

**NEW!**

WIRE FEEDER/WELDERS

# POWER MIG<sup>®</sup> 216

**Processes**

MIG, Flux-Cored

**Product Number**

K2816-1

**Input Power**

208/230V, 1/60 Hz / 220V, 1/50 Hz

**Input Current @ Rated Output**

208V:33A at 170A/24VDC/60% Duty Cycle

208V:40A at 216A/22VDC/30% Duty Cycle

230V:30A at 170A/24VDC/60% Duty Cycle

230V:36A at 216A/22VDC/30% Duty Cycle

**Rated Output**

170A at 24VDC, 60% Duty Cycle

216A at 22VDC, 30% Duty Cycle

**Max. Open Circuit Voltage**

36VDC

**Amperage Range**

30 - 250A

**Wire Feed Speed**

50 - 700 IPM (1.3 - 17.8 m/min)

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

206.5 lbs. (93.7 kg)

32.56 x 19.15 x 39.92"

(827 x 487 x 1,014 mm)

## POWER MIG<sup>®</sup> The Professional's Choice<sup>SM</sup>

The POWER MIG<sup>®</sup> 216 offers the autobody and sheet metal fabrication industries top welding performance with a host of professional features.

**FEATURES**

- ▶ **Diamond Core Technology<sup>™</sup>** – Delivers a forgiving arc, excellent out-of-position arc action, low spatter and a wide voltage sweet spot for steel, stainless steel or aluminum.
- ▶ **MAXTRAC<sup>®</sup> Cast Aluminum Industrial Wire Drive** – Features dual driven rolls, regulated wire feed speed control, brass-to brass connections and Lincoln's 100% wire supporting split wire guide system.
- ▶ **More Output and Better Efficiency** – Compare the best in class rated output, wide amperage range and efficiency.
- ▶ **Spool Gun Ready** – Just remove the standard MIG gun and plug in the optional Magnum<sup>®</sup> 100 SG spool gun for enhanced aluminum wire feeding performance.
- ▶ **New! Great Value-Adding Features** –
  - Coil Claw<sup>™</sup> Cable Management system keeps your workstation organized.
  - Convenient top-mounted gun expendables tray.
  - All metal case front.

**APPLICATIONS**

- ▶ Metal Fabrication
- ▶ Maintenance and Repair
- ▶ Autobody/Farm
- ▶ Light Industrial



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**WHAT'S INCLUDED**

- ▶ Magnum<sup>®</sup> 250L gun and 15 ft. (4.5 m) "quick-connect" cable assembly equipped with fixed gas nozzle assembly.
- ▶ Top-mounted gun expendables tray.
- ▶ Built-in undercarriage with easy-load gas cylinder platform.
- ▶ Work clamp and 10 ft. (3.0 m) cable.
- ▶ 10 ft. (3.0 m) 230V input power cable with plug.
- ▶ Drive roll and wire guide to feed both .035" & .045" (0.9 & 1.2 mm) wire.
- ▶ Gas regulator and hose kit for argon blend gases. (For use with CO<sub>2</sub> shielding gas, order a Lincoln S19298 CO<sub>2</sub> shielding gas bottle adapter.)
- ▶ Large color coded procedure recommendation sheet.

**INPUT****OUTPUT**

Two Year Extended  
Warranty Available.

**THE LINCOLN ELECTRIC COMPANY**

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**LINCOLN<sup>®</sup>**  
**ELECTRIC**  
THE WELDING EXPERTS<sup>®</sup>

## KEY CONTROLS

The POWER MIG® 216 control panel with the calibrated wire feed speed and the seven tapped voltage knob makes it easy to select the right procedure for your application.

The recommended settings are easily identified by the color coded procedural chart which is permanently mounted inside the wire drive compartment.



1. Power on/off switch
2. Wide range wire feed speed (WFS) control (up to 700 ipm). The dial is calibrated in true inches per minute for easy, accurate procedural change.
3. Seven voltage taps
4. Brass to brass connection bushing and work clamp access
5. Gun trigger lead connection

## A CLOSER LOOK



Gun Expendable Parts Compartment



Easy-Load Wire Compartment



Built-in Undercarriage With Easy-Load Gas Cylinder Platform



Professional Heavy Duty MAXTRAC® Wire Drive System



**Coil Claw** Keeps Your Workstation organized



Improved Control Panel, More Convenient Gun Connection and Power Switch Locations



Patented choke technology that produces an outstanding arc with better starts, a wider sweet spot, lower spatter levels and outstanding performance on aluminum and stainless steels.

**WIRE DRIVE SYSTEM**



**Split guides** support the wire through the entire drive system to minimize feeding problems.

Reliable **brass-to-brass gun receiver bushings** provide connectivity to Magnum® or competitive guns. Easier interchangeability, better mechanical support and electrical current transfer.

**Angled gun cable connection** for improved feedability and reduced gun liner wear.

**Easy turn numeric tension indicator** with optimized ranges for different wire types.

**Internal feedback drive system** allows you to maintain constant wire feed speed for consistent welds.

**Wide idler arm hinge** provides improved drive roll clamping pressure.

**Input bushing** protects the wire from damage.

**Two gear driven rolls.** No tools needed to swap rolls on or off.

**Separate drive gear** reduces pressure on motor shaft for long life.

**Removable outer wire guide** for easy access.

**GUN INFORMATION**





Included Magnum® 250L Gun



- Rated 250A @ 60% duty cycle with CO<sub>2</sub> shielding gas.
- Ships equipped to feed .035" – .045" (0.9 – 1.2 mm) solid steel wire. The 250L is capable of feeding .025" – .045" (0.6 – 1.2 mm) wire.
- Extra reach 15 ft. (4.5 m) gun cable length.
- Features ergonomic handle, gun hanger clip and 60 degree gun tube.

DRIVE ROLL KITS		
	Wire Size	Order Number
Solid	.023-.030" (0.6-0.8 mm)	KP1696-030S
	.035" (0.9 mm)	KP1696-035S
	.035/.045" combination	KP1696-1 <sup>(1)</sup>
	.040" (1.0 mm)	KP1696-2
	.045" (1.2 mm)	KP1696-045S
Cored	.035" (0.9 mm)	KP1697-035C
	.045" (1.2 mm)	KP1697-045C

<sup>(1)</sup> Included with POWER MIG® 216.

SPOOL GUN READY-LIGHT DUTY	SPOOL GUN CAPABLE-MEDIUM DUTY	SPOOL GUN CAPABLE-HEAVY DUTY
<p><b>Magnum® 100 SG Spool Gun – (K2532-1)</b></p> 	<p><b>Magnum® SG Spool Gun – (K487-25)</b></p> 	<p><b>Magnum® 250LX Spool Gun – (K2490-1)</b></p> 
<ul style="list-style-type: none"> <li>• 130 Amp 30% Duty Cycle</li> <li>• 10 ft. (3.0 m) cable length</li> <li>• Feeds .030" – .035" (0.8 – 0.9 mm) diameter wire</li> <li>• Wire Feed Speed is set at machine</li> <li>• Fixed wire spool brake with friction pads for 5356 wire</li> <li>• Fixed drive roll tension</li> </ul> 	<ul style="list-style-type: none"> <li>• 250 Amp 60% Duty Cycle</li> <li>• 25 ft. (7.6 m) cable length</li> <li>• Feeds .025" - 3/64" (0.6 – 1.2 mm) diameter wire</li> <li>• Single-Turn remote wire feed speed control at the gun</li> <li>• Adjustable wire spool brake</li> <li>• Adjustable drive roll tension</li> </ul>	<ul style="list-style-type: none"> <li>• 300 Amp 60% Duty Cycle</li> <li>• 25 ft. (7.6 m) cable length</li> <li>• Feeds .025" - 3/64" (0.6 – 1.2 mm) diameter wire</li> <li>• Multi-Turn remote wire feed speed control at the gun</li> <li>• Deluxe wire spool brake requires no adjustments</li> <li>• Adjustable drive roll tension</li> <li>• Ergonomic Sure Grip handle</li> <li>• Contact tip storage built in spool gun cover</li> <li>• Easy open wire drive rolls for easy wire loading</li> </ul>
Factory Ready! No Adapter Required!	Requires K2703-1 Adapter	Requires K2703-1 Adapter

## PROCESS CAPABILITIES

Process	Electrode Wire	Electrode Polarity	Shielding Gas	Minimum Thickness	Maximum Thickness <sup>(1)</sup>
<b>MIG</b> Mild Steel	.025, .030, .035, .045" (0.6, 0.8, 0.9, 1.2 mm) SuperArc® L50, L-56 SuperGlide® S-3, S-6	DC+	100% CO <sub>2</sub> or Ar/CO <sub>2</sub> Blend	24 ga. (.024") (0.6 mm)	5/16" (.312") (7.9 mm)
<b>MIG</b> Stainless	.030, .035, .045" (0.8, 0.9, 1.2 mm) SuperArc® 308LSi, 309LSi, 316LSi	DC+	Ar/CO <sub>2</sub> Blend or (Tri-Mix) 90% He, 7-8% Ar/Balance CO <sub>2</sub>	20 ga. (.036") (0.9 mm)	1/4" (.250") (6.4 mm)
<b>MIG</b> Aluminum <sup>(2)</sup>	3/64" (0.2 mm) SuperGlaze® 4043 and 5356	DC+	100% Argon	1/16" (.063") (1.6 mm)	1/4" (.250") (6.4 mm)
<b>Flux-Cored, Gas-Shielded</b> Mild Steel	.035, .045" (0.9, 1.2 mm) Outershield® 71M and MC-710	DC+	100% CO <sub>2</sub> or Ar/CO <sub>2</sub> Blend	12 ga. (.109") (2.7 mm)	1/2" (.500") (12.7 mm)
<b>Flux-Cored, Self-Shielded</b> Mild Steel	.035, .045" (0.9, 1.2 mm) Innershield® NR®-211-MP <sup>(3)</sup> and NR®-212	DC-	—	18 ga. (.050") (1.2 mm)	1/2" (.500") (12.7 mm)

<sup>(1)</sup> Lincoln Electric recommends multiple pass welds on 1/2" (12.7 mm) material. Consult the appropriate application procedures and guidelines for selecting the correct wire size, gas type and number of passes.

<sup>(2)</sup> For .035" (0.9 mm) and 4043 aluminum wire, the spool gun is recommended for best feeding results.

<sup>(3)</sup> .035" and .045" (0.9 and 1.2 mm) NR®-211-MP is only recommended up to 5/16" (7.9 mm) thick material.

## RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES



### GENERAL OPTIONS

**Magnum® Connection Kit**  
Permits use of Magnum® and Magnum® PRO gun and cable assemblies on POWER MIG®.  
**Order K466-6**



**Spindle Adapter for 8" O.D. Spools**  
Permits 8" (200 mm) O.D. spools to be mounted on 2" (51 mm) O.D. spindles.  
**Order K468**



### Welding Fume Extractors

Lincoln offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.  
**Request Publication E13.40**



### POWER MIG® Spool Gun Adapter

This kit is designed to allow the Magnum® SG or Magnum® 250LX spool gun to operate with the POWER MIG®. The kit includes the solenoid, gas lines, wiring harness and gun connection panel. The gun connection panel features a 6 pin MS-type connector for the Magnum® SG spool gun and a 7 pin MS-type connector for the Magnum® 250LX spool gun and a selector switch to choose which gun you are using.  
**Order K2703-1**  
**Note the K2703-1 spool gun adapter disables the Magnum® 100 SG capability.**



### Dual Cylinder Mounting Kit

Permits side-by-side mounting of two full size gas cylinders, with easy loading. Attaches easily to POWER MIG® undercarriage.  
**Order K1702-1**



### Canvas Cover

Protect your POWER MIG® when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent. Fits any POWER MIG® machine with or without a gas cylinder in the cylinder rack. Will not fit if spool gun holder is attached to the machine.  
**Order K2378-1**

**For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables.**  
Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

## CUSTOMER ASSISTANCE POLICY

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