

# LN-25 PRO

## Processes

MIG, MIG-STT<sup>®(1)</sup>, Pulsed, Flux-Cored

## Product Number

K2613-1 Standard  
K2613-2 Extra Torque  
K2614-1 Dual Power  
*See back for complete specs*

## Input Power

15-110 VDC (Standard/Extra Torque)  
15-110 VDC or 24-42 VAC (Dual)

## Output Capacity Current/Duty Cycle

325A/100%  
450A/60%

## Wire Size Range

See Back

## Wire Feed Speed Range

See Back

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

37 lbs. (16 kg)  
15 x 8.7 x 23.2 in.  
(381 x 221 x 589 mm)

## Portable Industrial Wire Feeders

Built upon the tradition and success of the LN-25, the LN-25 PRO is designed to be simple, reliable and easy to service. The LN-25 PRO is ideal for field construction and fabrication, shipyards, and rental companies.

### FEATURES

- ▶ **Performance – All Models**
  - 2-Step/trigger interlock provides comfort for long welds.
  - Sturdier and rugged spindle design with an incorporated brake.
- ▶ **Performance – Standard and Extra Torque Models**
  - Analog Voltmeter with polarity indicator LED automatically adjusts to welding polarity.
  - Non-linear wire feed speed gives single range control, yet maintains sensitivity with low wire feed speed.
- ▶ **Performance – Dual Power Model**
  - Display shows wire feed speed or amperage and welding voltage.
- ▶ **Reliability**
  - Lightweight, impact and flame resistant polycarbonate case design keeps the internal components protected.
  - Potted and trayed PC board protects against moisture and corrosion.
  - Reel locking mechanism eliminates spindle cross threading.
- ▶ **Serviceability**
  - Case can be replaced in less than 5 minutes - eliminates downtime.
  - Timer Kit available to prevent the electrode from sticking in the crater when using high wire feed speeds.

K2614-1  
LN-25 PRO Dual Power



K2613-1  
LN-25 PRO Standard

### APPLICATIONS

- ▶ Metal Fabrication
- ▶ Construction
- ▶ Shipbuilding
- ▶ Rental Fleet

### WHAT'S INCLUDED

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

### OUTPUT



### INPUT

All Model  
Across the Arc



K2614-1 Only  
Control Cable



**MAXTRAC**<sup>™</sup>  
Wire Drive System

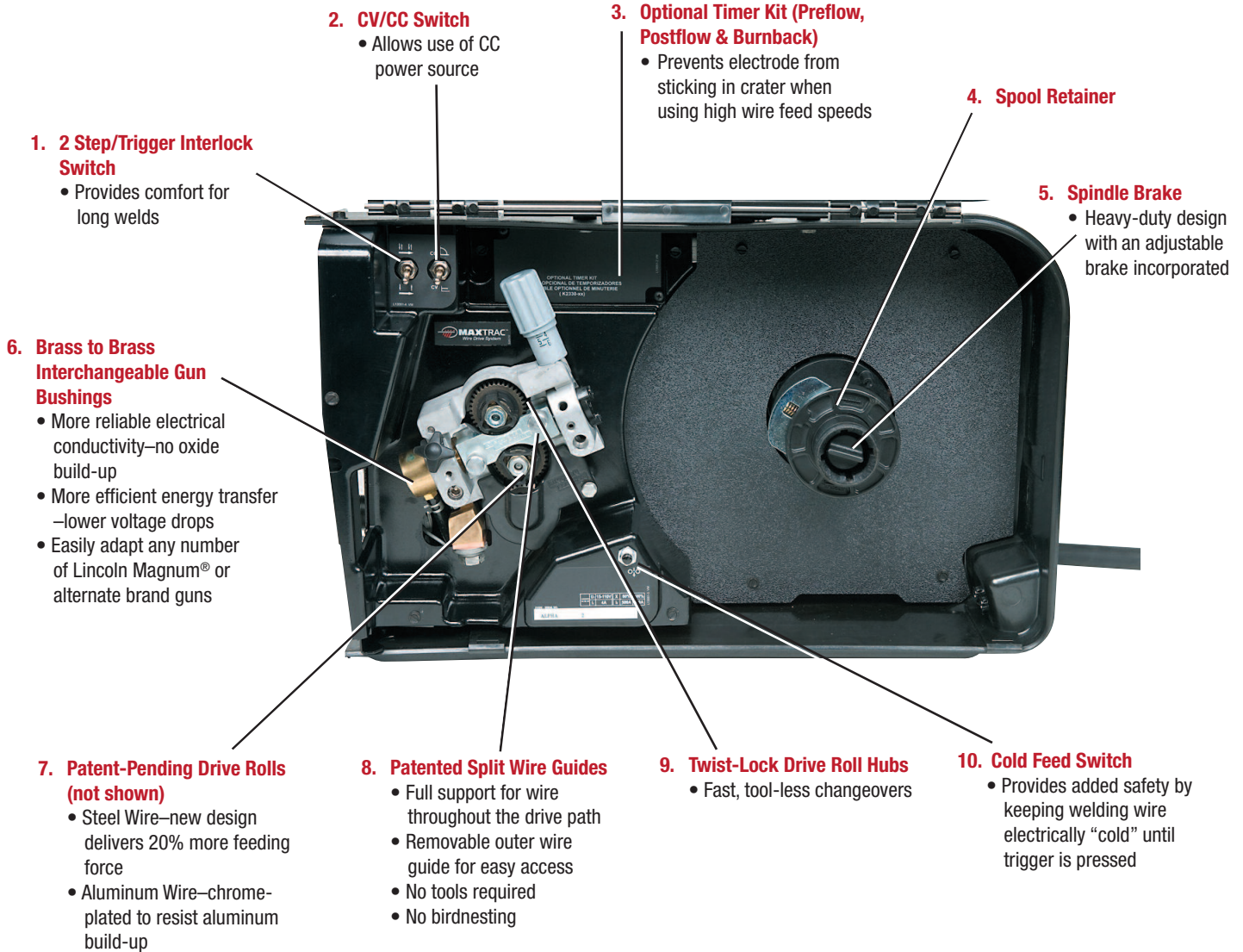


Two Year Extended  
Warranty Available in  
U.S.A. and Canada.

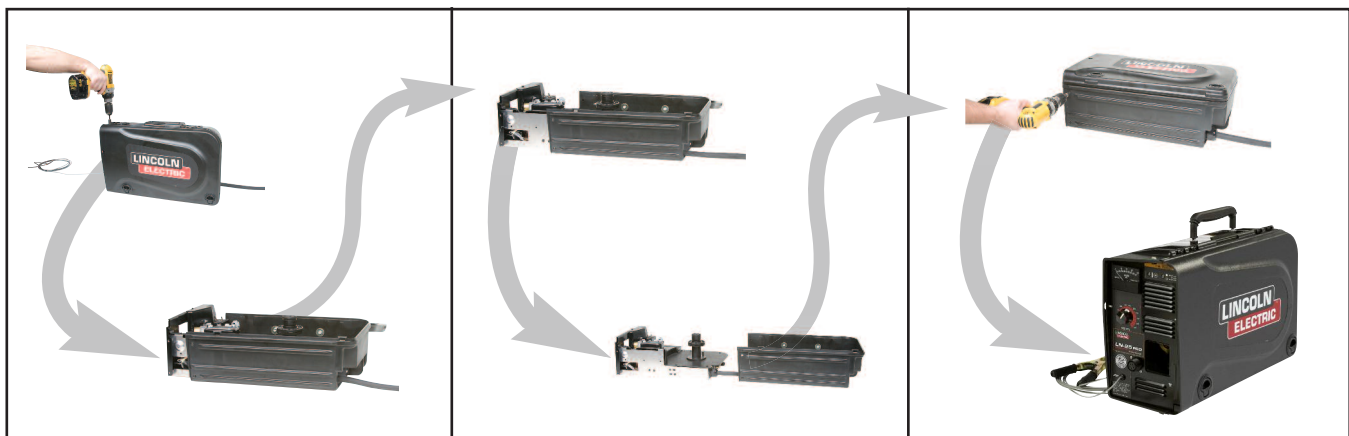
(1) STT<sup>®</sup> capability only with K2614-1 Dual Power Model.



## FEATURES



**EASY CASE REPLACEMENT IN MINUTES - Now a damaged case does not require ordering a new unit!**



1. Remove screws

2. Remove inside frame from case

3. Put frame in a new case and replace screws

## KEY CONTROLS

### LN-25 PRO



1. Analog Voltmeter
2. Wire Feed Speed Knob
3. 5-Pin Gun Trigger Connector
4. Work Sense Lead  
14.5 ft (4.4 m)
5. Thermal Protection LED
6. Welding Polarity Indicator LED

1. Gas Purge Pushbutton
2. Flow Meter Ball
3. Flow Meter Valve
4. Shielding Gas Inlet
5. Electrode Lead  
14 in. (356 mm)
6. Optional Water-Cooled  
Gun Connections

### LN-25 PRO DUAL POWER



1. Wire Feed Speed/Amperage Display
2. Wire Feed Speed LED
3. Amperage LED
4. Wire Feed Speed Knob
5. 5-Pin Gun Trigger Connector
6. Work Clip Connection
7. Thermal LED
8. Voltage Display
9. Voltage LED
10. Remote Voltage Control Knob  
(not presettable)

1. 14-Pin Control Cable Input

NOTE: In across-the-arc mode, voltage knob does not control voltage—adjust at power source.

## REQUIRED OPTIONS

### MAXTRAC® DRIVE ROLL & WIRE GUIDE KITS

Description	Order No.
<b>Steel Wire Sizes (includes stainless steel):</b>	
.023-.030 in (0.6-0.8 mm)	KP1696-030S
.035 in (0.9 mm)	KP1696-035S
.045 in (1.2 mm)	KP1696-045S
.052 in (1.4 mm)	KP1696-052S
.035, .045 in (0.9, 1.2 mm)	KP1696-1
.040 in (1.0 mm)	KP1696-2
1/16 in (1.6 mm)	KP1696-1/16S
<b>Cored Wire Sizes:</b>	
.030-.035 in (0.8-0.9 mm)	KP1697-035C
.040-.045 in (1.0-1.2 mm)	KP1697-045C
.052 in (1.4 mm)	KP1697-052C
1/16 in (1.6 mm)	KP1697-1/16C
<b>Steel or Cored Wire Sizes:</b>	
.068-.072 in (1.8 mm)	KP1697-068
5/64 in (2.0 mm)	KP1697-5/64
3/32 in (2.4 mm)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
.035 in (0.9 mm)	KP1695-035A
.040 in (1.0 mm)	KP1695-040A
3/64 in (1.2 mm)	KP1695-3/64A
1/16 in (1.6 mm)	KP1695-1/16A

### WELD POWER CABLES

Description	Order No.
Twist-Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)	K1840-10
Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)	K1842-10
Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)	K1842-35
Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)	K1842-60
Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)	K1842-110
Twist-Mate™ to Twist-Mate™, 1/0, 350A, 60% duty cycle, 25 ft. (7.6 m)	K1841-25
Twist-Mate™ to Twist-Mate™, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K1841-50

### CONTROL EXTENSION CABLES

Description	Order No.
Control Cable Extension, 10 ft. (3.0 m) - male 14 pin to female 14 pin	K1797-10
Control Cable Extension, 25 ft. (7.6 m) - male 14 pin to female 14 pin	K1797-25
Control Cable Extension, 50 ft. (15.2 m) - male 14 pin to female 14 pin	K1797-50
Control Cable Extension, 100 ft. (30.4 m) - male 14 pin to female 14 pin	K1797-100

## FEED PLATE GUN RECEIVER BUSHINGS

K1500-1 Gun Receiver Bushing	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)	K1500-4 Gun Receiver Bushing (Optional)	K1500-5 Gun Receiver Bushing (Optional)	K489-7 Fast-Mate Gun Receiver Bushing (Optional)
<ul style="list-style-type: none"> <li>Magnum® 200, 300 and 400 gun and cable assemblies with K466-1 connector kit.</li> <li>Lincoln Innershield® gun and cable assembly.</li> <li>Magnum® 550 gun and cable assembly with K613-1 connector kit.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® 200 and 400 fully assembled guns (K497-2x and K471-2x).</li> <li>Magnum® 200, 300 and 400 gun and cable assemblies with K466-10 connector kit.</li> <li>Guns with Tweco® #2, #3, and #4 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® 550 gun and cable assembly with K613-7 connection.</li> <li>Guns with Tweco® #5 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® 200, 300 and 400 gun and cable assemblies with K466-3 connector kit.</li> </ul>	<ul style="list-style-type: none"> <li>To adapt to OXO® guns.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum® gun and cable assemblies with Fast-Mate connections.</li> <li>Handles both single and dual procedure guns.</li> </ul>



## RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES



**K126 PRO Innershield® Gun**  
350A, 60% duty cycle air-cooled gun for flux-cored self-shielded Innershield® welding. Magnum® PRO expendable parts.  
**Order K126-11 (15 ft/4.5 m, K613-6 Gun Connector)**  
**Order K126-12 (15 ft/4.5 m, K466-10 Gun Connector)**



**Magnum® PRO Gun and Cable Assemblies**  
250-550 amps, air-cooled, gas-shielded welding guns.  
**See publication E12.01**



**Magnum® Self-Shielded Gun and Cable Assemblies**  
Available 250-600 amps.  
**See publication E12.110**



**Magnum® Gas-Shielded Gun and Cable Assemblies**  
Available 200-550 amps air-cooled, gas-shielded welding guns.  
**See publication E12.10**



**Adapter for Competitive PowerSources**  
Allows wire feeder to connect to select Miller Electric® power sources.  
**Order K2335-1**



**Prewflow, Postflow and Burnback Timer Kit**  
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds.  
**Order K2330-2**



**Jumper Plug Kit**  
For use with CV only power sources with 14 pin MS-type wire feeder connections and no contactor control switch. Jumper plug kit closes contactor for always hot welding output.  
**Order K484**



**14 Lb. Innershield® Coil Adapter**  
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. Wire not included.  
**Order K435**



**8 In. O.D. Spool Adapter**  
For small spools. Permits 8 in. (203 mm) O.D. spools to be mounted on 2 in. (51 mm) or 2.5 in. (64 mm) O.D. Spindles.  
**Order K468**



**Replacement Case Kit**  
Replace a damaged case without replacing the entire unit.  
**Order K2596-1 (aluminum)**  
**Order K2596-2 (plastic)**



**Twist Mate® Cable Plug**  
For connecting welding cable to output terminal receptacles. For 2/0 - 3/0 (70 - 90 mm<sup>2</sup>) cable.  
**Order K852-95**



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

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Gas Solenoid & Flow Meter	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)			Dimensions H x W x D in. (mm)	Net Weight Lbs. (kg)
						Solid	Cored	Aluminum		
LN-25 PRO Standard	K2613-1	15-110 VDC	325A/100% 450A/60%	Yes	50-700 (1.3-17.7)	.023-1/16 (0.6-1.6)	.030-5/64 (0.8-2.0)	.035-1/16 (0.9-1.6)	15 x 8.7 x 23.2 (381 x 221 x 589)	37 (16)
LN-25 PRO Extra Torque	K2613-2				30-400 (0.8-10.1)		.030-3/32 (0.8-2.4)			
LN-25 PRO Dual Power	K2614-1	15-110 VDC or 24-42 VAC	50-700 (1.3-17.7)	.030-5/64 (0.8-2.0)						

### CUSTOMER ASSISTANCE POLICY

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