

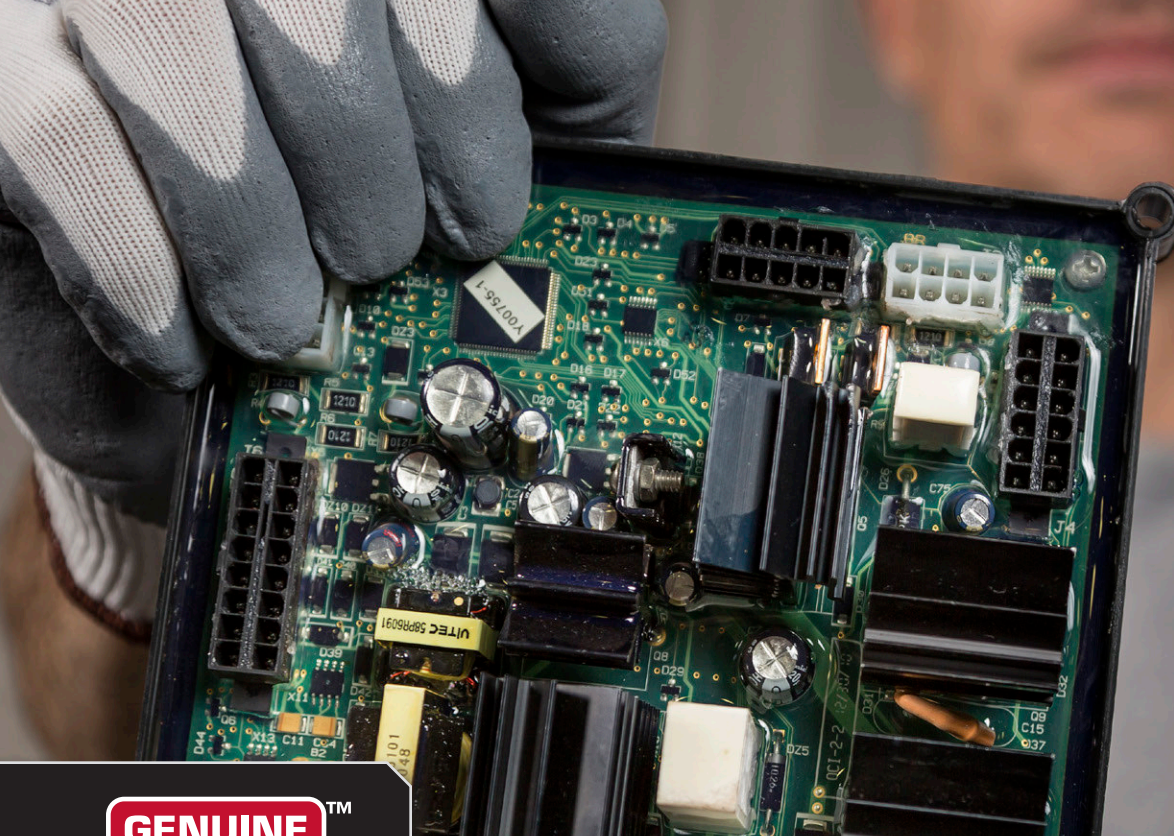


*2014 Welding & Cutting Solutions*

# Parts Guide







**GENUINE**™  
**LINCOLN**  
**PARTS**

## Unrivaled Service.

We are focused on providing you with the very best in service, wherever you are. You can expect:



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Twitter.com/LincolnElectric  
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- ▶ Direct access to welding expert technical support
- ▶ Lincoln Genuine Parts coverage
- ▶ Complimentary software updates at [www.powerwavesoftware.com](http://www.powerwavesoftware.com)

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THE WELDING EXPERTS™

Authorized Parts and Service

### 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.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.



We stand behind our products.  
<http://www.lincolnelectric.com/warranty>

Parts ordering is done electronically - orders placed by 3 PM EST - ship out by 5PM EST.

For machines past the warranty period, our genuine replacements parts have a 1 year warranty.

Some components, such as engines and batteries, warranted by component manufacturers.



Along with online access to operator manuals, service manuals and detailed parts lists, Lincoln Electric has developed several enhanced support channels:

LIVE CHAT: [WWW.LINCOLNELECTRIC.COM](http://WWW.LINCOLNELECTRIC.COM)  
 SERVICE SHOPS: [WWW.LINCOLNELECTRIC.COM/LOCATOR](http://WWW.LINCOLNELECTRIC.COM/LOCATOR)

PROTECT YOUR CUSTOMERS INVESTMENT!  
 Register machine at [lincolnelectric.com/register](http://lincolnelectric.com/register)

## Service Navigator™

For complete parts information on Lincoln Electric products, refer to the online Service Navigator on [mylincolnelectric.com](http://mylincolnelectric.com)

Welding Guides & Safety Materials and more available at [www.lincolnusmarketing.com](http://www.lincolnusmarketing.com)



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All line art is not drawn to scale.

Part numbers beginning with a "KP" are considered "expendable" parts. Expendable parts may be available individually or in bulk packages, depending upon the specific part. KP parts that are bulk packaged are identified with a "B" suffix on the end of the base part number (e.g. KP2010-1B1).

Please note that many of the parts that are bulk packaged are only available for purchase in these bulk quantities. Parts that are only available in bulk packages are identified with an asterisk (\*) and must be ordered in multiples of the "Order Quantity Multiples" number shown in the list (e.g. 10).

# Personal Protection Gear

See Welding Gear Catalog for full product offering



**LINCOLN® STARLITE® CLEAR SAFETY GLASSES**

These sleek, compact indoor glasses are extremely light-weight and durable. The unitary frameless clear lens style provides a wide field of vision, and their light weight make the glasses easy to wear. A special anti-fog coating has been added to reduce lens fogging. Meets ANSI Z87.1+ and CSA Z94.3  
**Order: K2965-1**



**LINCOLN® COVER2® SAFETY GLASSES**

Wear over your own prescription glasses to protect your eyes and eyewear. The lightweight indoor design features ratcheting adjustable-length temples, an integrated brow guard and side shields to offer added impact protection. Meets ANSI Z87.1+ and CSA Z94.3  
**Order: K2968-1**



**BIFOCAL SAFETY GLASSES**

When you need a little help reading or viewing close work, reach for a pair of Bifocal Safety Glasses, available in a choice of popular diopter levels. This models features full eye coverage and added slip-resistant temple tips. Meets ANSI Z87.1

**Order:**  
**K3117-100 1.0 DIOPTER**  
**K3117-150 1.5 DIOPTER**  
**K3117-200 2.0 DIOPTER**  
**K3117-250 2.5 DIOPTER**



**PADDED SAFETY GLASSES**

For long hours on the job, some operators prefer clear safety glasses with a soft non-slip goggle-style strap. This model also features a 360° foam liner to keep dust from your eyes and increase long-term comfort. Meets ANSI Z87.1 and CSA Z94.3  
**Order: K3119-1**



**FACE SHIELD**

Add a face shield to your personal protection arsenal for grinding, polishing, deburring and other operations. This shield features a clear impact resistant shield that wraps around the entire face. Meets ANSI Z87.1 and CSA Z94.3  
**Order: K3120-1**

**REPLACEMENT FACE SHIELD LENS**  
**Order: KP3164-1**



**SHADE 5 CUTTING AND GRINDING GOGGLES**

Select these premium full coverage shade 5 goggles for plasma and oxy-fuel cutting operations and most grinding tasks. These goggles provide a 100% surface seal on your face to keep sparks, spatter particles, sand, dirt and heat away from your eyes. Meets ANSI Z87.1  
**Order: K3118-1**



**SHADE 3 CUTTING AND GRINDING GOGGLES**

Select this industrial shade 3 goggle model for chipping, grinding and machining operations. Protects your face from sparks, spatter, particles, sand, dirt and heat. Meets ANSI Z87.1 and CSA Z94.3.  
**Order: K3118-2**

- Lincoln® Industrial Duffle Bag
- VIKING™ Black 3350 Series Auto-Darkening Helmet
- Shadow™ Split Leather-Sleeved Jacket
- Premium Leather MIG/Stick Welding Gloves
- Full Leather Steelworker® Gloves
- Finish Line™ Clear Safety Glasses
- Split Leather FR Welding Sleeves
- FR Doo Rag

- Order:**  
**K3236-M PREMIUM WELDING GEAR READY-PAK® - MEDIUM**  
**K3236-L PREMIUM WELDING GEAR READY-PAK® - LARGE**  
**K3236-XL PREMIUM WELDING GEAR READY-PAK® - EXTRA LARGE**  
**K3236-2XL PREMIUM WELDING GEAR READY-PAK® - 2X LARGE**



**EVERYTHING A WELDING STUDENT OR OCCASIONAL WELDER NEEDS TO GET STARTED.**

- Lincoln® Industrial Duffle Bag
- VIKING™ Black 1840 Series Auto-Darkening Helmet
- Traditional FR Cloth Jacket
- Traditional MIG/Stick Welding Gloves
- Full Leather Steelworker® Gloves
- Lincoln® Starlite® Clear Safety Glasses
- FR Doo Rag

- Order:**  
**K3105-M TRADITIONAL WELDING GEAR READY-PAK® - MEDIUM**  
**K3105-L TRADITIONAL WELDING GEAR READY-PAK® - LARGE**  
**K3105-XL TRADITIONAL WELDING GEAR READY-PAK® - EXTRA LARGE**  
**K3105-2XL TRADITIONAL WELDING GEAR READY-PAK® - 2X LARGE**



**K3096-1 LINCOLN® INDUSTRIAL DUFFLE BAG (WITHOUT CONTENTS)**





# VIKING™ 3350

## 3350 Series Helmets

Select a 3350 Series helmet to gain protected internal shade control, a generous view size and a standard size cartridge.

- Large U.S. 5.25 x 4.5 in. (133 x 114 mm) Cartridge Size
- Continuously Variable 6-13 Shade with Internal Control
- Continuously Variable Sensitivity and Delay
- Grind Mode
- Magnifying 'Cheater' Lens Capability
- 4 arc sensors
- Solar cells with a replaceable lithium battery
- 3.74 x 3.34 in. (95 x 85 mm) view size
- Hard Hat Adapter Capable
- 3 Year Warranty
- Pivot Style Headgear
- 1/1/1 Improved Optical clarity and enhanced color recognition



**3350 CODE RED™**  
K4034-2

**3350 TRIBAL™**  
K3074-2

**3350 BLACK**  
K3034-2

**TERRACUDA™**  
K3039-2



**MOJO™**  
K3101-2

**3350 ALL AMERICAN™**  
K3175-2

**TWISTED METAL™**  
K3248-2

**POLAR ARC™**  
K3255-2



**MOTORHEAD™**  
K3100-2

# VIKING™ 2450 SERIES

## 2450 Series Helmets

Select a 2450 Series helmet to gain protected internal shade control, a generous view size and a standard size cartridge.

- Large U.S. 5.25 x 4.5 in. (133 x 114 mm) Cartridge Size
- Continuously Variable 9-13 Shade with Internal Control
- Continuously Variable Sensitivity and Delay
- Grind Mode
- Magnifying 'Cheater' Lens Capability
- 4 arc sensors
- Solar cells with two replaceable lithium batteries
- 3.82 x 2.44 in. (97 x 62 mm) view size
- Hard Hat Adapter Capable
- 3 Year Warranty
- Pivot Style Headgear
- 1/1/1 Improved Optical clarity and enhanced color recognition



**STREET ROD™**  
K3035-2

**2450 BLACK**  
K3028-2

**GRAVEYARD SHIFT™**  
K3099-2



**HEAVY METAL™**  
K3029-2

**2450 ALL AMERICAN™**  
K3174-2

**HEMISFEAR™**  
K3030-1



# VIKING™

## VIKING™ 1840 SERIES



TRIBAL™  
K3024-2



JESSI COMBS  
AMP ANGEL™  
K3027-2



1840 BLACK  
K3023-2



1840 ALL  
AMERICAN™  
K3173-2

### 1840 Series Helmets

If you prefer external shade control for on the fly changes, select a compact 1840 Series helmet with a DINS-sized cartridge.

- Compact DINS 110 x 90 mm (4.33 x 3.54 in.) Cartridge Size
- Continuously Variable 9-13 Shade with External Control
- Continuously Variable Sensitivity and Delay
- Grind Mode

- Magnifying 'Cheater' Lens Capability
- 2 arc sensors
- Solar powered with battery assist (non-replaceable)
- 3.78 x 1.85 in. (96 x 47 mm) view size
- Hard Hat Adapter Capable
- 3 Year Warranty
- Pivot Style Headgear
- 1/1/1 Improved Optical clarity and enhanced color recognition

## NEW! VIKING™ 1740 SERIES



1740 BLACK  
K3282-1

### 1740 Series Helmets

Drive down the cost of ownership with a basic 1740 Series helmet.

- Compact DINS 110 x 90 mm (4.33 x 3.54 in.) Cartridge Size
- Continuously Variable 9-13 Shade with Internal Control
- Continuously Variable Sensitivity and Delay
- Grind Mode
- Magnifying 'Cheater' Lens Capability

- 2 Arc Sensors
- Solar powered with two replaceable AAA Alkaline batteries
- 3.78 x 1.67 in. (96 x 42.5 mm) View Size
- Hard Hat Capable
- 1/1/2 Optical Class
- Traditional Style Headgear
- 2 Year Warranty

## VIKING™ 2450D DIGITAL SERIES



2450D BLACK  
K3230-1

### 2450D DIGITAL SERIES AUTO-DARKENING HELMET

Are you ready to go digital? Access three modes – Welding, Cutting and Grind – using an easily understood LCD screen interface. Protected buttons are easy to use with gloved hands. Just one helmet, one cartridge, produces a full spectrum Shade 4-13 with variable sensitivity and delay.

- Large U.S. 5.25 x 4.5 in. (133 x 114 mm) Cartridge Size
- 3.82 x 2.44 in. (97 x 62 mm) View Size
- Large inside LCD screen provides intuitive helmet status information
- Three modes – Welding, Cutting, Grind

- Select Variable Shade 9-13 for Welding and 5-8 for Cutting, each with Variable Sensitivity and Delay
- Grind Mode fixes the helmet in a constant shade 4
- 4 arc sensors
- Solar Cells with two replaceable CR2450 lithium batteries
- Magnifying 'Cheater Lens' Capability
- Hard Hat Adapter Capable
- Optical Class 1/1/1/1

## NEW! PASSIVE INDUSTRIAL



Go old school with our non-electronic welding helmet.

- Low cost, low tech, high value.
- Lens Size – 5.25 x 4.5 in. (133 x 114 mm)
- Shade 10 Lens
- Magnifying 'Cheater' Lens Capability
- Hard Hat Capability
- Traditional Style Headgear
- 2 Year Warranty



### LEATHER TIG WELDING GLOVES

Our supple goat skin leather provides the right fit, sensitive feel and durable construction that precise TIG welding demands. The straight thumb design features welted seams and tough Kevlar® stitching to extend service life.

Size: M, L, XL

Order: K2981-M, K2981-L K2981-XL



### FULL LEATHER STEELWORKER® GLOVES

For fabrication work or light welding. Top grain cowhide leather delivers excellent fit and dexterity while the goat skin back allows the glove to breathe. The palm is padded for comfort and the hook and loop soft rubber tabbed wrist closure with non-constricting elastic band ensures a snug, comfortable fit.

Size: S, M, L, XL, 2XL

Order: K2977-S, K2977-M, K2977-L, K2977-XL, K2977-2XL




### TRADITIONAL MIG/STICK WELDING GLOVES

These general purpose gloves are constructed with heat and flame resistant split cowhide for all types of welding. Inside, the gloves feature a 100% soft sweat absorbent cotton lining for added comfort and heat resistance. Kevlar® stitching and welted seams offer added durability and thumb pads in high wear areas extend the work life of the glove.

Size: One size fits all


Order: K2979-ALL

Hand Sizing for Mens Gloves 		
Label Size	Hand Size in.	Hand Size cm
S	8.0	20
M	8.5	22
L	9.0	23
XL	9.5	24
2XL	10.0	25

### FR WELDING BEANIE

Protect your head with this authorized Lincoln Electric flame retardant beanie. Machine washable. One size fits all.

Order: K2994-L  
K2994-XL

Head Sizing 		
Label Size	Head Circumference Measured	Hat Size
L	22.0-23.0 in. (56-58 cm)	7 - 7 3/8
XL	23.0-24.4 in. (58-61 cm)	7 3/8 - 7 3/4



# VIKING Welding Helmets Replacement Parts

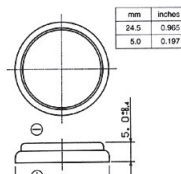
Sales Number	Description	Dimensions	1740 Series	1840 Series	2450 Series	2450D Series	3350 Series	700G Series	750S Series
KP3284-1	1740 SERIES ADF CARTRIDGE	DINS 110 X 90	1	•					
KP2853-2	700G/1840 ADF CARTRIDGE	DINS 110 X 90	1		•			•	
KP2932-2	2450 SERIES ADF CARTRIDGE	STD 4 X 5	1			•		•	
KP3243-2	2450D SERIES ADF CARTRIDGE	STD 4 X 5					•		
KP3045-2	3350 SERIES ADF CARTRIDGE	STD 4 X 5	1					•	
KP2899-1	750S SERIES ADF CARTRIDGE	STD 4 X 5	1						•
KP2897-1	INSIDE CLEAR COVER LENS	96 x 51.6 x 1.0 mm (3.78 x 2.03 x .04 in.)	5	•	•				•
KP2898-1	OUTSIDE CLEAR COVER LENS	114 x 133 x 1.0 mm (4.5 x 5.25 x .04 in.)	5			•	•	•	•
KP2913-1	OUTSIDE CLEAR COVER LENS	112 x 91.3 x 1.5mm (4.41 x 3.59 x .06 in.)	5						•
KP2931-1	INSIDE CLEAR COVER LENS	98.5 x 66.5 x 1.0mm (3.88 x 2.62 x .04 in.)	5			•	•		
KP3043-1	OUTSIDE CLEAR COVER LENS	114 x 100 x 1.5 mm (4.5 x 3.94 x .06 in.)	5	•	•				
KP3044-1	3350 INSIDE CLEAR COVER LENS	94.7 x 89.7 x 1.0 mm (3,73 x 3.53 x .04 in.)	5					•	
KP3046-100	CHEATER LENS 1.00 MAG	2 X 4.25 FRAME, 1.0 MAG	1	•	•	•	•	•	•
KP3046-125	CHEATER LENS 1.25 MAG	2 X 4.25 FRAME, 1.25 MAG	1	•	•	•	•	•	•
KP3046-150	CHEATER LENS 1.50 MAG	2 X 4.25 FRAME, 1.5 MAG	1	•	•	•	•	•	•
KP3046-175	CHEATER LENS 1.75 MAG	2 X 4.25 FRAME, 1.75 MAG	1	•	•	•	•	•	•
KP3046-200	CHEATER LENS 2.00 MAG	2 X 4.25 FRAME, 2.0 MAG	1	•	•	•	•	•	•
KP3046-225	CHEATER LENS 2.25 MAG	2 X 4.25 FRAME, 2.25 MAG	1	•	•	•	•	•	•
KP3046-250	CHEATER LENS 2.50 MAG	2 X 4.25 FRAME, 2.5 MAG	1	•	•	•	•	•	•
KP2930-1	SWEATBAND	N/A	2	•	•	•	•	•	•
KP2854-1	SWEATBAND	N/A	2					•	•
KP3908-1	HEADGEAR W/SWEATBAND	N/A	1		•	•	•	•	
KP2929-1	HEADGEAR W/SWEATBAND	N/A	1	•	•	•	•		
KP2851-1	HEADGEAR W/SWEATBAND	N/A	1					•	•
KP3047-1	HARD HAT ADAPTER	N/A	1	•	•	•	•	•	
S27978-54	BLACK REPLACEMENT SHELL	N/A	1	•	•				
S27978-58	OUTSIDE COVER LENS SEAL	N/A	1	•	•				
S27978-55	ADF HOLDER	N/A	1	•	•				
S27978-31	BLACK REPLACEMENT SHELL	N/A	1			•		•	
S27978-32	OUTSIDE COVER LENS SEAL	N/A	1			•		•	
S27978-33	ADF HOLDER	N/A	1			•		•	

## OPTIONAL ACCESSORIES

Part #	Magnifying "Cheater" Lens	QTY
KP3046-100	CHEATER LENS 1.00 MAGNIFICATION	1
KP3046-125	CHEATER LENS 1.25 MAGNIFICATION	1
KP3046-150	CHEATER LENS 1.50 MAGNIFICATION	1
KP3046-175	CHEATER LENS 1.75 MAGNIFICATION	1
KP3046-200	CHEATER LENS 2.00 MAGNIFICATION	1
KP3046-225	CHEATER LENS 2.25 MAGNIFICATION	1
KP3046-250	CHEATER LENS 2.50 MAGNIFICATION	1
KP3047-1	HARD HAT ADAPTER	1

## BATTERIES

1840, 2450 & 3350 SERIES CR2450 LITHIUM (2 REQUIRED FOR 2450)  
 1740 SERIES - AAA ALKALINE (2 REQUIRED)  
 AVAILABLE AT LOCAL RETAIL



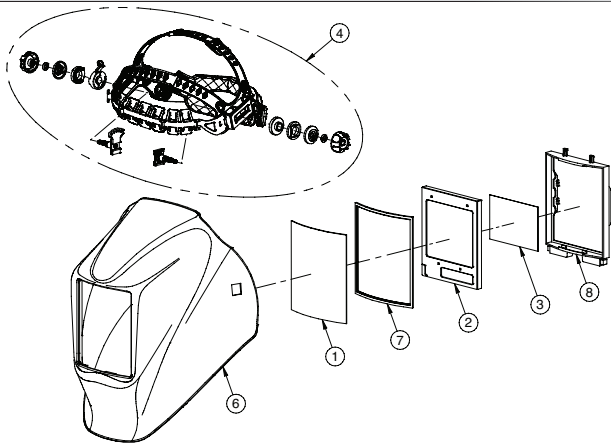
## HARD HAT ADAPTER

KP3047-1 HARD HAT ADAPTER



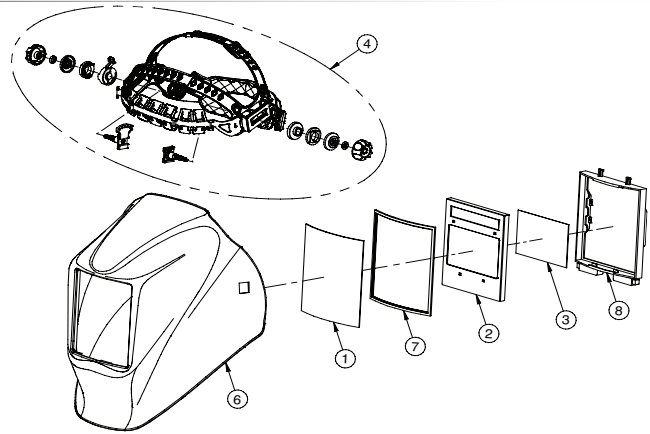


**3350 Series**



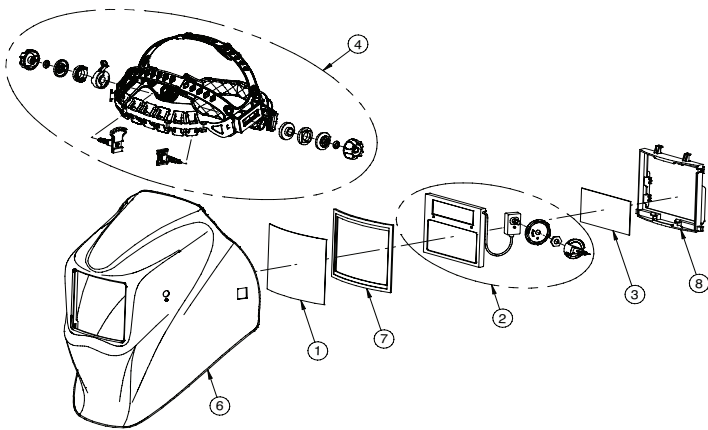
ITEM	Part #	DESCRIPTION	QTY
1	KP2898-1	OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP3045-2	ADF CARTRIDGE	1
3	KP3044-1	INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1	HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1	SWEATBAND (PKG. QTY: 2)	1
6	S27978-31	REPLACEMENT SHELL	1
7	S27978-32	OUTSIDE CLEAR LENS SEAL	1
8	S27978-33	ADF HOLDER	1

**2450 Series**



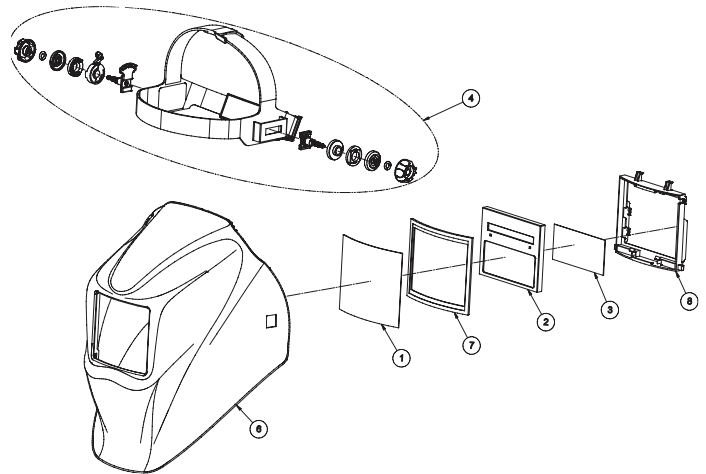
ITEM	Part #	DESCRIPTION	QTY
1	KP2898-1	OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP2932-2	ADF CARTRIDGE	1
3	KP2931-1	INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1	HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1	SWEATBAND (PKG. QTY: 2)	1
6	S27978-31	REPLACEMENT SHELL	1
7	S27978-32	OUTSIDE CLEAR LENS SEAL	1
8	S27978-33	ADF HOLDER	1

**1840 Series**



ITEM	Part #	DESCRIPTION	QTY
1	KP3043-1	OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP2853-2	ADF CARTRIDGE	1
3	KP2897-1	INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1	HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1	SWEATBAND (PKG. QTY: 2)	1
6	S27978-54	REPLACEMENT SHELL	1
7	S27978-58	OUTSIDE CLEAR LENS SEAL	1
8	S27978-55	ADF HOLDER	1

**1740 Series**

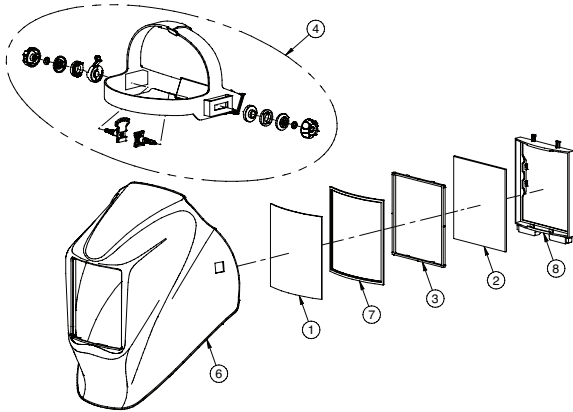


ITEM	Part #	DESCRIPTION	QTY
1	KP3043-1	OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP3284-1	ADF CARTRIDGE	1
3	KP3283-1	INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP2929-1	HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1	SWEATBAND (PKG. QTY: 2)	1
6	S27978-95	REPLACEMENT SHELL	1
7	S27978-58	OUTSIDE CLEAR LENS SEAL	1
8	S27978-55	ADF HOLDER	1

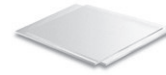


**Passive Industrial 11**

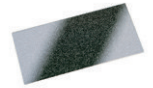
# Ultrashade Helmets



**Deluxe Sweat Band  
KP2081-5B1**



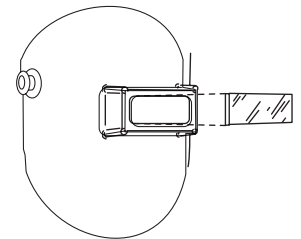
**Clear Outside  
4.5" x 5.25"  
Cover Lens  
KP2324-1B1\***



**Clear Inside  
4.25" x 2.0"  
Cover Lens  
KP2081-3B1\***

\* Part number listed is a package quantity of 10.

ITEM	Part #	DESCRIPTION	QTY
1	KP2898-1	OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP4003-1	SHADE 11 FILTER PLATE	1
3	KP4004-1	RETAINING FRAME	1
4	KP2929-1	HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1	SWEATBAND (PKG. QTY: 2)	1
6	S27978-31	REPLACEMENT SHELL	1
7	S27978-32	OUTSIDE CLEAR LENS SEAL	1
8	S27978-33	ADF HOLDER	1



## Standard Helmets

### HEADSHIELD HELMET LENSES Standard Headshield Lens

Product Name	Product #	Description
Super Visibility Filter Plates	#8 Shade	Tempered Glass. Resists impact & breakage, excellent visibility. Available in shades 8 thru 12 and 14. <sup>(1)(2)</sup>
	#9 Shade	
	#10 Shade	
	#11 Shade	
	#12 Shade	
	#14 Shade	
Clear Cover Plates	KP2106-1	Non-spatter. Clear plastic protects the lens & resists spatter sticking.
	KP2107-1	Plain. Clear, untempered glass protects lens at lower cost.

<sup>(1)</sup>Select shade numbers for headshield lenses to provide comfort and protection while welding. Consult ANSI Z87.1 and ANSI Z49.1.

<sup>(2)</sup>Tested in accordance with Federal Specifications GGG-H-211b or ANSI Z87.1.

# Magnum PRO Gun Expendables



UP TO  
**350A**  
RATED

## Included with Gun:

### K3080-1 Magnum PRO 100L

- ▶ Contact Tips KP2744-025T (Qty 1), KP2744-035T (Qty 1)
- ▶ 1/2 in. (12.7 mm) Thread-On Gas Nozzle Flush (KP3075-1-50F)
- ▶ Thread-on Gasless Nozzle (KP3084-1)
- ▶ Thread-on Diffuser (KP3076-1)
- ▶ Gun Liner (KP45-40-15)
- ▶ Integrated Gun Connector

### K3081-2 Magnum PRO 250L

- ▶ Contact Tips KP2744-035T (Qty 1), KP2744-045T (Qty 1)
- ▶ 1/2 in. (12.7 mm) Thread-on Gas Nozzle Flush (KP2742-1-50F)
- ▶ Thread-on Diffuser (KP2746-1)
- ▶ Gun Liner (KP42-4045-15)
- ▶ Integrated Gun Connector

### Magnum PRO Curve, Magnum PRO 250/350

- ▶ Contact Tip (Qty. 1) (KP2744-045)
- ▶ 0.625 in. (15.9 mm) Thread-On Gas Nozzle with 1/8 in. (3.2 mm) recess (KP2742-1-62R)
- ▶ Thread-On Diffuser (KP2746-1)

### Magnum PRO 450/550

- ▶ Contact Tip (Qty. 1) (KP2745-045)
- ▶ 0.625 in. (15.9 mm) Thread-On Gas Nozzle with 1/8 in. (3.2 mm) recess (KP2743-1-62R)
- ▶ Thread-On Diffuser (KP2747-1)



Magnum® PRO 100L



Magnum® PRO 250L



Magnum® PRO Curve™ Gun



Magnum® PRO Barrel Gun



Gas Diffuser Up To 350 A For Thread-on Nozzles

Thread-on
KP3076-1



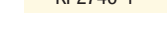
Gas Diffuser Up To 350 A For Thread-on Nozzles

Thread-on Light Duty
KP3141-1



Gas Diffuser 350 A For Thread-on Nozzles

Thread-on Standard Duty
KP2746-1



Gas Diffuser 350 A For Slip-on Nozzles

Slip-on
KP2746-2



Tapered Tip 350 A

Wire Diameter in. (mm)	Tapered Tip Pkg. Qty. - 10
.025 (0.6)	KP2744-025T
.030 (0.8)	KP2744-030T
.035 (0.9)	KP2744-035T
.040 (1.0)	KP2744-040T
.045 (1.2)	KP2744-045T
.052 (1.3)	KP2744-052T
1/16 (1.6)	KP2744-116T
5/64 (2.0)	KP2744-564T



Tapered Tip 350 A

Wire Diameter in. (mm)	Tapered Tip Pkg. Qty. - 10
.025 (0.6)	KP2744-025T
.030 (0.8)	KP2744-030T
.035 (0.9)	KP2744-035T
.040 (1.0)	KP2744-040T
.045 (1.2)	KP2744-045T
.052 (1.3)	KP2744-052T
1/16 (1.6)	KP2744-116T



Standard Tip 350 A

Wire Diameter in. (mm)	Standard Pkg. Qty. - 10
.025 (0.6)	KP2744-025
.030 (0.8)	KP2744-030
.035 (0.9)	KP2744-035
.040 (1.0)	KP2744-040
.045 (1.2)	KP2744-045
.052 (1.3)	KP2744-052
1/16 (1.6)	KP2744-116
5/64 (2.0)	KP2744-564



Gas Nozzle Up To 350 A

Gas Nozzle Diameter in. (mm)				
Thread-on	Nozzle	Qty.	.375 (9.5)	0.5 (12.7)
			Flush	1
Stickout	1/4 (6.4)	1	KP3075-1-38S	KP3075-1-50S



Tapered Thread-On 350 A

Thread-on	Nozzle	Gas Nozzle Diameter in. (mm)	
		Standard 0.375 (9.5)	Standard 0.625 (15.9)
Stickout	1/8 (3.2) Recess	KP2742-1-38R	KP2742-1-62R
	Flush	KP2742-1-38F	KP2742-1-62F
	1/8 (3.2) Stickout	KP2742-1-38S	KP2742-1-62S



Gas Nozzle 350 A 1/8 in. (3.2 mm) Recessed

Thread-on	Nozzle	Gas Nozzle Diameter in. (mm)		
		Standard 0.375 (9.5)	Standard 0.5 (12.7)	Standard 0.625 (15.9)
Stickout	1/8 (3.2) Recess	KP2742-1-38R	KP2742-1-50R	KP2742-1-62R
	Flush	KP2742-1-38F	KP2742-1-50F	KP2742-1-62F
	1/8 (3.2) Stickout	KP2742-1-38S	KP2742-1-50S	KP2742-1-62S
Slip-on	1/8 (3.2) Recess	—	KP2742-2-50R	KP2742-2-62R
	Flush	—	KP2742-2-50F	KP2742-2-62F
	1/8 (3.2) Stickout	—	KP2742-2-50S	KP2742-2-62S



Bottleneck Gas Nozzle 350 A Thread-on 1/8 in. (3.2 mm) Recessed

Thread-on	Bottleneck 0.5 (12.7)	
	KP3160-1-50R	
	KP3160-1-50F	
	KP3160-1-50S	



# UP TO 550A RATED



K126™ PRO  
Innershield® Gun



Magnum® PRO  
Barrel Gun



Magnum® PRO  
Fume Gun



Magnum® PRO  
External Dress Robotic Gun



Magnum® PRO  
Thru-Arm Robotic Gun



Gun Tube Insulator  
550 A

Part #
KP2907-1



Tip Holder 550 A  
Thread-on

Part #
KP2908-1



Contact Tip 550 A

Wire Diameter in. (mm)	Standard Pkg. Qty. - 10	Extended Life Pkg. Qty. - 10
0.035 (0.9)	KP2745-035	KP2745-035R
0.040 (1.0)	KP2745-040	NA
0.045 (1.2)	KP2745-045	KP2745-045R
0.052 (1.3)	KP2745-052	KP2745-052R
1/16 (1.6)	KP2745-116	KP2745-116R
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072R
5/64 (2.0)	KP2745-564	KP2745-564R
3/32 (2.4)	KP2745-332	KP2745-332R
7/64 (2.8)	KP2745-764	KP2745-764R
1/8 (3.2)	KP2745-18	NA



Gas Diffuser 550A  
For Thread-on Nozzles

**Thread-on Standard Duty**

KP2747-1

**Thread-on 1/4 in. Recess**

KP3155-1



Gas Diffuser 550A  
For Slip-on Nozzles

**Slip-on**

KP2747-2



Gun Tube Insulator  
550 A

Part #
KP2773-1



Contact Tip 550 A

Wire Diameter in. (mm)	Standard Pkg. Qty. - 10	Extended Life Pkg. Qty. - 10
0.035 (0.9)	KP2745-035	KP2745-035R
0.040 (1.0)	KP2745-040	NA
0.045 (1.2)	KP2745-045	KP2745-045R
0.052 (1.3)	KP2745-052	KP2745-052R
1/16 (1.6)	KP2745-116	KP2745-116R
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072R
5/64 (2.0)	KP2745-564	KP2745-564R
3/32 (2.4)	KP2745-332	KP2745-332R
7/64 (2.8)	KP2745-764	KP2745-764R
1/8 (3.2)	KP2745-18	NA



Gas Nozzle 550 A Thread-on  
1/8 in. (3.2 mm) Recessed

Gas Nozzle Diameter in. (mm)			
Nozzle		Standard 0.625 (15.9)	Standard 0.750 (19)
Thread-on	1/8 (3.2) Recess Flush	KP2743-1-62R	KP2743-1-75R
	1/8 (3.2) Stickout	KP2743-1-62S	KP2743-1-75S
	1/8 (3.2) Recess Flush	KP2743-2-62R	KP2743-2-75R
Slip-on	1/8 (3.2) Stickout	KP2743-2-62S	KP2743-2-75S



Bottleneck Gas Nozzle 550 A  
Thread-on 1/8 in. (3.2 mm)  
Recessed

Gas Nozzle Diameter in. (mm)		
Nozzle		Bottleneck 0.625 (15.9)
Thread-on	1/8 (3.2) Recess	KP3161-1-62R
	1/8 (3.2) Flush	KP3161-1-62F
	1/8 (3.2) Stickout	KP3161-1-62S

## Fewer Parts. Longer Life.

- Just TWO sets of expendable parts
- Copper Plus™ contact tips with Anti-Seize™ threads have more mass to help dissipate heat and reduce the chances of seizing.

# Magnum PRO 100L and 250L Gun Expendables

Product Name	Product Number	Amperage Rating 40% Duty Cycle	Wire Diameter Range		Cable Length ft. (m)
			CO <sub>2</sub>	in. (mm)	
Magnum <sup>®</sup> PRO 100L	K3080-1	100	.025 - .045	(0.6 - 1.2)	10 (3.0)
Magnum <sup>®</sup> PRO 250L	K3081-2	250	.025 - .045	(0.6 - 1.2)	15 (4.5)

Magnum<sup>®</sup> PRO expendable parts are interchangeable. Interchanging will require gun tube insulator and gas diffuser changes. Customers may choose to change expendable parts to standardize stocking parts or to make the gun more compact for tight spaces.

## Magnum<sup>®</sup> PRO 100L



Tapered Tip

CONTACT TIPS		
Wire Diameter in. (mm)	Tapered Tip	Tapered Tip
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP2744-025T	KP2744-025T-B100
0.030 (0.8)	KP2744-030T	KP2744-030T-B100
0.035 (0.9)	KP2744-035T	KP2744-035T-B100
0.040 (1.0)	KP2744-040T	KP2744-040T-B100
0.045 (1.2)	KP2744-045T	KP2744-045T-B100

GAS DIFFUSER	
Pkg. Qty.	Thread-on
1	KP3076-1
25	KP3076-1-B25



Gas Diffuser for 100L

GAS NOZZLE <sup>(1)</sup>				
Gas Nozzle Diameter in. (mm)				
Thread-on	Nozzle	Pkg. Qty.	.375 (9.5)	0.5 (12.7)
			Flush	1
		25	KP3075-1-38F-B25	KP3075-1-50F-B25
1/4 (6.4) Stickout		1	KP3075-1-38S	KP3075-1-50S
			25	KP3075-1-38S-B25



Gas Nozzle for 100L Thread-on Flush

GASLESS NOZZLE	
Pkg. Qty.	Part #
1	KP3084-1
25	KP3084-1-B25



GUN TUBE	
Gun Tubes	60° Gun Tube
Magnum <sup>®</sup> PRO 100L	KP3082-60



GUN LINER				
Cable Length	Pkg. Qty.	Steel .023-.035 in. (0.6-0.9 mm)	Steel .035-.045 in. (0.9-1.2 mm)	Aluminum .035 in. (0.9 mm)
		15 ft. (4.5 m)	1	KP35-40-15
	10	KP35-40-15-B10	KP45-40-15-B10	—

- (1) When using nozzle sizes less than 5/8 in., tapered tips are recommended.
- (2) Recommended for aluminum wire welding, recommended maximum cable length for aluminum is 10 ft. (3.0 m)
- (3) Standard on Magnum<sup>®</sup> PRO 100L
- (4) Standard on Magnum<sup>®</sup> PRO 250L

## Magnum<sup>®</sup> PRO 250L



Standard Tip



Tapered Tip

CONTACT TIPS				
Wire Diameter in. (mm)	Standard	Standard	Tapered Tip	Tapered Tip
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP2744-025	KP2744-025-B100	KP2744-025T	KP2744-025T-B100
0.030 (0.8)	KP2744-030	KP2744-030-B100	KP2744-030T	KP2744-030T-B100
0.035 (0.9)	KP2744-035	KP2744-035-B100	KP2744-035T	KP2744-035T-B100
0.040 (1.0)	KP2744-040	KP2744-040-B100	KP2744-040T	KP2744-040T-B100
0.045 (1.2)	KP2744-045	KP2744-045-B100	KP2744-045T	KP2744-045T-B100

GAS DIFFUSER	
Pkg. Qty.	Thread-on
1	KP2746-1
25	KP2746-1-B25



Gas Diffuser for 250L Thread-on

GUN TUBE INSULATOR	
Pkg. Qty.	Part #
1	KP2773-2
25	KP2773-2-B25



Gun tube Insulator 250L

GAS NOZZLE <sup>(1)</sup>					
Gas Nozzle Diameter in. (mm)					
Thread-on	Nozzle	Pkg. Qty.	.375 (9.5)	0.5 (12.7)	0.625 (15.9)
			1/8 (3.2) Recess	1	KP2742-1-38R
		25	KP2742-1-38R-B25	KP2742-1-50R-B25	KP2742-1-62R-B25
Flush		1	KP2742-1-38F	KP2742-1-50F	KP2742-1-62F
			25	KP2742-1-38F-B25	KP2742-1-50F-B25
1/8 (3.2) Stickout		1	KP2742-1-38S	KP2742-1-50S	KP2742-1-62S
			25	KP2742-1-38S-B25	KP2742-1-50S-B25



Gas Nozzle for 250L Thread-on 1/2 in. (12 mm) Flush

GUN TUBE		
Gun Tubes	60° Gun Tube	45° Gun Tube
Magnum <sup>®</sup> PRO 250L	KP3078-60	KP3078-45



GUN LINER					
Cable Length	Pkg. Qty.	Steel			Aluminum
		Steel .025-.030 in. (0.6-0.8 mm)	.030-.035 in. (0.8-0.9 mm)	.035-0.45 in. (0.9-1.2 mm)	.035-3/64 in. (0.9-1.2 mm)
15 ft. (4.5 m)	1	KP42-25-15	KP42-3035-15	KP42-4045-15 <sup>(4)</sup>	KP44N-3545-15 <sup>(2)</sup>
	10	—	—	KP42-4045-15-B10	—



# Magnum PRO Fume Gun Expendables

Both 350 and 550 Fume Guns use Magnum® PRO 550 expendables.

GUN CONNECTOR KIT			
Manufacturer	Wire Feeder Model	Magnum® PRO Fume 350	Magnum® PRO Fume 550
	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8	K613-6
Lincoln Electric	LF-72, LF-74 Series, LN-25 PRO	K466-10	K613-7 <sup>(1)</sup>
	Power Feed™ 10 and 25 series	K466-10	K613-7 <sup>(1)</sup>
	POWER MIG® Series and Power Wave® C300	K466-6	NA
Tweco Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2	K613-2
Miller	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	K466-3	K613-3



K466-10 Shown

(1) K1500-3 Gun Receiver Bushing is required for Power Feed 10 series, LF series and LN-25 PRO wire feeders.

MAGNUM® PRO FUME 350 GUN LINER in. (mm)		
.035-.045 (0.9-1.2)	.052-1/16 (1.3-1.6)	1/16-5/64 (1.6-2.0)
KP44-3545-15	KP44-116-15	KP44-564-15

MAGNUM® PRO FUME 550 GUN LINER in. (mm)			
.035-.045 (0.9-1.2)	.052-1/16 (1.3-1.6)	5/64-3/32 (2.0-2.4)	7/64-1/8 (2.8-3.2)
KP45-3545-15	KP45-116-15	KP45H-332-15	KP45-18-15



Contact Tip for up to 550 A

CONTACT TIPS 550 A				
Wire Diameter in. (mm)	Standard	Standard	Extended Life	Extended Life
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP2745-035	KP2745-035-B100	KP2745-035R	KP2745-035R-B100
0.040 (1.0)	KP2745-040	KP2745-040-B100	NA	NA
0.045 (1.2)	KP2745-045	KP2745-045-B100	KP2745-045R	KP2745-045R-B100
0.052 (1.3)	KP2745-052	KP2745-052-B100	KP2745-052R	KP2745-052R-B100
1/16 (1.6)	KP2745-116	KP2745-116-B100	KP2745-116R	KP2745-116R-B100
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072-B100	KP2745-072R	KP2745-072R-B100
5/64 (2.0)	KP2745-564	KP2745-564-B100	KP2745-564R	KP2745-564R-B100
3/32 (2.4) <sup>(1)</sup>	KP2745-332	KP2745-332-B100	KP2745-332R	KP2745-332R-B100
7/64 (2.8) <sup>(1)</sup>	KP2745-764	KP2745-764-B100	KP2745-764R	KP2745-764R-B100
1/8 (3.2) <sup>(1)</sup>	KP2745-18	KP2745-18-B100	NA	NA

DIFFUSERS 550 A		
Type		
Pkg Qty.	Thread on	Slip on
1	KP2747-1	KP2747-2
25	KP2747-1-B25	KP2747-2-B25



Gas Diffuser Slip-on



Gas Diffuser Thread-on

GAS NOZZLE 550 A			
Nozzle Diameter (I.D.)			
	Nozzle in. (mm)	Pkg. Qty.	0.625(5/8) in. (15.9 mm)
	Thread-on	1/8 (3.2) Recess	1
25			KP2743-1-62R-B25
Flush		1	KP2743-1-62F
		25	KP2743-1-62F-B25
Slip-on	1/8 (3.2) Stickout	1	KP2743-1-62S
		25	KP2743-1-62S-B25
	1/8 (3.2) Recess	1	KP2743-2-62R
		25	KP2743-2-62R-B25
Flush	1	KP2743-2-62F	
	25	KP2743-2-62F-B25	
1/8 (3.2) Stickout	1	KP2743-2-62S	
	25	KP2743-2-62S-B25	



Nozzle Thread-on 1/8" Recessed

(1) 550 only

GUN TUBE INSULATORS 550 A	
Pkg Qty.	Part #
1	KP2773-1
25	KP2773-1-B25



Gun Tube Insulator

## OPTIONAL PARTS

TRIGGER KIT	
Description	Part #
Locking Trigger Kit	KP2870-1



SMOKE EXTRACTOR NOZZLES MAGNUM® PRO	
Nozzle	Part #
GMAW Fume Extractor Nozzle	KP2871-1
FCAW Fume Extractor Nozzle	KP2872-1 <sup>(1)</sup>

(1) Standard with gun

# Magnum Gun Contact Tips

## CONTACT TIPS

### CONTACT TIPS 100 A

Wire Diameter in. (mm)	Standard		Tapered	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP11-25	KP11-25-B100	KP11T-25	—
0.030 (0.8)	KP11-30	KP11-30-B100	KP11T-30	—
0.035 (0.9)	KP11-35	KP11-35-B100	KP11T-35	—
0.035 (0.9) Aluminum	KP2078-1B1 <sup>(1)</sup>	—	—	—
0.045 (1.2)	KP11-45	KP11-45-B100	KP11T-45	—



Tapered



Heavy Duty



Standard Duty

<sup>(1)</sup> Recommended for aluminum wire welding.

### CONTACT TIPS 200 A and 250 A

Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 <sup>(1)</sup>	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 <sup>(1)</sup>	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 <sup>(1)</sup>	KP14A-364-B100 <sup>(1)</sup>	KP14AH-364 <sup>(1)</sup>	KP14AH-364-B100 <sup>(1)</sup>	—	—	KP2010-5B1 <sup>(1)</sup>	—

<sup>(1)</sup> Recommended for aluminum wire welding.

### CONTACT TIPS 300 A and 400 A

Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 <sup>(1)</sup>	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 <sup>(1)</sup>	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 <sup>(1)</sup>	KP14A-364-B100 <sup>(1)</sup>	KP14AH-364 <sup>(1)</sup>	KP14AH-364-B100 <sup>(1)</sup>	—	—	KP2010-5B1 <sup>(1)</sup>	—
0.052 (1.3)	KP14-52	KP14-52-B100	KP14H-52	KP14H-52-B100	KP14T-52	KP14T-52-B100	—	—
1/16 (1.6)	KP14-116	KP14-116-B100	KP14H-116	KP14H-116-B100	KP14T-116	—	—	—
5/64 (2.0)	KP14-564	—	KP14H-564	—	—	—	—	—

<sup>(1)</sup> Recommended for aluminum wire welding.

### CONTACT TIPS 500 A

Wire Diameter in. (mm)	Solid Wire, Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP15H-35	—
0.045 (1.2)	KP15H-45	—
0.052 (1.3)	KP15H-52	—
1/16 (1.6)	KP15H-116	—
5/64 (2.0)	KP15H-564	—
3/32 (2.4)	KP15H-332	—

### CONTACT TIPS 600 A

Wire Diameter in. (mm)	Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP16S-35	—
0.045 (1.2)	KP16S-45	—
0.052 (1.3)	KP16S-52	—
1/16 (1.6)	KP16S-116	KP16S-116-B100
5/64 (2.0)	KP16S-564	KP16S-564-B100
3/32 (2.4)	KP16S-332	KP16S-332-B100
7/64 (2.8)	KP16S-764	—
1/8 (3.2)	KP16S-18	—



# Magnum Gun Gas Nozzles and Insulators



Insulator

Coarse Thread  
Gas NozzleAdjustable Slip-On  
Gas Nozzle

GAS NOZZLES 100 A				
Nozzle	Pkg. Qty.	.37 Nozzle Diameter	.50 Nozzle Diameter	.625 Nozzle Diameter
Fixed Flush	1	—	KP21-50-F	—
Fixed Recessed	1	KP21T-37	KP21T-50	KP21T-62
Gasless Nozzle	1	KP1939-1	—	—
Spot Nozzle	1	—	—	KP21-62-FAS

GAS NOZZLES 200 A				
Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter
Adjustable Slip-On	1	KP22-37	KP22-50	KP22-62
Adjustable Slip-On	25	KP22-37-B25	KP22-50-B25	KP22-62-B25
Gasless Nozzle	1	KP1947-1	KP1947-1	KP1947-1
Spot Nozzle	1	KP21-62-FAS	KP21-62-FAS	KP21-62-FAS

GAS NOZZLES 300 A and 400 A					
Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter	.75 Nozzle Diameter
Adjustable Slip-On	1	—	KP24A-50	KP24A-62	—
Adjustable Slip-On	25	—	KP24A-50-B25	KP24A-62-B25	—
Slip-On Recessed	1	KP24A-37-SS	KP24A-50-SS	KP24A-62-SS	—
Slip-On Recessed	25	—	—	KP24A-62-SS-B25	—
Coarse Thread/Tip Recessed 1/8 in.	1	—	—	KP24CT-62-S	KP24CT-75-S
Coarse Thread/Tip Recessed 1/8 in.	25	—	—	KP24CT-62-S-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	—	—	KP24CT-62-R	KP24CT-75-R
Coarse Thread/Tip Recessed 1/4 in.	25	—	—	KP24CT-62-R-B25	—
Fixed Recessed	1	KP23-37	KP23-50	KP23-62	KP23-75
Fixed Recessed	25	KP23-37-B25	KP23-50-B25	KP23-62-B25	—
Fixed Tapered	1	KP23T-37	—	—	—
Fixed Tapered	25	KP23T-37-B25	—	—	—
Fixed Heavy Duty	1	—	—	KP23H-62	—
Fixed Heavy Duty	25	—	—	KP23H-62-B25	—
Fixed Flush	1	—	KP23-50F	KP23-62F	—
Fixed Flush	25	—	KP23-50F-B25	KP23-62F-B25	—

GAS NOZZLES 600 A				
Nozzle	Pkg. Qty.	.62 Nozzle Diameter	.75 Nozzle Diameter	.88 Nozzle Diameter
Coarse Thread/Tip Recessed 1/8 in.	1	KP26CT-62	KP26CT-75	—
Coarse Thread/Tip Recessed 1/8 in.	25	—	KP26CT-75-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	KP26CT-62-R	KP26CT-75-R	—
Self-Insulated/Tip Recessed 1/4 in.	1	—	KP26I-75	—

INSULATORS				
Nozzle	Pkg. Qty.	200 Amp	300 and 400 Amp	600 Amp
Adjustable Slip-On	1	KP32	—	—
Adjustable Slip-On	25	KP32-B25	—	—
Adjustable Slip-On	1	—	KP34A	—
Adjustable Slip-On	25	—	KP34A-B25	—
Coarse Thread	1	—	KP34CT	—
Coarse Thread	25	—	KP34CT-B25	—
Coarse Thread	1	—	—	KP36CT
Coarse Thread	25	—	—	KP36CT-B25

# Magnum Gun Gas Diffusers

GAS DIFFUSERS 100 A	
Pkg. Qty.	.025-.045 in. (0.6-1.2 mm)
1	KP35-50
25	—



100 A



200 A and 250 A



300 A and 400 A



600 A

GAS DIFFUSERS 200 A			
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
1	KP52-23	KP52FN	KP2051-1 <sup>(2)</sup> or KP52FN <sup>(1)</sup>
25	—	KP52FN-B25	KP2051-1B1 <sup>(2)</sup> or KP52FN-B25 <sup>(1)</sup>

GAS DIFFUSERS 250 A				
Nozzle	Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
For Adjustable Slip-On Nozzle	1	KP52-23	KP52	—
For Adjustable Slip-On Nozzle	25	—	KP52-B25	—
For Fixed Nozzle	1	KP2051-1	KP52FN	KP52FN
For Fixed Nozzle	25	—	KP52FN-B25	—
Specialty	1	KP2051-1	—	KP2051-1 <sup>(3)</sup>
Specialty	25	—	—	KP2051-1B1

GAS DIFFUSERS 300 A and 400 A		
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-5/64 in. (0.9-2.0 mm)
1	KP2024-2 <sup>(1)</sup>	KP54A
25	—	KP54A-B25

<sup>(1)</sup> Use KP42-25-x liner with this diffuser when feeding .025-.030 in. wire.

GAS DIFFUSERS 600 A		
Pkg. Qty.	.035-1/16 in. (0.9-1.6 mm)	5/64-1/8 (2.0-3.2 mm)
1	KP56S-SW	KP56S-H
25	—	KP56S-H-B10

<sup>(1)</sup> Permits use of 300 and 400 amp fixed nozzles with 200 amp gun and cable.

<sup>(2)</sup> Permits use of 100 amp contact tips with 200 amp gun and cable.

<sup>(3)</sup> Permits use of 100 amp contact tips and nozzles with Magnum<sup>®</sup> 250L gun tube.



# Recommended Replacement Guns

## COMMERCIAL / LIGHT INDUSTRIAL WIRE FEED WELDERS

Machine Name	Gun Name	Gun Part #	Page
POWER MIG 140**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 140C**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 140T**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 180**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 180C**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 180T**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 180 Dual**	Magnum PRO 100L	<b>K3080-1</b>	18
POWER MIG 200	Magnum 250L	<b>K533-7</b>	25
POWER MIG 215	Magnum 250L	<b>K533-7</b>	25
POWER MIG 216***	Magnum PRO 250L	<b>K3081-2</b>	18
POWER MIG 255	Magnum 250L	<b>K533-7</b>	25
POWER MIG 255XT***	Magnum PRO 250L	<b>K3081-2</b>	18
POWER MIG 256***	Magnum PRO 250L	<b>K3081-2</b>	18
POWER MIG 300	Magnum 300	<b>K470-2</b>	25
POWER MIG 350MP****	Magnum PRO Curve 300	<b>K2951-2-6-45</b>	18
PowerWave C300****	Magnum PRO Curve 300	<b>K2951-2-10-45</b>	18
SP-100	Magnum 100L	<b>K530-5</b>	25
SP-100-I	Magnum 100L	<b>K530-5</b>	25
SP-100T	Magnum 100L	<b>K530-5</b>	25
SP-125 Plus	Magnum 100L	<b>K530-5</b>	25
SP-130T	Magnum 100L	<b>K530-5</b>	25
SP-135 Plus	Magnum 100L	<b>K530-5</b>	25
SP-135T	Magnum 100L	<b>K530-5</b>	25
SP-140-I	Magnum 100L	<b>K530-5</b>	25
SP-150	SP-150	<b>K497-1 &amp; S19729</b>	-
SP-140T	Magnum100L	<b>K530-6</b>	25
SP-170	Magnum 100L	<b>K530-5</b>	25
SP-170-I	Magnum 100L	<b>K530-5</b>	25
SP-170T	Magnum 100L	<b>K530-5</b>	25
SP-175 Plus	Magnum 100L	<b>K530-5</b>	25
SP-175T	Magnum 100L	<b>K530-5</b>	25
SP-180T	Magnum 100L	<b>K530-6</b>	25
SP-200	Magnum 200L	<b>K497-1 &amp; S19729</b>	25
SP-255	Magnum 250SP	<b>K524-5</b>	25
Wire-Matic 255	Magnum 250L	<b>K533-7</b>	25

\*\* Earlier models were sold with the K530-6 Magnum 100L. See Page 28.

\*\*\* Earlier models were sold with the K533-7 Magnum 250L. See Page 28.

\*\*\*\* Earlier models were sold with the K470-2 Magnum 300. See Page 30.

## RETAIL WIRE FEED WELDERS

Machine Name	Gun Name	Gun Part #	Page
Easy-Core 125	Magnum 100L	<b>K530-6</b>	25
Easy-Core 140	Magnum 100L	<b>K530-6</b>	25
Easy-Core 180	Magnum 100L	<b>K530-6</b>	25
Handy Core	Hard wired internally	<b>S25532-11</b>	-
Handy MIG (Early Design)	Hard wired internally	<b>S25351-11</b>	-
Handy MIG (Present Design)	Hard wired internally	<b>S25695-11</b>	-
Hand Core 100	Hard wired internally	<b>S24355-16</b>	-
Handymig 170i	Magnum 100L	<b>K530-5</b>	25
MIG Pak 10	Magnum 100L	<b>K530-5</b>	25
MIG Pak 15	Magnum 100L	<b>K530-5</b>	25
MIG Pak 140	Magnum 100L	<b>K530-6</b>	25
MIG-Pak 180	Magnum 100L	<b>K530-6</b>	25
MIG Pak HD	Hard wired internally	<b>S25695-11</b>	-
Pro 100	Magnum 100L	<b>K530-5</b>	25
Pro 155	Magnum 100L	<b>K530-5</b>	25
Pro-Core 100	Magnum 100L	<b>K530-3</b>	25
Pro-Core 125	Magnum 100L	<b>K530-6</b>	25
Pro-MIG 135	Magnum 100L	<b>K530-5</b>	25
Pro-MIG 140	Magnum 100L	<b>K530-6</b>	25
Pro-MIG 175	Magnum 100L	<b>K530-5</b>	25
Pro MIG 180	Magnum 100L	<b>K530-6</b>	25
Quick Weld	Hard wired internally	<b>S25532-11</b>	-
Weldmark 135 Plus	Magnum 100L	<b>K530-5</b>	25
Weld-Pak 100	Magnum 100L	<b>K530-3</b>	25
Weld-Pak 125HD	Magnum 100L	<b>K530-6</b>	25
Weld-Pak 140HD	Magnum 100L	<b>K530-6</b>	25
Weld-Pak 100HD	Magnum 100L	<b>K530-3</b>	25
Weld-Pak 125	Magnum 100L	<b>K530-3</b>	25
Weld-Pak 155	Magnum 100L	<b>K530-3</b>	25
Weld Pak 175HD	Magnum 100L	<b>K530-3</b>	25
Weld Pak 180HD	Magnum 100L	<b>K530-3</b>	25
Weld-Pak 3200HD	Magnum 100L	<b>K530-5</b>	25
Weld-Pak 5000HD	Magnum 100L	<b>K530-3</b>	25
Weld-Pak HD	Hard wired internally	<b>S25532-11</b>	-
Work-Pak 125	Magnum 100L	<b>K530-6</b>	25

NOTE: 'Magnum PRO' series guns may be used in place of the older Magnum guns but Magnum PRO consumables are not compatible with older Magnum guns.

# Magnum PRO Guns



**Order a Ready Pak® with everything you need**

Product Name	Product Number	Amperage Rating @ Duty Cycle		Wire Diameter Range		Cable Length ft. (m)
		100% CO <sub>2</sub>	Mixed	In.	(mm)	
Magnum® PRO 100L (with Integrated Gun Connector)	<b>K3080-1</b>	100 @ 40%	-	.025 - 3/64 <sup>(1)</sup>	(0.6 - 1.2)	10 (3.0)
Magnum® PRO 250L® (with Integrated Gun Connector)	<b>K3081-1</b>	250 @ 40%	-	.025 - 3/64 <sup>(1)</sup>	(0.6 - 1.2)	15 (4.5)
Magnum® PRO Curve™ 200 Ready-Pak® (with K466-10 Gun Connector)	<b>K2950-2-10-45</b>	200 @ 60%	150 @ 60%	.025 - 3/64 <sup>(1)</sup>	(0.6 - 1.2)	15 (4.5)
Magnum® PRO Curve™ 300 Ready-Pak® (with K466-6 Gun Connector)	<b>K2951-2-6-45</b>	300 @ 60%	200 @ 60%	.025 - 5/64 <sup>(1)</sup>	(0.6 - 2.0)	15 (4.5)
Magnum® PRO Curve™ 300 Ready-Pak® (with K466-10 Gun Connector)	<b>K2951-2-10-45</b>	300 @ 60%	200 @ 60%	.025 - 5/64 <sup>(1)</sup>	(0.6 - 2.0)	15 (4.5)
Magnum® PRO Curve™ 300 Ready-Pak® (with K466-10 Gun Connector)	<b>K2951-2-10-116</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
Magnum® PRO Curve™ 400 Ready-Pak® (with K466-10 Gun Connector)	<b>K2952-2-10-45</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64 <sup>(1)</sup>	(0.6 - 2.0)	15 (4.5)
Magnum® PRO 250 Ready-Pak® (with K466-6 Gun Connector)	<b>K2651-2-6-45</b>	250 @ 100%	250 @ 100%	.035 - 5/64 <sup>(1)</sup>	(0.9 - 2.0)	15 (4.5)
Magnum® PRO 350 Ready-Pak® (with K466-10 Gun Connector)	<b>K2652-2-10-45</b>	350 @ 100%	285 @ 100%	.035 - 5/64 <sup>(1)</sup>	(0.9 - 2.0)	15 (4.5)
Magnum® PRO 450 Ready-Pak® (with K466-10 Gun Connector)	<b>K2653-2-10-45</b>	450 @ 100%	325 @ 100%	.035 - 5/64 <sup>(1)</sup>	(0.9 - 2.0)	15 (4.5)



Nozzle



Contact Tip



Diffuser



Insulator



Gooseneck

Gun Connector





...Or follow the next steps to customize your Magnum® PRO Gun.

# STEP 1

## Choose Your Model

Product Name	Product Number	Amperage Rating @ Duty Cycle		Wire Diameter Range		Cable Length ft. (m)
		100% CO <sub>2</sub>	Mixed	In.	(mm)	
<b>Semi Automatic GMAW/FCAW-GS</b>						
Magnum® PRO Curve™ 200	<b>K2950-1</b>	200 @ 60%	150 @ 60%	.025 - 3/64	(0.6 - 1.2)	10 (3.0)
	<b>K2950-2</b>	200 @ 60%	150 @ 60%	.025 - 3/64	(0.6 - 1.2)	15 (4.5)
Magnum® PRO Curve™ 300	<b>K2951-1</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K2951-2</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K2951-3</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K2951-4</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 300 Dual Procedure (Switch Control)	<b>K3130-1</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K3130-2</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K3130-3</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K3130-4</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 300 Dual Schedule (Trigger Control)	<b>K3092-1</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K3092-2</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K3092-3</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K3092-4</b>	300 @ 60%	200 @ 60%	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 400	<b>K2952-1</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K2952-2</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K2952-3</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K2952-4</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 400 Dual Procedure (Switch Control)	<b>K3098-1</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K3098-2</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K3098-3</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K3098-4</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 400 Dual Schedule (Trigger Control)	<b>K3093-1</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K3093-2</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K3093-3</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K3093-4</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	25 (7.6)
Magnum® PRO Curve™ 400A Short Neck	<b>K3055-1</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	10 (3.0)
	<b>K3055-2</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	15 (4.5)
	<b>K3055-3</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	20 (6.1)
	<b>K3055-4</b>	400 @ 60%	400 @ 50% DC	.025 - 5/64	(0.6 - 2.0)	25 (7.6)

continued

# Magnum PRO Guns

## Choose Your Model - continued

Product Name	Product Number	Amperage Rating @ Duty Cycle		Wire Diameter Range		Cable Length ft. (m)
		100% CO <sub>2</sub>	Mixed	In.	(mm)	
Magnum® PRO 250	K2651-1	250 @ 100%	250 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K2651-2	250 @ 100%	250 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K2651-3	250 @ 100%	250 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K2651-4	250 @ 100%	250 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 350	K2652-1	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K2652-2	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K2652-3	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K2652-4	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 350 Dual Procedure (Switch Control)	K3131-1	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K3131-2	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K3131-3	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K3131-4	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 350 Dual Schedule (Trigger Control)	K3132-1	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K3132-2	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K3132-3	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K3132-4	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 450	K2653-1	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K2653-2	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K2653-3	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K2653-4	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 450 Dual Procedure (Switch Control)	K3133-1	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K3133-2	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K3133-3	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K3133-4	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 450 Dual Schedule (Trigger Control)	K3134-1	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	10 (3.0)
	K3134-2	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
	K3134-3	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	20 (6.1)
	K3134-4	450 @ 100%	325 @ 100%	.035 - 5/64	(0.9 - 2.0)	25 (7.6)
Magnum® PRO 550	K2655-1	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	10 (3.0)
	K2655-2	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	15 (4.5)
	K2655-3	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	20 (6.1)
	K2655-4	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	25 (7.6)
Magnum® PRO 550 Dual Procedure (Switch Control)	K3135-1	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	10 (3.0)
	K3135-2	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	15 (4.5)
	K3135-3	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	20 (6.1)
	K3135-4	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	25 (7.6)
Magnum® PRO 550 Dual Schedule (Trigger Control)	K3136-1	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	10 (3.0)
	K3136-2	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	15 (4.5)
	K3136-3	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	20 (6.1)
	K3136-4	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	25 (7.6)
<b>Semi Automatic Fume</b>						
Magnum® PRO Fume 350	K2649-1	350 @ 100%	285 @ 100%	.035 - 5/64	(0.9 - 2.0)	15 (4.5)
Magnum® PRO Fume 550	K2650-1	550 @ 100%	375 @ 100%	.035 - 1/8	(0.9 - 3.2)	15 (4.5)
<b>Semi Automatic FCAW-S (Innershield®)</b>						
K126™ PRO	K126-10	350 @ 60% <sup>(2)</sup>	—	.035 - .120	(0.9 - 3.0)	10 (3.0)
	K126-11	350 @ 60% <sup>(2)</sup>	—	.035 - .120	(0.9 - 3.0)	15 (4.5)
	K126-12	350 @ 60% <sup>(2)</sup>	—	.035 - .120	(0.9 - 3.0)	15 (4.5)
	K126-13	350 @ 60% <sup>(2)</sup>	—	.035 - .120	(0.9 - 3.0)	15 (4.5)

(2) K126™ PRO is a gasless Innershield® FCAW-S gun

continued

# Magnum PRO Guns

## Choose Your Model - continued

Product Name	Product Number	Amperage Rating @ Duty Cycle		Wire Diameter Range		Cable Length ft. (m)
		100% CO <sub>2</sub>	Mixed	In.	(mm)	
<b>Robotic</b>						
<b>External Dress Air Cooled</b>						
Magnum® PRO Robotic 550	<b>K2647-4</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	4 (1.2)
Magnum® PRO Robotic 550	<b>K2647-5L</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	5.5 (1.7)
Magnum® PRO Robotic 550	<b>K2647-8</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	8 (2.4)
Magnum® PRO Robotic 550	<b>K2647-11</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	11 (3.3)
<b>Thru-Arm Air Cooled</b>						
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-100iC</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	Predetermined length per robot arm selection
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-100iCW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-120iC</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-120iCW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-100iC/6L</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-100iC/6LW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-120iC/10L</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550	<b>K3353-120iC/10LW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
<b>Thru-Arm Air Cooled Ready-Pak® Packages</b>						
Magnum® PRO Thru-Arm Robotic 550 (100iC)	<b>K3359-100iC</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	Predetermined length per robot arm selection
Magnum® PRO Thru-Arm Robotic 550 (100iC) w/air blast	<b>K3359-100iCA</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (100iC) w/wire brake	<b>K3359-100iCW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (100iC/6L)	<b>K3359-100iC/6L</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (100iC/6L) w/air blast	<b>K3359-100iC/6LA</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (100iC/6L) w/wire brake	<b>K3359-100iC/6LW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC)	<b>K3359-120iC</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC) w/air blast	<b>K3359-120iCA</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC) w/wire brake	<b>K3359-120iCW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC/10L)	<b>K3359-120iC/10L</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC/10L) w/air blast	<b>K3359-120iC/10LA</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	
Magnum® PRO Thru-Arm Robotic 550 (120iC/10L) w/wire brake	<b>K3359-120iC/10LW</b>	550 @ 100%		.035 - 5/64	(0.9 - 2.0)	



# STEP 2

## Choose Your Gun Connector Kit

Manufacturer	Wire Feeder Model	Magnum® PRO Curve™ 200/300/400	Magnum® PRO Barrel 250/350/450	Magnum® PRO Barrel 550	Magnum® PRO Fume 350	Magnum® PRO Fume 550	K126™ PRO Innershield®	
							For Small Feeder Bushings	For Large Feeder Bushings
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	<b>K466-1</b>	<b>K466-1</b>	<b>K613-1</b>	<b>K466-1</b>	<b>K613-1</b>	<b>K466-1</b>	<b>K613-1</b>
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	<b>K466-8</b>	<b>K466-8</b>	<b>K613-6</b>	<b>K466-8</b>	<b>K613-6</b>	<b>K466-8</b>	<b>K613-6</b>
	LF-72, LF-74 Series, LN-25 PRO, Activ8™	<b>K466-10</b>	<b>K466-10</b>	<b>K613-7<sup>(3)</sup></b>	<b>K466-10</b>	<b>K613-7<sup>(3)</sup></b>	<b>K466-10</b>	<b>K613-7</b>
	Power Feed® 10 and 25 series	<b>K466-10</b>	<b>K466-10</b>	<b>K613-7<sup>(3)</sup></b>	<b>K466-10</b>	<b>K613-7<sup>(3)</sup></b>	<b>K466-10</b>	<b>K613-7</b>
	POWER MIG® Series and Power Wave® C300	<b>K466-6</b>	<b>K466-6</b>	<b>NA</b>	<b>K466-6</b>	<b>NA</b>	<b>K466-6</b>	
Tweco®	Adapted No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	<b>K466-2</b>	<b>K466-2</b>	<b>K613-2</b>	<b>K466-2</b>	<b>K613-2</b>	<b>K466-2</b>	<b>K613-2</b>
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	<b>K466-3</b>	<b>K466-3</b>	<b>K613-3</b>	<b>K466-3</b>	<b>K613-3</b>	<b>K466-3</b>	<b>K613-3</b>



(3) K1500-3 Gun Receiver Bushing is required for Power Feed® 10 series, LF series and LN-25 PRO wire feeders.

# STEP 3

## Choose Your Gun Liner

Diameter in. (mm)	Magnum® PRO Curve™ 200	Magnum® PRO Curve™ 300/400	Magnum® PRO Barrel 250/350/450	Magnum® PRO Barrel 550	Magnum® PRO Fume 350	Magnum® PRO Fume 550	K126™ PRO Innershield®	
							K466 Series Gun Connector	K613 Series Gun Connector
.025-.030 (0.6-0.8)	15ft (4.5m) - KP42-25-15							
.030-.035 (0.8-0.9)	15ft (4.5m) - KP42-3035-15							
.035-.045 (0.9-1.2)	15ft (4.5m) - KP42-4045-15	15ft (4.5m) - KP44-3545-15 26ft (7.6m) - KP44-3545-25	15ft (4.5m) - KP44-3545-15 26ft (7.6m) - KP44-3545-25	15ft (4.5m) - KP45-3545-15 26ft (7.6m) - KP45-3545-25	15ft (4.5m) - KP44-3545-15 26ft (7.6m) - KP44-3545-25	15ft (4.5m) - KP45-3545-15 26ft (7.6m) - KP45-3545-25	15ft (4.5m) - KP44-3545-15 26ft (7.6m) - KP44-3545-25	15ft (4.5m) - KP45-3545-15 26ft (7.6m) - KP45-3545-25
.052-1/16 (1.3-1.6)		15ft (4.5m) - KP44-116-15 26ft (7.6m) - KP44-116-25	15ft (4.5m) - KP44-116-15 26ft (7.6m) - KP44-116-25	15ft (4.5m) - KP45-116-15 26ft (7.6m) - KP45-116-25	15ft (4.5m) - KP44-116-15 26ft (7.6m) - KP44-116-25	15ft (4.5m) - KP45-116-15 26ft (7.6m) - KP45-116-25	15ft (4.5m) - KP44-116-15 26ft (7.6m) - KP44-116-25	15ft (4.5m) - KP45-116-15 26ft (7.6m) - KP45-116-25
1/16-5/64 (1.6-2.0)		15ft (4.5m) - KP44-564-15 26ft (7.6m) - KP44-564-25	15ft (4.5m) - KP44-564-15 26ft (7.6m) - KP44-564-25		15ft (4.5m) - KP44-564-15 26ft (7.6m) - KP44-564-25		15ft (4.5m) - KP44-564-15 26ft (7.6m) - KP44-564-25	
1/16-3/32 (1.6-2.4)								15ft (4.5m) - KP45H-332-15
5/64-3/32 (2.0-2.4)				15ft (4.5m) - KP45H-332-15 26ft (7.6m) - KP45H-332-25		15ft (4.5m) - KP45H-332-15		15ft (4.5m) - KP45H-332-15
7/64-.120 (2.8-3.05)				15ft (4.5m) - KP45-18-15 26ft (7.6m) - KP45-18-25		15ft (4.5m) - KP45-18-15		15ft (4.5m) - KP45-18-15
Aluminum <sup>(4)</sup> .035-3/64 (0.9-1.2)	15ft (4.5m) - KP44N-3545-15 <sup>(4)</sup>	15ft (4.5m) - KP44N-3545-15 <sup>(4)</sup>	15ft (4.5m) - KP44N-3545-15 <sup>(4)</sup>	15ft (4.5m) - KP45N-3545-15 <sup>(4)</sup>	15ft (4.5m) - KP44N-3545-15 <sup>(4)</sup>	15ft (4.5m) - KP45N-3545-15 <sup>(4)</sup>		



KP42-XX-XX



KP44-XX-XX



KP45-XX-XX

(4) Recommended for aluminum wire welding.

# Magnum<sup>®</sup> PRO Robotic Gun Service Parts



External Dress, 22°

Thru-Arm Gooseneck, 45°  
Tregaskiss™

## For Use With Robotic Guns

### External Dress Gun Tube<sup>(14)</sup>

Product Number	Description
KP3056-22	Gooseneck, 22 Deg. Robotic A/C, LECO TCP
KP3056-45	Gooseneck, 45 Deg. Robotic A/C, LECO TCP
KP3056-180	Gooseneck, 180 Deg. Robotic A/C, LECO TCP
KP3057-22	Gooseneck, 22 Deg. Robotic A/C, TREG TCP

### THRU-ARM GUN TUBE

Product Number	Description
KP3354-22	22 Deg. Thru-Arm Gooseneck (Tregaskiss™)
KP3354-45	45 Deg. Thru-Arm Gooseneck (Tregaskiss™)
KP3355-22	22 Deg. Thru-Arm Gooseneck (Binzel®)
KP3355-45	45 Deg. Thru-Arm Gooseneck (Binzel®)
KP3355-180	180 Deg. Thru-Arm Gooseneck (Binzel®)

### JUMP LINERS<sup>(2)</sup> 550 A in. (mm)

.035-.045 (0.9-1.2)	.052-1/16 (1.3-1.6)	1/16 - 5/64 (1.6 - 2.0)
KP3364-1	KP3364-2	KP3364-3

### WIRE GUIDES<sup>(2)</sup>

Size	.035 - .045	.052 - 1/16	5/64
Part Number	KP3979-1	KP3979-2	KP3979-3

(2) Jump liners and wire guides are only used on Thru-arm torches with wire brake.

## EXTERNAL DRESS RECOMMENDED ACCESSORIES

### External Dress Torch Mounting Kits

Designed to mount the External Dress torch in the proper orientation for the application and fixturing presented to the robot. Consult Automation Division for correct mounting kit selection assistance.

#### Order

KP2769-22

22 Degree – Lincoln Electric Tool Center Point (TCP)

KP2769-45

45 Degree – Lincoln Electric Tool Center Point (TCP)

KP2769-180

180 Degree – Lincoln Electric Tool Center Point (TCP)



KP3054-22

22 Degree – Tregaskiss™ TCP, FANUC® Solid Mount

KP3055-22

22 Degree – Tregaskiss™ TCP, Tregaskiss™ Clutch Mount

Air Blast Kit

Blows spatter from the nozzle orifice. Includes 20 ft hose and fitting.

Order

K3352-1



### External Dress Break-Away Disks

Replaceable mounting interface disk designed to protect the robot arm by absorbing the effects of any damage in the event of a robot work envelope collision.

#### Order

KP3194-1

External Dress Break-Away Disk (Fanuc® iB)

KP3194-2

External Dress Break-Away Disk (Fanuc® 50 iC)

KP3194-3

External Dress Break-Away Disk (Fanuc® iC)

## THRU-ARM RECOMMENDED ACCESSORIES



### Thru-Arm Break-Away Disks

Replaceable mounting interface disk designed to protect the robot arm by absorbing the effects of any damage in the event of a robot work envelope collision.

#### Order

KP2920-1

Thru-Arm Break-Away Disk



### Thru-Arm Replacement Cable Assemblies

#### Order

KP3066-100ic

KP3066-100ic/6L

KP3066-120ic

KP3066-120ic/10L

## EXTERNAL DRESS AND THRU-ARM RECOMMENDED ACCESSORIES



### Robotic Gun Tube Straightener

Used in the event of a robot crash to check and correct robotic gun tube alignment. Compatible with all Magnum PRO External Dress and Thru-Arm Robotic Guns.

#### Order

K3193-1

(14) Note that External Dress guns include a 22 degree Lincoln Electric TCP gooseneck, liner and consumables. Mounting kit is not included.

(15) Note that Thru-Arm guns do not include a gooseneck, liner or consumables.



# Magnum® Guns



## Amperage Rating @ 60% Duty Cycle <sup>(1)</sup>

100% CO<sub>2</sub> Shielding Gas  
 Magnum® 100L: 100A  
 Magnum® 250L: 250A  
 Magnum® 200: 200A  
 Magnum® 300: 300A  
 Magnum® 400: 400A  
 Magnum® 550: 600A

## Wire Diameter Range in. (mm)

.025 - .045 (0.6 - 1.2)  
 .025 - .045 (0.6 - 1.2)  
 .025 - .045 (0.6 - 1.2)  
 .025 - 5/64 (0.6 - 2.0)  
 .025 - 5/64 (0.6 - 2.0)  
 .035 - 1/8 (0.9 - 3.2)

<sup>(1)</sup> Magnum® 100L and 250L are 40% duty cycle.

### PRODUCT SPECIFICATIONS

Gun Model	Gun Rating Amperage/Duty Cycle/Shielding Gas	Cable Length ft. (m)	Wire Diameter .025-.035 in. (0.6-0.9 mm)	Wire Diameter .035-.045 in. (0.9-1.2 mm)			Wire Diameter .052-1/16 in. (1.3-1.6 mm)			Wire Diameter 1/16-5/64 in. (1.6-2.0 mm)	
			Package	Gun Connector			Gun Connector			Gun Connector	
				Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™
Magnum® 100L	100A@40% CO <sub>2</sub>	10 (3.0)	K530-5, K530-6 <sup>(1)</sup>	K530-3 (FCAW-SS only)							
Magnum® 200	200A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5)		K497-2 K497-1	K498-1	K497-21 <sup>(3)</sup>					
Magnum® 250L	250A@40% CO <sub>2</sub>	12 (3.6) 15 (4.5)		K533-7 (Fixed Gas Nozzle) K533-3 (Adjustable Gas Nozzle)							
Magnum® 300	300A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5)		K470-1 K470-2		K1802-1 <sup>(2)</sup>	K470-4			K470-6	
Magnum® 400 STANDARD	400A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5) 20 (6.1) 25 (7.6)		K471-1 K471-2 K471-10 K471-13	K479-2	K2286-1 <sup>(2)</sup> K471-21 <sup>(2)</sup>	K471-4 K471-11 K471-14	K479-4	K471-22 <sup>(3)</sup>	K471-6 K471-15	K479-6
Magnum® 400 DUAL SCHEDULE	400A@60% CO <sub>2</sub>	15 (4.5)						K575-2			
Magnum® 400 DUAL PROCEDURE	400A@60% CO <sub>2</sub>	15 (4.5)		K1722-2							
Magnum® 400 SHORT NECK	400A@40% CO <sub>2</sub>	15 (4.5)		K541-3							

Gun Model	Amperage Rating	Cable Length ft. (m)	Wire Diameter .052-1/16 in. (1.3-1.6 mm)	Wire Diameter 5/64-3/32 in. (2.0-2.4 mm)
			Gun Connector 600 A Open-End	Gun Connector 600 A Open-End
Magnum® 550	550A@60% CO <sub>2</sub>	15 (4.5)	K598-7	K598-11

# Magnum® Gun Service Parts

## CABLE LINERS

MAGNUM® 100L {in. (mm)}		
ft. (m)	.035 (0.9) Aluminum <sup>(1)</sup>	.035-.045 (0.9-1.2)
15 (4.5)	KP1959-1	KP45-40-15



Magnum® 200 and 250L

Magnum® 300 and 400

MAGNUM® 200, 250L and 250SP {in. (mm)}				
ft. (m)	.025-.030 (0.6-0.8)	.030-.035 (0.8-0.9)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>
15 (4.5)	KP42-25-15	KP42-3035-15	KP42-4045-15	KP44N-3545-15 <sup>(1)</sup>



Magnum® 550

MAGNUM® 300 and 400 {in. (mm)}						
ft. (m)	.025-.030 (0.6-0.8)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	.052-1/16 (1.3-1.6)	1/16-5/64 (1.6-2.0)	1/16 (1.6) Aluminum <sup>(1)</sup>
15 (4.5)	KP42-25-15	KP44-3545-15	KP44N-3545-15 <sup>(1)</sup>	KP44-116-15	KP44-564-15	KP44N-116-15 <sup>(1)</sup>
26 (7.9)	—	KP44-3545-25	—	KP44-116-25	KP44-564-25	—

MAGNUM® 550 {in. (mm)}						
ft. (m)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	.052-1/16 (1.3-1.6)	1/16 (1.6) Aluminum <sup>(1)</sup>	5/64-3/32 (2.0-2.4)	7/64-1/8 (2.8-3.2)
15 (4.5)	KP45-3545-15	KP45N-3545-15	KP45-116-15	KP45N-116-15 <sup>(1)</sup>	KP45H-332-15	KP45-18-15
25 (7.6)	KP45-3545-25	—	KP45-116-25	—	KP45H-332-25	KP45-18-25

<sup>(1)</sup> Recommended for aluminum wire welding. Recommended maximum cable length is 10 ft. (3.0 m).

## GUN TUBES

GUN TUBES				
Use With These Magnum® Guns	Amperage Capacity	Angle		
		45°	60° (Standard)	82°
Magnum® 100L	100 A		KP2038-1	
Magnum® 200	200 A		KP2028-1	
	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 250L	250 A	KP2041-1	KP2015-1 (Hard cover) KP2111-1 (Rubber cover)	
Magnum® 300 Magnum® 400	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 550	600 A		KP1951-1 (3 in. radius bend) KP1951-2 (5 in. radius bend)	



45° Gun Tube



60° Gun Tube



82° Gun Tube

# Magnum® Gun Connector Kits

Gun Connector Kits are included with Fast-Mate™ Guns and Ready-Pak® Packages only.

Wire Feeder Manufacturer	Wire Feeder Model	Product Number
<b>Magnum® 200, 300 Open End, 400 Open End, Single Procedure</b>		
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	<b>K466-1</b>
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	<b>K466-8</b>
	LF-72, LF-74 Series, LN-25 PRO	<b>K466-10</b>
	Power Feed® 10 and 25 series	<b>K466-10</b>
	POWER MIG® Series and Power Wave® C300	<b>K466-6</b>
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	<b>K466-2</b>
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	<b>K466-3</b>
<b>Magnum® 200 Fast-Mate™, 300 Fast-Mate™, and 400 Fast-Mate™, Single Procedure</b>		
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	<b>K489-1</b>
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	<b>K489-1</b>
	Power Feed® 10 and 25 series	<b>K489-7</b>
	POWER MIG® Series and Power Wave® C300	<b>K489-8</b>
<b>Magnum® 400 Dual Procedure, Dual Schedule</b>		
Lincoln Electric®	Power Feed® 10 and 25 series	<b>K466-10</b>
<b>Magnum® 400 Fast-Mate™, Dual Procedure, Dual Schedule</b>		
Lincoln Electric®	Power Feed® 10 and 25 series	<b>K489-7</b>
<b>Magnum® 550 Open End</b>		
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	<b>K613-1</b>
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	<b>K613-6</b>
	Power Feed® 10 and 25 series	<b>K613-7</b>
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	<b>K613-2</b>
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	<b>K613-3</b>

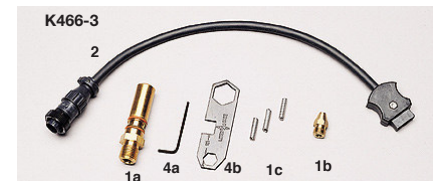


Gun Connector Assembly: S18645 (1a), T7028-234 (1b)  
Control Cable: M15608 (2)  
Gas Tube & Fitting: T10642-166 (3a), T14557-7 (3b), T13777-4 (3c)  
Connector Tools: T11563-4 (4a), S18845 (4b)

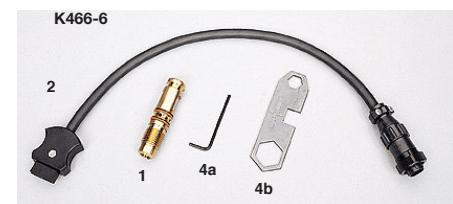


**O-Rings  
Not Shown  
T13483-8  
(5 PK)**

Gun Connector Assembly: S18653 (1a), S19762 (1b)  
Connector Tools: T11563-4 (4a), S18845 (4b)



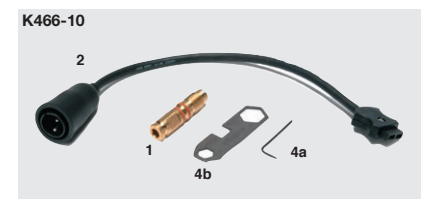
Gun Connector Assembly: S19760 (1a) S19761 (1b) S18685-XX (1c)  
Control Cable: M16325-1 (2)  
Connector Tools: T11563-4 (4a), S18845 (4b)



Gun Connector Assembly: S18653 (1)  
Control Cable: M16325-1 (2)  
Connector Tools: T11563-4 (4a), S18845 (4b)



Gun Connector Assembly: S18645-2 (1a & 1b)  
Control Cable: M15608 (2)  
Gas Tube & Fitting: T10642-166 (3a) T14557-7 (3b) T13777-4 (3c)  
Connector Tools: T11563-4 (4a), S18845 (4b)



Gun Connector Assembly: S18653 (1)  
Control Cable: M15608 (2)  
Connector Tools: T11563-4 (4a), S18845 (4b)



Gun Connector Assembly: S18645 (1a), T7028-234 (1b)  
Control Cable: M15608 (2)  
Gas Tube & Fitting: T10642-166 (3a),  
T14557-7 (3b), T13777-4 (3c)  
Connector Tools: T11563-4 (4a)



Gun Connector Assembly:  
S18653-1 (1)



Gun Connector Assembly: S19760-1 (1a),  
S19761-1(1b), KP2095-XX (1c)  
Control Cable: M16325 (2)  
Connector Tools: T11563-4 (4)



Gun Connector Assembly: S19760-1 (1a),  
S19761-1(1b), KP2095-XX (1c)  
Control Cable: M16325 (2)  
Connector Tools: T11563-4 (4)



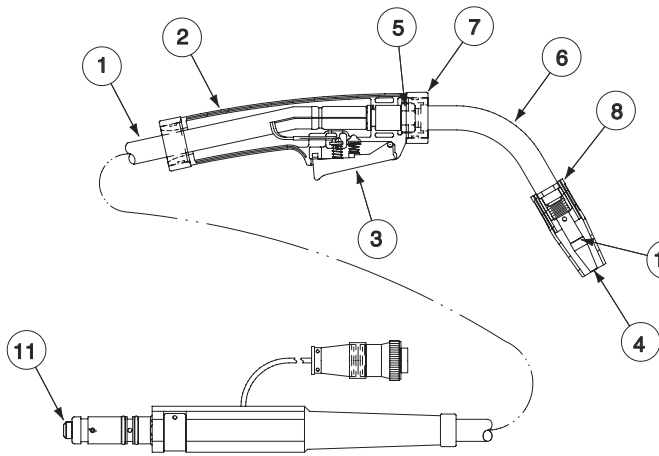
Gun Connector Assembly: S18645-3 (1)  
Control Cable: M15608 (2)  
Gas Tube & Fitting: T10642-166 (3a),  
T14557-7 (3b), T13777-4 (3c)  
Connector Tools: T11563-4 (4)



Gun Connector Assembly: S18653-1 (1)  
Control Cable: M15608 (2)  
Connector Tools: T11563-4 (4)

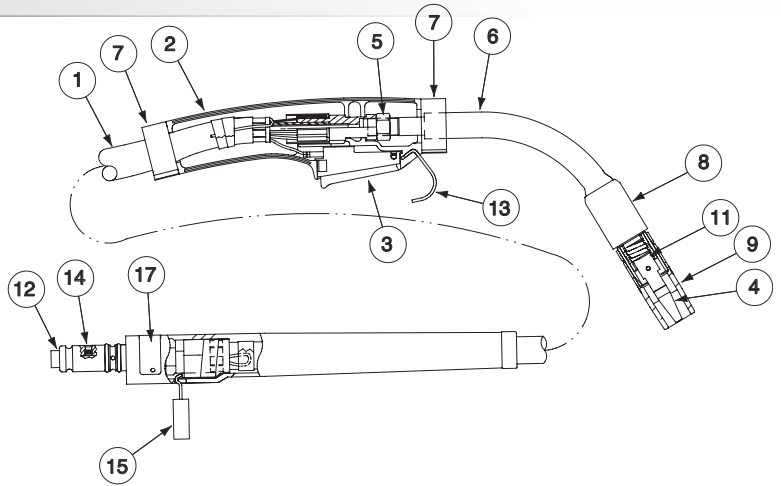


## Magnum® Pro 100L



ITEM	DESCRIPTION	Part #	QTY.
	Magnum Pro 100L Asbly (L16063-1), Includes:	<b>K3080-1</b>	
1	Cable Asbly	<b>M16318-2</b>	1
2	Gun Handle (Left & Right)	<b>G2209</b>	1
3	Trigger Assembly	<b>S19725</b>	1
4	Tapered Contact Tip (.035)	<b>KP2744-035T</b>	1
5	Locking Nut	<b>S19580</b>	1
6	Gun Tube Assembly	<b>KP3082-60</b>	1
7	Collar	<b>S19701</b>	2
8	Gas Nozzle (Flush)	<b>KP3075-1-50F</b>	1
10	Gas Diffuser	<b>KP3076-1</b>	1
11	Liner Assembly (.035-.045)	<b>KP45-40-15</b>	1

## Magnum® Pro 250L

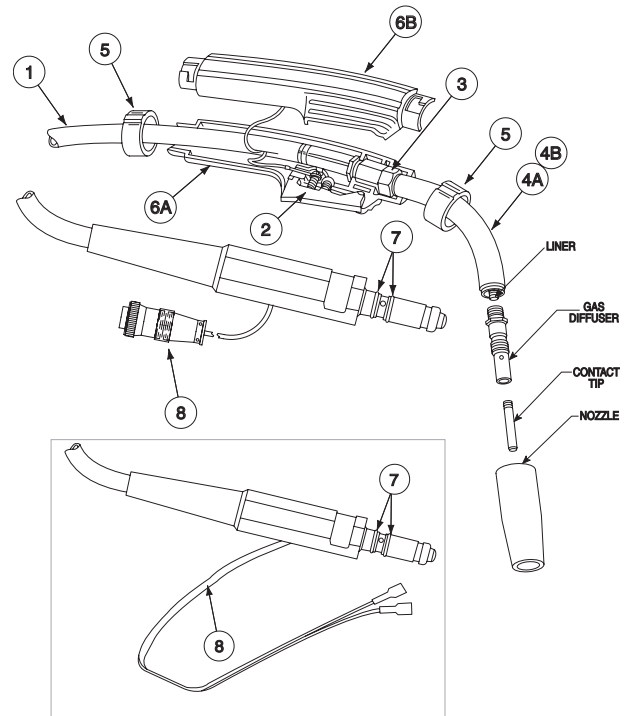


ITEM	DESCRIPTION	Part #	QTY
	Magnum® Pro 250L Asbly (L16051-3), Includes:	<b>K3081-2</b>	1
1	Cable Asbly,(15')	<b>L8324-6</b>	1
2	Gun Handle (Left & Right)	<b>G2217</b>	1
3	Trigger Assembly	<b>S18932</b>	1
4	Tapered Contact Tip (.035)	<b>KP2744-035T</b>	1
5	Locking Nut	<b>S19580</b>	1
6	Gun Tube Assembly	<b>KP3078-60</b>	1
7	Collar	<b>S19074</b>	2
8	Insulator	<b>KP2773-2</b>	1
9	Gas Nozzle	<b>KP2742-1-50F</b>	1
11	Gas Diffuser	<b>KP2746-1</b>	1
12	Liner Assembly (.035-.045)	<b>KP42-4045-15</b>	1
13	Hook	<b>S19241</b>	1
14	Set Screw	<b>S11604-51</b>	1
15	Gun Control Assembly	<b>M16700</b>	1
17	Clip	<b>S19732</b>	1

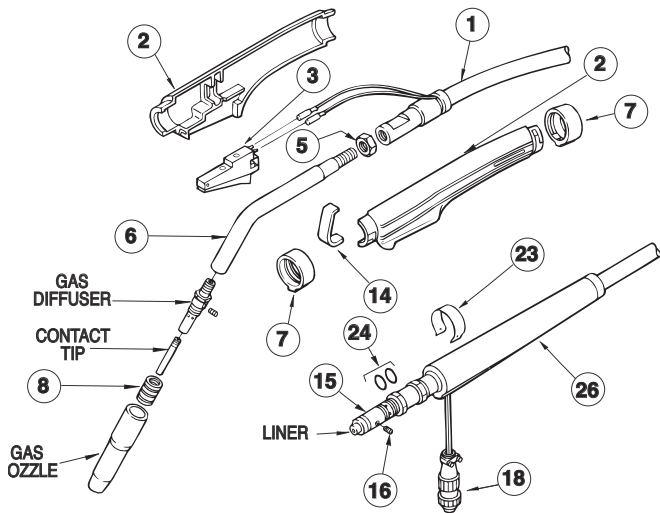
## Magnum® 100L (Classic)

Use only the parts marked "X" in the column for each assembly.

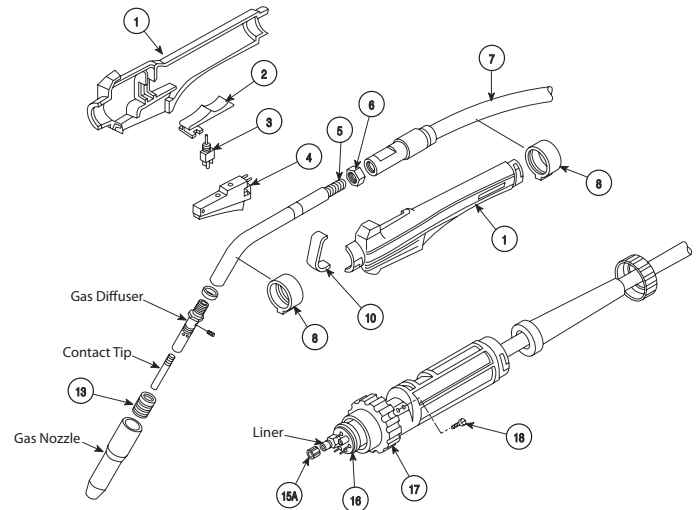
ITEM	DESCRIPTION	Part #				QTY
	New Complete Gun & Cable Assemblies					
	Magnum 100L (4 Pin Connector)	<b>K530-6</b>	X	-	-	
	Magnum 100L FCAW 035-045 (Spaded Lug Connector)	<b>K530-3</b>	-	X	-	
	Magnum 100L GMAW 025-035 (Spaded Lug Connector)	<b>K530-5</b>	-	-	X	
1	Cable Assembly (4 Pin Connector)	<b>M16318-2</b>	X	X	X	1
1	Cable Assembly (Spaded Lug Connector)	<b>M16318-1</b>	-	X	X	1
2	Trigger Assembly	<b>S19725</b>	X	X	X	1
3	Locking Nut	<b>S19580</b>	X	X	X	1
4A	Gun Tube Assembly	<b>KP2038-1</b>	X	X	X	1
4B	Gun Tube Assembly Cover	<b>T10642-162</b>	X	X	X	1
5	Collar	<b>S19701</b>	X	X	X	2
6	Gun Handle (Left and Right)	<b>G2209</b>	X	X	X	1
7	O Ring	<b>T13483-8</b>	X	X	X	2
8	Control Wire Cord (4 Pin Connector)	<b>S26388</b>	X	-	-	1
8	Control Wire Cord (Inset - Spaded Lug Connector)	<b>S19729</b>	-	X	X	1



## Magnum® 250L (Classic)



## Magnum® 250SP



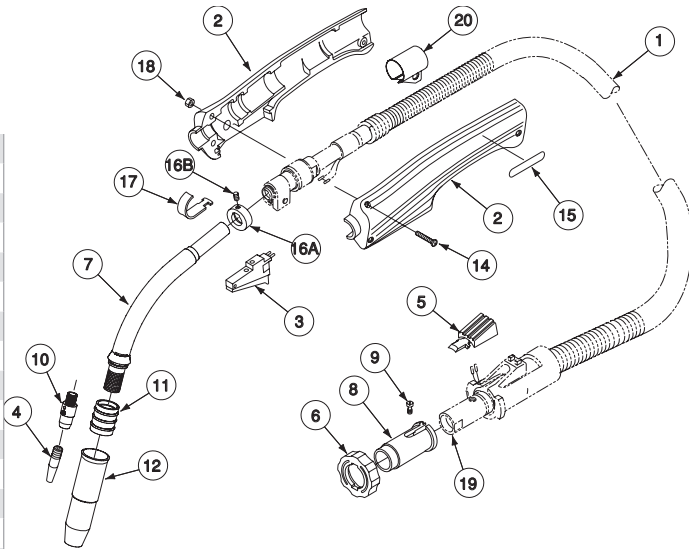
ITEM	DESCRIPTION	Part #	QTY
Magnum 250L Gun & Cable Assembly:			
	(12 Ft.) (Thread on Gas Nozzle)	<b>K533-7</b>	1
	(15 Ft.) (Slip on Gas Nozzle)	<b>K533-3</b>	1
2	Gun Handle (Left & Right)	<b>G2217</b>	1
3	Trigger Assembly	<b>S18932</b>	1
5	Locking Nut	<b>S19580</b>	1
6	Gun Tube Assembly		
	45°	<b>KP2041-1</b>	
	60° Hard Cover	<b>KP2015-1</b>	
	60° Rubber Cover	<b>KP2111-1</b>	1
7	Collar	<b>S19074</b>	2
8	Slip On Nozzle Insulator	<b>KP32</b>	1
14	Hook	<b>S19241</b>	1
15	Connector Assembly	<b>S20280</b>	1
16	Set Screw	<b>S11604-51</b>	1
18	Control Wire Cord	<b>M16700</b>	1
23	Clip	<b>S19732</b>	1
24	"O" Ring	<b>T13483-8</b>	2
26	Cable Boot	<b>M16324</b>	1

ITEM	DESCRIPTION	Part #	QTY
Magnum 250SP Gun & Cable Assembly:			
Gun & Cable Asbly, Includes:		<b>K524-5</b>	
1	Gun Handle (Left & Right)	<b>G2012</b>	1
2	Slide	<b>S19075</b>	1
3	Switch Assembly	<b>S19239</b>	1
4	Trigger Assembly	<b>S18932</b>	1
5	Gun Tube Assembly		
	45°	<b>KP2041-1</b>	
	60° Hard Cover	<b>KP2015-1</b>	
	60° Rubber Cover	<b>KP2111-1</b>	1
6	Locking Nut	<b>S19580</b>	1
7	Cable Asbly (12.5')	<b>M15805-1</b>	1
	Cable Asbly (15')	<b>M15805-2</b>	1
8	Collar	<b>S19074</b>	2
10	Hook	<b>S19241</b>	1
13	Slip on Nozzle Insulator	<b>KP32</b>	1
15a	Liner Nut	<b>S18991</b>	1
16	Central Adapter Asbly	<b>S18948-1</b>	1
17	Collar Nut	<b>S18929</b>	1
18	M4 x 0.70 PHS (Metric)	<b>T14731-19</b>	1
19	Decal (Magnum 255-SP)	<b>S18750-3</b>	

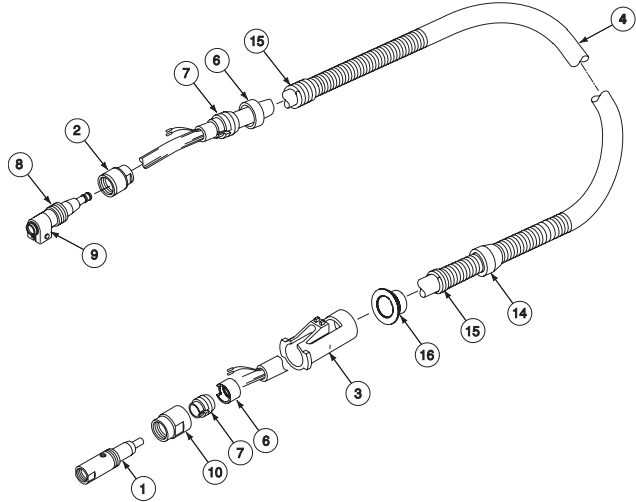
# Magnum® & Magnum® PRO Curve 200

Use only the parts marked "X" in the column for each assembly.

ITEM	DESCRIPTION	Part #	QTY	1	2
	Gun & Cable Asbly, Includes: (15')	<b>K497-1</b>	1	X	-
	Gun & Cable Asbly, Includes: (10')	<b>K497-2</b>	1	X	-
	Gun & Cable Asbly, Includes: (12')	<b>K497-5</b>	1	X	-
	Gun & Cable Asbly, Includes: (10')	<b>K2950-1</b>	1	-	X
	Gun & Cable Asbly, Includes: (15')	<b>K2950-2</b>	1	-	X
	Gun & Cable Asbly, Includes: (20')	<b>K2950-3</b>	1	-	X
	Gun & Cable Asbly, Includes: (25')	<b>K2950-4</b>	1	-	X
(Items 4, 10, 11, 12 & 20 are Not Included in the Asbly)					
1	Connector Assembly	<b>See Parts A</b>	1	X	X
2	Gun Handle (Left & Right)	<b>G2090</b>	1	X	X
3	Trigger Assembly	<b>S21002</b>	1	X	X
4	Contact Tip (.035)	<b>KP14-35</b>	1	X	-
4	Contact Tip (.045)	<b>KP14-45</b>	1	X	-
4	Contact Tip (.025)	<b>KP14-25</b>	1	X	-
4	Contact Tip (.030)	<b>KP14-30</b>	1	X	-
4	Contact Tip	<b>See Expendables</b>	1	-	X
5	Connector Cover	<b>L7723</b>	1	X	X
6	Nut (Cable Handle)	<b>S18690</b>	1	X	X
7	60° Gun Tube Assembly	<b>S19440</b>	1	X	-
7	60° Gun Tube Assembly	<b>KP2924-60</b>	1	-	X
8	Tail Piece	<b>M15607</b>	1	X	X
9	Gas Plug Assembly	<b>S18695</b>	1	X	X
10	Gas Diffuser Assembly (.035-.045)	<b>KP52</b>	1	X	-
10	Gas Diffuser	<b>See Expendables</b>	1	-	X
11	Slip on Nozzle Insulator Assembly	<b>KP32</b>	1	X	-
11	Insulator	<b>KP2773-2</b>	1	-	X
12	Gas Nozzle	<b>KP22-50</b>	1	X	-
12	Gas Nozzle	<b>See Expendables</b>	1	-	X
14	Pan Head Screw (for Handle Assembly)	<b>S18825-1</b>	3	X	X
15	Decal (Logo)	<b>S18750-4</b>	1	X	X
16	Collar Assembly, Includes:	<b>S18831</b>	1	X	X
16A	Collar	<b>S18830</b>	1	X	X
16B	Set Screw	<b>S11604-46</b>	1	X	X
17	Hanger	<b>M15693</b>	1	X	X
18	Handle Nut	<b>S18773</b>	3	X	X
19	15' Cable Liner (.035-.045) also used on 10' & 12'	<b>KP42-4045-15</b>	1	X	X
19	15' Cable Liner (.025-.030) also used on 10' & 12'	<b>KP42-25-15</b>	1	X	X
20	Spring Boot Retainer	<b>S24719-1</b>	1	X	X
Options.					
	Magnum® Fast-Connect Gas Tube Kit	<b>Order K481</b>			
	Magnum® Connector Kit (Lincoln Feeders)	<b>Order K466-1</b>			
	Magnum® Connector Kit (Tweco Adapted Feeders)	<b>Order K466-2</b>			
	Magnum® Connector Kit Miller Feeders)	<b>Order K466-3</b>			
	Magnum® Connector Kit (Hobart Feeders)	<b>Order K466-5</b>			
	82° Gun Tube Assembly	<b>M16504-1</b>			



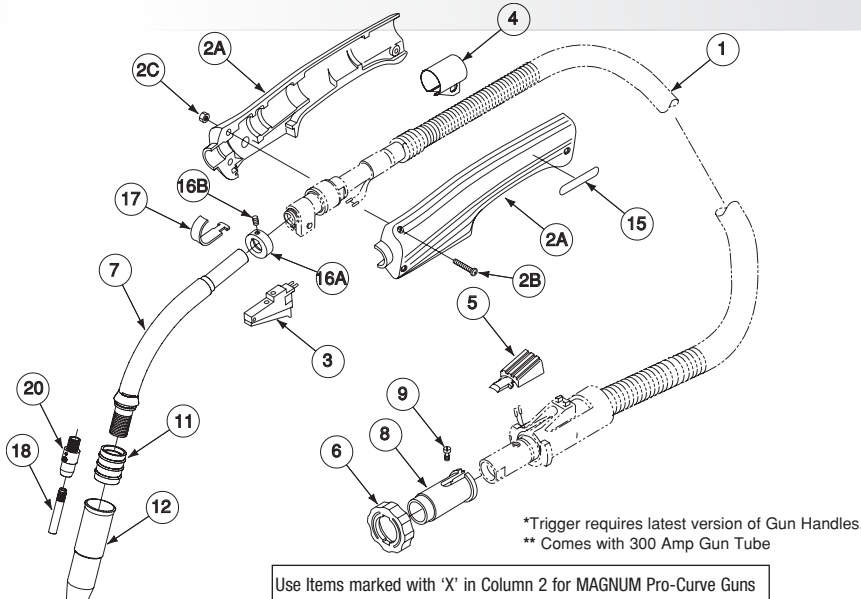
### Parts A



ITEM	DESCRIPTION	Part #	QTY
1	Incoming Connector Asbly	<b>S18789-1</b>	1
2	Connector Nut	<b>S19067</b>	1
3	Cable Handle	<b>L7725</b>	1
4	Cable Assembly	<b>NSS</b>	
6	Strain Relief Housing	<b>S18786-1</b>	2
7	Strain Relief	<b>S18787-1</b>	2
8	Gun Tube Connector Assembly, Includes:	<b>S18655-1</b>	1
	Gun Tube Connector	<b>M15635-1</b>	1
	Tube	<b>S19363</b>	1
	"O" Ring	<b>T13483-8</b>	1
9	Nozzle Clamp	<b>S15921-2</b>	1
	Clamping Screw	<b>T14438</b>	1
	Retaining Ring	<b>S9776-7</b>	1
10	Incoming End Nut	<b>S23822-200</b>	1
14	Sleeve	<b>S24773-1</b>	1
15	Spring Boot	<b>S24676-2</b>	2
16	Bushing	<b>S24679-2</b>	1

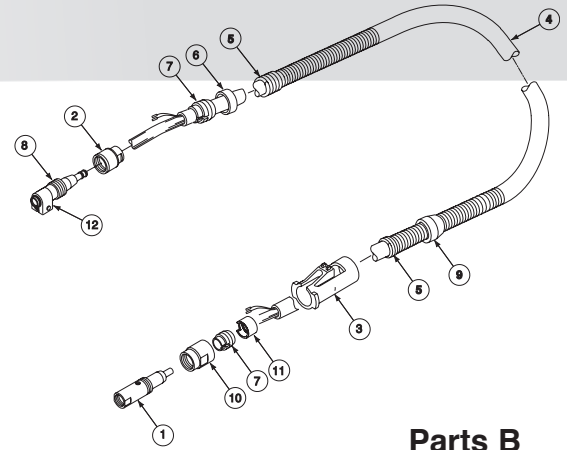


# Magnum® & Magnum® PRO Curve 300/400



Use Items marked with 'X' in Column 2 for MAGNUM Pro-Curve Guns

ITEM	DESCRIPTION	Part #	QTY		
Gun & Cable Assembly:					
	300 Amp (See Table 1)	<b>K470-[ ]</b>	1	X	-
	300 Amp (See Table 1)	<b>K2951-[ ]</b>	1	-	X
	400 Amp (See Table 1)	<b>K471-[ ]</b>	1	X	-
	**400 Amp (Short Neck) (See Table 1)	<b>K541-[ ]</b>	1	X	-
	400 Amp (Short Neck) (See Table 1)	<b>K3055-[ ]</b>	1	-	X
	400 Amp (See Table 1)	<b>K2952-[ ]</b>	1	-	X
1	Connector Assembly	<b>See Parts (B)</b>	1	X	X
2A	Gun Handle (Left & Right)	<b>G1927</b>	1	X	X
2B	Pan Head Screw (for Handle)	<b>S18825-1</b>	3	X	X
2C	Handle Nut (Knurled)	<b>S18773</b>	3	X	X
3	Trigger Assembly (Non Interlocking-Standard)	<b>S21002</b>	1	X	X
3	Trigger Assembly (Interlocking-Parts Order Only)	<b>S20677 *</b>	1	X	X
4	Spring Boot Retainer (Gun End Only)	<b>S24719</b>	1	X	X
5	Connector Cover	<b>L7723</b>	1	X	X
6	Nut (Cable Handle)	<b>S18690</b>	1	X	X
7	Gun Tube Assembly	<b>Magnum Expendables</b>	1	X	-
7	Gun Tube Assembly	<b>Pro-Curve Expendables</b>	1	-	X
8	Tail Piece	<b>M15607</b>	1	X	X
9	Gas Plug Assembly	<b>S18695</b>	1	X	X
11	Slip on Nozzle Insulator	<b>Magnum Expendables</b>	1	X	-
11	Slip on Nozzle Insulator	<b>Pro-Curve Expendables</b>	1	-	X
12	Gas Nozzle	<b>Magnum Expendables</b>	1	X	-
12	Gas Nozzle	<b>Pro-Curve Expendables</b>	1	-	X
15	Decal 300 Amp	<b>S18750-1</b>	1	X	-
15	Decal 400 Amp	<b>S18750-2</b>	1	X	-
15	Decal	<b>S27420-1</b>	1	-	X
16	Collar Assembly, Includes:	<b>S18831</b>	1	X	X
16A	Collar	<b>S18830</b>	1	X	X
16B	Set Screw	<b>S11604-46</b>	1	X	X
17	Hanger	<b>M15693</b>	1	X	X
18	Contact Tip	<b>Magnum Expendables</b>	1	X	-
18	Contact Tip	<b>Pro-Curve Expendables</b>	1	-	X
20	Gas Diffuser	<b>Magnum Expendables</b>	1	X	-
20	Gas Diffuser	<b>Pro-Curve Expendables</b>	1	-	X
Items Not Shown:					
	Cable Liners	<b>Magnum Expendables</b>	1	X	-
	Cable Liners	<b>Pro-Curve Expendables</b>	1	-	X
Options:					
	Magnum Connector Kits		1	X	X
	Magnum Fast-Connect Gas Tube Kit (for K466-1)	<b>Order K481</b>	1	X	X



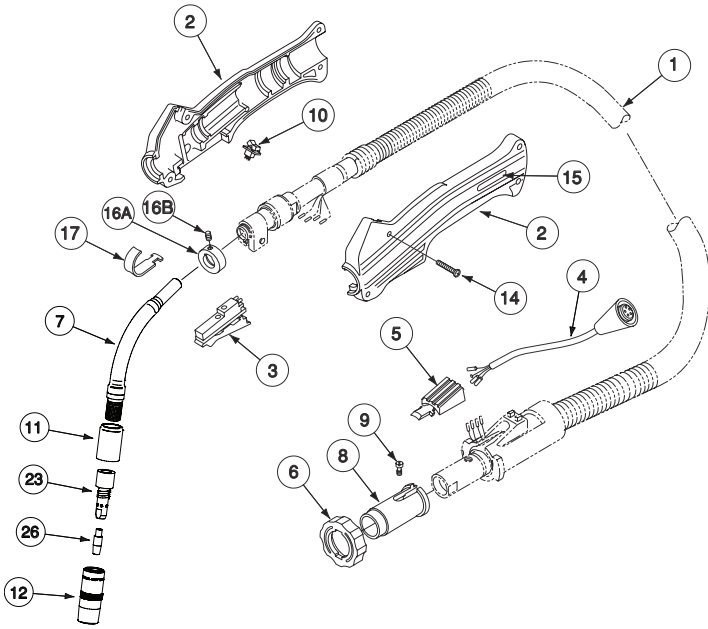
## Parts B

1	Incoming Connector Assembly	<b>S18789</b>	1
2	Connector Nut (300 Amp)	<b>S18749-1</b>	2
2	Connector Nut (400 Amp)	<b>S18749-2</b>	2
3	Cable Handle	<b>L7725</b>	1
4	Cable Assembly (Includes 4A)	<b>NSS</b>	
4A	Terminal (For Mating Gun Connector End)	<b>S19492-1</b>	2
5	Spring Boot	<b>S24676</b>	2
6	Strain Relief Housing	<b>S18786</b>	1
7	Strain Relief	<b>S18787</b>	2
8	Gun Tube Connector Assembly, Includes:	<b>S18655</b>	1
	Gun Tube Connector	<b>M15635</b>	1
	Tube	<b>S18847</b>	1
	"O" Ring	<b>T13483-8</b>	1
12	Nozzle Clamp	<b>S15921-2</b>	1
	Clamping Screw	<b>T14438</b>	1
	Retaining Ring	<b>S9776-7</b>	1
9	Spring Boot Retainer	<b>S24678</b>	1
10	Incoming End Nut (300 Amp)	<b>S23822-300</b>	1
10	Incoming End Nut (400 Amp)	<b>S23822-400</b>	1
11	Strain Relief Housing	<b>S24677</b>	1

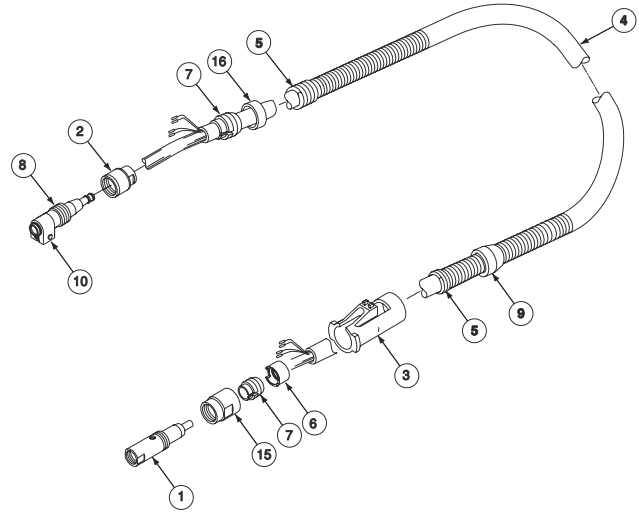
## TABLE 1

Part No	Amp	Length	Wire Size	Metric Wire Size
<b>K470-1</b>	300	10 FT	.035-.045"	0.9-1.2
<b>K470-2</b>	300	15 FT	.035-.045"	0.9-1.2
<b>K470-4</b>	300	15 FT	.052-1/16"	1.3-1.6
<b>K470-6</b>	300	15 FT	1/16-5/64"	1.6-2.0
<b>K471-1</b>	400	10 FT	.035-.045"	0.9-1.2
<b>K471-10</b>	400	20 FT	.035-.045"	0.9-1.2
<b>K471-11</b>	400	20 FT	.052-1/16"	1.3-1.6
<b>K471-13</b>	400	25 FT	.035-.045"	0.9-1.2
<b>K471-14</b>	400	25 FT	.052-1/16"	1.3-1.6
<b>K471-15</b>	400	25 FT	1/16-5/64"	1.6-2.0
<b>K471-2</b>	400	15 FT	.035-.045"	0.9-1.2
<b>K471-4</b>	400	15 FT	.052-1/16"	1.3-1.6
<b>K471-6</b>	400	15 FT	1/16-5/64"	1.6-2.0
<b>K2951-1</b>	300	10 FT	025-5/64"	0.6-2.0
<b>K2951-2</b>	300	15 FT	025-5/64"	0.6-2.0
<b>K2951-3</b>	300	20 FT	025-5/64"	0.6-2.0
<b>K2951-4</b>	300	25 FT	025-5/64"	0.6-2.0
<b>K2952-1</b>	400	10 FT	025-5/64"	0.6-2.0
<b>K2952-2</b>	400	15 FT	025-5/64"	0.6-2.0
<b>K2952-3</b>	400	20 FT	025-5/64"	0.6-2.0
<b>K2952-4</b>	400	25 FT	025-5/64"	0.6-2.0
<b>K3055-1</b>	400	10 FT	025-5/64"	0.6-2.0
<b>K3055-2</b>	400	15 FT	025-5/64"	0.6-2.0
<b>K3055-3</b>	400	20 FT	025-5/64"	0.6-2.0
<b>K3055-4</b>	400	25 FT	025-5/64"	0.6-2.0
<b>K541-3</b>	400	15 FT	.035-.045"	0.9-1.2

# Magnum® & Magnum® Pro 300 & 400 Gun & Cable (Dual Procedure)



**A**



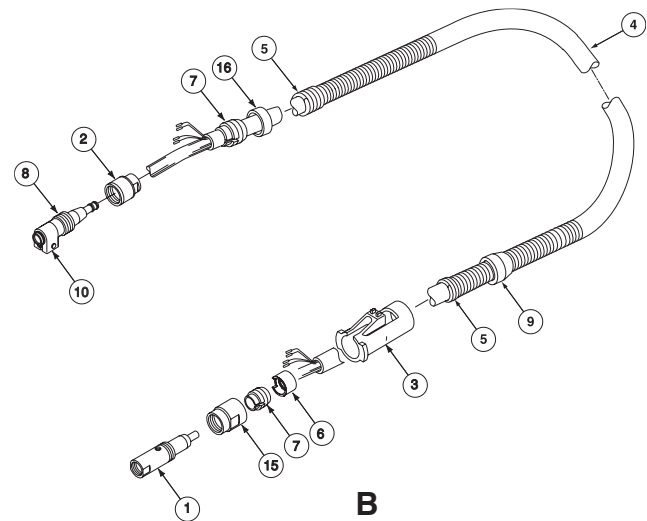
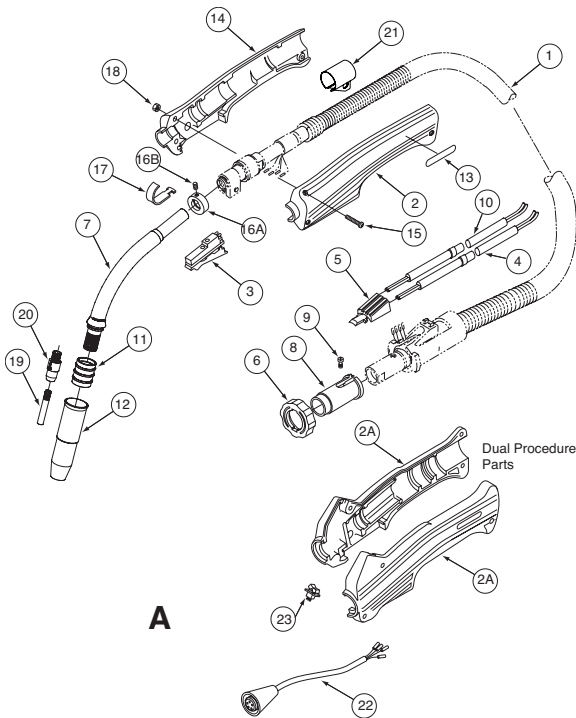
**B**

Use Items marked with 'X' in Column 2 for MAGNUM Pro-Curve 400 Guns

ITEM	DESCRIPTION	Part #	QTY		
	Magnum® Pro Curve 300 (Dual Procedure) (10 ft), Includes:	<b>K3130-1</b>	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (15 ft), Includes:	<b>K3130-2</b>	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (20 ft), Includes:	<b>K3130-3</b>	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (25 ft), Includes:	<b>K3130-4</b>	1	X	
	Magnum® Pro Curve 400 (Dual Procedure) (10 ft), Includes:	<b>K3098-1</b>	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (15 ft), Includes:	<b>K3098-2</b>	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (20 ft), Includes:	<b>K3098-3</b>	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (25 ft), Includes:	<b>K3098-4</b>	1	-	X
1	Connector Asbly	See PARTS B	1	X	X
2	Handle (Left & Right)	<b>G3598</b>	1	X	X
3	Trigger Assembly	<b>S21002</b>	1	X	X
4	Control Cable	<b>M19313</b>	1	X	X
5	Connector Cover	<b>L7723</b>	1	X	X
6	Nut (Cable Handle)	See P-202-AL.5	1	X	X
7	Gun Tube Assembly	<b>M22466-1</b>	1	X	-
7	Gun Tube Assembly	<b>M22466-2</b>	1	-	X
8	Tail Piece	<b>M15607</b>	1	X	X
9	Gas Plug Asbly	<b>S18695</b>	1	X	X
10	Rocker Switch	<b>S24514</b>	1	X	X
11	Insulator	See Pg 10 or 13	1	X	X
12	Gas Nozzle	See Pg 10 or 13	1	X	X
14	Pan Head Screw	<b>S18825-1</b>	4	X	X
15	Decal	<b>S18750-1</b>	1	X	-
15	Decal	<b>S18750-2</b>	1	-	X
16	Collar Assembly, Includes:	<b>S18831</b>	1	X	X
16A	Collar	<b>S18830</b>	1	X	X
16B	Set Screw	<b>S11604-46</b>	1	X	X
17	Hanger	<b>M15693</b>	1	X	X
23	Diffuser	See Pg 10 or 13	1	X	X
26	Contact Tip (1.2 - .045)	See Pg 10 or 13	1	X	X

ITEM	DESCRIPTION	Part #	QTY		
1	Incoming Connector Asbly	<b>S18789</b>	1	X	X
2	Connector Nut	<b>S18749-1</b>	1	X	-
2	Connector Nut	<b>S18749-2</b>	1	-	X
3	Cable Handle	<b>L8564</b>	1	X	X
4	Cable Assembly	<b>NSS</b>	1	X	-
4	Cable Assembly	<b>NSS</b>	1	-	X
5	Spring Boot	<b>S24676</b>	1	X	X
6	Strain Relief Housing	<b>S18786</b>	2	X	X
7	Strain Relief	<b>S18787</b>	2	X	X
8	Gun Tube Connector Assembly, Includes:	<b>S18655</b>	1	X	X
	Gun Tube Connector	<b>M15635</b>	1	X	X
	Tube	<b>S18847</b>	1	X	X
	"O" Ring	<b>T13483-8</b>	1	X	X
10	Nozzle Clamp	<b>S15921-2</b>	1	X	X
	Clamping Screw	<b>T14438</b>	1	X	X
	Retaining Ring	<b>S9776-7</b>	1	X	X
9	Spring Boot Retainer	<b>S24678</b>	1	X	X
15	Connector Nut	<b>S18749-1</b>	1	X	-
15	Connector Nut	<b>S18749-2</b>	1	-	X
16	Strain Relief Housing	<b>S24677</b>	1	X	X

## Magnum® 400 Dual Schedule & Dual Procedure



ITEM	DESCRIPTION	Part #	QTY
	Magnum Dual Schedule	<b>K574-[ ]*</b>	
	Magnum Dual Procedure	<b>K1722-[ ]</b>	
1	Connector Assembly	<b>See B</b>	1
2	Gun Handle (Left & Right) Dual Schedule	<b>G1927</b>	1
2A	Gun Handle (Left & Right) Dual Procedure	<b>G3598</b>	1
3	Trigger Assembly (DS Std.)	<b>S20124-1</b>	1
3	Trigger Assembly (DS Interlocking)	<b>S20124**</b>	1
3	Trigger Assembly (DP Std.)	<b>S21002</b>	1
3	Trigger Assembly (DP Interlocking)	<b>S20677**</b>	1
4	Control Cable (DS only)	<b>M16582-1</b>	1
5	Connector Cover	<b>L7723</b>	1
6	Nut (Cable Handle)	<b>S18690</b>	1
7	Gun Tube Assembly	<b>Pg 14-16***</b>	1
8	Tail Piece	<b>M15607</b>	1
9	Gas Plug Assembly	<b>S18695</b>	1
10	Control Cable (DS only)	<b>M16582-2</b>	1
11	Slip On Nozzle Insulator	<b>Pg 14-16***</b>	1
12	Gas Nozzle	<b>Pg 14-16***</b>	1
13	Decal	<b>S18750-2</b>	1
15	Pan Head Screw	<b>S18825-1</b>	3
16	Collar Assembly	<b>S18831</b>	1
16A	Collar	<b>S18830</b>	1
16B	Set Screw	<b>S11604-46</b>	1
17	Hanger	<b>M15693</b>	1
18	Handle Nut	<b>S18773</b>	3
19	Contact Tip	<b>Pg 14-16***</b>	1
20	Gas Diffuser Assembly	<b>Pg 14-16***</b>	1
21	Spring Boot Retainer (DS only)	<b>S24719</b>	1
22	Control Cable	<b>M19313</b>	1
23	Rocker Switch	<b>S24514</b>	1

ITEM	DESCRIPTION	Part #	QTY
	Connector Assembly(400DS/15 Ft. Cable), Includes:	<b>L8562-1</b>	
	Connector Assembly(400DS/25 Ft. Cable), Includes:	<b>L8562-2</b>	
	Connector Assembly(400DP/15 Ft. Cable), Includes:	<b>L8562-3</b>	
	Connector Assembly(400DP/10 Ft. Cable), Includes:	<b>L8562-4</b>	
	Connector Assembly(400DP/25 Ft. Cable), Includes:	<b>L8562-5</b>	
1	Incoming Connector Assembly	<b>S18789</b>	1
2	Connector Nut	<b>S18749-2</b>	2
3	Cable Handle	<b>L8564</b>	1
4	Cable Assembly(400 DS/15 Ft. Cable)	<b>L8561-1</b>	1
4	Cable Assembly(400 DS/25 Ft. Cable)	<b>L8561-2</b>	1
4	Cable Assembly(400 DP/15 Ft. Cable)	<b>L11057-1</b>	1
4	Cable Assembly(400 DP/10 Ft. Cable)	<b>L11057-2</b>	1
4	Cable Assembly(400 DP/25 Ft. Cable)	<b>L11057-3</b>	1
5	Spring Boot	<b>S24676</b>	1
6	Strain Relief Housing	<b>S18786</b>	2
7	Strain Relief	<b>S18787</b>	2
8	Gun Tube Connector Assembly, Includes:	<b>S18655</b>	1
	Gun Tube Connector	<b>M15635</b>	1
	Tube	<b>S18847</b>	1
	"O" Ring	<b>T13483-8</b>	1
10	Nozzle Clamp	<b>S15921-2</b>	1
	Clamping Screw	<b>T14438</b>	1
	Retaining Ring	<b>S9776-7</b>	1
9	Spring Boot Retainer	<b>S24678</b>	1
15	Incoming End Nut	<b>S23822-400</b>	1
16	Strain Relief Housing	<b>S24677</b>	1

\* To be discontinued.

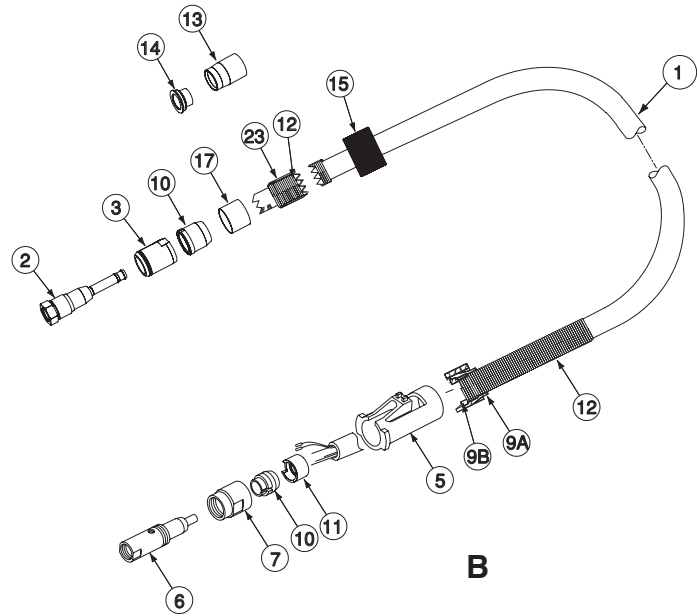
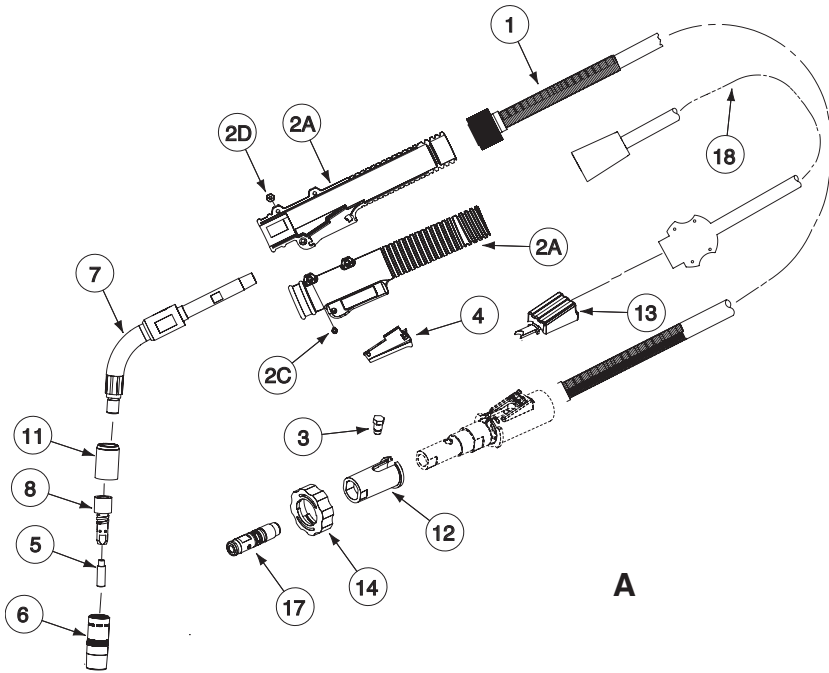
\*\* Interlocking trigger requires latest version of Gun Handles.

\*\*\* See Magnum 300 & 400 expendable section for these parts.



# Magnum® PRO 250/350/450/550 Parts

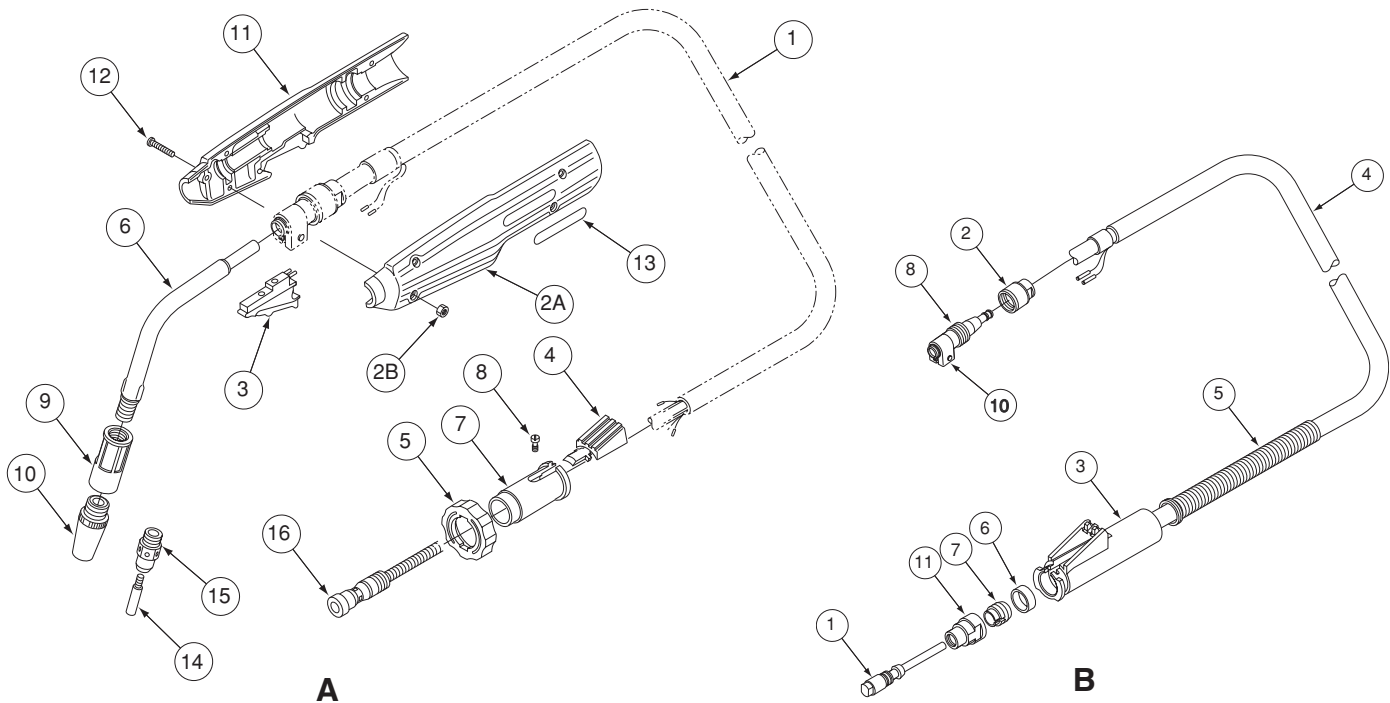
Use only the parts marked "X" in the column for each assembly.



#	DESCRIPTION	Part #	QTY	1	2	3	4	5	6	7
Gun & Cable Asbly: See Table Below for Lengths										
	250A Magnum Pro (-1 for 10') or (-2 for 15')	<b>K2651-[ ]</b>	1	X	-	-	-	-	-	-
	350A Magnum Pro (-1 for 10') or (-2 for 15')	<b>K2652-[ ]</b>	1	-	X	-	-	-	-	-
	450A Mag Pro (-1 for 10'), (-2 for 15'), (-4 for 25')	<b>K2653-[ ]</b>	1	-	-	X	-	-	-	-
	550A Mag Pro (-1 for 10'), (-2 for 15'), (-4 for 25')	<b>K2655-[ ]</b>	1	-	-	-	X	-	-	-
	250A Magnum Pro (15')	<b>K2651-2-6-45</b>	1	-	-	-	-	X	-	-
	350A Magnum Pro (15')	<b>K2652-2-10-45</b>	1	-	-	-	-	-	X	-
	450A Magnum Pro (15')	<b>K2653-2-10-45</b>	1	-	-	-	-	-	-	X
1	Connector Assembly	<b>See Parts (B)</b>	1	X	X	X	X	X	X	X
2A	Gun Handle (Left & Right)	<b>G6088-1</b>	1	X	X	X	X	X	X	X
2C	#6-32 x .50 SHCS (for Handle)	<b>T9447-87</b>	3	X	X	X	X	X	X	X
2D	#6-32 HN	<b>CF000005</b>	3	X	X	X	X	X	X	X
3	Molded Gas Plug	<b>S18695</b>	1	X	X	X	X	X	X	X
4	Trigger Asbly (Non Interlocking-Standard)	<b>S21002</b>	1	X	X	X	X	X	X	X
5	Contact Tip	<b>See Expendables</b>	1	X	X	X	X	X	X	X
6	Nozzle Assembly (250 & 350 Amp)	<b>KP2742-1-62R</b>	1	X	X	-	-	X	X	-
6	Nozzle Assembly (1/8" Recessed) (450 & 550 Amp)	<b>KP2743-1-62R</b>	1	-	-	X	X	-	-	X
7	Gun Tube Assembly (250 Amp)	<b>KP2866-60</b>	1	X	-	-	-	X	-	-
7	Gun Tube Assembly (350 Amp)	<b>KP2867-60</b>	1	-	X	-	-	-	X	-
7	Gun Tube Assembly (450 Amp)	<b>KP2868-60</b>	1	-	-	X	-	-	-	X
7	Gun Tube Assembly (550 Amp)	<b>KP2869-60</b>	1	-	-	-	X	-	-	-
8	Gas Diffuser	<b>See Expendables</b>	1	X	X	X	X	X	X	X
10	Decal (Not Shown)	<b>S27420</b>	1	X	X	X	X	X	X	X
11	Insulator	<b>S27472-1</b>	1	X	X	-	-	X	X	-
11	Insulator	<b>S27472</b>	1	-	-	X	X	-	-	X
12	Tail Piece	<b>M15607</b>	1	X	X	X	X	X	X	X
13	Connector Cover	<b>L7723</b>	1	X	X	X	X	X	X	X
14	Nut (Cable Handle)	<b>S18690</b>	1	X	X	X	X	X	X	X
16	CCC Decal (Not Shown)	<b>T13086-192</b>	1	X	X	X	X	X	X	X
17	Connector Assembly	<b>S18653</b>	1	-	-	-	-	X	X	X
18	Control Cable	<b>M16725-1</b>	1	-	-	-	-	X	-	-
18	Control Cable	<b>M15608</b>	1	-	-	-	-	-	X	X

#	DESCRIPTION	Part #	QTY	1	2	3	4
	Cable Assembly (250 Amp):	<b>NSS</b>	1	X	-	-	-
	Cable Assembly (350 Amp):	<b>NSS</b>	1	-	X	-	-
	Cable Assembly (450 Amp):	<b>NSS</b>	1	-	-	X	-
	Cable Assembly (550 Amp):	<b>NSS</b>	1	-	-	-	X
1	Cable (250 Amp)	<b>NSS</b>	1	X	-	-	-
2	Power Cable Male Cone	<b>S26287-5</b>	1	X	X	X	-
2	Power Cable Male Cone	<b>S26287-4</b>	1	-	-	-	X
3	Power Cable Female Nut	<b>S26288-5</b>	1	X	X	X	-
3	Power Cable Female Nut	<b>S26288-4</b>	1	-	-	-	X
5	Cable Handle	<b>L7725</b>	1	X	X	X	-
5	Cable Handle	<b>L8990</b>	1	-	-	-	X
6	Incoming Connector Asbly	<b>S18789</b>	1	X	X	X	-
6	Incoming Connector Asbly	<b>S20696</b>	1	-	-	-	X
7	Incoming End Nut	<b>S23822-300</b>	1	X	X	-	-
7	Incoming End Nut	<b>S23822-400</b>	1	-	-	X	-
7	Incoming End Nut	<b>S22506</b>	1	-	-	-	X
9A	Sleeve	<b>S24773-1</b>	1	X	-	-	-
9A	Spring Boot Retainer	<b>S24678</b>	1	-	X	X	-
9A	Cable Handle Insert	<b>S28061</b>	1	-	-	-	X
9B	Bushing	<b>S24679-2</b>	1	X	-	-	-
10	Strain Relief	<b>S18787</b>	2	X	X	X	-
10	Strain Relief	<b>S20695</b>	1	-	-	-	X
11	Strain Relief Housing	<b>S24677</b>	1	X	X	X	-
11	Strain Relief Housing	<b>S18786-1</b>	1	-	-	-	X
12	Spring Boot	<b>S24676-2</b>	2	X	-	-	-
12	Spring Boot	<b>S24676</b>	2	-	X	X	-
12	Spring Boot	<b>M17003-1</b>	2	-	-	-	X
13	Sleeve	<b>S24773-3</b>	1	X	-	-	-
14	Bushing	<b>S24679-4</b>	1	X	-	-	-
15	Knurled Nut	<b>S26299-1</b>	1	X	X	X	X
17	Strain Relief Housing	<b>S18786</b>	1	X	X	X	-
19	Spring Boot Retainer	<b>S24678</b>	1	-	X	X	-
23	Spring Boot Retainer	<b>S24678-1</b>	1	-	X	X	-
25	Hose Clamp (Not Shown)	<b>S20710-17</b>	2	-	-	-	X

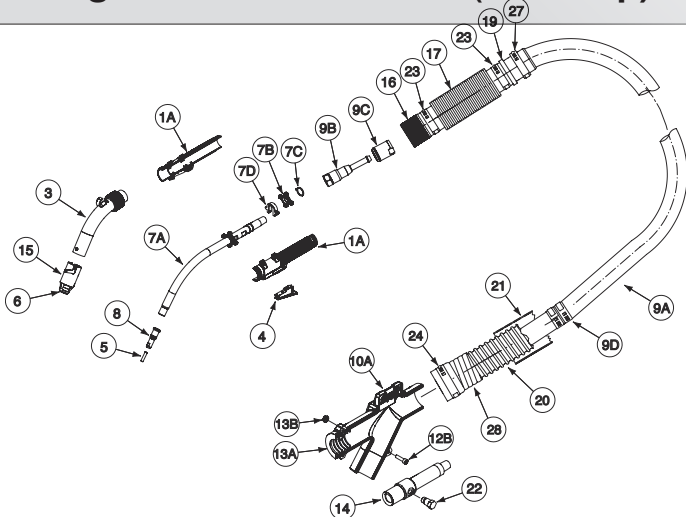
# Magnum<sup>®</sup> 550



ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Asbly, Includes:		<b>K598-[ ]</b>	
1	Connector Assembly	<b>See B</b>	1
2A	Gun Housing (Left & Right)	<b>G2480</b>	1
2B	Handle Nut	<b>S18773</b>	4
3	Trigger Asbly (Standard)	<b>S20677-1</b>	1
3	Trigger Asbly (Interlocking)	<b>S20677</b>	1
4	Connection Cover	<b>L7723</b>	1
5	Nut (Cable Handle)	<b>S18690</b>	1
6	Gun Tube Assembly	<b>See Pg 26</b>	1
7	Tail Piece	<b>M15607</b>	1
8	Gas Plug Assembly	<b>S18695</b>	1
9	Insulator Assembly	<b>See Pg 15</b>	1
10	Gas Nozzle	<b>See Pg 14</b>	1
12	Pan Head Screw	<b>S18825-1</b>	4
13	Decal	<b>S20676</b>	1
14	Contact Tip	<b>See Pg 14</b>	1
15	Gas Diffuser	<b>See Pg 16</b>	1
16	Cable Liner	<b>See Pg 15</b>	1

ITEM	DESCRIPTION	Part #	QTY
Connector Asbly (550A/10' Cable)		<b>L9047-1</b>	
Connector Asbly (550A/12' Cable)		<b>L9047-2</b>	
Connector Asbly (550A/15' Cable)		<b>L9047-3</b>	
Connector Asbly (550A/25' Cable)		<b>L9047-4</b>	
Includes:			
1	Incoming Connector Asbly	<b>S20696</b>	1
2	Connector Nut	<b>S20675</b>	1
3	Cable Handle	<b>L8990</b>	1
4	*Cable Asbly (10Ft. Cable)	<b>L9046-1</b>	1
4	*Cable Asbly (12Ft. Cable)	<b>L9046-2</b>	1
4	*Cable Asbly (15Ft. Cable)	<b>L9046-3</b>	1
4	*Cable Asbly (25Ft. Cable)	<b>L9046-4</b>	1
5	Cable Boot	<b>M17003</b>	1
6	Strain Relief Housing	<b>S18786-2</b>	1
7	Strain Relief	<b>S20695</b>	1
8	Gun Tube Connector Assembly, Includes:	<b>S18655-2</b>	1
	"O" Ring	<b>T13483-8</b>	1
10	Nozzle Clamp	<b>S15921-2</b>	1
	Clamping Screw	<b>T14438</b>	1
	Retaining Ring	<b>S9776-7</b>	1
	Set Screw	<b>S11604-22</b>	1
11	Connector Nut	<b>S22506</b>	1
	*Includes:		
	Terminal (Feeder End)	<b>S19492-1</b>	2
	Terminal (Gun End)	<b>S19492-2</b>	2

### Magnum Pro Fume Gun (350 Amp)

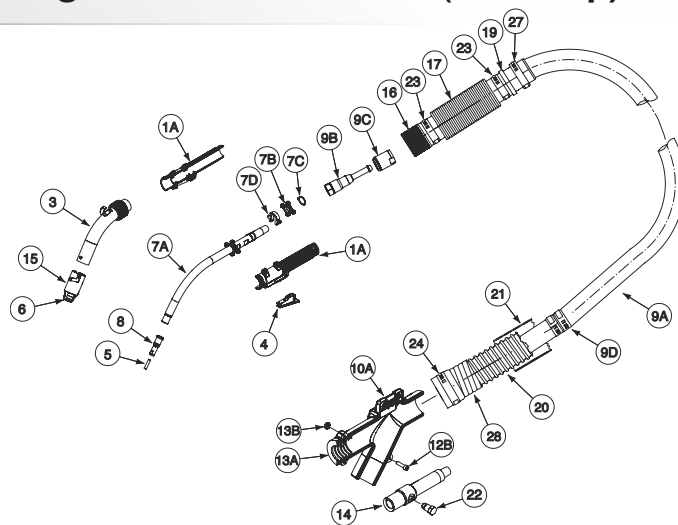


ITEM	DESCRIPTION	Part #	QTY.
	Magnum Pro Fume Gun (350 Amp), Includes:	<b>K2649-1</b>	1
1A	Fume Handle (Left & Right)	<b>G6086-1</b>	1
1B	#8-32 HN	<b>CF000042</b>	4
1C	Socket Head Cap Screw	<b>T9447-29</b>	4
3	Fume Tube Assembly (M21587)	<b>KP2739-1</b>	1
4	Trigger Assembly	<b>S21002-1</b>	1
4A	Decal (Not Shown)	<b>S27420</b>	1
5	Contact Tip (S26401-2 .045 1.2mm)	<b>KP2745-045</b>	1
6	Gas Nozzle Assembly (1/8" Recessed)	<b>S27462-2</b>	1
7	Gun Tube Assembly, Includes:	<b>M21567</b>	1
7A	Gun Tube	<b>KP2738-1</b>	1
7B	Gun Tube Spider	<b>S27232-1</b>	1
7C	Retaining Ring	<b>S9776-17</b>	1
7D	Gun Tube Lock	<b>S27235</b>	1
7E	Roll Pin (Not Shown)	<b>T9967-26</b>	1
8	Heavy Duty Diffuser Assembly (S26873-1)	<b>KP2747-1</b>	1
9	Cable Assembly, Includes:	<b>L13335-3</b>	1
9A	Cable	<b>L13336-3</b>	1
9B	Power Cable Male Cone	<b>S26287-5</b>	2
9C	Power Cable Female Nut	<b>S26288-5</b>	2
9D	Hose Clamp	<b>S20710-19</b>	4
10A	Right Modular Trigger Housing (Not Shown)	<b>L13299</b>	1
10B	#8-32 HN (Not Shown)	<b>CF000042</b>	2
11A	Left Modular Trigger Housing (Not Shown)	<b>L13298</b>	1
11B	Socket Head Cap Screw (Not Shown)	<b>T9447-29</b>	2
12A	Right Y Connector (Not Shown)	<b>G6075</b>	1
12B	Socket Head Cap Screw	<b>T9447-29</b>	3
13A	Left Y Connector	<b>G6074</b>	1
13B	#8-32 HN	<b>CF000042</b>	3
14	Molded Incoming Connector	<b>M21568</b>	1
15	Fume Collection Nozzle (L13337)	<b>KP2872-1</b>	1
16	Swivel Assembly	<b>S26314-1</b>	1
17	Bellows	<b>S26344-1</b>	1
18	Spring (Not Shown)	<b>S27241</b>	1
19	Tube Adapter	<b>S26289-1</b>	1
20	Vacuum Hose (1.50 I.D.)	<b>S19947-18</b>	1
21	Fume Hose Cover (S21147-11)	<b>KP2736-1</b>	1
22	Molded Gas Plug	<b>S18695</b>	1
23	Hose Clamp	<b>S20710-18</b>	3
24	Hose Clamp	<b>S20710-21</b>	1
28	Hose Adapter	<b>S20591-15</b>	1

Items Shipped Loose:

Fume Collection Nozzle, GMAW (Not Shown)	L13337-1	1
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### Magnum Pro Fume Gun (550 Amp)



ITEM	DESCRIPTION	Part #	QTY.
	Magnum Pro Fume Gun (550 Amp), Includes:	<b>K2650-1</b>	1
1A	Fume Handle (Left & Right)	<b>G6086-1</b>	1
1B	#8-32 HN	<b>CF000042</b>	4
1C	Socket Head Cap Screw	<b>T9447-29</b>	4
3	Fume Tube Assembly (M21587)	<b>KP2739-1</b>	1
4	Trigger Assembly	<b>S21002-1</b>	1
4A	Decal (Not Shown)	<b>S27420</b>	1
5	Contact Tip (S26401-6 3/32 2.4mm)	<b>KP2745-332</b>	1
6	Gas Nozzle Assembly (1/8" Recessed)	<b>S27462-2</b>	1
7	Gun Tube Assembly, Includes:	<b>M21567</b>	1
7A	Gun Tube	<b>KP2738-1</b>	1
7B	Gun Tube Spider	<b>S27232-1</b>	1
7C	Retaining Ring	<b>S9776-17</b>	1
7D	Gun Tube Lock	<b>S27235</b>	1
7E	Roll Pin (Not Shown)	<b>T9967-26</b>	1
8	Heavy Duty Diffuser Assembly (S26873-1)	<b>KP2747-1</b>	1
9	Cable Assembly, Includes:	<b>L13335-1</b>	1
9A	Cable	<b>L13336-1</b>	1
9B	Power Cable Male Cone	<b>S26287-4</b>	2
9C	Power Cable Female Nut	<b>S26288-4</b>	2
9D	Hose Clamp	<b>S20710-17</b>	4
10A	Right Modular Trigger Housing (Not Shown)	<b>L13299</b>	1
10B	#8-32 HN (Not Shown)	<b>CF000042</b>	2
11A	Left Modular Trigger Housing (Not Shown)	<b>L13298</b>	1
11B	Socket Head Cap Screw (Not Shown)	<b>T9447-29</b>	2
12A	Right Y Connector (Not Shown)	<b>G6075</b>	1
12B	Socket Head Cap Screw	<b>T9447-29</b>	3
13A	Left Y Connector	<b>G6074</b>	1
13B	#8-32 HN	<b>CF000042</b>	3
14	Molded Incoming Connector	<b>M21568</b>	1
15	Fume Collection Nozzle (L13337)	<b>KP2872-1</b>	1
16	Swivel Assembly	<b>S26314-1</b>	1
17	Bellows	<b>S26344-1</b>	1
18	Spring (Not Shown)	<b>S27241</b>	1
19	Tube Adapter	<b>S26289</b>	1
20	Vacuum Hose (1.75 I.D.)	<b>S19947-17</b>	1
21	Fume Hose Cover (S21147-11)	<b>KP2736-1</b>	1
22	Molded Gas Plug	<b>S18695</b>	1
23	Hose Clamp	<b>S20710-18</b>	2
24	Hose Clamp	<b>S20710-20</b>	2

Items Shipped Loose:

Fume Collection Nozzle, GMAW (Not Shown)	L13337-1	1
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# Spool Gun Adapters, Push Pull Compatibility

Lincoln Welder	Magnum 100 Spool Gun K2532-1	Magnum PRO 100SG Spool Gun K3269-1	Magnum Spool Gun K487-25	Magnum 250LX Spool Gun K2490-1	Magnum PRO AL 12 Pin Air K3355-1,2,3,4 12 Pin Water K3357-1,2,3,4 7 Pin Air K3356-1,2,3,4 7 Pin Water K3358-1,2,3,4	Python-Plus Push-Pull Gun K3038-1,2,3	Cougar Push-Pull Gun K2704-2,3
SP-140	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A
SP-150	N/A	N/A	N/A	N/A	N/A	N/A	N/A
SP-180	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A
SP-200	N/A	N/A	S19857	N/A	N/A	N/A	N/A
SP-250	N/A	N/A	N/A	N/A	N/A	N/A	N/A
SP-255	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Wirematic 250	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Wirematic 255	N/A	N/A	N/A	N/A	N/A	N/A	N/A
POWER MIG 140	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A
POWER MIG 180	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A
POWER MIG 180 Dual	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A
POWER MIG 215XT	Direct Connect	Direct Connect	K2703-1	K2703-1	N/A	N/A	N/A
POWER MIG 216	Direct Connect	Direct Connect	K2703-1	K2703-1	N/A	N/A	N/A
POWER MIG 255	N/A	N/A	K2310-1	K2310-1	N/A	N/A	N/A
POWER MIG 255C	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A
POWER MIG 255XT	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A
POWER MIG 256	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A
POWER MIG 300	N/A	N/A	N/A	N/A	N/A	N/A	N/A
POWER MIG 350MP	N/A	N/A	N/A	Direct Connect	Direct Connect	Direct Connect	Direct Connect
Power Wave C300	N/A	N/A	N/A	Direct Connect	Direct Connect	Direct Connect	Direct Connect

## K2445-1

### Magnum® SG Spool Gun Control Cable Adapter Plug

Allows K487-25 Magnum® SG Spool Gun's 6-pin control cable to plug into the POWER MIG® 256's 7-pin spool gun control receptacle.



## K2703-1

### POWER MIG® 216 Spool Gun Adapter

This kit is designed to allow the Magnum® SG or Magnum® 250LX™ spool gun to operate with the POWER MIG® 216.

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. (Note: The K2703-1 Spool Gun Adapter disables the Magnum® 100SG capability.)



## K2630-1

### Cool Arc® 35 Water Cooler

Attaches underneath and electrically connects to the Invertec® V311-T AC/DC. This smart cooler varies its speed based on coolant temperature and monitors coolant pressure.



## K1813-1

### Cool Arc® 40 Water Cooler

Reliable and affordable water cooler for water-cooled TIG, MIG, or plasma cutting applications. Input power: 115/1/50/60.



## K2187-1

### Cool Arc® 40 Water Cooler

Reliable and affordable water cooler for water-cooled TIG, MIG or plasma cutting applications. Input power: 220-240/1/50/60.



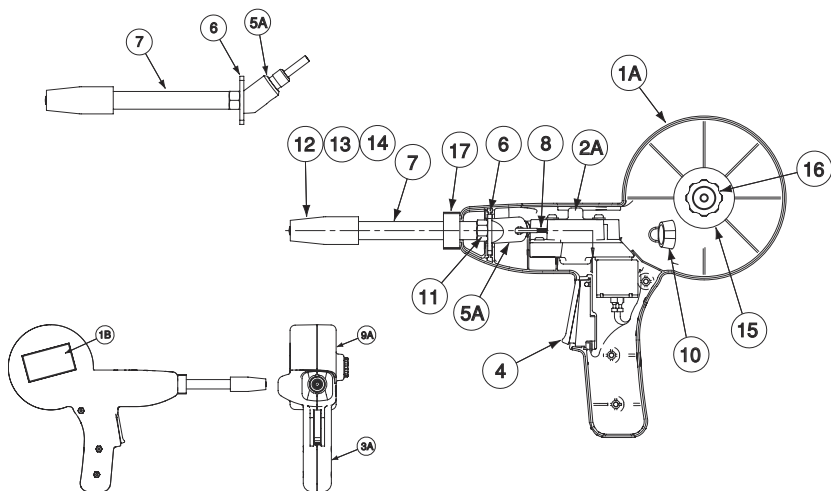
## K3086-1

### Cool Arc® 55

Designed to integrate directly with Power Wave® S-Series power sources, the Cool Arc® 55 is a rugged, reliable water cooler capable of cooling torches rated up to 500 amps. It is recommended for robotic and hand-held MIG, TIG and plasma cutting applications. Input power: 115V/1/60.



# Magnum® & Magnum® PRO 100SG Spool Guns



## EXPENDABLE PARTS

Description	Order Number
.030 (0.8 mm) Contact Tip, 10-pack	KP2039-2B1
.035 (0.9 mm) Contact Tip, 10-pack	KP2039-3B1
Gas Diffuser	KP2040-1
Gas Cone Assembly	KP1938-1
Gun Tube Assembly	KP2631-1
Drive Roll Assembly	KP2529-2
Liner Assembly	KP2632-1

### K3269-1

#### Magnum® PRO 100SG Spool Gun

Designed to easily feed 4 inch (102 mm) diameter 1 lb. (0.45 kg) spools of .030 inch (0.8 mm) or .035 inch (0.9 mm) diameter SuperGlaze® aluminum MIG wire. Features Magnum® PRO expendables. Includes gun, adapter kit, .035 inch (0.9 mm) Copper Plus™ contact tips (qty. 3), gas nozzle, and a 1 lb. (0.45 kg) spool of SuperGlaze® 4043 .035 inch (0.9 mm) MIG wire. Packaged in a convenient carrying case.



### K3159-1

#### Magnum® PRO Harness Adapter

Required for use with Magnum® PRO Dual Procedure or Dual Schedule guns when adapting to Miller Electric® wire feeders.

### K1738-1

#### Spool Gun Holder

Provides neat storage of spool gun cable, and gas hose on power source.



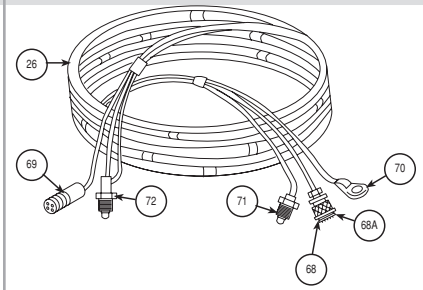
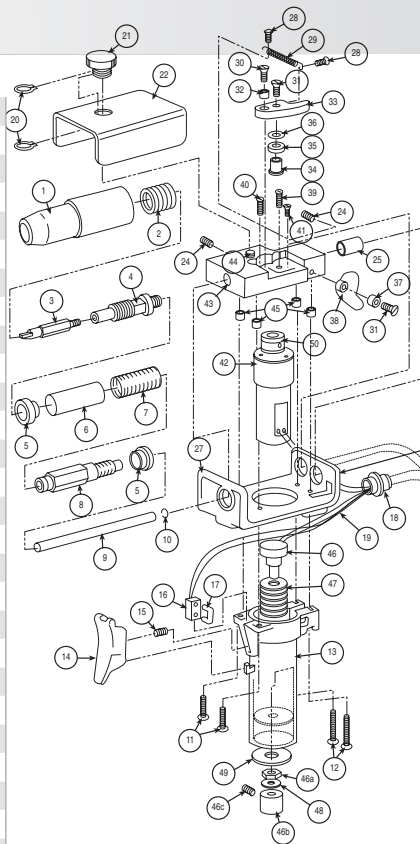
ITEM	DESCRIPTION	Part #	QTY	1	2
	Magnum 100SG, Includes:	<b>K2532-1</b>		X	-
	Magnum Pro 100SG, Includes:	<b>K3269-1</b>		-	X
1A	Gun Handle Right Half Includes:	<b>G5666</b>	1	X	X
1B	Warning Decal	<b>S25815</b>	1	X	X
	1/4-20 x 2.50 HHS	<b>CF000114</b>	1	X	X
	#6-32 HN	<b>CF000005</b>	3	X	X
	Push Nut	<b>S18535-2</b>	1	X	X
2A	Wire Drive Assembly, Includes:	<b>G5707</b>	1	X	X
	Twistlock Drive Roll Assembly	<b>KP2529-2</b>	1	X	X
	Hub	<b>M20860</b>	1	X	X
	Twist Lock	<b>S26238</b>	1	X	X
	Metric Screw Loctite 242 or Equivalent (1 drop req'd to lock Screw into place)	<b>T14731-63</b>	1	X	X
	Washer	<b>T9695-3</b>	1	X	X
	Shaft	<b>NSS</b>	1	X	X
	Bearing	<b>NSS</b>	2	X	X
	Gear	<b>NSS</b>	1	X	X
	Feedplate Base	<b>NSS</b>	1	X	X
	Feedplate Cover	<b>NSS</b>	1	X	X
	Nozzle Insert	<b>T12576-6</b>	1	X	X
	Idle Roll Assembly	<b>S26718</b>	1	X	X
	Motor & Pinion Assembly	<b>NSS</b>	1	X	X
	Metric Screw	<b>NSS</b>	2	X	X
	Self Tapping Screw	<b>S8025-96</b>	2	X	X
	Plain Washer	<b>S9262-3</b>	2	X	X
3A	Gun Handle Left Half	<b>G5665</b>	1	X	X
	#6-32 x 1.00 SHS	<b>CF000099</b>	3	X	X
4	Trigger Assembly	<b>S18932</b>	1	X	X
5A	Cable Assembly, Includes:	<b>L13018</b>	1	X	X
	Male Connector Plug (4 Pin)	<b>S18656</b>	1	X	X
	Cable Clamp	<b>S18658</b>	1	X	X
6	Gun Tube Mounting Plate	<b>S26622</b>	1	X	X
7	Gun Tube Asbly	<b>KP2631-1</b>	1	X	-
	Gun Tube Asbly	<b>KP3325-1</b>	1	-	X
8	Liner Assembly	<b>KP2632-1</b>	1	X	X
9A	Spool Cover Asbly, Includes:	<b>S26737</b>	1	X	X
	Spool Cover	<b>NSS</b>	1	X	X
	Locking Knob	<b>S26711</b>	1	X	X
	Product Decal	<b>S26775</b>	1	X	-
	Product Decal (Magnum Pro)	<b>S26775-1</b>	1	-	X
10	Grommet	<b>T9274-4</b>	1	X	X
11	Nut	<b>S19580</b>	1	X	X
12	Gas Diffuser (Magnum)	<b>KP35-50</b>	1	X	-
	Gas Diffuser (Magnum Pro)	<b>KP3076-1</b>	1	-	X
13	Contact Tip (.035 Std) (Magnum)	<b>KP11-35</b>	10	X	-
	Contact Tip (.035 Std Magnum Pro)	<b>KP2744-035T</b>	10	-	X
14	Gas Cone Assembly	<b>KP21-50-F</b>	1	X	X
14	Gas Nozzle (Flush) (Magnum Pro)	<b>KP3075-1-50F</b>	1	-	X
15	Brake Spring	<b>T11862-65</b>	3	X	X
16	Locking Knob	<b>S26711</b>	1	X	X
17	Locking Collar	<b>S19701</b>	1	X	X

# Magnum® Spool Guns

ITEM	DESCRIPTION	Part #	QTY
<b>Gun &amp; Cable Assembly,</b>			
1	Gas Nozzle Slip Adj. .62 ID (15.9 mm)	<b>KP24A-62</b>	1
2	Insulator for Adj. Slip Nozzle	<b>KP34-A</b>	1
3	Tip for .023-.025" (0.6 mm) Diameter Wire	<b>KP2010-7</b>	(2)
	Tip for .030" (0.8 mm) Diameter Wire	<b>KP2010-3</b>	(2)
	Tip for .035" (0.9 mm) Diameter Wire	<b>KP2010-4</b>	(2)
	Tip for .045" 3/64" (1.2 mm) Diameter Wire	<b>KP2010-5</b>	(2)
4	Gas Diffuser	<b>KP2010-6</b>	1
5	Spacer	<b>S18697-13</b>	2
6	Metal Sleeve	<b>S18697-12</b>	1
7	Insulating Sheath	<b>S18697-14</b>	1
8	Brass Barrel	<b>S18697-7</b>	1
9	Teflon Liner	<b>KP2010-1</b>	1
10	O-Ring	<b>S18697-17</b>	1
11	Screw, 8-32 x 3/4	<b>(1)</b>	2
12	Screw, 8-32 x 1-3/16	<b>(1)</b>	2
13	Handle (K469)	<b>S18697-35</b>	1
13	Handle (K487)	<b>S18697-57</b>	1
14	Trigger	<b>S18697-43</b>	1
15	Trigger Spring	<b>S18697-15</b>	1
16	Switch	<b>S18697-16</b>	1
17	Retaining Clip	<b>S18697-11</b>	1
18	6 Pin Plug	<b>S18697-1</b>	1
19	Wire, 16 Gauge (1.3 mm), High Temperature	<b>(1)</b>	1
20	Snap Ring	<b>S18697-9</b>	3
21	Hand Nut for Body Cover	<b>S18697-22</b>	1
22	Body Cover	<b>S18697-5</b>	1
23	Spool Holder Assembly		
24	Set Screw, 1/4-20 x 1/4, Nylon Tip	<b>(1)</b>	1
25	Support Bushing, Nylon	<b>S18697-2</b>	1
26	Cable Assembly, see P-198-F		
27	Molded Gun Base	<b>S18697-42</b>	1
28	Screw, 4-40 x 1/4	<b>(1)</b>	2
29	Pressure Roll Spring	<b>S18697-39</b>	1
30	Screw, 8-32 x 3/8 Flat Head	<b>(1)</b>	1
31	Screw, 8-32 x 1/4 Flat Head	<b>(1)</b>	2
32	Bushing, Roll Block	<b>S18697-24</b>	1
33	Roll Block	<b>S18697-37</b>	1
34	Bushing, Pressure Roll	<b>S18697-3</b>	1
35	Pressure Roll	<b>S18697-40</b>	1
36	Pressure Roll Spacer	<b>S18697-38</b>	1
37	Bushing, Release Lever	<b>S18697-25</b>	1
38	Pressure Release Lever	<b>S18697-8</b>	1
39	Screw, 4-40 x 1/2	<b>(1)</b>	1
40	Screw, 4-40 x 1/2	<b>(1)</b>	1
41	Screw, 4-40 x 5/16 Flat Head	<b>(1)</b>	1
42	Gear Motor, 24 VDC See P-198-G	<b>S18697-36</b>	
43	Body Block	<b>S18697-4</b>	1
44	Set Screw, 1/4 -20 x 1/2	<b>(1)</b>	4
45	Screw Insert, Nylon	<b>S18697-23</b>	4
46	Potentiometer, 100K	<b>S18697-53</b>	
46a	Retaining Nut	<b>(Incl)</b>	
46b	Knob	<b>S18697-55</b>	
46c	Set Screw	<b>(Incl)</b>	
47	Lock Washer, Internal Tooth, 3/8" I.D., 1/2" O.D.	<b>(1)</b>	5
48	O-Ring	<b>S18697-61</b>	1
49	Feed Dial	<b>S18697-62</b>	1
50	Drive Roll, Smooth	<b>KP2010-8</b>	1
	Drive Roll, Knurled	<b>KP2010-9</b>	1

Note: (1) Parts commonly available at hardware store.

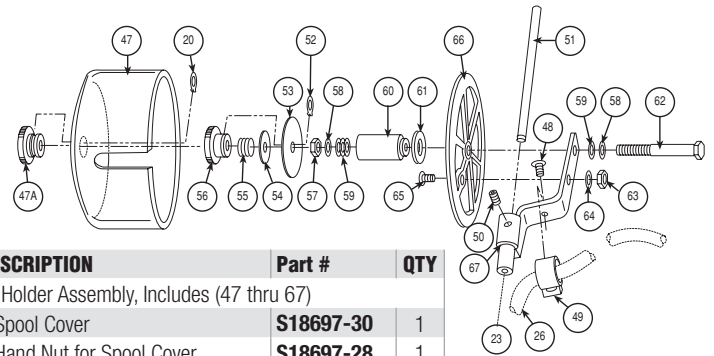
(2) Quantity as required.



ITEM	DESCRIPTION	Part #
26	Cable Assembly (K469) (Gas, Power and Control)(no rheostat in handle)	<b>S18697-48</b>
26	Cable Assembly (K487-25) (Gas, Power and Control) (rheostat in handle)	<b>S18697-56</b> <b>S18697-65</b> <b>(control only)</b>
68	6 Pin Plug	<b>S12020-33</b>
68A	Cable Clamp	<b>S12024-4</b>
69	6 Pin Receptacle	<b>S18697-50</b>
70	Lug Terminal, No. 4 Wire	<b>(1)</b>
71	Gas Fitting, 5/8-18 R.H. - 3/16" (4.8 mm) ID Tube	<b>S18697-58<sup>(2)</sup></b>
72	Gas & Power Fitting	<b>S18697-51</b>

<sup>(1)</sup> Parts commonly available at hardware store.

<sup>(2)</sup> Parts commonly available at welding supply store.

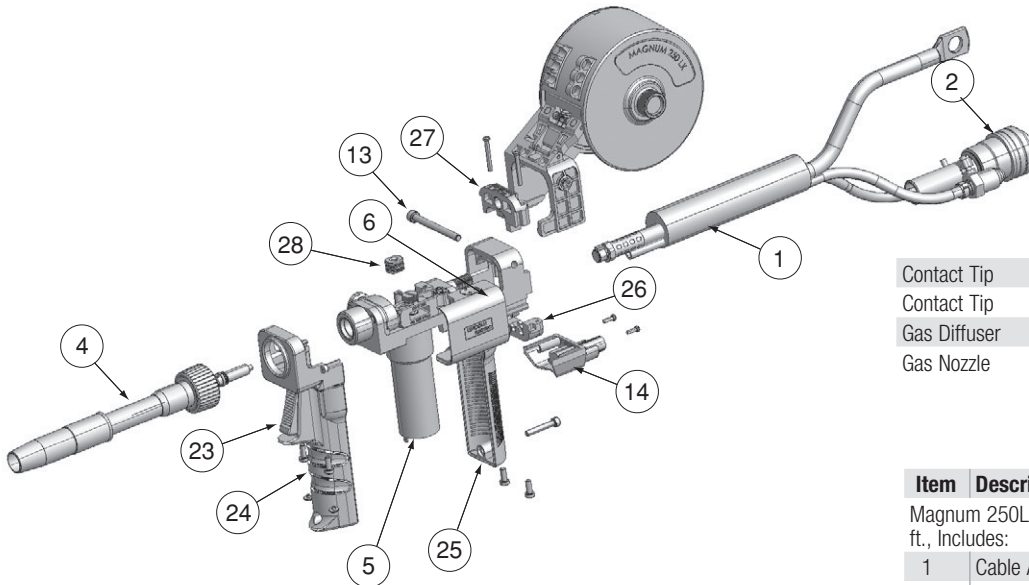


ITEM	DESCRIPTION	Part #	QTY
<b>Spool Gun Holder Assembly, Includes (47 thru 67)</b>			
47	Spool Cover	<b>S18697-30</b>	1
47a	Hand Nut for Spool Cover	<b>S18697-28</b>	1
48	Screw, 8-32 x 1/4	<b>S18697-60</b>	1
49	Plastic Cable Clamp	<b>(1)</b>	1
50	Set Screw, 8-32 x 1/8	<b>(1)</b>	1
51	Plastic Guide Tube	<b>S18697-33</b>	1
52	Snap Ring	<b>S18697-10</b>	1
53	Nylon Washer	<b>S18697-31</b>	1
54	Brass Washer	<b>(1)</b>	1
55	Spool Spring	<b>S18697-27</b>	1
56	Hand Nut, Brass	<b>S18697-6</b>	1
57	Nut, 1/4-20	<b>(1)</b>	1
58	Washer, 14 Shakeproof	<b>(1)</b>	2
59	Washer, 14 Disc Spring	<b>(1)</b>	3
60	Spool Spindle	<b>S18697-26</b>	1
61	Washer	<b>(1)</b>	1
62	Bolt, 1/4-20 x 3	<b>(1)</b>	1
63	Nut, 10-32	<b>(1)</b>	1
64	Washer, 10-32 Shakeproof	<b>(1)</b>	1
65	Screw, 10-32 x 1/2	<b>(1)</b>	1
66	Reel Base	<b>S18697-29</b>	1
67	Reel Support Bracket	<b>S18697-34</b>	1

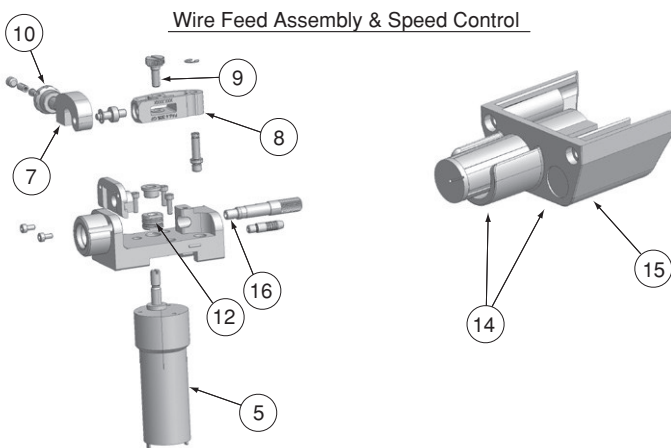
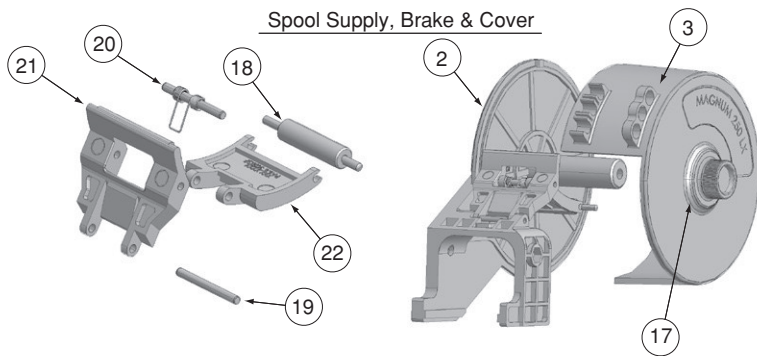
<sup>(1)</sup> Parts commonly available at hardware store.



# Magnum<sup>®</sup> 250 LX



Contact Tip	.035 (.9mm)	KP14H-35
Contact Tip	.045 - 3/64 (1.2mm)	KP14AH-364
Gas Diffuser	All	KP52FN
Gas Nozzle	All	KP23-50



Item	Description	Part #
Magnum 250LX Spool Gun, Air-Cooled, 25 ft., Includes:		K2490-1
1	Cable Assembly 25'	<b>S26374-1</b>
2	Connector	<b>S12020-50</b>
4	Barrel, Straight	<b>S26374-4</b>
4A	Barrel Liner	<b>KP2521-1</b>
5	Wire Feed Assembly	<b>See P-202-Z.1</b>
6	Wire Drive Cover	<b>S26374-6</b>
13	Hex Socket Head Screw (M6)	<b>S26374-13</b>
14	Wire Feed Speed Adjustment Pot Assembly	<b>S26374-14</b>
23	Trigger	<b>S26374-23</b>
24	Handle, Front (Includes Trigger)	<b>S26374-24</b>
25	Handle, Back	<b>S26374-25</b>
26	Cable Strain Relief, Bottom	<b>S26374-26</b>
27	Cable Strain Relief, Top	<b>S26374-27</b>
28	Drive Roll (Steel)	<b>KP2518-1</b>
	Drive Roll (Aluminum)	<b>KP2518-2</b>

Item	Description	Part #
2	Spool Supply & Brake Asbly	<b>S26374-2</b>
3	Spool Cover	<b>S26374-3</b>
5	Motor Gearbox	<b>S26374-5</b>
7	Pressure Lever	<b>S26374-7</b>
8	Pivot Arm	<b>S26374-8</b>
9	Set Screw, Pressure Roll	<b>S26374-9</b>
10	Pressure Adjustment Knob Asbly	<b>S26374-10</b>
11	Ball Bearing	<b>S26374-11</b>
12	Set Screw	<b>S26374-12</b>
14	Wire Feed Speed Adjustment Pot Assembly	<b>S26374-14</b>
15	Housing Potentiometer	<b>S26374-15</b>
16	Inlet Guide	<b>S26374-16</b>
17	Thumb Screw	<b>S26374-17</b>
18	Roller Pin	<b>S26374-18</b>
19	Pin	<b>S26374-19</b>
20	Spring	<b>S26374-20</b>
21	Spool Brake Lever	<b>S26374-21</b>
22	Roller Arm	<b>S26374-22</b>

# Magnum® PRO AL Push-Pull Guns

PRODUCT SPECIFICATIONS					
Product Name	Product Number 12-PIN	Product Number 7-PIN	Amperage Rating 100% Argon Gas	Wire Diameter Range in. (mm)	Cable Length ft. (m)
Magnum® PRO AL G225A	K3355-1	K3356-1	225A @ 60% Duty Cycle	.035 - 1/16 (0.9 - 1.6) aluminum and cored wire	15 (4.5)
	K3355-2	K3356-2			25 (7.6)
	K3355-3	K3356-3			35 (10.6)
	K3355-4	K3356-4			50 (15.2)
Magnum® PRO AL G450W	K3357-1	K3358-1	450A @ 60% Duty Cycle		15 (4.5)
	K3357-2	K3358-2			25 (7.6)
	K3357-3	K3358-3			35 (10.6)
	K3357-4	K3358-4			50 (15.2)

CONTACT TIPS 350A <sup>(1)</sup>	
Wire Diameter in. (mm)	Order Number
.030 (0.8)	KP2744-030A
	KP2744-030A-B100 <sup>(3)</sup>
.035 (0.9)	KP2744-035A
	KP2744-035A-B100 <sup>(3)</sup>
3/64 (1.2)	KP2744-364A5356
3/64 (1.2)	KP2744-364A
	KP2744-364A-B100 <sup>(3)</sup>
1/16 (1.6)	KP2744-116A
	KP2744-116A-B100 <sup>(3)</sup>

CONTACT TIPS 550A <sup>(1)</sup>	
Wire Diameter in. (mm)	Order Number
.030 (0.8)	KP2745-030A
	KP2745-030A-B100 <sup>(3)</sup>
.035 (0.9)	KP2745-035A
	KP2745-035A-B100 <sup>(3)</sup>
3/64 (1.2)	KP2745-364A5356
3/64 (1.2)	KP2745-364A <sup>(2)</sup>
	KP2745-364A-B100 <sup>(3)</sup>
1/16 (1.6)	KP2745-116A
	KP2745-116A-B100 <sup>(3)</sup>

STRAIGHT AND CURVED WATER-COOLED GUN TUBES (6 IN.)		
Product Name	Degree	Order Number
Magnum® PRO AL Air-Cooled	45°	KP3988-45
	45°	KP3380-45
	60°	KP3988-60
	60°	KP3380-60
	180°	KP3988-180
Magnum® PRO AL Water-Cooled	180°	KP3380-180
	45°	KP3381-45
	60°	KP3381-60
	180°	KP3381-180

CONTACT TIPS SPRING LOADED 550A	
Wire Diameter in. (mm)	Order Number
.030 (0.8)	KP3374-030A
.035 (0.9)	KP3374-035A
3/64 (1.2)	KP3374-364A
1/16 (1.6)	KP3374-116A



**7-pin to 12-pin Adapter**  
Use for connecting 7-pin push-pull guns such as the Magnum® PRO AL to a 12-pin connector in the Power Wave® C300.  
**Order K2910-1**

(1)Use of tip removal tool is recommended  
(3)Sold in quantity of 100

(1)Use of tip removal tool is recommended  
(2)This size tip furnished with gun  
(3)Sold in quantity of 100

TOOLS	
K3986-1	TOOL WRENCH 3/8" TORCH TIP
K3987-1	TOOL DRIVE ROLL REMOVAL
KP3376-1	LINER PACKAGE MAGNUM PRO
KP3377-1	SSCR LK CONDUIT

CABLE COVERS	
KP3378-15	CABLE COVER 15FT
KP3378-25	CABLE COVER 25FT
KP3378-35	CABLE COVER 35FT
KP3378-50	CABLE COVER 50FT

INSULATORS	
KP3982-1	250A/350A INSULATOR
KP3982-1-B25	250A/350A INSULATOR Pkg. Qty 25
KP3982-2	450A/550A INSULATOR
KP3982-2-B25	450A/550A INSULATOR Pkg. Qty 25

DRIVE ROLLS	
KP3989-1	DRIVE ROLL 0.035/0.040 INSULATED
KP3989-2	DRIVE ROLL 3/64 - 1/16 INSULATED
KP3990-1	DRIVE ROLL INSUL KNURL MAGNUM PRO

LINER	
KP3991-15	CONDUIT LINER 15FT MAGNUM PRO
KP3991-25	CONDUIT LINER 25FT MAGNUM PRO
KP3991-35	CONDUIT LINER 35FT MAGNUM PRO
KP3991-50	CONDUIT LINER 50FT MAGNUM PRO
KP3992-1	IDLER ROLL INSUL KNURL



# Python® & Python®-Plus Guns

Product Name	Product Number	Current Rated Current		Wire Diameter Range		Cable Length ft. (m)
		100% Argon		inches	(mm)	
Python®-Plus Air-Cooled	K3038-1	200A @ 100% Duty Cycle		.030 - 1/16	(0.8 - 1.6)	15 (4.5)
Python®-Plus Air-Cooled	K3038-2	200A @ 100% Duty Cycle		.030 - 1/16	(0.8 - 1.6)	25 (7.6)
Python®-Plus Air-Cooled	K3038-3	200A @ 100% Duty Cycle		.030 - 1/16	(0.8 - 1.6)	50 (15.2)
Python® Water-Cooled	K2212-2	400A @ 100% Duty Cycle		.030 - 1/16	(0.8 - 1.6)	25 (7.6)
Cougar™ Air-Cooled	K2704-2	300A @ 60% Duty Cycle		.035 - 1/16	(0.9 - 1.6)	25 (7.6)
Cougar™ Air-Cooled	K2704-3	300A @ 60% Duty Cycle		.035 - 1/16	(0.9 - 1.6)	50 (15.2)

## RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES



**7-pin to 12-pin Adapter**  
Use for connecting 7-pin push-pull guns such as the Python®-Plus to a 12-pin connector in the Power Wave® C300.  
Order K2910-1

CONTACT TIPS	
Wire Diameter in. (mm)	Order Number
.030 (0.8)	KP2217-1B1
.035 (0.9)	KP2217-2B1
3/64 (1.2)	KP2217-4B1
1/16 (1.6)	KP2217-5B1



Shown: KP2217-4B1



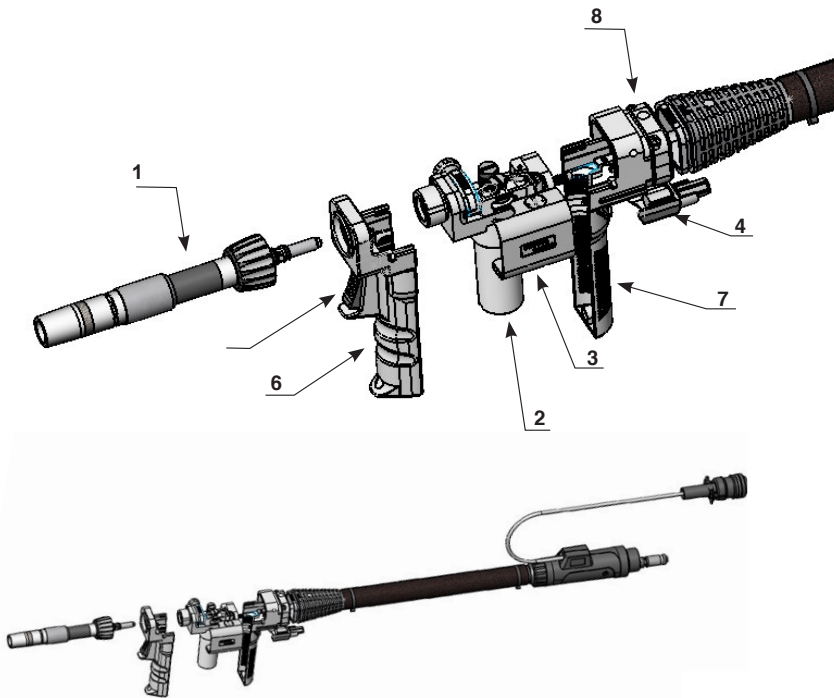
**Python®-Plus Air-Cooled Push-Pull Gun and Python® Water-Cooled Push-Pull Gun**  
The Python®-Plus air-cooled push-pull guns feature a Magnum® backend that integrates power, gas and wire conduit into a single easy connection for direct plug into a POWER MIG® 350MP wire feeder welder, Power Wave® C300 or Power Feed® 10M semiautomatic wire feeder. The Python® water-cooled push-pull gun has separate wire and conduit, power and gas connections and requires a connection adapter. See chart below for specifications.



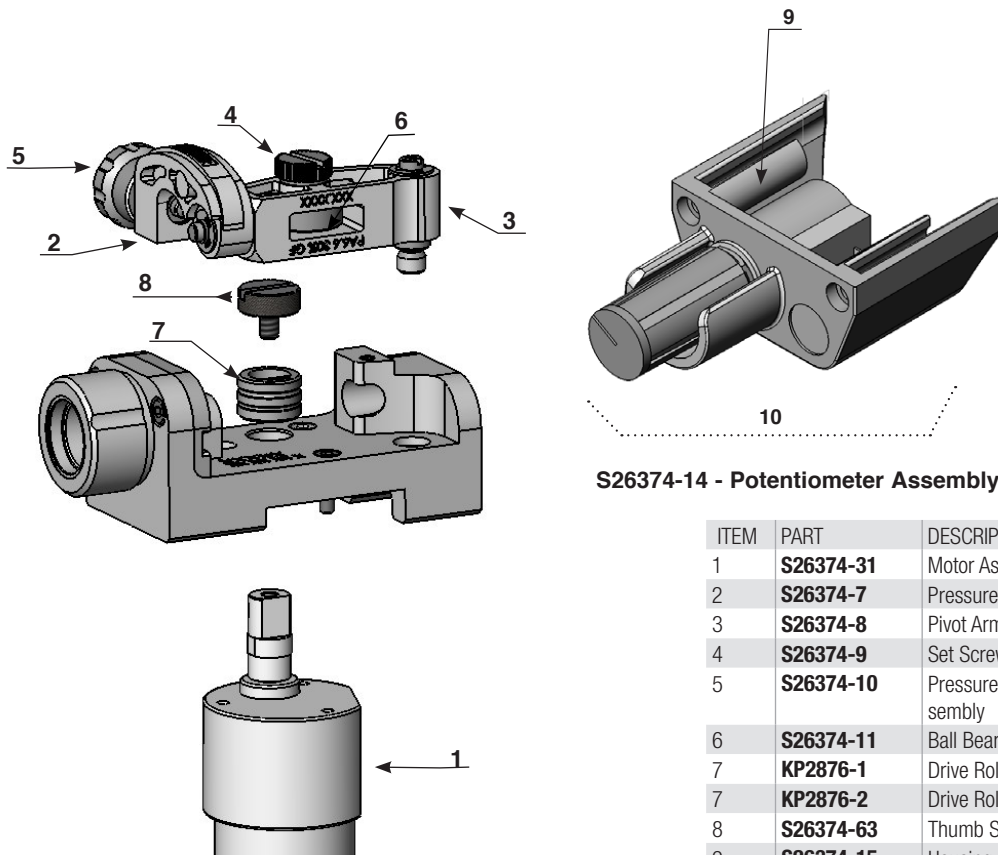
**Cougar™ Pistol-Grip Air-Cooled Push-Pull Guns**  
Cougar™ Push-Pull guns are intended for those operators who prefer an upright pistol-grip design for aluminum welding fabrication or production. Feature Sure-Grip™ handle, integrated strain relief and multi-turn potentiometer. Rated 300A @ 60% duty cycle w/Argon.  
See chart below for specifications.



# Cougar™ Parts



ITEM	PART	DESCRIPTION
1	<b>KP2877-180</b>	180 Degree Air-Cooled Gun Barrel
2	<b>S26374-31</b>	Motor Assembly
3	<b>S26374-6</b>	Wire Drive Cover
4	<b>S26374-14</b>	Potentiometer Assembly
5	<b>S26374-23</b>	Trigger Assembly
6	<b>S26374-24</b>	Handle, Front
7	<b>S26374-25</b>	Handle, Back
8	<b>S26374-33</b>	Strain Relief Clamp Kit
N/S	<b>S26374-28</b>	25' Cable Assembly - Cougar
N/S	<b>S26374-34</b>	50' Cable Assembly - Cougar
N/S	<b>S26374-35</b>	Cable Cover 25'
N/S	<b>S26374-36</b>	Cable Cover 50'
N/S	<b>S26374-37</b>	Power Cable Assembly 25'
N/S	<b>S26374-38</b>	Power Cable Assembly 50'
N/S	<b>S26374-39</b>	Wire Conduit Assembly 25'
N/S	<b>S26374-40</b>	Wire Conduit Assembly 50'
N/S	<b>S26374-41</b>	Control Wire Assembly 25'
N/S	<b>S26374-42</b>	Control Wire Assembly 50'
N/S	<b>S26374-60</b>	Gas Hose Assembly 25'
N/S	<b>S26374-61</b>	Gas Hose Assembly 50'
N/S	<b>S26374-32</b>	Rear End Feeder Connection Kit



**S26374-14 - Potentiometer Assembly**

ITEM	PART	DESCRIPTION
1	<b>S26374-31</b>	Motor Assembly
2	<b>S26374-7</b>	Pressure Lever
3	<b>S26374-8</b>	Pivot Arm
4	<b>S26374-9</b>	Set Screw, Pressure Roll
5	<b>S26374-10</b>	Pressure Adjustment Knob Assembly
6	<b>S26374-11</b>	Ball Bearing
7	<b>KP2876-1</b>	Drive Roll Kit AL .035-3/64"
7	<b>KP2876-2</b>	Drive Roll Kit AL 1/16"
8	<b>S26374-63</b>	Thumb Screw
9	<b>S26374-15</b>	Housing, Potentiometer
10	<b>S26374-14</b>	Potentiometer Assembly



# Cougar™ Service Parts

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Amperage Rating	Wire Diameter Range		Cable Length ft. (m)
			in.	(mm)	
Cougar™ Air Cooled	K2704-2	Argon: 300A @ 60% Duty Cycle	.035 - 1/16	(0.9 - 1.6)	25 (7.6)
Cougar™ Air Cooled	K2704-3	Argon: 300A @ 60% Duty Cycle	.035 - 1/16	(0.9 - 1.6)	50 (15.2)

## EXPENDABLE PARTS

### WIRE CONDUITS

Length ft. (m)	Wire Diameter in. (mm)	Part #
15 ft. (4.5)	.035 - 1/16 (0.9 - 1.6)	KP2881-15
25 ft.(7.6)	.035 - 1/16 (0.9 - 1.6)	KP2881-25
50 ft.(15.2)	.035 - 1/16 (0.9 - 1.6)	KP2881-50

### GUN BARRELS

Angle (Degrees)	Cooling System	Part #
60	Air-Cooled	KP2877-60
45	Air-Cooled	KP2877-45
180	Air-Cooled	KP2877-180

### GAS DIFFUSER

Type	
Pkg. Qty.	Thread-on
1	KP2746-1
25	KP2746-1-B25



Thread-on Gas Diffuser

### ALUMINUM CONTACT TIP FOR PUSH PULL

Wire Diameter in. (mm)	Part #
.035 (0.9)	KP2744-035A
3/64 (1.2)	KP2744-364A
3/64 (1.2)*	KP2744-364A5356
1/16 (1.6)	KP2744-116A

\* For low amperage 5356 wire applications.

### GUN TUBE INSULATOR

Pkg. Qty.	Part #
1	KP2773-2
25	KP2773-2-B25



Gun Tube Insulator

### GAS NOZZLE

		Nozzle Diameter (I.D.)		
Thread-on	Nozzle	Pkg. Qty.	0.5 in. (12.7 mm)	0.625(5/8) in. (15.9 mm)
	1/8 (3.2) Recess	1	KP2742-1-50R	KP2742-1-62R
		25	KP2742-1-50R-B25	KP2742-1-62R-B25
	Flush	1	KP2742-1-50F	KP2742-1-62F
25		KP2742-1-50F-B25	KP2742-1-62F-B25	



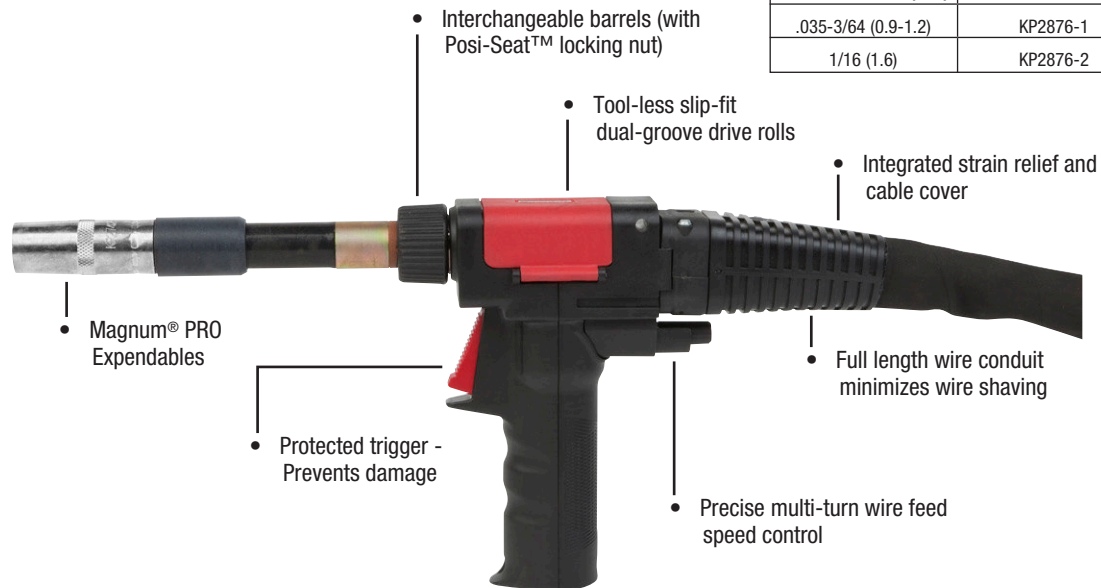
Thread-On Gas Nozzle

### BARREL LINERS

Angle (Degrees)	Barrel Size	Part #
45° and 60°	Barrel Liner (.035 - 1/16")	KP2879-1
180°	Barrel Liner (.035 - 1/16")	KP2879-2

### DRIVE ROLLS

Wire Diameter in. (mm)	Part #
.035-3/64 (0.9-1.2)	KP2876-1
1/16 (1.6)	KP2876-2



# Magnum® Classic Self-Shielded Semiautomatic Guns

## TECHNICAL SPECIFICATIONS

Product Number	GUN		WIRE DIAMETERS				Gun Tube Angle
	Rated Amps @ 60% Duty Cycle	Gun Cable Length ft. (m)	.068-5/64 in. (1.7-2.0 mm)	.062-3/32 in. (1.6-2.4 mm)	3/32 in. (1.6-2.4 mm)	7/64-.120 in. (1.6-2.4 mm)	
K115-1	450	10 (3.0)				■	82°
K115-2	450	15 (4.5)				■	82°
K115-3	450	10 (3.0)			■		82°
K115-4	450	15 (4.5)			■		82°
K115-8	450	15 (4.5)				■	45°
K115-10	450	15 (4.5)			■		45°
K116-2	600	15 (4.5)				■	Straight
K126-1 Classic	350	10 (3.0)		■			62°
K126-2 Classic	350	15 (4.5)		■			62°
K345-10	350	10 (3.0)	■				90°



**K115**  
Rated 450 amps. Use 3/32-.120 in. (2.4-3.0 mm) diameter wires. Choose from 10 or 15 ft. (3 or 4.5 m) cable lengths. 82° or 45° gun tubes.



**K126 Classic**  
Rated 350 amps. Use .062-3/32 in. (1.6-2.4 mm) diameter wires. Choose from 10 or 15 ft. (3 or 4.5 m) cable lengths. 62° gun tube.



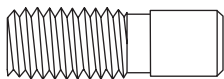
**K116**  
Rated 600 amps. Use 7/64-.120 in. (2.8-3.0 mm) diameter wire. 15 ft. (4.5 m) cable length. Adjustable grip angle. Straight gun tube.



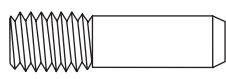
**K345**  
Rated 350 amps. Use .068-5/64 in. (1.7-2.0 mm) diameter wires. Cable is 10 ft. (3 m) in length. Reduced wire feed speed thumb switch. 90° gun tube.

## EXPENDABLE PARTS

Description	K115-1, -2, -8	K115-3, -4, -10	K116-2	K126-1, -2 (3)	K345-10
<b>Gun Tubes</b>					
30° Standard Length				KP1914-2	KP1914-2
30° Long Length				KP1914-1	KP1914-1
45°	KP1910-1	KP1910-2			
45° Hardfacing	KP1952-1				
62°				KP1909-1	KP1909-1
82°	KP1907-1	KP1907-2			
Straight			KP1908-1, -2		
82° Hardfacing	KP1953-1				
90°				KP1920-1	KP1920-1
<b>Contact Tips Severe Duty</b>					
1/16 in.				KP2100-2B1	
.068-.072 in.				KP2100-1B1(1)	KP2100-1B1(1)
5/64 in.				KP2100-4B1(1)	KP2100-4B1(1)
3/32 in.		KP2103-4B1(1)		KP2100-3B1(1)	
7/64 in.	KP2103-6B1(1)		KP2103-6B1(1)		
.120 in.	KP2103-3B1(1)		KP2103-3B1(1)		
<b>Contact Tips Extended Life</b>					
1/16 in.				KP2935-116	
.072 in.				KP2935-072	
5/64 in.				KP2935-564	
3/32 in.				KP2935-332	



Contact Tips (KP2103)



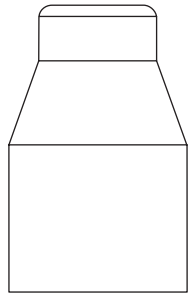
Contact Tips (KP2100-X)

(1) Included as standard with Gun and Cable Assembly. (2) Thread protector. (3) K126 PRO Innershield® Guns are detailed in Publication E12.11.

# Magnum Classic Self-Shielded Semiautomatic Guns Insulated Guides

## K115 & K116

Electrical Stickout In./mm	Part Number
1-1/2" (38 mm)	<b>KP1971-1</b>
2-3/4" (70 mm)	<b>KP1965-1</b>
3-3/4" (95 mm)	<b>KP1965-2</b>



Insulated Guide  
(KP1971-1)



Insulated Guide  
(KP1965-2)

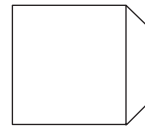


Insulated Guide  
(KP1965-1)

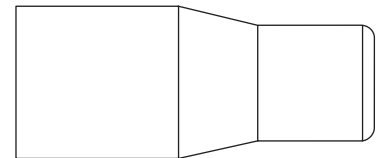
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## K126 (Classic)

Electrical Stickout	Thread Protector	Insulated Guide
.75-1.50"	<b>KP2089-1</b>	-
1.50"	-	<b>KP1987-1</b>
2.00" (51 mm)	-	<b>KP1995-1</b>
2.75" (70 mm)	-	<b>KP2090-1</b>



Thread Protector  
(KP2089-1)



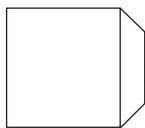
Insulated Guide  
(KP1995-1)



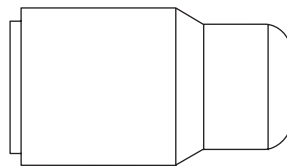
Insulated Guide (KP2090-1)

## K264, K345, K355 & K361

Electrical Stickout In.	Thread Protector	Insulated Guide
3/4-1-1/2"	<b>KP2089-1</b>	<b>KP1987-1</b>
2"	-	<b>KP1995-1</b>



Thread Protector (KP2089-1)



Insulated Guide (KP1987-1)

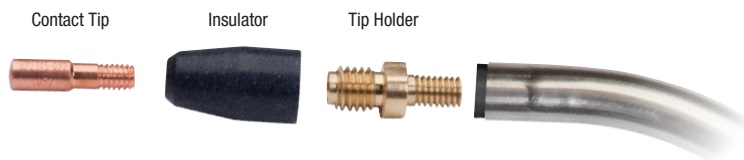
### Insulated Guides

Description	K115-1, -2, -8	K115-3, -4, -10	K116-2	K126-1, -2 <sup>(3)</sup>	K345-10
1-1/2 in. Stickout	KP1971-1 <sup>(1)</sup>	KP1971-1 <sup>(1)</sup>	KP1971-1 <sup>(1)</sup>		
1-1/2 in. Stickout				KP1987-1	KP1987-1
2 in. Stickout				KP1995-1	KP1995-1 <sup>(1)</sup>
2-3/4 in. Stickout				KP2090-1	
2-3/4 in. Stickout	KP1965-1 <sup>(1)</sup>	KP1965-1 <sup>(1)</sup>	KP1965-1 <sup>(1)</sup>		
3-3/4 in. Stickout	KP1965-2	KP1965-2	KP1965-2		
3-3/4 in. Stickout				KP2089-1 <sup>(1)(2)</sup>	KP2089-1 <sup>(1)(2)</sup>

(1) Included as standard with Gun and Cable Assembly. (2) Thread protector.

# K126™ PRO Expendables

## EXPENDABLE PARTS



K466-10 Gun Connector Shown<sup>(5)</sup>

### TIP HOLDER AND INSULATOR

Description	Part Number	Pkg. Qty.
Tip Holder	KP2908-1	1
Insulator	KP2907-1	1

### CONTACT TIPS 550 A

Wire Diameter in. (mm)	Standard		Extended Life	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP2745-035	KP2745-035-B100	KP2745-035R	KP2745-035R-B100
0.040 (1.0)	KP2745-040	KP2745-040-B100	NA	NA
0.045 (1.2)	KP2745-045	KP2745-045-B100	KP2745-045R	KP2745-045R-B100
0.052 (1.3)	KP2745-052	KP2745-052-B100	KP2745-052R	KP2745-052R-B100
1/16 (1.6)	KP2745-116	KP2745-116-B100	KP2745-116R	KP2745-116R-B100
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072-B100	KP2745-072R	KP2745-072R-B100
5/64 (2.0)	KP2745-564	KP2745-564-B100	KP2745-564R	KP2745-564R-B100
3/32 (2.4) <sup>(1)</sup>	KP2745-332	KP2745-332-B100	KP2745-332R	KP2745-332R-B100
7/64 (2.8) <sup>(1)</sup>	KP2745-764	KP2745-764-B100	KP2745-764R	KP2745-764R-B100
1/8 (3.2) <sup>(1)</sup>	KP2745-18	KP2745-18-B100	NA	NA

(1) 550 only

### GUN TUBE (GOOSENECKS)

Part Number	Gun Tube Description
<b>Reverse Bend<sup>(2)</sup> Stainless Steel Jacket</b>	
KP2906-62R	62° Reverse Bend, 6 in. (152 mm)
KP2906-30R	30° Reverse Bend, 6 in. (152 mm)
KP2906-30R-L	30° Reverse Bend, 12 in. (305 mm)
<b>Non-Reverse Stainless Steel Jacket</b>	
KP2906-62	62° Non-Reverse Bend, 6 in. (152 mm)
KP2906-30	30° Non-Reverse Bend, 6 in. (152 mm)
KP2906-30-L	30° Non-Reverse Bend, 12 in. (305 mm)
<b>Reverse Bend Classic Braided Varnish Jacket<sup>(3)</sup></b>	
KP2927-62R	62° Reverse Bend, 6 in. (152 mm)
KP2927-30R-L	30° Reverse Bend, 12 in. (305 mm)
KP2482-1	30° Reverse Bend, 11.68 in. (297 mm)
<b>Non-Reverse Bend Classic Braided Varnish Jacket<sup>(3)</sup></b>	
KP3267-1	30° Non-Reverse Bend, 12 in. (305 mm)

(2) Reverse Bend gun tubes require a 3/32 in. (2.4 mm) liner.

(3) Gun tubes require corresponding gun connector and liner. Maximum diameter 5/64 in. (2.0 mm)

### GENERAL OPTIONS



**Magnum® PRO Harness Adapter**  
Required for use with Magnum® PRO Dual Procedure or Dual Schedule guns when adapting to Miller Electric® wire feeders.  
**Order K3159-1**

### OPTIONAL GUN CONNECTOR KIT

Manufacturer	Wire Feeder Model	For Small Feeder Bushings	For Large Feeder Bushings
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8	K613-6 <sup>(4)</sup>
	LF-72, LF-74 Series, LN-25 PRO Power Feed® 10 and 25 series	K466-10 <sup>(5)</sup>	K613-7
	POWER MIG® Series and Power Wave® C300	K466-6	NA
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2	K613-2
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	K466-3	K613-3

Note: K466 series gun connectors are limited to 5/64 in. (2.0 mm) diameter wire.

(4) K613-6 standard on K126-10, -11, -13

(5) K466-10 standard on K126-12

### GUN LINERS in. (mm)

K466 Series Gun Connector	K613 Series Gun Connector
Wire Diameter 1/16 - 5/64 in. (1.6 - 2.0 mm)	Wire Diameter 1/16 - 3/32 in. (1.6 - 2.4 mm)
KP44-564-15	KP45H-332-15



Shown: KP3267-1 Gun Tube

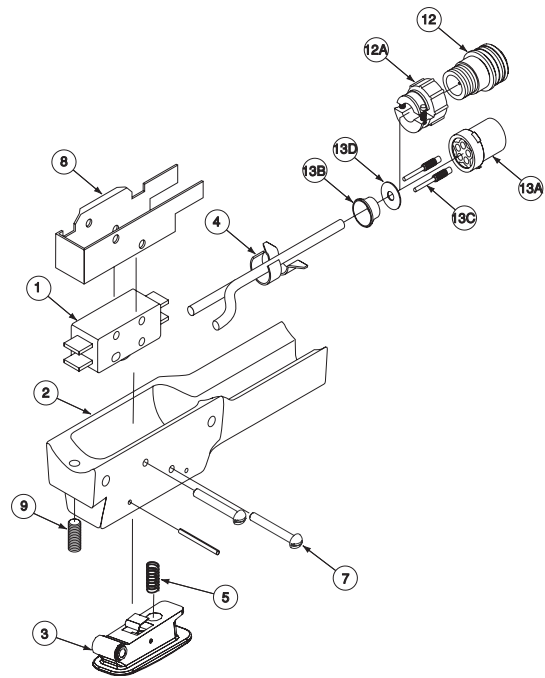
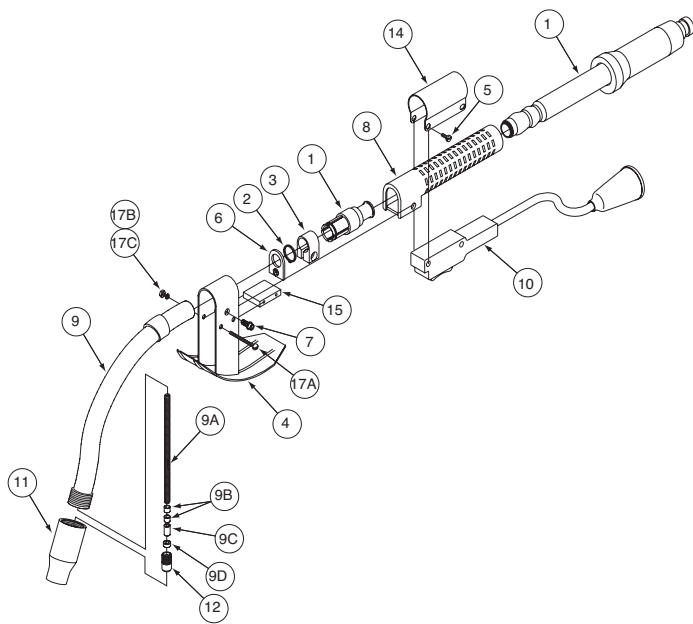
Stainless Gun Tube 30°



Braided Varnish Classic Gun Tube 62°



# Innershield® K115 Squirt Gun & Cable



ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly Includes:			
1	Conductor Cable, Includes: (3/32-.120") 15 or 10 ft.	L5728-5* or -10*	1
1	Conductor Cable, Includes: (5/64") 15 or 10 ft.	L5728-7* or -14*	1
	Handle, Wire Feeder End	M14048	1
	Connector, Wire Feeder End	S12801-6	1
	Connector, Gun End	S12802-13	1
	Connector, Gun End	S12802-14	1
	Clamping Tube, Both Ends	S7748-40	2
2	Snap Ring	S9776-7	1
3	Clamp	S15921-2	1
4	Clamp and Shield Assembly	S12880	1
5	Pan Head Screw	CF000049	4
6	Spatter Shield	T12027	1
7	Socket Head Cap Screw	T14438	1
8	Handle	M10102-1	1
9	Nozzle (82o), Includes:	See Expendables	1
9	Nozzle (45o), Includes:	See Expendables	1
9A	Nozzle Liner, Tight Wound Steel Spring (.120)	KP2095-6	1
9A	Nozzle Liner, Tight Wound Steel Spring (3/32)	KP2095-5**	1
9A	Nozzle Liner, Tight Wound Steel Spring (5/64)	KP2095-13	1
9B	Nozzle Insert (.120, 7/64)	KP2094-3*	1
9B	Nozzle Insert (5/64, 3/32)	KP2094-1	2
9C	Nozzle Insert Retainer	T12977-2	1
9D	Liner Locking Screw	T12932-2	1
10	Trigger and Control Cable Assembly key	M12462-[ ]	
11	Insulated Guides	See Expendables	
12	Contact Tip (Length 1-1/8")	See Expendables	1
14	Switch Housing Clamp	S15922-1	1
17	Round Head Screw (#8-32 x 1.50)	CF00119	2
17A	Lock Washer	T9695-3	2
17B	Hex Nut (#8-32)	CF000042	2

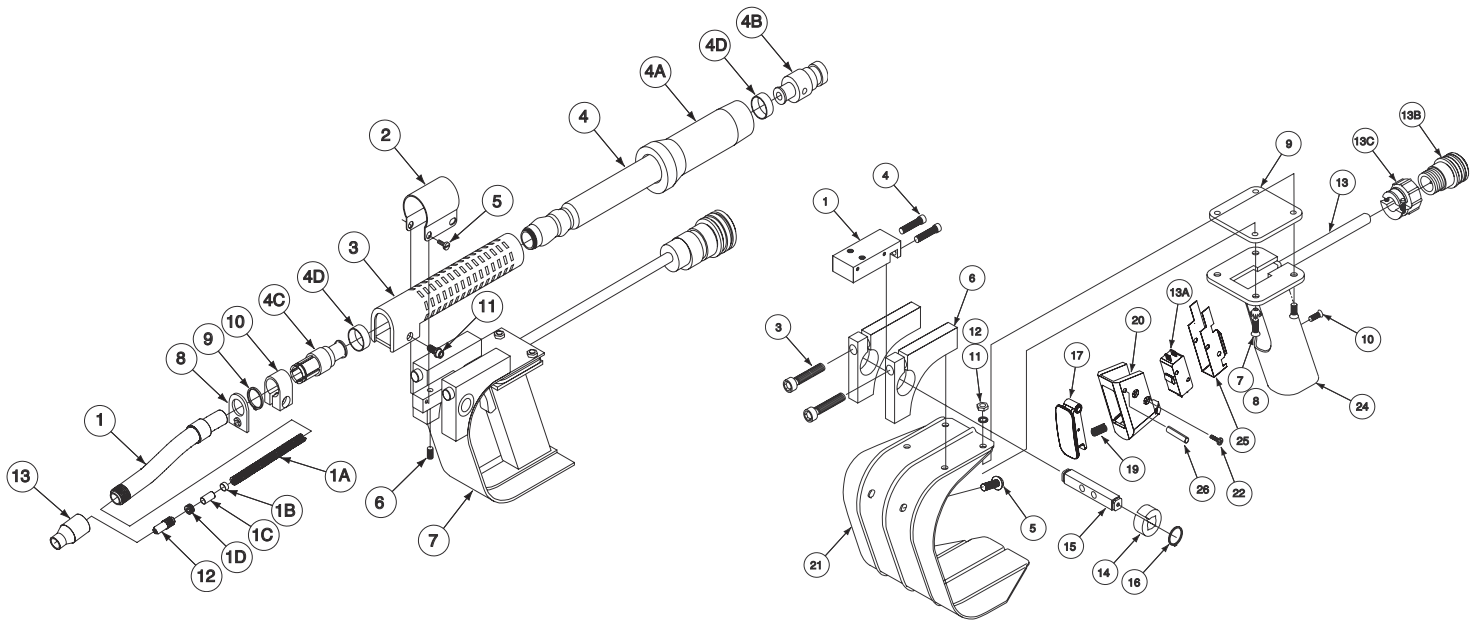
\* Discontinued. Available until stock is depleted.

\*\* Discontinued. Use KP2095-2.

ITEM	DESCRIPTION	Part #	QTY
Trigger & Control Cable Asbly,		Includes:	
1	Micro Switch	T12485	1
2	Housing	L10706	1
3	Trigger Assembly	S23982*	1
4	Cord Clamp	T11669-2	1
5	Coil Spring	T12025	2
6	Roll Pin	T9967-52	2
7	#3-48 x .75 RHS	CF000312	2
8	Insulating Sleeving	S14878	1
9	Set Screw	S11604-22	1
12	Polarized Plug, Wire Feeder End, (Not Shown) (Old Style)	S12020-6	1
12	Polarized Plug, Wire Feeder End	S12020-16	1
12A	Clamp at Polarized Plug (Old Style) (Not Shown)	S12024-1	1
12A	Clamp at Polarized Plug	S12024-4	1
	Molded Plug Kit Includes:	S19757	1
13A	Connector Body	NSS	1
13B	Connector Cover	NSS	1
13C	Connector Pin	NSS	2
13D	Insulating Washer	NSS	1
13E	Strain Relief	NSS	1

\*For earlier design "straight pull" trigger, contact Service Department for replacement parts.

# Innershield® K116 Squirt Gun, Cable & Gun Handle



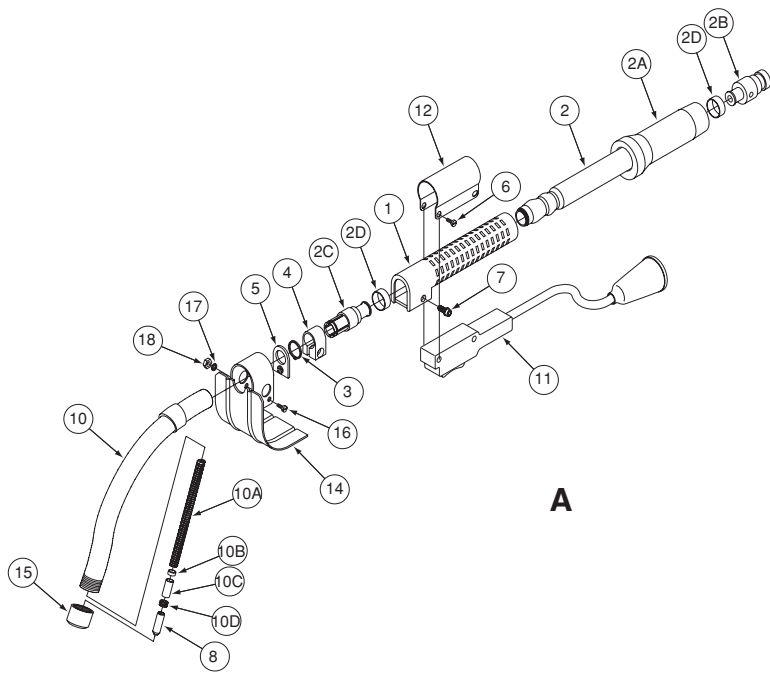
ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly Includes:			
1	Nozzle, Includes:	<b>See Expendables</b>	
1A	Nozzle Liner	<b>KP2095-7*</b>	1
1B	Nozzle Insert (.120 & 7/64")	<b>KP2094-3</b>	1
1B	Nozzle Insert (3/32")	<b>KP2094-1</b>	1
1C	Nozzle Insert Retainer	<b>T12977-2</b>	1
1D	Liner Locking Screw	<b>T12932-2</b>	1
2	Switch Housing Clamp	<b>S12339-1</b>	1
3	Handle	<b>M10102-1</b>	1
4	Conductor Cable, Includes: (15 ft)	<b>L5728-5*</b>	
4A	Handle, Wire Feeder End	<b>M14048</b>	1
4B	Connector, Wire Feeder End	<b>S12801-4</b>	1
4C	Connector, Gun End	<b>S12802-13</b>	1
4D	Clamping Tube, Both Ends	<b>S7748-40</b>	2
5	Pan Head Screw	<b>CF000049</b>	4
6	Socket Head Screw	<b>S11604-9</b>	2
7	Handle & Control Cable Assembly - 10' Length	<b>L5734-10*</b>	
8	Spatter Shield	<b>T12027</b>	1
9	Snap Ring	<b>S9776-7</b>	1
10	Clamp	<b>S15921-2</b>	1
11	Socket Head Cap Screw	<b>T14438</b>	1
12	Contact Tip	<b>See Expendables</b>	1
13	Insulated Guide	<b>See Expendables</b>	1

ITEM	DESCRIPTION	Part #	QTY
Handle & Control Cable Assembly - 10' Length			
		<b>L5734-10</b>	
1	Handle Mounting Bracket	<b>S12905</b>	1
3	Socket Head Cap Screw	<b>T9447-36</b>	2
4	Socket Head Cap Screw	<b>T9447-22</b>	2
5	#8-32 x.5 RHS	<b>CF000033</b>	12
6	Handle Pivot Block	<b>S12690</b>	1
7	#8-32 x.625 FHS	<b>CF000147</b>	2
8	Lock Washer	<b>T10441-1</b>	2
9	Insulating Pad	<b>T12241</b>	1
10	#8-32 x.5 FHS	<b>CF000146</b>	3
11	Lock Washer	<b>T4291-A</b>	2
12	#8-32 HN	<b>CF000042</b>	2
13	Control Cable, Includes: 15' Length Cable	<b>M10427-15</b>	1
13A	Micro Switch	<b>T12485</b>	1
13B	Polarized Plug, Wire Feeder End	<b>S12020-6</b>	1
13C	Clamp at Plug	<b>S12024-1</b>	1
14	Friction Bushing	<b>T12233</b>	2
15	Handle Pivot Shaft	<b>T12239</b>	1
16	Snap Ring	<b>S9776-25</b>	2
17	Trigger Assembly	<b>S23982[*]</b>	1
19	Spring	<b>T12025</b>	2
20	Trigger Mounting Block	<b>M18910</b>	1
21	Gun Shield	<b>L4188</b>	1
22	#3-48 x .75 RHS	<b>CF000312</b>	2
23	Roll Pin	<b>T9967-27</b>	2
24	Handle	<b>S12687-1</b>	1
25	Switch Insulation	<b>S14878</b>	1
26	Roll Pin	<b>T9967-52</b>	1

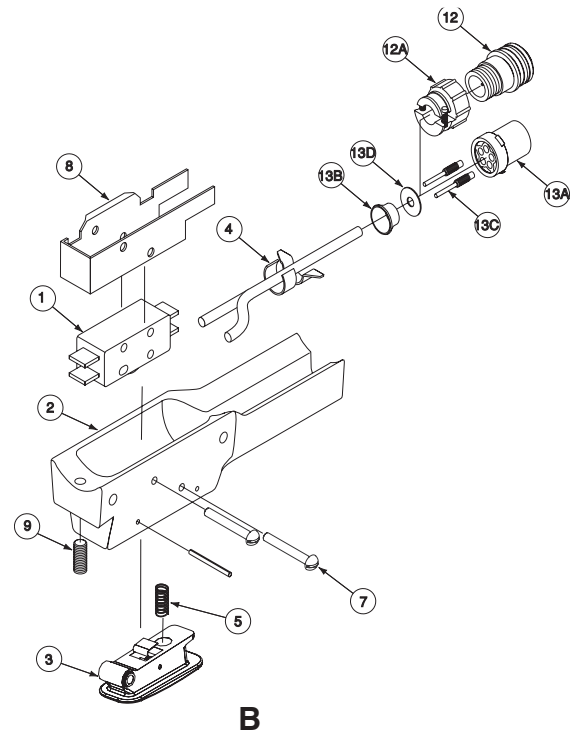
\* Discontinued. No longer available.

\*For earlier design "straight pull" trigger, contact Service Department for replacement parts.

# Innershield® Classic K126 Squirt Gun, Cable



## K126, K112 & K113 Trigger & Control Cable Parts

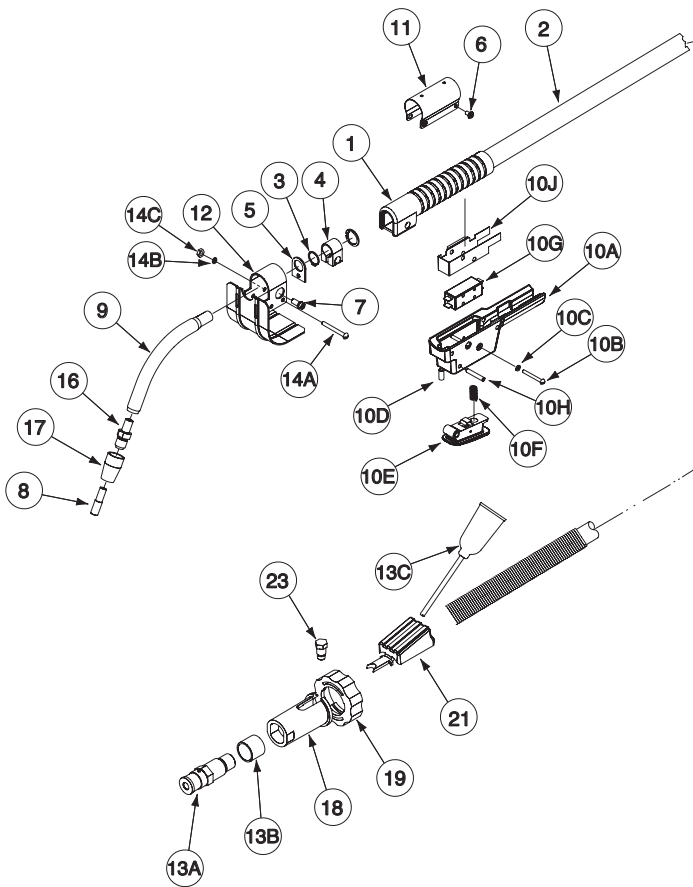


ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly, Includes:			
1	Handle	M10102-1	1
2	Conductor Cable, Includes: (15')	L6250-1*	1
2	Conductor Cable, Includes: (10')	L6250-2*	1
2A	Handle & Stiffener, Wire Feeder End	M14050-1	
2B	Connector, Wire Feeder End	S12801-3	1
2C	Connector, Gun End	S12802-12	1
2D	Clamping Tube, Both Ends	S16997	2
3	Snap Ring	S9776-7	1
4	Clamp	S15921-2	1
5	Spatter Shield	T12027	1
6	#8-32 x .25 PNHS	CF000148	4
7	Socket Head Cap Screw	T14438	
8	Contact Tip	See Expendables	
10	Nozzle, Includes (Gun Tube):	KP1909-1	1
10A	Nozzle Liner, Tight Wound Steel Spring	KP2095-4	1
10B	Nozzle Insert	KP2094-2	1
10C	Nozzle Insert Retainer	T12977-1	1
10D	Liner Locking Screw	T12932-1	1
11	Trigger & Control Cable	For Details See B	
	10 ft.	M12462-10	1
	15 ft.	M12462-15	1
12	Clamp	S15922-1	1
14	Heat Shield Assembly	S13037	1
15	Thread Protector, 3/4 to 1-1/2" Stickout	KP2089-1	1
16	#8-32 x 1.50 RHS	CF000119	4
17	Lock Washer	T9695-3	2
18	#8-32 HN	CF000042	2

ITEM	DESCRIPTION	Part #	QTY
Trigger & Control Cable Assembly, Includes:			
1	Micro Switch	T12485	1
2	Housing	L10706	1
3	Trigger Assembly	S23982*	1
4	Cord Clamp	T11669-2	1
5	Coil Spring	T12025	2
6	Roll Pin	T9967-52	1
7	#3-48x.75 RHS	CF000312	1
8	Switch Insulation	S14878	1
9	Set Screw	S11604-22	1
12	Polarized Plug, Wire Feeder End, (Not Shown) (Old Style)	S12020-6	1
12	Polarized Plug, Wire Feeder End	S12020-16	1
12A	Clamp at Polarized Plug (Old Style) (Not Shown)	S12024-1	1
12A	Clamp at Polarized Plug	S12024-4	1
Molded Plug Kit, Includes:			
		S19757	1
13A	Connector Body	NSS	1
13B	Connector Cover	NSS	1
13C	Connector Pin	NSS	2
13D	Insulating Washer	NSS	1
13E	Strain Relief	NSS	1

**Note :** When tip life is limited by tip being fused over the use of KP2105-[ ] tips may result in a lower overall cost.

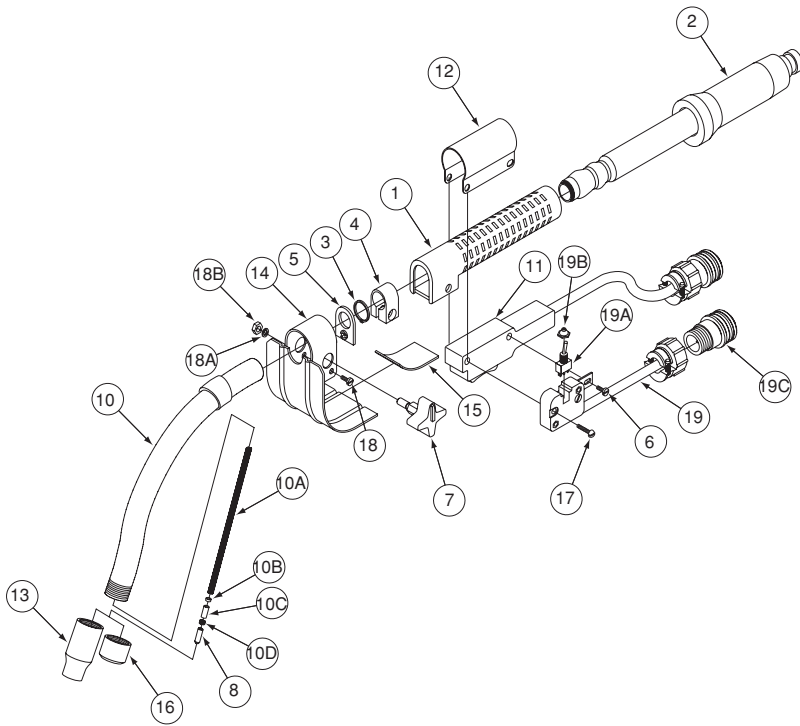
# K126™ PRO Gun



ITEM	DESCRIPTION	Part #	QTY	1	2	3	4
	Gun & Cable Assembly (G6760-2), Includes:	<b>K126-11</b>	1	X	-	-	-
	Gun & Cable Assembly (G6760-1), Includes:	<b>K126-12</b>	1	-	X	-	-
	Gun & Cable Assembly (G6760-3), Includes:	<b>K126-10</b>	1	-	-	X	-
	Gun & Cable Assembly (G6760-4), Includes:	<b>K126-13</b>	1	-	-	-	X
1	Handle	<b>M10102-2</b>	1	X	X	X	X
2	Cable Assembly (15') (L15654), Includes:	<b>NSS</b>	1	X	X	X	X
3	Snap Ring	<b>S9776-7</b>	1	X	X	X	X
4	Clamp	<b>S15921-1</b>	1	X	X	X	X
5	Spatter Shield	<b>T12027</b>	1	X	X	X	X
6	8-32 x .25 PHS	<b>CF000148</b>	4	X	X	X	X
7	Clamping Screw	<b>T14438</b>	1	X	X	X	X
8	Contact Tip, 5/64" (2.0 mm)	<b>KP2745-564R</b>	X	X	X	X	X
9	Formed Gun Tube	<b>KP2906-62</b>	1	X	X	X	-
9	Formed Gun Tube	<b>KP3267-1</b>	1	-	-	-	X
10	Gun Control Assembly, Includes:	<b>M22370</b>	1	X	X	X	X
10A	Switch Housing	<b>L10706</b>	1	X	X	X	X
10B	#3-48 x .875 RHS	<b>CF000138</b>	2	X	X	X	X
10C	Lock Washer	<b>E106A-17</b>	2	X	X	X	X
10D	Set Screw	<b>S11604-22</b>	1	X	X	X	X
10E	Trigger Assembly	<b>S23982</b>	1	X	X	X	X
10F	Trigger Coil Spring	<b>T12025</b>	1	X	X	X	X
10G	Trigger Switch Assembly	<b>S28279</b>	1	X	X	X	X
10H	Roll Pin	<b>T9967-52</b>	1	X	X	X	X
10J	Switch Insulation	<b>S14878</b>	1	X	X	X	X
11	Clamp	<b>S15922-1</b>	1	X	X	X	X
12	Heat Shield Assembly	<b>S13037</b>	1	X	X	X	X
13	Gun Connector Kit Assembly, Includes:	<b>K613-1</b>	1	X	-	X	-
13	Gun Connector Kit Assembly, Includes:	<b>K466-10</b>	1	-	X	-	-
13	Gun Connector Kit Assembly, Includes:	<b>K613-6</b>	1	-	-	-	X
13A	Connector Assembly	<b>S18645-1</b>	1	X	-	X	-
13A	Connector Assembly	<b>S18653</b>	1	-	X	-	-
13A	Connector Assembly	<b>S18645-3</b>	1	-	-	-	X
13B	Insulation Tube	<b>T7028-234</b>	1	X	-	X	X
13C	Gun Control Assembly	<b>M15608</b>	1	X	X	X	X
14A	#8-32 x 1.50 RHS	<b>CF000119</b>	2	X	X	X	X
14B	Lock Washer	<b>T9695-3</b>	2	X	X	X	X
14C	#8-32 HN	<b>CF000042</b>	2	X	X	X	X
16	Tip Holder	<b>KP2908-1</b>	1	X	X	X	X
17	Insulator	<b>KP2907-1</b>	1	X	X	X	X
18	Tail Piece	<b>M15607</b>	1	X	X	X	X
19	Nut (Cable Handle)	<b>S18690</b>	1	X	X	X	X
21	Connector Cover	<b>L7723</b>	1	X	X	X	X
23	Molded Gas Plug	<b>S18695</b>	1	X	X	X	X
24	Cable Liner (Not Shown)	<b>KP45H-332-15</b>	1	X	-	X	X
24	Cable Liner (Not Shown)	<b>KP44-564-15</b>	1	-	X	-	-



# Innershield® K264, K345, K355 & K361 Squirt Gun & Cable Assemblies

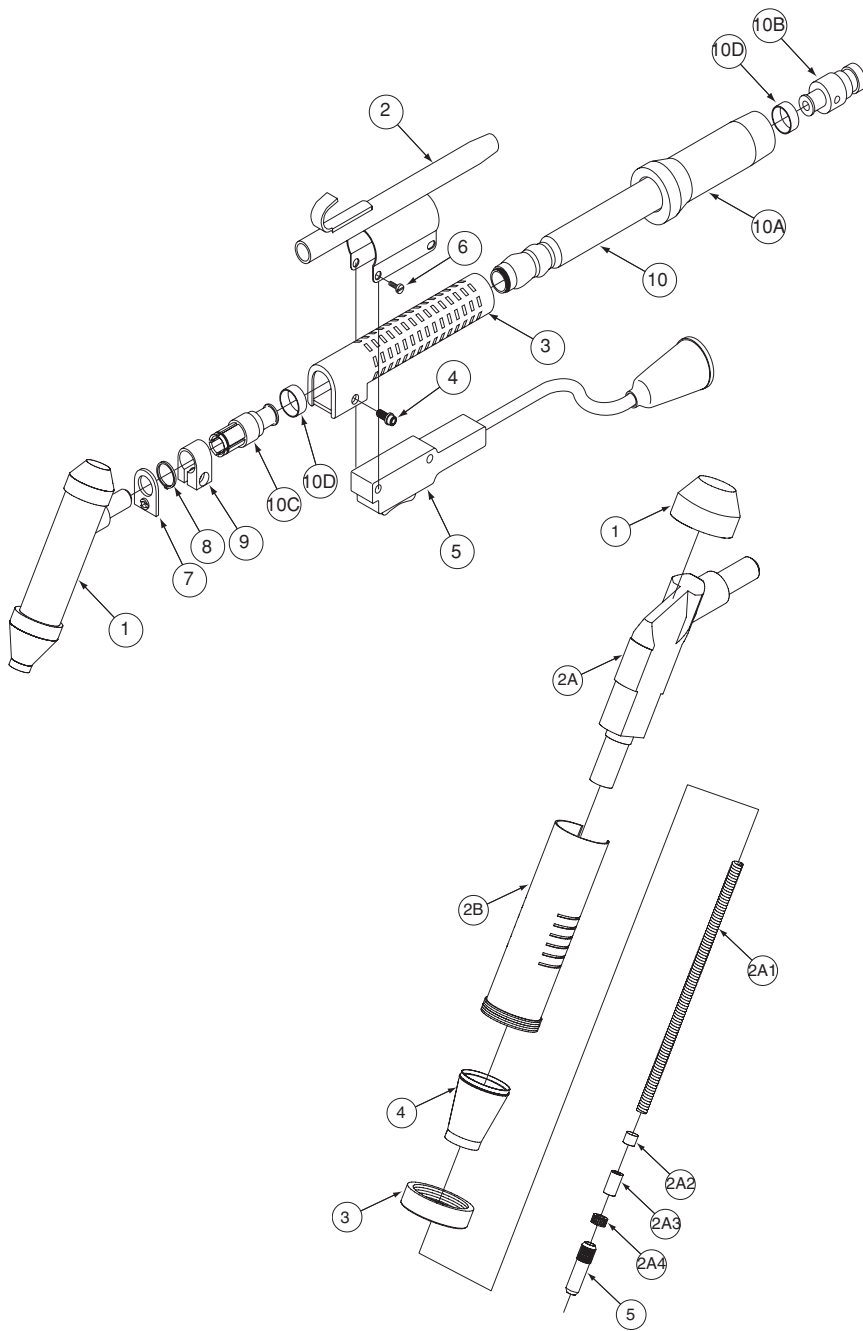


ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly, Includes:			
1	Handle	M10102	1
2	Conductor Cable (K264-8)	L5993-2	1
2	Conductor Cable (for K355-10)	L5993-3	1
2	Conductor Cable (for K345-10 & K361-10)	L5993-4	
3	Retaining Ring	S9776-7	1
4	Clamp	S11598-1	1
5	Spatter Shield	T12027	1
6	Pan Head Screw	CF000049	3 or 4
7	Hand Screw Assembly	T13858	1
8	Contact Tip	See Expendables	1
10	62° Nozzle Assembly	KP1909-1 (Std.)	1
10	90° Nozzle Assembly	KP1920-1	1
10	30° Nozzle Assembly - 6" long	KP1914-2	1
10	30° Nozzle Assembly - 12" long	KP1914-1	1
10A	62° and 30° Nozzle Liner 6" long	KP2095-4	1
10A	90° Nozzle Liner	KP2095-14*	1
10A	30° Nozzle Liner - 12" Long	KP2095-9*	1
10B	Nozzle Insert	T12576-2	1
10C	Nozzle Insert Retainer	T12977-1	1
10D	Liner Locking Screw	T12932-1	1
11	Trigger & Control Cable Assembly (8 ft.)	M12956-8	1
11	Trigger & Control Cable Assembly (10 ft.)	M12956-10	1
12	Clamp	S15922-1	1
13	Nozzle Assembly Insulated Guide	See Expendables	1
14	Heat Shield Assembly	S13037	1
15	Gun Caution Decal	T13297	1
16	Thread Protector	KP2089-1	1
17	Round Head Screw (K345 & K355)	CF000096	1
18	Round Head Screw	CF000119	2
18A	Lock Washer	T9695-3	2
18B	Hex Nut	CF000042	2
19	Switch & Cable Assembly, (K345 & K355) Includes:	S16383-1	1
19A	Switch	T13381-6	1
19B	Switch Boot	T13938-6	1
19C	Polarized Plug	S12020-17	1

Note: When tip life is limited by tip being fused over, KP2105-[ ] tips may give a lower overall cost.

\* Discontinued. Use KP2095-15.

# K112 & K113 Sub Arc Gun Assembly



ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly:			
	500 Amp, 15 ft., 1/16" Electrode	<b>K112 *</b>	
	600 Amp, 15 ft., 5/64" Electrode	<b>K113-1</b>	
	600 Amp, 15 ft., 3/32" Electrode	<b>K113-2</b>	
1	Gun Assembly		
2	Clamp and Flux Tube Assembly	<b>S16165</b>	1
3	Handle	<b>M10102-1</b>	1
4	Socket Head Cap Screw	<b>T14438</b>	1
5	Trigger and Control Cable Assembly Parts Breakdown	<b>(See K126 info)</b>	
6	#8-32 x .25 PHS	<b>CF000148</b>	4
7	Spatter Shield	<b>T12027</b>	1
8	Retaining Ring	<b>S9776-7</b>	1
9	Clamp (for K112)	<b>S11598-1</b>	1
9	Clamp (for K113-1,-2)	<b>S15921-2</b>	1
10	Conductor Cable for K112, Includes:	<b>L6250-4</b>	1
10A	Handle and Stiffener	<b>M14050-1</b>	1
10B	Connector, Feeder End	<b>S12801-9</b>	1
10C	Connector, Gun End	<b>S12802-16</b>	1
10D	Clamping Tube, Both Ends	<b>S16997</b>	2
10	Conductor Cable for K113-1, -2 Includes:	<b>L5728-7</b>	1
10A	Handle and Stiffener	<b>M14048</b>	1
10B	Connector, Feeder End	<b>S12801-6</b>	1
10C	Connector, Gun End	<b>S12802-14</b>	1
10D	Clamping Tube, Both Ends	<b>S7748-40</b>	2

\* Discontinued

Gun Assembly (K112)	<b>M10614-7</b>	
Gun Assembly (K113-1)	<b>M10614-9</b>	
Gun Assembly (K113-2)	<b>M10614-8</b>	
Includes:		
1	Cap	<b>T14181</b> 1
2	Housing & Nozzle Assembly 1/16" (K112)	<b>M10670-5</b> 1
	5/64" (K113-1)	<b>M10670-7</b> 1
	3/32" (K113-2) Includes:	<b>M10670-6</b> 1
2A	Nozzle (for K112)	<b>S13813-1</b> 1
	Nozzle (for K113-1)	<b>S13813-4</b> 1
	Nozzle (for K113-2)	<b>S13813-3</b> 1
2A1	Nozzle Liner 1/16"	<b>KP2095-3 ***</b> 1
	Nozzle Liner 5/64"	<b>KP2095-12***</b> 1
	Nozzle Liner 3/32"	<b>KP2095-11**</b> 1
2A2	Ceramic Insert	<b>KP2094-2</b> 1
2A3	Retainer	<b>T12977-1</b> 1
2A4	Hollow Lock Set Screw	<b>T12932-1</b> 1
2B	Housing	<b>S13486-2</b> 1
3	Collar	<b>S12964-1</b> 1
4	Nozzle Flux Cone	
	(1/2" Opening)	<b>KP1968-1*</b> 1
	(5/8" Opening)	<b>KP1968-5</b> 1
	(3/4" Opening)	<b>KP1968-4</b> 1
	(13/16" Opening)	<b>KP1968-2</b> 1
	(15/16" Opening)	<b>KP1968-3</b> 1
	Chamfered Flux Cone (3/4" Opening)	<b>T14278</b> 1
5	Contact Tip	
	1/16" Size	<b>KP2086-2B1</b> 10
	5/64" Size	<b>KP2086-4B1</b> 10
	3/32" Size	<b>KP2086-3B1</b> 10

## K119 Flux Cone

Fits K113 submerged arc guns for welding without the Continuous Flux Feed Tank Assembly.

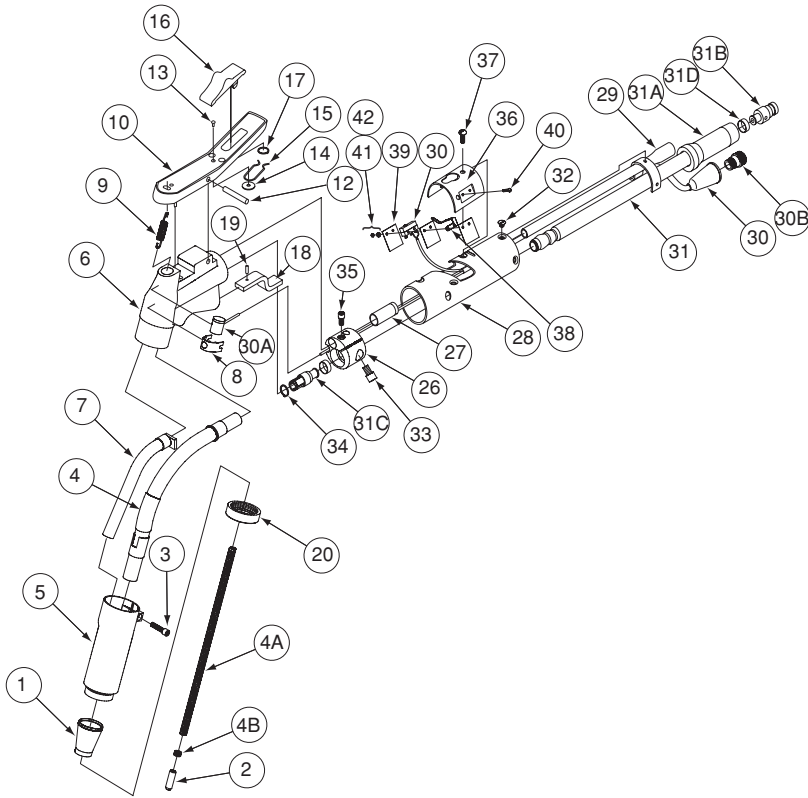


\*Discontinued. Use KP1968-5.

\*\*Discontinued. Use KP2095-4.

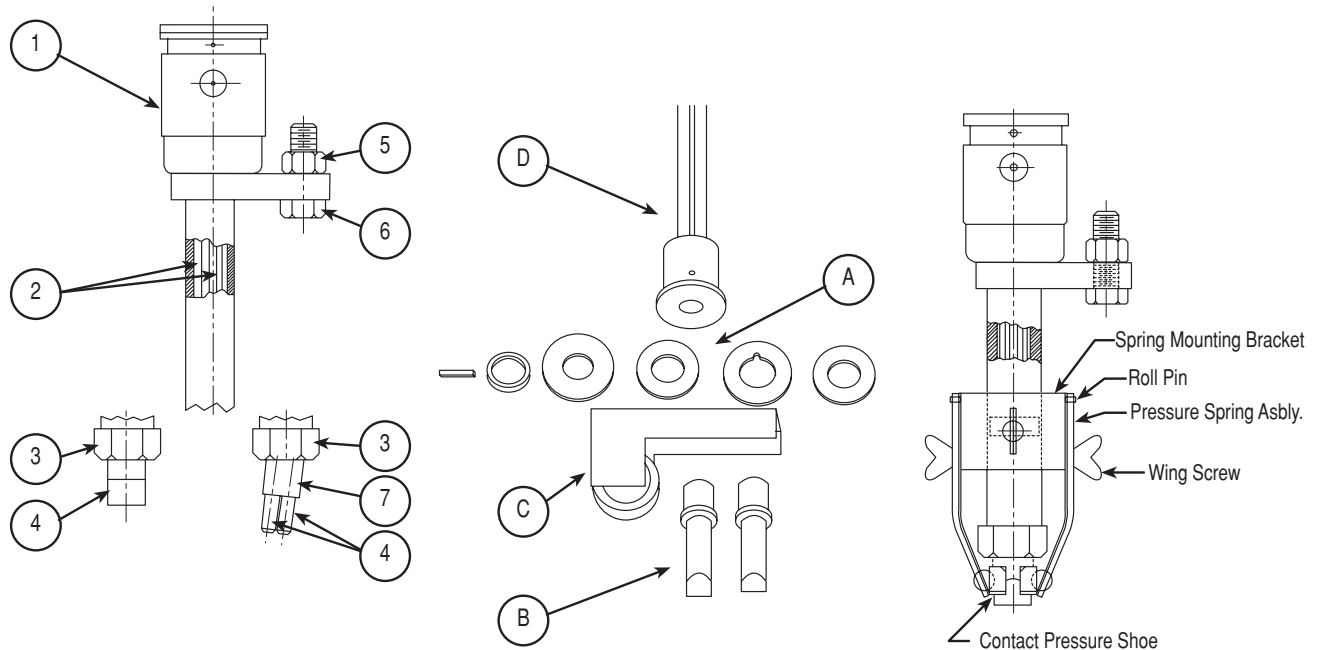
\*\*\*Discontinued. Use KP2095-1

# K114 Squirtgun & Cable



ITEM	DESCRIPTION	Part #	QTY
Squirtgun & Cable Includes:			
1	Nozzle Flux Cone 13/16" Opening (Optional)	KP1968-2	1
1	5/8" Opening (Standard)	KP1968-5	1
1	3/4" Opening (Optional)	KP1968-4	1
1	15/16" Opening (Optional)	KP1968-3	1
2	Contact Tip (3/32")	KP2088-2B1	1
2	Contact Tip (5/64" Optional)	KP2088-3B1	1
	Gun Assembly, Includes:	L5757-A	1
3	Socket Head Cap Screw	T9447-22	1
4	Nozzle, Includes:	S13816	1
4A	Tight Wound Steel Spring	T12931-2	1
4B	Liner Locking Screw	T12932-2	1
5	Gun Tube	S13042	1
6	Right & Left Gun Mount	L3828	1
7	Flux Shut Off Assembly	S11686	1
8	Receptacle Clamp	T11521	1
9	Spring	T11514	1
10	Lever	S11567-1	1
11	Left Gun Mount	See Note 1	1
12	Pivot Pin	T11546	1
13	Rivet	T10167-1	1
14	Plain Washer	S9262-39	1
15	Spring Clip	S11685	1
16	Trigger	S11569	1
17	Snap Ring	S9776-16	1
18	Gun Hanger	T11523	1
19	Roll Pin	T9967-23	1
20	Collar	S12964-1	1
	Handle & Conductor Cable Assembly, Includes:	L5757-B	
26	Clamping Ring	S12903	1
27	Tube Insulator	T11584	1
28	Handle	S11629	1
29	Flux Tube	S11822	1
30	Control Cable	M9473	1
	Micro Switch	S12182-1	1
30A	3 Contact Receptacle, Gun End	T11155-1	1
30B	5 Contact Receptacle, Wire End	S12020-6	1
31	Conductor Cable, Includes:	L5728-6	1
31A	Handle & Stiffener, Wire Feeder End	M14048	1
31B	Connector, Wire Feeder End	S12801-6	1
31C	Connector, Gun End	S12802-14	1
31D	Clamping Tube, Both Ends	S7748-40	2
32	#8-32 x .1875 FHS	CF000133	2
33	Socket Head Screw	T9447-8	1
34	Snap Ring	S9776-28	1
35	Socket Head Screw	T9447-21	1
36	Switch Mounting Plate	S11588	1
37	#8-32 x .50 RHS	CF000033	3
38	Actuator	T11527	1
39	Insulation	T11522	3
40	#2-56 x .4375 RHS	CF000135	2
41	Lock Washer	T9695-10	2
42	#2-56 HN	CF000136	2
	Nozzle Extension, 2-1/4" Stickout, (Not Shown)	S12891-1	1
	Housing	S13028-1	1
	Insert	T12329-1	1
	Tip (3/32")	KP2091-1*	1

# K129 Sub Arc Tiny Twinarc



**NOTES:** Nozzles with spring loaded contact shoes (illustrated on the right) should be converted to the newer design by discarding items named below and using the appropriate contact tip holder and tips or correct one piece contact tip, depending on wire size. Intermediate design (one piece) contact tips for 1/16 and 5/64 wire should be converted to the new (lower replacement cost) contact tip holder and contact tips design by ordering the appropriate contact tips and tip holder from the parts list below.

Item	Description	Part #	Qty.
	Twinarc - Complete - Includes all: K129* Nozzle Assembly - Stripped - Includes Items 1, 3, 5 & 6	M11609	1
	Wire Kits Include Items 2, 4, A & B:		
	.045"	KP1901-1	1
	1/16"	KP1901-2	1
	5/64"	KP1901-4	1
	3/32"	KP1901-3	1
1	Nozzle Body Assembly	S13164	1
2	Guide Tube .045 & .052 Wire	KP2092-1**	2
	1/16, 5/64 & 3/32 Wire	KP2092-2	2
3	Nozzle Collar	S13157	1
4	Contact Tip		
	.045" Wire	KP1979-1**	1
	.052" Wire	KP1979-2	1
	1/16" Wire	KP2100-2B1*	2
	5/64" Wire	KP2100-4B1*	2
	3/32" Wire	KP2100-3B1*	2
5	Hex Nut 1/2-13	CF000027	1
6	Hex Head Screw 1/2-13 x 1.50	CF000052	1
7	Tip Holder - 1/16, 5/64 & 3/32 Wire (Std.), Includes Nozzle Insert	KP1988-1 KP2094-4	1 2

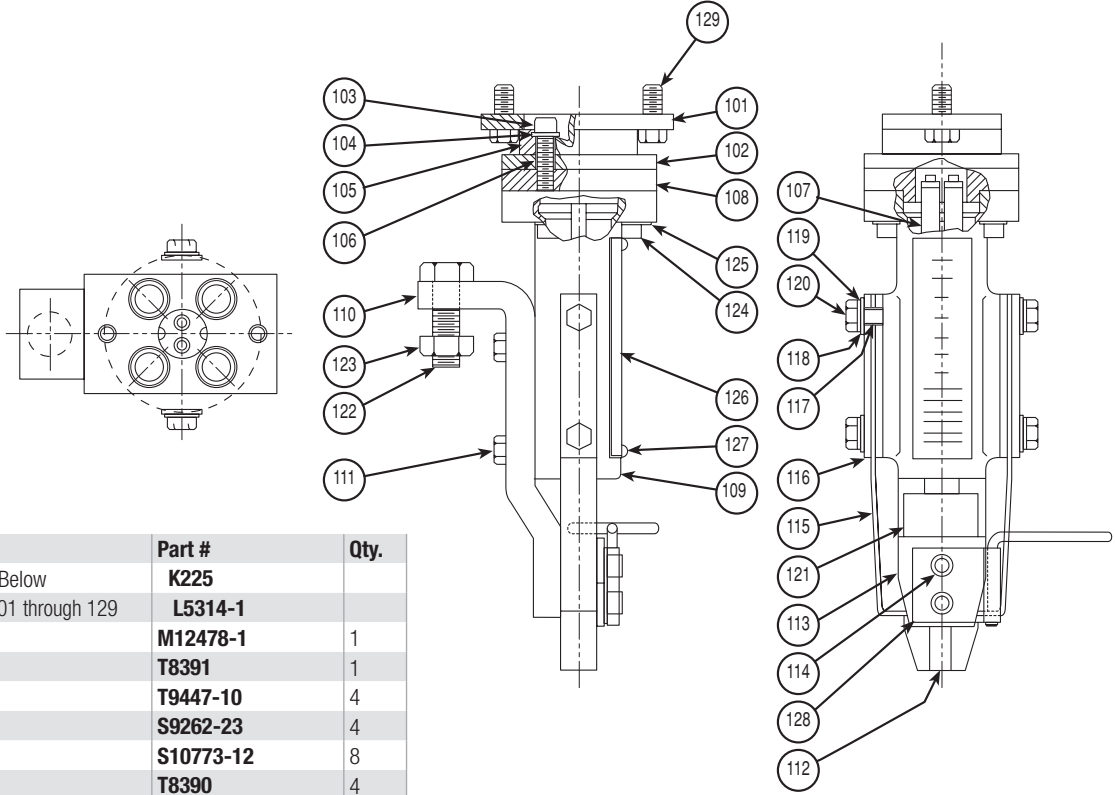
Item	Description	Part #	Qty.
7	Tip Holder - (Special Side-by-Side Wire)	KP2171-1	1
<b>Note:</b> When Tip Life is limited by tip being fused over, the use of KP2105-7 Tips may result in a lower overall cost.			
A	Drive Roll - .045 & .052 Wire	KP1888-1	1
A	Drive Roll - 1/16 & 5/64 Wire	KP1888-2	1
A	Drive Roll Assembly - 3/32 Wire, Includes:		
	Outer Drive Rolls	KP1889-1	2
	Center Drive Roll	S14905	1
	Drive Roll Spacer	T12146-1	1
	Drive Roll Key	M8776-6	1
B	Wire Guides		
	.045" & .052" Wire	KP1970-1	2
	1/16" Wire	KP1970-2**	2
	5/64" & 3/32" Wire	KP1970-3	2
C	Idle Roll Assembly, Includes:	S13165	1
	Idle Roll	S18583	1
D	Incoming Wire Guide Assembly	KP2122-1	1

\* Contact Tips as listed come in packaged quantities of 10 pieces. Packages of 100 pieces are available by adding "-B100" to the listed Part #.

\*\* Discontinued.



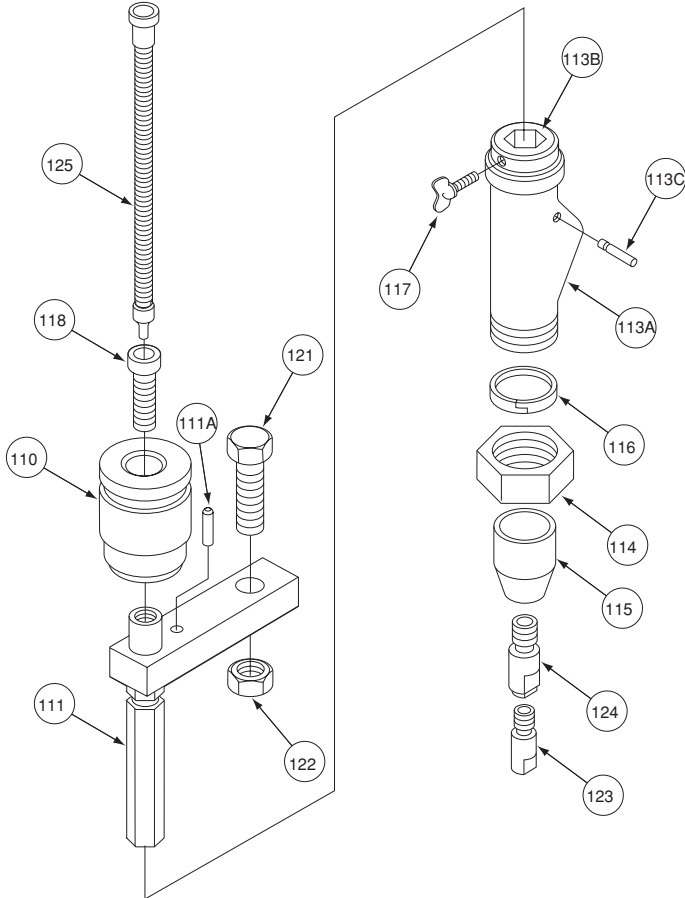
# K225 Sub Arc Twinarc Kit



Item	Description	Part #	Qty.
Twinarc - Complete - Includes All Below		<b>K225</b>	
Nozzle Assembly - Includes Items 101 through 129		<b>L5314-1</b>	
101	Adapter Plate	<b>M12478-1</b>	1
102	Adapter Insulation	<b>T8391</b>	1
103	Socket Head Screw	<b>T9447-10</b>	4
104	Washer	<b>S9262-23</b>	4
105	Insulating Washer	<b>S10773-12</b>	8
106	Insulating Bushing	<b>T8390</b>	4
107	Electrode Guide Tube	<b>KP2084-1</b>	2
108	Socket Plate	<b>S9842</b>	1
109	Nozzle Body	<b>M7913</b>	1
110	Current Bar	<b>S9544</b>	1
111	Hex Head Screw	<b>CF000015</b>	4
112	Center Contact Block (.375 Electrode Spacing)	<b>T10252-1</b>	1
	(.500 Electrode Spacing)	<b>T10252-2</b>	1
	(.625 Electrode Spacing)	<b>T10252-3</b>	1
113	Line Up Plate	<b>T10245</b>	1
114	Socket Head Screw	<b>T9447-11</b>	2
115	Spring	<b>S7664</b>	2
116	Spring Insulation	<b>T8724</b>	4
117	Insulating Bushing	<b>T8725</b>	4
118	Washer	<b>S9262-23</b>	4
119	Lock Washer	<b>E106A-2</b>	4
120	1/4-20 x 1.00 HHCS	<b>CF000015</b>	4
121	Contact Jaw	<b>T10266</b>	2
122	1/2-13 x 1.50 HHCS	<b>CF000052</b>	1
123	1/2-13 HN	<b>CF000027</b>	1
124	Socket Head Screw	<b>T9447-10</b>	2
125	Washer	<b>T10248</b>	2
128	Flux Tube Support Assembly	<b>T10684</b>	1
129	5/16-18 x .75 HHCS	<b>CF000040</b>	2
Drive Rolls			
	Outer Drive Rolls	<b>KP1889-1</b>	2
	Center Drive Roll	<b>S14905</b>	1
	Drive Roll Spacer	<b>T12146-1</b>	1
	Idle Roll Assembly	<b>S13165</b>	1
	Drive Roll Key	<b>M8776-6</b>	1
	Wire Guide Tubes - Upper & Lower	<b>KP1982-1</b>	2

# K231-1 Contact Nozzle Assembly

This Nozzle Inset is not required when using 1/8" or larger wire

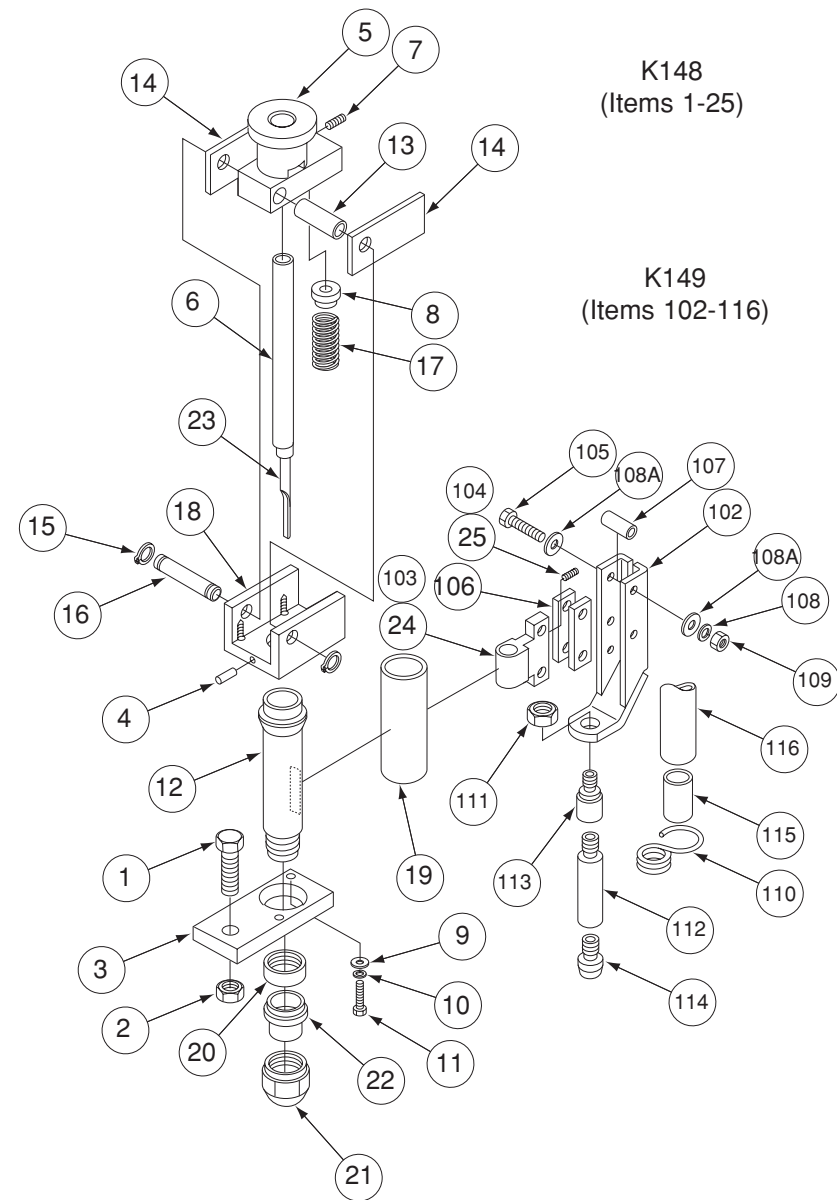


ITEM	DESCRIPTION	Part #	QTY
	*These parts are included with the K231-1		
For LT-34 ONLY, order Items 119, 120, and 125 separately.			
Nozzle Assembly		<b>M8241-1</b>	
110	Nozzle Insulator	<b>S10493-1</b>	1
111	Nozzle Body	<b>S10157</b>	1
111A	Roll Pin	<b>T9967-10</b>	1
113A	Cone Body Assembly, Includes:	<b>M8249</b>	1
113B	Flux Cone Plug	<b>S10138</b>	1
113C	Roll Pin	<b>T9967-30</b>	1
114	Retaining Nut	<b>S10147</b>	1
115	Flux Cone	<b>KP2085-1</b>	1
116	Locking Ferrule	<b>T10574</b>	1
117	Thumb Screw	<b>T9078-1</b>	1
118	Special Socket Head Screw	<b>T10570</b>	1
* 119	Rubber Flux Tube (Not Shown)	<b>T10642-2</b>	1
119	Rubber Flux Tube, LT34 Only (Not Shown)	<b>T10642-10</b>	1
* 120	Steel Flux Tube (Not Shown)	<b>T6996-9</b>	1
120	Steel Flux Tube, LT34 Only (Not Shown)	<b>S10487</b>	1
* 121	Hex Head Screw - Lead to Nozzle	<b>CF000052</b>	1
* 122	Hex Nut	<b>CF000027</b>	1
123	Contact Tip 7/32 Wire Size	<b>KP1962-5B1</b>	1
	3/16 Wire size	<b>KP1962-2B1</b>	1
	* 5/32 Wire Size	<b>KP1962-4B1</b>	1
	* 1/8 Wire Size	<b>KP1962-1B1</b>	1
	3/32 Wire Size	<b>KP1962-3B1</b>	1
	3/32 Wire Size; (3/8-24 Thread) Old Style	<b>KP2082-1B1</b>	1
	* 3/32 Wire Size; (5/16-18 Thread - See Note 1)	<b>KP2100-3B1</b>	1
	5/64 Wire Size; (3/8-24 Thread) Old Style	<b>KP2082-2B1</b>	1
	5/64 Wire Size; (5/16-18 Thread - See Note 1)	<b>KP2100-4B1</b>	1
	1/16 Wire Size; (5/16 -18 Thread - See Note 1)	<b>KP2100-2B1</b>	1
124	Adapter (3/8-24 Female Thread) for 3/32 and 5/64 KP2082 Tips	<b>See Note 2</b>	1
* 124	Adapter (5/16-18 Female Thread) for .035 thru 3/32 KP2100 Tips	<b>KP1992-1</b>	1
* 125	Nozzle Inset for 3/32 and 5/64 Wire (For NA-[ ])	<b>S15106-3/32</b>	1
125	Nozzle Inset for 5/64 Wire (For LAF-[ ] & LT-34)	<b>KP2121-2</b>	1
	Nozzle Extension (5.38" long) (For 3/32 & Larger Wire)	<b>KP2721-1</b>	As Req'd

Note 1 When KP2100 - [ ] tip life is limited by tip being fused over, the use of KP2105- [ ] tips may result in a lower overall cost.

Note 2 This part is no longer available, order Adapter KP1992-1 and the appropriate KP2100 Tips or KP2105 Tips.

# Innershield® K148 Positive Contact Nozzle Parts



K148  
(Items 1-25)

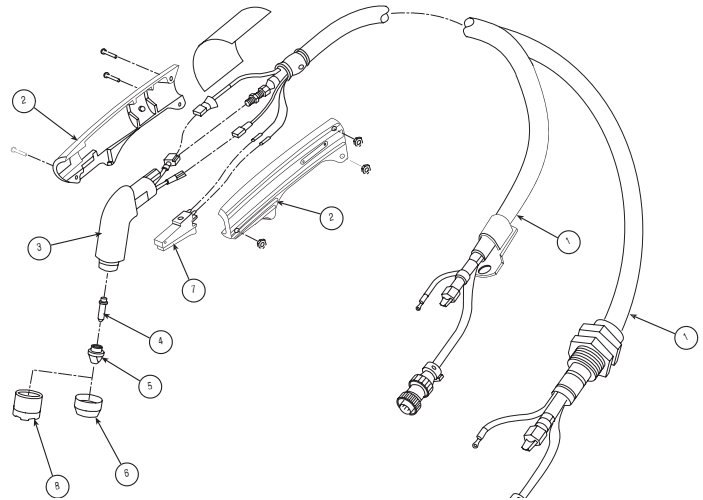
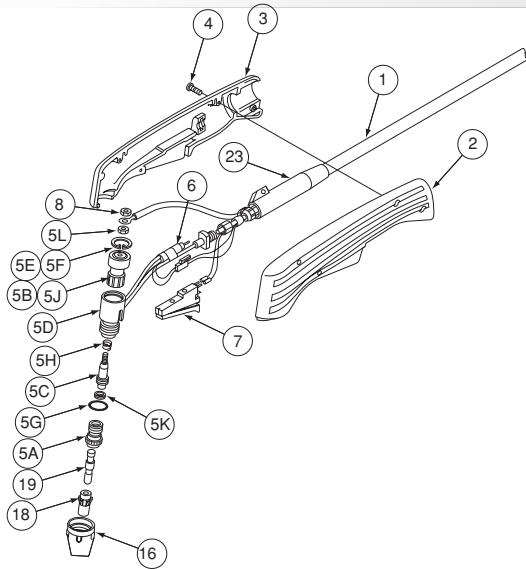
K149  
(Items 102-116)

ITEM	DESCRIPTION	Part #	QTY
Contact Nozzle Assembly Includes:		<b>K148-[A], B, C</b>	
1	1/2-13 x 1.5 HHCS	<b>CF000052</b>	1
2	1/2-13 HN	<b>CF000027</b>	1
3	Cable Connector	<b>S12576</b>	1
4	Roll Pin	<b>T9967-35</b>	1
5	Pivot Body	<b>M10340-1</b>	1
6	Guide Tube Assembly, 3/32" - 1/8" Wire	<b>KP1974-1</b>	1
6	Guide Tube Assembly, 5/32-3/16 Wire	<b>KP1974-2</b>	1
6	Guide Tube Assembly, .068-5/64 Wire	<b>KP1974-3</b>	1
7	Set Screw	<b>S11604-19</b>	1
8	Insulating Spacer	<b>T12157</b>	1
9	Flat Washer	<b>S9262-23</b>	2
10	Lock Washer	<b>E106A-2</b>	2
11	1/4-20 x 1.00 HHCS	<b>CF000015</b>	2
12	Nozzle Body	<b>M11327</b>	1
13	Insulating Tube	<b>T7028-51</b>	1
14	Insulation	<b>S12579</b>	2
15	Snap Ring	<b>S9776-25</b>	2
16	Pivot Pin	<b>T12158</b>	1
17	Spring	<b>T10247-8</b>	1
18	Nozzle Holder	<b>S13762</b>	1
19	Window Cover	<b>S7748-64</b>	1
20	Thread Protecting Collar	<b>S13805</b>	1
21	Nozzle Collar	<b>S13804</b>	1
22	Nozzle Tip (3/32-3/16")	<b>KP1973-1</b>	1
22	Nozzle Tip (.068-5/64")	<b>KP1991-1</b>	1
23	Inner Guide	<b>KP1980-1</b>	1
24	Extension Support Arm Mounting Bracket	<b>S13758</b>	
25	Set Screw	<b>S11604-19</b>	1
Water Cooling Tube Assembly (Not Illustrated)		<b>T12928</b>	

K149 Linc-Fill Extension Assembly for 3/32" Wire		<b>K149-3/32</b>	
K149 Linc-Fill Extension Assembly for 1/8" Wire		<b>K149-1/8</b>	
K149 Linc-Fill Extension Assembly for 5/32" Wire		<b>K149-5/32</b>	
Includes:			
102	Extension Arm Assembly	<b>S13757</b>	1
103	Mounting Block	<b>S13758</b>	1
104	Set Screw	<b>S11604-19</b>	1
105	1/4-20 x 1.375	<b>CF000118</b>	2
106	Insulation	<b>T8477-16</b>	2
107	Insulating Tube	<b>T11851-3</b>	2
108	Lock Washer	<b>E106A-2</b>	2
108A	Plain Washer	<b>S9262-23</b>	2
109	1/4-20 HN	<b>CF000017</b>	2
110	Flux Hose Clamp	<b>T12929</b>	1
111	1/8-11 HJN	<b>CF0000140</b>	1
112	Extension Tube - 2" Long	<b>KP1975-2</b>	1
113	Extension Tube - 1" Long	<b>KP1975-1*</b>	1
114	Extension Tube End (2 3/4 Electrical Stickout)	<b>KP1976-3</b>	1
114	Extension Tube End (2 1/4 Electrical Stickout)	<b>KP1990-1</b>	1
114	Extension Tube End	<b>KP1976-1</b>	1
114	Extension Tube End	<b>KP1976-4</b>	1
114	Extension Tube End	<b>KP1976-2</b>	1
115	Flux Hose	<b>T10642-34</b>	1
116	Flux Tube Tip	<b>S7748-35</b>	1

\* Discontinued. Available until stock is depleted.

# PCT-20 Hand-Held Torch PCT-40 & 60 Torch & Cable



ITEM	DESCRIPTION	Part #	QTY
	PCT 20 Torch & Cable Asbly - 15'	<b>K1615-1</b>	1
1	Cable Assembly (15')	<b>NSS</b>	1
1	Cable Assembly (25')	<b>NSS</b>	1
2	Gun Handle (Left & Right)	<b>G3110</b>	1
4	Machine Screw	<b>S18825-1</b>	1
5	Torch Head Asbly, Includes:	<b>M17874</b>	1
5A	Swirl Ring Asbly	<b>S22148</b>	1
5B	Insulator	<b>S22152</b>	1
5C	Piston	<b>S22153</b>	1
5D	Torch Body Asbly	<b>S22998</b>	1
5E	Retaining Ring	<b>S9776-67</b>	1
5F	O-Ring (Not Shown)	<b>T13483-35</b>	2
5G	O-Ring	<b>T13483-23</b>	1
5H	Compression Spring	<b>T11862-55</b>	1
5J	Seal (Rod & Piston)	<b>S23002-1</b>	1
5K	Seal (Rod & Piston)	<b>S23002-2</b>	1
5L	#12-28 Br HN	<b>CF000206</b>	1
6	Solenoid Assembly	<b>S23866</b>	1
6A	Hose Clamp (Not Shown)	<b>S20710-13</b>	2
6B	Pincers (Hose Clamp Crimping Tool) (Not Shown)	<b>NSS</b>	
7	Trigger & Housing Assembly	<b>S21002</b>	1
8	#12-28 Brass Hex Nut	<b>CF000206</b>	1
9	Decal (Not Shown)	<b>S18750-12</b>	1
15	O-Ring (Not Shown)	<b>T13483-36</b>	1
16	Shield Cup	<b>KP2064-1</b>	1
18	Vortech Nozzle (.028")	<b>KP2062-1B1*</b>	1
19	Electrode	<b>KP2063-1B1*</b>	1

\* Part # listed is a package quantity of 5.

ITEM	DESCRIPTION	Part #	QTY
	MAG PCT-60 Torch & Cable Assembly 70°, 60 Amp, 25 Ft.	<b>K871-1</b>	1
	MAG PCT-40 Torch	<b>Discontinued</b>	
1	Cable Assembly 60 Amp, 25 Ft.	<b>L7747-1</b>	1
	50 Ft.	<b>L7747-2</b>	1
1	Cable Assembly 40 Amp, 25 Ft. (Below Code 9900)	<b>L8478-1</b>	1
	50 Ft. (Below Code 9900)	<b>L8478-2</b>	1
	25 Ft. (Above Code 9900)	<b>L8932-1</b>	1
	50 Ft. (Above Code 9900)	<b>L8932-2</b>	1
2	Handle Repair Kit, includes:	<b>S19837</b>	1
	Handle, LH	<b>NSS</b>	1
	Handle Nut	<b>S18773</b>	3
	Handle, RH	<b>NSS</b>	1
	#6-32 x .75 PHS	<b>S18825-1</b>	3
3	Torch Head Molded Assembly	<b>M15616</b>	1
4	Electrode	<b>KP2012-1B1*</b>	1
5	Nozzles - PCT-60		
	Cutting .035" (.9 mm) Orifice	<b>KP2008-1B1*</b>	1
	Cutting .042" (1.1 mm) Orifice	<b>KP2008-2B1*</b>	1
	Cutting .052" (1.3 mm) Orifice	<b>KP2008-3B1*</b>	1
	Gouging .078" (2.0 mm) Orifice	<b>KP2008-4B1*</b>	1
	Nozzles - PCT-40		
	Cutting .042" (1.1 mm) Orifice	<b>KP2008-5B1*</b>	1
6	Shield Cup Assembly (PCT-60)	<b>KP2077-1</b>	1
6	Shield Cup Assembly (PCT-40)	<b>KP2014-1</b>	1
7	Trigger Assembly	<b>S21002</b>	1
8	Drag Cup Assembly (PCT-60)	<b>KP2075-1</b>	1
8	Drag Cup Assembly (PCT-40)	<b>KP2027-1**</b>	1

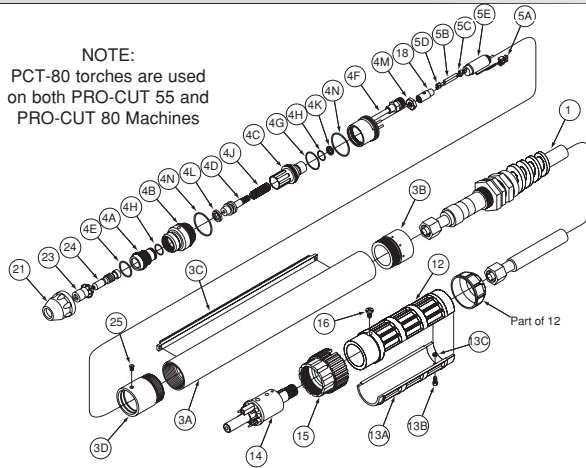
\* Part # listed is a package quantity of 5.

\*\* Discontinued

**NSS - Not Sold Separately**



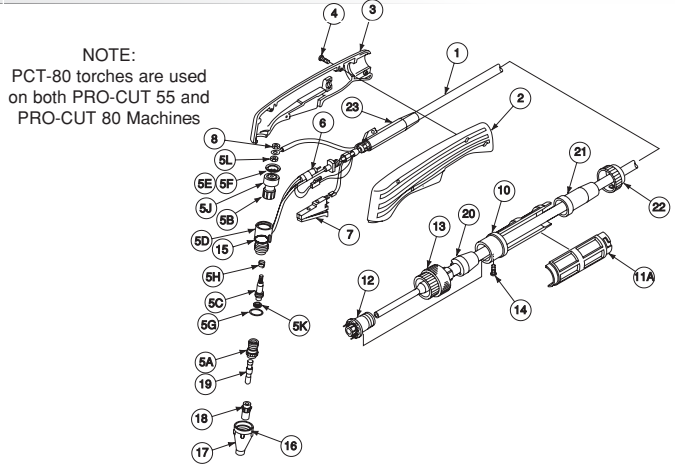
# PCT-80 Machine Torch



NOTE:  
PCT-80 torches are used on both PRO-CUT 55 and PRO-CUT 80 Machines

ITEM	DESCRIPTION	Part #	QTY
PCT-80 Machine Torch & Cable Assembly 25'			
1	Cable Assembly (25")	<b>L10811-1</b>	1
1	Cable Assembly (50")	<b>L10811-2</b>	1
3	Machine Barrel Asbly, Includes:	<b>M19012</b>	1
3A	Machine Torch Barrel	<b>M19015</b>	1
3B	Barrel Insert	<b>S24123</b>	1
3C	Gear Rack	<b>S20855</b>	1
3D	Torch Sleeve	<b>S24003</b>	1
4	Torch Head Asbly, Includes:	<b>M18864</b>	1
4A	Swirl Ring Assembly	<b>S22148</b>	1
4B	Torch Body	<b>M18820</b>	1
4C	Insulator	<b>M18821</b>	1
4D	Piston	<b>S23876</b>	1
4E	O-Ring (.737 I.D.)	<b>T13483-36</b>	1
4F	Torch Cap Assembly	<b>S24124</b>	1
4G	O-Ring (.785 I.D.)	<b>T13483-35</b>	2
4H	O-Ring (.426 I.D.)	<b>T13483-23</b>	1
4J	Spring, Compression	<b>T11862-55</b>	1
4K	Seal (Rod & Piston) (.250 I.D., .375 O.D.)	<b>S23002-1</b>	1
4L	Seal (Rod & Piston) (.312 I.D., .500 O.D.)	<b>S23002-2</b>	2
4M	#12-28 Br HN	<b>CF000206</b>	1
4N	O-Ring (.989 I.D.)	<b>T13483-37</b>	2
5	Solenoid Assembly, Includes:	<b>S23866</b>	1
5A	Micro Receptacle Housing	<b>S23004-2</b>	1
5B	Tubing, Silicon	<b>T10642-215</b>	2
5C	Tubing, Copper	<b>S22996-2</b>	1
5D	Hose Clamp	<b>S20710-13</b>	2
5E	Solenoid	<b>S22999</b>	1
12	Handle Top	<b>S22990-1A</b>	1
13A	Handle Bottom	<b>S24048</b>	1
13B	Socket Head Cap Screw	<b>T9447-102</b>	1
13C	#4-40 HN	<b>CF000002</b>	1
14	Central Adapter Assembly	<b>S22990-1E</b>	1
15	Collar Nut	<b>S22990-1F</b>	1
16	Fillister Head Screw	<b>S22990-1G</b>	1
18	Connector-Electrode	<b>S24455</b>	1
21	Shield Cup	<b>KP2064-1</b>	1
23	Nozzle (.043)	<b>KP2062-2B1*</b>	1
	Nozzle (.053)	<b>KP2062-3B1*</b>	1
24	Electrode	<b>KP2063-1B1*</b>	1
25	#6-32 x .25 FHS	<b>CF000379</b>	1
Items Not Shown:			
	Arc Striking Switch Assembly	<b>S24211</b>	1
	Plug & Lead Assembly	<b>S18250-581*</b>	1
	Remote Control Adapter	<b>S24210</b>	1
	Gouging Nozzle (.068)	<b>KP2062-4B1*</b>	1

# PCT-80 Handheld Torch



NOTE:  
PCT-80 torches are used on both PRO-CUT 55 and PRO-CUT 80 Machines

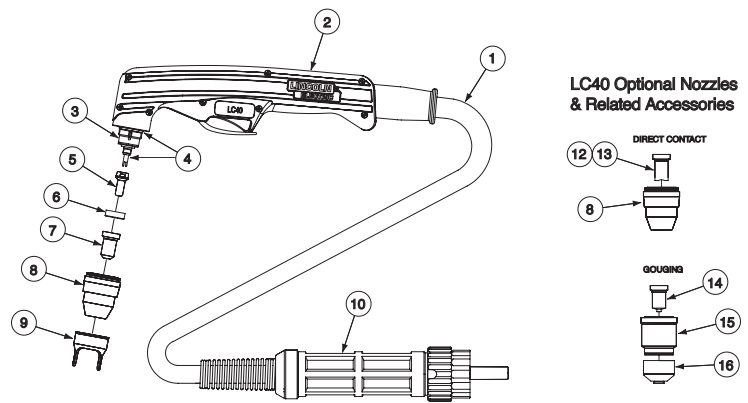
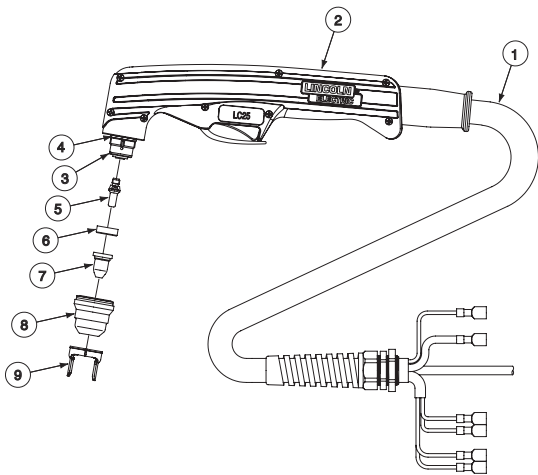
ITEM	DESCRIPTION	Part #	QTY
PCT 80 Torch & Cable Assembly 25'			
		<b>K1571-1</b>	1
PCT 80 Torch & Cable Assembly 50'			
		<b>K1571-2</b>	1
1	Cable Assembly -25'	<b>L10259-1</b>	1
	Cable Assembly -50'	<b>L10259-2</b>	1
2	Handle (Left & Right)	<b>G3110</b>	1
4	Machine Screw	<b>S18825-1</b>	1
5	Torch Head Assembly, Includes:	<b>M17874</b>	1
5A	Swirl Ring Assembly	<b>S22148</b>	1
5B	Insulator	<b>S22152</b>	1
5C	Piston	<b>S22153</b>	1
5D	Torch Body Assembly	<b>S22998</b>	1
5E	Retaining Ring	<b>S9776-67</b>	1
5F	O-Ring (Not Shown)	<b>T13483-35</b>	2
5G	O-Ring	<b>T13483-23</b>	1
5H	Compression Spring	<b>T11862-55</b>	1
5J	Seal (Rod & Piston)	<b>S23002-1</b>	1
5K	Seal (Rod & Piston)	<b>S23002-2</b>	1
5L	#12-28 Brass Hex Nut	<b>CF000206</b>	1
6	Solenoid Assembly	<b>S23866</b>	1
6A	Hose Clamp (Not Shown)	<b>S20710-13</b>	2
6B	Pincers (Hose Clamp Crimping Tool) (Not Shown)	<b>NSS</b>	
7	Trigger & Housing Assembly	<b>S21002</b>	1
8	#12-28 Brass Hex Nut	<b>CF000206</b>	1
9	Decal (Not Shown)	<b>S18750-11</b>	1
10	Handle Top	<b>S22990-1A</b>	1
11A	Handle Bottom, Includes:	<b>S24048</b>	1
11B	#4-40 Socket Head Cap Screw (Not Shown)	<b>T9447-102</b>	1
11C	#4-40 Hex Nut (Not Shown)	<b>CF000002</b>	1
12	Central Adapter Assembly	<b>S22990-1E</b>	1
13	Collar Nut	<b>S22990-1F</b>	1
14	Fillister Head Screw	<b>S22990-1G</b>	1
15	O-Ring	<b>T13483-36</b>	1
16	Shield Cup	<b>KP2064-1</b>	1
17	Drag Cup	<b>KP2065-1**</b>	1
18	Nozzle (35 - 60 Amp.)	<b>KP2062-2B1*</b>	1
18	Nozzle (60 - 85 Amp.)	<b>KP2062-3B1*</b>	1
19	Electrode	<b>KP2063-1B1*</b>	1
20	Strain Relief	<b>S24015</b>	1
21	Cable Boot	<b>S24773</b>	1
22	Handle Nut	<b>S22990-1C</b>	1
23	Handle Boot	<b>M15751-1</b>	1
24	Spring Boot (Not Shown)	<b>S24676-1</b>	1
25	Bushing (Not Shown)	<b>S24679-1</b>	1

\* Part # listed is a package quantity of 5.

\*\* Part # listed is a package quantity of 6.

# Tomahawk® LC25

# Tomahawk® LC40



ITEM	DESCRIPTION	Part #	QTY
LC25 Torch & Cable Assembly, Includes:			
1	Cable Assembly (10 Ft.)	<b>K2846-1</b>	1
2	Handle	<b>S28173-1</b>	1
3	Torch Head (70°)	<b>S28173-2</b>	1
4	"O" Ring	<b>S28173-4</b>	1
5	Electrode	<b>KP2842-1</b>	5
6	Swirl Ring	<b>KP2842-4</b>	3
7	Nozzle	<b>KP2842-2</b>	5
8	Retaining Cap	<b>KP2842-3</b>	1
9	Spacer	<b>KP2842-5</b>	2
10	Electrode Key (Not Shown)	<b>S28173-5</b>	1

ITEM	DESCRIPTION	Part #	QTY
LC40 Handheld Plasma Torch (20") (6m), Includes:			
1	LC40 Cable (20") (6m)	<b>K2847-1</b>	1
2	Handle (Includes Trigger)	<b>S28173-1</b>	1
3	Torch Head (70°)	<b>S28174-1</b>	1
4	Cooling Kit (Includes Cooling Tube & O-Ring)	<b>S28174-3</b>	1
5	Electrode	<b>KP2843-1</b>	5
6	Swirl Ring	<b>KP2842-4</b>	3
7	Nozzle (40A)	<b>KP2843-2</b>	5
8	Retaining Cap	<b>KP2843-5</b>	1
9	Spacer	<b>KP2843-10</b>	2
10	Connector Assembly	<b>S28174-4</b>	1
11	Electrode Key (Not Shown)	<b>S28173-5</b>	1

LC 25 TORCH AND CONSUMABLES	
Product Number	Description
K2846-1	Complete Torch*
KP2842-1	Electrode
KP2842-2	Nozzle
KP2842-3	Retaining Cap
KP2842-4	Swirl Ring
KP2842-5	Spacer

Optional Nozzles & Related Accessories:			
(Not Included in K2847-1)			
12	Nozzle (Direct Contact) (25A)	<b>KP2843-9</b>	5
13	Nozzle (Direct Contact) (40A)	<b>KP2843-3</b>	5
14	Nozzle (Gouging)	<b>KP2843-4</b>	5
15	Retaining Cap (Gouging)	<b>KP2843-6</b>	1
16	Gouge Shield	<b>KP2843-8</b>	2

LC 40 TORCH AND CONSUMABLES		
Product Number	Description	
K2847-1	Complete Torch*	
KP2843-1	Electrode	Standard
KP2843-2	Nozzle 40A	Standard
KP2843-3	Nozzle (Contact) 40A	Options
KP2843-4	Nozzle (Gouging)	Options
KP2843-5	Retaining Cap	Standard
KP2843-6	Retaining Cap (Gouging)	Options
KP2843-8	Gouge Shield	Options
KP2843-9	Nozzle (Contact) - 25A	Options
KP2843-10	Spacer	Standard

\*Includes cable and 1 set of all expendable parts.



**K2886 - Plasma Circle Cutting Guide Kit**  
For cutting circles from 2" to 40" (50.8 - 1016mm) in diameter



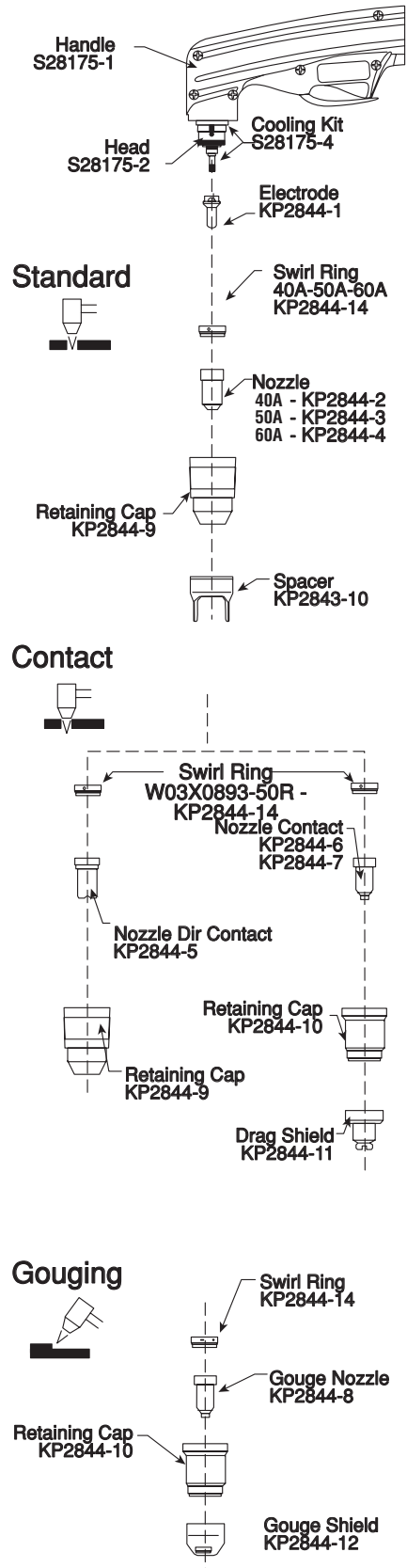
**K2377-1 - Canvas Cover**  
Made of canvas that is flame retardant, mildew resistant and water repellent

\*Includes cable and 1 set of all expendable parts.

- It is normal for the electrode and nozzle to wear during operation.
- Electrodes should typically be replaced when erosion reaches 0.025 in. (0.65 mm).
- A green and erratic arc will indicate the end of electrode life. The electrode should be immediately replaced.
- It is recommended that the KP2843-1 Electrode and KP2843-2 Nozzle (40A) be replaced as a complete set.

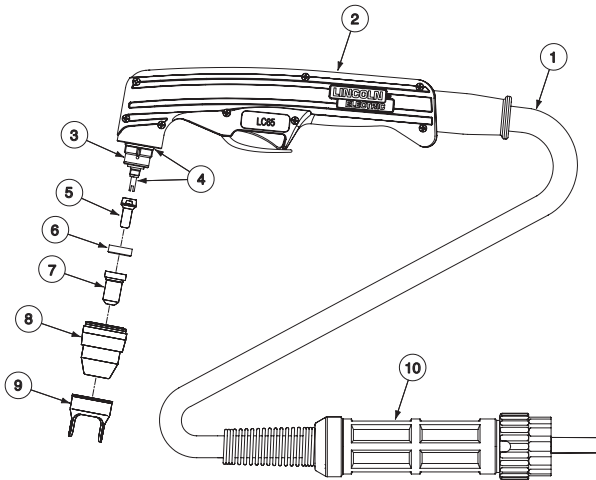
# Tomahawk® LC65 Plasma Torch

## LC65 Parts

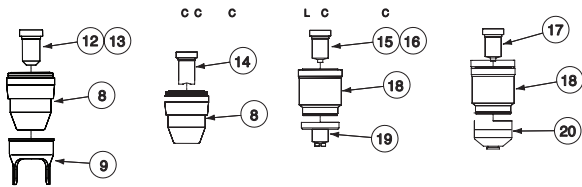


Part #	Description	
K2848-1	LC65 Handheld Plasma Torch 25 ft (7.5 m)	
K2848-2	LC65 Handheld Plasma Torch 50 ft (15 m)	
KP2844-1	Electrode (60A)	Standard
KP2844-4	Nozzle (60A)	Standard
KP2844-9	Retaining Cap (40A-60A)	Standard
KP2843-10	Spacer	Standard
KP2844-14	Swirl Ring (40,50,60A)	Standard
<b>Optional Nozzles &amp; Related Accessories: (Not Included in K2848-1 or -2)</b>		
KP2844-2	Nozzle (40A)	Optional
KP2844-3	Nozzle (50A)	Optional
KP2844-5	Nozzle (Direct Contact) (40A)	Optional
KP2844-6	Nozzle (Shielded Contact) (50A)	Optional
KP2844-7	Nozzle (Shielded Contact) (60A)	Optional
KP2844-8	Nozzle (Gouging)	Optional
KP2844-10	Retaining Cap (Shielded Contact)	Optional
KP2844-11	Shield (50,60A)	Optional
KP2844-12	Gouge Shield	Optional
K2848-3	LC-65M Machine Plasma Torch (25.) (7.5m)	
KP2844-1	Electrode	Standard
KP2844-4	Nozzle (60A)	Standard
KP2844-9	Retaining Cap (40,60A)	Standard
KP2844-14	Swirl Ring (40,50,60A)	Standard
<b>Optional Nozzles &amp; Related Accessories: (Not Included in K2848-3)</b>		
KP2844-2	Nozzle (40A)	Optional
KP2844-3	Nozzle (50A)	Optional
KP2844-6	Nozzle (Shielded Contact) (50A)	Optional
KP2844-7	Nozzle (Shielded Contact) (60A)	Optional
KP2844-8	Nozzle (Gouging)	Optional
KP2844-10	Retaining Cap (Shielded Contact)	Optional
KP2844-12	Gouge Shield	Optional
KP2844-13	Spacer	Optional

# Tomahawk® LC 65 Plasma Torch

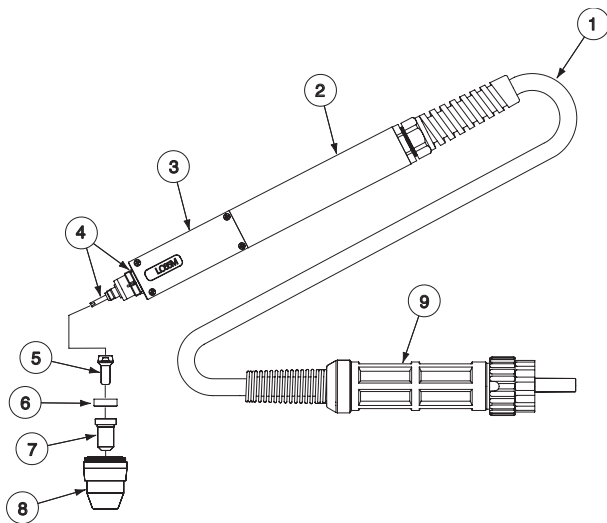


LC65

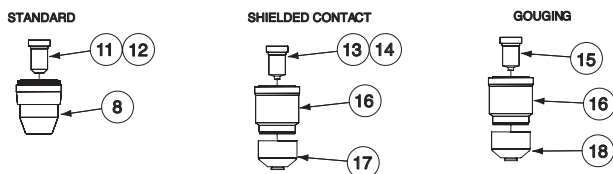


ITEM	DESCRIPTION	Part #	QTY
	LC65 Handheld Plasma Torch (25') (7.5m), Includes:	<b>K2848-1</b>	
1	LC65 Cable (25') (7.5m)	<b>S28175-5</b>	1
	LC65 Handheld Plasma Torch (50') (15m), Includes:	<b>K2848-2</b>	
1	LC65 Cable (50') (15m)	<b>S28175-3</b>	1
2	Handle (Includes Trigger)	<b>S28175-1</b>	1
3	Torch Head (70°)	<b>S28175-2</b>	1
4	Cooling Kit (Includes Cooling Tube & O-Ring)	<b>S28175-4</b>	1
5	Electrode (60A)	<b>KP2844-1</b>	5
6	Swirl Ring (40,50,60A)	<b>KP2844-14</b>	3
7	Nozzle (60A)	<b>KP2844-4</b>	5
8	Retaining Cap (40A-60A)	<b>KP2844-9</b>	1
	Retaining Cap (Shielded Contact)	<b>PKP2844-10</b>	1
9	Spacer	<b>KP2843-10</b>	2
10	Connector Assembly	<b>S28175-9</b>	1
11	Electrode Key (Not Shown)	<b>S28173-5</b>	1
Optional Nozzles & Related Accessories: (Not Included in K2848-1 or -2)			
12	Nozzle (40A)	<b>KP2844-2</b>	5
13	Nozzle (50A)	<b>KP2844-3</b>	5
14	Nozzle (Direct Contact) (40A)	<b>KP2844-5</b>	5
15	Nozzle (Shielded Contact) (50A)	<b>KP2844-6</b>	5
16	Nozzle (Shielded Contact) (60A)	<b>KP2844-7</b>	5
17	Nozzle (Gouging)	<b>KP2844-8</b>	5
18	Retaining Cap (Shielded Contact)	<b>KP2844-10</b>	1
19	Shield (50,60A)	<b>KP2844-11</b>	2
20	Gouge Shield	<b>KP2844-12</b>	2

# Tomahawk® LC 65M Machine Plasma Torch



LC65M Optional Nozzles & Related Accessories



ITEM	DESCRIPTION	Part #	QTY
	LC65M Machine Plasma Torch (25') (7.5m), Includes:	<b>K2848-3</b>	1
1	LC65M Cable (25') (7.5m)	<b>S28175-7</b>	1
2	Positioning Tube	<b>S28175-8</b>	1
3	Torch Head (180°)	<b>S28175-6</b>	1
4	Cooling Kit (Cooling Tube & O-ring)	<b>S28175-4</b>	1
5	Electrode	<b>KP2844-1</b>	5
6	Swirl Ring (40,50,60A)	<b>KP2844-14</b>	3
7	Nozzle (60A)	<b>KP2844-4</b>	5
8	Retaining Cap (40,60A)	<b>KP2844-9</b>	1
9	Connector Assembly	<b>S28175-9</b>	1
10	Electrode Key (Not Shown)	<b>S28173-5</b>	1
Optional Nozzles & Related Accessories: (Not Included in K2848-3)			
11	Nozzle (40A)	<b>KP2844-2</b>	5
12	Nozzle (50A)	<b>KP2844-3</b>	5
13	Nozzle (Shielded Contact) (50A)	<b>KP2844-6</b>	5
14	Nozzle (Shielded Contact) (60A)	<b>KP2844-7</b>	5
15	Nozzle (Gouging)	<b>KP2844-8</b>	5
16	Retaining Cap (Shielded Contact)	<b>KP2844-10</b>	1
17	Shield (50,60A)	<b>KP2844-13</b>	2
18	Gouge Shield	<b>KP2844-12</b>	2

\* Part # listed is a package quantity of 5.  
 \*\* Part # listed is a package quantity of 2



# Torchmate®

## Growth Series™ 2x2™ CNC Prototyping System / Tomahawk® 625 One-Pak®



### TOMAHAWK® 625 TORCH CONSUMABLES

Product Number	Description	
KP2843-1	Electrode	Standard
KP2843-2	Nozzle 40A	Standard
KP2843-3	Nozzle (Contact) 40A	Optional
KP2843-4	Nozzle (Gouging)	Optional
KP2843-5	Retaining Cap	Standard
KP2843-6	Retaining Cap (Gouging)	Optional
KP2843-8	Gouge Shield	Optional
KP2843-9	Nozzle (Contact) - 25A	Optional
KP2843-10	Spacer	Standard

### Important phone numbers and email addresses for Torchmate

**Consumables & Parts orders: (775) 673-2200 Ext 2 or [Parts@Torchmate.com](mailto:Parts@Torchmate.com)**  
**To check the status of your order: (775) 673-2200 Ext 2 or [Sales@torchmate.com](mailto:Sales@torchmate.com)**  
**Customer Service & Support: (775) 673-2200 Ext 3 or [Support@Torchmate.com](mailto:Support@Torchmate.com)**

Part#	Description	Qty
03-0001-009-New	AVHC Lead Screw	1
03-0001-011	AVHC Bronze Nut	1
03-0001-016-New	AVHC Roller Bearing and Curve Spring	1
03-0001-016	AVHC Flanged Bearing for AVHC.	1
03-0001-010	AVHC Screw Coupling for Arc Voltage Height Control	1
03-0001-029-New	AVHC Linear Shaft for New lifter station (7.25" length)	2
03-0001-017	AVHC Linear Bearings, 0.5", Set of 4 w/ 2 O-Rings	1
11-0001-001	99R6 Ball Bearings	4
12-0003-001	Anti Backlash Drive Nut (4')	1
Drive- for 2x2	Spare Drive Card	1
12-0002-000	95T80 Neoprene Glass Timing Belt	1
08-0005-025	25' Motor cable extension	1
08-0004-380	Nema 23, 380 oz-in Stepper Motor	1
11-0000-002	3/8-16 Hex Jam Nut Zinc	4
11-0000-003	3/8-16x1 Button Soc. Cap Screw	4
11-0000-001-	3/8 AN Flat Washer Cadmium Yellow	16
12-0001-001	Hi-precision ss ball bearings. 1/4" ID, 1/2" OD.	3
11-0002-002	3 hole aluminum corner bracket	1
	45amp 65amp and 85amp nozzles for specified plasma cutter	10
	45amp 65amp and 85amp electrodes for specified plasma cutter	5
	45amp 65amp and 85amp swirl rings for specified plasma cutter	1

### RECOMMENDED ACCESSORIES



**TOMAHAWK® 625 OPTIONS**  
**Small Canvas Cover**  
 Protect your Tomahawk® when not in use. Made from red canvas that is flame retardant, mildew resistant and water repellent.  
**Order K2377-1**



**LC40M Machine Replacement Torch**  
 Includes 20 ft. (6 m) torch cable and one set of all required torch expendable parts.  
**Order K2847-2**

### Software Minimum Computer Requirements

- ▶ Windows® XP/Vista® 2007
- ▶ 1 Ghz Processor
- ▶ 1 GB RAM
- ▶ 30 GB Hard Drive

# TIG Torch Starter Pack



## K2265-1 TIG-Mate™ 17V (V for Valve) Air-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17V Ultra-Flex™ torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, adapter K2505-1 and work clamp and cable.



## K2266-1 TIG-Mate™ 17 Air-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17 Ultra-Flex™ torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, Twist Mate™ adapter K1622-1, and work clamp and cable.



## K2267-1 TIG-Mate™ 20 Water-Cooled TIG Torch Starter Pack

Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTW-20 torch, parts kit, Harris® flowmeter/regulator, 10 ft. (3.0 m) gas hose, Twist Mate™ adapter K1622-4, work clamp and cable and 10 ft. (3.0 m) water hose.

## TYPICAL CURRENT RANGES FOR TUNGSTEN ELECTRODES<sup>(1)</sup>

	DCEN(-)	DCEP(+)	AC				
			Balanced Wave		Unbalanced Wave		
Tungsten Electrode Diameter In. (mm)	1%, 2% Thoriated Tungsten	1%, 2% Thoriated Tungsten	Pure Tungsten	1%, 2% Thoriated Tungsten Zirconiated	Pure Tungsten	1%, 2% Thoriated Tungsten Zirconiated	Alumina Nozzle Size
0.020 (0.5)	5-20	(2)	10-20	5-20	5-15	5-20	4,5,6
0.040 (1.0)	15-80	(2)	20-30	20-60	10-60	15-80	4,5,6
1/16 (1.6)	70-150	10-20	30-80	60-120	50-100	70-150	5,6
3/32 (2.4)	150-250	15-30	60-130	100-180	100-160	140-235	6,7,8
1/8 (3.2)	250-400	25-40	100-180	160-250	150-210	225-325	6,7,8
5/32 (4.0)	400-500	40-55	160-240	200-320	200-275	300-400	8,10

<sup>(1)</sup> With argon gas.

<sup>(2)</sup> DCEP (+) is not commonly used in these sizes.

### K814

#### Arc Start™ Switch

May be used in place of the Foot or Hand Amptrol™. Comes with a 25 ft. (7.6 m) cable and 6 pin plug connector. Attaches to the TIG torch for convenient finger control to start and stop the weld cycle at the current set on the machine.



### K963-3

#### Hand Amptrol™

Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6-pin plug connection). Hook and loop straps secure it to the torch.



### K963-4

#### Hand Amptrol™ with 12-pin Universal Connector

Provides 25 ft. (7.6 m) of remote current control for TIG welding.



### K870

#### Foot Amptrol™

Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).



### K870-2

#### Foot Amptrol™ with 12-pin Universal Connector

Provides 25 ft. (7.6 m) of remote current control for TIG welding.



### K1622-1

#### Twist Mate™ Torch Adapter

Use to connect 1-piece air-cooled TIG torches (PTA-9/PTA-17) to power sources with combined gas/power Twist Mate™ connectors.



### K2320-1

#### Foot Amptrol™ Connector Kit

Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).



### K2909-1

#### 6-pin to 12-pin Adapter

Use for adapting existing 6-pin remote controls such as the K870, K857, and K963-3 to the new 12-pin connector.



### K3127-1

#### Wireless Foot Pedal and Receiver for TIG Power Sources K3350-1 pedal, K3351-1 receiver



# TIG Torch Assemblies

## Air-Cooled



**PTA-9 & PTA-9F**  
Air-cooled TIG torch, rated 125 amps at 60% duty cycle. The PTA-9F is equipped with a flexible head for easy maneuverability into tight places.

**PTA-17, PTA-17V, PTA-17F & PTA-17FV**  
Air-cooled TIG torch, rated 150 amps at 60% duty cycle. The PTA-17V is equipped with a valve for gas flow control. The PTA-17F is equipped with a flexible head for easy maneuverability into tight spaces. The PTA-17FV is equipped with both a gas valve and a flexible head.

**PTA-26, PTA-26V, PTA-26F & PTA-26FV**  
Air-cooled TIG torch, rated 200 amps at 60% duty cycle. The PTA-26V is equipped with a valve for gas flow control. The PTA-26F is equipped with a flexible head for easy maneuverability into tight spaces. The PTA-26FV is equipped with both a gas valve and flexible head.

## Water-Cooled



**PTW-18**  
Water-cooled TIG torch, rated 350 amps at 100% duty cycle.

**PTW-20**  
Water-cooled TIG torch, rated 250 amps at 100% duty cycle.



**Zippered Cable Covers**  
Protect TIG torch cables in high abrasion applications with zippered cable covers. Available for 12.5 ft. (3.8 m) and 25 ft. (7.6 m) TIG torches.

Order **K918-1** (12.5 ft.)  
**K918-2** (25 ft.)

## Pro-Torch™ TIG Torches

Model	Product Number	Rated Current	Tungsten Range inches (mm)	Length ft. (m)	Number of Cables
<b>Air-Cooled</b>					
PTA-9	K1781-1	125A	.020-1/8	12.5 (3.8)	1
	K1781-3	125A	(0.5-3.2)	25.0 (7.6)	1
PTA-9F Ultra-Flex™	K1781-9 <sup>(1)</sup>	125A	.020-1/8 (0.5-3.2)	12.5 (3.8)	1
PTA-17	K1782-1	150A	.020-5/32	12.5 (3.8)	1
	K1782-2	150A	(0.5-4.0)	12.5 (3.8)	2
	K1782-3	150A		25.0 (7.6)	1
	K1782-4	150A		25.0 (7.6)	2
PTA-17F	K1782-10	150A	.020-5/32 (0.5-4.0)	25.0 (7.6)	1
PTA-17FV	K1782-11	150A	.020-5/32 (0.5-4.0)	25.0 (7.6)	1
	K1782-13			12.5 (3.8)	1
PTA-17V	K1782-6	150A	.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1782-7	150A		12.5 (3.8)	2
	K1782-8	150A		25.0 (7.6)	1
	K1782-9	150A		25.0 (7.6)	2
PTA-17 Ultra-Flex™	K1782-12	150A	.020-5/32 (0.5-4.0)	12.5 (3.8)	1
PTA-26	K1783-1	200A	.020-5/32 (0.5-4.0)	12.5 (3.8)	1
	K1783-2	200A		12.5 (3.8)	2
	K1783-3	200A		25.0 (7.6)	1
	K1783-4	200A		25.0 (7.6)	2
PTA-26F	K1783-10	200A	.020-5/32 (0.5-4.0)	25.0 (7.6)	1
PTA-26FV	K1783-11	200A	.020-5/32 (0.5-4.0)	25.0 (7.6)	1
PTA-26V	K1783-7	200A	.020-5/32 (0.5-4.0)	12.5 (3.8)	2
	K1783-8	200A		25.0 (7.6)	1
	K1783-9	200A		25.0 (7.6)	2
<b>Water-Cooled</b>					
PTW-18	K1784-1	350A	.020-5/32 (0.5-4.0)	12.5 (3.8)	3
	K1784-2	350A		25.0 (7.6)	3
PTW-20	K1784-3	250A	.020-1/8 (0.5-3.2)	12.5 (3.8)	3
	K1784-4	250A		25.0 (7.6)	3

## Lincoln Electric Adapters

Model	Product Number
<b>For Precision TIG® 275/375 Power Sources</b>	
PTA-26 (one-piece power cable)	K2166-1 
PTA-9, -17 (one-piece power cable)	K2166-3 
PTA-9, -17, -26 (two-piece power cable)	K2166-2 
PTW-18, -20	No adapter required.
<b>For Invertec® V160-T, V205-T AC/DC, V205-T DC &amp; Precision TIG® 225, Square Wave™ TIG 175 Power Sources</b>	
PTA-9, -17	K1622-1 
PTW-18, -20	K1622-4 
PTA-26	K1622-3 
<b>For TIG Module &amp; Power Sources with 1/2 in. (50.8 mm) Stud Output Terminals</b>	
PTW-18, -20	K2505-2 and K1622-4 
PTA-26, -26V	K2505-2 and K1622-3
PTA-9, -17	K2505-2 and K1622-1
PTA-9, -17, -26 (two-piece power cable)	No adapter required
<b>For Invertec® V160-S, V275-S, V350 PRO and Power Sources with Twist Mate™ Power and Separate Gas</b>	
PTA-9FV, -17V, -17FV	K2505-1 and K1622-1 
<b>For Invertec® V155-S and Power Sources with small Twist Mate™ Power and Separate Gas</b>	
PTA-9FV, -17V, -17FV	K960-2 

<sup>(1)</sup> Pre-configured package with K1622-1 Twist Mate™ adapter and 1/16 in. (1.6 mm) gas lens collet body, collet, and gas lens installed.



# Pro-Torch™ TIG Torch Parts Kits

## Parts Kits

Torch Series	Parts Kit	Items Included	Item No.
PTA-9 Series	KP507	Back Cap - Long Collet - .040 (1.0) Collet - 1/16 (1.6) Collet Body - .040 (1.0) Collet Body- 1/16 (1.6) Alumina Nozzle - 1/4 (6.0) Alumina Nozzle - 5/16 (8.0) Alumina Nozzle - 3/8 (10.0) Tungsten Electrodes, included: (2% Thoriated) .040" x 7.0" (1.0 x 178 mm) 1/16" x 7.0" (1.6 x 178 mm)	KP2035-4B1 KP2029-2B1 KP2029-3B1 KP2031-2B1 KP2031-3B1 KP2017-1B1 KP2017-2B1 KP2017-3B1
PTA-17 Series	KP508	Back Cap - Short Collet - .040 (1.0) Collet - 1/16 (1.6) Collet - 3/32 (2.4) Collet Body - .040 (1.0) Collet Body - 1/16 (1.6) Collet Body - 3/32 (2.4) Alumina Nozzle - 1/4 (6.0) Alumina Nozzle - 5/16 (8.0) Alumina Nozzle - 3/8 (10.0) Tungsten Electrodes, included: (2% Thoriated) .040" x 7.0" (1.0 x 178 mm) 1/16" x 7.0" (1.6 x 178 mm) 3/32" x 7.0" (2.4 x 178 mm)	KP2036-2B1 KP2030-2B1 KP2030-3B1 KP2030-4B1 KP2032-2B1 KP2032-3B1 KP2032-4B1 KP2016-6B1 KP2016-5B1 KP2016-4B1
PTW-18 & PTA-26	KP509	Back Cap -Short Collet - 1/16 (1.6) Collet - 3/32 (2.4) Collet - 1/8 (3.2) Collet Body - 1/16 (1.6) Collet Body - 3/32 (2.4) Collet Body - 1/8 (3.2) Alumina Nozzle - 5/16 (8.0) Alumina Nozzle - 3/8 (10.0) Alumina Nozzle - 1/2 (12.5) Tungsten Electrodes, included: (2% Thoriated) 1/16" x 7.0" (1.6 x 178 mm) 3/32" x 7.0" (2.4 x 178 mm) 1/8" x 7.0" (3.2 x 178 mm)	KP2036-2B1 KP2031-3B1 KP2031-4B1 KP2031-5B1 KP2032-3B1 KP2032-4B1 KP2032-5B1 KP2016-5B1 KP2016-4B1 KP2016-2B1
PTW-20	KP510	Back Cap - Long Collet - 1/16 (1.6) Collet - 3/32 (2.4) Collet - 1/8 (3.2) Collet Body - 1/16 (1.6) Collet Body - 3/32 (2.4) Collet Body - 1/8 (3.2) Alumina Nozzle - 5/16 (8.0) Alumina Nozzle - 3/8 (10.0) Alumina Nozzle - 7/16 (11.0) Tungsten Electrodes, included: (2% Thoriated) 1/16" x 7.0" (1.6 x 178 mm) 3/32" x 7.0" (2.4 x 178 mm) 1/8" x 7.0" (3.2 x 178 mm)	KP2035-3B1 KP2029-3B1 KP2029-4B1 KP2029-5B1 KP2031-3B1 KP2031-4B1 KP2031-5B1 KP2017-2B1 KP2017-3B1 KP2017-4B1

## Gas Lenses Parts Kits

Torch Series	Parts Kit	Items Included	Item No.
PTA-9 or PTW-20 Series	KP2414-1	Back Cap - Long Collet - .040 (1.0) Collet - 1/16 (1.6) Collet - 3/32 (2.4) Gas Lens - .040 (1.0) Gas Lens - 1/16 (1.6) Gas Lens - 3/32 (2.4) Alumina Nozzle - 5/16 (8.0) Alumina Nozzle - 3/8 (10.0) Alumina Nozzle - 7/16 (11.0) Tungsten Electrodes, included: (2% Thoriated) 1/16" x 7.0" (1.6 x 178 mm) 3/32" x 7.0" (2.4 x 178 mm) .040" x 7.0" (1.0 x 178 mm)	KP2035-4B1 KP2029-2B1 KP2029-3B1 KP2029-4B1 KP2033-2B1 KP2033-3B1 KP2033-4B1 KP2019-2B1 KP2019-3B1 KP2019-4B1

## Gas Hook-up Kits for Connecting Power Sources with 1/2 in. (50.8 mm) output terminals



KP504 For PTW-18 and PTW-20				
Item	Part #	Industry Std. Part #	Description	
2(a)	S19558-4	40V76	Water Hose	12.5 ft. (3.8m)
1(b)	S19558-1	40V77	Gas Hose	12.5 ft. (3.8m)
2(d)	S19558-5		Water Adapter Fittings	5/8 ft. (15.8mm)
1(d)	S19558-6	11N18	Water Hose Coupler	
1(e)	S19257-1	45V11	Power Cable Adapter	

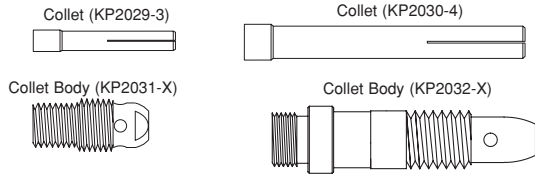
KP505 For PTA-9, PTA-9F, PTA-17, PTA-17F, PTA-26 and PTA-26F				
Item	Part #	Industry Std. Part #	Description	
1(a)	S19558-2	-	Gas Hose	18 in. (457mm) from solenoid valve to power cable adapter
1(b)	S19558-1	40V77	Gas Hose	12.5 ft. (3.8m)

KP506 (For PTA-17V and PTA-26V)				
Item	Part #	Industry Std. Part #	Description	
1(a)	S19558-1	40V77	Gas Hose	12.5 in. (3.8m) with 5/8-18 right hand male fittings.



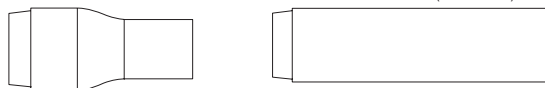
# Pro-Torch™ TIG Expendable Parts

Tungsten Diameter In./mm	Torch Type	
	PTA-9 Series PTW-20 Series	PTA-17 Series PTA-26 Series PTW-18 Series
<b>Collet</b>	Length 1.0"	Length 1-15/16"
.020" (0.5 mm)	KP2029-1B1	KP2030-1B1
.040" (1.0 mm)	KP2029-2B1	KP2030-2B1
1/16" (1.6 mm)	KP2029-3B1	KP2030-3B1
3/32" (2.4 mm)	KP2029-4B1	KP2030-4B1
1/8" (3.2 mm)	KP2029-5B1	KP2030-5B1
5/32" (4.0 mm)	-	KP2030-6B1
<b>Collet Body</b>	Length 13/16"	Length 1-13/16"
.020" (0.5 mm)	KP2031-1B1	KP2032-1B1
.040" (1.0 mm)	KP2031-2B1	KP2032-2B1
1/16" (1.6 mm)	KP2031-3B1	KP2032-3B1
3/32" (2.4 mm)	KP2031-4B1	KP2032-4B1
1/8" (3.2 mm)	KP2031-5B1	KP2032-5B1
5/32" (4.0 mm)	-	KP2032-6B1



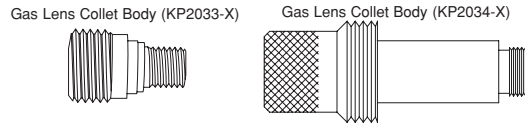
## Alumina Nozzles (for use with above collet bodies)

Orifice Diameter In./mm	Size (16th in.)	Torch Type	
		PTA-9 Series PTW-20 Series	PTA-17 Series PTA-26 Series PTW-18 Series
1/4" (6 mm)	4	KP2017-1B1	KP2016-6B1
5/16" (8 mm)	5	KP2017-2B1	KP2016-5B1
3/8" (10 mm)	6	KP2017-3B1	KP2016-4B1
7/16" (11 mm)	7	KP2017-4B1	KP2016-3B1
1/2" (12.5 mm)	8	KP2017-5B1	KP2016-2B1
5/8" (16 mm)	10	KP2017-6B1	KP2016-1B1



These parts are not to scale due to space limitations.

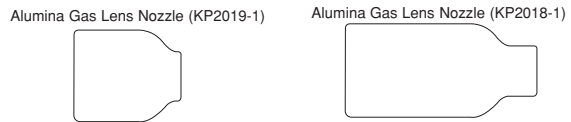
Tungsten Diameter In./mm	Torch Type PTA-9 Series PTW-20 Series Length 7/8"	PTA-17 Series PTA-26 Series PTW-18 Series Length 1-15/16"
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## Gas Lens Collet Bodies

.020" (0.5 mm)	KP2033-1B1	KP2034-1B1
.040" (1.0 mm)	KP2033-2B1	KP2034-2B1
1/16" (1.6 mm)	KP2033-3B1	KP2034-3B1
3/32" (2.4 mm)	KP2033-4B1	KP2034-4B1
1/8" (3.2 mm)	KP2033-5B1	KP2034-5B1
5/32" (4.0 mm)	-	KP2034-6B1

Note: KP2034-X series Gas Lens Collet Bodies require KP2037-3 gas lens insulator.



## Alumina Gas Lens Nozzles (for use with Gas Lens Collet Bodies)

Size (16th inch)	Length	Length
1/4" (6 mm)	4	1 11/16" (42.9mm)
5/16" (8 mm)	5	KP2019-1B1
3/8" (10 mm)	6	KP2019-2B1
7/16" (11 mm)	7	KP2019-3B1
1/2" (12.5 mm)	8	KP2019-4B1
11/16" (17 mm)	Short	KP2018-1B1
		Length
		.700" (7.8 mm)
		KP2018-6B1

Note: KP2018-X series Alumina Gas Lens Nozzles require the KP2037-3 gas lens insulator.



## Back Caps

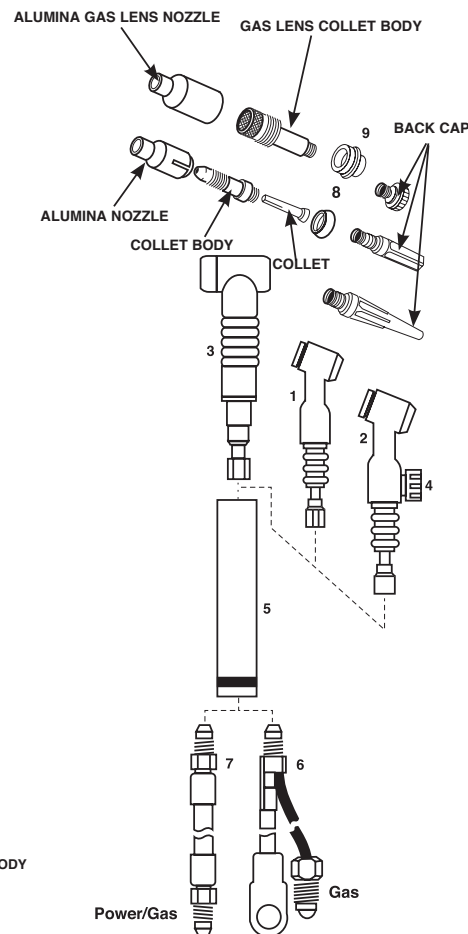
Short	KP2035-1B1	KP2036-2B1
Medium	KP2035-2B1	
Long	KP2035-4B1	KP2036-1B1



# TIG Torch Assemblies

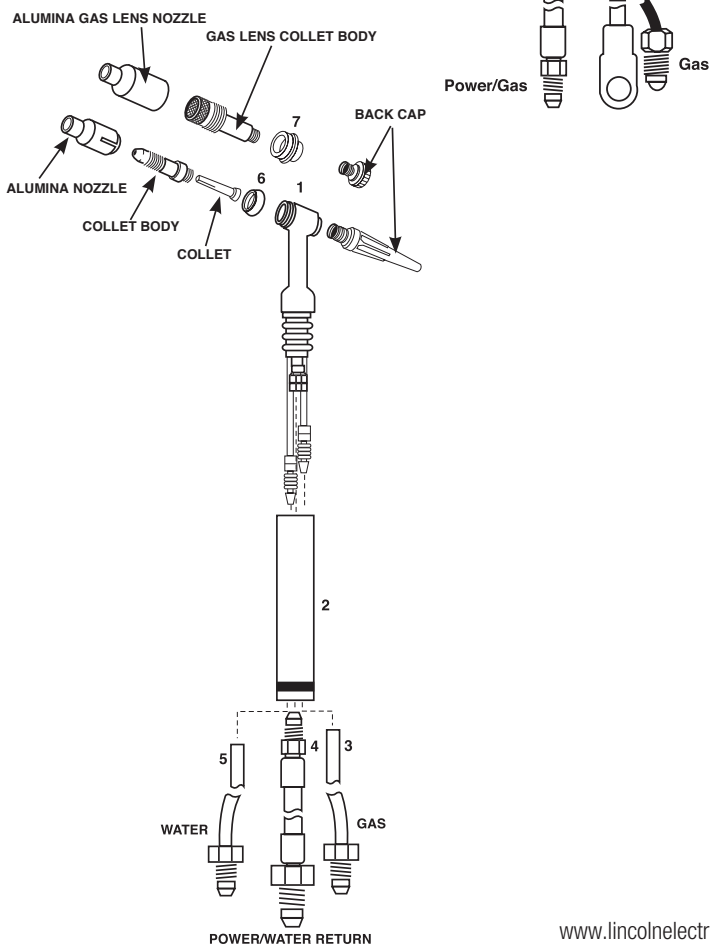
## PTA-9, -17, -26 (Formerly LA26 Torch) SERIES AIR-COOLED

Item	Description	Part #	Model
1	Torch body with gaskets	S19258-1	PTA-9
		S19259-1	PTA-17
		S19260-1	PTA-26
2	Torch body with gaskets	S19259-2	PTA-17V
		S19260-2	PTA-26V
3	Torch body with gaskets	S24922-1	PTA-9F
		S24923-1	PTA-17F
		S24925-1	PTA-26F
4	Valve Knob with "O" Ring	S19515-1M	PTA-17V
		S19515-2M	PTA-26V
5	Torch Handle	S19511-1	PTA-9, PTA-17, PTA-17V
		S19511-2	PTA-26, PTA-26V
6	Power Cable and Gas, 2 piece 12.5' (3.8 m)	S19512-2	PTA-9, PTA-17
		S19512-6	PTA-26
		S19512-4	PTA-9
		S19512-8	PTA-26
7	Power Cable and Gas, 1 piece 12.5' (3.8 m)	S19512-1	PTA-9, PTA-17
		S19512-5	PTA-26
		S19512-3	PTA-9, PTA-17
		S19512-7	PTA-26
8	Cup Gasket, 2 pack	S19515-6M	PTA-9
		S19515-7M	PTA-17, PTA-26
		S19515-9M	PTA-17F, PTA-26F
9	Gas Lens Insulator	KP2037-3B1	PTA-17, PTA-26



## PTW-18, -20 SERIES WATER-COOLED

1	Torch body with gaskets	S19261-1	PTW-18	
		S19262-1	PTW-20	
2	Torch Handle	S19511-2	PTW-18	
		S19511-1	PTW-20	
3	Gas Hose (Blue)	12.5' (3.8 m)	S19512-17	PTW-18
		25' (7.6 m)	S19512-20	PTW-18
		12.5' (3.8 m) (standard)	S19512-11	PTW-20
		25' (7.6 m)	S19512-14	PTW-20
4	Power Cable	12.5' (3.8 m)	S19512-15	PTW-18
		25' (7.6 m)	S19512-18	PTW-18
		12.5' (3.8 m)	S19512-9	PTW-20
		25' (7.6 m)	S19512-12	PTW-20
5	Water Hose (Red)	12.5' (3.8 m)	S19512-16	PTW-18
		25' (7.6 m)	S19512-19	PTW-18
		12.5' (3.8 m)	S19512-10	PTW-20
		25' (7.6 m)	S19512-13	PTW-20
6	Cup Gasket, 2 pack	S19515-7M	PTW-18	
		S19515-6M	PTW-20	
7	Gas Lens Insulation, 2 pack	KP2037-3B1	PTW-18	



# Fume Extraction Filters

Product Number	Description	Pkg. Qty.	Miniflex	X-Tractor 1GC	X-Tractor 3A	X-Tractor 5A, 3G, 4G	X-Tractor 8A	Mobiflex 200-M	Mobiflex 400-MS	Statiflex 200-M	Statiflex 400-MS	Statiflex 6000-MS	Statiflex Filter Bank	DownFlex 100-NF	DownFlex 200-M	DownFlex 400-MS/A
K2389-1	Activated Carbon Filter	1	●													
KP2390-1	LongLife-H Filter	1	●													
KP2390-2	HEPA Filter	1	●													
KP2390-3	Prefilter	1	●													
K1673-1	Cellulose Filter	1						●		●						
K1673-3	High Efficiency Cellulose/ Polyester Filter	1						●		●						
K1852-1	Activated Carbon Filter	1						●		●						
K1673-2	Cellulose Filter	1							●		●					
K1673-4	High Efficiency Cellulose/ Polyester Filter	1							●		●					
S23281-8	Spark Arrestor	1						●		●						
S23281-24	Pre-Filter	1							●		●					
KP2069-1	Filter Cartridge	1		●	●											
KP2061-1	Filter Cartridge	1				●										
KP3984-1	Filter Cartridge	1					●									
K2752-13	LongLife Filter	2													●	●
K2752-14	HEPA Filter	1													●	●
K2752-12	Spark Arrestors	2												●	●	●
KP4052-1	Pre-Spark Arrestors	2													●	●
K3367-1	Filter Cartridge	2										●				
K3368-1	High Efficiency Filter Cartridge	2										●				
KP3369-1	Filter Cartridge, MERV 16	1											●			
KP3370-1	Filter Cartridge, MERV 11	1											●			



Activated Carbon Filter for Miniflex

KP2390-1; LongLife-H Filter for Miniflex

KP2390-2; HEPA Filter for Miniflex

K1673-1; Cellulose Filter

K1673-2; Cellulose Filter

K1673-3; Cellulose/polyester high efficiency filter. Filter class MERV 16 per ASHRAE 52.2.

K1673-4; Cellulose/polyester high efficiency filter. Filter class MERV 16 per ASHRAE 52.2.



K1852-1; Mobiflex 200M filter with Activated Carbon Filter

K2752-12; Spark Arrestors for DownFlex Tables

K2752-13; LongLife filter for the 200M and 400MS/A DownFlex Tables

K2752-14; HEPA Filter for DownFlex Tables

KP2069-1; Filter for X-Tractor 1GC and 3A

KP3369-1; High efficiency filter (MERV 16) for Statiflex Filter Banks.

KP3984-1; Filter for X-Tractor 8A

# Portable



**MINIFLEX**  
**K3972-1 (115 VAC)**  
**K3973-1 (230 VAC)**  
 with  
 optional EN 20 Extraction Nozzle



**X-TRACTOR 1GC**  
**K652-1 (115 VAC)**  
**K652-2 (230 VAC)**  
 Shown with optional  
 K639-5 Suction Nozzle

## ACCESSORIES

**K639-1** SHM-300  
 Nozzle, 12 inches  
 (300 mm)



**K639-2** SHM-400  
 Nozzle, 16 inches  
 (400 mm)

**K639-3** SHM-500 Nozzle, 20 inches  
 (500 mm)

**Aluminum Suction Nozzles with  
 Magnetic Mounting**

Includes S20591-7 adapter for 1-3/4 inch  
 (45 mm) hose. Best capture distance:  
 approximately 1-1/2 inches (38 mm).

Clamp to attach nozzle to magnet  
 S21544-1.

**K639-4**  
**SHMS-400 Low  
 Noise Nozzle**

16 inch (400 mm)  
 aluminum suction  
 nozzle with magnetic  
 mounting. Includes  
 S20591-7 adapter for 1-3/4 inch (45 mm)  
 hose. Best capture distance: 1-1/2 inches  
 (38 mm).



Clamp to attach nozzle to magnet  
 S21544-2.

**K639-5**  
**SHFA Flat Suction  
 Nozzle**

6 inch (150 mm)  
 aluminum suction  
 nozzle with 20 inches  
 (500 mm) flexible steel  
 hose and magnetic mounting. Includes  
 S20591-7 adapter for 1-3/4 inch (45 mm)  
 hose. Best capture distance: < 4 inches  
 (100 mm).



Clamp to attach nozzle to magnet  
 S21544-3.

**K639-6**  
**UNM Suction Nozzle  
 for Heavy Smoke**

8 inch (200 mm)  
 aluminum suction  
 nozzle with magnetic  
 mounting. Includes  
 S20591-7 adapter for 1-3/4 inch (45 mm)  
 hose. Best capture distance: < 4 inches  
 (100 mm).



Clamp to attach nozzle to magnet  
 S21544-4.

**K639-20**  
**Gun Mounted  
 Nozzle Kit  
 (OT-25)**

Nickel plated  
 brass nozzle slips over the gun's gas nozzle  
 and secures with screw. Includes a total  
 of 16 ft. (5 m) of hose and all necessary  
 adapters including SS-3245 (S20591-14)  
 for connection to 1-3/4 inch (45 mm) hose.  
 Gun sold separately.



**K639-14**  
**SHMT ROUND  
 SUCTION  
 NOZZLE**

Clamp to  
 attach nozzle to magnet S21544-7.



**K2389-5**  
**EN 20  
 Extraction  
 Nozzle**

**K2389-6**  
**EN 40 Extraction Nozzle**



**S21544-10** Magnet for  
 fume nozzle



**K2389-8**  
**K2389-9**  
**Extraction  
 Hoses**

Use to extend  
 or replace 8 ft.  
 (2.5 m) hose included with the Miniflex®.  
 Length of K2389-8 is 16 ft. (5 m). Length  
 of K2389-9 for 8 ft. (2.5 m). Both hoses  
 are 1-3/4 inches (45 mm) in diameter.



**K2389-3**  
**NKT Nozzle  
 Kit for  
 Magnum  
 MIG guns**

**K2389-4**  
**NKC Nozzle  
 Kit for  
 Magnum  
 MIG guns**



**K2389-10**  
**HOSE-TO-HOSE ADAPTER**

**S20591-7**  
**HOSE-TO-TUBE ADAPTER**  
 Hose size 1-3/4 in. (45 mm)  
 to tube size 1-1/2 in (38 mm).



## MINIFLEX ONLY OPTIONS



**HOSE CONNECTION OUTLET**  
**K2389-2**

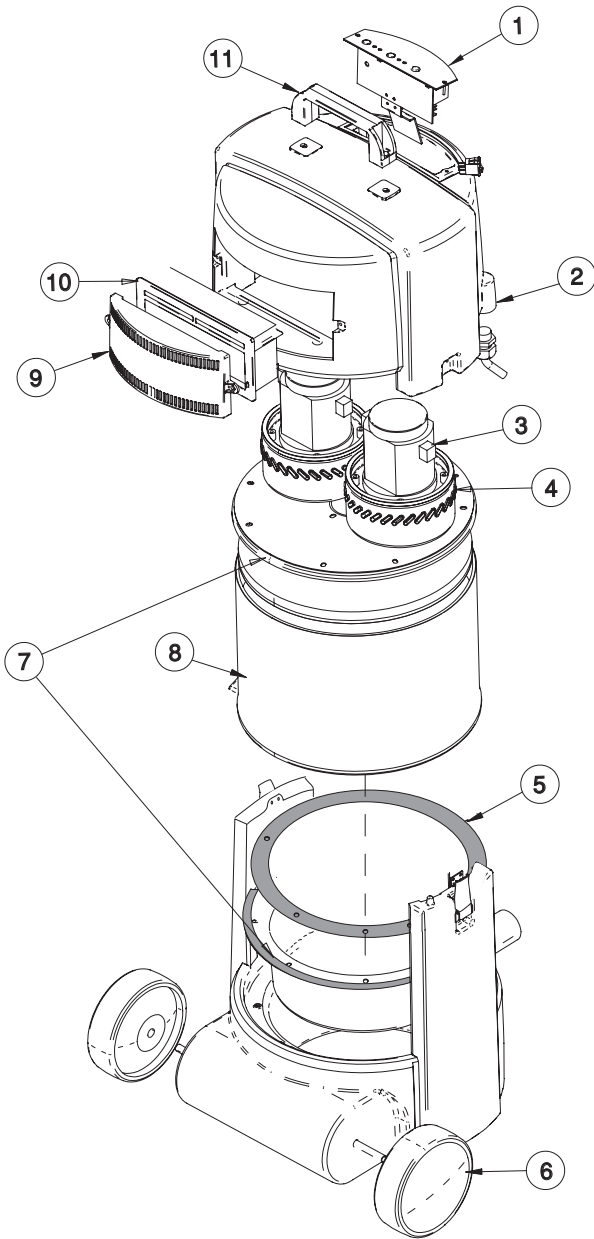


**WALL MOUNTING BRACKET**  
**for MINIFLEX**  
**K2389-7**



# Miniflex<sup>®</sup> Portable Fume Extractor

## K2376-1, K3972-1 & K3973-1



ITEM	DESCRIPTION	Part #	QTY			
	Miniflex Portable Fume Extractor, Includes:	K2376-1	1	X	-	-
	Miniflex Portable Fume Extractor, Includes:	K3972-1	1	-	X	-
	Miniflex Portable Fume Extractor, Includes:	K3973-1	1	-	-	X
1	Control Panel and PC Board	S23384-22	1	X	-	-
2	Switch	S23384-23	1	X	X	X
3	Carbon Brushes (2 sets), Seals, 115V	S23384-24	1	X	X	-
3	Carbon Brushes (2 sets), Seals, 230V	S23384-64	1	-	-	X
4	Motor, Seals, 115V	S23384-25	2	X	X	-
4	Motor, Seals, 230V	S23384-65	2	-	-	X
5	Prefilter	KP2390-3	1	X	X	X
6	Set of Wheels (2 pieces, excludes Wheel Covers)	S23384-27	1	X	X	X
7	Seals, Main Filter (Set)	S23384-26	1	X	X	X
8	LongLife-H Filter	KP2390-1	1	X	X	X
9	Outlet Cover	S23384-49	1	X	X	X
10	HEPA Filter	KP2390-2	1	X	X	X
11	Handle	S23384-50	1	X	X	X
12A	Control Panel (Not Shown)	S23384-66	1	-	X	X
12B	PC Board 115V or 230V (Not Shown)	S23384-67	1	-	X	X



# Mobiflex®

## BASE UNITS



**MOBIFLEX 100-NF**  
K1666-1  
with  
K1668-1 Hose & Hood Set and  
K1668-2 Extension Hose Kit



**MOBIFLEX 200-M**  
K1653-(2,3) 115V  
K2497-2 230V  
Shown with optional  
K1668-1 Hose Set



**MOBIFLEX 400-MS**  
K1741-(1,2) 115V  
K2497-4 230V  
Shown with  
required Extraction Arm

## ARMS



**LFA 3.1**  
K2633-1  
(10 ft.) EXTRACTION ARM



**LFA 3.1**  
K2633-2  
(10 ft.) EXTRACTION ARM  
LAMP KIT WITH ARC SENSOR



**LFA 4.1**  
K2633-3  
(13 ft.) EXTRACTION ARM

**LFA 4.1**  
K2633-4  
(13 ft.) EXTRACTION ARM  
LAMP KIT WITH ARC SENSOR

## ACCESSORIES



**16' HOSE/HOOD SET**  
K1668-1



**TAPERED CONNECTION**  
6"-8" FLANGE  
(REQUIRED WHEN HOOKING  
HOSE TO MOBIFLEX® UNITS)  
USED ONLY FOR K1668-1 ON  
MOBIFLEX® 200M, 400 MS.  
S23267

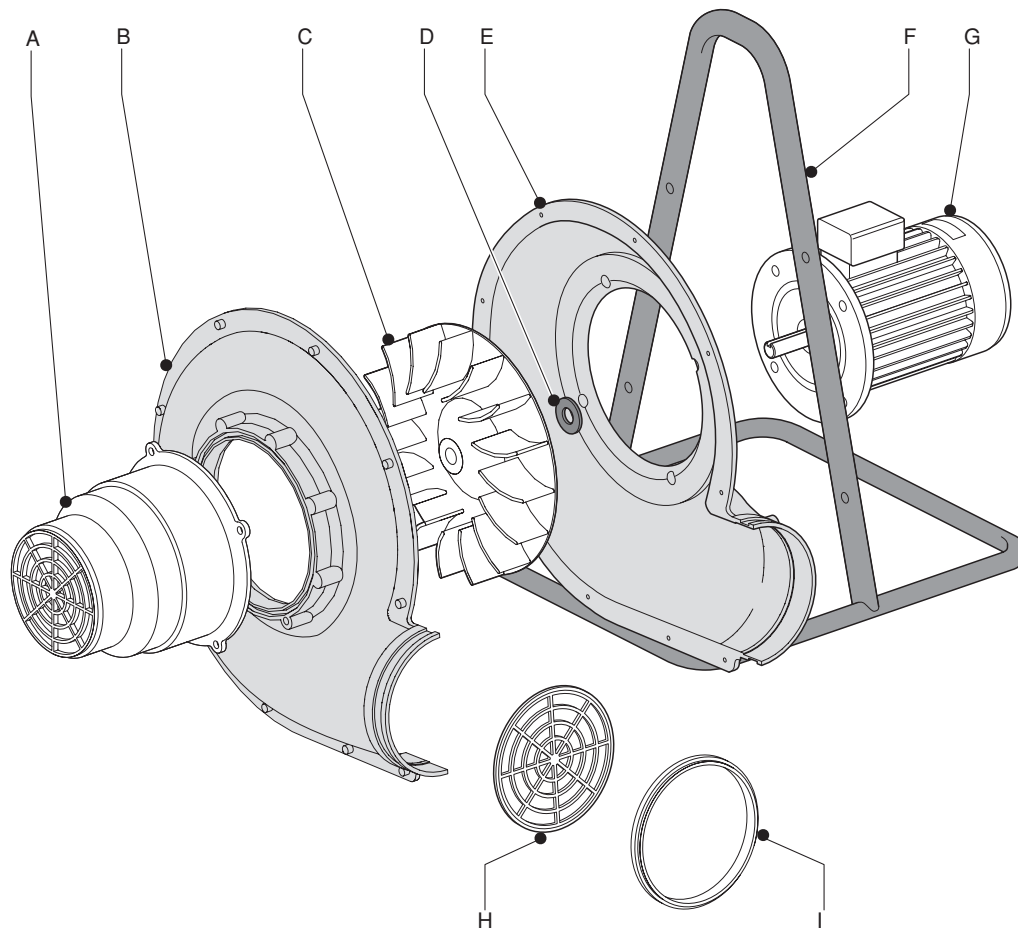


**EXHAUST OR**  
EXTENSION HOSE SET  
K1668-2



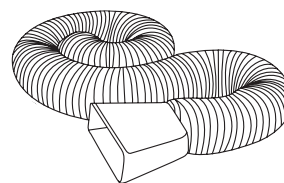
**16' HOSE/HOOD SET WITH**  
TAPERED CONNECTION  
6"-8" FLANGE  
K1668-3

# K1666-1 Mobiflex® 100-NF Portable Fan Assembly

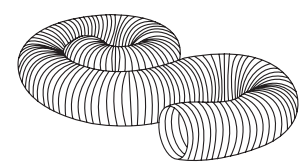


ITEM	DESCRIPTION	Part #	QTY
A	Connection Flange	<b>S23267</b>	1
B	Fan Housing, Blower Side	<b>S23281-19</b>	1
C	Fan Wheel	<b>S23281-2</b>	1
D	Shim, 0.75x1.00x0.05 in.	<b>S23281-15</b>	1
E	Fan Housing, Motor Side	<b>S23281-1</b>	1
F	Carrying Handle	<b>S23281-20</b>	1
G	Motor, 1hp, 120VAC, 60Hz, 11A	<b>S23281-14</b>	1
H	Outlet Grid	<b>S23281-21</b>	1
I	Sealing Ring	<b>S23281-22</b>	1
	ITEMS NOT SHOWN		
	Starter/Overload Switch	<b>K1494-2</b>	1

## USE WITH



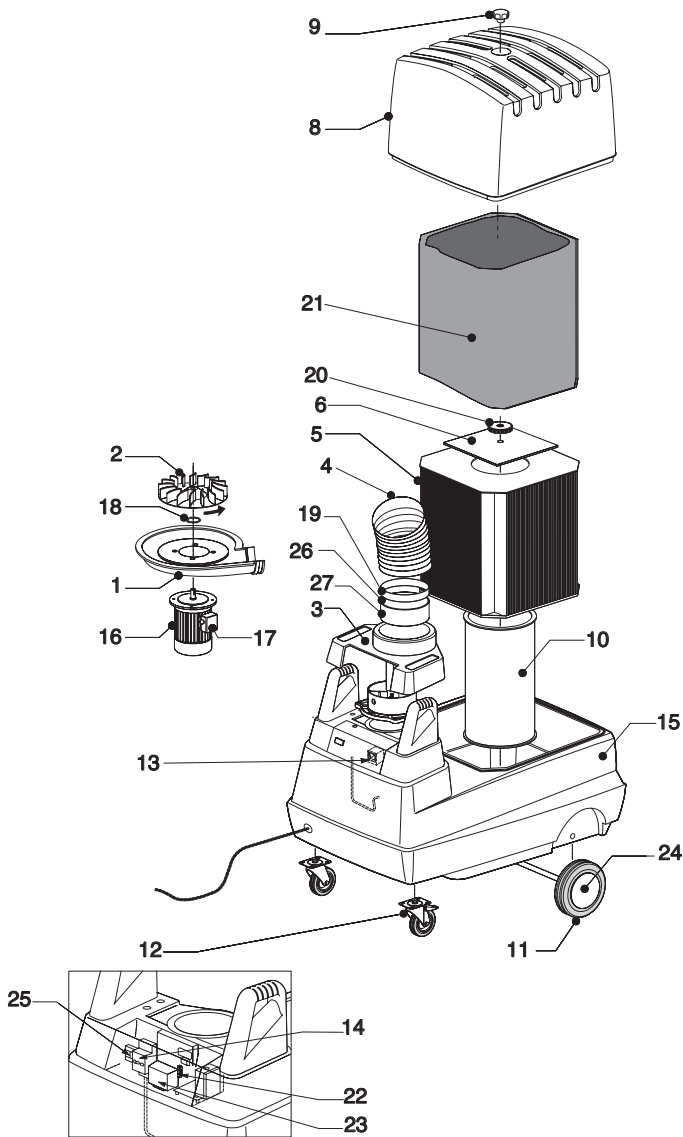
**HOSE AND HOOD SET**  
K1668-1



**EXHAUST OR  
EXTENSION HOSE SET**  
K1668-2

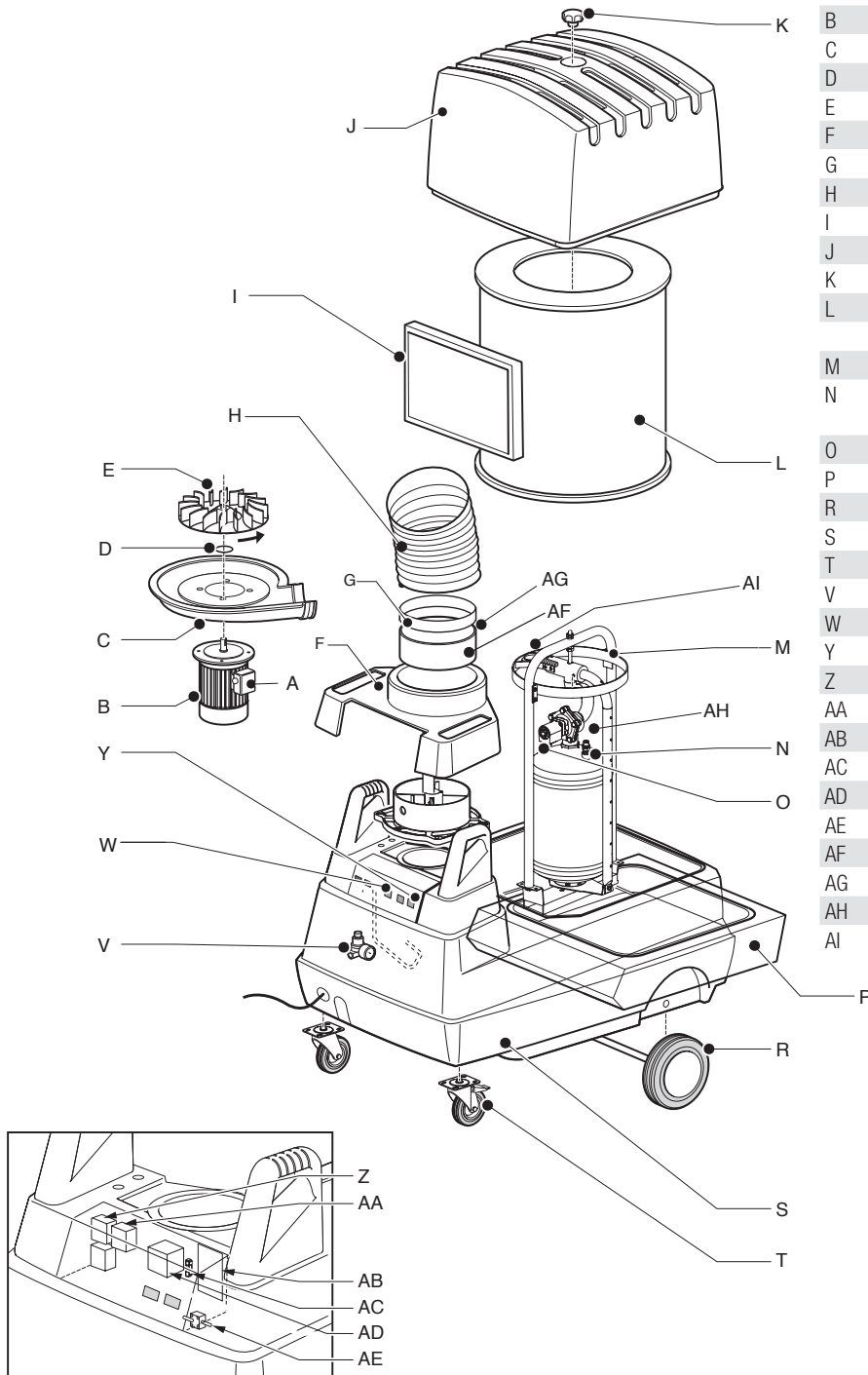


# Mobiflex<sup>®</sup> 200-M Base Unit



ITEM	DESCRIPTION	Part #	QTY	1	2	3
	Mobiflex 200-M, Includes:	<b>K1653-1</b>	1	X	-	-
	Mobiflex 200-M, Includes:	<b>K1653-2</b>	1	-	X	-
	Mobiflex 200-M, Includes:	<b>K1653-3</b>	1	-	-	X
1	Fan Housing, Motor Side	<b>S23281-1</b>	1	X	X	X
2	Fan Wheel	<b>S23281-2</b>	1	X	X	X
3	Control Housing, Mobiflex	<b>S23281-3</b>	1	X	X	X
4	Replacement Hose, 4 ft.	<b>S23282-12</b>	1	X	X	X
5	Cellulose Filter	<b>K1673-1</b>	1	X	X	-
5	Cellulose/Polyester High Efficiency Filter	<b>K1673-3</b>	1	-	-	X
6	Filter Cover Plate, 200-M	<b>S23281-5</b>	1	X	X	X
8	Filter Housing, Mobiflex	<b>S23281-6</b>	1	X	X	X
9	Thumb Nut	<b>S23281-7</b>	1	X	X	X
10	Spark Arrester, 200-M	<b>S23281-8</b>	1	X	X	X
11	Rear Wheel, Mobiflex	<b>S23281-9</b>	2	X	X	X
12	Front Caster Assembly, Mobiflex	<b>S23281-10</b>	2	X	X	X
13	Filter Maintenance Indicator	<b>S23281-11</b>	1	X	X	X
14	Motor Protection Switch, Mobiflex (ON/OFF Switch)	<b>K1494-2</b>	1	X	X	X
15	Main Housing, Mobiflex	<b>S23281-13</b>	1	X	X	X
16	Motor	<b>S23281-14</b>	1	X	X	X
17	Motor Capacitor	<b>S23281-4</b>	1	X	X	X
18	Washer	<b>S23281-15</b>	1	-	X	X
19	Rubber Seal, 8"	<b>S23282-1</b>	1	X	X	X
20	Knurled Nut	<b>S23281-16</b>	1	-	X	X
21	Activated Carbon Filter (Optional)	<b>K1852-1</b>	1	-	X	X
22	Fuse (2.0 Amp/250 V, Slow-Blow)	<b>S23284-2</b>	1	-	X	X
23	Transformer (230/115/24 V, 48 VA)	<b>S23284-4</b>	1	-	X	X
24	Starlock	<b>S23281-70</b>	1	-	X	X
25	Contactar (24 V/60 HZ/10 VA) (Not ON/OFF Switch)	<b>S23284-5</b>	1	-	X	X
26	Red Plastic Ring	<b>S23282-36</b>	1	-	X	X
27	Clamping Pin	<b>S23282-19</b>	1	-	X	X
28	Fuse Holder (20 Amp) (Not Shown)	<b>S23284-1</b>	1	-	X	-
29	Terminal Connection Block (Not Shown)	<b>S23284-3</b>	1	-	X	-

# Mobiflex® 400-MS Base Unit



ITEM	DESCRIPTION	Part #	QTY		
Mobiflex 400-MS, Includes:		<b>K1741-1</b>		<b>X</b>	
Mobiflex 400-MS, Includes:		<b>K1741-2</b>			<b>X</b>
A	Motor Capacitor	<b>S23281-4</b>	1	X	X
B	Motor	<b>S23281-14</b>	1	X	X
C	Fan Housing	<b>S23281-1</b>	1	X	X
D	Washer - Shim Fan Brad	<b>S23281-15</b>	1	X	X
E	Fan Wheel	<b>S23281-2</b>	1	X	X
F	Control Housing	<b>S23281-3</b>	1	X	X
G	Rubber Seal 8 in.	<b>S23282-1</b>	1	X	X
H	Replacement Hose	<b>S23282-12</b>	1	X	X
I	Pre-Filter	<b>S23281-24</b>	1	X	X
J	Filter Cover	<b>S23281-26</b>	1	X	X
K	Thumb Nut	<b>S23281-7</b>	1	X	X
L	Cellulose Filter	<b>K1673-2</b>	1	X	-
	Cellulose / Polyester High Efficiency Filter	<b>K1673-4</b>	1	-	X
M	Filter Cleaning Unit, Complete	<b>S23281-27</b>	1	X	X
N	Pressure Relief Valve 6-10 Bar (2400-4000 in. WG)	<b>S23281-31</b>	1	X	X
O	Membrane Valve	<b>S23281-28</b>	1	X	X
P	Dust Tray	<b>S23281-30</b>	1	X	X
R	Rear Wheel	<b>S23281-9</b>	2	X	X
S	Base	<b>S23281-29</b>	1	X	X
T	Front Caster with Brake	<b>S23281-10</b>	1	X	X
V	Pressure Reducing Valve	<b>S23281-31</b>	1	X	X
W	Control Light Indicator	<b>S23281-32</b>	1	X	X
Y	On/Off - Reset Button	<b>S23281-33</b>	1	X	X
Z	Contactors, 24V/60HZ, 10A	<b>S23284-5</b>	1	X	X
AA	Main Switch/Starter Overload SW	<b>K1494-2</b>	1	X	X
AB	Control PC Board	<b>S23281-34</b>	1	X	X
AC	Fuse 2A/250V, Slow Blow	<b>S23284-2</b>	1	X	X
AD	Transformer 115/24V, 48VA	<b>S23284-4</b>	1	X	X
AE	Pressure Difference Switch	<b>S23281-35</b>	1	X	X
AF	Red Plastic Ring	<b>S23282-36</b>	1	X	X
AG	Clamping Pin	<b>S23282-19</b>	1	X	X
AH	Valve	<b>S23281-62</b>	1		X
AI	Piston Mechanism	<b>S23281-61</b>	1		X

# Mobiflex® 400-MS Base Unit Arm Detail

K1741-1,-2 MOBIFLEX® 400 options:

- K2633-1 LFA 3.1 10 ft. Arm
- K2633-2 LFA 3.1 Lamp Kit w/Arc Sensor Kit
- K2633-3 LFA 4.1 13 ft. Arm
- K2633-4 LFA 4.1 Lamp Kit w/Arc Sensor Kit

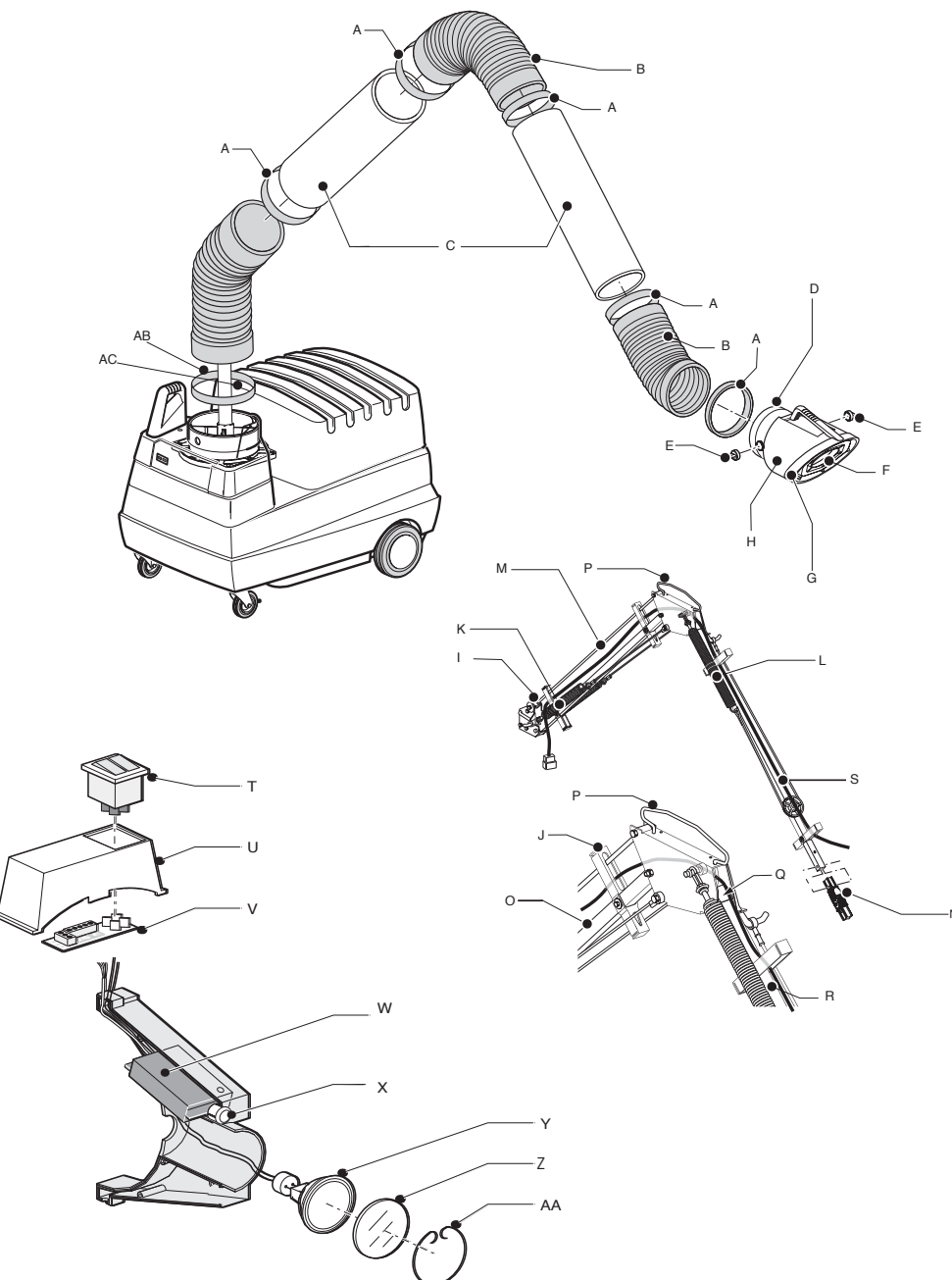
or

- K1668-3 Hose set and Hood Set with Required
- S23267 Tapered Flange Connection

ITEM	DESCRIPTION	Part #	QTY
A	Rubber Seal 8 in.	S23282-1	6
B	Replacement Hose Section	S23282-12	3
C	Arm Section LFA 3.1	S23282-2	2
	Arm Section LFA 4.1	S23282-3	2
D	Throat Rotatable Hood	S23384-37	1
E	Rotary Knob Throttle Valve	S23282-4	2
F	Airflow Focus Vanes	S23282-33	1
G	Rotatable Hood Rim	S23282-40	1
H	Rotatable Hood	S23282-5	1
I	Tee Connection Rod	S23282-39	2
J	Tube Spacer	S23282-28	4
K	Spring Set Fan Side LFA 3.1	S23828-31	1
	Spring Set Fan Side LFA 4.1	S23282-32	1
L	Spring Set Hood Side LFA 3.1	S23282-29	1
	Spring Set Hood Side LFA 4.1	S23282-30	1
M	Rod LFA 3.1	S23282-37	1
	Rod LFA 4.1	S23282-38	1
N	Hood Hinge with Rubber Protection Cover	S23282-23	1
O	Steel Tube Fan Side LFA 3.1	S23282-26	1
	Steel Tube Fan Side LFA 4.1	S23282-27	1
P	Hose Running Guard	S23282-35	1
Q	Plastic Friction Plug	S23282-6	2
R	Aluminum Tube Hood Side LFA 3.1	S23282-24	1
	Aluminum Tube Hood Side LFA 4.1	S23282-25	1

LFA 3.1/4.1 Lamp Kit w/Arc Sensor Kit - PN's K2633-2 & K2633-4

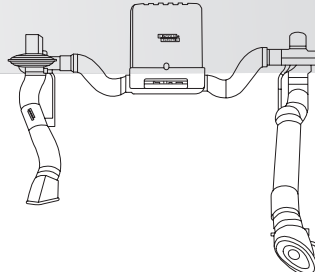
S	Connection Wire	S23270-1	1
T	Remote Switch, Lamp	S23283-1	1
U	Switch Enclosure	S23283-2	1
V	Interconnection PC Board	S23283-3	1
W	Automatic Start-Stop Arc Sensor	S23275	1
X	Plastic Lens Cap	S23283-8	2
Y	Halogen Lamp	S23283-6	1
Z	Glass Spatter Guard	S23283-10	1
AA	Holding Spring	S23283-9	1
AB	Clamping Pin	S23282-19	1
AC	Red Plastic Ring	S23282-36	1



**Statiflex**<sup>®</sup>



**STATIFLEX 200 M**  
K1654-(1,3)  
*Single Arm Base Unit*



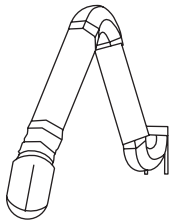
**STATIFLEX 200 M DUAL ARM**  
K1654-(1,2)



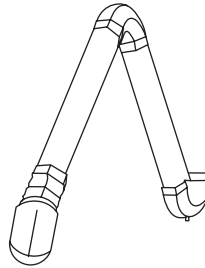
**STATIFLEX 400 MS**  
K1742-1

**STATIFLEX 200'S**  
(REQUIRES EITHER SW OPTION OR ARC SENSOR KIT)

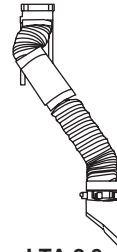
**STATIFLEX 400**  
(REQUIRES ARC SENSOR KIT)



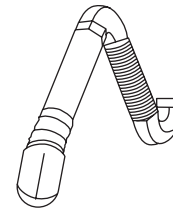
**LFA 3.1**  
K1655-1



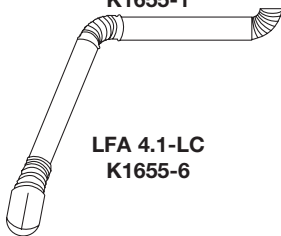
**LFA 4.1**  
K1655-2



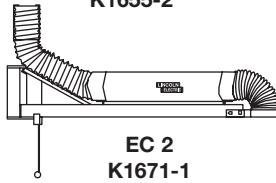
**LTA 2.0**  
K1655-3



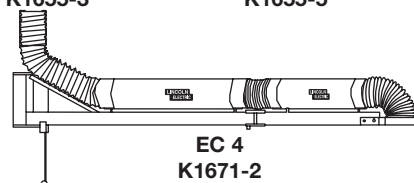
**LFA 2.0**  
K1655-5



**LFA 4.1-LC**  
K1655-6

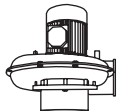


**EC 2**  
K1671-1



**EC 4**  
K1671-2

**FANS**



**SF2400**  
K1656-1



**SF4200**  
NO REPLACEMENT  
PARTS AVAILABLE  
RECOMMENDED FOR EC2/EC4  
K1656-4

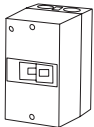


**SF2400 LMB**  
LFA 3.1, LFA 4.1,  
& LFA 4.1 LC  
K1657-1

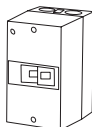


**SF2400 TMB**  
LTA 2.0, LFA 2.0,  
EC2, EC4  
K1657-2

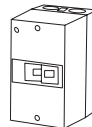
**SW OPTIONS**



**STARTER OVERLOAD  
SWITCH 120V SF2400**  
K1494-2

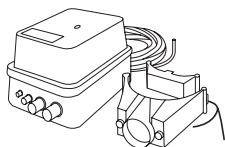


**STARTER OVERLOAD  
SWITCH 230V SF2400**  
K1494-3

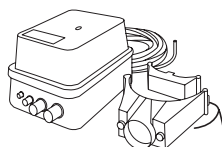


**STARTER OVERLOAD  
SWITCH for SF4200 FAN**  
K1494-10

**ARC SENSORS**



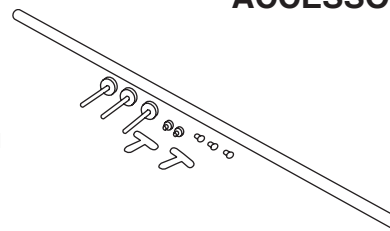
**LAMP KIT WITH  
ARC SENSOR  
(SF2400 FAN)**  
K1669-4



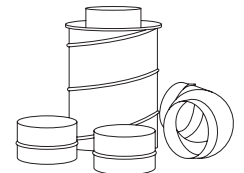
**LAMP KIT WITH  
ARC SENSOR  
(SF4200 FAN)**  
K1669-10

**WALL MOUNTING BRACKETS**

**ACCESSORIES**



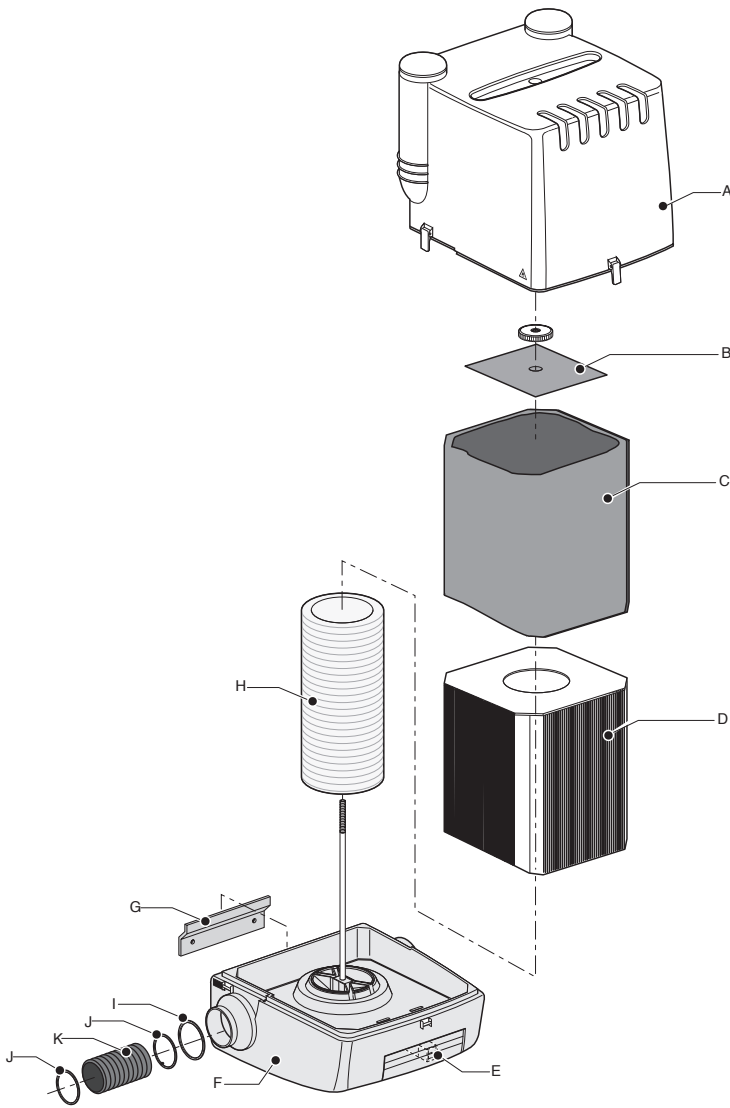
**FEEDER HANGER RAIL**  
for EC2 & EC4  
K1672-1



**AIR EXHAUST  
SILENCER**  
K1534-2



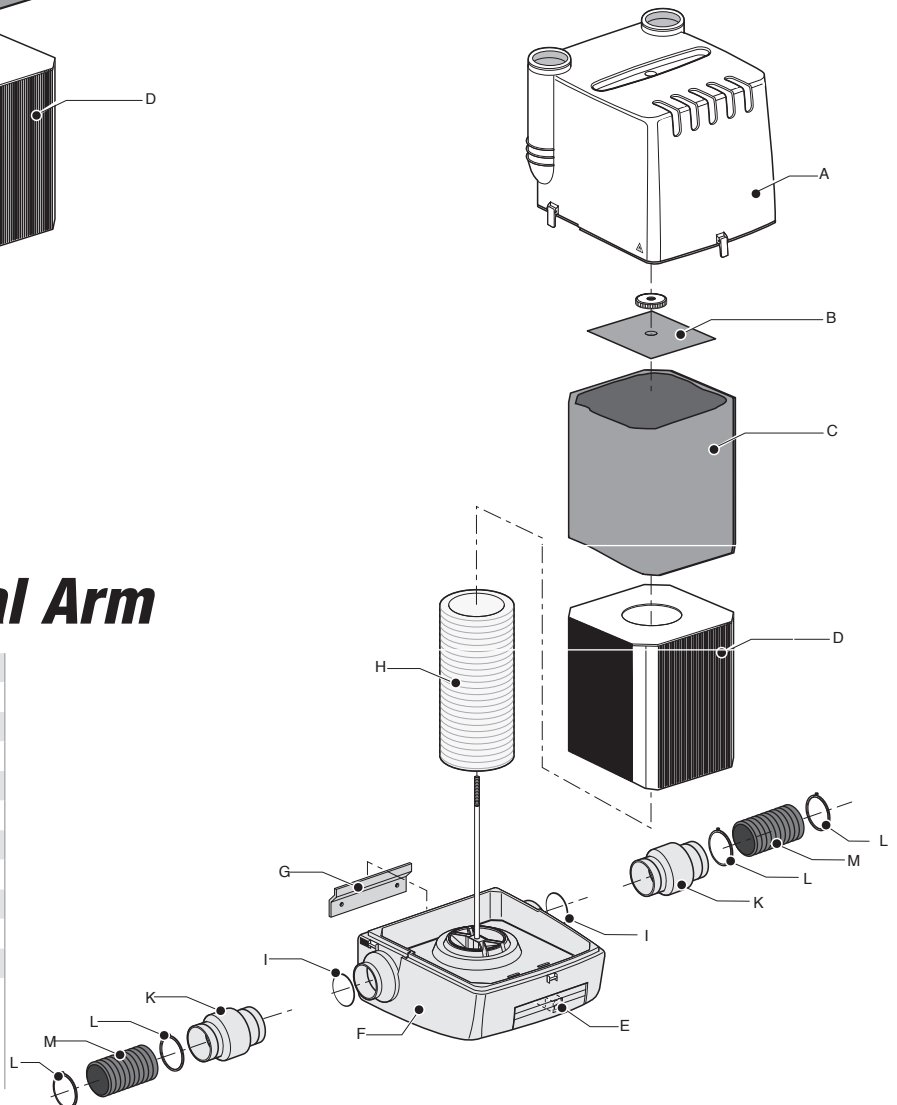
# Statiflex® 200-M Single Arm



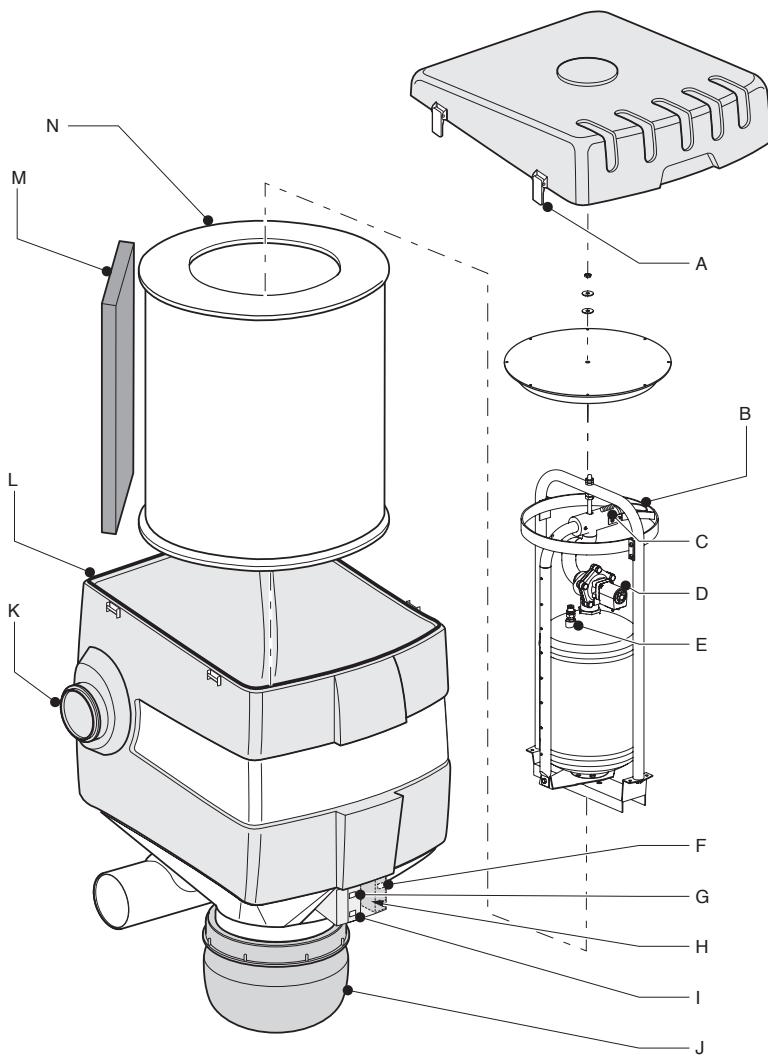
ITEM	DESCRIPTION	Part #	QTY	1	2
	<b>Statiflex 200-M</b>	<b>K1654-1</b>		X	-
	<b>Statiflex 200-M</b>	<b>K1654-3</b>		-	X
A	Filter Cover	<b>S23281-16</b>	1	X	X
B	Filter Cover Plate	<b>S23281-5</b>	1	X	X
C	(Optional) Activated Carbon Filter	<b>K1852-1</b>	1	X	X
D	Cellulose Filter	<b>K1673-1</b>	1	X	-
D	Cellulose/Polester Filter	<b>K1673-3</b>	1	-	X
E	Filter Maintenance Indicator	<b>S23281-11</b>	1	X	X
F	Bottom Housing	<b>S23281-17</b>	1	X	X
G	Mounting Bracket	<b>S23281-18</b>	1	X	X
H	Prefilter	<b>S23281-8</b>	1	X	X
I	6 in. Sealing Ring	<b>S23281-22</b>	1	X	X
K,J	Hose & Clamp Kit Includes two 6" Hose Clamp (J) & one 6" Connection Hose (K)	<b>S23268</b>	1		

# Statiflex® 200-M Dual Arm

ITEM	DESCRIPTION	Part #	QTY
A	Filter Cover	<b>S23281-16</b>	1
B	Filter Cover Plate	<b>S23281-5</b>	1
C	(Optional) Activated Carbon Filter	<b>K1852-1</b>	1
D	Cellulose Filter	<b>K1673-1</b>	1
E	Filter Maintenance Indicator	<b>S23281-11</b>	1
F	Bottom Housing	<b>S23281-17</b>	1
G	Mounting Bracket	<b>S23281-18</b>	1
H	Prefilter	<b>S23281-8</b>	1
I	6 in. Sealing Ring	<b>S23281-22</b>	1
K	6 in. Non-Return Valve	<b>K1743-2</b>	1
M, L	Hose & Clamp Kit Includes two 6" Hose Clamp (L) & one 6" Connection Hose (K)	<b>S23268</b>	2

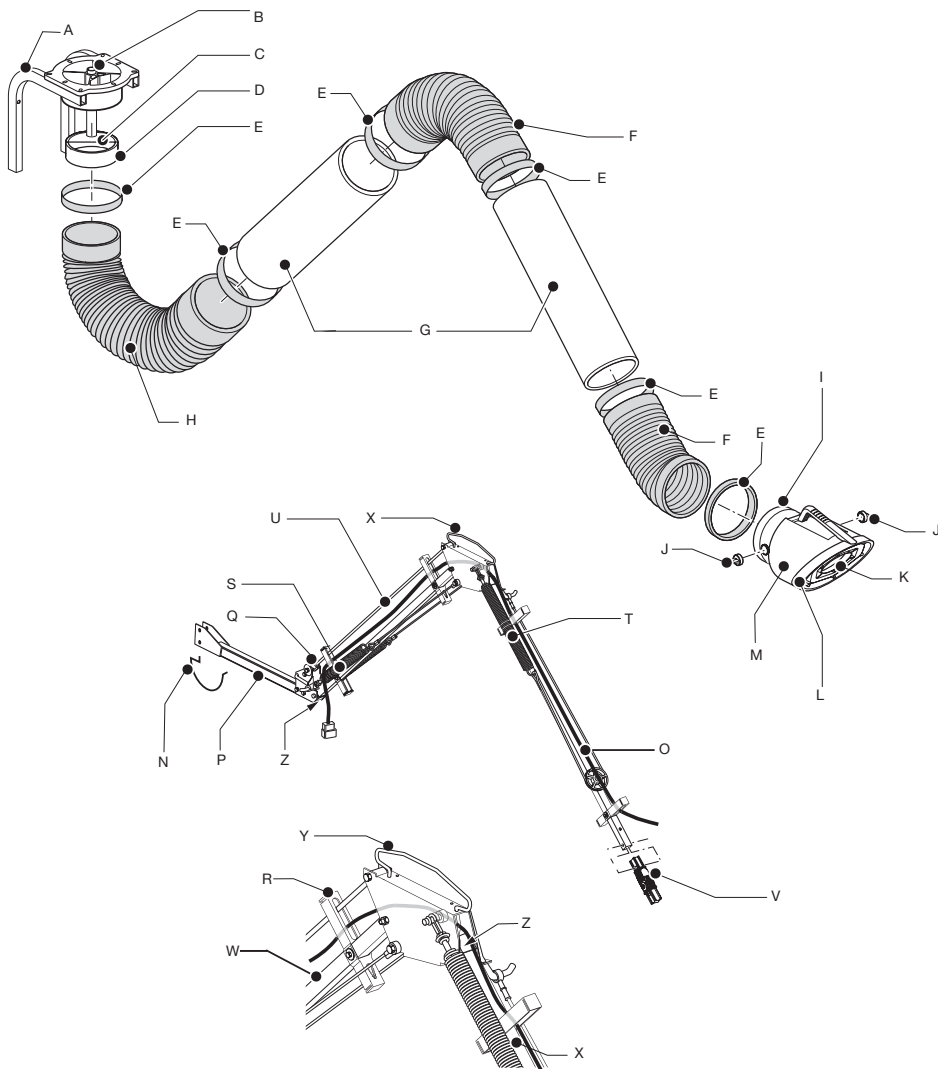


# Statiflex® 400-MS Base Unit



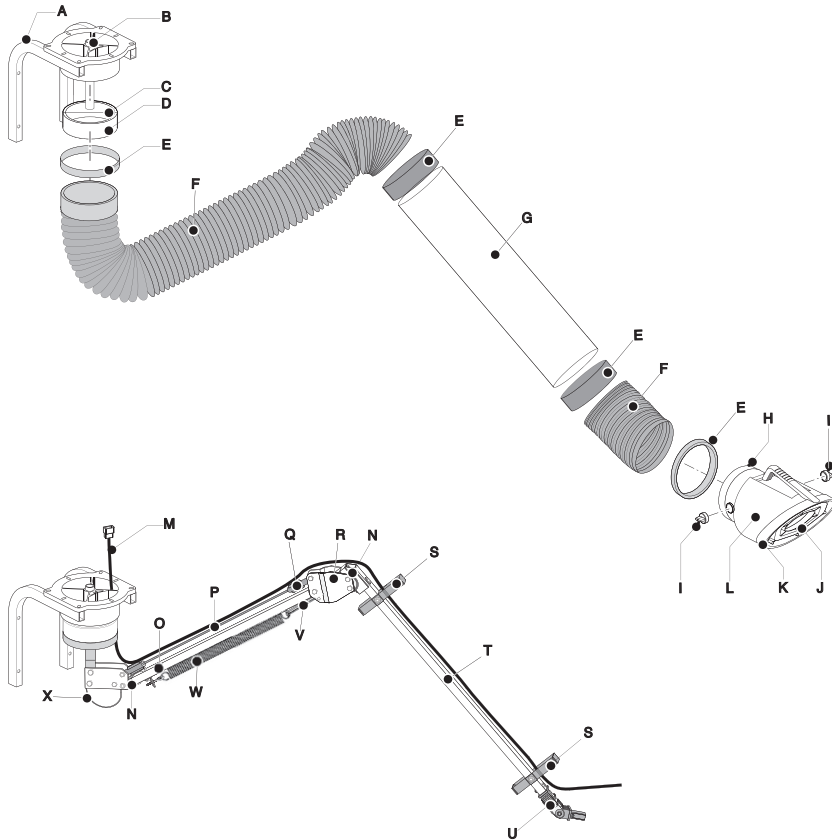
ITEM	DESCRIPTION	Part #	QTY	1	2
	<b>Statiflex 400-MS</b>	<b>K1742-1</b>		X	
	<b>Statiflex 400-MS</b>	<b>K1742-2</b>			X
A	Cover Lock	<b>S23281-60</b>	4	X	X
B	O Ring	<b>NA</b>	1	X	X
C	Piston Mechanism	<b>S23281-61</b>	1	X	X
D	Membrane Valve	<b>S23281-28</b>	1	X	X
E	Pressure Relief Valve 6-10 Bar (2400-4000 in. WG)	<b>S23281-63</b>	1	X	X
F	Pressure Difference Switch	<b>S23281-35</b>	1	X	X
G	Control Light 24 V, Yellow	<b>S23281-32</b>	1	X	X
H	Control PC Board	<b>S23281-34</b>	1	X	X
I	Reset/Start Button	<b>S23281-33</b>	1	X	X
J	Residue Collection Barrel	<b>S23281-38</b>	1	X	X
K	Inlet Sealing Ring	<b>S23281-22</b>	1	X	X
L	Rubber Sealing Filter Cover	<b>S23281-58</b>	1	X	X
M	Pre Filter	<b>S23281-24</b>	1	X	X
N	Cellulose Filter	<b>K1673-2</b>	1	X	X
N	Cellulose Filter/Polyester High Efficiency Filter	<b>K1673-4</b>	1	-	X
	ITEMS NOT SHOWN:			X	X
	Outlet Cover	<b>S23281-59</b>	1	X	X

# LFA 3.1/4.1



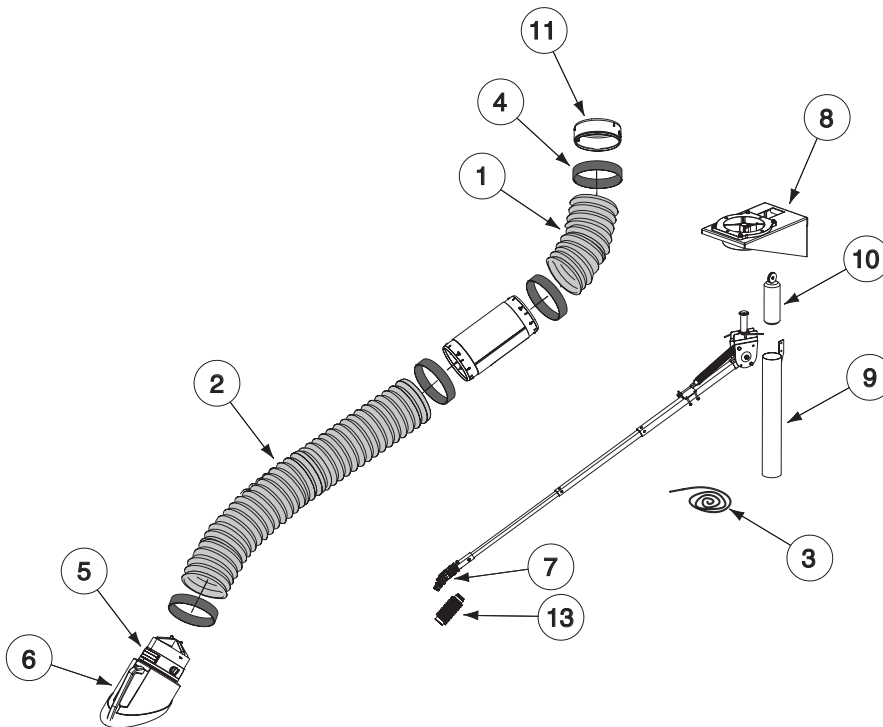
ITEM	DESCRIPTION	Part #	QTY
A	Wall Mounting Bracket	K1657-1	1
B	Base Swivel Mount	S23282-34	1
C	Clamping Pin	S23282-19	1
D	Red Plastic Ring	S23282-36	1
E	Rubber Seal 8 in.	S23282-1	6
F	Replacement Hose Section	S23282-12	2
G	Arm Section LFA 3.1	S23282-2	2
	Arm Section LFA 4.1	S23282-3	2
H	Replacement Hose Section 1150 mm (45 in.)	S23282-12	1
I	Throat Rotatable Hood	S23384-37	1
J	Rotary Knob Throttle Valve	S23282-4	2
K	Airflow Focus Vanes	S23282-33	1
L	Rotatable Hood Rim	S23282-40	1
M	Rotatable Hood	S23282-5	1
N	Spring Bracket	S23282-20	1
O	Connection Wire (wire only)	S23270-1	1
P	18 in. Arm Hanging Adapter Bar	S23282-22	1
Q	Tee Connection Rod	S23282-39	2
R	Tube Spacer	S23282-28	4
S	Spring Set Fan Side LFA 3.1	S23828-31	1
	Spring Set Fan Side LFA 4.1	S23282-32	1
T	Spring Set Hood Side LFA 3.1	S23282-29	1
	Spring Set Hood Side LFA 4.1	S23282-30	1
U	Rod LFA 3.1	S23282-37	1
	Rod LFA 4.1	S23282-38	1
V	Hood Hinge with Rubber Protection Cover	S23282-23	1
W	Steel Tube Fan Side LFA 3.1 Steel	S23282-26	1
	Tube Fan Side LFA 4.1	S23282-27	1
X	Aluminum Tube Hood Side LFA 3.1	S23282-24	1
	Aluminum Tube Hood Side LFA 4.1	S23282-25	1
Y	Hose Running Guard	S23282-35	1
Z	Plastic Friction Plug	S23282-6	2

# LFA 2.0 Stationary Extraction Arm



ITEM	DESCRIPTION	Part #	QTY
A	Wall Mounting Bracket Kit	K1657-2	1
B	Base Swivel Mount	S23282-34	1
C	Clamping Pin	S23282-19	1
D	Red Plastic Ring	S23282-36	1
E	Rubber Seal 8 in.	S23282-1	4
F	Hose Set	S23384-30	1
G	Arm Section 2.5 ft.	S23282-2	1
H	Throat Rotatable Hood	S23384-37	1
I	Rotary Knob Throttle Valve	S23282-4	2
J	Airflow Focus Vane	S23282-33	1
K	Rotatable Hood Rim	S23282-40	1
L	Rotatable Hood	S23282-5	1
M	Connection Wire (wire only)	S23270-1	1
N	Plastic Friction Plug	S23282-6	1
O	Inner Tube Fan Side	S23384-35	1
P	Threaded Rod	S23384-33	1
Q	Tee Connection Rod	S23282-39	1
R	Friction Clamp	S23384-39	1
S	Tube Spacer	S23282-28	2
T	Inner Tube Hood Side	S23384-34	1
U	Hood Hinge with Rubber	S23282-23	1
V	Spring Hook	S23384-32	1
W	Arm Spring Fan Side	S23384-31	1
X	Spring Bracket	S23282-20	1

# LTA 2.0-CW Telescopic Extraction Arm

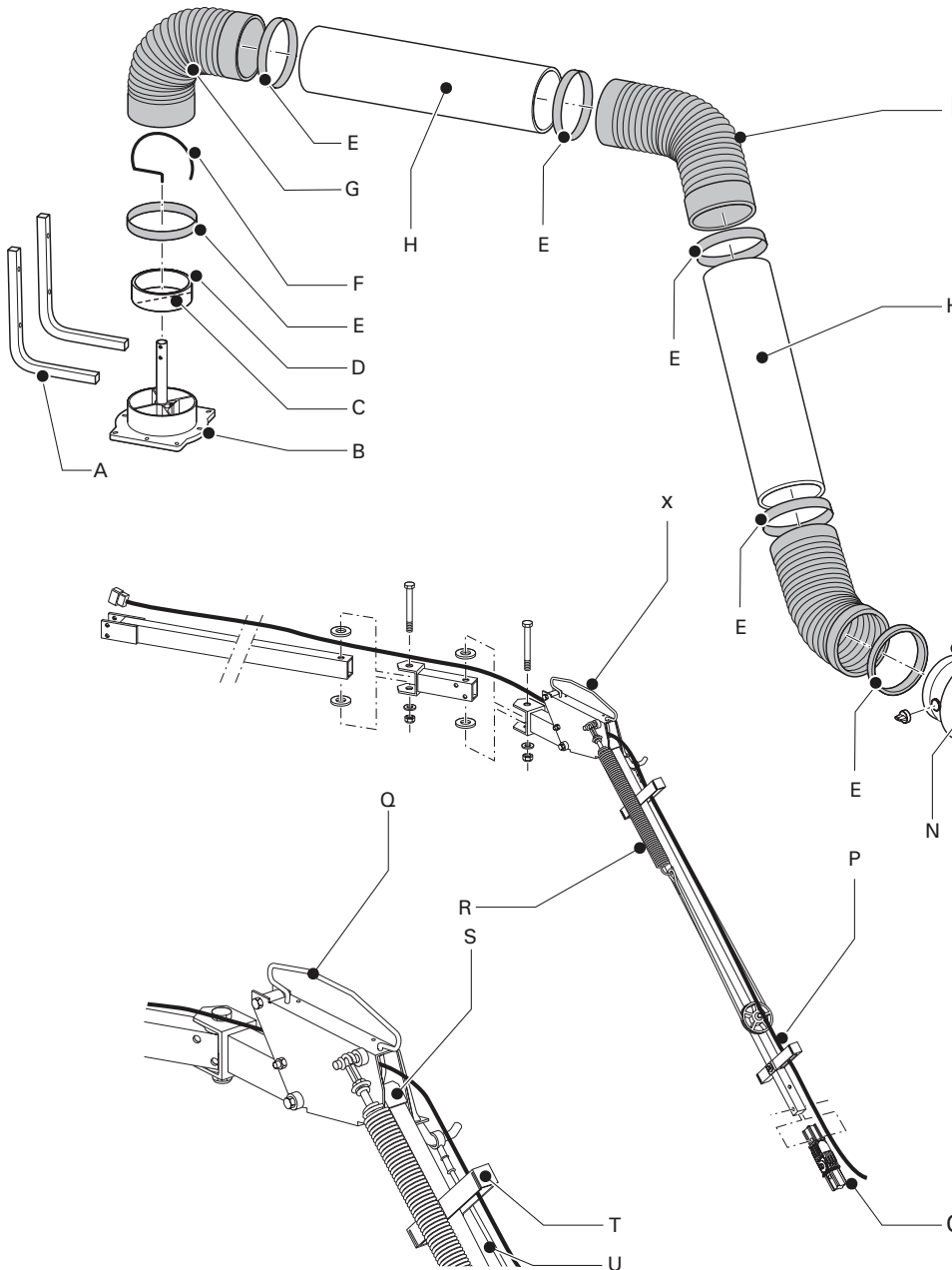


ITEM	DESCRIPTION	Part #	QTY
1	Flexible Hose, 20"	S23384-30	1
2	Flexible Hose, 65"	S23384-30	1
3	Polyester Rope 0.16, LTA CW	S23282-44	1
4	Rubber Seal 8"	S23282-1	4
5	Rotatable Hood, Complete	S23384-37	1
6	Rotatable Hood	S23282-5	1
7	Hinge Set Rotatable Hood w/Prot Cover	S23282-23	1
8	Wall Mounting Bracket	S23282-45	1
9	Counterweight Guide	S23282-47	1
10	Counterweight	S23282-46	1
11	Red Plastic Ring	S23282-36	1
12	Tube (not shown)	S23282-8	1
13	Rubber Protection Cover (Hood Hinge)	S23384-41	1

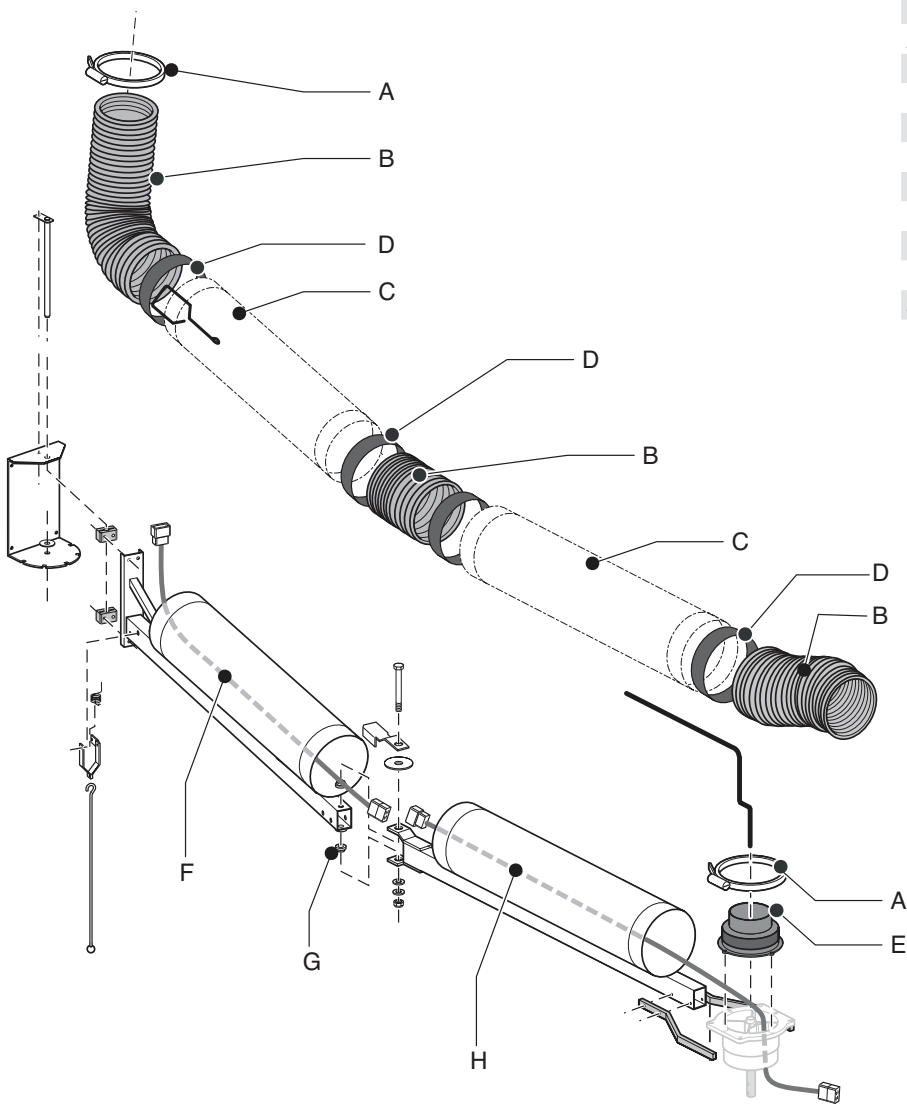


# LFA 4.1 Low Ceiling Extraction Arm

ITEM	DESCRIPTION	Part #	QTY
A	Wall Mounting Bracket	K1657-1	
B	Base Swivel Mount	S23282-34	1
C	Clamping Pin	S23282-19	1
D	Red Plastic Ring	S23282-36	1
E	Rubber Seal 8 in.	S23282-1	6
F	Spring Bracket	S23282-20	1
G	Replacement Hose Section	S23282-12	1
H	Arm Section LFA 4.1	S23282-3	2
I	Replacement Hose Section	S23282-12	2
J	Throat Rotatable Hood	S23384-37	1
K	Rotary Knob Throttle Valve	S23282-4	3
L	Airflow Focus Vanes	S23282-33	1
M	Rotatable Hood Rim	S23282-40	1
N	Rotatable Hood	S23282-5	1
O	Hood Hinge with Rubber	S23282-23	1
P	Connection Wire (wire only)	S23270-1	1
Q	Hose Running Guard	S23282-35	1
R	Spring Set Hood Side	S23282-30	1
S	Plastic Friction Plug	S23282-6	2
T	Tube Spacer	S23282-28	4
U	Aluminum Tube Hood Side	S23282-25	1



# EC 2/4 Extension Crane

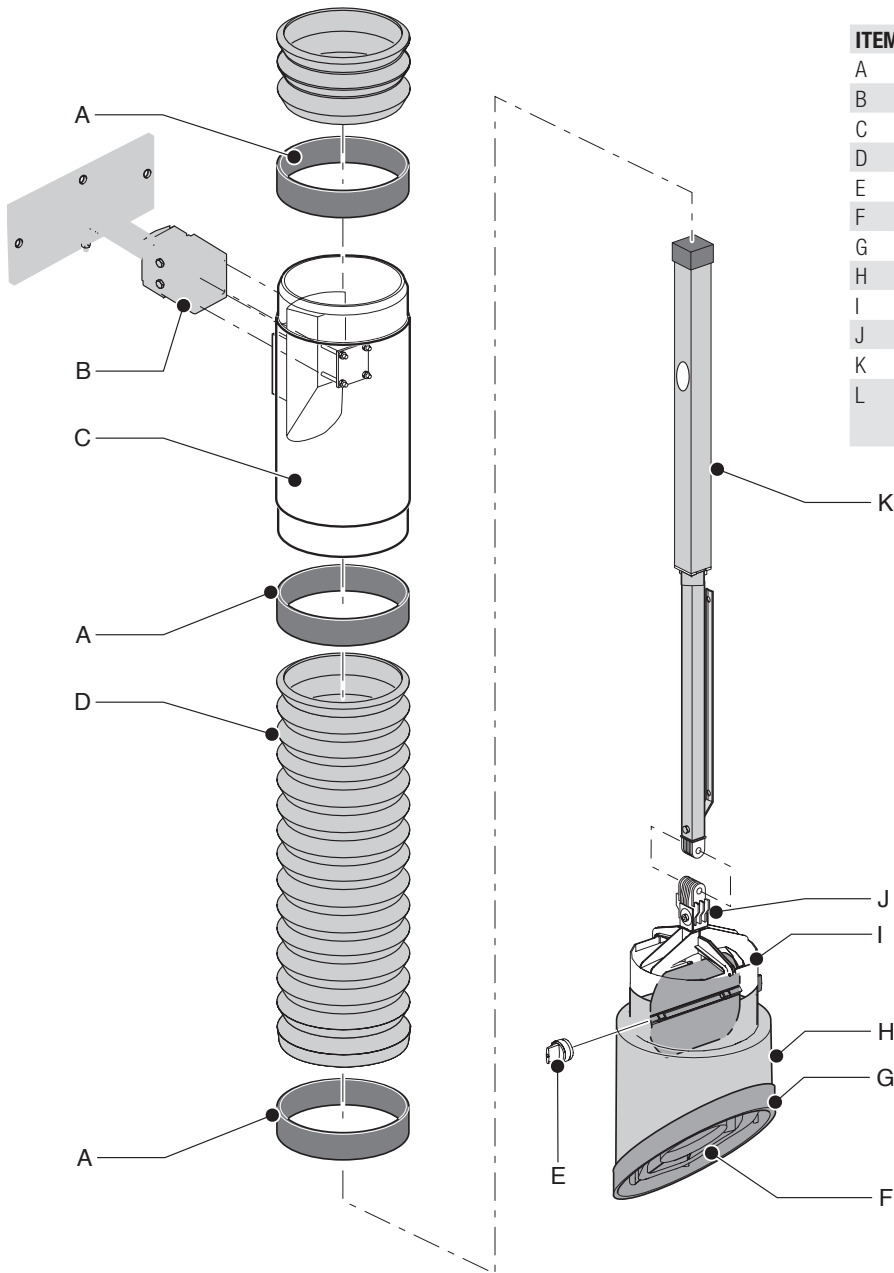


ITEM	DESCRIPTION	Part #	QTY
A	Hose Clamp	S23289	1
B	Hose Set (3 Pieces)	S23282-12	1
C	Plastic Tube	S23282-3	1
D	Rubber Seal 8 in.	S23282-1	1
E	Connection Flange	S23267	1
F	Connection Wire (wire only)	S23270-1	1
G	Slide Bearing	S23282-11	1
H	Connection Wire Extension Part	NA	1
I	Arm Mounting Bracket	S23282-41	2
J	Wall Mounting Bracket	K1657-2	1

(J) Wall Mounting Bracket if used  
w SF2400 Fan K1657-2

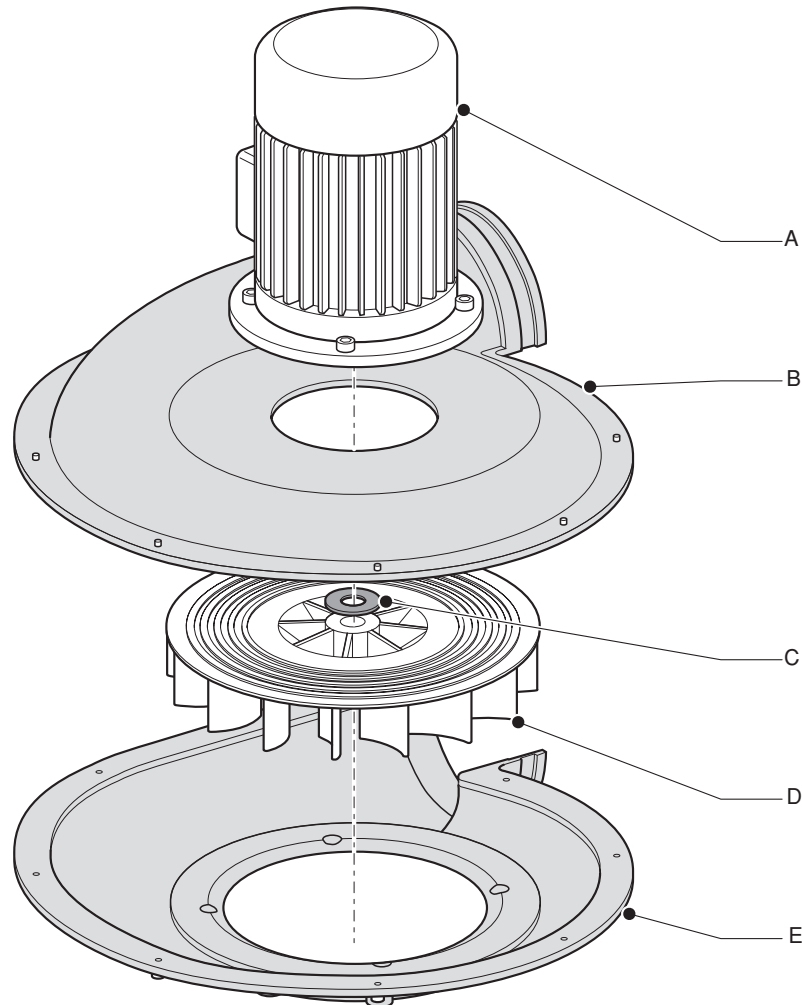
Recommended Fan is SF4200

# LTA 2.0 Telescopic Extraction Arm



ITEM	DESCRIPTION	Part #	QTY
A	Rubber Seal 8 in.	S23282-1	4
B	Rotating Hinge	S23282-7	1
C	Arm Section	S23282-8	1
D	Replacement Hose Section	S23282-12	2
E	Rotary Knob Throttle Valve	S23282-4	2
F	Airflow Focus Vane	S23282-33	1
G	Rotatable Hood Rim	S23282-40	1
H	Rotatable Hood	S23282-5	1
I	Throat Rotatable Hood	S23384-37	1
J	Hood Hinge Incl. Protection Cover	S23282-23	1
K	Telescopic Guide	S23282-9	1
L	Wall Mounting Bracket if used w/ SF2400 Fan (Not Shown)	K1657-2	1

# K1656-1 SF2400 Stationary Fan



ITEM	DESCRIPTION	Part #	QTY
A	Motor, 1hp, 120VAC, 60Hz, 11A	<b>S23281-14</b>	1
B	Fan Housing, Motor Side	<b>S23281-1</b>	1
C	Shim, 0.75x1.00x0.05 in.	<b>S23281-15</b>	1
D	Fan Wheel	<b>S23281-2</b>	1
E	Fan Housing, Blower Side	<b>S23281-19</b>	1
ITEMS NOT SHOWN	Sealing Ring	<b>S23281-22</b>	1



# Drive Rolls

## Wire Drive System Cross Reference

Solid wire use V-groove rolls

Cored wire use Knurled rolls

Aluminum wire use U-groove rolls

Hardfacing use V-knurled rolls

Use the table to locate the letter reference code for a particular Wire Feed Welder or Wire Feeder's drive system. Turn to the page with that letter code to identify replacement kits and parts that are available for that wire drive system. Pay special attention to the overall rating of the specific machine. Do not exceed the machine's ratings (wire, type, wire size, and welding amperage).

- **Do not exceed the wire sizes and types recommended for use with your welder.**
- **Do not exceed the welding output rating of your machine.**

\* Use the correct drive rolls: Because flux-cored wire is softer than solid wire, knurled drive rolls provide a good "bite" on the wire without compressing and deforming it — which could happen if standard drive rolls are used.

\* Check wire tension. Too much or too little tension on either the drive rolls or the wire spool hub can lead to poor wire feeding performance. Adjust according to your owner's manual.

\* Inspect consumables. Remove excess spatter from contact tips, replace worn contact tips and liners and discard the wire if it appears rusty.

### INDUSTRIAL WIRE FEEDERS

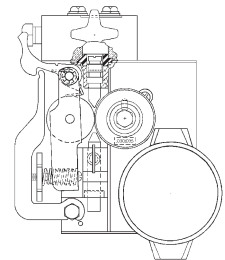
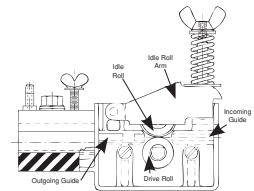
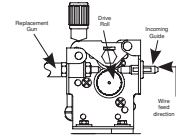
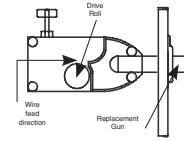
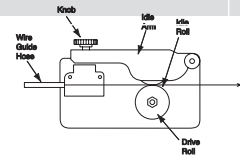
AutoDrive 4R90	J
Activ8™	K1
Cruiser (Tractor)	L
FlexFeed 74 HT (4 Roll)	K2
LF-72 (2 Roll)	K1
LF-74 (4 Roll)	K2
LN-10 (4 Roll)	J
LN-15	K1
LN-23P	E
LN-25	E
LN-25 PRO	K1
LN-25 PRO Dual Power	K1
LN-35	E
LN-7 (2 Roll)	E
LN-7 GMA (2 Roll)	E
LN-7 GMA (4 Roll)	I
LN-742 (2 Roll)	E
LN-742 (4 Roll)	I
LN-8 (2 Roll)	G
LN-9 (4 Roll)	E
LN-9 GMA (2 Roll)	G
LN-9 GMA (4 Roll)	I
LT-56	M
LT-7	M
MAXsa 22	L
MAXsa 29	L
NA-3	L
NA-4	L
NA-5	L
PF-10S	L
Power Feed 10 (4 Roll)	J
Power Feed 10M (4 Roll)	J
Power Feed 10R (4 Roll)	J
Power Feed 11 (4 Roll)	J
Power Feed 15M	K1
Power Feed 25M	K1
Power Wave C300	K1
Power Wave C350	K1
STT-10 (4 Roll)	J
SYNERGIC 7 (4 Roll)	I
POWER MIG 140C	N
POWER MIG 140T	N
POWER MIG 180C	N
POWER MIG 180T	N
POWER MIG 180 Dual	N
POWER MIG 200	K1
POWER MIG 215	K1
POWER MIG 215XT	K1
POWER MIG 216	K1
POWER MIG 255	K1
POWER MIG 255C	K1
POWER MIG 255XT	K1
POWER MIG 300	K1
POWER MIG 350MP	K1
SP-100-I	C
SP-100T	C
SP-130T	C
SP-135T	C
SP-140-I	C
SP-140T	P1
SP-150	E
SP-170	C
SP-170-I	C
SP-170T	C
SP-175T	C
SP-180T	P1
SP-200	E
SP-250 & SP-255	F
Wire-Matic 250 & 255	F

### RETAIL WIRE FEED WELDERS

Core Pak 125 (Code 11550)	P1
Core Pak 125 (Code 11639)	P2
Easy-Core 125 (Code 11503)	P1
Easy-Core 125 (Code 11633)	P2
Easy-MIG 140 (Code 11504)	P1
Easy-MIG 140 (Code 11637)	P2
Easy-MIG 180	P1
Handy Core	B1
Handy Core 100 (Arcweld Brand)	A
Handy MIG	B2
Handy MIG 101 (Arcweld Brand)	A
Handymig 170i	C
MIG Pak 10	C
MIG Pak 15	C
MIG Pak 140 (Code 11440)	P1
MIG Pak 140 (Code 11636)	P2
MIG Pak 180	P1
MIG Pak HD	B1
Pro 100	C
Pro 155	C
Pro-Core 100	C
Pro Core 125 (Code 11300)	P1
Pro Core 125 (Code 11631)	P2
Pro-MIG 135	C
Pro-MIG 140 (Code 11288 Only)	C
Pro-MIG 140 (Code 11173)	P1
Pro MIG 140 (Code 11634)	P2
Pro-MIG 175	C
Pro-MIG 180	P1
Quick Weld	B1
Weld-Pak 100	C
Weld-Pak 100HD	C
Weld-Pak 125	C
Weld-Pak 125HD (Code 11302)	P1
Weld-Pak 125HD (Code 11632)	P2
Weld-Pak 140HD (Code 11303)	P1
Weld-Pak 140HD (Code 11635)	P2
Weld-Pak 155	C
Weld-Pak 180HD	P1
Weld-Pak 3200HD	C
Weld-Pak 5000HD	C
Weld-Pak HD	B1
Work Pak 125 (Code 11506)	P1
Work Pak 125 (Code 11638)	P2

# Drive Rolls

Wire Size	Type	Drive Roll(s)	Idle Arm	Idle Roll	Incoming Guide Tube	Outgoing Guide Tube
<b>A - Handy Core 100 (Arcweld Brand), Handy MIG 101 (Arcweld Brand)</b>						
.023-.025"	Groove 1: .023-.025" Wire Groove 2: .030-.035" Wire	S24355-14	S24355-7	S24355-6	-	
<b>B1 - Handy Core, MIG Pak HD, Quick Weld, Weld-Pak HD</b>						
.035" Cored Wire	Groove 1: .035" Knurled Groove 2: .035" Knurled	KP2243-035	-	-	-	
<b>B2 - Handy MIG</b>						
.023-.030" Solid .035" Cored Wire	.023-.030" Solid .035" Cored Wire	KP2200-1	-	-	KP2201-1*	
<b>C - SP-100-I, SP-100T, SP-130T, SP-135T, SP-140-I, SP-170, SP-170-I, SP-170T, SP-175T, Handymig 170i, MIG Pak 10, MIG Pak 15, Pro 100, Pro 155, Pro-Core 100, Pro-MIG 135, Pro-MIG 140 (Code 11288 Only), Pro-MIG 175, Weld-Pak 100, Weld-Pak 100HD, Weld-Pak 125, Weld-Pak 155, Weld-Pak 3200HD, Weld-Pak 5000HD</b>						
.023-.030" Solid .035" Cored	Groove 1: .023-.025" Smooth Groove 2: .030-.035" Knurled	KP1884-1	L7562	M9300-55	KP2009-10	
.023-.030" Solid .035" Cored	Groove 1: .023-.025" Smooth Groove 2: .030-.035" Smooth	KP665-035				
.035"-.045" Cored	Groove 1: .035-.045" Knurled Groove 2: .035-.045" Knurled	KP665-045C <sup>(1)</sup>				
.035" Aluminum	Groove 1: .035" U Groove Groove 2: .035" U Groove	M19631 <sup>(2)</sup>				



## E - LN-23P, LN-25, LN-35, LN-7 (2 Roll), LN-7 GMA (2 Roll), LN-742 (2 Roll), LN-9 GMA (2 Roll), SP-150, SP-200

### KP653 DRIVE ROLL KITS\*

Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide	Outgoing Guide Insert
.023-.025"	V-groove	KP653-025S	KP2139-1	KP2125-1	KP2124-1
.030"	V-groove	KP653-030S	KP2139-1	KP2125-1	KP2124-1
.035"	Knurled	KP653-035C	KP2139-3	KP2125-1	KP2124-1
.035"	V-groove	KP653-035S	KP2139-3	KP2125-1	KP2124-1
.045-.052"	Knurled	KP653-052C	KP2139-3	KP1999-1	KP2124-3
.045-.052"	V-groove	KP653-052S	KP2139-3	KP1999-1	KP2124-3
1/16"	Knurled & V-groove	KP653-1/16	KP2139-5	KP2125-3	KP2124-5
.068-3/32"	Knurled	KP653-3/32	KP2139-8	KP2125-5	KP2124-8
7/64"	Hardfacing	KP653-7/64H	KP2139-8	KP2125-4	KP2124-7
0.12	Knurled	KP653-120C	KP2139-7	KP2125-4	KP2124-7

### KP1682 CLUTCHED DRIVE ROLL KITS\*

Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide	
.035"	Aluminum	KP1682-035A	KP2132-2	KP2137-1	Clutch Bolt: S24474
3/64"	Aluminum	KP1682-3/64A	KP2132-2	KP2137-3	Latch: S24299
1/16"	Aluminum	KP1682-1/16A	S21273-1/16	KP2137-2	Torsion Spring: S24300
1.0 m	Aluminum	KP1682-1.0A	KP2132-2	KP2137-3	

### KP654 DRIVE ROLL KITS\*

Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide	Outgoing Guide Insert
.035"	Aluminum	KP654-035A	KP2139-1	KP2125-1	KP2124-1
3/64"	Aluminum	KP654-3/64A	KP2139-3	KP1999-1	KP2124-1
1/16"	Aluminum	KP654-1/16A	KP2139-5	KP2125-3	KP2124-5

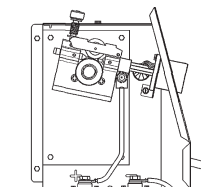
\*U-Groove drive rolls \*\* These kits are to be discontinued. Kits and parts will be available until stock is depleted.  
 Note: All Clutched drive roll kits include many other parts that may be available for sale individually. They also include parts for 4 roll drive systems. See IM638 for details.

## F - SP-250, SP-255, Wire-Matic 250 & 255

### KP674 DRIVE ROLL KITS

Wire Size	Type	Qty Inc	Drive Roll Kit #	Incoming Guide	Outgoing Guide
.025"-.035"	Solid	1	KP674-035S	KP2139-3	KP2053-2 <sup>(1)**</sup> M15812-3 <sup>(2)</sup>
.035"	Cored	2	KP674-035C*	KP2139-3	KP2053-2 <sup>(1)**</sup> M15812-3 <sup>(2)</sup>
.045"	Solid	1	KP674-045S	KP2139-3	KP2053-2 <sup>(1)**</sup> M15812-3 <sup>(2)</sup>
.045"	Cored	2	KP674-045C*	KP2139-3	KP2053-2 <sup>(1)**</sup> M15812-3 <sup>(2)</sup>
3/64"	Aluminum	1	KP674-3/64A	KP2139-3	KP2053-2 <sup>(1)**</sup> M15812-3 <sup>(2)</sup>

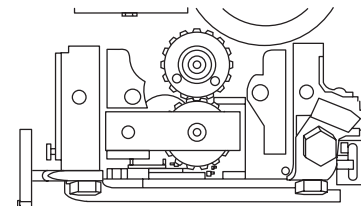
\*Split drive roll design  
 (1) Use for Wirematic 250/255 or SP255-I  
 (2) Use for SP250, SP250-I or SP255  
 \*\* Discontinued. Available until stock is depleted.



# Drive Rolls

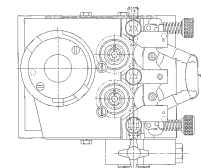
## G - LN-8 (2 Roll), LN-9 (2 Roll), NA-R (2 Roll),

Wire Size	Type	Drive Roll Kit #	Idle Roll Assembly	Incoming Guide Tube	Outgoing Guide Tube	Outgoing Guide Insert
.030-.035"	Solid	<b>KP502-035</b>	S12722-035	KP2123-1	KP2117-1	KP2118-1
.045-.052"	Solid	<b>KP502-052</b>	S12722-052	KP2123-2	KP2117-2	KP2118-2
.045-.052"	Cored	<b>KP502-052C</b>	S12722-052	KP2123-2	KP2117-2	KP2118-2
1/16"	Solid	<b>KP502-1/16</b>	S12722-1/16	KP2123-3	KP2117-3	KP2118-3
1/16"	Cored	<b>KP502-1/16C</b>	S12722-1/16	KP2123-3	KP2117-3	KP2118-3
.068-3/32"	Cored	<b>KP502-3/32</b>	S12722-3/32	KP2123-5	KP2119-2	KP2120-2
7/64-.120"	Cored	<b>KP502-120</b>	S12722-120	2123-4	KP2119-1	KP2120-1
7/64"	Hardfacing	<b>KP502-7/64H</b>	S12722-7/64H	KP2123-4	KP2119-1	KP2120-1



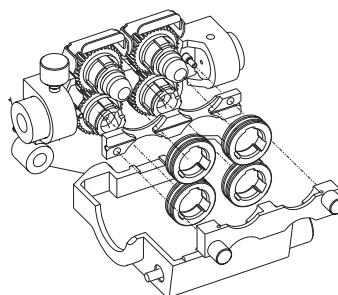
## I - LN-7 GMA (4 Roll), LN-742 (4 Roll), LN-9 GMA (4 Roll), SYNERGIC 7 (4 Roll)

Wire Size	Type	Drive Roll Kit #	Idle Roll Assembly	Incoming Guide Tube	Outgoing Guide Tube	Outgoing Guide Insert
.035 - .040"	Solid	<b>KP655-035S</b>	KP2139-4	KP2114-1	KP2125-1	KP2124-1 & -2
.045 - .052"	Cored	<b>KP655-052C</b>	KP2139-4	KP2114-2	KP1999-1	KP2124-3 & -4
.045 - .052"	Solid	<b>KP655-052S</b>	KP2139-4	KP2114-2	KP1999-1	KP2124-3 & -4
1/16"	Solid/Cored	<b>KP655-1/16</b>	KP2139-6	KP2114-3	KP2125-3	KP2124-5 & -6
.068 - 3/32"	Cored	<b>KP655-3/32</b>	KP2139-9	KP2114-5	KP2125-5	KP2124-8
7/64 - .120"	Cored	<b>KP655-120C*</b>	T13467-120F	KP2114-4	KP2125-4	KP2124-7



## J AutoDrive 4R90, LN-10 (4 Roll), Power Feed 10 (4 Roll), Power Feed 10M (4 Roll), Power Feed 10R (4 Roll), Power Feed 11 (4 Roll), STT-10 (4 Roll)

Wire Size	Type	Drive Roll Kit #
.023 - .030"	Solid	<b>KP1505-030S</b>
.035"	Solid	<b>KP1505-035S</b>
.030 - .035"	Cored	<b>KP1505-035C</b>
.040	Solid	<b>KP1505-.040S</b>
.040 - .045"	Solid	<b>KP1505-045S</b>
.040 - .045"	Cored	<b>KP1505-045C</b>
.052"	Solid	<b>KP1505-052S</b>
.052"	Cored	<b>KP1505-052C</b>
1/16"	Solid	<b>KP1505-1/16S</b>
1/16"	Cored	<b>KP1505-1/16C</b>
.068 - .072"	Cored	<b>KP1505-068</b>
5/64"	Cored or Solid	<b>KP1505-5/64</b>
3/32"	Cored or Solid	<b>KP1505-3/32</b>
7/64"	Cored or Solid	<b>KP1505-7/64</b>
7/64"	Hardfacing wire	<b>KP1505-7/64H</b>
.120	Cored or Solid	<b>KP1505-120</b>



KP1505 drive roll kits include four drive rolls and one inner wire guide.

### KP1507 DRIVE ROLL KITS

Wire Size	Type	Drive Roll Kit #	Inner Wire Guide	Outer Wire Guide	Conduit Bushing
.035"	Aluminum	<b>KP1507-035A</b>	M18796-1	KP2071-2	S23750-1
.040"	Aluminum	<b>KP1507-040A</b>	M18796-1	KP2071-2	S23750-1
3/64"	Aluminum	<b>KP1507-3/64A</b>	M18796-2	KP2071-2	S23750-1
1/16"	Aluminum	<b>KP1507-1/16A</b>	M18796-3	KP2071-2	S23750-1
3/32"	Aluminum	<b>KP1507-3/32A</b>	M18796-4	KP2071-2	S23750-2

#### ADDITIONAL PARTS COMMON TO ALL KP1507 ALUMINUM DRIVE ROLL KITS

Pressure Spring	T11862-57	Thrust Washer	T14043
Knurled Knob Assembly	S22933	1/8" Socket	T11563-2
Flex Tube	T10642-226	7/64" Socket	T11563-6
		5/32" Socket	T11563-5

# Drive Rolls

**K1 - Activ8, LF-72 (2 Roll), LN-15, LN-25 PRO, LN-25 PRO Dual Power, Power Feed 15M, Power Feed 25M, Power Wave C300, Power Wave C350, POWER MIG 200, POWER MIG 215, POWER MIG 215XT, POWER MIG 216, POWER MIG 255, POWER MIG 255C, POWER MIG 255XT, POWER MIG 300, POWER MIG 350MP**

**KP1696 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #
.023-.030	Solid	KP1696-030S
.035	Solid	KP1696-035S
.035 / .045	Solid	KP1696-1
.040	Solid	KP1696-2
1/16	Solid	KP1696-1/16S
.045	Solid	KP1696-045S
.052	Solid	KP1696-052S

KP1696 drive roll kits include two drive rolls and one inner wire guide.

**KP1697 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #
.035"	Cored	KP1697-035C
.045"	Cored	KP1697-045C
.052"	Cored	KP1697-052C
1/16"	Cored	KP1697-1/16C
.068"	Cored	KP1697-068
5/64"	Cored	KP1697-5/64
3/32"	Cored	KP1697-3/32

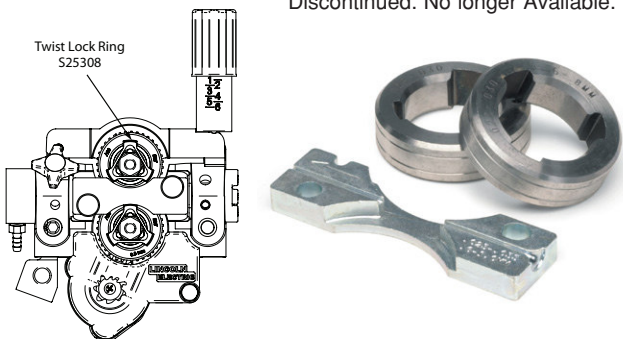
KP1697 drive roll kits include two drive rolls and one inner wire guide. NOT INCLUDED WITH KIT Outer Guide KP2071-3

**KP1697 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #	Outer Guide	Inner Guide
.035"	Aluminum*	KP1695-035A	KP2071-4	KP2173-1
.040"	Aluminum	KP1695-040A	KP2071-4	KP2173-2
3/64"	Aluminum	KP1695-3/64A	KP2071-4	KP2173-2
1/16"	Aluminum	KP1695-1/16A	KP2071-4	KP2173-3**
3/32"	Aluminum	KP1695-3/32A	KP2071-4	KP2173-4

\*.035 Aluminum recommended for Push Pull systems only.

\*\* Discontinued. No longer Available.



**K2 - FlexFeed 74 HT (4 Roll), LF-74 (4 Roll)**

**Stainless Steel**

**KP1505 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #
.023-.030"	Solid	KP1505-030S
.035"	Solid	KP1505-035S
.040"	Solid	KP1505-040S
1/16"	Solid	KP1505-1/16S
.040 / .045"	Solid	KP1505-045S
.052"	Solid	KP1505-052S

KP1505 drive roll kits include four drive rolls and one inner wire guide.

**Cored Drive Roll**

**KP1505 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #
.030 / .035"	Cored	KP1505-035C
.040 / .045"	Cored	KP1505-045C
.052"	Cored	KP1505-052C
1/16"	Cored	KP1505-1/16C

KP1505 drive roll kits include four drive rolls and one inner wire guide. NOT INCLUDED WITH KIT Outer Guide KP2071-1

**Solid Steel or Cored Drive Roll**

**KP1505 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #
.068 / .072"	Cored/Solid	KP1505-068
5/64"	Cored/Solid	KP1505-5/64
3/32"	Cored/Solid	KP1505-3/32
7/64"	Cored/Solid	KP1505-7/64
7/64"	Hardfacing	KP1505-7/64H

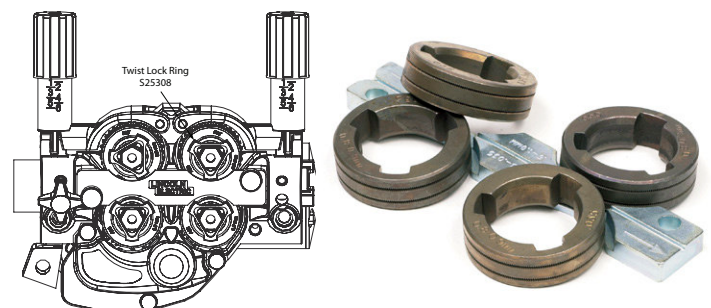
KP1505 drive roll kits include four drive rolls and one inner wire guide. NOT INCLUDED WITH KIT Outer Guide KP2071-1

**Aluminum**

**KP1507 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #	Inner Wire Guide	Outer Wire Guide	Conduit Bushing
.035"	Aluminum*	KP1507-035A	M18796-1	KP2071-2	S23750-1
.040"	Aluminum	KP1507-040A	M18796-1	KP2071-2	S23750-1
3/64"	Aluminum	KP1507-3/64A	M18796-2	KP2071-2	S23750-1
1/16"	Aluminum	KP1507-1/16A	M18796-3	KP2071-2	S23750-1
3/32"	Aluminum	KP1507-3/32A	M18796-4	KP2071-2	S23750-2

\*.035 Aluminum recommended for Push Pull systems only.





# Drive Rolls

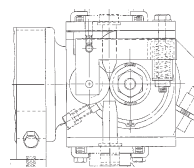
**L - Cruiser (Tractor), MAXsa 22, MAXsa 29, NA-3, NA-4, NA-5, PF-10S, LT-56, LT-7**

**KP1899 DRIVE ROLL KITS**

Wire Size	Type	Drive Roll Kit #	No. Required	Incoming Guide	Outgoing Guide
3/32-7/32"	Wires	KP1899-1	2	KP2116-2	KP1963-1
1/16-3/32"	Wires	KP1899-2	2	KP2116-1	KP2097-2
.035-.052"	Solid Wire	KP1899-3	1	KP1967-1	KP2097-1
.045-.052"	Cored Wire	KP1899-4	2	KP1967-1	KP2097-1

KP1505 drive roll kits include four drive rolls and one inner wire guide.

Note: Tiny Twin drive rolls are on page 55



**M - Cruiser (Tractor), MAXsa 22, MAXsa 29, NA-3, NA-4, NA-5, PF-10S, LT-56, LT-7**

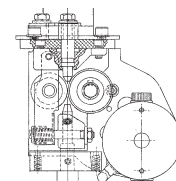
**Parts Sold Individually**

Wire Size	Type	Drive Roll Kit #	Qty Included	Qty Required	Incoming Guide	Outgoing Tube	Idle Roll Assembly
.052 -1/16"	Solid & Cored	KP2268-1	1	2	KP1984-1	KP1985-2**	
.068 -3/32"	Solid & Cored	KP2268-2	1	2	KP1984-1	KP1985-2**	S16666-1
3/32 -3/16"	Solid & Cored	KP2268-3	1	2	KP1984-1	KP1985-1	
.045"- .052"	Solid & Cored	KP2268-4	1	2	KP1984-1	KP1985-2**	

\*These Drive Rolls are a split, knurled design. Each Drive Roll KP# includes one drive roll - two drive rolls are required per assembly.

\*\* Discontinued

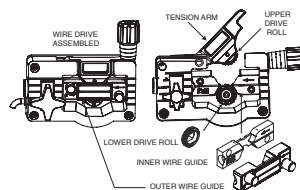
Note: Tiny Twin drive rolls for LT-7 K277-1 are on page 55



**N - POWER MIG 140C, POWER MIG 140T, POWER MIG 180C, POWER MIG 180T, POWER MIG 180 Dual**

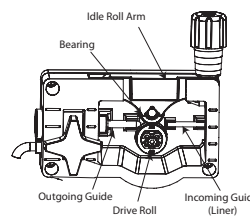
Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide
.025"/.030"	Solid	KP2529-1	KP2531-1	S26899
.035"	Solid	KP2529-2	KP2531-1	S26899
.030"/.045"	Cored	KP2529-3	KP2531-2	S26899

Wire Guide Knob included as part of S26899 Outer Wire guide.



**P1 - SP-140T, SP-180T, Core Pak 125 (Code 11550), Easy-Core 125 (Code 11503), Easy-MIG 140 (Code 11504), Easy-MIG 180, MIG Pak 140 (Code 11440), MIG Pak 180, Pro Core 125 (Code 11300), Pro-MIG 140 (Code 11173), Pro-MIG 180, Weld-Pak 125HD (Code 11302), Weld-Pak 140HD (Code 11303), Weld-Pak 180HD, Work Pak 125 (Code 11506)**

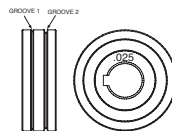
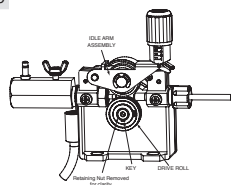
Wire Size	Type	Drive Roll Kit #	Incoming/Outgoing Guide Kit
.025"/.030"	Solid	KP2529-1	KP2530-1
.035"	Solid	KP2529-2	KP2530-1
.030"/.045"	Cored	KP2529-3	KP2530-1



**P2 - Core Pak 125 (Code 11639), Easy-Core 125 (Code 11633), Easy-MIG 140 (Code 11637), MIG Pak 140 (Code 11636), Pro Core 125 (Code 11631), Pro MIG 140 (Code 11634), Weld-Pak 125HD (Code 11632), Weld-Pak 140HD (Code 11635), Work Pak 125 (Code 11638)**

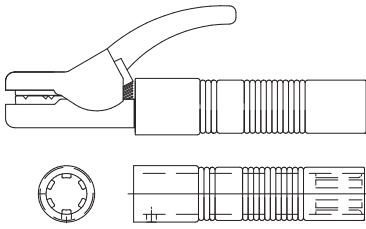
Wire Size	Type	Drive Roll Kit #
.025"	Solid	KP2948-1*
.030"- .035"	Solid	KP2948-1*
.030"- .035"	Cored	KP2948-1*

\* Key included with kit.



# Electrode Holders / Work Clamps

## ELECTRODE HOLDERS

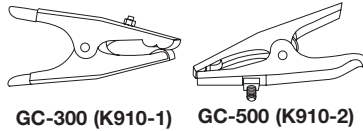


Product Number	Product Name	Description	Rating	Electrode Range
K909-7	EH-305HD (Magnum®)	Heavy duty	300 Amps @ 60% Duty Cycle 400 Amps @ 35% Duty Cycle	5/64 - 3/16" (2.0 - 4.8 mm)
K909-8	EH-405HD (Magnum®)	Heavy duty	400 Amps @ 60% Duty Cycle 500 Amps @ 35% Duty Cycle	1/8 - 5/16" (3.2 - 7.9 mm)
K909-6 <sup>(1)</sup>	T300	Medium duty	300 Amps @ 60% Duty Cycle	5/32" (4.0 mm) and smaller

<sup>(1)</sup> The T300 electrode holder was designed with no jaw insulation for pipe welders who require balance, light weight and cool operation. Its use may not meet OSHA standards.

## WORK CLAMPS

Product Number	Product Name	Rating
K910-1	GC-300	300 amps @ 60% Duty Cycle
K910-2	GC-500	500 amps @ 60% Duty Cycle



### K704 Accessory Kit, 400 Amp

For stick welding. Includes 35 ft. (10.7 m) #2/0 electrode cable with lug, 30 ft. (9.1 m) #2/0 work cable with lugs, headshield, filter plate, work clamp and electrode holder.



### K875 Accessory Kit, 150 Amp

For stick welding. Includes 20 ft. (6.1 m) #6 electrode cable with lug, 15 ft. (4.6 m) #6 work cable with lugs, headshield, filter plate, work clamp and electrode holder.

### K2150-1 Work Clamp and Cable Assembly

15 ft. 2/0 cable with 1/2 inch (12.7 mm) stud lug and work clamp.



### K2374-1 Stick Electrode Holder and Cable

Includes 12.5 ft. (3.8 m) electrode cable with Twist Mate™ connectors.



### K2394-1 Stick Electrode Holder, Work Clamp, Cable & Twist Mate™ Set

Includes 200 amp stick holder, welding cable, work cable, work clamp and Twist Mate™ connections.



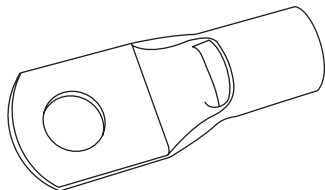
### K1803-1 Work and Wire Feeder 2/0 Weld Cable Package

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.



### K1803-2 Work and Wire Feeder 2/0 Weld Package

Includes Tweco®-style Cam-Lock connectors, work clamps, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.



## CABLE LUGS

Product Number	Cable Size (mm <sup>2</sup> )
S1119-6	4(21)
S1119-6	3(27)
S1119-6	2(34)
S1119-14	1(42)
S1119-14	1/0(53)
S1119-14	2/0(67)
S1119-1	3/0(85)
S1119-1	4/0(107)

### K2946-1 Tweco® Style Cam-Lock Adapter Plug for Work and Electrode Cables

Cable plug for 2/0 (50 mm<sup>2</sup>) cable.







### K2176-1 Twist Mate™ to Lug Adapter





For connection of lugged cable to Twist Mate™ connectors, 18 inch (457 mm) long.



**Control Cables and Adapters**

	Product Number	Description	Connection	Use	Length ft. (m)
	K1501-10	Wire Feeder Control Cable	Male 14-pin to Female 9-pin	LN-10, DH-10	10 (3.1)
	K1818-10	Wire Feeder Control Cable	Female 6-pin to Male 14-pin	LN-7	10 (3.1)
	K1819-10	Wire Feeder Control Cable	Female 8-pin to Male 14-pin	LN-742, LN-25	10 (3.1)
	K1820-10	Wire Feeder Control Cable	Female 9-pin to Male 14-pin	LN-8, LN-9, NA-3, NA-4, NA-5	10 (3.1)
	K1822-25	Wire Feeder Control Cable	—	LT-7	25 (7.6)
	K2393-1	Wire Feeder Control Cable	Male 14-pin to Female 8-pin	LN-23P (K316L-2)	25 (7.6)
	K2393-2	Wire Feeder Control Cable	Male 14-pin to Female 8-pin	LN-23P (K316L-2)	75 (22.8)
	K1797-10	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder.	10 (3.1)
	K1797-25	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		25 (7.6)
	K1797-50	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		75 (22.8)
	K1797-100	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		100 (30.4)
K1798	Adapter Cable for Control Cable to Terminal Strip of Power Source	Female 14-pin control cable to terminal strip			
	K1543-8	ArcLink®/Linc-Net™ Control Cable		For Power Wave®/Power Feed® Systems	8 (2.4)
	K1543-16	ArcLink®/Linc-Net™ Control Cable			16 (4.9)
	K1543-25	ArcLink®/Linc-Net™ Control Cable			25 (7.6)
	K1543-50	ArcLink®/Linc-Net™ Control Cable			50 (15.2)
	K1543-100	ArcLink®/Linc-Net™ Control Cable		100 (30.4)	
	K2683-25	Heavy Duty ArcLink®/Linc-Net™ Control Cable		For Power Wave®/Power Feed® Systems	25 (7.6)
K2683-50	Heavy Duty ArcLink®/Linc-Net™ Control Cable		50 (15.2)		
K2683-100	Heavy Duty ArcLink®/Linc-Net™ Control Cable		100 (30.4)		
	K1785-2	Heavy Duty Control Cable	14-pin	For synchronizing Power Wave® AC/DC 1000® SD units and connecting MAXsa™ Feed Heads and MAXsa™ Controllers. For use with FANUC® arms having integrated cable. For connecting Control Unit to Wire Drive in LN-10, DH-10 Boom applications.	1.5 (0.46)
	K1785-4	Heavy Duty Control Cable			4 (1.2)
	K1785-8	Heavy Duty Control Cable			8 (2.4)
	K1785-12	Heavy Duty Control Cable			12 (3.6)
	K1785-16	Heavy Duty Control Cable			16 (4.9)
	K1785-25	Heavy Duty Control Cable			25 (7.6)
	K1785-50	Control Cable			50 (15.2)
	K1785-100	Control Cable			100 (30.4)
	K2709-25	Wire Drive Control Cable			Male 14-pin to Female 14-pin
K2709-50	Wire Drive Control Cable	Male 14-pin to Female 14-pin	50 (15.2)		
K2709-100	Wire Drive Control Cable	Male 14-pin to Female 14-pin	100 (30.4)		

**Weld Power Cables**

	Product Number	Description	Connection	Length ft. (m)
	K1840-10	Weld Power Cable, 1/0, 350A, 60% duty cycle	Twist Mate™ to Lug	10 (3.1)
	K1842-10	Weld Power Cable, 3/0, 600A, 60% duty cycle	Lug to Lug	10 (3.1)
	K1842-35	Weld Power Cable, 3/0, 600A, 60% duty cycle	Lug to Lug	35 (10.7)
	K1842-60	Weld Power Cable, 3/0, 600A, 60% duty cycle	Lug to Lug	60 (18.3)
	K1842-110	Weld Power Cable, 4/0, 600A, 60% duty cycle	Lug to Lug	110 (33.5)
		K1841-25	Weld Power Cable, 1/0, 350A, 60% duty cycle	Twist Mate™ to Twist Mate™
K1841-50		Weld Power Cable, 2/0, 350A, 60% duty cycle	Twist Mate™ to Twist Mate™	50 (15.2)
	K2163-35 <sup>(1)</sup>	Weld Power Cable, 4/0	Lug to Lug	35 (10.7)
	K2163-60 <sup>(1)</sup>	Weld Power Cable, 4/0	Lug to Lug	60 (18.3)
	K1796-25	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle	Lug to Lug	25 (7.6)
	K1796-50	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle	Lug to Lug	50 (15.2)
	K1796-75	Coaxial Weld Power Cable, 1/0, 325A, 60% duty cycle	Lug to Lug	75 (22.8)
	K1796-100	Coaxial Weld Power Cable, 1/0, 300A, 60% duty cycle	Lug to Lug	100 (30.4)
	K2593-100	Coaxial Weld Power Cable, #1, 250A, 100% duty cycle	Lug to Lug	100 (30.4)

<sup>(1)</sup> Two cables per package.

**K802D****Power Plug Kit**

Provides two 115V plugs rated at 20 amps each, and two 230V plugs rated at 15 amps each. 115V plugs may not be compatible with common household receptacles.

**115V****K802N****Power Plug Kit**

Provides four 120V plugs rated at 20 amps each, and one dual voltage, full KVA plug rated at 120/240V, 50 amps. 120V plug may not be compatible with common household receptacles.

**120V****K586-1****Deluxe Adjustable Gas Regulator and Hose Kit**

Accommodates CO<sub>2</sub>, argon, or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.

**K2335-1****Adapter for Competitive Power Sources**

Allows wire feeder to connect to select Miller Electric® power sources.

**K937-45****Control Cable Extension**

Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. Available in 45 ft. (13.7 m) sections.

**K1816-1****Full-KVA Adapter Kit (1-Phase)**

Provides convenient connection of Lincoln Electric® equipment with NEMA 6-50P plug to Lincoln® engine driven welders having a full KVA receptacle.

**K1859-2****Water Cooler Hoses (CGA to CGA)**

For 5/8 inch (15.9 mm) LH CGA fitting applications at both cooler and wire feeder. Kit contains two 25 ft. (7.6 m) hoses with 5/8 inch left hand CGA fittings on both ends of hose.

**T12153-9****Full-KVA Power Plug (1-Phase)**

One dual voltage plug rated at 120/240V, 50 amps. NEMA 14-50P.

**T12153-10****Full-KVA Power Plug (3-Phase)**

One plug rated at 240V, 50 amps. NEMA 15-50P.

**3100211****Harris® Argon/CO<sub>2</sub> Flowmeter Regulator**

Flowmeter and regulator in one compact unit. Dual calibration on flow tube. Includes 10 ft. (3.0 m) shielding gas hose with 5/8-18 male connectors on both ends.

**3100338****Harris® Argon/Helium Flowmeter Regulator**

Flowmeter and regulator in one compact unit. Dual calibration on flow tube. Includes 10 ft. (3.0 m) shielding gas hose with 5/8-18 male connectors on both ends.





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