LN-25X™

Fewer cables. Greater control.

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

Input

Output

Product Number
K4267-4 LN-25X w/TVT CE Model (Twistmate/Dinse, w/Flowmeter)

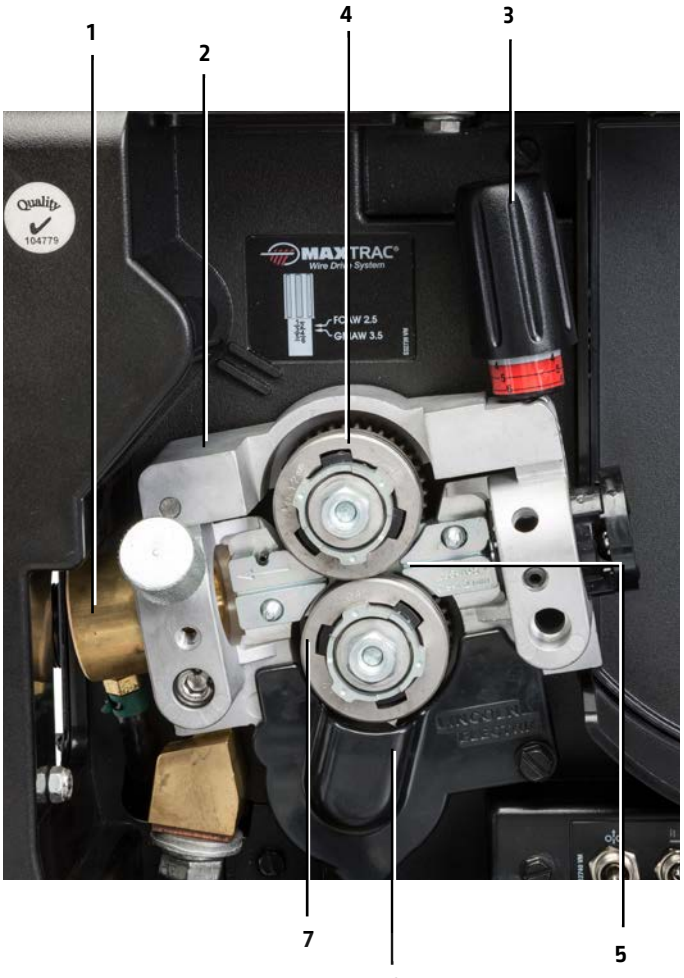
Features

- **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 Twistmate/Dinse sytle male connector** on input power cable
- **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 w/True Voltage Technology (TVT) – Improve all aspects of your operation with CrossLinc Technology 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

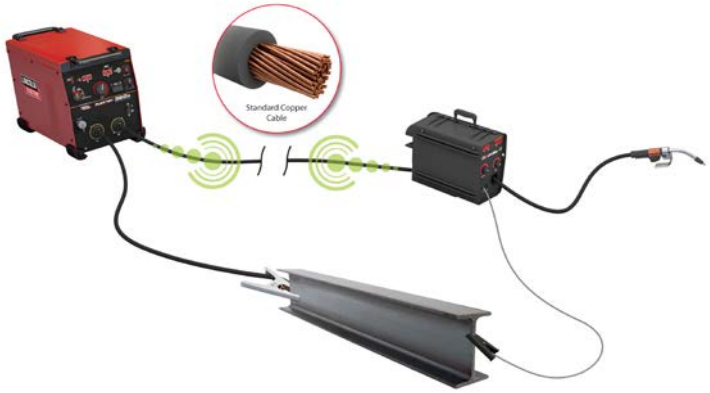
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

Productivity

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

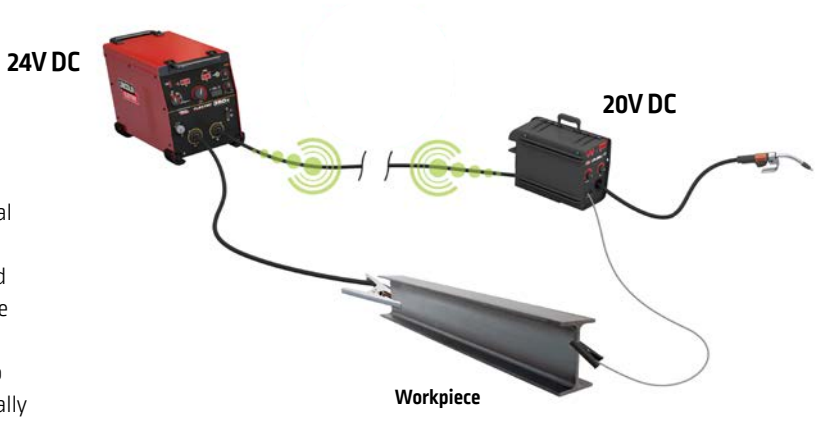
Crosslinc Technology Communicates Settings Directly Over The Weld Cables.

- No additional control cable is needed.
- Pre-set the desired voltage on the feeder.
- The feeder sends the signal to the CrossLinc enabled power source.
- The CrossLinc compatible power source puts out the desired voltage.
- The Activ8X recieves the voltage and lets you know the actual voltage at the arc.

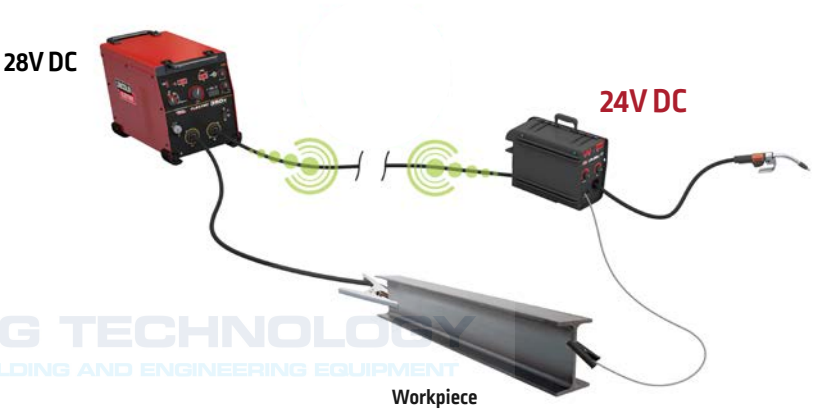


TVT™ True Voltage Technology™

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. Long cables and multiple connections can create a difference in voltage (voltage drop) between the power source and the weld. In the example to the right, 24volts is set on the welding power source. Due to electrical resistance through long cables, only 20volts are actually available at the arc. This may 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, 24v is preset at the Activ8X wire feeder. TVT senses there is a 4 volt drop due to long weld cables and compensates by increasing the welder output to 28V. The result is the desired 24v 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 in 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

Index	Desription
K14166-1	Weld Power Cable, TM-TM, 70MM2-10M
K14166-2	Weld Power Cable, TM-TM, 70MM2-15M
K14166-3	Weld Power Cable, TM-TM, 70MM2-5M
K14166-4	Weld Power Cable, TM-TM, 70MM2-30M
K14167-1	Weld Power Cable, TM-TM, 95MM2-30M
K14167-2	Weld Power Cable, TM-TM, 95MM2-5M
K14167-3	Weld Power Cable, TM-TM, 95MM2-10M
K14167-4	Weld Power Cable, TM-TM, 95MM2-15M

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.

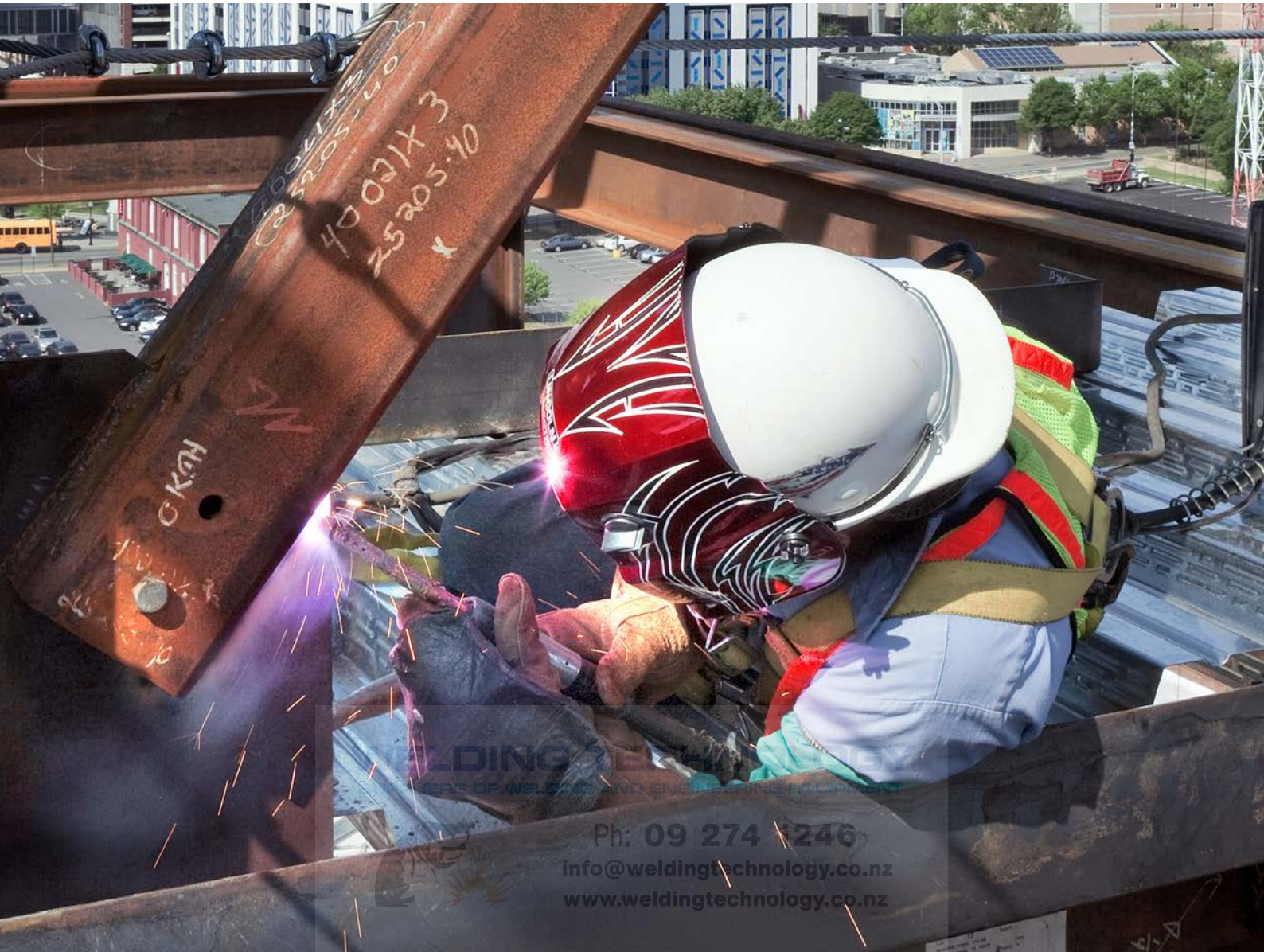
The LN-25X will also work with any CV power source as a simple, across the arc feeder, but without CrossLinc or TVT capabilities.

FLEXTEC 350X
Construction

FLEXTEC 350X
Standard

FLEXTEC 500X

FLEXTEC 650X



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
10. Shielding Gas Inlet
11. Work Sense Lead
12. Electrode Lead (w/Dinse)

INSIDE VIEW

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

ACCESSORIES

K489-7
Fast-Mate EURO Adapter

K2330-2
Preflow, Postflow and Burnback Timer Kit

Weld Power Cable
Twist Mate to Twist Mate
K14166-1 (70MM2-10M)
K14166-2 (70MM2-15M)
K14166-3 (70MM2-5M)
K14166-4 (70MM2-30M)
K14167-1 (95MM2-30M)
K14167-2 (95MM2-5M)
K14167-3 (95MM2-10M)
K14167-4 (95MM2-15M)

LGS2 MIG/MAG TORCHES
W10429-36-xM
(x = 3; 4; 5 length in m)

K126-11 (15ft 062-332)
K126-12 (15ft 1/16-5/64)
K126™ PRO Innershield® 350A

Steel Wire Drive Roll Kits
Includes: 2 V groove drive rolls and inner wire guide
KP1696-030S .023-.030 (0.6-0.8MM)
KP1696-035S .035 (0.9MM)
KP1696-045S .045 (1.2MM)
KP1696-052S .052 (1.4MM)
KP1696-1/16S 1/16 (1.6MM)
KP1696-1 .035-.045 (0.9, 1.2MM)
KP1696-2 .040 (1.0MM)

Cored Wire Drive Roll Kits
Includes: 2 knurled drive rolls and inner wire guide
KP1697-035C .030-.035" (0.8-0.9MM)
KP1697-045C .040-.045" (1.0-1.2MM)
KP1697-052C .052" (1.4MM)
KP1697-1/16C 1/16" (1.6MM)
KP1697-068 .068-.072" (1.7-1.8MM)
KP1697-5/64 5/64" (2.0MM)
KP1697-3/32 3/32"(2.4MM)

Aluminum Wire Drive Roll Kits
Includes: 2 polished U groove drive rolls, outer wire guide and inner wire guide
KP1695-035A .035" (0.9 MM)
KP1695-040A .040" (1.0MM)
KP1695-3/64A 3/64" (1.2MM)
KP1695-1/16A 1/16" (1.6MM)

R-2013-027-1R & D-1319-010-1R
KIT Quick Gas Connector

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 CE Model	K4267-4	15-115V DC	450A @ 60%	Yes	Twist Mate/ Dinse	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)

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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