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 »
15-115 VDC *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)

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LINCOLN ELECTRIC

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 digtial meters** for easy viewing even in bright sunlight
- **Included Tweco sytle 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**

TECHNOLOGY SPOTLIGHT

MAXTRAC® Wire Drive System

1. **Brass to Brass Interchangeable Gun Bushings** options for most weld gun styles. Excellent electrical contact for consistent arc.

2. **Rigid Cast Aluminum Frame**

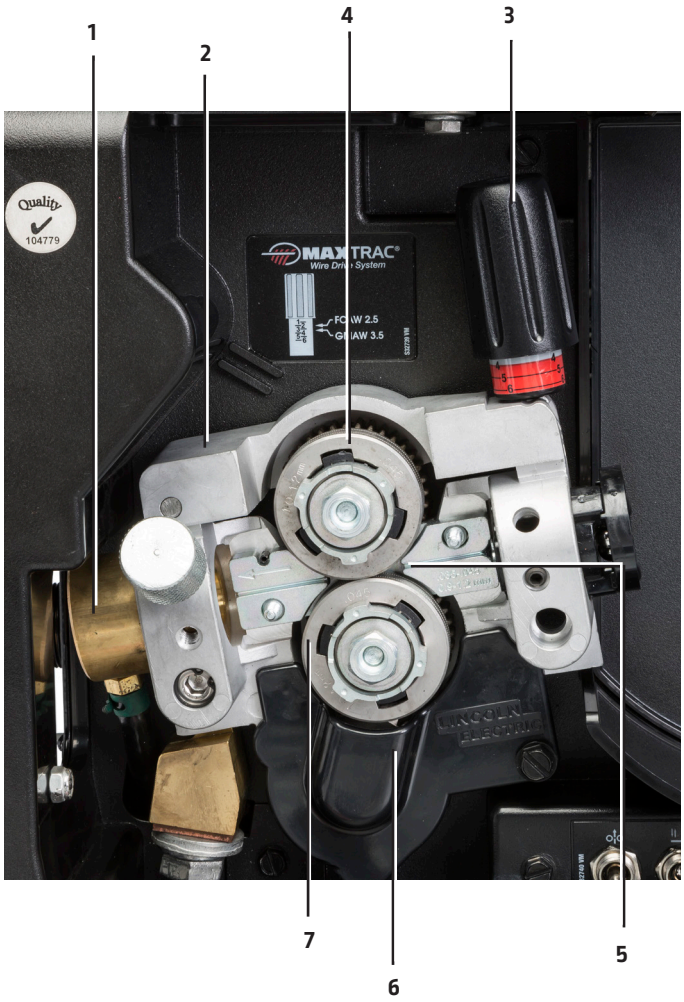
3. **Twist-Lock Drive Roll Hubs** toolless drive roll replacement

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 TECHNOLOGY AND TRUE VOLTAGE TECHNOLOGY (TVT)

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

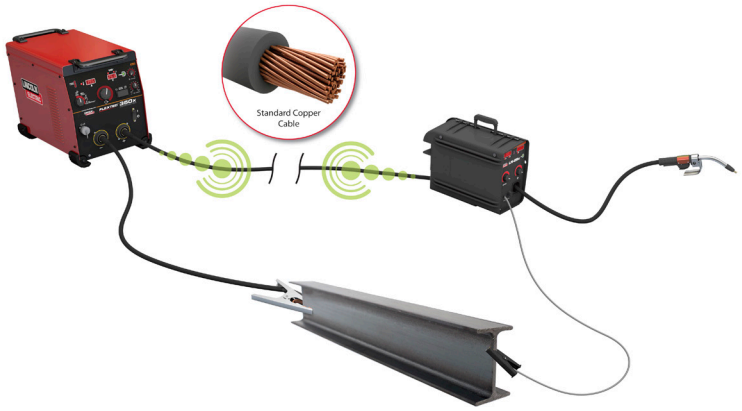
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

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.

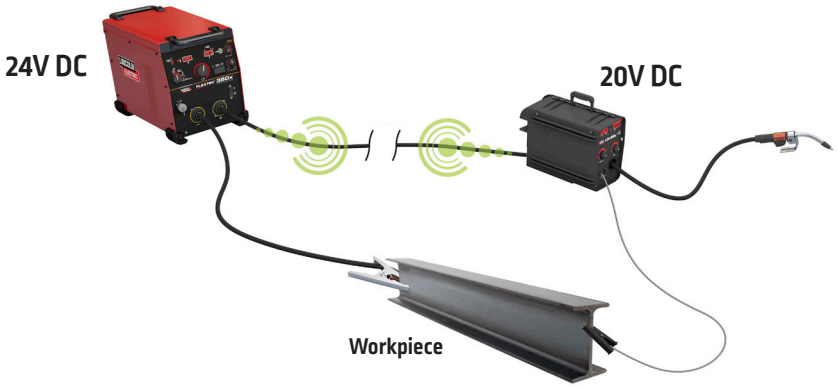
Crosslinc Technology Communicates Settings Directly Over The Weld Cables.

- 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 recieves the voltage and lets you know the exact voltage at the arc.

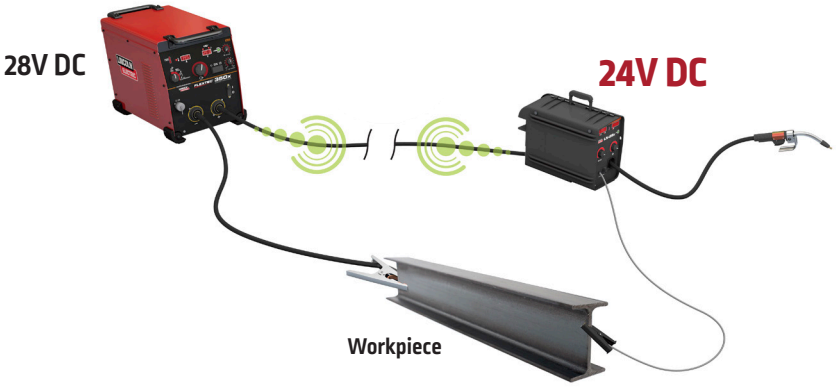


TVT™ True Voltage Technology™

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

[1]Included with machine. [2]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
	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
4/0 Cable	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™

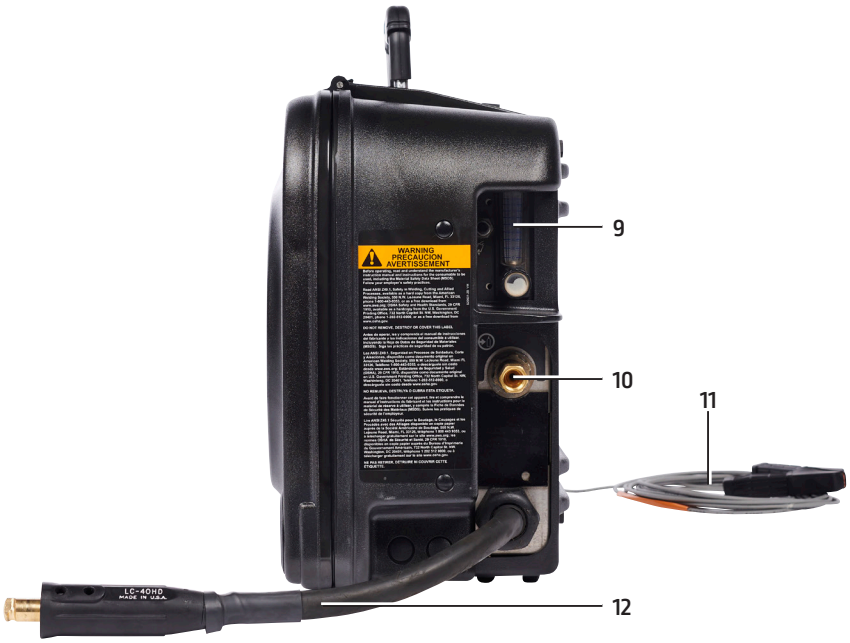
KEY CONTROLS

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

Deluxe Adjustable Gas Regulator
Deluxe Gas Regulator for Mixed Gases, Adapter for CO_2 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 connectinc welding cable to output terminal receptacles.
Order K852-70 for 1/0-2/0 (50-70 mm^2) cable
Order K852-95 for 2/0-3/0 (70-90 mm^2) cable

Twist Mate Cable Receptacle
For connecting welding cable to Twist Mate Cable Plug.
Order K1759-70 for 1/0-2/0 (50-70 mm^2) cable
Order K1759-95 for 2/0-3/0 (70-95mm^2) 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.

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.

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