

LN-25X[®]

FEWER CABLES. GREATER CONTROL.



Shown: LN-25X w/CrossLinc Technology (K4267-2)

PORTABLE INDUSTRIAL WIRE FEEDER

We understand the needs of those working hard in the field every single day. Whether you're working on a large structure in a shipyard, or you're 100 feet off of the ground, your safety and efficiency should never be jeopardized. The less you have to move, the more valuable you are. We believe good equipment should never limit your capabilities, and the LN-25X wire feeder with CrossLinc[®] and True Voltage Technology[™] (TVT[™]) helps you get the job done with drastically less movement.

Processes »

MIG, Flux-Cored

Applications »

Construction, Pipe, Metal Fabrication, Shipbuilding, Rental Fleet

Output »



Input »



All Models
Across the Arc

Product Number »

K4267-2 LN-25X w/TVT (Tweco[®])
K4267-3 LN-25X w/TVT (Tweco, w/Flowmeter)
K4267-4 LN-25X w/TVT CE Model
(Twistmate/Dinse, w/Flowmeter)
K4267-5 LN-25X Extra Torque w/TVT (Tweco)

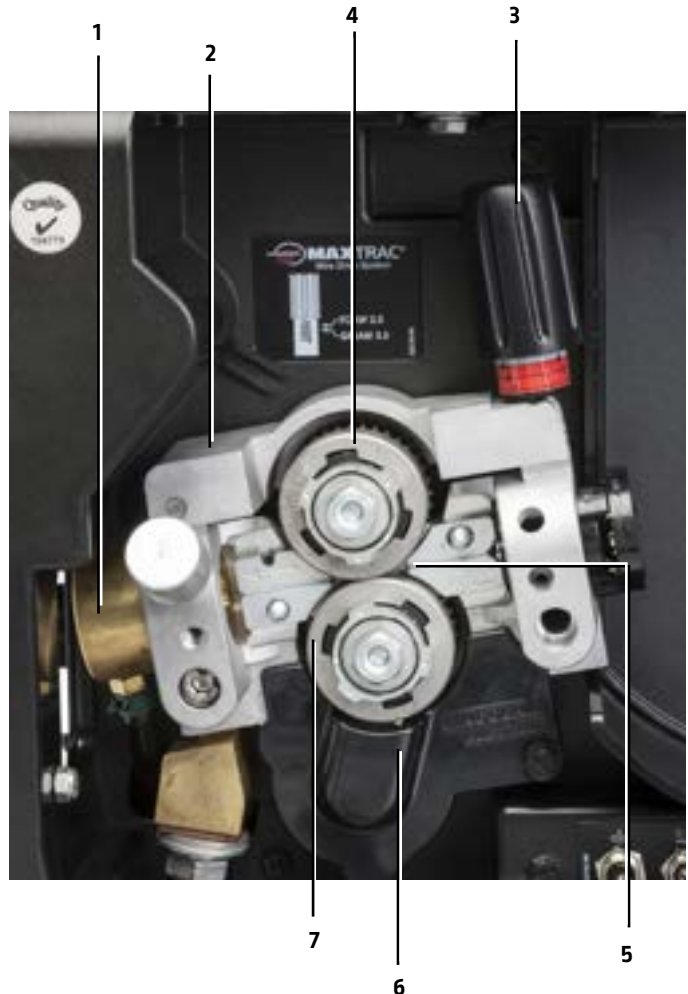
FEATURES

- **Maxtrac® Wire Drive System** – Heavy-duty cast aluminum wire drive system provides reliable feeding and durability
- **CrossLinc® Technology** – Control output at a distance with no additional cables
- **True Voltage Technology™ (TVT™)** – Voltage drop compensation. Get what you set
- **Tachometer feedback** ensures accurate wire feed speed
- **Trigger Interlock Switch** – Provides operator comfort for long welds
- **Replaceable and Flame Resistant Case** – Protects internal components, easy to replace
- **Potted PC Boards** – For moisture and corrosion protection
- **Split Wire Guide** – Reduces birdnesting and allows for easy cleaning no-fuss wire guide alignment
- **Bright digital meters** for easy viewing even in bright sunlight
- **Included Tweco style male connector** on input power cable. (Twistmate/Dinse connector on CE model)
- **Optional Flowmeter** – for easy gas flow adjustment at the feeder
- **Weld Timers** – Pre-Flow, Post-Flow, and Burn Back
- **Adjustable Wire Run-In Speed** – for softer starting
- **Configurable for English or metric units**
- **Arc Hours Meter**
- **Dual Procedure capable** - allows two distinct WFS and Voltage settings to be recalled from the LN-25X with the flip of a switch on the dual procedure gun

TECHNOLOGY SPOTLIGHT



1. **Brass to Brass Interchangeable Gun Bushings** options for most weld gun styles. Excellent electrical contact for consistent arc.
2. **Rigid Cast Aluminum Frame**
3. **Twist-Lock Drive Roll Hubs** toolless drive roll replacement
4. **Patented Dual Spring Pressure Arm** optimized for both soft and hard wires
5. **Patented Split Wire Guides** nothing to align, easy wire loading. easy to clean
6. **Separate Drive Gear** reduced force on the drive motor shaft for consistent feeding
7. **Patented Drive Rolls** Patented Dual Groove Drive Roll





Crosslinc with True Voltage Technology (TVT) – Improve all aspects of your operation with Crosslinc and TVT.

Safety

- Reduce jobsite clutter by removing cumbersome control cables.
- Eliminate unnecessary movement of personnel across the jobsite.
- No need to drag heavy control cables around the site.

Quality

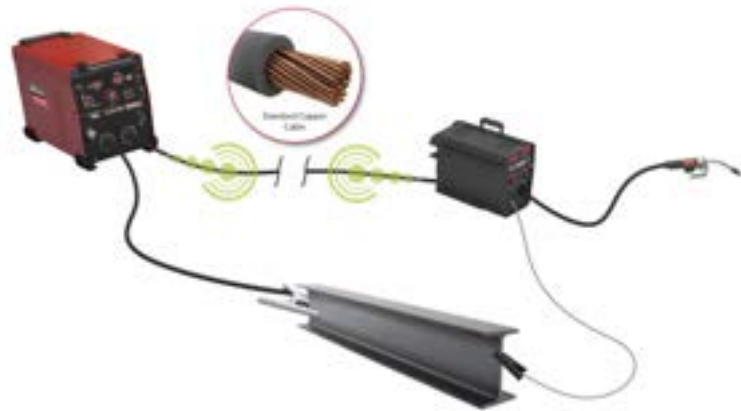
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

Productivity

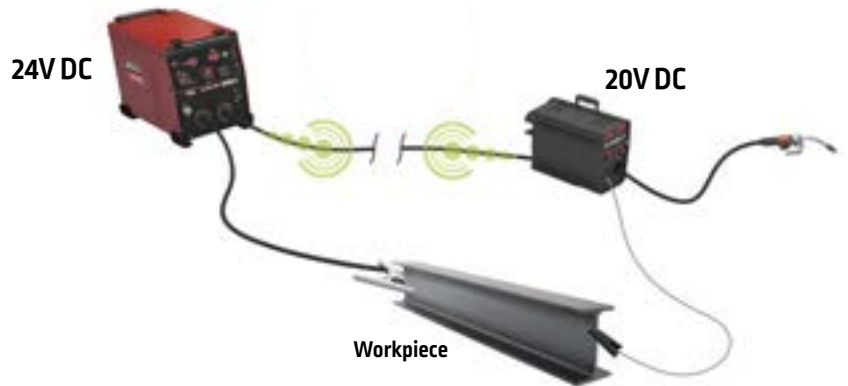
- Setup faster with fewer cable connections.
- Eliminate helpers or trips to the power source to make procedure adjustments.
- Minimize rework with easy settings adjustments.

Crosslinc Technology Communicates Settings Directly Over The Weld Cables.

- No additional control cable is needed.
- Set the desired voltage on the feeder.
- The feeder sends the signal to the Flextec with CrossLinc power source.
- The CrossLinc compatible power source puts out the desired voltage.
- The LN-25X receives the voltage and lets you know the exact voltage at the arc.



As is common in many outdoor welding applications: (Structural steel, Shipbuilding, Offshore, etc.) the operator can be located hundreds of feet away from the power source. All that cable can create a difference in voltage, or voltage drop, between the power source and the weld. In the example below, 24 volts is set on the welding power source. Due to electrical resistance through long cables, only 20 volts are actually available at the arc. This would result in a cold weld.



True Voltage Technology (TVT) sees this drop and gives you the true voltage you set by adjusting the power source to compensate for the voltage drop. In the example below, 24 volts is preset at the LN-25X. TVT senses there is a 4 volt drop due to long weld cables and compensates by increasing the welder output to 28 volts. The result is the desired 24 volts available at the welding arc.



REQUIRED ACCESSORIES

FEED PLATE GUN ADAPTERS

| K1500-1 ^(a) | K1500-2 ^(b) | K1500-3 | K1500-4 | K1500-5 | K489-7 |
|---|---|---|---|---|---|
| Lincoln Electric | Tweco #2 - #4 | Tweco #5 | Miller® Guns | OXO® Guns | Fast-Mate™ / Euro Connector |
| Compatible gun connector kits: | Compatible gun connector kits: | Compatible gun connector kits: | Compatible gun connector kits: | | Compatible with weld guns with Fast-Mate™ or Euro connectors |
| K466-1 K613-1 K613-6 K466-8 | K466-10 K466-2 K466-6 | K613-7 K613-2 | K466-3 K613-3 | | |
|  |  |  |  |  |  |

^(a)Included with machine. ^(b)Installed in machine.

MAXTRAC DRIVE ROLL & WIRE GUIDE KITS

| Description | Product No. |
|---|--------------|
| Steel Wire Sizes (includes stainless steel): | |
| .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 |
| Cored Wire Sizes: | |
| .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 |
| Steel or Cored Wire Sizes: | |
| .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 |
| Aluminum Wire Sizes: | |
| .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 | Product No. | |
|-------------|--|-----------|
| 1/0 Cable | Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. [3.0 m] | K1840-10 |
| | Twist Mate to Twist Mate, 1/0, 350A, 60% duty cycle, 25 ft. [7.6 m] | K1841-25 |
| 2/0 Cable | Tweco-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. [15.2 m] | K2485-2 |
| | Tweco-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. [15.2 m] | K2484-2 |
| | Twist Mate to Twist Mate, 2/0, 350A, 60% duty cycle, 50 ft. [15.2 m] | K1841-50 |
| 3/0 Cable | Tweco-Style male plug and female receptacle 3/0, 600A, 60% duty cycle, 50 ft. [15.2 m] | K2485-3 |
| | Tweco-Style male plug and 0.53 lug, 3/0, 600A, 60% duty cycle, 50 ft. [15.2 m] | K2484-3 |
| | Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. [3.0 m] | K1842-10 |
| 4/0 Cable | 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 |

Look for the X

CrossLinc compatible feeders and power sources carry an X in their name, i.e. LN-25X, FLEXTEC® 350X. When paired together, CrossLinc communication will be established.

The LN-25X will also work with any CV power source as a simple, across the arc feeder, but without CrossLinc or TVT capabilities.



FLEXTEC 350X
Construction

FLEXTEC 350X
Standard

FLEXTEC 500X

FLEXTEC 650X

Ranger® 330MPX™



FRONT VIEW

- 1. Work Power Lead
- 2. Wire Feed Speed Control
- 3. Wire Feed Speed/Amp Display
- 4. Voltage Display
- 5. Hidden Setup Menu Access
- 6. Voltage Control
- 7. Gun Connection Block
- 8. 5-pin Gun Trigger Connector



BACK VIEW

- 9. Optional Flow Meter^[1]
- 10. Shielding Gas Inlet
- 11. Work Sense Lead
- 12. Electrode Lead
(w/Tweco style connector^[2])



INSIDE VIEW

- 13. Cold Feed Switch
- 14. MAXTRAC Drive System
- 15. 2-Step / 4-Step Switch
- 16. Spool Retainer
- 17. Spindle Brake



[1] Included on the K4267-3 LN-25X w/Flow Meter and the K4267-4 LN-25X CE model
 [2] Twistmate/Dinse connector on the K4267-4 CE model.

RECOMMENDED ACCESSORIES

GENERAL OPTIONS



K126 PRO Innershield® Gun
350 A, 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)

See publication E12.111



Magnum Self-Shielded Gun and Cable Assemblies

Available 250-600 amps.

See publication E12.110



Magnum PRO Gun and Cable Assemblies

250-550 amps, air-cooled, gas-shielded welding guns.

See publication E12.01



Magnum PRO Curve Semiautomatic Guns

Magnum PRO Curve guns for MIG or flux-cored, gas-shielded welding. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.

See publication E12.05



Work and Wire Feeder 2/0 Weld Cable Package

Includes Twist Mate connectors, work clamp, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.

Order K1803-1



Weld Cable Package Work & Power Lead 2/0 - Tweco Male & GC500 / Tweco Male & Lug - 10 ft (3 m)

Includes Tweco style Cam-Lock connectors, work clamps, 10 ft. (3.0 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.

Order K1803-2



Weld Cable Package - Work Lead - TM & GC500 Ground Clamp (2/0, 350A, 60%) - 15 ft (4.5 m)

Includes Twist Mate (Dinse) connector, ground clamp, 15 ft. (4.5 m) 2/0 cable. Rated 350 amps, 60% duty cycle.

Order K1803-3



Work Clamp

Jaws open full 2-1/2 in. (63 mm). Welding cable lug bolts directly to the work clamp. 60% duty cycle. Select K910-1 for 300 Amp applications. K910-2 for 500 Amp.

Order K910-1 & K910-2



Tweco-Style Plug

Male, 1/0 through 2/0.

Order K3416-70



Tweco-Style Receptacle

Female, 1/0 through 2/0.

Order K3417-70



Tweco-Style Plug

Male, 3/0 through 4/0.

Order K3416-90



Tweco-Style Receptacle

Female, 3/0 through 4/0.

Order K3417-90



Tweco to Lug Adapter

Contains two adapters to connect Tweco cables to power sources with standard output studs.

Order K2487-1



Magnum PRO Curve HDE™ 250 Guns

Magnum® PRO Semi-Automatic MIG welding gun with 250A 100% mixed gas duty cycle. Designed to maximize performance and operator comfort.

See Publication E12.08.1, E12.08



Deluxe Adjustable Gas Regulator
Deluxe Gas Regulator for Mixed Gases, Adapter for CO₂ and 10 ft. (3.0m) Hose.

Order K586-1



Wire Feed Speed Meter

A wire feed speed meter with digital display.

Order K283



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 K2596-2 (plastic)



Twist Mate Cable Plug

For connecting welding cable to output terminal receptacles.

Order K852-70 for 1/0-2/0

(50-70 mm²) cable

Order K852-95 for 2/0-3/0

(70-90 mm²) cable



Twist Mate Cable Receptacle

For connecting welding cable to Twist Mate Cable Plug.

Order K1759-70 for 1/0-2/0

(50-70 mm²) cable

Order K1759-95 for 2/0-3/0

(70-95mm²) cable

PRODUCT SPECIFICATIONS

| Product Name | Product Number | Input Power | Output Capacity Current/Duty Cycle | Flow Meter | Input Power Connection | Wire Feed Speed Range ipm (m/min) | Wire Size Range - in. (mm) | | | Dimensions H x W x D in (mm) | Net Wt lb (kg) |
|-----------------------------------|----------------|-------------|------------------------------------|------------|------------------------|-----------------------------------|----------------------------|---------------------|---------------------|-----------------------------------|----------------|
| | | | | | | | Solid | Cored | Aluminum | | |
| LN-25X w/CrossLinc and TVT | | | | | | | | | | | |
| Base Model | K4267-2 | 15-115V DC | 450A @ 60% | No | Tweco Style | 50-700 (1.3-17.8) | .023-1/16 (0.6-1.6) | .030-5/64 (0.9-2.0) | .035-1/16 (0.9-1.6) | 15 x 8.7 x 23.2 (381 x 221 x 589) | 40 (18.1) |
| Base Model w/ Flowmeter | K4267-3 | | | Yes | Tweco Style | | | | | | |
| CE Model | K4267-4 | | | Yes | Twist Mate/ Dinse | | | | | | |
| Extra Torque Model | K4267-5 | | | No | Tweco Style | 30-400 (0.8-10.2) | .030-3/32 (0.9-2.4) | | | | |

For best welding results with Lincoln Electric® equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

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