG
- Pulsed DC TIG
- MIG
- Pulsed MIG
- Flux-Cored

Output



Input



Literature

E5.100

| Product Name | Product Number | Input Power Voltage/Phase/Hz | Rated Output: Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|--|--|--|--|------------------------------------|-----------------|
| Power Wave® C300⁶⁰ Educational Ready-Pak® Pkg. | K2774-4 | 3-Ph 50/60: 208/220-230/380-415/ 460/575 1-Ph 50/60: 208/220-230 | 300A/29V/40% 250/27V/100% | 3-Ph/40% Duty Cycle: 30/28/16/14/11A 1-Ph/40% Duty Cycle: 53/48/29A | 5-300A DC WFS: 50-700 ipm (1.27-17.8 m/min) | 33 x 20 x 42 (838 x 508 x 1067) | 180 (81.6) |

Robotic Education Cell 2.0

Advancing the Skills of the Next Generation

- Teaching robotics, crucial to the global competitiveness of many employers, can accelerate student skills and employment rates
- Demonstrate and teach real-life industrial robotic concepts, programming and welding
- Ideal for advanced manufacturing welding lab and classrooms, recruitment, trade schools, workforce development
- Designed to fit through a standard doorway, but with expanding work surfaces
- Includes robot, welding equipment, integrated safety, teach pendant, software and more



Processes

- GMAW
- Pulsed GMAW
- Flux-Cored

Input



Literature

E10.122

| Product Name | Product Number | Work Surface Area, ft ² (m ²) | Input Power | H x W x D in (mm) | Net Wt. lb (kg) |
|--|----------------|--|--|---|-----------------|
| Robotic Welding & Programming Training Package | AD2437-1 | 13.89 (1.29) | 230V Standard/Welding Voltage 120V Optional/Robot Operation and Programming | Sides Expanded: 81.23 x 64.82 x 66 (2057 x 1651 x 1676) | 870 (304) |
| Classroom Ready w/CERT and 120V Option | AD2437-2 | | | Sides Folded: 81.23 x 64.82 x 32 (2057 x 1651 x 813) | |
| Classroom Ready and Vision Enabled w/CERT, 120V Option and Vision Enabled | AD2437-3 | | | | |

Welding Booth

Complete Training or Production Environment

- Ideal for career centers, community colleges, union or industry training centers or stationary production welding applications
- Configurable with lighting, shelving, brackets, hooks, air and shielding gas connections
- Weld fume source extraction can be added to the booth and connected to a central system
- Rugged steel construction stands up to the demands of a training or production environment



Processes

- (Dependent on welding power source)
- Stick
- TIG
- MIG
- Flux-Cored
- Plasma Cutting
- Oxyfuel Cutting

Literature

MC10-87

Plasma Cutting 2x2 and 4x4 Educational Packages

Add CNC Cutting to Your Program

- Ideal 2-D cutting platform for schools, colleges and training centers
- Unlimited Software Licensing for students and one Master Teacher license
- Receive a fully assembled table with base and slate - Just connect air and water
- Torchmate® Visual Machine Designer™ software makes it easy to understand nesting, scanning, tool path concepts and more



Processes

- Plasma Cutting

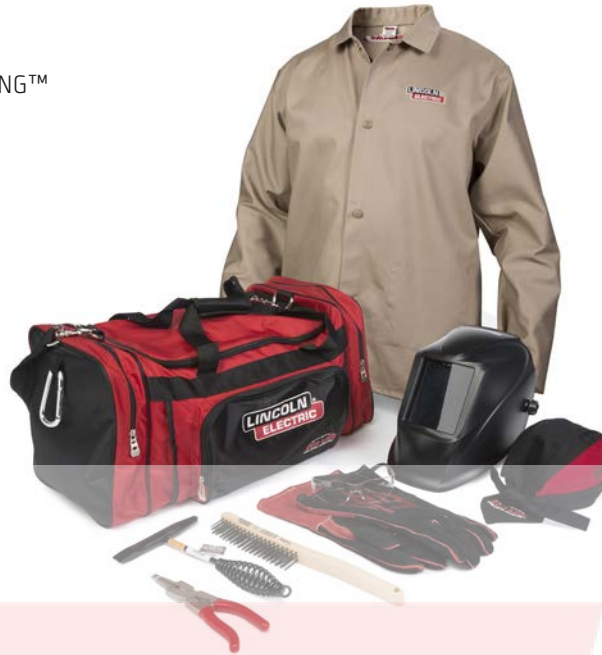
Literature

torchmate.com

Standard Welding Gear Ready-Pak®

Start Your Career Off Right

- Features Traditional FR Cloth Jacket and VIKING™ 1840 Black Helmet
- Long lasting quality
- Comfortable and stylish



Order Number

- K4416-M
- K4416-L
- K4416-XL
- K4416-2XL
- K4416-3XL
- K3096-1
- Replacement Lincoln®
- Industrial Duffel Bag

Literature

- E14.743

BOLTS AND TOOLS



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

VRTEX® 360

System Includes

- Mobile Virtual Welding Machine
- Welding Stand
- Welding Helmet
- GMAW Gun
- Retractable Stinger
- Coupons
 - Flat Plate
 - Tee Joint
 - Groove Joint
- 2 in. (50.8 mm) diameter XXS Pipe
- 6 in. (152.4 mm) diameter Sch 40 Pipe

One-Pak® Packages include

- VRTEX 360 system
- Upgrades 2, 3, 4, 5
- Curriculum
- Project-based lessons for student and instructor

VRTEX® Mobile

System Includes

- Mobile Virtual Welding Machine
- Tabletop Stand
- Welding Helmet
- GMAW Gun
- Retractable SMAW Stinger Device
- Coupons
 - Flat plate
 - Tee Joint
 - Groove Joint

REALWELD® One-Pak®

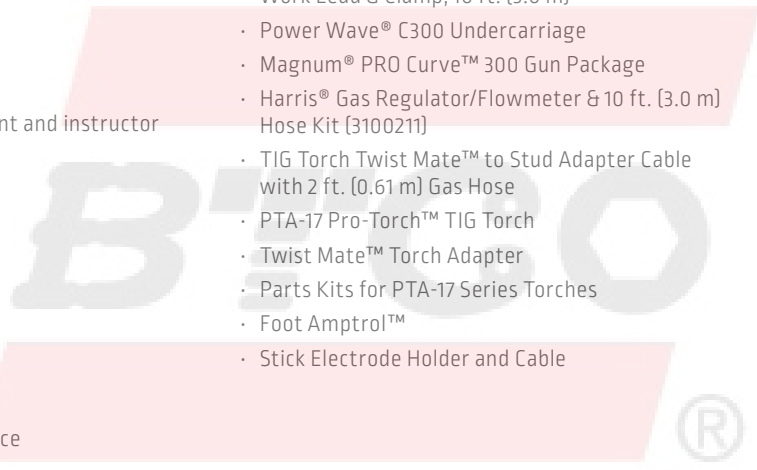
System Includes

- Power Wave C300 welding power source (K2675-2)
- Cart (K2734-2)
- Miniflex® fume extraction system (K2376-1)
- Nozzle (K2389-5),
- 6 in. (152 mm) weld jigs

Power Wave® C300

Educational Ready-Pak® Package (K2774-4)

- Drive Roll Kit, 0.035/0.045 in. (0.9/1.2 mm)
- Input Cord, 10 ft. (3.0 m)
- Work Lead & Clamp, 10 ft. (3.0 m)
- Power Wave® C300 Undercarriage
- Magnum® PRO Curve™ 300 Gun Package
- Harris® Gas Regulator/Flowmeter & 10 ft. (3.0 m) Hose Kit (3100211)
- TIG Torch Twist Mate™ to Stud Adapter Cable with 2 ft. (0.61 m) Gas Hose
- PTA-17 Pro-Torch™ TIG Torch
- Twist Mate™ Torch Adapter
- Parts Kits for PTA-17 Series Torches
- Foot Amptrol™
- Stick Electrode Holder and Cable



What's Included

Base Model/Unit Includes » Some base models include a set of specific standard accessories

One-Pak® Packages » Assembly required

Ready-Pak® Packages » Fully assembled

Robotic Education Cell 2.0

System Includes

- Power Wave® R350
- Power Wave® Software Capability
 - Production Monitoring
 - CheckPoint™
- AutoDrive® 4R100 Wire Drive
- Magnum® PRO robotic welding torch and consumables
- SuperArc® L-56® GMAW welding wire
- FANUC® Robotics ARC Mate® 50iC/5L Robot Arm
- FANUC® Robotics R-30iA Mate Controller
- FANUC® Robotics LR ArcTool® Software
- R-30iA Teach Pendant

All packages include above and:

AD2437-1 Robotic Education Cell, Gen 2.0, Basic

- Robotic 3-in-1 welding fixture
- Education Cell Project Based Lessons - Book 1
- Education Cell Project Based Lessons - Book 2
- Miniflex Fume Extraction
- Lettering Program (preset program creating letters)

AD2437-2 Robotic Education Cell, Gen 2.0, w/Cert & 120V

- Robotic 3-in-1 welding fixture
- Education Cell Project Based Lessons - Book 1
- Education Cell Project Based Lessons - Book 2
- Miniflex Fume Extraction
- Lettering Program (preset program creating letters)
- 120V option
- Cert training program, 25 seat Weldpro
- Additional Instructor Cert training program

AD2437-3 Robotic Education Cell, Gen 2.0, w/Cert, 120V, IR Vision

- Robotic 3-in-1 welding fixture
- Education Cell Project Based Lessons - Book 1
- Education Cell Project Based Lessons - Book 2
- Miniflex Fume Extraction
- Lettering Program (preset program creating letters)
- 120V option
- Cert training program, 25 seat Weldpro
- Additional Instructor Cert training program
- IRVision

Plasma Cutting 2x2 and 4x4

Educational Packages

Torchmate® 2x2 CNC Educational System

- 2x2 Portable CNC Table
- Waterbed Table
- True Arc Voltage Height Control
- USB Electronics Box (cabling included)
- Torchmate® Visual Machine Designer™ Software

Torchmate® 4x4 CNC Educational System

System Includes

- 4x4 Portable CNC Table
- Waterbed Table
- True Arc Voltage Height Control
- USB Electronics Box (cabling included)
- Torchmate® Visual Machine Designer™ Software

Standard Welding Gear Ready-Pak®

Includes

- Lincoln® Industrial Duffle Bag
- Industrial Passive Welding Helmet
- Traditional Khaki FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Lincoln® Startlite® Clear Safety Glasses
- FR Doo Rag
- Spring Handle Chipping Hammer
- Radius™ Welding Pliers
- Radius 3 x19 Carbon Steel Wire Brush

Tel: (+974) 443 54 298
www.boltsandtools.com

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www.boltsandtools.com

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www.boltsandtools.com



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www.boltsandtools.com

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Accessories

Feed Plate Gun Adapters

| FEED PLATE GUN ADAPTERS | | | | | |
|---|---|---|---|---|---|
| K1500-1 | K1500-2 | K1500-3 | K1500-4 | K1500-5 | Magnum® PRO Fast-Mate™ |
| Lincoln Electric | Tweco® #2 - #4 | Tweco® #5 | Miller® guns | OXO® guns | Compatible Gun Connector Kits K489-1 K489-2 K489-7 K489-8 |
| Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8 | Compatible Gun Connector Kits K466-10 K466-2 K466-6 | Compatible Gun Connector Kits K613-7 K613-2 | Compatible Gun Connector Kits K466-3 K613-3 | | |
|  |  |  |  |  |  |

| FEED PLATE GUN ADAPTERS | | | | | |
|---|---|---|---|---|---|
| K3344-1 | K3345-1 | K3346-1 | K3347-1 | K3348-1 | K3349-1 |
| Lincoln Electric | Tweco® #2 - #4 | Tweco® #5 | Miller® guns | OXO® guns | Magnum® Fast-Mate™ |
| Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8 | Compatible Gun Connector Kits K466-10 K466-2 K466-6 | Compatible Gun Connector Kits K613-7 K613-2 | Compatible Gun Connector Kits K466-3 K613-3 | | Single and dual procedure guns |
|  |  |  |  |  |  |

Weld Power Cables

| Product Name | Product Number | Description | Connection | Length ft (m) |
|-------------------|-------------------------|---|----------------------------|---------------|
| Weld Power Cables | K1840-10 | Weld Power Cable, 1/0, 350A, 60% duty cycle | Twist Mate™ to Lug | 10 (3.1) |
| | K1842-10 | Weld Power Cable, 3/0, 600A, 60% duty cycle | Lug to Lug | 10 (3.1) |
| | K1842-35 | | | 35 (10.7) |
| | K1842-60 | | | 60 (18.3) |
| | K1842-110 | Weld Power Cable, 4/0, 600A, 60% duty cycle | | 110 (33.5) |
| | K1841-25 | Weld Power Cable, 1/0, 350A, 60% duty cycle | Twist Mate™ to Twist Mate™ | 25 (7.6) |
| | K1841-50 | Weld Power Cable, 2/0, 350A, 60% duty cycle | | 50 (15.2) |
| | K2163-35 ⁽¹⁾ | Weld Power Cable, 4/0 | Lug to Lug | 35 (10.7) |
| | K2163-60 ⁽¹⁾ | | | 60 (18.3) |
| | K1796-25 | Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle | Lug to Lug | 25 (7.6) |
| | K1796-50 | | | 50 (15.2) |
| | K1796-75 | Coaxial Weld Power Cable, 1/0, 325A, 60% duty cycle | | 75 (22.8) |
| | K1796-100 | Coaxial Weld Power Cable, 1/0, 300A, 60% duty cycle | | 100 (30.4) |
| | K2593-100 | Coaxial Weld Power Cable, #1, 250A, 100% duty cycle | Lug to Lug | 100 (30.4) |

Feed Plate Gun Adapters » Tweco® is a registered trademark of Victor Technologies. Miller® and OXO® is a registered trademark of Miller Electric Mfg. Co.
Weld Power Cables » ⁽¹⁾Two cables per package.

Accessories

Control Cables and Adapters

| Product Name | Product Number | Description | Connection | Use | Length ft (m) | | | |
|--|----------------|---|---|--|---|-----------|--|------------|
| Wire Feeder Control Cables | K1501-10 | Wire Feeder Control Cable | Male 14-pin to Female 9-pin | LN-10, DH-10 | 10 (3.1) | | | |
| | K1818-10 | | Female 6-pin to Male 14-pin | LN-7 | 10 (3.1) | | | |
| | K1819-10 | | Female 8-pin to Male 14-pin | LN-742, LN-25 | 10 (3.1) | | | |
| | K1820-10 | | Female 9-pin to Male 14-pin | LN-8, LN-9, NA-3, NA-4, NA-5 | 10 (3.1) | | | |
| | K1822-25 | | — | LT-7 | 25 (7.6) | | | |
| | K2393-1 | | Male 14-pin to Female 8-pin | LN-23P (K316L-2) | 25 (7.6) | | | |
| | K2393-2 | | | | | 75 (22.8) | | |
| Extensions and Adapters | K1797-10 | Wire Feeder Control Cable Extension | Male 14-pin to Female 14-pin | May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder. | 10 (3.1) | | | |
| | K1797-25 | | | | 25 (7.6) | | | |
| | K1797-50 | | | | 50 (15.2) | | | |
| | K1797-100 | | | | 100 (30.4) | | | |
| | K1798 | Adapter Cable for Control Cable to Terminal Strip of Power Source | Female 14-pin Control Cable to Terminal Strip | — | — | | | |
| ArcLink®/Linc-Net™ Control Cables | K1543-8 | ArcLink®/Linc-Net™ Control Cable | Male 5-pin to Female 5-pin | For Power Wave®/ Power Feed® Systems | 8 (2.4) | | | |
| | K1543-16 | | | | 16 (4.9) | | | |
| | K1543-25 | | | | 25 (7.6) | | | |
| | K1543-50 | | | | 50 (15.2) | | | |
| | K1543-100 | | | | 100 (30.4) | | | |
| | K2683-25 | | | | Heavy Duty ArcLink®/Linc-Net™ Control Cable | | | 25 (7.6) |
| | K2683-50 | | | | | | | 50 (15.2) |
| | K2683-100 | | | | | | | 100 (30.4) |
| Submerged Arc/Automation | K1785-2 | Heavy Duty Control Cable | 14-pin | For synchronizing Power Wave® AC/DC 1000® SD units and connecting MAXsa™ Feed Heads and MAXsa™ Controllers. For use with FANUC® arms having integrated cable. For connecting Control Unit to Wire Drive in LN-10, DH-10 Boom applications. | 1.5 (0.46) | | | |
| | K1785-4 | | | | 4 (1.2) | | | |
| | K1785-8 | | | | 8 (2.4) | | | |
| | K1785-12 | | | | 12 (3.6) | | | |
| | K1785-16 | | | | 16 (4.9) | | | |
| | K1785-25 | | | | 25 (7.6) | | | |
| | K1785-50 | | | | 50 (15.2) | | | |
| | K1785-100 | 100 (30.4) | | | | | | |
| | K2709-25 | Wire Drive Control Cable | Male 14-pin to Female 14-pin | For external dress of FANUC® robotic arm or hard automation. | 25 (7.6) | | | |
| | K2709-50 | | | | 50 (15.2) | | | |
| | K2709-100 | | | | 100 (30.4) | | | |

Accessories » Drive Roll and Wire Guide Kits

| Product Name | Product Number | Description/Wire Size, in (mm) | Wire Feeders |
|--|----------------|--------------------------------|--|
| 2-ROLL WIRE DRIVE SYSTEMS | | | |
| Solid Wire (includes stainless steel) | KP1696-030S | 0.023-0.030 [0.6-0.8] | Activ8™ |
| | KP1696-035S | 0.035 [0.9] | LF-72 |
| | KP1696-1 | 0.035, 0.045 [0.9, 1.2] | LN-25 PRO |
| | KP1696-2 | 0.040 [1.0] | LN-25 PRO Dual Power |
| | KP1696-045S | 0.045 [1.2] | Power Feed® 25M |
| | KP1696-052S | 0.052 [1.4] | POWER MIG® 216 |
| | KP1696-1/16S | 1/16 [1.6] | POWER MIG® 216 |
| Cored Wire | KP1697-035C | 0.030-0.035 [0.8-0.9] | POWER MIG® 256 |
| | KP1697-045C | 0.040-0.045 [1.0-1.2] | POWER MIG® 350MP |
| | KP1697-052C | 0.052 [1.4] | |
| | KP1697-1/16C | 1/16 [1.6] | |
| | KP1697-068 | 0.068-0.072 [1.7-1.8] | |
| | KP1697-5/64 | 5/64 [2.0] | |
| Aluminum Wire | KP1695-035A | 0.035 [0.9] | |
| | KP1695-040A | 0.040 [1.0] | |
| | KP1695-3/64A | 3/64 [1.2] | |
| | KP1695-1/16A | 1/16 [1.6] | |
| Solid Wire | KP2529-1 | 0.025/0.030 [0.6/0.8] | POWER MIG® 140C |
| | KP2529-2 | 0.035 [0.9] | POWER MIG® 180C |
| Cored Wire | KP2529-3 | 0.030/0.045 [0.8/1.2] | POWER MIG® 180 Dual POWER MIG® 210 MP |

| Product Name | Product Number | Description/Wire Size, in (mm) | Wire Feeders |
|----------------------------------|----------------|--------------------------------|---------------|
| 4-ROLL WIRE DRIVE SYSTEMS | | | |
| Solid Wire | KP4335-035S | 0.035 [0.9] | AutoDrive® S |
| | KP4335-040S | 0.040 [1.0] | |
| | KP4335-045S | 0.045 [1.2] | |
| | KP4335-052S | 0.052 [1.4] | |
| Aluminum Wire | KP4335-035A | 0.035 [0.9] | AutoDrive® SA |
| | KP4335-3/64A | 3/64 [1.2] | |
| | KP4335-1/16A | 1/16 [1.6] | |
| Aluminum Wire | KP4414-035A | 0.035 [0.9] | AutoDrive® SA |
| | KP4414-3/64A | 3/64 [1.2] | |
| | KP4414-1/16A | 1/16 [1.6] | |

| Product Name | Product Number | Description/Wire Size, in (mm) | Wire Feeders |
|--|--------------------------------|--------------------------------|-----------------------|
| 4-ROLL WIRE DRIVE SYSTEMS | | | |
| Solid Wire, Smooth V Groove | KP1505-030S | 0.023-0.030 [0.6-0.8] | AutoDrive® 4R100 |
| | KP1505-035S | 0.035 [0.9] | AutoDrive® 4R200 |
| | KP1505-040S | 0.040 [1.0] | DH-10 |
| | KP1505-045S | 0.045 [1.2] | FlexFeed™ 74 HT |
| | KP1505-052S | 0.052 [1.4] | FlexFeed™ 84 Single |
| | KP1505-1/16S | 1/16 [1.6] | FlexFeed™ 84 Dual |
| | KP1505-1 | 0.035, 0.045 [0.9, 1.2] | LF-74 |
| Cored Steel Wire, Knurled V Groove (Knurled V Groove with matching Smooth U Groove) | KP1505-2 | 0.040 [1.0] | LN-10 |
| | KP1505-035C | 0.030-0.035 [0.8-0.9] | Power Feed® 10M |
| | KP1505-045C | 0.040-0.045 [1.0-1.2] | Power Feed® 10M Dual |
| | KP1505-052C ⁽³⁾ | 0.052 [1.4] | Power Feed® 10R |
| | KP1505-1/16C ⁽³⁾ | 1/16 [1.6] | Power Feed® 84 Single |
| Cored or Solid Steel Wire, Knurled V Groove | KP1505-7/64H ⁽²⁾⁽³⁾ | 7/64 [2.8] Hardfacing | Power Feed® 84 Single |
| | KP1505-035C | 0.030-0.035 [0.8-0.9] | Power Feed® 84 Dual |
| | KP1505-045C | 0.040-0.045 [1.0-1.2] | |
| | KP1505-052C ⁽³⁾ | 0.052 [1.4] | |
| | KP1505-1/16C ⁽³⁾ | 1/16 [1.6] | |
| | KP1505-068 ⁽³⁾ | 0.068-0.072 [1.7-1.8] | |
| | KP1505-5/64 ⁽³⁾ | 5/64 [2.0] | |
| | KP1505-3/32 ⁽³⁾ | 3/32 [2.4] | |
| | KP1505-7/64 ⁽²⁾⁽³⁾ | 7/64 [2.8] | |
| | KP1505-.120 ⁽²⁾⁽³⁾ | 0.120 [3.2] | |
| Hardfacing Wires, Knurled, Smooth V Groove | KP1505-7/64C | 7/64 [2.8] | |
| | KP1505-7/64H ⁽²⁾⁽³⁾ | 7/64 [2.8] Hardfacing | |
| Aluminum Wire, Smooth U Groove | KP1507-035A | 0.035 [0.9] | AutoDrive® S |
| | KP1507-040A | 0.040 [1.0] | |
| | KP1507-3/64A | 3/64 [1.2] | |
| | KP1507-1/16A ⁽³⁾ | 1/16 [1.6] | |
| | KP1507-3/32A ⁽³⁾ | 3/32 [2.4] | |

⁽¹⁾Not for use with the LF-72. ⁽²⁾Not for use with the LF-74. ⁽³⁾Not for use with the AutoDrive 4R100.





Accessories » Drive Roll and Guide Tube Kits

| Product Name | Product Number | Description/Wire Size, in (mm) | Wire Feeders |
|----------------------------------|----------------------------|-----------------------------------|--------------|
| 2-ROLL WIRE DRIVE SYSTEMS | | | |
| Solid Wire | KP653-025S | 0.023-0.025 [0.6-0.6] | LN-7 GMA |
| | KP653-030S | 0.030 [0.8] | LN-23P |
| | KP653-035S | 0.035-0.040 [0.9-1.0] | LN-25 |
| | KP653-052S | 0.045-0.052 [1.2-1.4] | |
| Cored Wire | KP653-035C | 0.035 [0.9] | LN-25 |
| | KP653-052C | 0.045-0.052 [1.2-1.4] | |
| Solid or Cored Wire | KP653-1/16 | 1/16 [1.6] | LN-25 |
| | KP653-3/32 ⁽²⁾ | 0.068-3/32 [1.7-2.4] | |
| Hardfacing | KP653-7/64H ⁽¹⁾ | 7/64 [2.8] | LN-25 |
| Aluminum Wire | KP654-035A | 0.035 [0.9] | LN-25 |
| | KP654-3/64A | 3/64 [1.2] | |
| | KP654-1/16 | 1/16 [1.6] | |
| Solid Wire | KP502-052 | 0.040, 0.045-0.052 [1.0, 1.2-1.4] | LN-8 |
| | KP502-1/16 | 1/16 [1.6] | LN-9 |
| Cored Wire | KP502-052C | 0.045-0.052 [1.0-1.4] | LN-9 |
| | KP502-1/16C | 1/16-0.062 [1.6-1.6] | |
| | KP502-120 | 7/64-0.120 [2.8-3.0] | |
| Solid or Cored Wire | KP502-3/32 | 0.068-3/32 [1.7-2.4] | LN-9 |
| Hardfacing | KP502-7/64H | 7/64 [2.8] | LN-9 |

| Product Name | Product Number | Description/Wire Size, in (mm) | Wire Feeders |
|----------------------------------|----------------|-------------------------------------|--------------|
| 2-ROLL WIRE DRIVE SYSTEMS | | | |
| Solid Wire Drive Roll | KP1899-1 | 3/32-7/32 [2.4-5.6] | NA-3S |
| | KP1899-2 | 1/16, 5/64, 3/32 [1.6, 2.0, 2.4] | NA-4 |
| | KP1899-3 | 0.035, 0.045, 0.052 [0.9, 1.2, 1.4] | NA-5 |
| Cored Wire Drive Roll | KP1899-4 | 0.045-0.052 [1.0-1.4] | NA-5 |
| Knurled Drive Roll | KP1885-1 | 3/32-7/32 [2.4-5.6] | NA-5 |
| | KP1886-1 | 1/16-3/32 [1.6-2.4] | |
| Outgoing Guide | KP1963-1 | 3/32-7/32 [2.4-5.6] | NA-5 |
| Incoming Guide | KP2116-2 | 3/32-7/32 [2.4-5.6] | NA-5 |

⁽¹⁾Not for use with the LN-25 PRO and LN-25 PRO Dual Power. ⁽²⁾For LN-7 only.

Welding Safety Checklist

| Hazard | Factors To Consider | Precaution Summary |
|--|--|---|
| Electric Shock Can Kill  | <ul style="list-style-type: none"> Wetness Welder in or on workpiece Electrode holder and cable insulation | <ul style="list-style-type: none"> Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood. Wear dry, hole-free gloves. (Change as necessary to keep dry.) Do not touch electrically "hot" parts or electrode with bare skin or wet clothing If wet area and welder cannot be insulated from workpiece with dry insulation, use a semiautomatic, constant-voltage welder or stick welder with voltage reducing device. Keep electrode holder and cable insulation in good condition. Do not use if insulation damaged or missing. |
| Fumes and Gases Can Be Dangerous  | <ul style="list-style-type: none"> Confined area Positioning of welder's head Lack of General ventilation Electrode types (i.e.: manganese, chromium, etc. (See MSDS)) | <ul style="list-style-type: none"> Use ventilation or exhaust to keep air breathing zone clear, comfortable. Use helmet and positioning of head to minimize fume in breathing zone. Read warnings on electrode container and Material Safety Data Sheet (MSDS) for electrode Provide additional ventilation/exhaust where special ventilation requirements exist. Use special care when welding in a confined area. Do not weld unless ventilation is adequate. |
| Welding Sparks Can Cause Fire or Explosion  | <ul style="list-style-type: none"> Containers which have held combustibles Flammable materials | <ul style="list-style-type: none"> Do not weld on containers which have held combustible materials (unless strict AWS F4.1 procedures are followed). Check before welding. Remove flammable materials from welding area or shield from sparks, heat. Keep a fire watch in area during and after welding. Wear fire retardant clothing and hat. Use earplugs when welding overhead. |
| Arc Rays Can Burn Eyes and Skin  | <ul style="list-style-type: none"> Process: Gas-shielded arc most severe | <ul style="list-style-type: none"> Select a filter lens which is comfortable for you while welding. Always use helmet when welding. Provide non-flammable shielding to protect others. Wear clothing which protects skin while welding. |

Arc Welding Fumes and Gases

The **fume plume** contains solid particles from the consumables, base metal, and base metal coating. For common mild steel arc welding, depending on the amount and length of exposure to these fumes, most immediate or short term effects are temporary, and include symptoms of burning eyes and skin, dizziness, nausea, and fever. Long-term exposure to welding fumes can lead to siderosis (iron deposits in the lungs) and may affect pulmonary function. Bronchitis and some lung fibrosis have been reported.

Some compounds which may be in welding fume, and reported health effects of overexposure are below. See the MSDS for the consumable product used for specific information.

- Barium** may cause severe stomach pain, slow pulse rate; irregular heartbeat, ringing of the ears, convulsion and muscle spasms. In extreme cases can cause death.
- Cadmium** fumes can be fatal even under brief overexposures, with symptoms much like metal fume fever.
- Chromium** and its compounds are on the IARC (International Agency for Research on Cancer) and NTP (National Toxicology Program) lists as posing a cancer risk to humans. Some forms of these metals are known or suspected to cause lung cancer in processes other than welding and asthma has been reported.
- Manganese:** Manganese overexposure may affect the central nervous system, resulting in poor coordination, difficulty in speaking, and tremor of arms or legs. This condition is considered irreversible.
- Nickel:** Nickel and its compounds are on the IARC (International Agency for Research on Cancer) and NTP (National Toxicology Program) lists as posing a cancer risk to humans.
- Silica:** Overexposure can cause severe lung damage (silicosis). Crystalline silica is present in submerged arc flux.
- Zinc:** Overexposure to zinc may cause metal fume fever with symptoms similar to the common flu.

Your work area has adequate ventilation when there is enough ventilation and/or exhaust to control worker exposure to hazardous materials in the welding fumes and gases so the applicable limits for those materials is not exceeded. See the MSDS for the legal limits, the OSHA PEL (Permissible Exposure Limit), and the recommended guideline, the ACGIH TLV (Threshold Limit Value). Confirm that if the worker exposure does not exceed the applicable exposure limit for compounds in the fumes and gases by having an industrial hygienist take and analyze a sample of the breathing air. A respirator may be required if exposure cannot be controlled to the PEL or TLV.

Read the product label and material safety data sheet for the electrode posted in the work place or in the electrode or flux container to see what fumes can be reasonably expected from use of the product and to determine if special ventilation is needed. Know what the base metal is, and determine if there is any paint, plating, or coating that could expose you to toxic fumes and/or gases. Remove it from the metal being welded, if possible.

If you start to feel uncomfortable, dizzy or nauseous, you may be overexposed to fumes and gases, or suffering from oxygen deficiency. Stop welding and get some fresh air immediately. Notify your supervisor and co-workers so the situation can be corrected and other workers can avoid the hazard. Be sure you are following these safe practices, the consumable labeling and MSDS and improve the ventilation in your area. Do not continue welding until the situation has been corrected.



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