

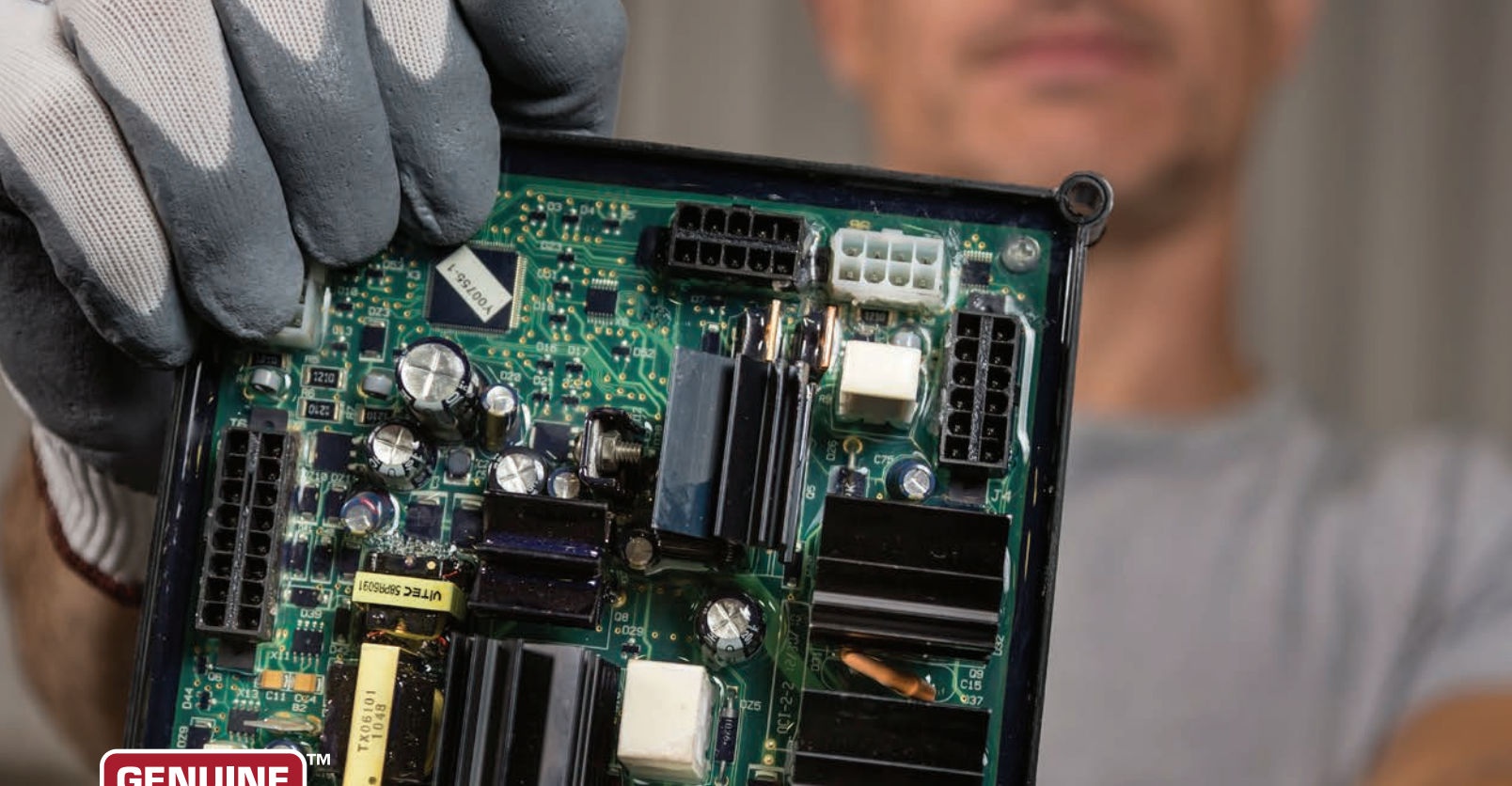
BK291

**LINCOLN**<sup>®</sup>  
**ELECTRIC**

# 2019 Countertop Parts Guide



[www.lincolnelectric.com/locator](http://www.lincolnelectric.com/locator)



# Unrivaled Service.

## Finding the Code Number

- There are normally three ways to identify a Lincoln Electric welder:
1. Product Number – letter "K" or "U" followed by numbers and/or letters. For example: K2175-1
  2. Code Number – 4 to 5 digit number. For example: 10859
  3. Serial Number – 11 digit alphanumeric. For example: U1060512345

When you use Service Navigator at [lincolnelectric.com](http://lincolnelectric.com), you need to enter the code number of the welder. A common mistake is to enter the product number.

The code number can be found on the nameplate of the welder, located either on the front or back of the unit.

## Find the closest Lincoln Authorized Repair Facility

[www.lincolnelectric.com/locator](http://www.lincolnelectric.com/locator)

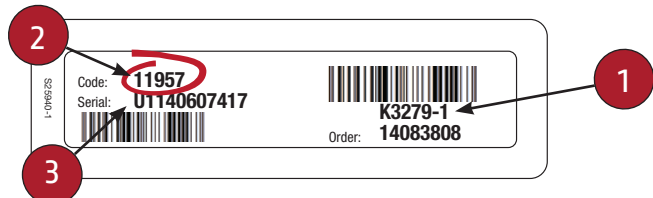
Lincoln Authorized Repair Facilities are certified on the latest products, troubleshooting procedures and repair techniques.

## Determining Manufacturing Date From Serial Number

Country of Mfg.	Facility of Mfg.	Year of Mfg.	Month of Mfg.	Incrementing Digits
1 character	1 digit	2 digit	2 digit	5 digit

**U1141010383**

*Serial Number is REQUIRED for Warranty Claims*



### 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.

<b>Welding Helmets &amp; Gear</b> .....	<b>4</b>
PAPR™ Series Helmet.....	5
VIKING™ Helmets .....	6
Retail Helmets .....	8
VIKING™ Helmet Replacement Parts .....	9
<b>Recommended Replacement Guns</b> .....	<b>12</b>
<b>MIG Guns</b> .....	<b>13</b>
Magnum® PRO Guns.....	13
Magnum® PRO Gun Connector Kits .....	14
Magnum® PRO Gun Liners .....	15
Magnum® PRO 100L & 175L Gun Expendables .....	16
Magnum® PRO 250L Gun Expendables.....	18
Magnum® PRO 350A Gun Expendables .....	20
Magnum® PRO Barrel & Curve 550A Gun Expendables .....	24
Magnum® PRO Fume Gun Expendables.....	26
Magnum® Gun Connector Kits .....	28
Magnum® Guns.....	30
Magnum® Gun Contact Tips .....	31
Magnum® Gun Gas Nozzles .....	32
Magnum® Gun Insulators and Gas Diffusers.....	33
Magnum® Gun Cable Liners and Gun Tubes .....	34
Magnum® 100L .....	35
Magnum® 200 .....	36
Magnum® 250 & 250L .....	38
Magnum® 300 & 400.....	39
Magnum® 550.....	42
<b>Push Pull &amp; Spool Guns</b> .....	<b>44</b>
Magnum® PRO AL Push-Pull Guns .....	45
Magnum® & Magnum® PRO 100SG Spool Guns.....	53
Magnum® Spool Guns .....	54
Magnum® 250 LX.....	55
Cougar™ .....	56
<b>Innershield Guns</b>	
K126™ PRO Expendables .....	58
K126™ PRO Gun What's Included .....	59
Magnum® Classic Self-Shielded Semiautomatic Guns.....	60
Innershield® K115 Squirt Gun & Cable.....	62
Innershield® K116 Squirt Gun, Cable & Gun Handle .....	63
Innershield® Classic K126 Squirt Gun, Cable .....	64
K126, K112 & K113 Trigger & Control Cable Parts .....	64
Innershield® K264, K345, K355 & K361 Squirt Gun & Cable Assemblies.....	65

<b>Submerged Arc Guns &amp; Torches</b>	
K112 & K113 Sub Arc Gun Assembly .....	66
K114 Squirtgun & Cable .....	67
K129 Sub Arc Tiny Twinarc® .....	68
K225 Sub Arc Twinarc® Kit .....	69
K231-1 Contact Nozzle Assembly.....	70
Innershield® K148 Positive Contact Nozzle Parts .....	71
<b>Plasma Torches</b>	
PCT-20 Handheld Torch .....	72
PCT-40 & 60 Torch & Cable .....	72
PCT-80 Machine Torch.....	73
PCT-80 Handheld Torch.....	73
Tomahawk® LC25.....	74
Tomahawk® LC40.....	74
Tomahawk® LC 65 Handheld Plasma Torch.....	75
Tomahawk® LC 65M Machine Plasma Torch .....	76
Tomahawk® LC105 Handheld Plasma Torch .....	77
Tomahawk® LC105MR Machine Plasma Torch .....	77
Torchmate®.....	78
<b>TIG Torch</b> .....	<b>79</b>
TIG Torch Connection Adapters .....	80
Gas Hook-up Kits.....	81
Tungsten Electrode.....	82
TIG Parts Kits .....	82
TIG Expendable Parts .....	84
TIG Replacement Parts .....	86
<b>Drive Rolls</b> .....	<b>88</b>
<b>Engine Service Parts</b>	
Kubota®.....	94
Kohler® .....	95
<b>Electrode Holders / Work Clamps</b> .....	<b>96</b>
<b>Control Cables &amp; Adapters</b> .....	<b>98</b>
<b>Gas Regulator and Flowmeters</b> .....	<b>99</b>
<b>Weld Fume Control Replacement Filters</b> .....	<b>100</b>
<b>Touch Up Paint</b> .....	<b>103</b>

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

Parts ordering is done electronically -  
orders placed by 3 PM EST - ship out 2nd Day Air.

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

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



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

PROTECT YOUR CUSTOMERS INVESTMENT!

Register machine at [lincolnelectric.com/register](http://lincolnelectric.com/register)

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

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 Equipment Catalog for full product offering



## LINCOLN® STARLITE® CLEAR SAFETY GLASSES

These sleek, compact indoor glasses are extremely lightweight 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

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

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)



# PAPR™ Series Helmet



Shown: KP5121-1 VIKING™ PAPR™ 3350 Series Helmet

## VIKING™ PAPR 3350 Welding Helmet

### Includes:

- Blower Unit
- VIKING™ 3350 Black Helmet
- Head Cover
- Hose
- 2 Particulate Filters
- 29-52 in. (736.6-1,320.8 mm) Padded Belt
- Shoulder Strap
- 120V Battery Charger
- Duffle Bag
- Rechargeable Battery
- Pre-Filter
- Spark Guard
- Hose Cover
- Extra helmet cover lenses:
  - Inside quantity, 2
  - Outside quantity, 5
- Instruction Manual



Shown:  
VIKING™ PAPR  
Welding Helmet

## Replacement Parts » VIKING™ PAPR™ 3350 Helmet

Product Name	Product Number
VIKING™ PAPR 3350 Helmet Assembly (PKG includes Headgear and Headcovering)	K3930-1
Outside Cover Lens	KP2898-1
Outside Cover Lens Seal	9S527978-32
3350 Auto-Darkening Lens	KP3045-3
Inside Cover Lens	KP3044-1
Lens Holder	9S527978-33
Headgear (including plenum and sweatband)	KP3942-1
Sweatband	KP3943-1
Headcovering (w/hook and loop attachment)	KP3940-1
Blower Assembly (PKG includes filter cover assembly)	KP3944-1
Battery Pack-Standard	KP3937-1
HE Filter Assembly	KP3424-2
HE Filter Assembly	KP3424-6
Pre-filter	KP3935-1
Spark Screen	KP3936-1
Battery Charger	KP3932-1
PAPR Belt Assembly	KP5123-1
Shoulder Strap Assembly	KP5124-1
Belt Extension (extends belt to 60 in.)	KP3939-1
Hose Assembly with Cover	KP5122-1
Cheater Lens 1.00 MAG	KP3046-100
Cheater Lens 1.25 MAG	KP3046-125
Cheater Lens 1.50 MAG	KP3046-150
Cheater Lens 1.75 MAG	KP3046-175
Cheater Lens 2.00 MAG	KP3046-200
Cheater Lens 2.25 MAG	KP3046-225
Cheater Lens 2.50 MAG	KP3046-250
Duffle Bag	K3096-1
CE Plug Adapter Kit	KP4255-1

# VIKING Helmets

## VIKING™ 3350 Series

VIKING 3350 Series, our top-of-the-line helmet series, provides the best optical clarity available in a welding helmet today and the largest viewing area in its class.



### Processes

- All

### Product Number

- K3034-3 Black
- K4181-3 Foose Imposter™
- K4412-3 White Tail Camo™
- K4034-3 Code Red®
- K3372-3 Jessi vs. The Robot™
- K4158-3 Zombie™
- K3175-3 All American®
- K3248-3 Twisted Metal®
- K3039-3 Terracuda®
- K3100-3 Motorhead®
- K3101-3 Mojo®
- K3255-3 Polar Arc®
- K3616-3 Born to Weld®
- K4440-3 Hot Rodders®
- K3428-3 Steampunk®

## VIKING™ 3250D FGS

VIKING FGS™ Series, our most technologically advanced helmet series, features an integrated grind shield, side windows and industry leading optics.



### Processes

- All

### Product Number

- K3540-3 Black

## VIKING™ 2450 Series

VIKING 2450 Series, the latest evolution in our highly successful mid-priced auto-darkening helmet line, offer improved headgear for greater comfort and flexibility.



### Processes

- All

### Product Number

- K3028-3 Black
- K4411-3 White Tail Camo™
- K3029-3 Heavy Metal®
- K3035-3 Street Rod®
- K3174-3 All American®
- K3099-3 Graveyard Shift®
- K4427-3 Jessi the Welder®

## VIKING™ 2450D

With all the features of our standard 2450, the 2450D helmet gives you access to three modes – welding, cutting, and grinding – with a user-friendly LCD screen digital interface.



### Processes

- All

### Product Number

- K3230-3 Black

## VIKING™ 1840 Series

VIKING 1840 Series, our affordable helmet series, provides the best optical clarity with external control allows for quick and easy shade changes.



**Processes**

- All

**Product Number**

- K3023-3 Black
- K3173-3 All American™
- K4175-3 Aztec™

## VIKING™ 1740

VIKING 1740 Series auto darkening welding helmet is economically priced and is solar powered with battery assist - no on/off switch to remember!



**Processes**

- All

**Product Number**

- K3282-1 Black
- K4375-2 Ignition™
- K3282-2 Black
- K3495-2 Recode™

## Industrial Passive™

The Viking™ Industrial Passive economically priced fixed shade helmet comes in a matte black finish and a decal sheet for customizing the shell to fit your personal style.



**Processes**

- All

**Product Number**

- K3371-1 Industrial Passive



**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

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



**HARD HAT ADAPTER**

KP3047-1 HARD HAT ADAPTER - SEE PAGE 8 FOR COMPATIBILITY

# Replacement Parts » Retail Helmets



K3063-1 Red Fierce Welding Helmet shown.

Product	KH619 - Outside Cover Lens	KP3323-1 - Replacement Inside / Outside Cover Lenses	KH778 - Replacement Inside / Outside Cover Lenses	KP3046-100 - Cheater Lens 1.00 MAG	KP3046-125 - Cheater Lens 1.25 MAG	KP3046-150 - Cheater Lens 1.50 MAG	KP3046-175 - Cheater Lens 1.75 MAG	KP3046-200 - Cheater Lens 2.00 MAG	KP3046-225 - Cheater Lens 2.25 MAG	KP3046-250 - Cheater Lens 2.50 MAG	KP2854-1 - VIKING™ All Purpose Sweatband Pack	KP2851-1 - VIKING™ 700G/750Series Headgear W/Sweatband	KP3324-1 - Replacement Headgear	KP4100-1 - Replacement Headgear
K2799-1 - Darkfire Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K2799-2 - Darkfire Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K2800-1 - Passive Welding Helmet	✓			✓	✓	✓	✓	✓	✓	✓	✓			
K2933-1 - Grunge Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K2934-1 - Flag Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K2953-1 - Century Welding Helmet		✓		✓	✓	✓	✓	✓	✓	✓	✓		✓	
K3057-1 - Shade 11 Welding Helmet		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓			
K3063-1 - Red Fierce Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K3064-1 - Blue Fierce Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K3079-1 - Oh Canada Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K3087-1 - Skullsaw Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K3190-1 - Bloodshot Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K3296-1 - Accelerate Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K3319-1 - Marquette Welding Helmet		✓		✓	✓	✓	✓	✓	✓	✓	✓		✓	
K3320-1 - Eliminator Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓		
K3320-2 - Accelerate Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			✓
K3419-1 - Black Glossy Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			✓
K3445-1 - Camo Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			✓
K3446-1 - Red Steel Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K4071-1 - Blaze Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K4134-1 - Lone Star Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			
K4438-1 - Galaxis Welding Helmet			✓	✓	✓	✓	✓	✓	✓	✓	✓			



# Replacement Parts » VIKING™ Helmets

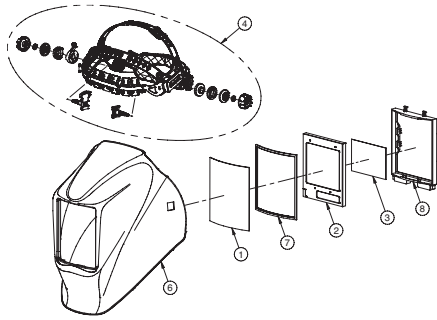
PART NUMBER	DESCRIPTION	SIZE	PKG. QTY	PASSIVE INDUSTRIAL	700G	750S	1740	1840	2450	2450D	3250D FGS	3350
KP4100-1	RATCHET HEADGEAR W/ SWEATBAND	N/A	1	✓			✓					
KP2851-1	RATCHET HEADGEAR	N/A	1		✓	✓						
KP3908-1	PIVOT HEADGEAR W/ SWEATBAND	N/A	1					✓	✓	✓		✓
KP3706-1	HEADGEAR W/ SWEATBAND	N/A	1								✓	
KP2930-1	SWEATBAND	N/A	2	✓			✓	✓	✓	✓	✓	✓
KP2854-1	SWEATBAND	N/A	2		✓	✓						
KP3047-1	HARD HAT ADAPTER	N/A	1	✓			✓	✓	✓	✓		✓
KP3707-1	SLOTTED HARDHAT ADAPTER	N/A	1								✓	
KP3708-1	HALO HARDHAT ADAPTER	N/A	1								✓	
95S27978-31	BLACK REPLACEMENT SHELL	N/A	1	✓					✓	✓		✓
95S27978-54	BLACK REPLACEMENT SHELL	N/A	1				✓	✓				
KP3704-1	FGS REPLACEMENT SHELL	N/A	1								✓	
KP2897-1	INSIDE CLEAR LENS	96 X 51.6 X 1.0mm [3.78 X 2.03 X .04 in.]	5		✓	✓	✓	✓				
KP2931-1	INSIDE CLEAR LENS	98.5 X 66.5 X 1.0mm [3.88 X 2.62 .04 in.]	5						✓	✓		
KP3701-1	INSIDE COVER LENS	78 X 108 X 1.00mm [3.09 X 4.28 X .04 in.]	5								✓	
KP3044-1	INSIDE CLEAR LENS	94.7 X 89.8 X 1.0mm [3.73 X 3.53 X .04 in.]	5									✓
KP2898-1	OUTSIDE COVER LENS	114 X 133 X 1.0mm [4.5 X 5.25 X .04 in.]	5	✓		✓			✓	✓		✓
KP2913-1	OUTSIDE COVER LENS	112 X 91.3 X 1.5mm [4.41 X 3.59 X .06 in.]	5		✓							
KP3043-1	OUTSIDE COVER LENS	114 X 100 X 1.5mm [4.5 X 3.94 X .06 in.]	5				✓	✓				
KP3700-1	OUTSIDE COVER LENS	100 x 158.2 x 1.2mm [3.95 X 5.9 X 0.06 in.]	5								✓	
95S27978-32	OUTSIDE COVER LENS SEAL	N/A	1	✓					✓	✓		✓
95S27978-58	OUTSIDE COVER LENS SEAL	N/A	1				✓	✓				
KP3046-100	CHEATER LENS 1.00 MAG	2 X 4.25 FRAME	1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-125	CHEATER LENS 1.25 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-150	CHEATER LENS 1.50 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-175	CHEATER LENS 1.75 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-200	CHEATER LENS 2.00 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-225	CHEATER LENS 2.25 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP3046-250	CHEATER LENS 2.50 MAG		1	✓	✓		✓	✓	✓	✓	✓	✓
KP4003-1	SHADE 11 FILTER PLATE		114 X 133 X 1.0mm [4.5 X 5.25 X .04 in.]	1	✓							
KP2853-3	ADF REPLACEMENT KIT	DINS 110 X 90	1		✓			✓				
KP3284-2	ADF REPLACEMENT KIT		1				✓					
KP2899-1*	ADF REPLACEMENT KIT		1			✓						
KP2932-3	ADF REPLACEMENT KIT		1						✓			✓
KP3243-2	ADF REPLACEMENT KIT (W/4C)	STD 4 X 5	1							✓		
KP3243-3	ADF REPLACEMENT KIT		1							✓		
KP3045-3	ADF REPLACEMENT KIT (W/4C)		1									✓
KP3703-3	ADF REPLACEMENT KIT	4.80 x 6.07	1								✓	
KP4004-1	RETAINING FRAME	4.45 X 5.20 FRAME	1	✓								
95S27978-55	ADF HOLDER	N/A	1				✓	✓				
95S27978-33	ADF HOLDER	N/A	1						✓	✓		✓
-	CR2450 LITHIUM BATTERY	N/A	N/A						**	**	**	***

\* = OBSOLETE

\*\* = 2 REQUIRED

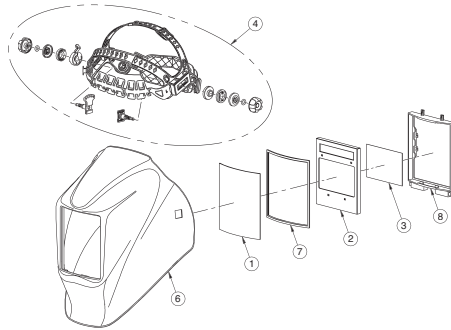
\*\*\* = 1 REQUIRED

### 3350 Series



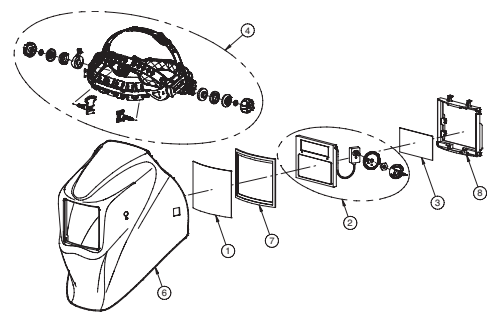
Part #	DESCRIPTION	QTY
1	KP2898-1 OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP3045-3 4C ADF CARTRIDGE	1
3	KP3044-1 INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1 HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1 SWEATBAND (PKG. QTY: 2)	1
6	9SS27978-31 REPLACEMENT SHELL	1
7	9SS27978-32 OUTSIDE CLEAR LENS SEAL	1
8	9SS27978-33 ADF HOLDER	1

### 2450 & 2450D Series



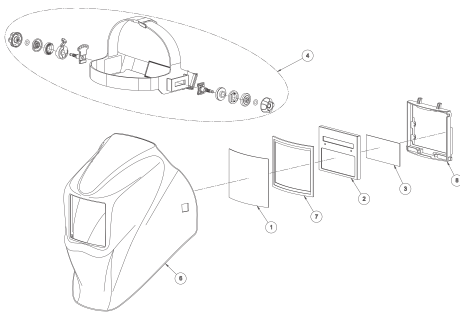
Part #	DESCRIPTION	QTY
1	KP2898-1 OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP2932-3 4C 2450 ADF CARTRIDGE	1
2	KP3243-2 2450D ADF CARTRIDGE	1
2	KP3243-3 4C 2450D ADF CARTRIDGE	1
3	KP2931-1 INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1 HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1 SWEATBAND (PKG. QTY: 2)	1
6	9SS27978-31 REPLACEMENT SHELL	1
7	9SS27978-32 OUTSIDE CLEAR LENS SEAL	1
8	9SS27978-33 ADF HOLDER	1

### 1840 Series



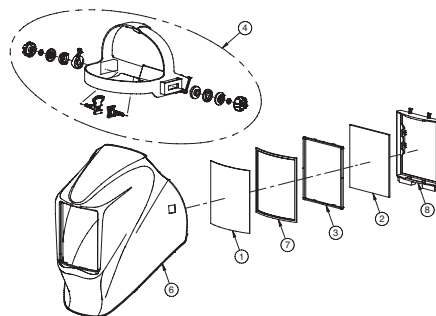
Part #	DESCRIPTION	QTY
1	KP3043-1 OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP2853-3 4C ADF CARTRIDGE	1
3	KP2897-1 INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1 HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1 SWEATBAND (PKG. QTY: 2)	1
6	9SS27978-54 REPLACEMENT SHELL	1
7	9SS27978-58 OUTSIDE CLEAR LENS SEAL	1
8	9SS27978-55 ADF HOLDER	1

### 1740 Series



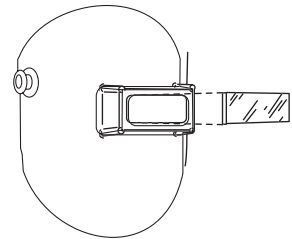
Part #	DESCRIPTION	QTY
1	KP3043-1 OUTSIDE CLEAR LENS (PKG. QTY: 5)	1
2	KP3284-2 ADF CARTRIDGE	1
3	KP3283-1 INSIDE CLEAR LENS (PKG. QTY: 5)	1
4	KP3908-1 HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1 SWEATBAND (PKG. QTY: 2)	1
6	9SS27978-95 REPLACEMENT SHELL	1
7	9SS27978-58 OUTSIDE CLEAR LENS SEAL	1
8	9SS27978-55 ADF HOLDER	1

### Passive Industrial 11



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	KP3908-1 HEADGEAR ASSEMBLY (INCLUDING SWEATBAND)	1
5	KP2930-1 SWEATBAND (PKG. QTY: 2)	1
6	9SS27978-31 REPLACEMENT SHELL	1
7	9SS27978-32 OUTSIDE CLEAR LENS SEAL	1
8	9SS27978-33 ADF HOLDER	1

### Standard Helmets Standard Headshield Lens

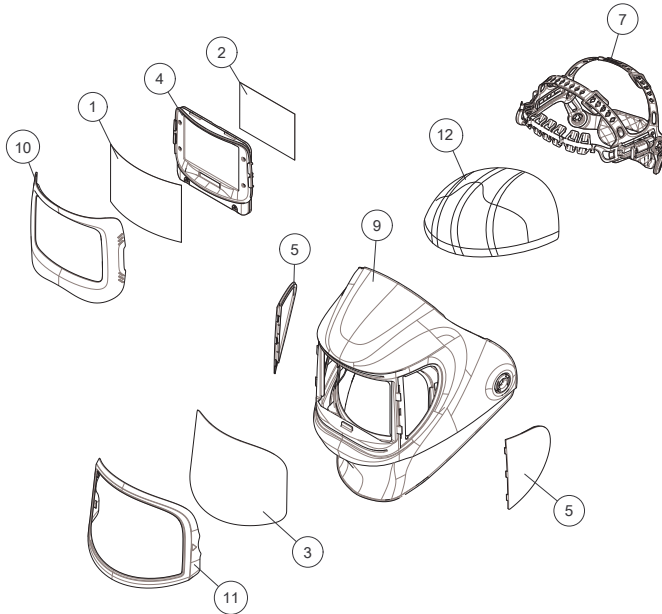


Product Name	Part #
Super Visibility Filter Plates Tempered Glass. Resists impact & breakage, excellent visibility. <sup>(1)(2)</sup>	#8 Shade KP1981-1
	#9 Shade KP1981-2
	#10 Shade KP1981-3
	#11 Shade KP1981-4
	#12 Shade KP1981-5
	#14 Shade KP1981-6
Clear Cover Plates	KP2106-1 - Non-spatter. Clear plastic 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.

## 3250D FGS Series



Part #	DESCRIPTION	QTY
1	KP3700-1 FGS - OUTSIDE COVER LENS	1
2	KP3701-1 FGS - INSIDE COVER LENS	1
3	KP3702-1 FGS - CLEAR GRIND SHIELD LENS	1
4	KP3703-3 REPLACEMENT 3250D ADF	1
5	9SS32652-5 SIDE LENS	1
7	KP3706-1 FGS - HEADGEAR	1
9	KP3704-1 FGS - SHELL (W/SIDE WINDOW)	1
10	9SS32652-10 FRONT LENS HOLDER	1
11	9SS32652-3 GRIND SHIELD LENS HOLDER	1
12	KP3709-1 HEAD COVER	1

Part #	DESCRIPTION	QTY
KP3046-100	1.00 MAG CHEATER LENS KIT	1
KP3046-125	1.25 MAG CHEATER LENS KIT	1
KP3046-150	1.50 MAG CHEATER LENS KIT	1
KP3046-175	1.75 MAG CHEATER LENS KIT	1
KP3046-200	2.00 MAG CHEATER LENS KIT	1
KP3046-225	2.25 MAG CHEATER LENS KIT	1
KP3046-250	2.50 MAG CHEATER LENS KIT	1
KP3707-1	SLOTTED HARDHAT ADAPTER	1
KP3708-1	SPRING HARDHAT ADAPTER	1
KP3705-1	FGS - SIDE LENS COVERS	1
KP2930-1	SWEATBAND	1

# Recommended Replacement Guns

## COMMERCIAL / LIGHT INDUSTRIAL WIRE FEED WELDERS

Machine Name	Gun Name	Gun Part #	Page
POWER MIG 140**	Magnum PRO 100L	K3080-1	17
POWER MIG 140C**	Magnum PRO 100L	K3080-1	17
POWER MIG 140T**	Magnum PRO 100L	K3080-1	17
POWER MIG 180**	Magnum PRO 100L	K3080-1	17
Power MIG 180 C (AU)	Magnum 100L	K530-6	35
POWER MIG 180C**	Magnum PRO 100L	K3080-1	17
POWER MIG 180T**	Magnum PRO 100L	K3080-1	17
POWER MIG 180 Dual**	Magnum PRO 100L	K3080-1	17
POWER MIG 200***	Magnum 250L	K533-7	
POWER MIG 210	Magnum PRO 175L	K4076-1	17
POWER MIG 215***	Magnum 250L	K533-7	
POWER MIG 216***	Magnum PRO 250L	K3081-2	19
POWER MIG 255***	Magnum 250L	K533-7	
POWER MIG 255XT***	Magnum PRO 250L	K3081-2	19
POWER MIG 256***	Magnum PRO 250L	K3081-2	19
Power MIG 260	Magnum PRO 250L	K3081-2	19
POWER MIG 300	Magnum 300	K470-2	39
POWER MIG 350MP****	Magnum PRO Curve 300	K2951-2-6-45	22
PowerWave C300****	Magnum PRO Curve 300	K2951-2-6-45	22
SP-100	Magnum 100L	K530-5	35
SP-100-I	Magnum 100L	K530-5	35
SP-100T	Magnum 100L	K530-5	35
SP-125 Plus	Magnum 100L	K530-5	35
SP-130T	Magnum 100L	K530-5	35
SP-135 Plus	Magnum 100L	K530-5	35
SP-135T	Magnum 100L	K530-5	35
SP-140-I	Magnum 100L	K530-5	35
SP-150	SP-150	K497-1 & S19729	36
SP-140T	Magnum100L	K530-6	35
SP-170	Magnum 100L	K530-5	35
SP-170-I	Magnum 100L	K530-5	35
SP-170T	Magnum 100L	K530-5	35
SP-175 Plus	Magnum 100L	K530-5	35
SP-175T	Magnum 100L	K530-5	35
SP-180T	Magnum 100L	K530-6	35
SP-200	Magnum 200L	K497-1 & S19729	36
SP-255	Magnum 250SP	K524-5	38
Wire-Matic 255***	Magnum PRO 250L	K3081-2	19

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

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

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

## RETAIL WIRE FEED WELDERS

Machine Name	Gun Name	Gun Part #	Page
Easy-Core 125	Magnum 100L	K530-6	35
Easy-Core 140	Magnum 100L	K530-6	35
Easy-Core 180	Magnum 100L	K530-6	35
FC-90	Hard wired internally	95S31898-4	-
Handy Core	Hard wired internally	95S25532-11	89 (B1)
Handy MIG (Early Design)	Hard wired internally	95S25351-11	89 (B2)
Handy MIG (Present Design)	Hard wired internally	95S25695-11	89 (B1)
Hand Core 100	Hard wired internally	95S24355-16	89 (A)
Handymig 170i	Magnum 100L	K530-5	35
LE31MP	Magnum PRO 100L w/8 pin	K530-7	17
Mega Force 140iMP	Magnum PRO 100L w/8 pin	K530-7	17
MIG Pak 10	Magnum 100L	K530-5	35
MIG Pak 15	Magnum 100L	K530-5	35
MIG Pak 140	Magnum 100L	K530-6	35
MIG Pak 140MP	Magnum PRO 100L w/8 pin	K530-7	17
MIG-Pak 180	Magnum 100L	K530-6	35
MIG Pak HD	Hard wired internally	95S25695-11	-
Pro 100	Magnum 100L	K530-5	35
Pro 155	Magnum 100L	K530-5	35
Pro-Core 100	Magnum 100L	K530-3	35
Pro-Core 125	Magnum 100L	K530-6	35
Pro-MIG 135	Magnum 100L	K530-5	35
Pro-MIG 140	Magnum 100L	K530-6	35
Pro-MIG 175	Magnum 100L	K530-5	35
Pro MIG 180	Magnum 100L	K530-6	35
Quick Weld	Hard wired internally	95S25532-11	89 (B1)
Weldmark 135 Plus	Magnum 100L	K530-5	35
Weld-Pak 100	Magnum 100L	K530-3	35
Weld-Pak 125HD	Magnum 100L	K530-6	35
Weld-Pak 140HD	Magnum 100L	K530-6	35
Weld-Pak 100HD	Magnum 100L	K530-3	35
Weld-Pak 125	Magnum 100L	K530-3	35
Weld-Pak 155	Magnum 100L	K530-3	35
Weld Pak 175HD	Magnum 100L	K530-3	35
Weld Pak 180HD	Magnum 100L	K530-3	35
Weld-Pak 3200HD	Magnum 100L	K530-5	35
Weld-Pak 5000HD	Magnum 100L	K530-3	35
Weld-Pak HD	Hard wired internally	95S25532-11	89 (B1)
Work-Pak 125	Magnum 100L	K530-6	35

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. See Magnum PRO Ready-Pak on next page.

# Magnum® PRO Guns - What's Included



## Magnum® PRO L-Series

- K3080-1 Magnum® PRO 100L
- K4076-1 Magnum® PRO 175L
- ▶ 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™ Gun

- ▶ 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 Barrel Gun

- 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)

### GUN REQUIRES

- ▶ Gun Connector Kit
- ▶ Gun Liner



## 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)	K3080-1	100 @ 40%	-	.025 - 3/64 <sup>(1)</sup>	[0.6 - 1.2]	10 (3.0)
Magnum® PRO 175L (with Integrated Gun Connector)	K4076-1	175 @ 40%	-	.025 - 3/64 <sup>(1)</sup>	[0.6 - 1.2]	10 (3.0)
Magnum® PRO 250L® (with Integrated Gun Connector)	K3081-1	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)	K2950-2-10-45	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)	K2951-2-6-45	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)	K2951-2-10-45	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)	K2951-2-10-116	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)	K2952-2-10-45	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)	K2651-2-6-45	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)	K2652-2-10-45	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)	K2653-2-10-45	450 @ 100%	325 @ 100%	.035 - 5/64 <sup>(1)</sup>	[0.9 - 2.0]	15 (4.5)

# Magnum<sup>®</sup> PRO Gun Connector Kits

For Magnum Connector Kits see page 28

Manufacturer	Wire Feeder Model	Magnum <sup>®</sup> PRO Curve <sup>™</sup> 200/300/400	Magnum <sup>®</sup> PRO Barrel 250/350/450	Magnum <sup>®</sup> PRO Barrel 550	Magnum <sup>®</sup> PRO Fume 350	Magnum <sup>®</sup> PRO Fume 550	K126 <sup>™</sup> PRO Innershield <sup>®</sup> For Small Feeder Bushings	K126 <sup>™</sup> PRO Innershield <sup>®</sup> For Large Feeder Bushings
Lincoln Electric <sup>®</sup>	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1	K466-1	K613-1	K466-1	K613-1	K466-1	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8	K466-8	K613-6	K466-8	K613-6	K466-8	K613-6
	LF-72, LF-74 Series, LN-25 PRO, Activ8 <sup>™</sup>	K466-10	K466-10	K613-7 <sup>[3]</sup>	K466-10	K613-7 <sup>[3]</sup>	K466-10	K613-7
	Power Feed <sup>®</sup> 10M, 15M, 25M, LN-10, DH-10, STT10, LN-15	K466-10	K466-10	K613-7 <sup>[3]</sup>	K466-10	K613-7 <sup>[3]</sup>	K466-10	K613-7
	POWER MIG <sup>®</sup> Series and Power Wave <sup>®</sup> C300	K466-6	K466-6	NA	K466-6	NA	K466-6	
Tweco <sup>®</sup>	Adapted No. 2, No. 3, No. 4 Guns [K466], No. 5 [K613]	K466-2	K466-2	K613-2	K466-2	K613-2	K466-2	K613-2
Miller <sup>®</sup>	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	K466-3	K613-3	K466-3	K613-3	K466-3	K613-3

See Feed Plate Adapters on Page 29



[3] K1500-3 Gun Receiver Bushing is required for Power Feed<sup>®</sup> 10 series, LF series and LN-25 PRO wire feeders.

# Magnum<sup>®</sup> PRO Gun Liners

Diameter in (mm)	Magnum <sup>®</sup> PRO Curve™ 200	Magnum <sup>®</sup> PRO Curve™ 300/400	Magnum <sup>®</sup> PRO Barrel 250/350/450	Magnum <sup>®</sup> PRO Barrel 550	Magnum <sup>®</sup> PRO Fume 350	Magnum <sup>®</sup> PRO Fume 550	K126™ PRO Innershield® K466 Series Gun Connector	K613 Series Gun Connector
0.025-0.030 [0.6-0.8]	15 ft (4.5 m) - KP42-25-15							
0.030-0.035 [0.8-0.9]	15 ft (4.5 m) - KP42-3035-15							
0.035-0.045 [0.9-1.2]	15 ft (4.5 m) - KP42-4045-15	15 ft (4.5 m) - KP44-3545-15 26 ft (7.6 m) - KP44-3545-25	15 ft (4.5 m) - KP44-3545-15 26 ft (7.6 m) - KP44-3545-25	15 ft (4.5 m) - KP45-3545-15 26 ft (7.6 m) - KP45-3545-25	15 ft (4.5 m) - KP44-3545-15 26 ft (7.6 m) - KP44-3545-25	15 ft (4.5 m) - KP45-3545-15 26 ft (7.6 m) - KP45-3545-25	15 ft (4.5 m) - KP44-3545-15 26 ft (7.6 m) - KP44-3545-25	15 ft (4.5 m) - KP45-3545-15 26 ft (7.6 m) - KP45-3545-25
0.052-1/16 [1.3-1.6]		15 ft (4.5 m) - KP44-116-15 26 ft (7.6 m) - KP44-116-25	15 ft (4.5 m) - KP44-116-15 26 ft (7.6 m) - KP44-116-25	15 ft (4.5 m) - KP45-116-15 26 ft (7.6 m) - KP45-116-25	15 ft (4.5 m) - KP44-116-15 26 ft (7.6 m) - KP44-116-25	15 ft (4.5 m) - KP45-116-15 26 ft (7.6 m) - KP45-116-25	15 ft (4.5 m) - KP44-116-15 26 ft (7.6 m) - KP44-116-25	15 ft (4.5 m) - KP45-116-15 26 ft (7.6 m) - KP45-116-25
1/16-5/64 [1.6-2.0]		15 ft (4.5 m) - KP44-564-15 26 ft (7.6 m) - KP44-564-25	15 ft (4.5 m) - KP44-564-15 26 ft (7.6 m) - KP44-564-25		15 ft (4.5 m) - KP44-564-15 26 ft (7.6 m) - KP44-564-25		15 ft (4.5 m) - KP44-564-15 26 ft (7.6 m) - KP44-564-25	
1/16-3/32 [1.6-2.4]								15 ft (4.5 m) - KP45H-332-15
5/64-3/32 [2.0-2.4]				15 ft (4.5 m) - KP45H-332-15 26 ft (7.6 m) - KP45H-332-25		15 ft (4.5 m) - KP45H-332-15		15 ft (4.5 m) - KP45H-332-15
7/64-1/20 [2.8-3.05]				15 ft (4.5 m) - KP45-18-15 26 ft (7.6 m) - KP45-18-25		15 ft (4.5 m) - KP45-18-15		15 ft (4.5 m) - KP45-18-15
Aluminum <sup>(4)</sup> 0.035-3/64 [0.9-1.2]	15 ft (4.5 m) - KP44N-3545-15 <sup>(4)</sup>	15 ft (4.5 m) - KP44N-3545-15 <sup>(4)</sup>	15 ft (4.5 m) - KP44N-3545-15 <sup>(4)</sup>	15 ft (4.5 m) - KP45N-3545-15 <sup>(4)</sup>	15 ft (4.5 m) - KP44N-3545-15 <sup>(4)</sup>	15 ft (4.5 m) - KP45N-3545-15 <sup>(4)</sup>		

<sup>(4)</sup> Recommended for aluminum wire welding.



KP42-XX-XX



KP44-XX-XX



KP45-XX-XX

# Magnum<sup>®</sup> PRO 100L & 175L Gun Expendables

## Expendable Parts

Magnum PRO expendable parts are interchangeable. Interchanging expendable parts 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.



## CONTACT TIPS

Wire Diameter		Tapered Tip	
in	(mm)	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

## GASLESS NOZZLE



Pkg. Qty.	Part Number
1	KP3084-1
25	KP3084-1-B25

## GUN TUBE



Gun Tubes	60° Gun Tube
Magnum PRO 100L	KP3082-60
Magnum PRO 175L	KP4087-1

## GAS NOZZLE<sup>1</sup>



Nozzle	Pkg. Qty.	Gas Nozzle Diameter-in (mm)	
		3/8 [9.5]	1/2 [12.7]
Flush	1	KP3075-1-38F	KP3075-1-50F
	25	KP3075-1-38F-B25	KP3075-1-50F-B25
1/4 in [6.4 mm] Stickout	1	KP3075-1-38S	KP3075-1-50S
	25	KP3075-1-38S-B25	KP3075-1-50S-B25

## GUN LINER



Cable Length	Pkg Qty	Steel	Steel	Aluminum
		0.023-0.035 in (0.6-0.9 mm)	0.035-0.045 in (0.9-1.2 mm)	0.035 in (0.9 mm)
15 ft (4.5 m)	1	KP35-40-15 <sup>3</sup>	KP45-40-15	KP1959-1 <sup>2</sup>
	10	KP35-40-15-B10	KP45-40-15-B10	-

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Amperage Rating 40% Duty Cycle	Wire Diameter Range		Cable Length	
			in	(mm)	ft	(m)
<b>Magnum PRO 100L</b>	K3080-1	100	0.025- 0.045	[0.6-1.2]	10	(3.0)
<b>Magnum PRO 175L</b>	K4076-1	175	0.025- 0.045	[0.6- 1.2]	10	(3.0)

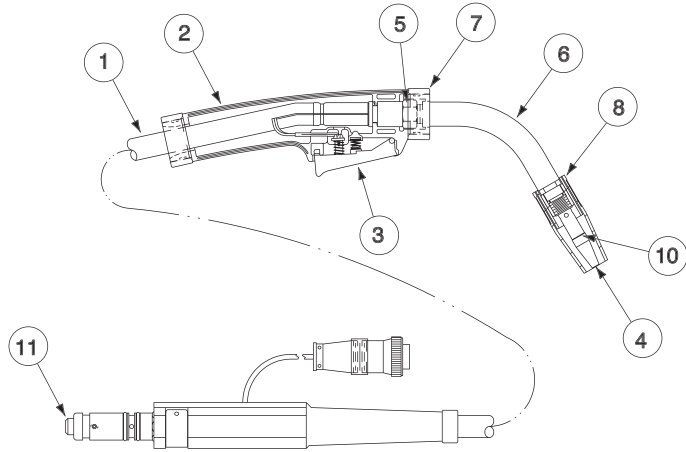
<sup>1)</sup> When using nozzle sizes less than 5/8 in., tapered tips are recommended.

<sup>2)</sup> Recommended for aluminum wire welding, recommended maximum cable length for aluminum is 10 ft. (3.0 m)

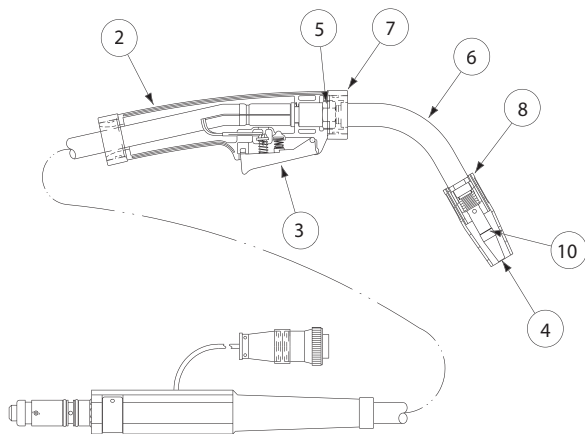
<sup>3)</sup> Standard on Magnum PRO 100L



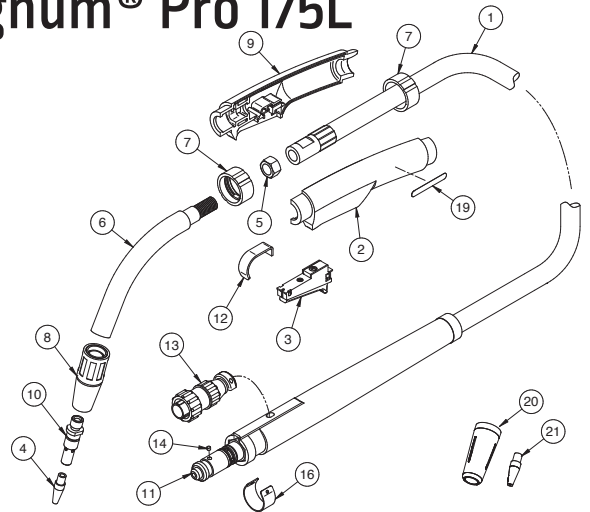
# Magnum® Pro 100L



ITEM	DESCRIPTION	Part #	QTY.
Magnum Pro 100L Asbly (L16063-1), Includes:		<b>K3080-1</b>	
1	Cable Asbly	9SM16318-2	1
2	Gun Handle (Left & Right)	9SG2209	1
3	Trigger Assembly	9SS19725	1
4	Tapered Contact Tip (.035)	KP2744-035T	1
5	Locking Nut	9SS19580	1
6	Gun Tube Assembly	KP3082-60	1
7	Collar	9SS19701	2
8	Gas Nozzle (Flush)	KP3075-1-50F	1
10	Gas Diffuser	KP3076-1	1
11	Liner Assembly (.035-.045)	KP45-40-15	1



# Magnum® Pro 175L



ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Asbly, Includes:		<b>K4076-1</b>	1
1	Cable Assembly (10')	L8324-7	1
2	Gun Handle (LEFT & RIGHT)	9SG2217	1
3	Trigger Assembly	9SS18932	1
4	Tapered Contact Tip (.035)	KP2744-035T	1
5	Locking Nut	9SS19580	1
6	Gun Tube Assembly	KP4087-1	1
7	Collar	9SS19074	2
8	Gas Nozzle (FLUSH)	KP3075-1-50F	1
9	Gun Handle (LEFT & RIGHT)	9SG2217	1
10	Gas Diffuser	KP3076-1	1
11	Liner Assembly (.025 - .035)	KP35-40-15	1
12	Hook	9SS19241	1
13	Control Wire Cord	9SM16700	1
14	Set Screw	9SS11604-51	1
15	Cable Fastener (Not Shown)	9ST11889	2
16	Clip	9SS19732	1
19	Decal	9SS27420-2	1


ITEM	DESCRIPTION	Part #	QTY.
MAGNUM PRO 100L 10FT W 8-PIN		<b>K530-7</b>	
2	GUN HANDLE SET	9SG2209	1
3	TRIGGER ASBLY	9SS19725	1
4	TAPERED CONTACT TIP 350A, .035	KP2744-035T	1
5	HEX LOCKING NUT	9SS19580	1
6	MAGNUM PRO 100L 60 DEG. GUN TUBE	KP3082-60	1
7	LOCKING COLLAR	9SS19701	2
8	NOZZLE PRO 100L THREAD-ON FLUSH .5 ID	KP3075-1-50F	1
10	MAGNUM PRO 100L GAS DIFFUSER	KP3076-1	1
Items Not Shown: LINER 023-035 [35-40-15]		KP35-40-15	1

# Magnum<sup>®</sup> PRO 250L Gun Expendables

## Expendable Parts


Magnum PRO expendable parts are interchangeable. Interchanging expendable parts 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.

### 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

### GUN TUBE INSULATOR




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

### GUN TUBE




Gun Tubes	60° Gun Tube	45° Gun Tube
Magnum PRO 250L	KP3078-60	KP3078-45

### GAS NOZZLE<sup>1</sup> IN (MM)



Nozzle	Pkg. Qty.	3/8 [9.5]	1/2 [12.7]	5/8 [15.9]
1/8 [3.2] Recess	1	KP2742-1-38R	KP2742-1-50R	KP2742-1-62R
	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	KP2742-1-62F-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	KP2742-1-62S-B25

### GUN LINER



Cable Length	Pkg Qty	Steel			Aluminum
15 ft [4.5 m]	1	KP42-25-15	KP42-3035-15	KP42-4045-15 <sup>1</sup>	KP44N-3545-15 <sup>2</sup>
	10	-	-	KP42-4045-15-B10	-

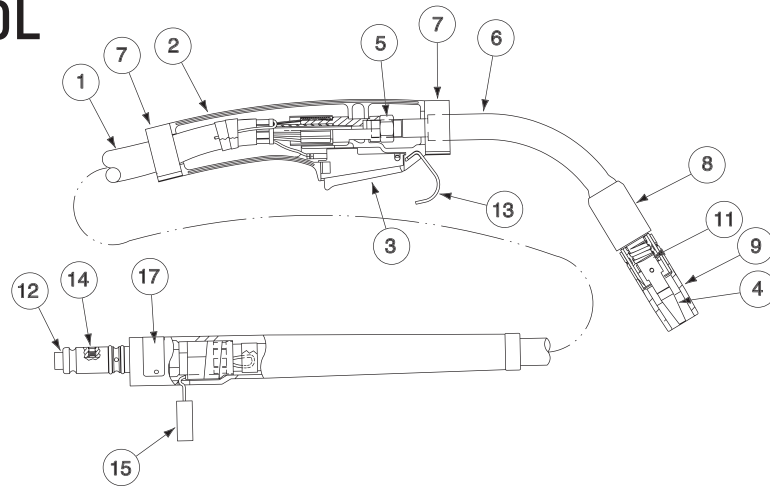
### PRODUCT SPECIFICATIONS

Product Name	Product Number	Amperage Rating 40% Duty Cycle	Wire Diameter Range in (mm)		Cable Length ft (m)
Magnum PRO 250 L	K3081-2	250	0.025-0.045	[0.6 - 1.2]	15 [4.5]

[1] Standard on Magnum PRO 250L

[2] Recommended for aluminum wire welding, recommended maximum cable length for aluminum is 10 ft. (3.0 m)

# Magnum® Pro 250L



ITEM	DESCRIPTION	Part #	QTY
	Magnum® Pro 250L Asbly (L16051-3), Includes:	K3081-2	1
1	Cable Asbly,(15')	9SL8324-6	1
2	Gun Handle (Left & Right)	9SG2217	1
3	Trigger Assembly	9SS18932	1
4	Tapered Contact Tip (.035)	KP2744-035T	1
5	Locking Nut	9SS19580	1
6	Gun Tube Assembly	KP3078-60	1
7	Collar	9SS19074	2
8	Insulator	KP2773-2	1
9	Gas Nozzle	KP2742-1-50F	1
11	Gas Diffuser	KP2746-1	1
12	Liner Assembly (.035-.045)	KP42-4045-15	1
13	Hook	9SS19241	1
14	Set Screw	9SS11604-51	1
15	Gun Control Assembly	9SM16700	1
17	Clip	9SS19732	1

# Magnum® PRO 350A Gun Expendables

## Expendable Parts

Magnum PRO expendable parts are interchangeable. Interchanging expendable parts 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.



### CONTACT TIPS 350A

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
0.052 [1.3]	KP2744-052	KP2744-052-B100	KP2744-052T	KP2744-052T-B100
1/16 [1.6]	KP2744-116	KP2744-116-B100	KP2744-116T	KP2744-116T-B100
5/64 [2.0]	KP2744-564	KP2744-564-B100	KP2744-564T	KP2744-564T-B100



### GAS DIFFUSER

Pkg. Qty.	Thread-on Standard Duty	Thread-on Light Duty	Thread-on Extended Reach	Slip-on
1	KP2746-1	KP3141-1 <sup>(1)</sup>	KP3360-1	KP2746-2
25	KP2746-1-B25	KP3141-1-B25 <sup>(1)</sup>	KP3360-1-B25	KP2746-2-B25

### TRIGGER KIT

Description	Part Number
Locking Trigger Kit	KP2870-1

### GUN TUBE INSULATOR 350A

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



Bottleneck Gas Nozzle for up to 350A Thread-on 1/8" (3.2 mm) Recessed



Gas Nozzle for up to 350A Thread-on 1/8" (3.2 mm) Recessed



Extended Reach Gas Nozzle for up to 350A Thread-on 1/8" (3.2 mm) Recessed

### GAS NOZZLE 350A

		Gas Nozzle Diameter in. (mm)						
		Nozzle	Pkg. Qty.	Standard 3/8 [9.5]	Standard 1/2 [12.7]	Extended Reach 1/2 [12.7]	Bottleneck 1/2 [12.7]	Standard 5/8 [15.9]
Thread-on	1/8 [3.2] Recess		1 25	KP2742-1-38R KP2742-1-38R-B25	KP2742-1-50R KP2742-1-50R-B25	KP3359-1-50R KP3359-1-50R-B25	KP3160-1-50R KP3160-1-50R-B25	KP2742-1-62R KP2742-1-62R-B25
	Flush		1 25	KP2742-1-38F KP2742-1-38F-B25	KP2742-1-50F KP2742-1-50F-B25	—	KP3160-1-50F KP3160-1-50F-B25	KP2742-1-62F KP2742-1-62F-B25
	1/8 [3.2] Stickout		1 25	KP2742-1-38S KP2742-1-38S-B25	KP2742-1-50S KP2742-1-50S-B25	—	KP3160-1-50S KP3160-1-50S-B25	KP2742-1-62S KP2742-1-62S-B25
Slip-on	1/8 [3.2] Recess		1 25	—	KP2742-2-50R KP2742-2-50R-B25	—	—	KP2742-2-62R KP2742-2-62R-B25
	Flush		1 25	—	KP2742-2-50F KP2742-2-50F-B25	—	—	KP2742-2-62F KP2742-2-62F-B25
	1/8 [3.2] Stickout		1 25	—	KP2742-2-50S KP2742-2-50S-B25	—	—	KP2742-2-62S KP2742-2-62S-B25

### GUN TUBE<sup>2</sup>

Gun Tubes	45° Gun Tube	60° Gun Tube	82° Gun Tube	Flexible
Magnum® PRO Curve™ 200	KP2924-45	KP2924-60	—	—
Magnum® PRO Curve™ 300	KP2925-45	KP2925-60	—	—
Magnum® PRO Curve™ 400	KP2926-45	KP2926-60 / KP2926-60L <sup>(3)(4)</sup>	KP2926-82	KP3200-1



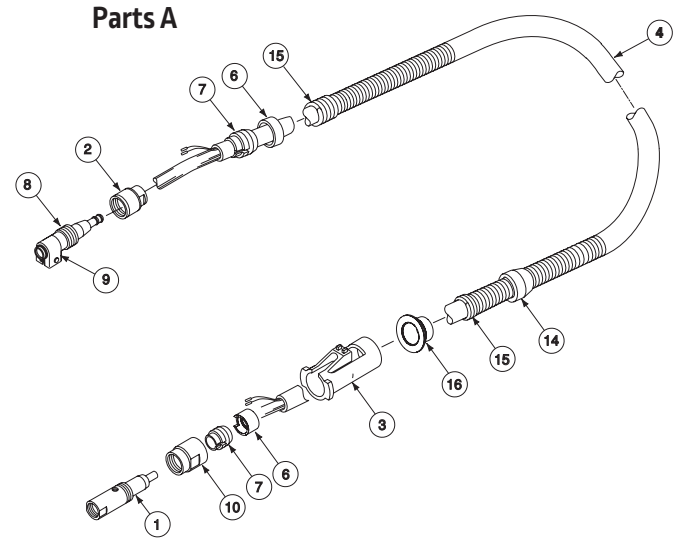
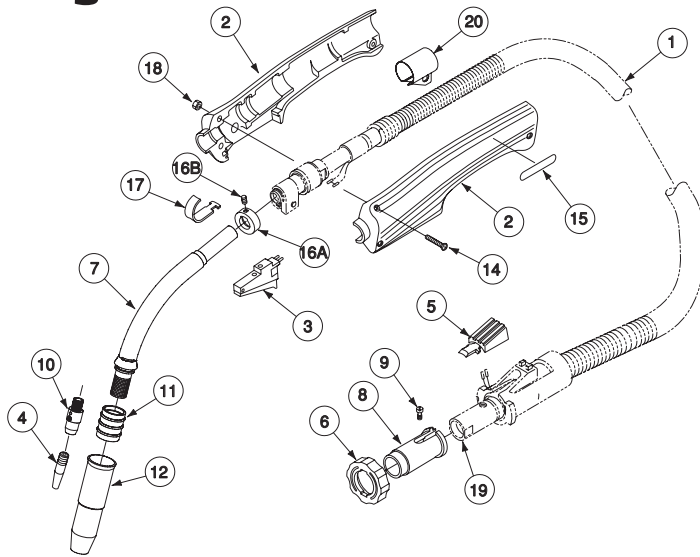
(1) For use with Magnum® PRO 100L KP3075-1-XXX nozzles only

(2) Can be used on existing Magnum® Guns

(3) Extended version.

(4) When using an extended gun tube and extended gas nozzle, a 25 ft. liner should be used.

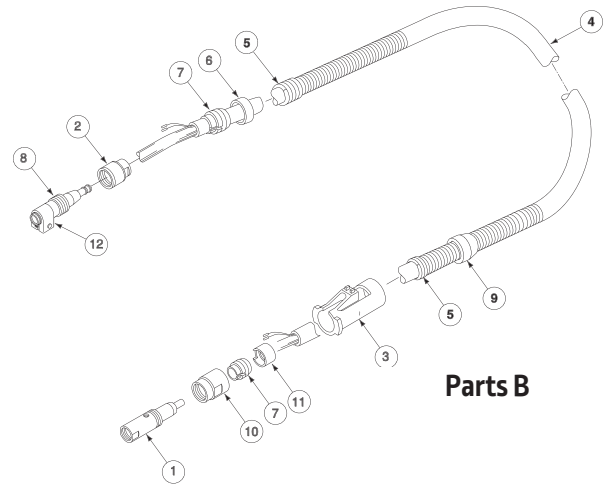
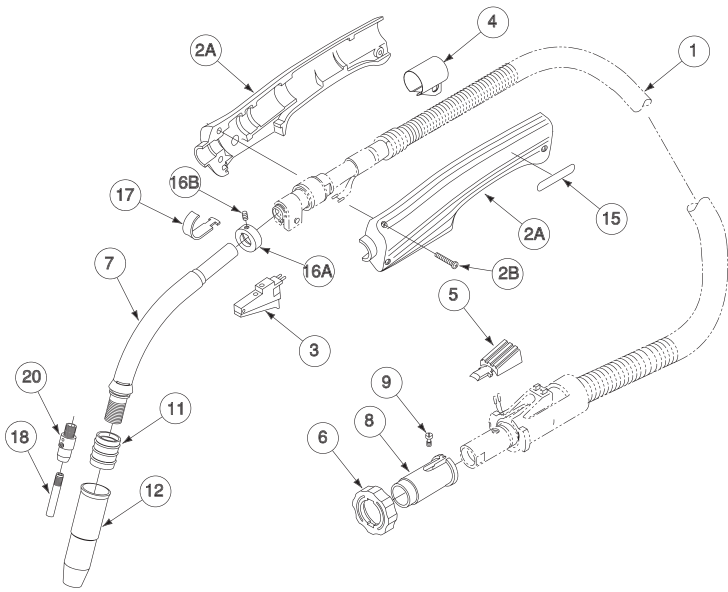
# Magnum® PRO Curve 200



ITEM	DESCRIPTION	Part #	QTY
	Gun & Cable Asbly, Includes: [10']	K2950-1	1
	Gun & Cable Asbly, Includes: [15']	K2950-2	1
	Gun & Cable Asbly, Includes: [20']	K2950-3	1
	Gun & Cable Asbly, Includes: [25']	K2950-4	1
	(Items 4, 10, 11, 12 & 20 are Not Included in the Asbly)		
1	Connector Assembly	See Parts A	1
2	Gun Handle (Left & Right)	9SG2090	1
3	Trigger Assembly	9SS21002	1
4	Contact Tip	Pg 20	1
5	Connector Cover	9SL7723	1
6	Nut (Cable Handle)	9SS18690	1
7	60° Gun Tube Assembly	KP2924-60	1
8	Tail Piece	9SM15607	1
9	Gas Plug Assembly	9SS18695	1
10	Gas Diffuser	Pg 20	1
11	Insulator	KP2773-2	1
12	Gas Nozzle	Pg 20	1
14	Pan Head Screw (for Handle Assembly)	9SS18825-1	3
15	Decal (Logo)	9SS27420-1	1
16	Collar Assembly, Includes:	9SS18831	1
16A	Collar	9SS18830	1
16B	Set Screw	9SS11604-46	1
17	Hanger	9SM15693	1
18	Handle Nut	9SS18773	3
19	15' Cable Liner (.035-.045) also used on 10' & 12'	KP42-4045-15	1
19	15' Cable Liner (.025-.030) also used on 10' & 12'	KP42-25-15	1
20	Spring Boot Retainer	9SS24719-1	1

ITEM	DESCRIPTION	Part #	QTY
1	Incoming Connector Asbly	9SS18789-1	1
2	Connector Nut	9SS19067	1
3	Cable Handle	9SL7725	1
4	Cable Assembly	NSS	
6	Strain Relief Housing	9SS18786-1	2
7	Strain Relief	9SS18787-1	2
8	Gun Tube Connector Assembly, Includes:	9SS18655-1	1
	Gun Tube Connector	M15635-1	1
	Tube	9SS19363	1
	"O" Ring	9ST13483-8	1
9	Nozzle Clamp	9SS15921-1	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
10	Incoming End Nut	9SS23822-200	1
14	Sleeve	9SS24773-1	1
15	Spring Boot	9SS24676-2	2
16	Bushing	9SS24679-2	1

# Magnum® Pro Curve 300 & 400 Gun & Cable



ITEM	DESCRIPTION	Part #	QTY
<b>Gun &amp; Cable Assembly:</b>			
	300 Amp [See Table 1]	K2951-[-]	1
	400 Amp (Short Neck) [See Table 1]	K3055-[-]	1
	400 Amp [See Table 1]	K2952-[-]	1
1	Connector Assembly	See Parts (B)	1
2A	Gun Handle (Left & Right)	9SG1927	1
2B	Pan Head Screw (for Handle)	9SS18825-1	3
3	Trigger Assembly (Non Interlocking-Standard)	9SS21002	1
3	Trigger Assembly (Interlocking-Parts Order Only)	9SS20677 *	1
4	Spring Boot Retainer (Gun End Only)	9SS24719	1
5	Connector Cover	9SL7723	1
6	Nut (Cable Handle)	9SS18690	1
7	Gun Tube Assembly	See Pg 20 & 24	1
8	Tail Piece	9SM15607	1
9	Gas Plug Assembly	9SS18695	1
11	Slip on Nozzle Insulator	See Pg 20 & 24	1
12	Gas Nozzle	See Pg 20 & 24	1
15	Decal	9SS27420-1	1
16	Collar Assembly, Includes:	9SS18831	1
16A	Collar	9SS18830	1
16B	Set Screw	9SS11604-46	1
17	Hanger	9SM15693	1
18	Contact Tip	See Pg 20 & 24	1
20	Gas Diffuser	See Pg 20 & 24	1

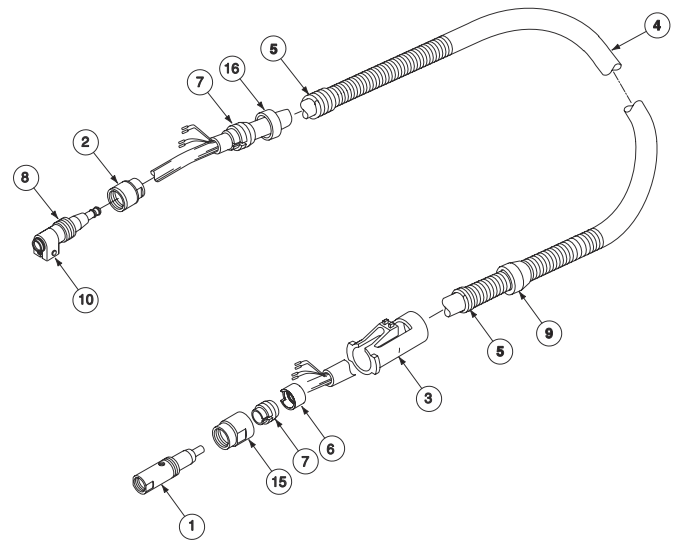
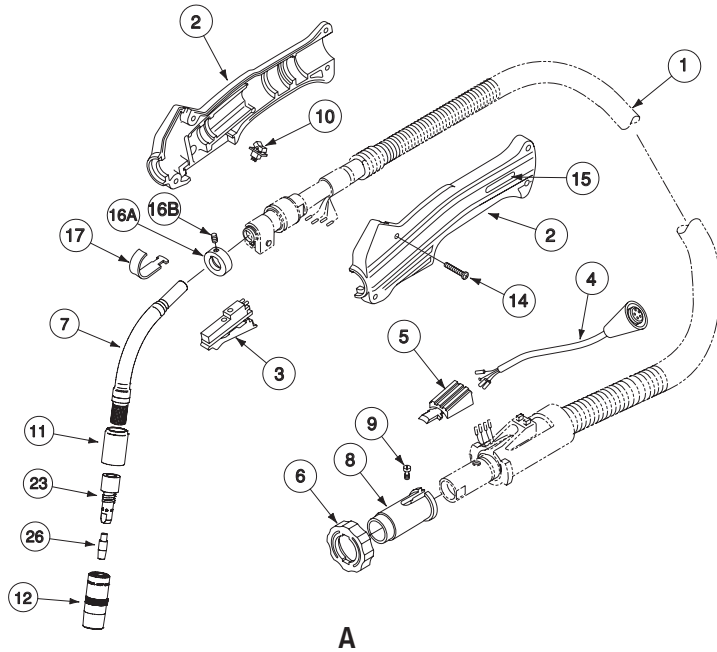
\*Trigger requires latest version of Gun Handles.  
 \*\* Comes with 300 Amp Gun Tube

1	Incoming Connector Assembly	9SS18789	1
2	Connector Nut (300 Amp)	9SS18749-1	2
2	Connector Nut (400 Amp)	9SS18749-2	2
3	Cable Handle	9SL7725	1
4	Cable Assembly (Includes 4A)	NSS	
4A	Terminal (For Mating Gun Connector End)	9SS19492-1	2
5	Spring Boot	9SS24676	2
6	Strain Relief Housing	9SS18786	1
7	Strain Relief	9SS18787	2
8	Gun Tube Connector Assembly, Includes:	9SS18655	1
	Gun Tube Connector	9SM15635	1
	Tube	9SS18847	1
	"O" Ring	9ST13483-8	1
12	Nozzle Clamp	9SS15921-1	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
9	Spring Boot Retainer	9SS24678	1
10	Incoming End Nut (300 Amp)	9SS23822-300	1
10	Incoming End Nut (400 Amp)	9SS23822-400	1
11	Strain Relief Housing	9SS24677	1

**TABLE 1**

Part No	Amp	Length	Wire Size	Metric Wire Size
K2951-1	300	10 FT	025-5/64"	0.6-2.0
K2951-2	300	15 FT	025-5/64"	0.6-2.0
K2951-3	300	20 FT	025-5/64"	0.6-2.0
K2951-4	300	25 FT	025-5/64"	0.6-2.0
K2952-1	400	10 FT	025-5/64"	0.6-2.0
K2952-2	400	15 FT	025-5/64"	0.6-2.0
K2952-3	400	20 FT	025-5/64"	0.6-2.0
K2952-4	400	25 FT	025-5/64"	0.6-2.0
K3055-1	400	10 FT	025-5/64"	0.6-2.0
K3055-2	400	15 FT	025-5/64"	0.6-2.0
K3055-3	400	20 FT	025-5/64"	0.6-2.0
K3055-4	400	25 FT	025-5/64"	0.6-2.0

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



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:	K3130-1	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (15 ft), Includes:	K3130-2	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (20 ft), Includes:	K3130-3	1	X	
	Magnum® Pro Curve 300 (Dual Procedure) (25 ft), Includes:	K3130-4	1	X	
	Magnum® Pro Curve 400 (Dual Procedure) (10 ft), Includes:	K3098-1	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (15 ft), Includes:	K3098-2	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (20 ft), Includes:	K3098-3	1	-	X
	Magnum® Pro Curve 400 (Dual Procedure) (25 ft), Includes:	K3098-4	1	-	X
1	Connector Asbly	See PARTS B	1	X	X
2	Handle (Left & Right)	9SG3598	1	X	X
3	Trigger Assembly	9SS21002	1	X	X
4	Control Cable	9SM19313	1	X	X
5	Connector Cover	9SL7723	1	X	X
6	Nut (Cable Handle)	9SS18690	1	X	X
7	Gun Tube Assembly	KP2925-60	1	X	-
7	Gun Tube Assembly	KP2926-60	1	-	X
8	Tail Piece	9SM15607	1	X	X
9	Gas Plug Asbly	9SS18695	1	X	X
10	Rocker Switch	9SS24514	1	X	X
11	Insulator	See Pg 20 & 24	1	X	X
12	Gas Nozzle	See Pg 20 & 24	1	X	X
14	Pan Head Screw	9SS18825-1	4	X	X
15	Decal	9SS18750-1	1	X	-
15	Decal	9SS18750-2*	1	-	X
16	Collar Assembly, Includes:	9SS18831	1	X	X
16A	Collar	9SS18830	1	X	X
16B	Set Screw	9SS11604-46	1	X	X
17	Hanger	9SM15693	1	X	X
23	Diffuser	See Pg 20 & 24	1	X	X
26	Contact Tip (1.2 - .045)	See Pg 20 & 24	1	X	X

\* Obsolete

ITEM	DESCRIPTION	Part #	QTY		
1	Incoming Connector Asbly	9SS18789	1	X	X
2	Connector Nut	9SS18749-1	1	X	-
2	Connector Nut	9SS18749-2	1	-	X
3	Cable Handle	9SL8564	1	X	X
4	Cable Assembly	NSS	1	X	-
4	Cable Assembly	NSS	1	-	X
5	Spring Boot	9SS24676	1	X	X
6	Strain Relief Housing	9SS18786	2	X	X
7	Strain Relief	9SS18787	2	X	X
8	Gun Tube Connector Assembly, Includes:	9SS18655	1	X	X
	Gun Tube Connector	9SM15635	1	X	X
	Tube	9SS18847	1	X	X
	"O" Ring	9ST13483-8	1	X	X
10	Nozzle Clamp	9SS15921-1	1	X	X
	Clamping Screw	9ST14438	1	X	X
	Retaining Ring	9SS9776-7	1	X	X
9	Spring Boot Retainer	9SS24678	1	X	X
15	Connector Nut	9SS18749-1	1	X	-
15	Connector Nut	9SS18749-2	1	-	X
16	Strain Relief Housing	9SS24677	1	X	X

# Magnum<sup>®</sup> PRO Barrel & Curve 550A Gun Expendables

## Expendable Parts

Magnum PRO expendable parts are interchangeable. Interchanging expendable parts 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.



## CONTACT TIPS

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	-	-
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	-	-

(1) 550 only



## GAS DIFFUSER 550A

Pkg. Qty.	Thread-on Standard Duty	Thread-on 1/4 in. Recess	Slip-on
1	KP2747-1	KP3155-1	KP2747-2
25	KP2747-1-B25	KP3155-1-B25	KP2747-2-B25

## TRIGGER KIT



Description	Part Number
Locking Trigger Kit	KP2870-1

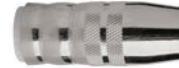
## GUN TUBE INSULATOR 550A

Pkg. Qty.	Part Number
1	KP2773-1
25	KP2773-1-B25



## GAS NOZZLE 550A

	Nozzle	Pkg. Qty.	Gas Nozzle Diameter - in. (mm)		
			Standard 0.625 [15.9]	Bottleneck 0.625 [15.9]	Standard 0.750 [19]
Thread-on	1/8 (3.2) Recess	1 25	KP2743-1-62R KP2743-1-62R-B25	KP3161-1-62R KP3161-1-62R-B25	KP2743-1-75R KP2743-1-75R-B25
	Flush	1 25	KP2743-1-62F KP2743-1-62F-B25	KP3161-1-62F KP3161-1-62F-B25	KP2743-1-75F KP2743-1-75F-B25
	1/8 (3.2) Stickout	1 25	KP2743-1-62S KP2743-1-62S-B25	KP3161-1-62S KP3161-1-62S-B25	KP2743-1-75S KP2743-1-75S-B25
Slip-on	1/8 (3.2) Recess	1 25	KP2743-2-62R KP2743-2-62R-B25	- -	KP2743-2-75R KP2743-2-75R-B25
	Flush	1 25	KP2743-2-62F KP2743-2-62F-B25	- -	KP2743-2-75F KP2743-2-75F-B25
	1/8 (3.2) Stickout	1 25	KP2743-2-62S KP2743-2-62S-B25	- -	KP2743-2-75S KP2743-2-75S-B25



## GUN TUBE 450A & 550A

	450 Gun Tube	600 Gun Tube	820 Gun Tube	1800 Gun Tube
Magnum PRO 450 Barrel	KP2868-45	KP2868-60	KP2868-82	KP2868-180
Magnum PRO 550 Barrel	KP2869-45	KP2869-60 KP2869-60SN <sup>(2)</sup> / KP2869-60L <sup>(3)(4)</sup>	---	KP2869-180



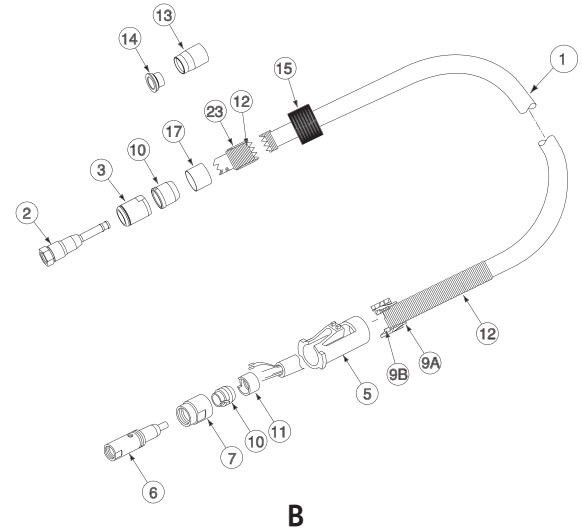
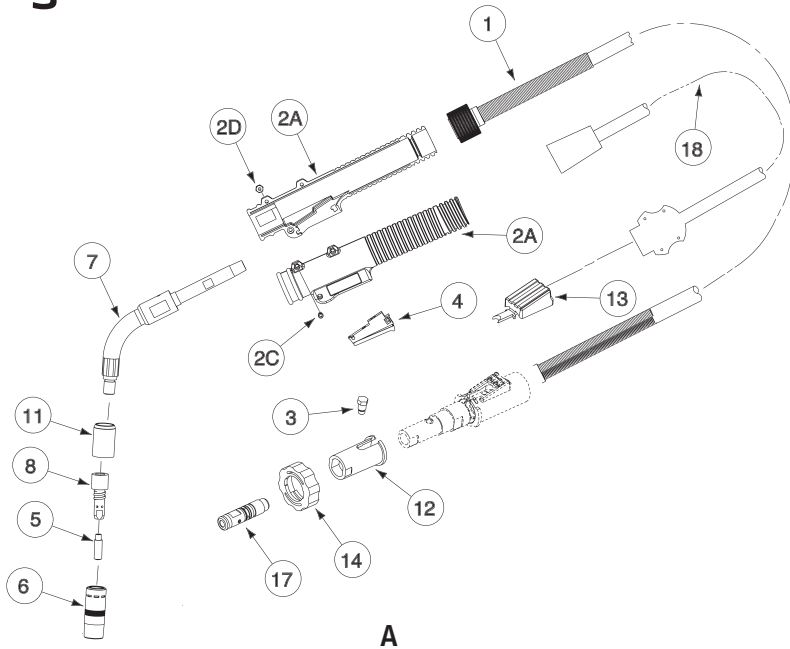
(2) Short neck for up to 3/32 in. wire.

(3) Extended version.

(4) When using an extended gun tube and extended gas nozzle, a 25 ft. liner should be used.



# Magnum® PRO Barrel 250/350/450/550 Parts



A

B

Use Items marked with 'X' in Column for desired gun

#	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']	K2651-[-]	1	X	-	-	-	-	-	-
	350A Magnum Pro [-1 for 10'] or [-2 for 15']	K2652-[-]	1	-	X	-	-	-	-	-
	450A Mag Pro [-1 for 10'], [-2 for 15'], [-4 for 25']	K2653-[-]	1	-	-	X	-	-	-	-
	550A Mag Pro [-1 for 10'], [-2 for 15'], [-4 for 25']	K2655-[-]	1	-	-	-	X	-	-	-
	250A Magnum Pro [15']	K2651-2-6-45	1	-	-	-	-	X	-	-
	350A Magnum Pro [15']	K2652-2-10-45	1	-	-	-	-	-	X	-
	450A Magnum Pro [15']	K2653-2-10-45	1	-	-	-	-	-	-	X
1	Connector Assembly	See Parts [B]	1	X	X	X	X	X	X	X
2A	Gun Handle (Left & Right)	9SG6088-1	1	X	X	X	X	X	X	X
2C	#6-32 x .50 SHCS (for Handle)	9ST9447-87	3	X	X	X	X	X	X	X
2D	#6-32 HN	9SCF000005	3	X	X	X	X	X	X	X
3	Molded Gas Plug	9SS18695	1	X	X	X	X	X	X	X
4	Trigger Asbly (Non Interlocking-Standard)	9SS21002	1	X	X	X	X	X	X	X
5	Contact Tip	Pg 20 & 24	1	X	X	X	X	X	X	X
6	Nozzle Assembly (250 & 350 Amp)	KP2742-1-62R	1	X	X	-	-	X	X	-
6	Nozzle Assembly (1/8" Recessed) [450 & 550 Amp]	KP2743-1-62R	1	-	-	X	X	-	-	X
7	Gun Tube Assembly (250 Amp)	KP2866-60	1	X	-	-	-	X	-	-
7	Gun Tube Assembly (350 Amp)	KP2867-60	1	-	X	-	-	-	X	-
7	Gun Tube Assembly (450 Amp)	KP2868-60	1	-	-	X	-	-	-	X
7	Gun Tube Assembly (550 Amp)	KP2869-60	1	-	-	-	X	-	-	-
8	Gas Diffuser	Pg 20 & 24	1	X	X	X	X	X	X	X
10	Decal (Not Shown)	9SS27420	1	X	X	X	X	X	X	X
11	Insulator (350A)	KP2773-2	1	X	X	-	-	X	X	-
11	Insulator (550-A)	KP2773-1	1	-	-	X	X	-	-	X
12	Tail Piece	9SM15607	1	X	X	X	X	X	X	X
13	Connector Cover	9SL7723	1	X	X	X	X	X	X	X
14	Nut (Cable Handle)	9SS18690	1	X	X	X	X	X	X	X
17	Connector Assembly	9SS18653	1	-	-	-	-	X	X	X
18	Control Cable	M16325-1	1	-	-	-	-	X	-	-
18	Control Cable	9SM15608	1	-	-	-	-	-	X	X

#	DESCRIPTION	Part #	QTY	1	2	3	4
Cable Assembly (250 Amp):		NSS	1	X	-	-	-
Cable Assembly (350 Amp):		NSS	1	-	X	-	-
Cable Assembly (450 Amp):		NSS	1	-	-	X	-
Cable Assembly (550 Amp):		NSS	1	-	-	-	X
1	Cable (250 Amp)	NSS	1	X	-	-	-
2	Power Cable Male Cone	9SS26287-5	1	X	X	X	-
2	Power Cable Female Cone	9SS26287-4	1	-	-	-	X
3	Power Cable Female Nut	9SS26288-5	1	X	X	X	-
3	Power Cable Female Nut	9SS26288-4	1	-	-	-	X
5	Cable Handle	9SL7725	1	X	X	X	-
5	Cable Handle	9SL8990	1	-	-	-	X
6	Incoming Connector Asbly	9SS18789	1	X	X	X	-
6	Incoming Connector Asbly	9SS20696	1	-	-	-	X
7	Incoming End Nut	9SS23822-300	1	X	X	-	-
7	Incoming End Nut	9SS23822-400	1	-	-	X	-
7	Incoming End Nut	9SS22506	1	-	-	-	X
9A	Sleeve	9SS24773-1	1	X	-	-	-
9A	Spring Boot Retainer	9SS24678	1	-	X	X	-
9A	Cable Handle Insert	9SS28061	1	-	-	-	X
9B	Bushing	9SS24679-2	1	X	-	-	-
10	Strain Relief	9SS18787	2	X	X	X	-
10	Strain Relief	9SS20695	1	-	-	-	X
11	Strain Relief Housing	9SS24677	1	X	X	X	-
11	Strain Relief Housing	9SS18786-1	1	-	-	-	X
12	Spring Boot	9SS24676-2	2	X	-	-	-
12	Spring Boot	9SS24676	2	-	X	X	-
12	Spring Boot	9SM17003-1	2	-	-	-	X
13	Sleeve	9SS24773-3	1	X	-	-	-
14	Bushing	9SS24679-4	1	X	-	-	-
15	Knurled Nut	9SS26299-1	1	X	X	X	X
17	Strain Relief Housing	9SS18786	1	X	X	X	-
19	Spring Boot Retainer	9SS24678	1	-	X	X	-
23	Spring Boot Retainer	9SS24678-1	1	-	X	X	-
25	Hose Clamp (Not Shown)	9SS20710-17	2	-	-	-	X

# Magnum<sup>®</sup> PRO Fume Gun Expendables

Both 350 and 550 Fume Guns use Magnum<sup>®</sup> PRO 550 expendables.



## GUN CONNECTOR KIT



Manufacturer	Wire Feeder Model	Magnum <sup>®</sup> PRO Fume 350	Magnum <sup>®</sup> PRO Fume 550
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
	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>
Tweco Adapted	POWER MIG <sup>®</sup> Series and Power Wave <sup>®</sup> C300	K466-6	-
Miller	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2	K613-2
	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

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

## CONTACT TIPS



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	-	-
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	-	-

(1) 550 only

## GAS DIFFUSER 550A



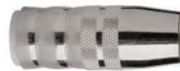
Pkg. Qty.	Thread-on Standard Duty	Thread-on 1/4 in. Recess	Slip-on
1	KP2747-1	KP3155-1	KP2747-2
25	KP2747-1-B25	KP3155-1-B25	KP2747-2-B25

## GUN TUBE INSULATOR 550A



Pkg. Qty.	Part Number
1	KP2773-1
25	KP2773-1-B25

## GAS NOZZLE 550A



		Gas Nozzle Diameter in. (mm)				
		Nozzle	Pkg. Qty.	Standard 0.625 [15.9]	Bottleneck 0.625 [15.9]	Standard 0.750 [19]
Thread-on	1/8 (3.2) Recess		1 25	KP2743-1-62R KP2743-1-62R-B25	KP3161-1-62R KP3161-1-62R-B25	KP2743-1-75R KP2743-1-75R-B25
	Flush		1 25	KP2743-1-62F KP2743-1-62F-B25	KP3161-1-62F KP3161-1-62F-B25	KP2743-1-75F KP2743-1-75F-B25
	1/8 (3.2) Stickout		1 25	KP2743-1-62S KP2743-1-62S-B25	KP3161-1-62S KP3161-1-62S-B25	KP2743-1-75S KP2743-1-75S-B25
Slip-on	1/8 (3.2) Recess		1 25	KP2743-2-62R KP2743-2-62R-B25	- -	KP2743-2-75R KP2743-2-75R-B25
	Flush		1 25	KP2743-2-62F KP2743-2-62F-B25	- -	KP2743-2-75F KP2743-2-75F-B25
	1/8 (3.2) Stickout		1 25	KP2743-2-62S KP2743-2-62S-B25	- -	KP2743-2-75S KP2743-2-75S-B25

## TRIGGER KIT

Description	Part Number
Locking Trigger Kit	KP2870-1

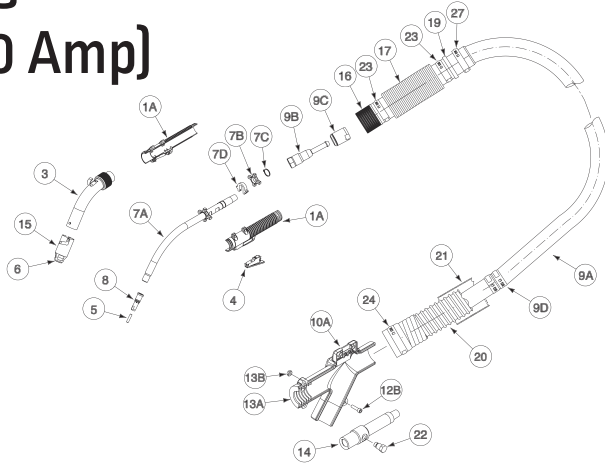


## SMOKE EXTRACTOR NOZZLES

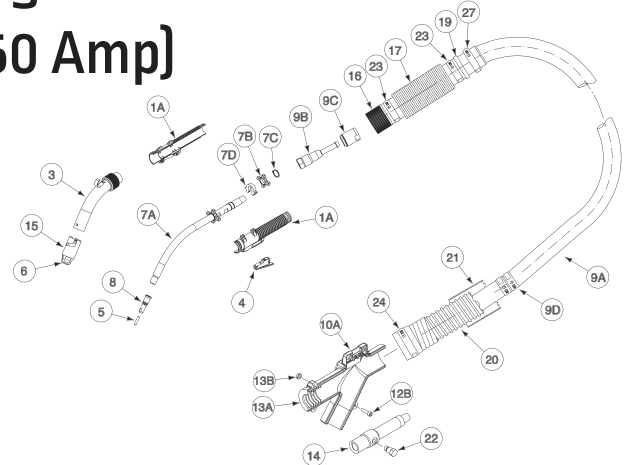
Nozzle	Part Number
GMAW Fume Extractor Nozzle	KP2871-1
FCAW Fume Extractor Nozzle	KP2872-1 <sup>(1)</sup>

(1) Standard with gun

# Magnum Pro Fume Gun (350 Amp)



# Magnum Pro Fume Gun (550 Amp)



ITEM	DESCRIPTION	Part #	QTY.
	Magnum Pro Fume Gun (350 Amp), Includes:	K2649-1	1
1A	Fume Handle (Left & Right)	95G6086-1	1
1B	#8-32 HN	95CF000042	4
1C	Socket Head Cap Screw	95T9447-29	4
3	Fume Tube Assembly (M21587)	KP2739-1	1
4	Trigger Assembly	95S21002-1	1
	Decal	95S27420	1
5	Contact Tip (S26401-2 .045 1.2mm)	KP2745-045	1
6	Gas Nozzle Assembly (1/8" Recessed)	KP2743-2-62R	1
7A	Gun Tube	KP2738-1	1
7B	Gun Tube Splicer	95S27232-1	1
7C	Retaining Ring	95S9776-17	1
7D	Gun Tube Lock	95S27235	1
	Roll Pin	95T9967-26	1
8	Heavy Duty Diffuser Assembly (S26873-1)	KP2747-1	1
9	Cable Assembly, Includes:	95L13335-3	1
9A	Cable	95L13336-3	1
9B	Power Cable Male Cone	95S26287-5	2
9C	Power Cable Female Nut	95S26288-5	2
9D	Hose Clamp	95S20710-19	4
10A	Right Modular Trigger Housing	95L13299	1
	#8-32 HN	95CF000042	2
	Left Modular Trigger Housing	95L13298	1
	Socket Head Cap Screw	95T9447-29	2
	Right Y Connector	95G6075	1
12B	Socket Head Cap Screw	95T9447-29	3
13A	Left Y Connector	95G6074	1
13B	#8-32 HN	95CF000042	3
14	Molded Incoming Connector	95M21568	1
15	Fume Collection Nozzle (L13337)	95SKP2872-1	1
16	Swivel Assembly	95S26314-1*	1
17	Bellows	95S26344-1	1
	Spring	95S27241	1
19	Tube Adapter	95S26289-1	1
20	Vacuum Hose (1.50 I.D.)	95S19947-18	1
21	Fume Hose Cover (S21147-11)	KP2736-1	1
22	Molded Gas Plug	95S18695	1
23	Hose Clamp	95S20710-18	3
24	Hose Clamp	95S20710-21	1

ITEM	DESCRIPTION	Part #	QTY.
	Magnum Pro Fume Gun (550 Amp), Includes:	K2650-1	1
1A	Fume Handle (Left & Right)	95G6086-1	1
1B	#8-32 HN	95CF000042	4
1C	Socket Head Cap Screw	95T9447-29	4
3	Fume Tube Assembly (M21587)	KP2739-1	1
4	Trigger Assembly	95S21002-1	1
4A	Decal (Not Shown)	95S27420	1
5	Contact Tip (S26401-6 3/32 2.4mm)	KP2745-332	1
6	Gas Nozzle Assembly (1/8" Recessed)	KP2743-2-62R	1
7A	Gun Tube	KP2738-1	1
7B	Gun Tube Splicer	95S27232-1	1
7C	Retaining Ring	95S9776-17	1
7D	Gun Tube Lock	95S27235	1
	Roll Pin	95T9967-26	1
8	Heavy Duty Diffuser Assembly (S26873-1)	KP2747-1	1
9	Cable Assembly, Includes:	95L13335-1	1
9A	Cable	95L13336-1	1
9B	Power Cable Male Cone	95S26287-4	2
9C	Power Cable Female Nut	95S26288-4	2
9D	Hose Clamp	95S20710-17	4
10A	Right Modular Trigger Housing	95L13299	1
	#8-32 HN (Not Shown)	95CF000042	2
	Left Modular Trigger Housing	95L13298	1
	Socket Head Cap Screw	95T9447-29	2
	Right Y Connector	95G6075	1
12B	Socket Head Cap Screw	95T9447-29	3
13A	Left Y Connector	95G6074	1
13B	#8-32 HN	95CF000042	3
14	Molded Incoming Connector	95M21568	1
15	Fume Collection Nozzle (L13337)	KP2872-1	1
16	Swivel Assembly	95S26314-1*	1
17	Bellows	95S26344-1	1
	Spring	95S27241	1
19	Tube Adapter	95S26289	1
20	Vacuum Hose (1.75 I.D.)	95S19947-17	1
21	Fume Hose Cover (S21147-11)	KP2736-1	1
22	Molded Gas Plug	95S18695	1
23	Hose Clamp	95S20710-18	2
24	Hose Clamp	95S20710-20	2

Items Shipped Loose:  
Fume Collection Nozzle, GMAW (Not Shown)

KP2871-1  
\* Obsolete

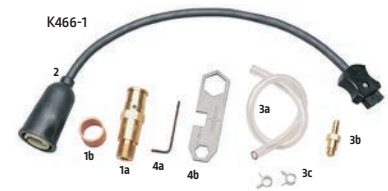
Items Shipped Loose:  
Fume Collection Nozzle, GMAW (Not Shown)

KP2871-1  
\* Obsolete

# 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, SP200 [Up to .052 in. (1.4 mm) Wire]	K466-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8
	LF-72, LF-74 Series, LN-25 PRO	K466-10
	Power Feed® 10 and 25 series	K466-10
	POWER MIG® Series and Power Wave® C300	K466-6
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2
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
<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]	K489-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K489-1
	Power Feed® 10 and 25 series	K489-7
	POWER MIG® Series and Power Wave® C300	K489-8
<b>MAGNUM® 400 DUAL PROCEDURE, DUAL SCHEDULE</b>		
Lincoln Electric®	Power Feed® 10 and 25 series	K466-10
<b>MAGNUM® 400 FAST-MATE™, DUAL PROCEDURE, DUAL SCHEDULE</b>		
Lincoln Electric®	Power Feed® 10 and 25 series	K489-7
<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]	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K613-6
	Power Feed® 10 and 25 series	K613-7
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	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	K613-3



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)

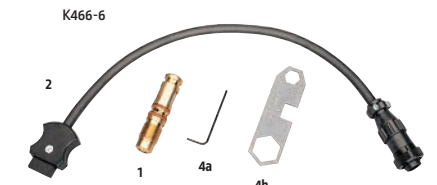


**O-Rings  
Not Shown  
T13483-8  
(5 PK)**

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: 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)



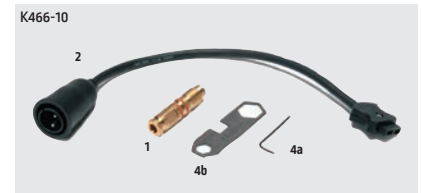
Gun Connector Assembly: S19760-1 (1a), S19761-1(1b), KP2095-XX (1c)  
Control Cable: M16325 (2)  
Connector Tools: T11563-4 (4)



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)



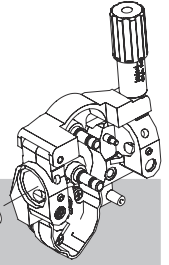
Gun Connector Assembly: S18653-1 (1)  
Control Cable: M15608 (2)  
Connector Tools: T11563-4 (4)



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

# Feed Plate Gun Adapters

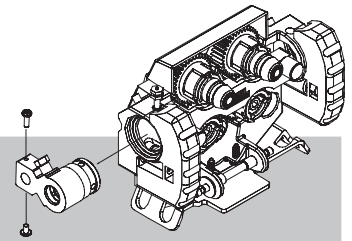
Used to connect guns to semiautomatic feeders.



Feeder:		Activ8 <sup>(1)</sup> , LN-25 PRO <sup>(2)</sup> , LN-25 Pipe <sup>(2)</sup> , LN-25 Ironworker <sup>(2)</sup> , Power Feed 25M <sup>(1)</sup> , LF-72, LF-74, LN-10, DH-10, STT-10				
<b>Gun:</b>	Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-1 Innershield gun Magnum 550 with K613-1	Tweco® #2, #3, #4 Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-10	Tweco® #5 Lincoln Electric Magnum & Magnum PRO 550 with K613-7	Miller® guns Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-3	OXO® guns	Lincoln Electric Magnum® Fast-Mate™ (both single and dual procedure guns)
<b>Gun adapter (receiver bushing)</b>	Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8	Compatible Gun Connector Kits K466-10 K466-2 K466-6	Compatible Gun Connector Kits K613-7 K613-2	Compatible Gun Connector Kits K466-3 K613-3		Compatible Gun Connector Kits K489-1 K489-2 K489-7 K489-8
<b>Part #</b>	<b>K1500-1</b>	<b>K1500-2</b>	<b>K1500-3</b>	<b>K1500-4</b>	<b>K1500-5</b>	<b>K489-7</b>

<sup>(1)</sup> Comes with K1500-2 gun adapter

<sup>(2)</sup> Comes with K1500-2 gun adapter installed, K1500-1 shipped loose



Feeder:		FlexFeed 74 HT, Power Feed 84				
<b>Gun:</b>	Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-1	Tweco® #2, #3, #4 Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-10	Tweco® #5 Lincoln Electric Magnum & Magnum PRO 550 with K613-7	Miller® guns Lincoln Electric Magnum & Magnum PRO 200, 300 & 400 with K466-3	OXO® guns	Lincoln Electric Magnum® Fast-Mate™ (both single and dual procedure guns)
<b>Gun adapter (receiver bushing)</b>	Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8	Compatible Gun Connector Kits K466-10 K466-2 K466-6	Compatible Gun Connector Kits K613-7 K613-2	Compatible Gun Connector Kits K466-3 K613-3		Single and dual procedure guns
<b>Part #</b>	<b>K3344-1</b>	<b>K3345-1</b>	<b>K3346-1</b>	<b>K3347-1</b>	<b>K3348-1</b>	<b>K3349-1</b>

# Magnum® Guns



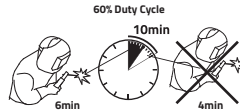
## Amperage Rating @ 60% Duty Cycle <sup>(1)</sup>

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 Name	Cut Length ft (m)	Wire Diameter, in (mm)								
		0.025-0.035 [0.6-0.9] Package	0.035-0.045 [0.9-1.2]			0.052-1/16 [1.3-1.6]			1/16-5/64 [1.6-2.0]	
			Open-End*	Fast-Mate™	Package	Open-End*	Fast-Mate™	Package	Open-End*	Fast-Mate™
<b>Magnum® Guns Series</b>										
100L	10 (3.0)	K530-5 K530-6 <sup>(1)</sup>	K530-3 (FCAW-SS only)			---	---	---	---	---
200	10 (3.0)	---	K497-2	---	---	---	---	---	---	---
	15 (4.5)	---	K497-1	K498-1	K497-21 <sup>(3)</sup>	---	---	---	---	---
250L	12 (3.6)	---	K533-7 (Fixed Gas Nozzle)			---	---	---	---	---
	15 (4.5)	---	K533-3 (Adjustable Gas Nozzle)			---	---	---	---	---
300	10 (3.0)	---	K470-1	---	---	---	---	---	---	---
	15 (4.5)	---	K470-2	---	K1802-1 <sup>(2)</sup>	K470-4	---	---	K470-6	---
400 Standard	10 (3.0)	---	K471-1	---	---	---	---	---	---	---
	12 (3.6)	---	---	---	---	---	---	---	---	---
	15 (4.5)	---	K471-2	K479-2	K2286-1 <sup>(2)</sup> K471-21 <sup>(3)</sup>	K471-4	K479-4	K471-22 <sup>(3)</sup>	K471-6	K479-6
	20 (6.1)	---	K471-10	---	---	K471-11	---	---	---	---
	25 (7.6)	---	K471-13	---	---	K471-14	---	---	471-15	---
400 Dual Schedule	15 (4.5)	---	---	---	---	---	K575-2	---	---	---
400 Dual Procedure	15 (4.5)	---	K1722-2	---	---	---	---	---	---	---
400 Short Neck	15 (4.5)	---	K541-3	---	---	---	---	---	---	---
450WC	15 (4.5)	---	K684-12 <sup>(4)</sup>	---	---	K684-12 <sup>(4)</sup>	---	---	K684-12 <sup>(4)</sup>	---
550	15 (4.5)	---	---	---	---	K598-7	---	---	K598-11 <sup>(5)</sup>	---

\* Open-End requires gun connector kit. See page 26

Magnum 100L » <sup>(1)</sup>Includes 4-pin MS-Type connection for trigger control

Magnum 200 » <sup>(2)</sup>Includes K466-1 Connector Kit

Magnum 300 » <sup>(3)</sup>Includes K466-10 Connector Kit

Magnum 400 Standard » <sup>(2)</sup>Includes K466-1 Connector Kit <sup>(3)</sup>Includes K466-10 Connector Kit

Magnum 450WC » <sup>(4)</sup>0.035-1/16 in. [0.9-1.6 mm] Solid Wire, 0.045-5/64 in. [1.2-2.0 mm] Flux-Cored Wire

Magnum 550 » <sup>(5)</sup>K598-11 : 600A Open End 5/64-3/32 in. [2.0-2.4 mm] Solid Wire

# Magnum® Gun Contact Tips

## CONTACT TIPS 100 A (MAGNUM® 100L)

Wire Diameter in. (mm)	Standard		Tapered
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10
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

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



Tapered



Heavy Duty



Standard Duty

## CONTACT TIPS 200 A AND 250 A (MAGNUM® 200, MAGNUM® 250L, MAGNUM® 250SP)

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
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 (MAGNUM® 300 & MAGNUM® 400)

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
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 (MAGNUM® 550)

Wire Diameter in. (mm)	Solid Wire, Heavy Duty Pkg. Qty. - 10
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



Coarse Thread  
Gas Nozzle



Adjustable Slip-On Gas  
Nozzle

## GAS NOZZLES 100 A (MAGNUM® 100L)

Nozzle	Package Quantity	0.37 Nozzle Diameter	0.50 Nozzle Diameter	0.625 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 (MAGNUM® 200, MAGNUM® 250L, & MAGNUM® 250SP)

Nozzle	Package Quantity	.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 (MAGNUM® 300 & MAGNUM® 400)

Nozzle	Package Quantity	0.38 Nozzle Diameter	0.50 Nozzle Diameter	0.62 Nozzle Diameter	0.75 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-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	KP23H-62F	-
Fixed Flush	25	-	KP23-50F-B25	KP23H-62F-B25	-

## GAS NOZZLES 600 A (MAGNUM® 550)

Nozzle	Package Quantity	0.62 Nozzle Diameter	0.75 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
Coarse Thread / Tip Recessed 1/4 in.	1	-	KP261-75



# Magnum® Gun Insulators and Gas Diffusers

## INSULATORS



Magnum® 200  
Magnum® 250L  
Magnum® 250SP

Magnum® 300  
Magnum® 400

Magnum® 550

Nozzle	Package Quantity	200 Amp	300 & 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

## GAS DIFFUSERS 100 A (MAGNUM® 100L)



Wire Size	Item Number
.025-.045 in. (0.6-1.2 mm)	KP35-50

## GAS DIFFUSERS 200 A (MAGNUM® 200)



Wire Size	Package Quantity	Item Number
.025-.030 in. (0.6-0.8 mm)	1	KP52-23
.035-.045 (0.9-1.2 mm)	1	KP52FN
	25	KP52FN-B25
.025-.045 (0.6-1.2 mm)	1	KP2051-1 <sup>(2)</sup> or KP52FN <sup>(1)</sup>
	25	KP2051-1B1 <sup>(2)</sup> or KP52FN-B25 <sup>(1)</sup>

## GAS DIFFUSERS 250 A (MAGNUM® 250L & MAGNUM® 250SP)



Wire Size	Package Quantity	For Adjustable Slip-On Nozzle	For Fixed Nozzle	Specialty
.025-.030 in. (0.6-0.8 mm)	1	KP52-23	KP2051-1	KP2051-1
.035-.045 (0.9-1.2 mm)	1	KP52	KP52FN	-
	25	KP52-B25	KP52FN-B25	-
.025-.045 (0.6-1.2 mm)	1	-	KP52FN	KP2051-1 <sup>(3)</sup>
	25	-	-	KP2051-1B1

<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® 250L gun tube.

## GAS DIFFUSERS 300 A AND 400 A (MAGNUM® 300 & MAGNUM® 400)



Wire Size	Package Quantity	Item Number
.025-.030 in. (0.6-0.8 mm)	1	KP2024-2 <sup>(1)</sup>
	25	-
.035-5/64 in. (0.9-2.0 mm)	1	KP54A
	25	KP54A-B25

## GAS DIFFUSERS 600 A (MAGNUM® 550)



Wire Size	Package Quantity	Item Number
.035-1/16 in. (0.9-1.6 mm)	1	KP56S-SW
	25	-
5/64-1/8 (2.0-3.2 mm)	1	KP56S-H
	25	KP56S-H-B10

# Magnum® Gun Cable Liners and Gun Tubes

## MAGNUM® 100L

ft (m)	0.035 (0.9) Aluminum <sup>(1)</sup>	0.025-0.035 (0.6-0.9)	0.035-0.045 (0.9-1.2)
15 (4.5)	KP1959-1	KP35-40-15	KP45-40-15

## MAGNUM® 200, 250L and 250SP - in (mm)

ft (m)	0.025-0.030 (0.6-0.8)	0.030-0.035 (0.8-0.9)	0.035-0.045 (0.9-1.2)	0.035-3/64 (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® 300 and 400 - in (mm)

ft (m)	0.025-0.030 (0.6-0.8)	0.035-0.045 (0.9-1.2)	0.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	0.052-1/16 (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	KP44-116-15 <sup>(1)</sup>
26 (7.9)	-	KP44-3545-25	-	KP44-116-25	KP44-564-25	-

## MAGNUM® 300 and 400 - in (mm)

ft (m)	0.025-0.030 (0.6-0.8)	0.035-0.045 (0.9-1.2)	0.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	0.052-1/16 (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	KP44-116-15 <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).

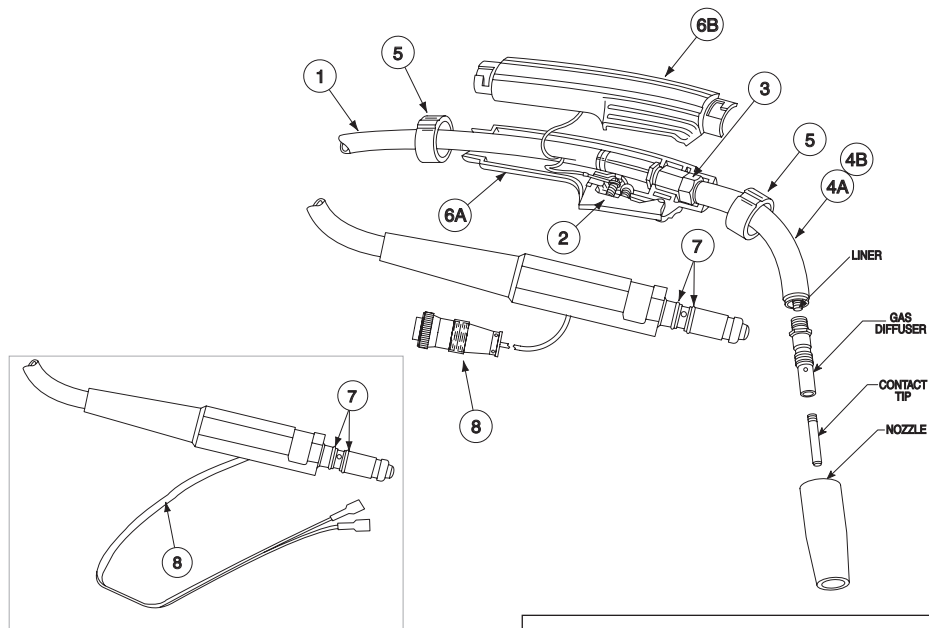


## GUN TUBES

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)	



# Magnum® 100L (Classic)

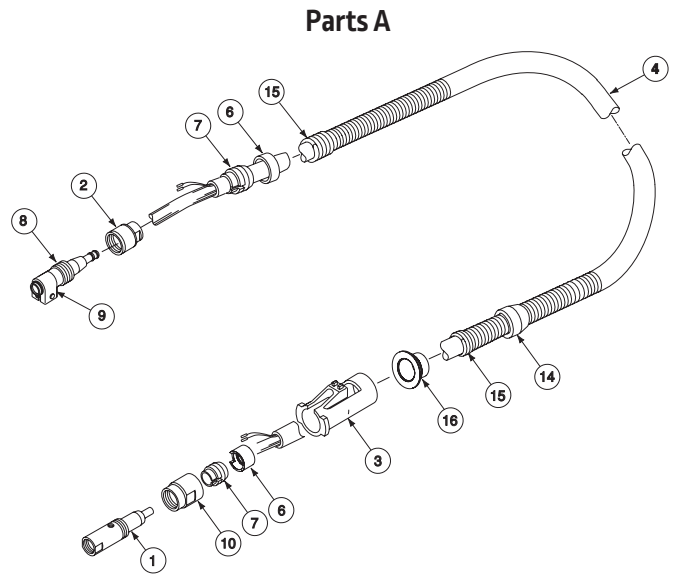
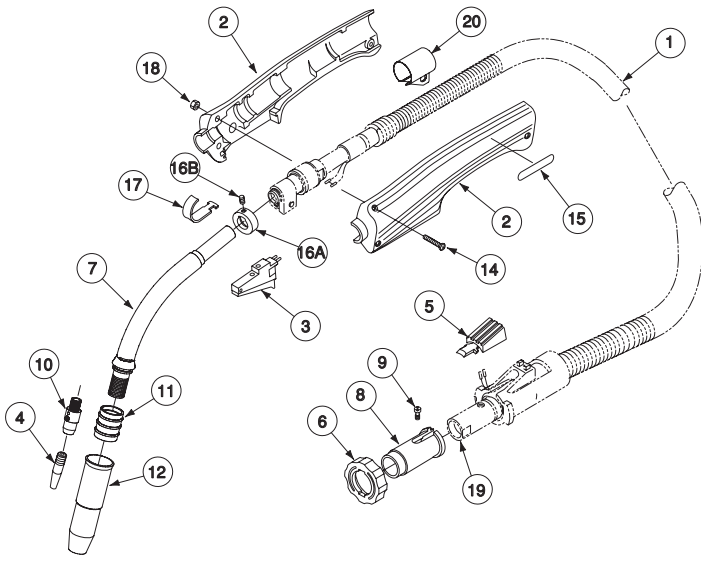


Use Items marked with 'X' in Column for desired gun

ITEM	DESCRIPTION	Part #				QTY
NEW COMPLETE GUN & CABLE ASSEMBLIES						
	Magnum 100L (4 Pin Connector)	K530-6	X	-	-	
	Magnum 100L FCAW 035-045 (Spaded Lug Connector)	K530-3	-	X	-	
	Magnum 100L GMAW 025-035 (Spaded Lug Connector)	K530-5	-	-	X	
1	Cable Assembly (4 Pin Connector)	9SM16318-2	X	-	-	1
1	Cable Assembly (Spaded Lug Connector)	9SM16318-1	-	X	X	1
2	Trigger Assembly	9SS19725	X	X	X	1
3	Locking Nut	9SS19580	X	X	X	1
4A	Gun Tube Assembly	KP2038-1	X	X	X	1
4B	Flex Tube	9ST10642-162	X	X	X	1
5	Collar	9SS19701	X	X	X	2
6	Gun Handle (Left and Right)	9SG2209	X	X	X	1
7	O Ring	9ST13483-8	X	X	X	2
8	Control Wire Cord (4 Pin Connector)	9SM16700	X	-	-	1
8	Control Wire Cord (Inset - Spaded Lug Connector)	9SS19729	-	X	X	1

Magnum Expendables page 32-34

# Magnum<sup>®</sup> 200

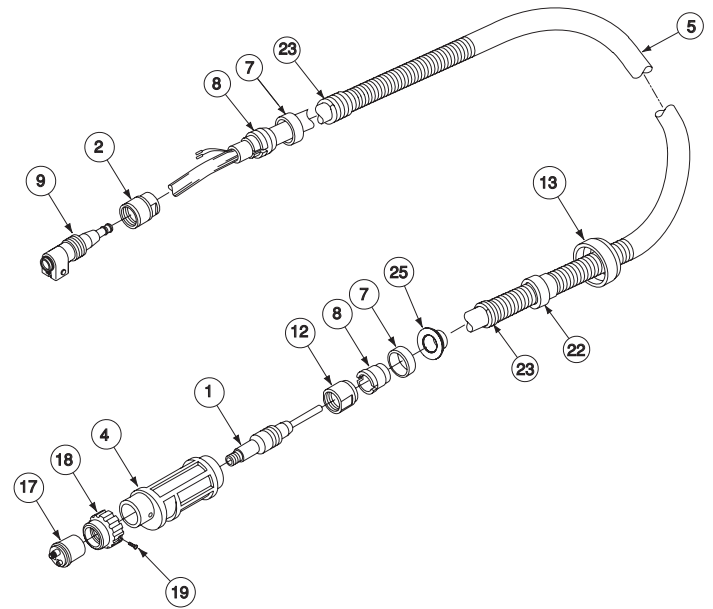
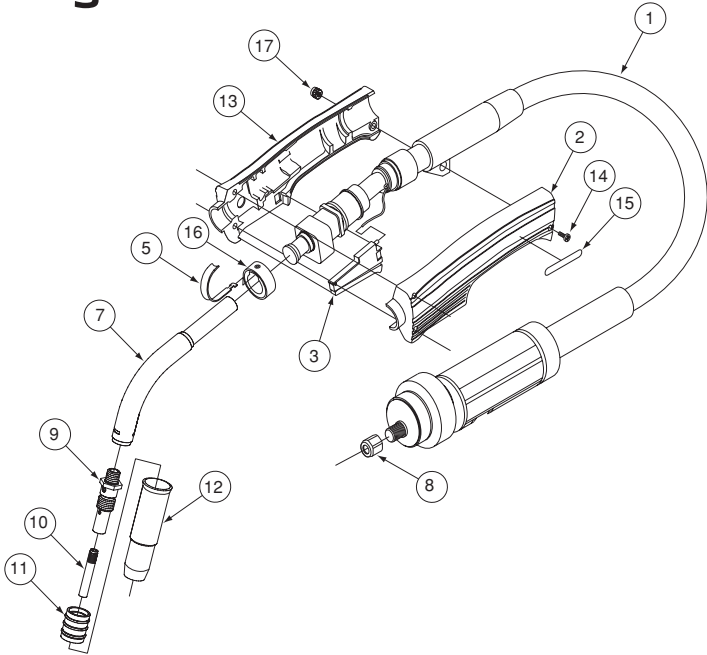


ITEM	DESCRIPTION	PART NUMBER	QTY
	Gun & Cable Asbly, Includes: (15')	K497-1	1
	Gun & Cable Asbly, Includes: (10')	K497-2	1
	Gun & Cable Asbly, Includes: (12')	K497-5	1
	(Items 4, 10, 11, 12 & 20 are Not Included in the Asbly)		
1	Connector Assembly	See Parts A	1
2	Gun Handle (Left & Right)	9SG2090	1
3	Trigger Assembly	9SS21002	1
4	Contact Tip (.035)	KP14-35	1
4	Contact Tip (.045)	KP14-45	1
4	Contact Tip (.025)	KP14-25	1
4	Contact Tip (.030)	KP14-30	1
5	Connector Cover	9SL7723	1
6	Nut (Cable Handle)	9SS18690	1
7	60° Gun Tube Assembly	KP2028-1	1
8	Tail Piece	9SM15607	1
9	Gas Plug Assembly	9SS18695	1
10	Gas Diffuser Assembly (.035-.045)	KP52	1
11	Slip on Nozzle Insulator Assembly	KP32	1
12	Gas Nozzle	KP22-50	1
14	Pan Head Screw (for Handle Assembly)	9SS18825-1	3
15	Decal (Logo)	9SS18750-4	1
	Collar Assembly, Includes:	9SS18831	1
16A	Collar	S18830	1
16B	Set Screw	9SS11604-46	1
17	Hanger	9SM15693	1
18	Handle Nut	9SS18773	3
19	15' Cable Liner (.035-.045) also used on 10' & 12'	KP42-4045-15	1
19	15' Cable Liner (.025-.030) also used on 10' & 12'	KP42-25-15	1
20	Spring Boot Retainer	9SS24719-1	1
	Options.		
	Magnum <sup>®</sup> Fast-Connect Gas Tube Kit	Order K481	
	Magnum <sup>®</sup> Connector Kit (Lincoln Feeders)	Order K466-1	
	Magnum <sup>®</sup> Connector Kit (Tweco Adapted Feeders)	Order K466-2	
	Magnum <sup>®</sup> Connector Kit Miller Feeders)	Order K466-3	
	82° Gun Tube Assembly	KP1941-1	

ITEM	DESCRIPTION	PART NUMBER	QTY
1	Incoming Connector Asbly	9SS18789-1	1
2	Connector Nut	9SS19067	1
3	Cable Handle	9SL7725	1
4	Cable Assembly	NSS	
6	Strain Relief Housing	9SS18786-1	2
7	Strain Relief	9SS18787-1	2
8	Gun Tube Connector Assembly, Includes:	9SS18655-1	1
	Gun Tube Connector	M15635-1	1
	Tube	S19363	1
	"O" Ring	9ST13483-8	1
9	Nozzle Clamp	9SS15921-1	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
10	Incoming End Nut	9SS23822-200	1
14	Sleeve	9SS24773-1	1
15	Spring Boot	9SS24676-2	2
16	Bushing	9SS24679-2	1

Magnum Expendables page 31-34

# Magnum® 200 Fast-Mate



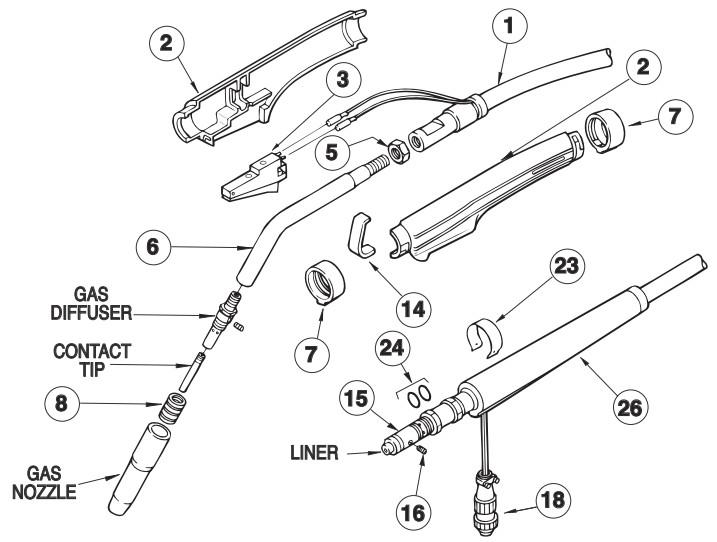
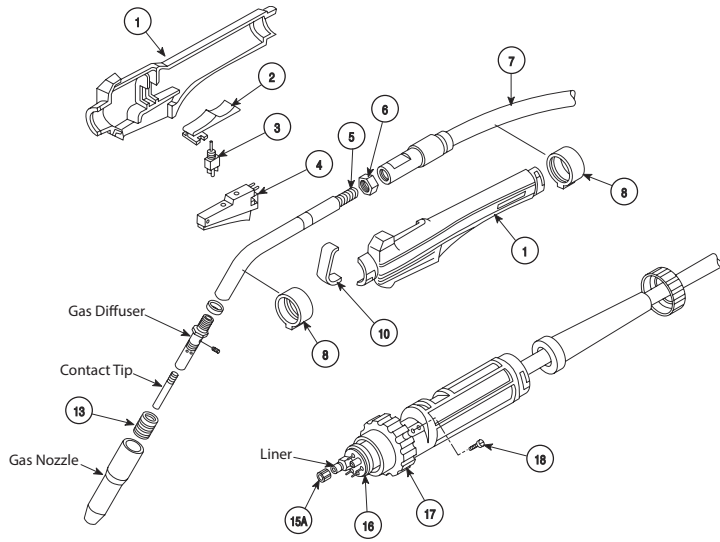
ITEM	DESCRIPTION	PART NUMBER	QTY.
Gun & Cable Asbly, Includes:		K498-1	
1	Connector Assembly	See Column B	1
2	Gun Housing (Left & Right)	9SG2090	1
3	Trigger Assembly	9SS21002	1
5	Hanger	9SM15693	1
7	Gun Tube Assembly	KP2028-1	1
8	Liner Nut	9SS18991	1
9	Gas Diffuser	Pg 33	1
10	Contact Tip	Pg 31	1
11	Slip on Nozzle Insulator	Pg 33	1
12	Gas Nozzle	Pg 32	1
14	Pan Head Screw	9SS18825-1	3
15	Decal (Logo)	9SS18750-4	1
16	Collar Assembly	9SS18831	1
17	Handle Nut	9SS18773	3
	Spring Boot Retainer	9SS24719-1	1
	Socket Key	9ST11563-4	1

ITEM	DESCRIPTION	PART NUMBER	QTY
Connector Assembly			
	[200 Amp, 10 ft. Cable] (L7996-5)	(NSS)	1
	[200 Amp, 15 ft. Cable] (L7996-6)	(NSS)	1
1	Incoming Connector Assembly	9SS19153-1	1
2	Connector Nut	9SS19067	1
4	Cable Handle	9SM15808	1
5	Cable Assembly (200 Amp, 15 ft. Cable)	9SL7761-12	1
7	Strain Relief Housing (200 Amp)	9SS18786-1	2
8	Strain Relief (200 Amp)	9SS18787-1	2
9	Gun Tube Connector Assembly, Includes:	9SS18655-1	1
	Gun Tube Connector	M15635-1	1
	"O" Ring	9ST13483-8	1
	Nozzle Clamp	9SS15921-1	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
12	Incoming Connector Nut	9SS19067	1
13	Boot Nut	9SS18930	1
17	Central Adapter Assembly	9SS18948-2	1
18	Collar Nut	9SS18929	1
19	Set Screw	9ST14731-19*	1
23	Spring Boot	9SS24676-2	2
25	Bushing	9SS24679-3	1

Magnum Expendables page 31-34

\* Obsolete

# Magnum® 250SP Magnum® 250L (Classic)



ITEM	DESCRIPTION	PART #	QTY
Gun & Cable Asbly, Includes:		K524-5	
1	Gun Handle (Left & Right)	9SG2012	1
2	Slide	9SS19075	1
3	Switch Assembly	9SS19239	1
4	Trigger Assembly	9SS18932	1
5	Gun Tube Assembly		
	45°	KP2041-1	
	60° Hard Cover	KP2015-1	
	60° Rubber Cover	KP2111-1	1
6	Locking Nut	9SS19580	1
7	Cable Asbly [12.5']	9SM15805-1	1
	Cable Asbly [15']	9SM15805-2	1
8	Collar	9SS19074	2
10	Hook	9SS19241	1
13	Slip on Nozzle Insulator	KP32	1
15a	Liner Nut	9SS18991	1
16	Central Adapter Asbly	S18948-1	1
17	Collar Nut	9SS18929	1
18	M4 x 0.70 PHS (Metric)	9ST14731-19*	1
19	Decal (Magnum 255-SP)	9SS18750-3	

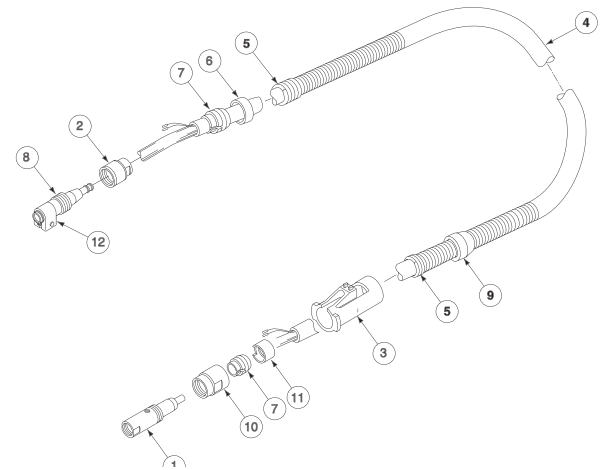
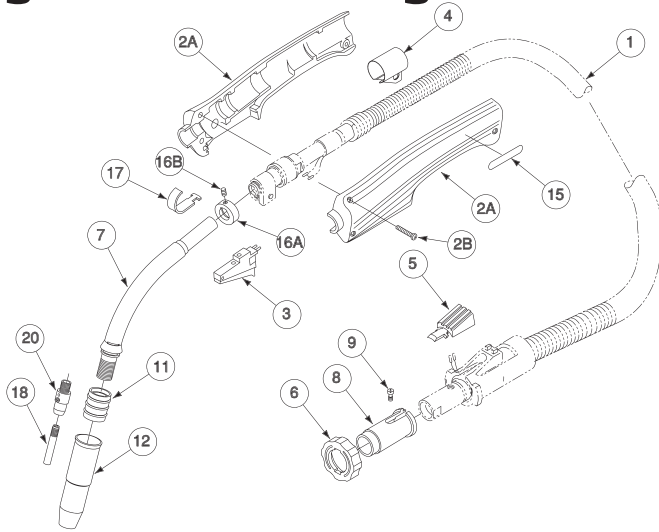
ITEM	DESCRIPTION	PART #	QTY
Gun & Cable Assembly Includes:			
2	Gun Handle (Left & Right)	9SG2217	1
3	Trigger Assembly	9SS18932	1
5	Locking Nut	9SS19580	1
6	Gun Tube Assembly		
	45°	KP2041-1	
	60° Hard Cover	KP2015-1	
	60° Rubber Cover	KP2111-1	1
7	Collar	9SS19074	2
8	Slip On Nozzle Insulator	KP32	1
14	Hook	9SS19241	1
15	Connector Assembly	9SS20280	1
16	Set Screw	9SS11604-51	1
18	Control Wire Cord	9SM16700	1
23	Clip	9SS19732	1
24	"O" Ring	9ST13483-8	2
26	Cable Boot	9SM16324	1

Magnum Expendables page 31-34

Magnum Expendables page 31-34

\* Obsolete

# Magnum® 300 & Magnum® 400



ITEM	DESCRIPTION	PART #	QTY
<b>Gun &amp; Cable Assembly:</b>			
300 Amp [See Table 1]		K470-[-]	1
400 Amp [See Table 1]		K471-[-]	1
**400 Amp [Short Neck] [See Table 1]		K541-[-]	1
1	Connector Assembly	See Parts [B]	1
2A	Gun Handle [Left & Right]	9SG1927	1
2B	Pan Head Screw (for Handle)	9SS18825-1	3
3	Trigger Assembly [Non Interlocking-Standard]	9SS21002	1
3	Trigger Assembly [Interlocking-Parts Order Only]	9SS20677 *	1
4	Spring Boot Retainer [Gun End Only]	9SS24719	1
5	Connector Cover	9SL7723	1
6	Nut [Cable Handle]	9SS18690	1
7	Gun Tube Assembly	Pg 34	1
8	Tail Piece	9SM15607	1
9	Gas Plug Assembly	9SS18695	1
11	Slip on Nozzle Insulator	Pg 33	1
12	Gas Nozzle	Pg 32	1
15	Decal 300 Amp	9SS18750-1	1
15	Decal 400 Amp	9SS18750-2***	1
16	Collar Assembly, Includes:	9SS18831	1
16A	Collar	S18830	1
16B	Set Screw	9SS11604-46	1
17	Hanger	9SM15693	1
18	Contact Tip	Pg 31	1
20	Gas Diffuser	Pg 33	1
<b>Items Not Shown:</b>			
	Cable Liners	Pg 34	1
<b>Options:</b>			
	Magnum Connector Kits	Pg 28	1
	Magnum Fast-Connect Gas Tube Kit [for K466-1]	Order K481	1

## Parts B

1	Incoming Connector Assembly	9SS18789	1
2	Connector Nut [300 Amp]	9SS18749-1	2
2	Connector Nut [400 Amp]	9SS18749-2	2
3	Cable Handle	9SL7725	1
4	Cable Assembly [Includes 4A]	NSS	
4A	Terminal [For Mating Gun Connector End]	9SS19492-1	2
5	Spring Boot	9SS24676	2
6	Strain Relief Housing	9SS18786	1
7	Strain Relief	9SS18787	2
8	Gun Tube Connector Assembly, Includes:	9SS18655	1
	Gun Tube Connector	M15635	1
	Tube	S18847	1
	"O" Ring	9ST13483-8	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
9	Spring Boot Retainer	9SS24678	1
10	Incoming End Nut [300 Amp]	9SS23822-300	1
10	Incoming End Nut [400 Amp]	9SS23822-400	1
11	Strain Relief Housing	9SS24677	1
12	Nozzle Clamp	9SS15921-1	1

## TABLE 1

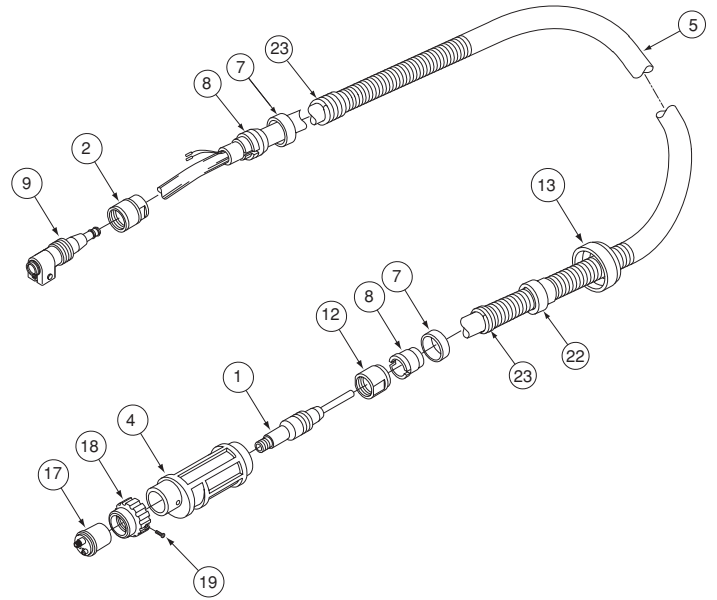
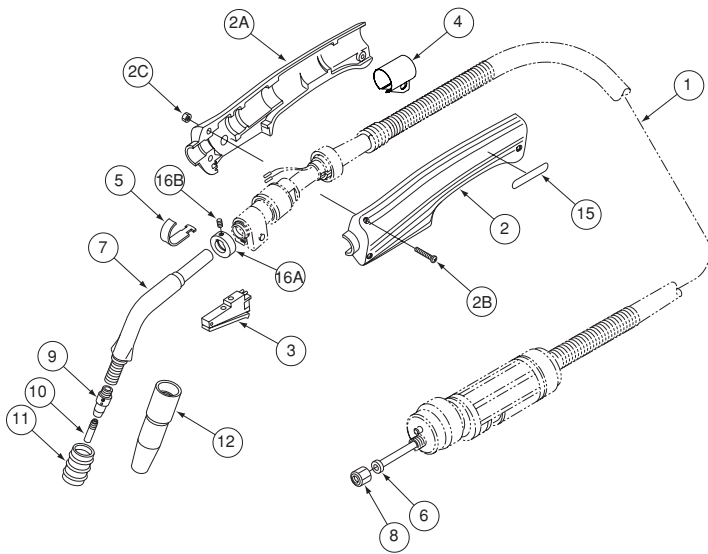
PART NO	AMP	LENGTH	WIRE SIZE	METRIC WIRE SIZE
K470-1	300	10 FT	.035-.045"	0.9-1.2
K470-2	300	15 FT	.035-.045"	0.9-1.2
K470-4	300	15 FT	.052-1/16"	1.3-1.6
K470-6	300	15 FT	1/16-5/64"	1.6-2.0
K471-1	400	10 FT	.035-.045"	0.9-1.2
K471-10	400	20 FT	.035-.045"	0.9-1.2
K471-11	400	20 FT	.052-1/16"	1.3-1.6
K471-13	400	25 FT	.035-.045"	0.9-1.2
K471-14	400	25 FT	.052-1/16"	1.3-1.6
K471-15	400	25 FT	1/16-5/64"	1.6-2.0
K471-2	400	15 FT	.035-.045"	0.9-1.2
K471-4	400	15 FT	.052-1/16"	1.3-1.6
K471-6	400	15 FT	1/16-5/64"	1.6-2.0

\*Trigger requires latest version of Gun Handles.

\*\* Comes with 300 Amp Gun Tube

\*\*\* Obsolete

# Magnum® 400 Fast Mate



ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly Includes:			
400 Amp-Specify Cable Length & Wire Size.		<b>K479-1</b>	
1	Connector Assembly	<b>See Parts B</b>	1
2	Gun Housing (Left & Right)	<b>9SG1927</b>	1
2B	Pan Head Screw	<b>9SS18825-1</b>	3
2C	Handle Nut (Knurled)	<b>9SS18773</b>	3
3	Trigger Assembly (Non Interlocking-Standard)	<b>9SS21002</b>	
3	Trigger Assembly (Interlocking-Parts Order Only)	<b>9SS20677*</b>	1
4	Spring Boot Retainer (Gun End)	<b>9SS24719</b>	1
5	Hanger	<b>9SM15693</b>	1
6	Liner Assembly	<b>Pg 31-34</b>	1
7	Gun Tube Assembly	<b>Pg 31-34</b>	1
8	Liner Nut	<b>9SS18991</b>	1
9	Gas Diffuser	<b>Pg 31-34</b>	1
10	Contact Tip	<b>Pg 31-34</b>	1
11	Slip on Nozzle Insulator	<b>Pg 31-34</b>	1
12	Gas Nozzle	<b>Pg 31-34</b>	1
15	Decal (300 Amp)	<b>9SS18750-1</b>	1
15	Decal (400 Amp)	<b>9SS18750-2**</b>	1
16	Collar Assembly, Includes:	<b>9SS18831</b>	1
16A	Collar	<b>S18830</b>	1
16B	Set Screw	<b>9SS11604-46</b>	1

Magnum Expendables page 31-34

\*\* Obsolete

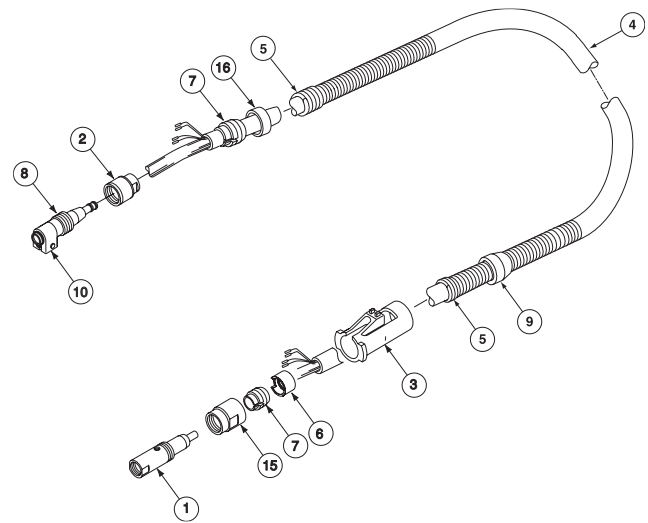
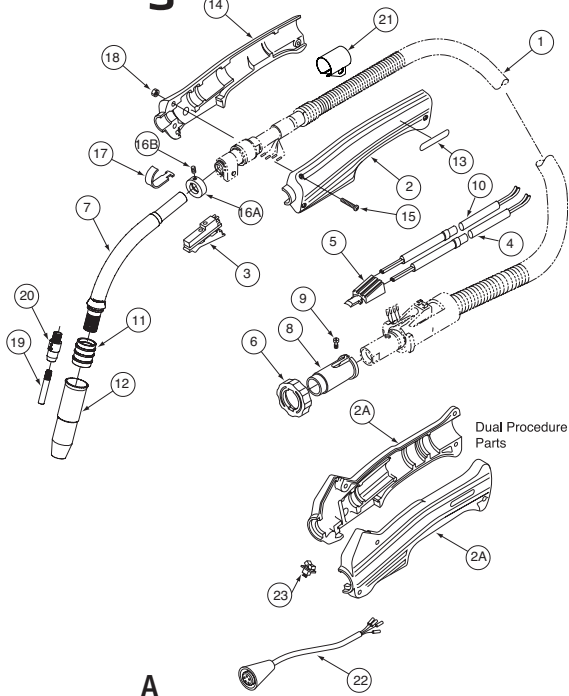
## Parts B

ITEM	DESCRIPTION	Part #	QTY
Connector Assembly Includes:			
1	Incoming Connector Assembly (300-400 Amp)	<b>9SS19153</b>	1
2	Connector Nut (300 Amp)	<b>9SS18749-1</b>	1
2	Connector Nut	<b>9SS18749-2</b>	1
4	Cable Handle	<b>9SM15808</b>	1
5	Cable Assembly		
	(300 Amp-10Ft. Cable)	<b>L7761-7</b>	1
5	(300 Amp-15Ft. Cable)	<b>L7761-8</b>	1
5	(400 Amp-10Ft. Cable)	<b>L7761-9</b>	1
5	(400 Amp-15Ft. Cable)	<b>L7761-10</b>	1
5	(300 Amp-12Ft. Cable)	<b>L7761-15</b>	1
5	(400 Amp-12Ft. Cable)	<b>L7761-16</b>	1
5	(400 Amp-20Ft. Cable)	<b>L7761-21</b>	1
5	(400 Amp-25Ft. Cable)	<b>L7761-22</b>	1
7	Strain Relief Housing (300-400 Amp)	<b>9SS18786</b>	2
8	Strain Relief (300-400 Amp)	<b>9SS18787</b>	2
9	Gun Tube Connector Assembly, Includes:	<b>9SS18655</b>	1
	Gun Tube Connector	<b>9SM15635</b>	1
	Tube	<b>9SS18847</b>	1
	"O" Ring	<b>9ST13483-8</b>	1
	Nozzle Clamp	<b>9SS15921-1</b>	1
	Clamping Screw	<b>9ST14438</b>	1
	Retaining Ring	<b>9SS9776-7</b>	1
12	Incoming Connector Nut (300 Amp)	<b>9SS19126-1</b>	1
12	Incoming Connector Nut (400 Amp)	<b>9SS19126-2</b>	1
13	Boot Nut	<b>9SS18930</b>	1
17	Central Adapter Assembly	<b>9SS18948-2</b>	1
18	Collar Nut	<b>9SS18929</b>	1
19	Set Screw	<b>9ST14731-19**</b>	1
22	Spring Boot Retainer	<b>9SS24679</b>	1
23	Spring Boot	<b>9SS24676</b>	2

\*\* Obsolete



# Magnum® 400 Dual Schedule & Procedure



A

B

ITEM	DESCRIPTION	Part #	QTY
	Magnum Dual Schedule	K574-[ ]*	
	Magnum Dual Procedure	K1722-[ ]	
1	Connector Assembly	See B	1
2	Gun Handle (Left & Right) Dual Schedule	9SG1927	1
2A	Gun Handle (Left & Right) Dual Procedure	9SG3598	1
3	Trigger Assembly (DS Std.)	9SS20124-1	1
3	Trigger Assembly (DS Interlocking)	9SS20124**	1
3	Trigger Assembly (DP Std.)	9SS21002	1
3	Trigger Assembly (DP Interlocking)	9SS20677**	1
4	Control Cable (DS only)	9SM16582-1	1
5	Connector Cover	9SL7723	1
6	Nut (Cable Handle)	9SS18690	1
7	Gun Tube Assembly	Pg 31-34	1
8	Tail Piece	9SM15607	1
9	Gas Plug Assembly	9SS18695	1
10	Control Cable (DS only)	9SM16582-2	1
11	Slip On Nozzle Insulator	Pg 31-34	1
12	Gas Nozzle	Pg 31-34	1
13	Decal	9SS18750-2***	1
15	Pan Head Screw	9SS18825-1	3
	Collar Assembly	9SS18831	1
16A	Collar	9SS18830	1
16B	Set Screw	9SS11604-46	1
17	Hanger	9SM15693	1
18	Handle Nut	9SS18773	3
19	Contact Tip	Pg 31-34	1
20	Gas Diffuser Assembly	Pg 31-34	1
21	Spring Boot Retainer (DS only)	9SS24719	1
22	Control Cable	9SM19313	1
23	Rocker Switch	9SS24514	1

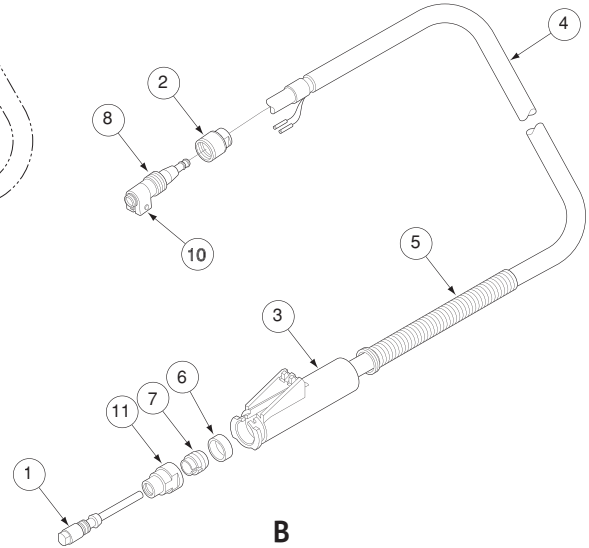
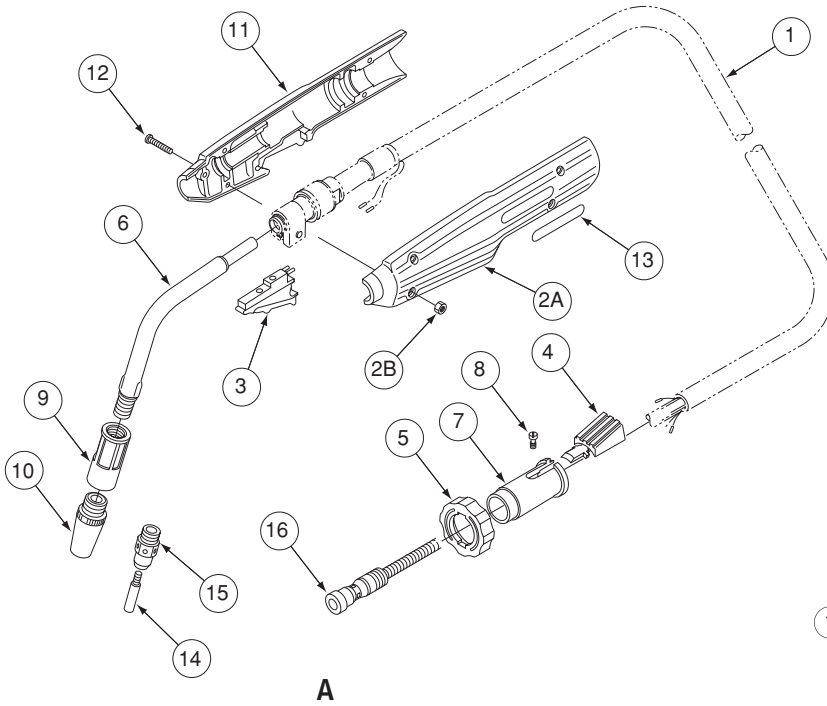
ITEM	DESCRIPTION	Part #	QTY
	Connector Assembly(400DS/15 Ft. Cable), Includes:	L8562-1	
	Connector Assembly(400DS/25 Ft. Cable), Includes:	L8562-2	
	Connector Assembly(400DP/15 Ft. Cable), Includes:	L8562-3	
	Connector Assembly(400DP/10 Ft. Cable), Includes:	L8562-4	
	Connector Assembly(400DP/25 Ft. Cable), Includes:	L8562-5	
1	Incoming Connector Assembly	9SS18789	1
2	Connector Nut	9SS18749-2	2
3	Cable Handle	9SL8564	1
4	Cable Assembly(400 DS/15 Ft. Cable)	L8561-1	1
4	Cable Assembly(400 DS/25 Ft. Cable)	L8561-2	1
4	Cable Assembly(400 DP/15 Ft. Cable)	L11057-1	1
4	Cable Assembly(400 DP/10 Ft. Cable)	L11057-2	1
4	Cable Assembly(400 DP/25 Ft. Cable)	L11057-3	1
5	Spring Boot	9SS24676	1
6	Strain Relief Housing	9SS18786	2
7	Strain Relief	9SS18787	2
8	Gun Tube Connector Assembly, Includes:	9SS18655	1
	Gun Tube Connector	M15635	1
	Tube	S18847	1
	"O" Ring	9ST13483-8	1
10	Nozzle Clamp	9SS15921-1	1
	Clamping Screw	9ST14438	1
	Retaining Ring	9SS9776-7	1
9	Spring Boot Retainer	9SS24678	1
15	Incoming End Nut	9SS23822-400	1
16	Strain Relief Housing	9SS24677	1

\* To be discontinued.

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

\*\*\* Obsolete

# Magnum® 550

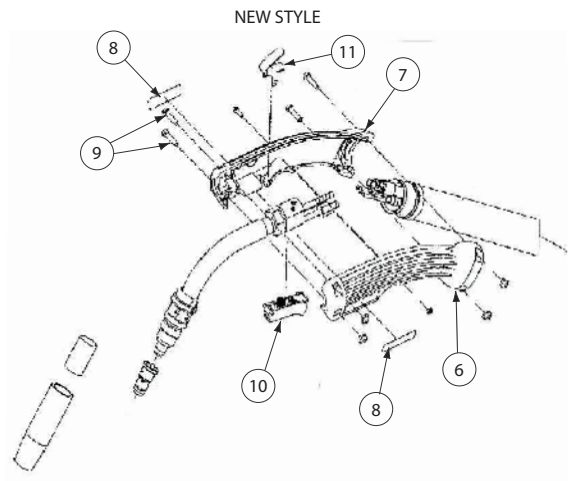
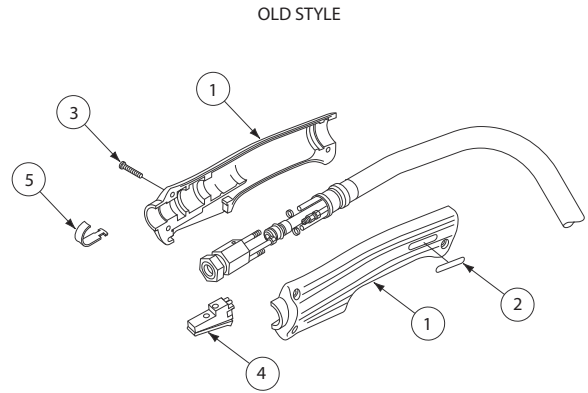
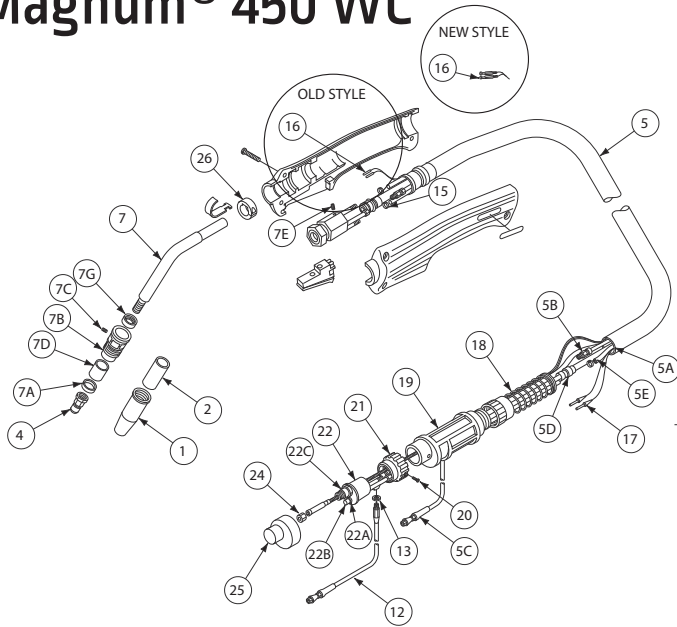


ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Asbly, Includes:		<b>K598-[ ]</b>	
1	Connector Assembly	See B	1
2A	Gun Housing (Left & Right)	95G2480	1
2B	Handle Nut	95S18773	4
3	Trigger Asbly (Standard)	95S20677-1	1
3	Trigger Asbly (Interlocking)	95S20677	1
4	Connection Cover	95L7723	1
5	Nut (Cable Handle)	95S18690	1
6	Gun Tube Assembly	See Pg 34	1
7	Tail Piece	95M15607	1
8	Gas Plug Assembly	95S18695	1
9	Insulator Assembly	See Pg 31-34	1
10	Gas Nozzle	See Pg 31-34	1
12	Pan Head Screw	95S18825-1	4
13	Decal	95S20676	1
14	Contact Tip	See Pg 31-34	1
15	Gas Diffuser	See Pg 31-34	1
16	Cable Liner	See Pg 31-34	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	95S20696	1
2	Connector Nut	95S20675	1
3	Cable Handle	95L8990	1
4	Cable Asbly (10Ft. Cable)	L9046-1	1
4	Cable Asbly (12Ft. Cable)	L9046-2	1
4	Cable Asbly (15Ft. Cable)	L9046-3	1
4	Cable Asbly (25Ft. Cable)	L9046-4	1
5	Cable Boot	95M17003	1
6	Strain Relief Housing	95S18786-2	1
7	Strain Relief	95S20695	1
8	Gun Tube Connector Assembly, Includes:	95S18655-2	1
	"O" Ring	95T13483-8	1
10	Nozzle Clamp	95S15921-1	1
	Clamping Screw	95T14438	1
	Retaining Ring	95S9776-7	1
	Set Screw	95S11604-22	1
11	Connector Nut	95S22506	1
	Terminal (Feeder End)	95S19492-1	2
	Terminal (Gun End)	95S19492-2	2

Magnum Expendables page 31-34

# Magnum® 450 WC



ITEM	DESCRIPTION	Part #	QTY
1	NOZZLE GAS FIXED-1/8 RECESS .59 ID	KP1957-4	1
2	INSULATOR GAS NOZZLE MAGNUM 450WC	KP2060-1	1
4	DIFFUSER MAGNUM 450WC GUN	KP2059-1	1
5	4.5M HOSE/CABLE ASBLY	9SS22333-4	1
5A	4.5M OUTER SHEATH	9SS22333-4A	1
5B	4.5M POWER CABLE	9SS22333-4B	1
5C	4.5M WATER HOSE	9SS22333-4C	1
5D	4.5M WIRE GUIDE CONDUIT	9SS22333-4D	1
5E	4.5M GAS HOSE	9SS22333-4E	1
7	60 GUN TUBE (WATER COOLED)	9SS24298-7	1
7A	GUN TUBE INSULATION	9SS22333-7A	1
7B	NOZZLE HOLDER	9SS24298-7B	1
7C	SET SCREW (M4 X .7 X 4)	9SS24298-7C	2
7D	CERAMIC INSULATOR	9SS22333-7D	1
7E	ALLEN SCREW M6X6	9SS22333-7E	1
7G	INSULATION RING	9SS24298-7G	1
12	WATER HOSE	9SS22333-12	1
13	SEALING WASHER	9SS22333-13	1
	O RING	9SS22333-14	1
15	HOSE CLAMP	9SS22333-15	1
16	TERMINAL CRIMP DETAIL	9SS19492-2	2
17	SWITCH CONTROL LEAD 4.5M	9SS22333-17B	2
18	CABLE SUPPORT	9SS22333-18	1
19	ADAPTOR SUPPORT	9SS22333-19*	1
20	METRIC PAN HD SCREW	9ST14731-19*	1
21	COLLAR NUT	9SS18929	1
22	CENTRAL ADAPTOR BLOCK	9SS22333-22	1
22A	INSULATION	9SS22228	2
22B	CONTACT PIN	9SS22239	2
22C	LINER NIPPLE	9SS22333-23	1
24	LINER NUT	9SS18991	1
25	PROTECTION CAP	9SS20623*	1
26	SPLIT COLLAR	9SS24298-5	1
	HEX HEAD CAP SCREW (M3 X.5 X 10)	9SS24298-6	2

ITEM	DESCRIPTION	Part #	QTY
6	HANDLE LEFT	9SS22333-24	1
7	HANDLE RIGHT	9SS22333-25	1
8	STICKER "MAGNUM 453 WC"	9SS22333-26	2
9	HARDWARE PACK	9SS22333-27	1
10	TRIGGER SWITCH BLACK COMPL.	9SS22333-28	1
11	GUN SUSPENSION HOOK	9SS22333-29	1

\* Obsolete

# Push Pull & Spool Gun Adapters & Accessories

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	Magnum PRO AL Pistol K3478-1,2,3 K3479-1,2	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	N/A
SP-150	N/A	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	N/A
SP-200	N/A	N/A	95S19857	N/A	N/A	N/A	N/A	N/A
SP-250	N/A	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	N/A
Wirematic 250	N/A	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	N/A
POWER MIG 140	Direct Connect	Direct Connect	N/A	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	N/A
POWER MIG 180 Dual	Direct Connect	Direct Connect	N/A	N/A	N/A	N/A	N/A	N/A
POWER MIG 210MP	Direct Connect	Direct Connect	N/A	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	N/A
POWER MIG 216	Direct Connect	Direct Connect	K2703-1	K2703-1	N/A	N/A	N/A	N/A
POWER MIG 255	N/A	N/A	K2310-1	K2310-1	N/A	N/A	N/A	N/A
POWER MIG 255C	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A	N/A
POWER MIG 255XT	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A	N/A
POWER MIG 256	N/A	N/A	K2445-1	Direct Connect	N/A	N/A	N/A	N/A
POWER MIG 260	N/A	N/A	K2445-1	Direct Connect	7 pin 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	N/A
POWER MIG 350MP	N/A	N/A	N/A	Direct Connect	12 pin Direct Connect 7 pin - K2910-1	Direct Connect	Direct Connect	Direct Connect
Power Wave C300	N/A	N/A	N/A	K2910-1	12 pin Direct Connect 7 pin - K2910-1	K2910-1	K2910-1	K2910-1

N/A = Not Available

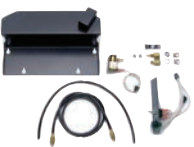
**K2445-1**  
Magnum® SG Spool Gun  
Control Cable Adapter Plug

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.]



**K2910-1**  
7-pin to 12-pin Adapter

Use for connecting 7-pin push-pull guns such as the Magnum® Pro AL and the Python®-Plus to the new 12-pin connector.



**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.



**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.



All other LINCOLN coolers use a 50/50 mix of Ethylene Glycol available at: Cole Parmer at 1800 323 4340 Witeg Scientific 1888 419 4834

**K4816-1**  
FlexCool™ 35

A cooler designed for Plasma Arc Cutting and specifically designed to integrate with the FlexCut® 200 system.



**K3086-1**  
Cool Arc® 55 Water Cooler

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.



**K3950-1**  
Cool Arc® 47 Water Cooler

Designed to integrate directly with the Aspect™ 375 power source. Use only STARBRITE coolant [KP4159-1].

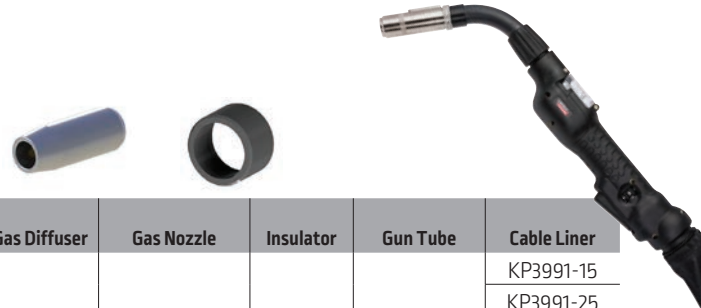


**KP4159-1**  
One Gallon of Low Conductivity Coolant

Recommended for the new Cool Arc® 47 Water Cooling System



# Magnum<sup>®</sup> PRO AL Push-Pull Guns



## STOCK CONFIGURATIONS

Model	Pin Style	Product Number Front Trigger	Product Number Rear Trigger	Gun Cable Length - ft (m)	Contact Tips	Gas Diffuser	Gas Nozzle	Insulator	Gun Tube	Cable Liner
G225A Air Cooled	7 PIN	K3421-1	K3356-1	15 [4.5]	KP2745-364AT 3/64 [1.2]	KP2747-1A	KP2743-1-62R	KP3982-1	KP3380-45	KP3991-15
		K3421-2	K3356-2	25 [7.6]						KP3991-25
		K3421-3	K3356-3	35 [9.1]						KP3991-35
		K3421-4	K3356-4	50 [15.2]						KP3991-50
G450W Water Cooled	7 PIN	K3423-1	K3358-1	15 [4.5]		N/A Water Cooled	KP3375-1	KP3982-2	KP3381-60	KP3991-15
		K3423-2	K3358-2	25 [7.6]						KP3991-25
		K3423-3	K3358-3	35 [9.1]						KP3991-35
		K3423-4	K3358-4	50 [15.2]						KP3991-50
G225A Air Cooled	12 PIN	K3420-1	K3355-1	15 [4.5]		KP2747-1A	KP2743-1-62RA	KP3982-1	KP3380-45	KP3991-15
		K3420-2	K3355-2	25 [7.6]						KP3991-25
		K3420-3	K3355-3	35 [9.1]						KP3991-35
		K3420-4	K3355-4	50 [15.2]						KP3991-50
G450W Water Cooled	12 PIN	K3422-1	K3357-1	15 [4.5]	N/A Water Cooled		KP3375-1	KP3982-2	KP3381-60	KP3991-15
		K3422-2	K3357-2	25 [7.6]						KP3991-25
		K3422-3	K3357-3	35 [9.1]						KP3991-35
		K3422-4	K3357-4	50 [15.2]						KP3991-50

## CONTACT TIPS

Wire Diameter in (mm)	350A		550A		550A Spring Loaded
	Pkg. Qty. -10	Pkg. Qty.-100	Pkg. Qty.-10	Pkg. Qty-100	
0.035 [0.9]	KP2744-035AT	-	KP2745-035AT	-	KP3374-035A
3/64 [1.2]	KP2744-364AT KP2744-364AT5356	KP2744-364AT-B100	KP2745-364AT KP2745-364AT5356	KP2745-364AT-B100	KP3374-364A
1/16 [1.6]	KP2744-116AT	KP2744-116AT-B100	KP2745-116AT KP2745-116AT5356	KP2745-116AT-B100	KP3374-116A

## OPTIONAL 6" GUN TUBES

Compatible Guns	Degree	Order Number
<b>350A/550A Expendables Compatibility/Threaded Diffuser</b>		
Straight, Air- & Water-Cooled	180°	KP3380-180
Air- & Water-Cooled	60°	KP3380-60
Air- & Water-Cooled	45°	KP3380-45 <sup>(3)</sup>
<b>550A Expendables ONLY/Fixed Diffuser</b>		
Straight & Water-Cooled Gun Tube Assembly	180°	KP3381-180 <sup>(1)</sup>
Water-Cooled Gun Assembly	60°	KP3381-60 <sup>(4)</sup>
Water-Cooled Gun Assembly	45°	KP3381-45 <sup>(1)</sup>
Straight, Air- & Water-Cooled	180°	KP3988-180 <sup>(2)</sup>
Air- & Water-Cooled	60°	KP3988-60 <sup>(2)</sup>
Air- & Water-Cooled	45°	KP3988-45 <sup>(2)</sup>

- (1) Water-Cooled ONLY. Diffuser and nozzles are both water cooled. Use with water-cooled nozzle KP3375-1.
- (2) Diffuser is water-cooled. Nozzle is standard air-cooled Magnum PRO 550A Expendable (KP2743-1-62RA)
- (3) Included with K3355-XX and K3356-XX guns
- (4) Included with K3357-XX and K3358-XX guns

## MAINTENANCE COMPONENTS

Liner Package  
Magnum PRO  
KP3376-1



- 1/16" [1.6mm] Jump Liner  
KP3376-1
- 0.035 - 3/64" [0.9 - 1.2mm] Jump Liner  
KP3376-3

Knurled Insulated Drive Roll  
KP3990-1



KP3989-1  
Insulated Groove Drive Roll Kit  
For .035" [0.9mm] dia. and .040" [1.0mm] dia. aluminum wire. Includes insulated groove drive roll and insulated idler roll Assy.



KP3989-2  
Insulated Groove Drive Roll Kit  
For 3/64" [1.2mm] dia. and .062" [1.6mm] dia. aluminum wire. Includes insulated groove drive roll and insulated idler roll Assy.



Insulated Idler Roll  
KP3992-1 [3/64 wire]  
KP3992-035 [0.035 wire]  
KP3992-116 [1/16 wire]

Micro Switch Assembly  
S29830-47



Trigger Kit - S29830-48  
Trigger adjustment kit includes a spring and sensitivity adjustment screw replacement.

Coolant, 1 Gallon - KP3379-4  
Order in multiples of 4

Coolant, 5 Gallon - KP3379-5

O-Ring Kit - S29830-83

Hardwares Kit - S29830-51

Noalox Kit - S29830-52

## TOOLS & ADAPTERS

Tool Wrench 3/8" Torch Tip  
K3986-1



Drive Roll Removal Tool  
K3987-1



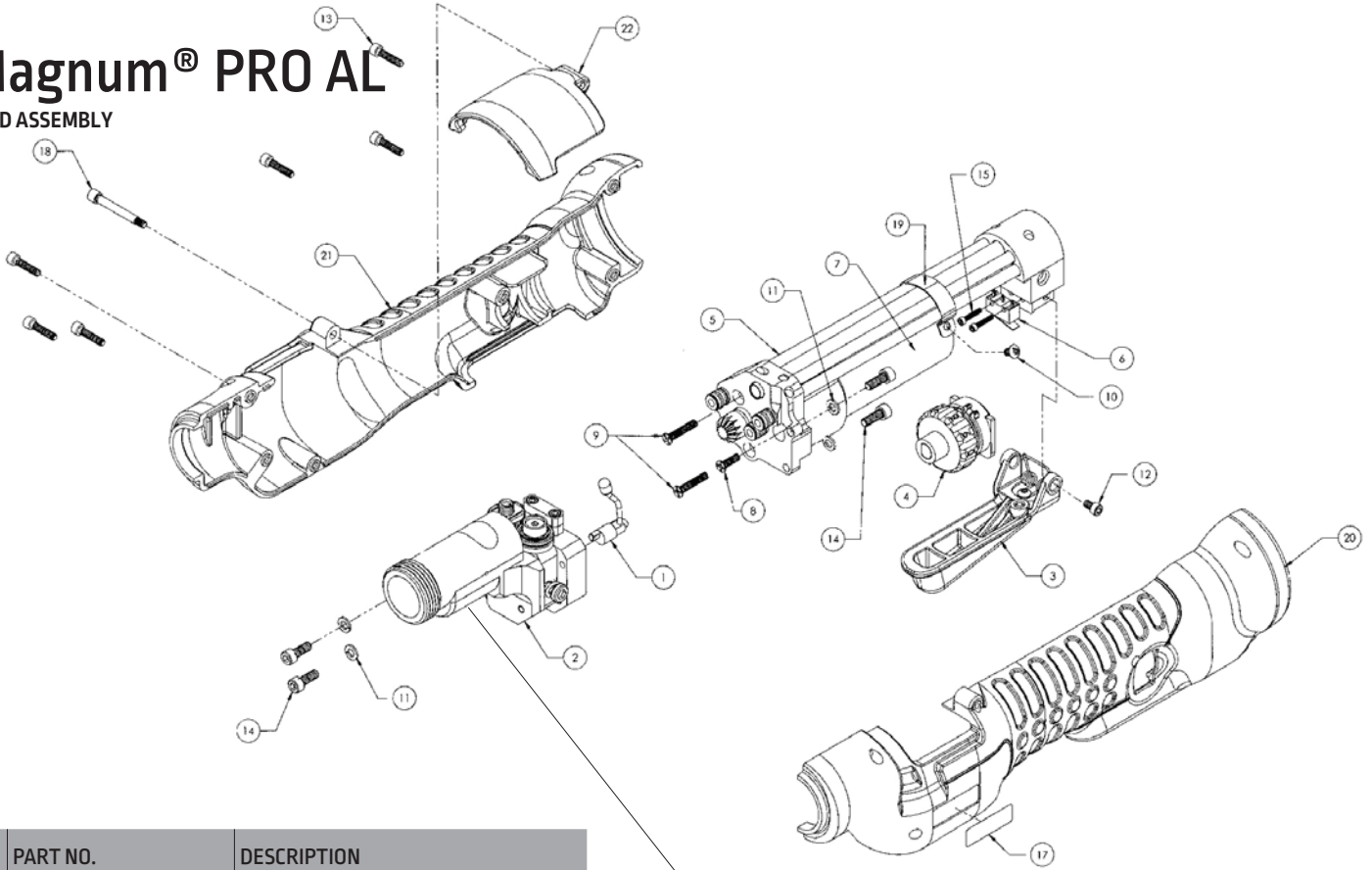
7-pin to 12-pin  
Adapter  
K2910-1, K2910-2

Use for connecting 7-pin push-pull guns such as the Magnum<sup>®</sup> PRO AL to a 12-pin connector in the Power Wave<sup>®</sup> C300.



# Magnum® PRO AL

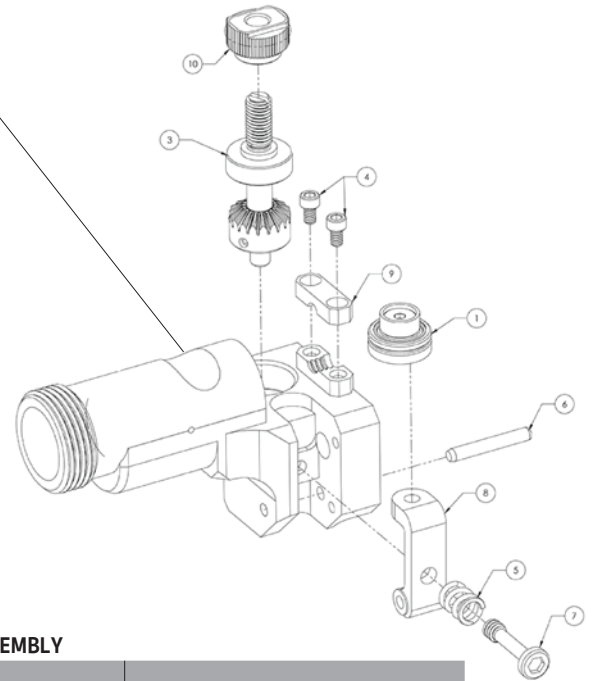
## HEAD ASSEMBLY



NO.	PART NO.	DESCRIPTION
1	9SS29830-1	Cam Idler Arm Assembly
2	9SS29830-6	Front Body Assembly, A/W
3	9SS29830-48	Trigger Assembly
4	9SS29830-50	Pot Assembly Kit
5	9SS29830-10	Rear Body Assembly
6	9SS29830-47	Micro Swx Assembly
7	9SS29830-13	Motor 24VDC, Standard
8	included in 9SS29830-51	Scr FH Phil 82 4-40 x 3/8 SST
9	included in 9SS29830-51	Scr FH Phil 82 4-40 5/8 SST
10	included in 9SS29830-51	Scr Button 4-40 x 1/2 SST
11	included in 9SS29830-51	Washer SPR LK #6 SST
12	included in 9SS29830-51	Scr Soc. HD Cap #4-40, SST
13	included in 9SS29830-45	Screw SHC 4-40 x 1/2 SST
14	included in 9SS29830-51	Scr SHC 6-32 x 3/8 SST
15	included in 9SS29830-51	Scr Soc HD Cap #1-72 x 3/8 LG SST
17	9SS29830-98	Handle Decal
18	included in 9SS29830-45	Scr Shoulder 1/8, Door MX
19	9SS29830-85	Strap Motor
20	included in 9SS29830-45	Kit Handle Magnum® Pro AL Gun: includes item 13, 17, 18 and 22
21	included in 9SS29830-45	Kit Handle Magnum® Pro AL Gun: includes item 13, 17, 18 and 22
22	9SS29830-15	Door

### CABLE COVERS

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

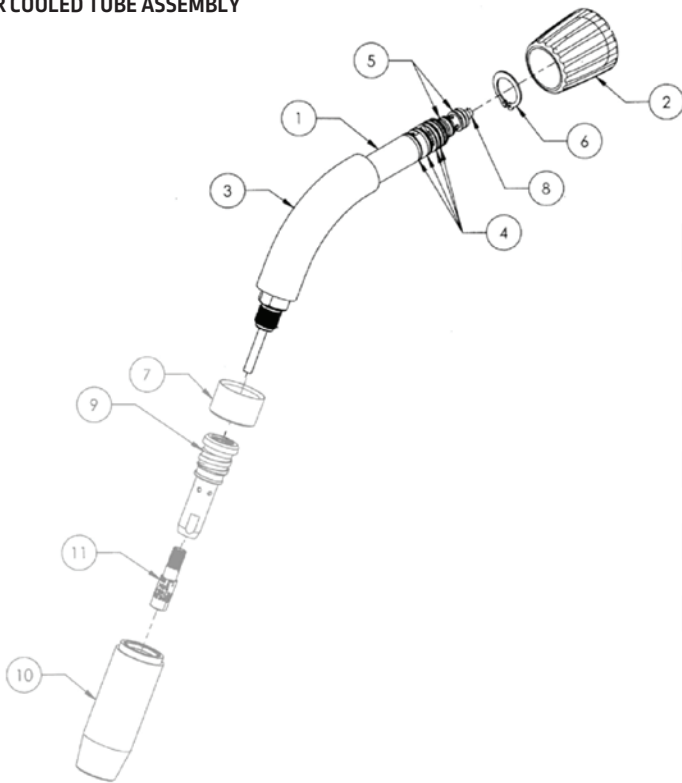


### FRONT BODY ASSEMBLY

NO.	PART NO.	DESCRIPTION
1	KP3992-1	Idler Roll Insulated Knurl Assembly
4	included in 9SS29830-51	Scr Soc. HD. Cap #4-40 SST
5	9SS29830-88	0.29 x 0.047 x 0.32 Comp. Spring
6	9SS29830-89	1/8 x 7/8 SST Dowel Pin
7	included in 9SS29830-51	Idler Adjusting Screw
8	9SS29830-86	Idler Arm
9	9SS29830-87	Clamp Body
10	KP3990-1	Drive Roll Insulated Knurl Assembly

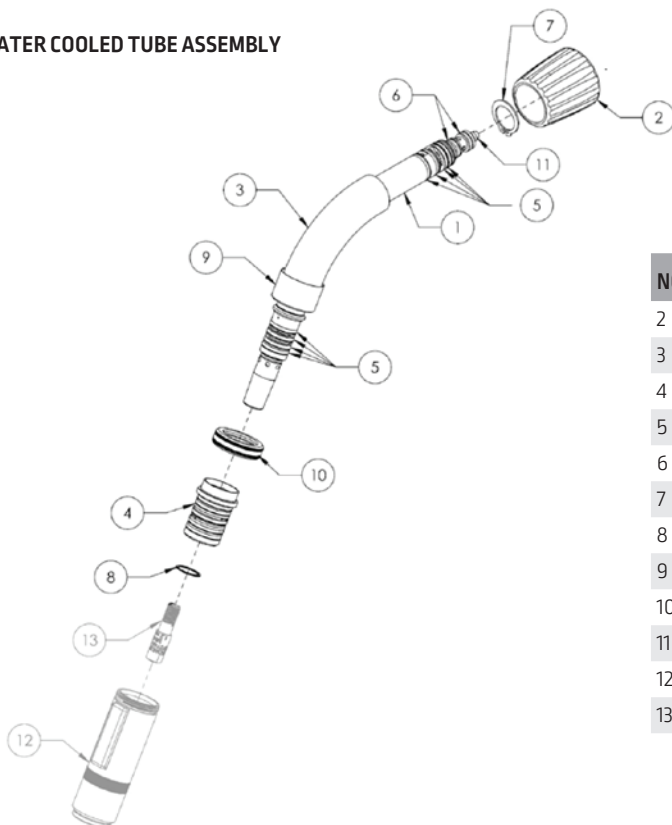
# Magnum® PRO AL continued

## AIR COOLED TUBE ASSEMBLY



NO.	PART NUMBER	DESCRIPTION
2	included in 9SS29830-49	Nut Gun Tube Assembly
3	included in 9SS29830-49	Insulator Gun Tube
4	included in 9SS29830-83	O-Ring 0.489ID x 0.07W
5	included in 9SS29830-83	O-Ring 0.301ID x 0.07W
6	S29830-90	Ring Ret Ext 1/4OD x 0.023W
7	See pg 45	Insulator
8	KP3376-1	Liner Package
9	See pg 45	Gas Diffuser
10	See pg 45	Gas Nozzle
11	See pg 45	Contact Tip

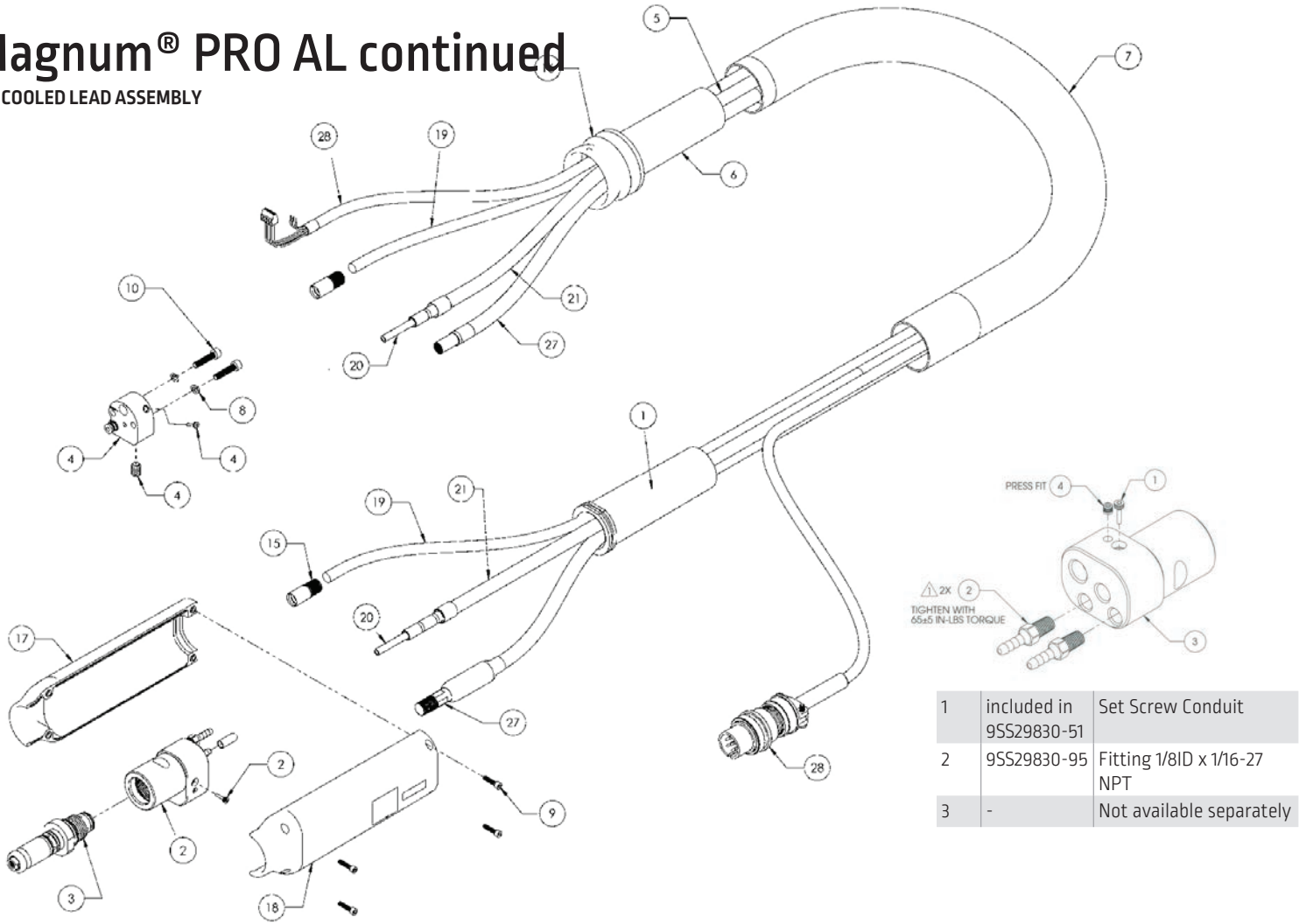
## WATER COOLED TUBE ASSEMBLY



NO.	PART NUMBER	DESCRIPTION
2	included in 9SS29830-49	Nut Gun Tube Assembly
3	included in 9SS29830-49	Insulator Gun Tube
4	9SS29830-92	Insulator Nozzle with Five O-Rings
5	included in 9SS29830-83	O-Ring .489 ID x .07 W
6	included in 9SS29830-83	O-Ring .301 ID x .07 W
7	9SS29830-90	Retaining Ring 5/8 Shaft
8	9SS29830-91	Ring Ret 0.500 Dia Shaft Spiral SST
9	See pg 45	Insulator
10	9SS29830-93	Retaining Nut W/C
11	KP3376-1	Liner Package
12	See pg 45	Gas Nozzle
13	See pg 45	Contact Tip

# Magnum® PRO AL continued

## AIR COOLED LEAD ASSEMBLY



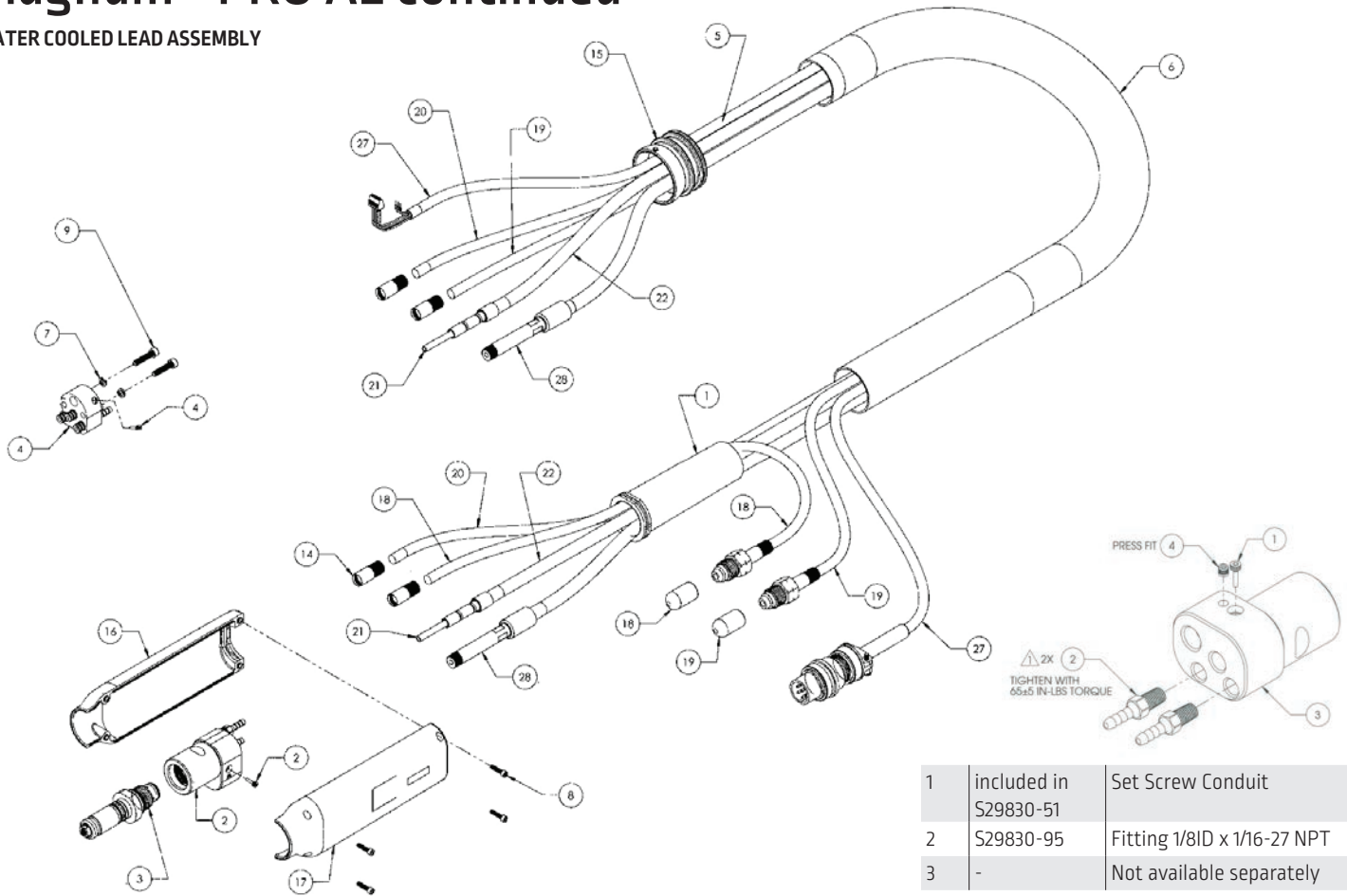
1	included in 95S29830-51	Set Screw Conduit
2	95S29830-95	Fitting 1/8ID x 1/16-27 NPT
3	-	Not available separately

NO.	DESCRIPTION	15' PART NO.	25' PART NO.	35' PART NO.	50' PART NO.
1	Boot Torch Assembly			95S29830-2	
2	Power Manifold Assembly, A/W			95S29830-3	
3	Power Pin Adapter Assembly			95S29830-5	
4	Rear Connector Assembly, A/C			95S29830-9	
5	Wrap Spiral Cord, 13 in			95S29830-94	
6	Boot Torch			95S29830-99	
7	Cable Cover	KP3378-15	KP3378-25	KP3378-35	KP3378-50
8	Washer Split Lock 0.270D x 0.171D x 0.04 thk			included in 95S29830-51	
9	Screw SHC 4-40 x 1/2 SST			included in 95S29830-46	
10	Scr Shc 8-32 x 3/4 SST			included in 95S29830-51	
15	Retainer 5/16 Hose			95S29830-14	
16	Swivel Joint Molded			95S29830-11	
17	Handle Kit: Includes item 9			95S29830-46	
18	Handle Kit: Includes item 9			95S29830-46	
19	Gas Hose	95S29830-21	95S29830-22	95S29830-23	95S29830-24
20	Conduit Liner	KP3991-15	KP3991-25	KP3991-35	KP3991-50
21	Teflon Tube Conduit Assembly	95S29830-25	95S29830-26	95S29830-27	95S29830-28
24	Compound Joint Noalox Kit			S29830-52	
27	Power Cable Assembly Global	95S29830-29	95S29830-30	95S29830-31	95S29830-32
28	Controller Cable Assembly (Models K3356, K3358)	95S29830-41	95S29830-42	95S29830-43	95S29830-44
28	Controller Cable Assembly (Models K3355, K3357)	95S29830-37	95S29830-38	95S29830-39	95S29830-40



# Magnum® PRO AL continued

## WATER COOLED LEAD ASSEMBLY



1	included in S29830-51	Set Screw Conduit
2	S29830-95	Fitting 1/8ID x 1/16-27 NPT
3	-	Not available separately

NO.	DESCRIPTION	15' PART NO.	25' PART NO.	35' PART NO.	50' PART NO.
1	Boot Torch Assembly		95S29830-2		
2	Power Manifold Assembly, A/W		95S29830-3		
3	Power Pin Adapter Assembly		95S29830-5		
4	Rear Connector Assembly W/C S		95S29830-12		
5	Wrap Spiral Cord, 13 in		95S29830-94		
6	Cable Cover	KP3378-15	KP3378-25	KP3378-35	KP3378-50
7	Washer Split Lock, 0.27OD x 0.17ID x 0.04 THK		included in 95S29830-51		
8	Screw SHC 4-40 x 1/2 SST		included in 95S29830-46		
9	SCR SHC 8-32 x 3/4 SST		included in 95S29830-51		
14	Hose Retainer, 5/16		95S29830-14		
15	Swivel Joint Molded Magnum® Pro AL Gun		95S29830-11		
16	Handle Kit: includes item 8		95S29830-46 17		
18	Hose Water Assembly RED		95S29830-16		
19	Hose Water Assembly, BLUE	95S29830-17	95S29830-18	95S29830-19	95S29830-20
20	Gas Hose Assembly	95S29830-21	95S29830-22	95S29830-23	95S29830-24
21	Conduit Liner	KP3991-15	KP3991-25	KP3991-35	KP3991-50
22	Conduit Tef Tube	95S29830-25	95S29830-26	95S29830-27	95S29830-28
24	Compound Joint Noalox Kit		S29830-52		
27	Controller Cable Assembly (Models K3356, K3358)	95S29830-41	95S29830-42	95S29830-43	95S29830-44
27	Controller Cable Assembly (Models K3355, K3357)	95S29830-37	95S29830-38	95S29830-39	95S29830-40
28	Power Cable/Water Euro Assembly	95S29830-33	95S29830-34	95S29830-35	95S29830-36

# Magnum<sup>®</sup> PRO AL Pistol Guns

550A EXPENDABLES ARE STANDARD WITH THE MAGNUM<sup>®</sup> PRO AL PISTOL.



CONTACT TIPS 350A	
Wire Diameter in. (mm)	Order Number
0.035 (0.9)	KP2744-035AT
3/64 (1.2)	KP2744-364AT KP2744-364AT5356 KP2744-364AT-B100 <sup>(1)</sup>
	KP2744-116AT KP2744-116AT5356 KP2744-116AT-B100 <sup>(1)</sup>

(1) Sold in quantity of 100

CONDUIT LINERS, ALUMINUM	
Description ft (m)	Order Number
Liner, .035-1/16", Aluminum, 15 [4.5]	KP3543-35116-15
Liner, .035-1/16", Aluminum, 25 [7.6]	KP3543-35116-25
Liner, 3/64-1/16", Aluminum, 35 [10.7]	KP3543-364116-35
Liner, 3/64-1/16", Aluminum, 50 [15.2]	KP3543-364116-50

GUN TUBE ASSEMBLIES		
Cooling System	Degree	Order Number
Air-Cooled	180°	KP3541-180 <sup>(1)</sup>
Air-Cooled	60°	KP3541-60 <sup>(2)</sup>
Air-Cooled	45°	KP3541-45 <sup>(3)</sup>
Water-Cooled	180°	KP3542-180 <sup>(2)</sup>
Water-Cooled	60°	KP3542-60 <sup>(3)</sup>
Water-Cooled	45°	KP3542-45 <sup>(3)</sup>

(1) Included with K3478-XX guns  
 (2) Included with K3479-XX guns  
 (3) 9553244-22 and KP2879-3 required for assembly

350A SERIES EXPENDABLES	
Description	Order Number
Gas Diffuser, each	KP2746-1
Gas Diffuser, 25 pcs.	KP2746-1-B25
Insulator, 350A Gun Tube, each	KP2773-2
Insulator, 350A Gun Tube, 25 pcs.	KP2773-2-B25
Gas Nozzle Assembly 5/8 in (15.9 mm)	KP2742-1-62R

For all possible options, reference bulletin E12.09.



CONTACT TIPS 550A	
Wire Diameter in. (mm)	Order Number
0.035 (0.9)	KP2745-035AT <sup>(1)</sup>
3/64 (1.2)	KP2745-364AT <sup>(1)</sup> KP2745-364AT5356 KP2745-364AT-B100 <sup>(2)</sup>
	KP2745-116AT KP2745-116AT5356 KP2745-116AT-B100 <sup>(2)</sup>

(1) Included with gun  
 (2) Sold in Quantity of 100

CONDUIT LINERS, STEEL	
Description ft (m)	Order Number
Liner, .035-.045, Steel, 15 [4.5]	KP3544-3545-15
Liner, .035-.045, Steel, 25 [7.6]	KP3544-3545-25
Liner, .035-.045, Steel, 35 [10.7]	KP3544-3545-35

COOLANT	
Description in. (mm)	Order Number
1 Gallon (order in multiples of 4)	KP3379-4
5 Gallon	KP3379-5

550A SERIES EXPENDABLES	
Description	Order Number
Gas Diffuser	KP2747-1A
Gas Diffuser, 25 pcs.	KP2747-1A-B25
Insulator, 550A Gun Tube, each	KP2773-1
Insulator, 550A Gun Tube, 25 pcs.	KP2773-1-B25
Gas Nozzle Assembly 5/8 in (15.9 mm)	KP2743-1-62RA

Use with water-cooled nozzle KP3375-1  
 For all possible options, reference bulletin E12.09



JUMP LINERS	
Description in. (mm)	Order Number
Jump Liner 0.035 - 1/16 [0.9 - 1.6]	KP2879-3

DRIVE ROLLS	
Description in. (mm)	Order Number
0.035 (0.9) Groove	KP3546-035
3/64 (1.2) Groove	KP3546-364
3/64 (1.2) Knurl	KP3547-364
1/16 (1.6) Knurl	KP3547-116

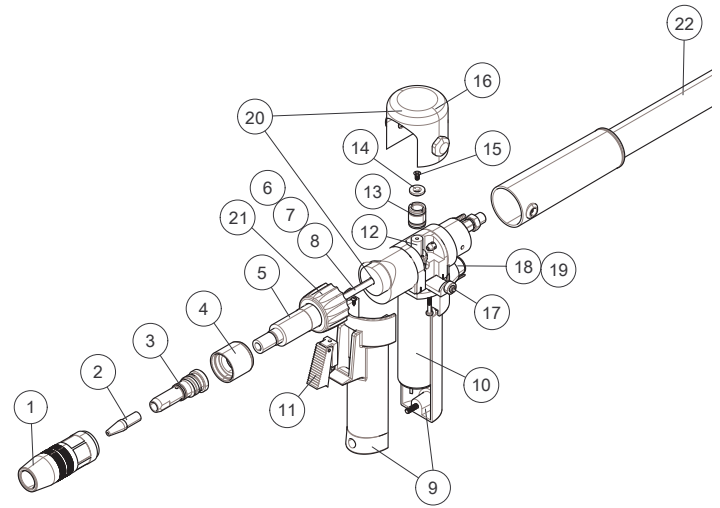
### RECOMMENDED ACCESSORIES



**12-pin to 7-pin Adapter**  
 Use for connecting 12-pin push-pull guns such as the Magnum<sup>®</sup> PRO AL to a 7-pin feeder connector.  
**Order K2910-2**

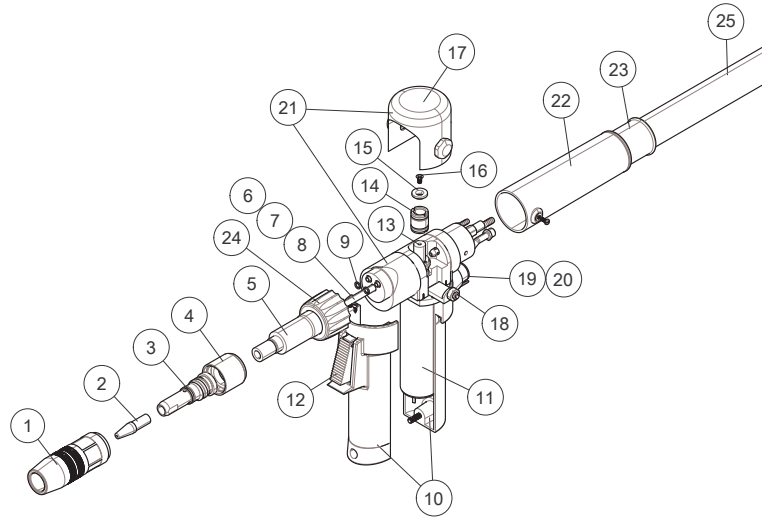
# Magnum® PRO AL Pistol Air

ITEM	DESCRIPTION	Part #	QTY	1	2	3
	MAGNUM PRO AL PA 15'	K3478-1		X	.	.
	MAGNUM PRO AL PA 25'	K3478-2		.	X	.
	MAGNUM PRO AL PA 35'	K3478-3		.	.	X
	MAGNUM PRO AL PA 50'	K3478-4		.	.	X
1	NOZZLE THREAD ON .625 ID 1/8R	KP2743-1-62RA	1	X	X	X
2	TAPERED CONTACT TIP, 3/64 AL	KP2745-364AT	1	X	X	X
3	HEAVY DUTY ALUM. GAS DIFFUSER	KP2747-1A	1	X	X	X
4	INSULATOR	KP2773-1	1	X	X	X
5	GUN TUBE ASBLY 180 DEGREE AC	KP3541-180	1	X	X	X
6	180 DEGREE WIRE GUIDE TUBE	95S32441-21	1	X	X	X
7	NUT FOR COPPER WIRE GUIDE TUBES	95S32441-23	1	X	X	X
8	WIRE LINER (.035-1/16") 45' & 60' NECK	KP2879-3	1	X	X	X
9	HANDLE FRONT AND REAR	95S32441-26	1	X	X	X
10	GEARMOTOR	95S32441-30	1	X	X	X
11	TRIGGER	95S26374-23	1	X	X	X
12	DRIVE ROLL SEAT CPL	95S32441-13	1	X	X	X
13	DRIVE ROLL - 3/64" (1.2MM)	KP3546-364	1	X	X	X
14	WASHER FOR DRIVE ROLL	95S32441-11	1	X	X	X
15	SCREW FOR DRIVE ROLL	95S32441-12	1	X	X	X
16	VE PRESSURE CAP	95S32441-28	1	X	X	X
17	IDLER ARM BEARING	95S32441-29	1	X	X	X
18	POTENTIOMETER	95S32441-31	1	X	X	X
19	POTENTIOMETER KNOB	95S32441-32	1	X	X	X
20	TORCH BODY AC WITH PRESSURE CAP	95S32441-33	1	X	X	X
21	BARREL NUT	95S26374-45	1	X	X	X
22	CABLE ASBLY AC 15'	KP3548-15	1	X	.	.
22	CABLE ASBLY AC 25'	KP3548-25	1	.	X	.
22	CABLE ASBLY AC 35'	KP3548-35	1	.	.	X
22	CABLE ASSEMBLY, AIR COOLED, 50 FT	KP3548-50	1	.	.	X
Items Not Shown:						
	O-RING	9ST13483-8	1	X	X	X
	LINER NUT	95S22645-400	1	X	X	X
	LINER, .035-3/64, ALUMINUM, 15'	KP3543-35364-15	1	X	.	.
	LINER, .035-3/64, ALUMINUM, 25'	KP3543-35364-25	1	.	X	.
	LINER, .035-3/64, ALUMINUM, 35'	KP3543-35364-35	1	.	.	X
	LINER, .035-3/64, ALUMINUM, 50'	KP3543-35364-50	1	.	.	X
	GUN TUBE ASBLY 45 DEGREE AC	KP3541-45	1	X	X	X
	GUN TUBE ASBLY 60 DEGREE AC	KP3541-60	1	X	X	X
	CURVED GUIDE TUBE(.035-1/16) AC&WC	95S32441-22	1	X	X	X
	DRIVE ROLL - .035" (.9MM)	KP3546-035	1	X	X	X
	AIR COOLED GAGE	95S32441-49	1	X	X	X



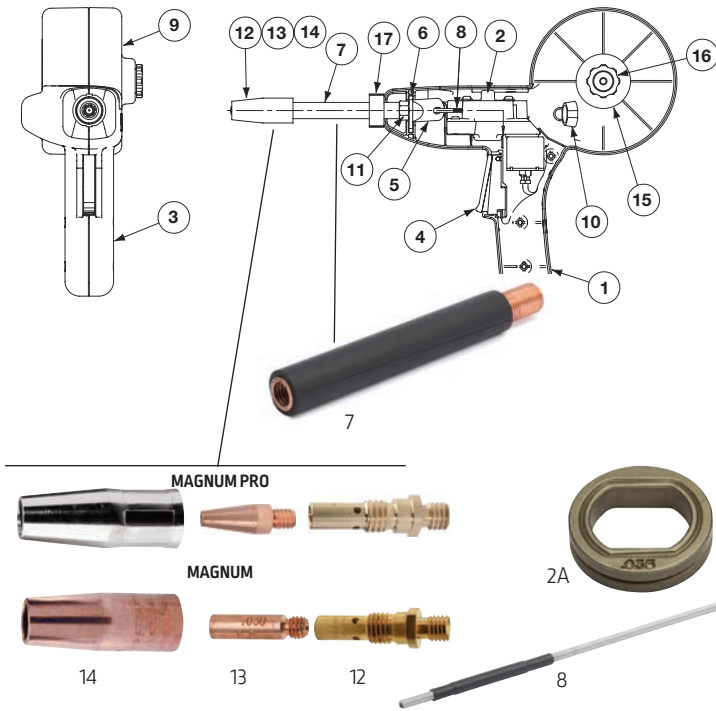
# Magnum® PRO AL Pistol Water

ITEM	DESCRIPTION	Part #	QTY	1	2
	MAGNUM PRO AL PW 15'	K3479-1		X	·
	MAGNUM PRO AL PW 25'	K3479-2		·	X
1	NOZZLE THREAD ON .625 ID 1/8R	KP2743-1-62RA	1	X	X
2	TAPERED CONTACT TIP, 3/64 AL	KP2745-364AT	1	X	X
3	HEAVY DUTY ALUM. GAS DIFFUSER	KP2747-1A	1	X	X
4	INSULATOR	KP2773-1	1	X	X
5	GUN TUBE ASBLY 180 DEGREE WC	KP3542-180	1	X	X
6	180 DEGREE WIRE GUIDE TUBE	9SS32441-21	1	X	X
7	NUT FOR COPPER WIRE GUIDE TUBES	9SS32441-23	1	X	X
8	WIRE LINER (.035-1/16") 45' & 60' NECK	KP2879-3	1	X	X
9	O-RING KIT WATER COOLED TORCH BODY	9SS32441-25	1	X	X
10	HANDLE FRONT AND REAR	9SS32441-26	1	X	X
11	GEARMOTOR	9SS32441-30	1	X	X
12	TRIGGER	9SS26374-23	1	X	X
13	DRIVE ROLL SEAT CPL	9SS32441-13	1	X	X
14	DRIVE ROLL - 3/64" (1.2MM)	KP3546-364	1	X	X
15	WASHER FOR DRIVE ROLL	9SS32441-11	1	X	X
16	SCREW FOR DRIVE ROLL	9SS32441-12	1	X	X
17	DRIVE PRESSURE CAP	9SS32441-28	1	X	X
18	IDLER ARM BEARING	9SS32441-29	1	X	X
19	POTENTIOMETER	9SS32441-31	1	X	X
20	POTENTIOMETER KNOB	9SS32441-32	1	X	X
21	TORCH BODY AC WITH PRESSURE CAP	9SS32441-33	1	X	X
22	CABLE SUPPORT RUBBER FRONT	9SS32441-35	1	X	X
23	CABLE SUPPORT RUBBER FRONT	9SS32441-36	1	X	X
24	BARREL NUT	9SS26374-45	1	X	X
25	CABLE ASBLY WC 15'	KP3549-15	1	X	·
25	CABLE ASBLY WC 25'	KP3549-25	1	·	X
	Items Not Shown:				
	O-RING	9ST13483-8	1	X	X
	LINER NUT	9SS22645-400	1	X	X
	LINER, .035-3/64, ALUMINUM, 15'	KP3543-35364-15	1	X	·
	LINER, .035-3/64, ALUMINUM, 25'	KP3543-35364-25	1	·	X
	GUN TUBE ASBLY 45 DEGREE WC	KP3542-45	1	X	X
	GUN TUBE ASBLY 60 DEGREE WC	KP3542-60	1	X	X
	CURVED GUIDE TUBE(.035-1/16) AC&WC	9SS32441-22	1	X	X
	DRIVE ROLL - .035" (9MM)	KP3546-035	1	X	X
	WATER COOLED GAGE	9SS32441-50	1	X	X



# Magnum® & Magnum® PRO 100SG Spool Guns

Use Items marked with 'X' in Column for desired gun



### 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.



### K1738-1

#### Spool Gun Holder

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

### 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.



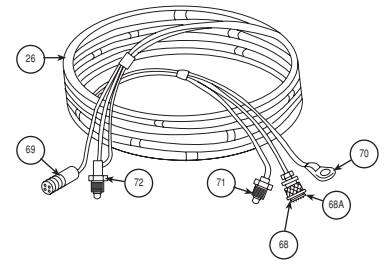
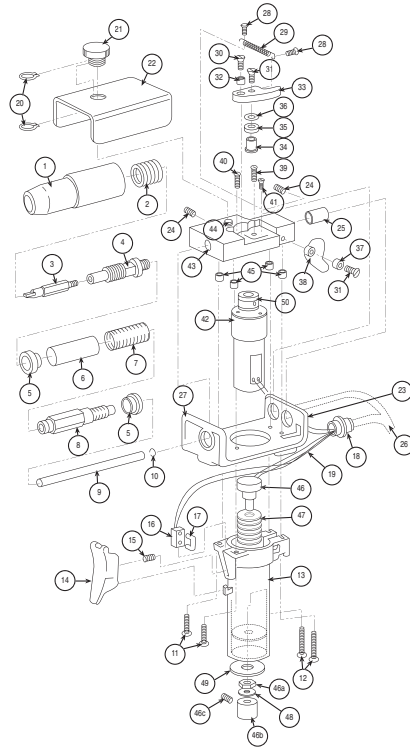
ITEM	DESCRIPTION	Part #	QTY	1	2	3
	Magnum 100SG, Includes:	K2532-1		X	-	-
	Magnum PRO 100SG, Includes:	K3269-1		-	X	-
	Magnum PRO 100SG w/8 Pin	K4360-1		-	-	X
1	Gun Handle Right Half Includes:	9SG5666	1	X	X	X
1A	Warning Decal	9SS25815	1	X	X	X
1B	1/4-20 x 2.50 HHS	9SCF000114	1	X	X	X
1C	#6-32 HN	9SCF000005	3	X	X	X
1D	Push Nut	9SS18535-2	1	X	X	X
2	Wire Drive Assembly, Includes:	9SG5707	1	X	X	X
2A	Twistlock Drive Roll Assembly	KP2529-2	1	X	X	X
2B	Hub	9SM20860	1	X	X	X
2C	Twist Lock	9SS26238	1	X	X	X
2D	Metric Screw	9ST14731-72	1	X	X	X
2E	Lock Washer	9ST9695-3	1	X	X	X
2F	Shaft	9SS26311	1	X	X	X
2G	Bearing	9SM9300-141	2	X	X	X
2H	Gear	9SS26298	1	X	X	X
2J	Feedplate Base	9SG5668*	1	Dis	Dis	X
2K	Feedplate Cover	NSS	1	X	X	X
2L	Nozzle Insert	9ST12576-6*	1	Dis	Dis	X
2M	Idle Roll Assembly	9SS26718	1	X	X	X
2N	Motor & Pinion Assembly	S26679*	1	Dis	Dis	X
2O	Metric Screw	9ST14731-64	2	X	X	X
2P	Self Tapping Screw	9SS8025-96	2	X	X	X
2Q	Plain Washer	9SS9262-3	2	X	X	X
3A	Gun Handle Left Half	9SG5665	1	X	X	X
3B	#6-32 x 1.00 RHS	9SCF000099	3	X	X	X
4	Trigger Assembly	9S9SS18932	1	X	X	X
5	Cable Assembly, Includes:	9SL13018	1	X	X	-
5	Cable Assembly, Includes:	9SL13018-1	1	-	-	X
5A	Male Connector Plug (8 Pin)	9SS32140	1	-	-	X
5A	Male Connector Plug (4 Pin)	9SS18656	1	X	X	-
5B	Cable Clamp	9SS18658-1	1	X	X	X
6	Gun Tube Mounting Plate	9SS26622	1	X	X	X
7	Gun Tube Asbly	KP2631-1	1	X	-	-
7	Gun Tube Asbly	KP3325-1	1	-	X	X
8	Liner Assembly	KP2632-1	1	X	X	X
9	Spool Cover Asbly, Includes:	9SS26737	1	X	X	X
9A	Spool Cover	NSS	1	X	X	X
9B	Locking Knob	9SS26711	1	X	X	X
9C	Product Decal	9SS26775	1	X	-	-
9D	Product Decal (Magnum Pro)	9SS26775-1	1	-	X	X
10	Grommet	9ST9274-4	1	X	X	X
11	HEX LOCKING NUT 7/16-20	9SS19580	1	X	X	X
12	Gas Diffuser (Magnum)	KP35-50	1	X	-	-
12	Gas Diffuser (Magnum Pro)	KP3076-1	1	-	X	X
13	Contact Tip (.035 Std) (Magnum)	KP11-35	10	X	-	-
13	Contact Tip (.035 Std Magnum Pro)	KP2744-035T	10	-	X	X
14	Gas Nozzle (Flush) (Magnum)	KP21-50-F	1	X	X	-
14	Gas Nozzle (Flush) (Magnum Pro)	KP3075-1-50F	1	-	X	X
15	Brake Spring	9ST11862-65	1	X	X	X
16	Locking Knob	9SS26711	1	X	X	X
17	Locking Collar	9SS19701	1	X	X	X
	HARNESS	9SM21182	1	X	-	-

\* obsolete

# Magnum® Spool Guns

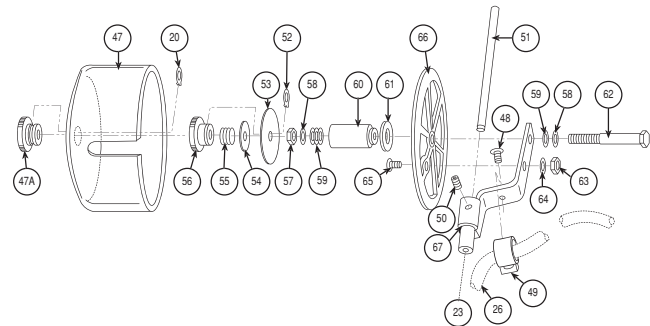
ITEM	DESCRIPTION	Part #	QTY
<b>Gun &amp; Cable Assembly, k487-25</b>			
1	Gas Nozzle Slip Adj. .62 ID (15.9 mm)	KP24A-62	1
2	Insulator for Adj. Slip Nozzle	KP34-A	1
3	Tip for .023-.025" (0.6 mm) Diameter Wire	KP2010-7B1	(2)
	Tip for .030" (0.8 mm) Diameter Wire	KP2010-3B1	(2)
	Tip for .035" (0.9 mm) Diameter Wire	KP2010-4B1	(2)
	Tip for .045" 3/64" (1.2 mm) Diameter Wire	KP2010-5B1	(2)
4	Gas Diffuser	KP2010-6	1
5	Spacer	95S18697-13	2
6	Metal Sleeve	95S18697-12	1
7	Insulating Sheath	95S18697-14	1
8	Brass Barrel	95S18697-7	1
9	Teflon Liner	KP2010-1	1
10	O-Ring	95S18697-17	1
11	Screw, 8-32 x 3/4	(1)	2
12	Screw, 8-32 x 1-3/16	(1)	2
13	Handle (K469)	95S18697-35	1
13	Handle (K487)	95S18697-57	1
14	Trigger	95S18697-43	1
15	Trigger Spring	95S18697-15	1
16	Switch	95S18697-16	1
17	Retaining Clip	95S18697-11	1
18	6 Pin Plug	95S18697-1	1
19	Wire, 16 Gauge (1.3 mm), High Temperature	(1)	1
20	Snap Ring	95S18697-9	3
21	Hand Nut for Body Cover	95S18697-22	1
22	Body Cover	95S18697-5	1
23	Spool Holder Assembly		
24	Set Screw, 1/4-20 x 1/4, Nylon Tip	(1)	1
25	Support Bushing, Nylon	95S18697-2	1
26	Cable Assembly, see P-198-F		
27	Molded Gun Base	95S18697-42	1
28	Screw, 4-40 x 1/4	(1)	2
29	Pressure Roll Spring	95S18697-39	1
30	Screw, 8-32 x 3/8 Flat Head	(1)	1
31	Screw, 8-32 x 1/4 Flat Head	(1)	2
32	Bushing, Roll Block	95S18697-24	1
33	Roll Block	95S18697-37	1
34	Bushing, Pressure Roll	95S18697-3	1
35	Pressure Roll	95S18697-40	1
36	Pressure Roll Spacer	95S18697-38	1
37	Bushing, Release Lever	95S18697-25	1
38	Pressure Release Lever	95S18697-8	1
39	Screw, 4-40 x 1/2	(1)	1
40	Screw, 4-40 x 1/2	(1)	1
41	Screw, 4-40 x 5/16 Flat Head	(1)	1
42	Gear Motor, 24 VDC See P-198-G	95S18697-36	1
43	Body Block	95S18697-4	1
44	Set Screw, 1/4 -20 x 1/2	(1)	4
45	Screw Insert, Nylon	95S18697-23	4
46	Potentiometer, 100K	95S18697-53	1
46a	Retaining Nut	(Incl)	
46b	Knob	95S18697-55	1
46c	Set Screw	(Incl)	
47	Lock Washer, Internal Tooth, 3/8" I.D., 1/2" O.D.	(1)	5
48	O-Ring	95S18697-61	1
49	Feed Dial	95S18697-62	1
50	Drive Roll, Smooth	KP2010-8	1
	Drive Roll, Knurled	KP2010-9	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)	95S18697-48
26	Cable Assembly (K487-25) [Gas, Power and Control] (rheostat in handle)	95S18697-56 95S18697-65 (control only)
68	6 Pin Plug	95S12020-33
68A	Cable Clamp	95S12024-4
69	6 Pin Receptacle	95S18697-50
70	Lug Terminal, No. 4 Wire	(1)
71	Gas Fitting, 5/8-18 R.H. - 3/16" (4.8 mm) ID Tube	95S18697-58 <sup>(2)</sup>
72	Gas & Power Fitting	95S18697-51

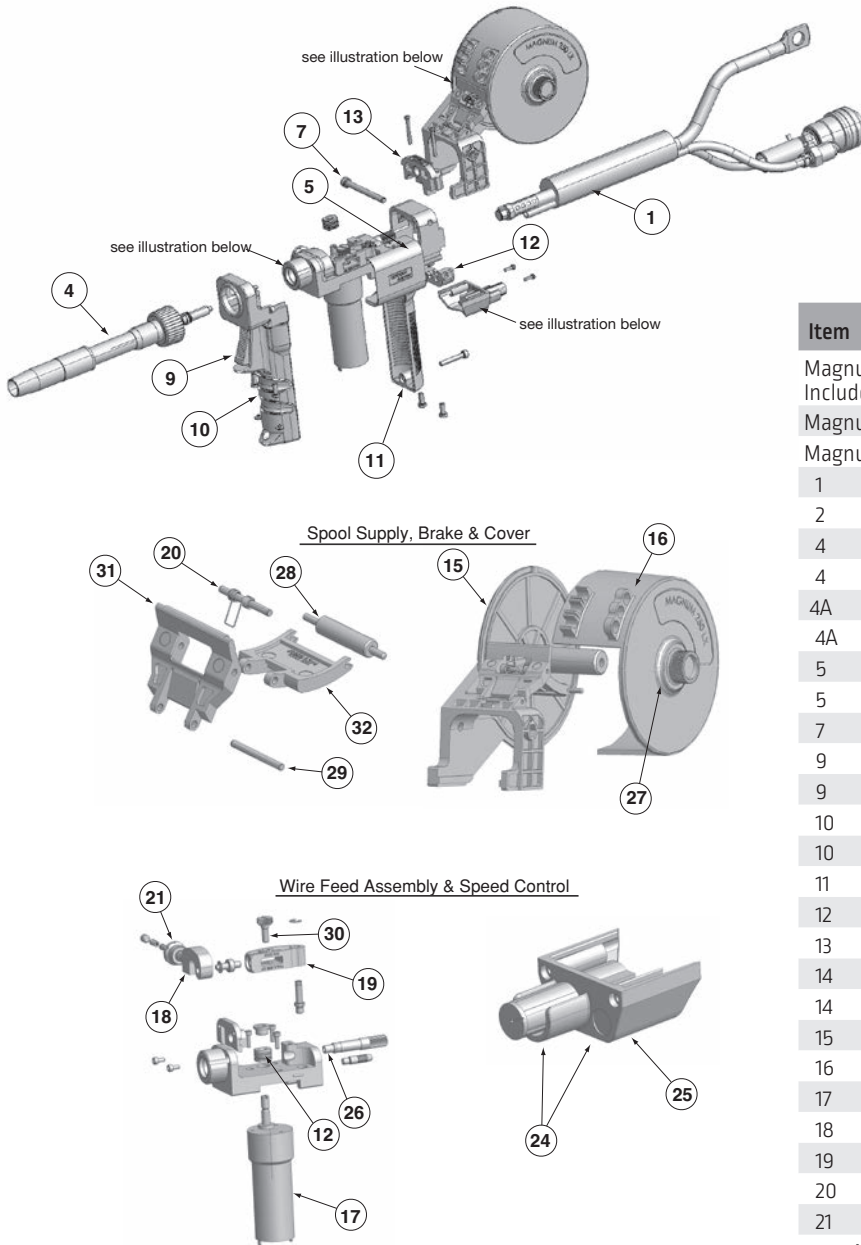
<sup>(1)</sup> Parts commonly available at hardware store.  
<sup>(2)</sup> Parts commonly available at welding supply store.



ITEM	DESCRIPTION	Part #	QTY
<b>Spool Gun Holder Assembly, Includes (47 thru 67)</b>			
47	Spool Cover	95S18697-30	1
47a	Hand Nut for Spool Cover	95S18697-28	1
48	Screw, 8-32 x 1/4	95S18697-60	1
49	Plastic Cable Clamp	(1)	1
50	Set Screw, 8-32 x 1/8	(1)	1
51	Plastic Guide Tube	95S18697-33	1
52	Snap Ring	95S18697-10	1
53	Nylon Washer	95S18697-31	1
54	Brass Washer	(1)	1
55	Spool Spring	95S18697-27	1
56	Hand Nut, Brass	95S18697-6	1
57	Nut, 1/4-20	(1)	1
58	Washer, 1/4 Shakeproof	(1)	2
59	Washer, 1/4 Disc Spring	(1)	3
60	Spool Spindle	95S18697-26	1
61	Washer	(1)	1
62	Bolt, 1/4-20 x 3	(1)	1
63	Nut, 10-32	(1)	1
64	Washer, 10-32 Shakeproof	(1)	1
65	Screw, 10-32 x 1/2	(1)	1
66	Reel Base	95S18697-29	1
67	Reel Support Bracket	95S18697-34	1

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

# Magnum® 250 LX



For K3569-2 & K3570-2		
45/60 Degree 550A Liner		KP3673-50
45 Degree Barrel w/Nut		KP3682-45
60 Degree Barrel w/Nut		KP3682-60
Internal Valve O-Ring Kit		9SS26374-114

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 #	1	2
	Magnum 250LX Spool Gun, Air-Cooled, 25 ft., Includes:	K2490-1	X	•
	Magnum® PRO 250LX GT Spool Gun	K3569-2	•	X
	Magnum® PRO 250LX Spool Gun	K3570-2	•	X
1	Cable Assembly 25'	9SS26374-1	X	X
2	Connector	9SS12020-50	X	X
4	Barrel, Straight	9SS26374-4	X	•
4	180° Barrel w/Nut	KP3682-180	•	X
4A	Barrel Liner	KP2521-1	X	•
4A	180° 550A Liner	KP2879-5	•	X
5	Wire Drive Cover	9SS26374-6	X	•
5	Drive Roll Cover	9SS26374-109	•	X
7	Hex Socket Head Screw (M6)	9SS26374-13	X	X
9	Trigger	9SS26374-23	X	•
9	Trigger & Screw Cover Kit	9SS26374-110	•	X
10	Handle, Front (Includes Trigger)	9SS26374-24	X	•
10	Handle w/Trigger Kit	9SS26374-111	•	X
11	Handle, Back	9SS26374-25	X	•
12	Cable Strain Relief, Bottom	9SS26374-26	X	X
13	Cable Strain Relief, Top	9SS26374-27	X	X
14	Drive Roll (Steel)	KP2518-1	X	•
14	Drive Roll (Aluminum)	KP2518-2	X	X
15	Spool Supply & Brake Asbly	9SS26374-2	X	X
16	Spool Cover	9SS26374-3	X	X
17	Motor Gearbox	9SS26374-5	X	X
18	Pressure Lever	9SS26374-7	X	X
19	Pivot Arm	9SS26374-8	X	X
20	Set Screw, Pressure Roll	9SS26374-9	X	X
21	Pressure Adjustment Knob Asbly	9SS26374-10	X	X
22 - N/S	Ball Bearing	9SS26374-11	X	X
23	Set Screw	9SS26374-12	X	X
24	Wire Feed Speed Adjustment Pot Assembly	9SS26374-14	X	X
25	Housing Potentiometer	9SS26374-15	X	X
26	Inlet Guide	9SS26374-16	X	X
27	Thumb Screw	9SS26374-17	X	X
28	Roller Pin	9SS26374-18	X	X
29	Pin	9SS26374-19	X	X
30	Spring	9SS26374-20	X	X
31	Spool Brake Lever	9SS26374-21	X	X
32	Roller Arm	9SS26374-22	X	X
	Gas Valve Replacement Kit	9SS26374-107	•	X

# Cougar™ Expendables

## 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)



**GUN TUBE INSULATOR**  
350 A

Part #
KP2773-2



**GAS DIFFUSER 350 A FOR THREAD-ON NOZZLES**

Thread-on Standard Duty
KP2746-1

**STANDARD CONTACT TIP 350 A**

Wire Diameter in. (mm)	Standard Pkg. Qty. - 10
.035 (0.9)	KP2744-035AT
3/64 (1.2)	KP2744-364AT
3/64 (1.2)*	KP2744-364AT5356
1/16 (1.6)	KP2744-116AT

\* For low amperage 5356 wire applications.



**GAS NOZZLE 350 A**

Nozzle	Standard 1/2 (12.7)	Standard 5/8 (15.9)
1/8 (3.2) Recess	KP2742-1-50R	KP2742-1-62R
Flush	KP2742-1-50F	KP2742-1-62F

## BARREL LINERS

ANGLE (DEGREES)	BARREL SIZE	Part Number
45° and 60°	(.035 - 1/16")	KP2879-1
180°	(0.35 - 1/16")	KP2879-2

## DRIVE ROLLS

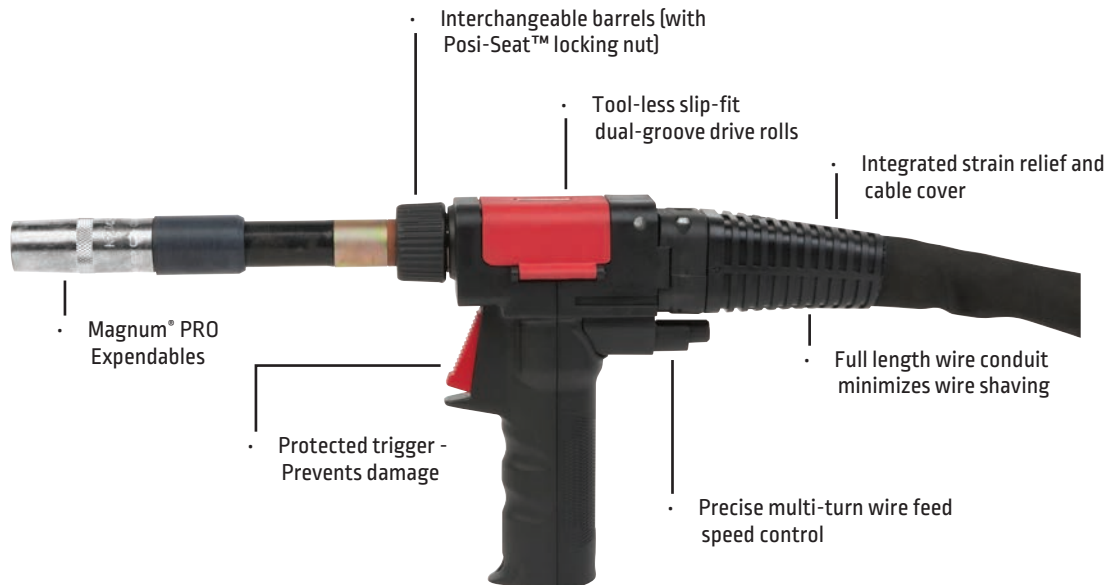
Wire Diameter in. (mm)	Part Number
.035-3/64 (0.9-1.20)	KP2876-1
1/16 (1.6)	KP2876-2

## GUN BARRELS

ANGLE (DEGREES)	Cooling System	Part Number
60°	Air-Cooled	KP2877-60
45°	Air-Cooled	KP2877-45
180°	Air-Cooled	KP2877-180

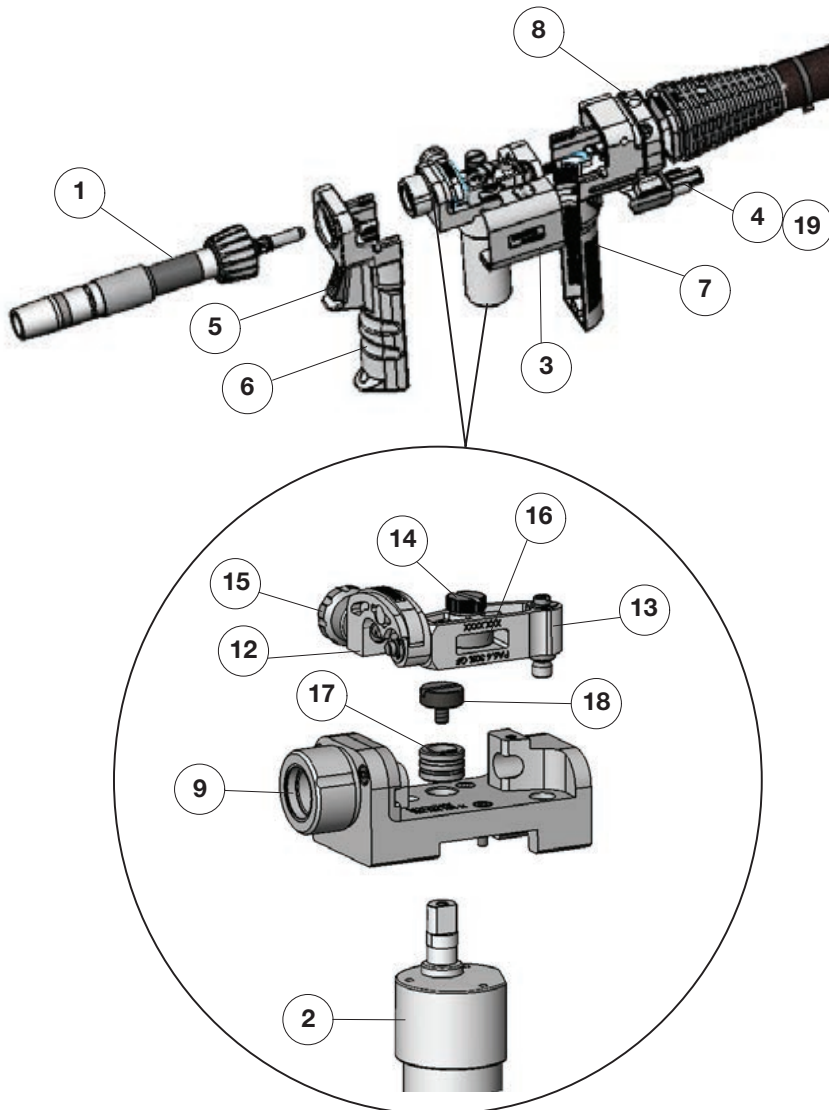
## WIRE CONDUITS

Length ft. (m)	Wire Diameter in. (mm)	Part Number
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





# Cougar™ Service Parts



ITEM	PART	DESCRIPTION
1	KP2877-180	180 Degree Air-Cooled Gun Barrel
2	9SS26374-31	Motor Assembly
3	9SS26374-6	Wire Drive Cover
4	9SS26374-14	Wire Feed Speed Adjustment Potentiometer Assembly
5	9SS26374-23	Trigger
6	9SS26374-24	Handle - Front
7	9SS26374-25	Handle - Back
8	9SS26374-33	Strain Relief Clamp Kit
9	9SS26374-106	Torch Body Assembly
	9SS26374-28	25' Cable Assembly - Cougar
	9SS26374-34	50' Cable Assembly - Cougar
	9SS26374-35	Cable Cover 25'
	9SS26374-36	Cable Cover 50'
	9SS26374-37	Power Cable Assembly 25'
	9SS26374-38	Power Cable Assembly 50'
	9SS26374-39	Wire Conduit Assembly 25'
	9SS26374-40	Wire Conduit Assembly 50'
	9SS26374-41	Control Wire Assembly 25'
	9SS26374-42	Control Wire Assembly 50'
	9SS26374-60	Gas Hose Assembly 25'
	9SS26374-61	Gas Hose Assembly 50'
	9SS26374-32	Rear End Feeder Connection Kit
12	9SS26374-7	Pressure Lever With Snap Ring
13	9SS26374-8	Pivot Arm
14	9SS26374-9	Set Screw - Pressure Roll
15	9SS26374-10	Pressure Adjustment Knob Asbly
16	9SS26374-11	Ball Bearing
17	KP2876-1	Drive Roll Kit Al .035 - 3/64 Inch
17	KP2876-2	Drive Roll Kit Al 1/16"
18	9SS26374-63	Thumb Screw
19	9SS26374-15	Housing Potentiometer

# K126™ PRO Expendables



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

## INSULATOR

Pkg. Qty.	Part Number
1	KP2907-1

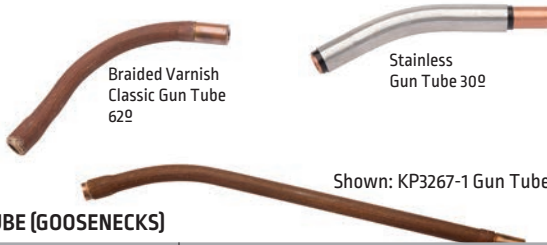
## TIP HOLDER

Pkg. Qty.	Part Number
1	KP2908-1

## CONTACT TIPS 550A

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	-	-
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	-	-

(1) 550 only



## GUN TUBE (GOOSENECKS)

Parts Number	Gun Tube Description
<b>Reverse Bend<sup>(2)</sup></b>	
<b>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</b>	
<b>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</b>	
<b>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</b>	
<b>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)

## 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
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

## 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

# K126™ PRO Gun What's Included

**K126-10 & K126-11**

- ▶ 5/64 in. (.2.0 mm) Contact Tip (KP2745-564)
- ▶ Tip Holder (KP2908-1)
- ▶ Insulator (KP2907-1)
- ▶ 62Ω Non-Reverse Stainless Steel 6 in. (152 mm) Bend Gun Tube (KP2906-62)
- ▶ Lincoln Electric Gun Connector (K613-6)
- ▶ 3/32 in. (.2.4 mm) Liner (KP45H-332-15)

**K126-12**

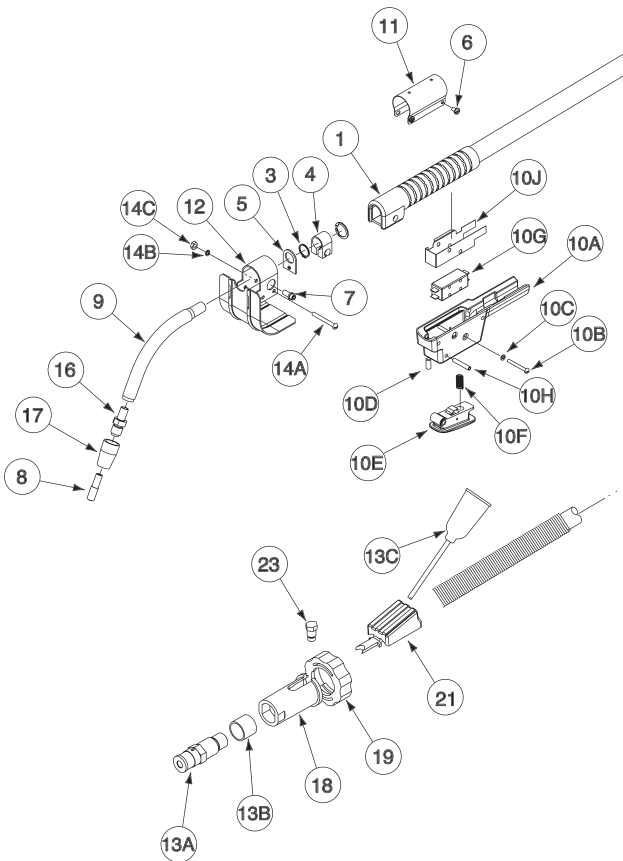
- ▶ 5/64 in. (.2.0 mm) Contact Tip (KP2745-564)
- ▶ Tip Holder (KP2908-1)
- ▶ Insulator (KP2907-1)
- ▶ 62Ω Non-Reverse Stainless Steel 6 in. (152 mm) Bend Gun Tube (KP2906-62)
- ▶ #4 size Gun Connector (K466-10)
- ▶ 5/64 in. (.2.0 mm) Liner (KP44-564-15)

**K126-13**

- ▶ 5/64 in. (.2.0 mm) Contact Tip (KP2745-564)
- ▶ Tip Holder (KP2908-1)
- ▶ Insulator (KP2907-1)
- ▶ 30Ω Non-Reverse Classic Braided 12 in. (305 mm) Gun Tube (KP3267-1)
- ▶ Gun Connector (K466-10)
- ▶ 3/32 in. (.2.4 mm) Liner (KP45H-332-15)



Use Items marked with 'X' in Column for desired gun



ITEM	DESCRIPTION	Part #	QTY	1	2	3	4
	Gun & Cable Assembly (G6760-2), Includes:	K126-11	1	X	-	-	-
	Gun & Cable Assembly (G6760-1), Includes:	K126-12	1	-	X	-	-
	Gun & Cable Assembly (G6760-3), Includes:	K126-10	1	-	-	X	-
	Gun & Cable Assembly (G6760-4), Includes:	K126-13	1	-	-	-	X
1	Handle	9SM10102-2	1	X	X	X	X
3	Snap Ring	9SS9776-7	1	X	X	X	X
4	Clamp	9SS15921-1	1	X	X	X	X
5	Spatter Shield	9ST12027	1	X	X	X	X
6	8-32 x .25 PHS	9SCF000148	4	X	X	X	X
7	Clamping Screw	9ST14438	1	X	X	X	X
8	Contact Tip, 5/64" (.2.0 mm)	KP2745-564R	X	X	X	X	X
9	Formed Gun Tube	KP2906-62	1	X	X	X	-
9	Formed Gun Tube	KP3267-1	1	-	-	-	X
10	Gun Control Assembly, Includes:	9SM22370	1	X	X	X	X
10A	Switch Housing	9SL10706	1	X	X	X	X
10B	#3-48 x .875 RHS	9SCF000138	2	X	X	X	X
10C	Lock Washer	9SE106A-17	2	X	X	X	X
10D	Set Screw	9SS11604-22	1	X	X	X	X
10E	Trigger Assembly	9SS23982	1	X	X	X	X
10F	Trigger Coil Spring	9ST12025	1	X	X	X	X
10G	Trigger Switch Assembly	9SS28279	1	X	X	X	X
10H	Roll Pin	9ST9967-52	1	X	X	X	X
10J	Switch Insulation	9SS14878	1	X	X	X	X
11	Clamp	9SS15922-1	1	X	X	X	X
12	Heat Shield Assembly	9SS13037	1	X	X	X	X
13	Gun Connector Kit Assembly, Includes:	K613-1	1	X	-	X	-
13	Gun Connector Kit Assembly, Includes:	K466-8	1	-	X	-	-
13	Gun Connector Kit Assembly, Includes:	K613-6	1	-	-	-	X
13A	Connector Assembly	9SS18645-1	1	X	-	X	-
13A	Connector Assembly	9SS18653	1	-	X	-	-
13A	Connector Assembly	9SS18645-3	1	-	-	-	X
13B	Insulation Tube	9ST7028-234	1	X	-	X	X
13C	Gun Control Assembly	9SM15608	1	X	X	X	X
14A	#8-32 x 1.50 RHS	9SCF000119	2	X	X	X	X
14B	Lock Washer	9ST9695-3	2	X	X	X	X
14C	#8-32 HN	9SCF000042	2	X	X	X	X
16	Tip Holder	KP2908-1	1	X	X	X	X
17	Insulator	KP2907-1	1	X	X	X	X
18	Tail Piece	9SM15607	1	X	X	X	X
19	Nut (Cable Handle)	9SS18690	1	X	X	X	X
21	Connector Cover	9SL7723	1	X	X	X	X
23	Molded Gas Plug	9SS18695	1	X	X	X	X
24	Cable Liner (Not Shown)	KP45H-332-15	1	X	-	X	X
24	Cable Liner (Not Shown)	KP44-564-15	1	-	X	-	-

# Magnum® Classic Self-Shielded Semiautomatic Guns



**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.



**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.



**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.



**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.

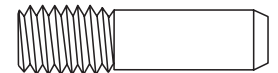
## TECHNICAL SPECIFICATIONS

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°

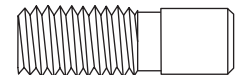
## EXPENDABLES

Description	K115-1, K115-2, K115-8	K115-3, K115-4, K115-10	K116-2	K126-1, K126-2	K345-10
<b>CONTACT TIPS SEVERE DUTY</b>					
1/16 in.	—	—	—	KP2100-2B1	—
.068-.072 in.	—	—	—	KP2100-1B1 <sup>(1)</sup>	KP2100-1B1 <sup>(1)</sup>
5/64 in.	—	—	—	KP2100-4B1 <sup>(1)</sup>	KP2100-4B1 <sup>(1)</sup>
3/32 in.	—	KP2103-4B1 <sup>(1)</sup>	KP2103-4B1	KP2100-3B1 <sup>(1)</sup>	—
7/64 in.	KP2103-6B1 <sup>(1)</sup>	—	KP2103-6B1 <sup>(1)</sup>	—	—
.120 in.	KP2103-3B1 <sup>(1)</sup>	—	KP2103-3B1 <sup>(1)</sup>	—	—
<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	—

<sup>(1)</sup> Included as standard with Gun and Cable Assembly. <sup>(2)</sup> Thread protector.



Contact Tips (KP2100-X)



Contact Tips (KP2103)

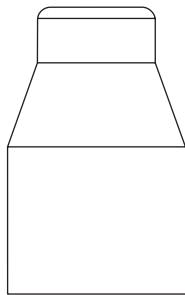
## GUN TUBES

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

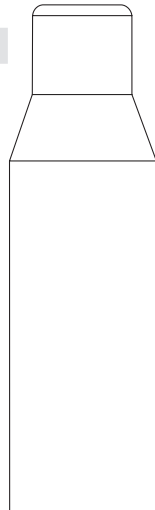
# Magnum® Classic Self-Shielded Semiautomatic Guns Insulated Guides

## K115 & K116

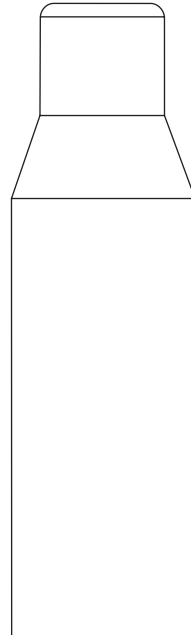
Electrical Stickout in (mm)	Part Number
1-1/2 (38)	KP1971-1
2-3/4 (70)	KP1965-1
3-3/4 (95)	KP1965-2



Insulated Guide (KP1971-1)



Insulated Guide (KP1965-2)

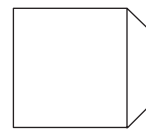


Insulated Guide (KP1965-1)

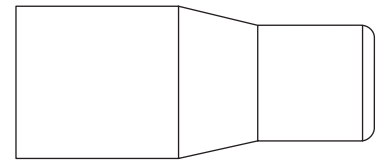
Line art is drawn to scale.

## K126 (Classic)

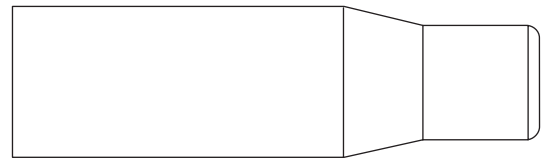
Electrical Stickout	Thread Protector	Insulated Guide
.75-1.50"	KP2089-1	-
1.50"	-	KP1987-1
2.00" (51 mm)	-	KP1995-1
2.75" (70 mm)	-	KP2090-1



Thread Protector (KP2089-1)



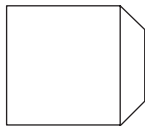
Insulated Guide (KP1995-1)



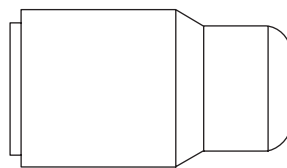
Insulated Guide (KP2090-1)

## K264, K345, K355 & K361

Electrical Stickout - in	Thread Protector	Insulated Guide
3/4-1-1/2	KP2089-1	KP1987-1
2	-	KP1995-1



Thread Protector (KP2089-1)



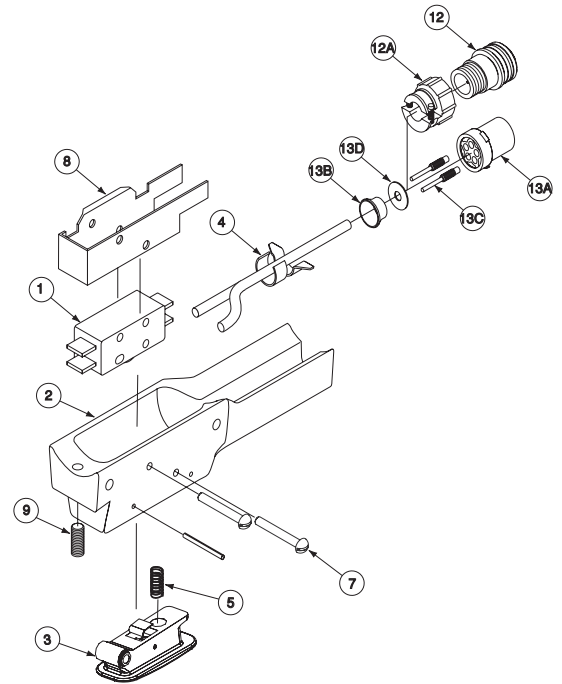
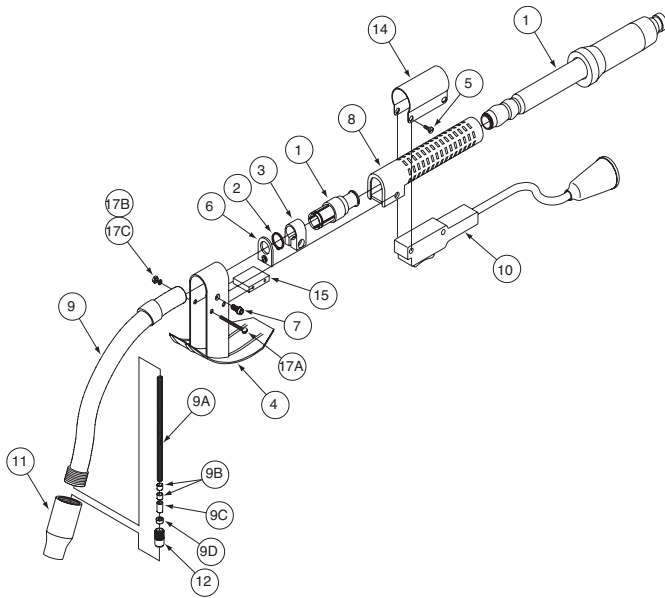
Insulated Guide (KP1987-1)

## INSULATED GUIDES

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

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

# 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	9SM14048	1
	Connector, Wire Feeder End	9SS12801-6	1
	Connector, Gun End	9SS12802-13	1
	Connector, Gun End	9SS12802-14	1
	Clamping Tube, Both Ends	9SS7748-40	2
2	Snap Ring	9SS9776-7	1
3	Clamp	9SS15921-1	1
4	Clamp and Shield Assembly	9SS12880	1
5	Pan Head Screw	9SCF000049	4
6	Spatter Shield	9ST12027	1
7	Socket Head Cap Screw	9ST14438	1
8	Handle	9SM10102-1	1
9	Nozzle (820), Includes:	Pg 58-59	1
9	Nozzle (450), Includes:	Pg 58-59	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	9ST12977-2	1
9D	Liner Locking Screw	9ST12932-2	1
10	Trigger and Control Cable Assembly	9SM12462-[ ]	
	Insulated Guides	Pg 58-59	
12	Contact Tip (Length 1-1/8")	Pg 58-59	1
14	Switch Housing Clamp	9SS15922-1	1
17	Round Head Screw (#8-32 x 1.50)	9SCF00119	2
17A	Lock Washer	9ST9695-3	2
17B	Hex Nut (#8-32)	9SCF000042	2

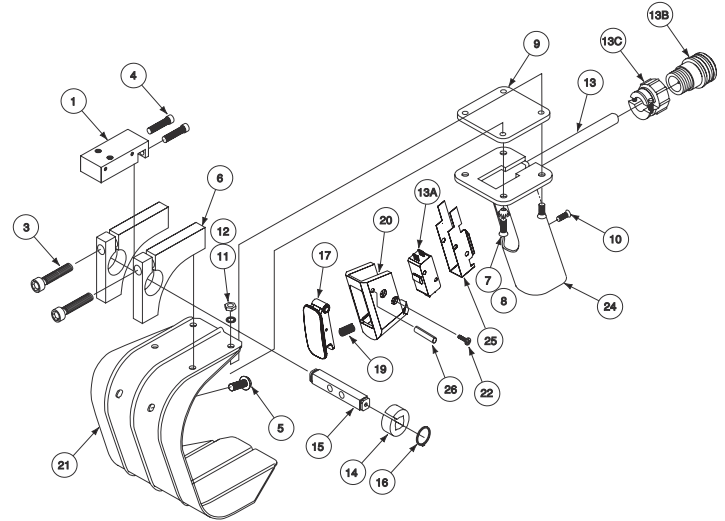
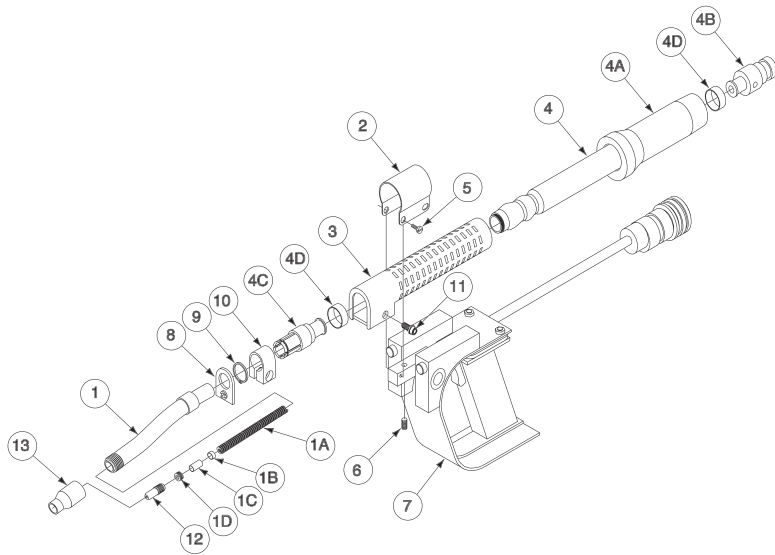
\* Discontinued. Available until stock is depleted.

\*\* Discontinued. Use KP2095-2.

ITEM	DESCRIPTION	Part #	QTY
Trigger & Control Cable Asbly,		<b>Includes:</b>	
1	Micro Switch	9ST12485	1
2	Housing	9SL10706	1
3	Trigger Assembly	9SS23982*	1
4	Cord Clamp	9ST11669-2	1
5	Coil Spring	9ST12025	2
6	Roll Pin	9ST9967-52	2
7	#3-48 x .75 RHS	9SCF000312	2
8	Insulating Sleeving	9SS14878	1
9	Set Screw	9SS11604-22	1
12	Polarized Plug, Wire Feeder End, (Not Shown) (Old Style)	9SS12020-6	1
12	Polarized Plug, Wire Feeder End	9SS12020-16	1
12A	Clamp at Polarized Plug (Old Style) (Not Shown)	9SS12024-1	1
12A	Clamp at Polarized Plug	9SS12024-4	1
	Molded Plug Kit Includes:	9SS19757	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



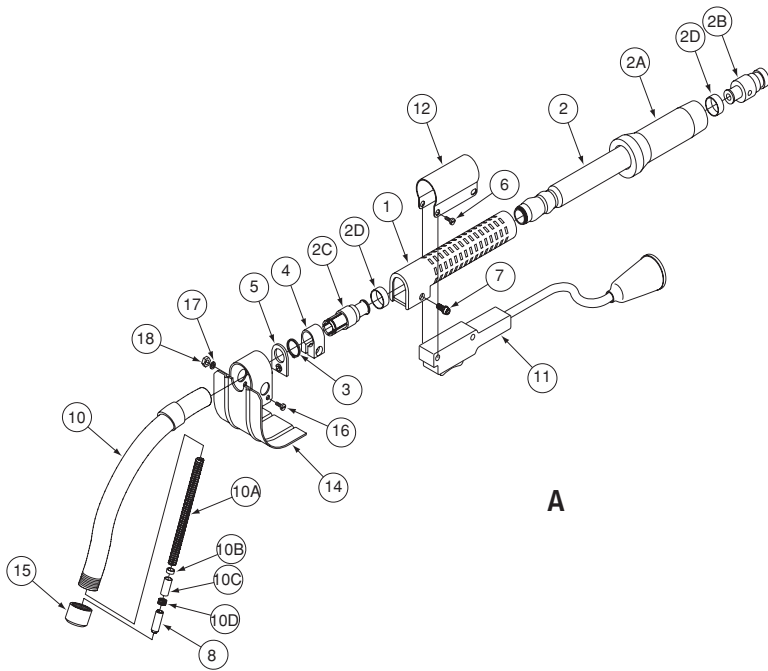
ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly Includes:			
1	Nozzle, Includes:	Pg 58-59	
1A	Nozzle Liner	KP2095-7*	1
1B	Nozzle Insert (.120 & 7/64")	KP2094-3	1
1B	Nozzle Insert (3/32")	KP2094-1	1
1C	Nozzle Insert Retainer	9ST12977-2	1
1D	Liner Locking Screw	9ST12932-2	1
2	Switch Housing Clamp	9SS12339-1	1
3	Handle	9SM10102-1	1
4	Conductor Cable, Includes: (15 ft)	9SL5728-5*	
4A	Handle, Wire Feeder End	9SM14048	1
4B	Connector, Wire Feeder End	9SS12801-4	1
4C	Connector, Gun End	9SS12802-13	1
4D	Clamping Tube, Both Ends	S7748-40	2
5	Pan Head Screw	9SCF000049	4
6	Socket Head Screw	9SS11604-9	2
7	Handle & Control Cable Assembly - 10' Length	9SL5734-10*	
8	Spatter Shield	9ST12027	1
9	Snap Ring	9SS9776-7	1
10	Clamp	9SS15921-1	1
11	Socket Head Cap Screw	9ST14438	1
12	Contact Tip	Pg 58-59	1
13	Insulated Guide	Pg 58-59	1

ITEM	DESCRIPTION	Part #	QTY
Handle & Control Cable Assembly - 10' Length			
1	Handle Mounting Bracket	9SS12905	1
3	Socket Head Cap Screw	9ST9447-36	2
4	Socket Head Cap Screw	9ST9447-22	2
5	#8-32 x.5 RHS	9SCF000033	12
6	Handle Pivot Block	9SS12690	1
7	#8-32 x.625 FHS	CF000147	2
8	Lock Washer	9ST10441-1	2
9	Insulating Pad	9ST12241	1
10	#8-32 x.5 FHS	9SCF000146	3
11	Lock Washer	9ST4291-A	2
12	#8-32 HN	9SCF000042	2
13	Control Cable, Includes: (15 ft)	9SM10427-15	1
13A	Micro Switch	9ST12485	1
13B	Polarized Plug, Wire Feeder End	9SS12020-6	1
13C	Clamp at Plug	9SS12024-1	1
14	Friction Bushing	9ST12233	2
15	Handle Pivot Shaft	9ST12239	1
16	Snap Ring	9SS9776-25	2
17	Trigger Assembly	9SS23982[*]	1
19	Spring	9ST12025	2
20	Trigger Mounting Block	9SM18910	1
21	Gun Shield	9SL4188	1
22	#3-48 x .75 RHS	9SCF000312	2
23	Roll Pin	9ST9967-27	2
24	Handle	9SS12687-1	1
25	Switch Insulation	9SS14878	1
26	Roll Pin	9ST9967-52	1

\* Discontinued. No longer available.

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

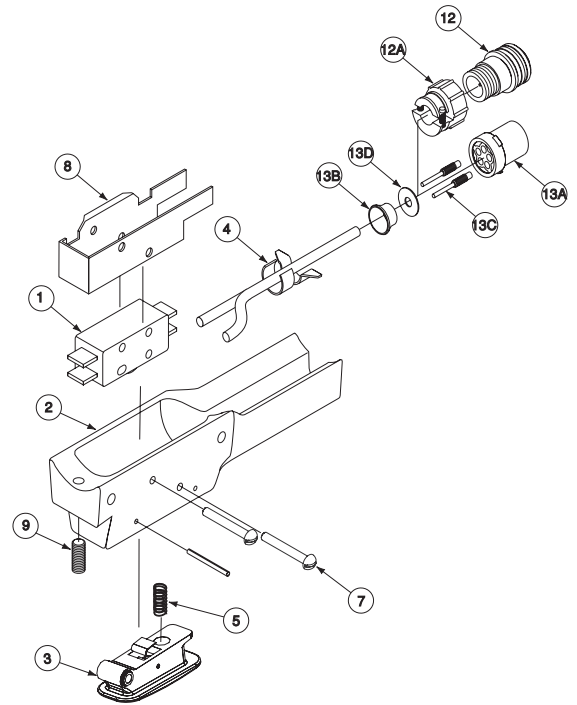
# Innershield® Classic K126 Squirt Gun, Cable



A

ITEM	DESCRIPTION	Part #	QTY
Gun & Cable Assembly, Includes:			
1	Handle	9SM10102-1	1
2	Conductor Cable, Includes: (15')	L6250-1	1
2	Conductor Cable, Includes: (10')	L6250-2	1
2A	Handle & Stiffener, Wire Feeder End	9SM14050-1	
2B	Connector, Wire Feeder End	9SS12801-3	1
2C	Connector, Gun End	9SS12802-12	1
2D	Clamping Tube, Both Ends	9SS16997	2
3	Snap Ring	9SS9776-7	1
4	Clamp	9SS15921-1	1
5	Spatter Shield	9ST12027	1
6	#8-32 x .25 PNHS	9SCF000148	4
7	Socket Head Cap Screw	9ST14438	
8	Contact Tip	Pg 58-59	
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	9ST12977-1	1
10D	Liner Locking Screw	9ST12932-1	1
11	Trigger & Control Cable	For Details See B	
	10 ft.	9SM12462-10	1
	15 ft.	9SM12462-15	1
12	Clamp	9SS15922-1	1
14	Heat Shield Assembly	9SS13037	1
15	Thread Protector, 3/4 to 1-1/2" Stickout	KP2089-1	1
16	#8-32 x 1.50 RHS	9SCF000119	4
17	Lock Washer	9ST9695-3	2
18	#8-32 HN	SCF000042	2

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

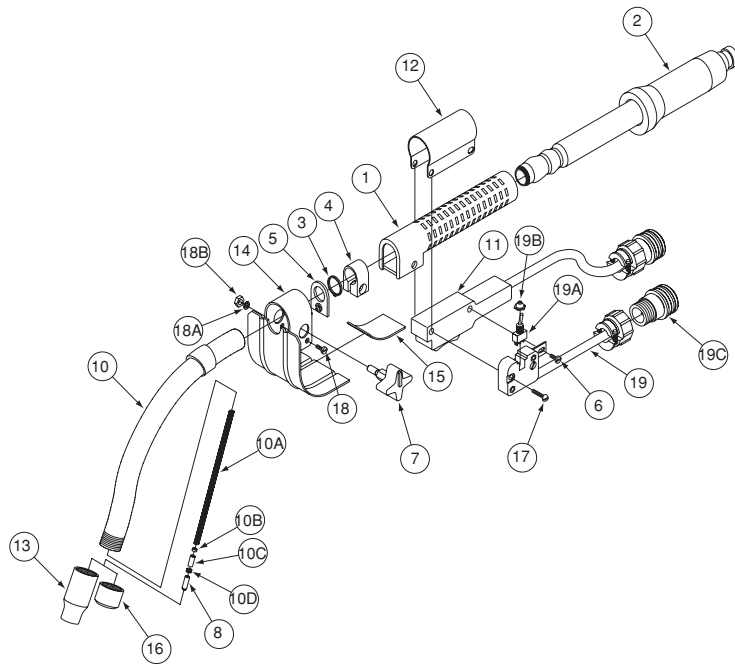


B

ITEM	DESCRIPTION	Part #	QTY
Trigger & Control Cable Assembly, Includes:			
1	Micro Switch	9ST12485	1
2	Housing	9SL10706	1
3	Trigger Assembly	9SS23982*	1
4	Cord Clamp	9ST11669-2	1
5	Coil Spring	9ST12025	2
6	Roll Pin	9ST9967-52	1
7	#3-48x.75 RHS	9SCF000312	1
8	Switch Insulation	9SS14878	1
9	Set Screw	9SS11604-22	1
12	Polarized Plug, Wire Feeder End, (Not Shown) (Old Style)	9SS12020-6	1
12	Polarized Plug, Wire Feeder End	9SS12020-16	1
12A	Clamp at Polarized Plug (Old Style) (Not Shown)	9SS12024-1	1
12A	Clamp at Polarized Plug	9SS12024-4	1
	Molded Plug Kit, Includes:	9SS19757	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



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

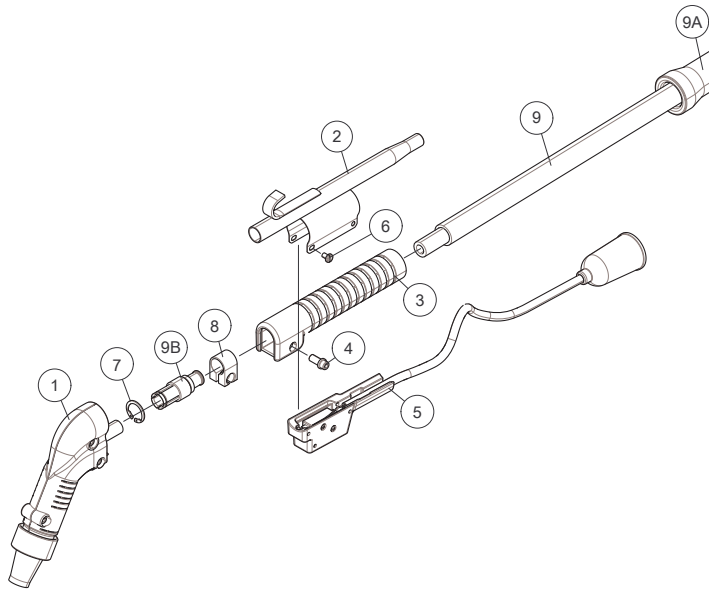


ITEM	DESCRIPTION	Part #	QTY
<b>Gun &amp; Cable Assembly, Includes:</b>			
1	Handle	9SM10102	1
2	Conductor Cable (K264-8)	9SL5993-2	1
2	Conductor Cable (for K355-10)	9SL5993-3	1
2	Conductor Cable (for K345-10 & K361-10)	9SL5993-4	1
3	Retaining Ring	9SS9776-7	1
4	Clamp	9SS11598-1	1
5	Spatter Shield	9ST12027	1
6	Pan Head Screw	9SCF000049	3 or 4
7	Hand Screw Assembly	9ST13858	1
8	Contact Tip	See Pg 56	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	9ST12576-2	1
10C	Nozzle Insert Retainer	9ST12977-1	1
10D	Liner Locking Screw	9ST12932-1	1
11	Trigger & Control Cable Assembly (8 ft.)	9SM12956-8	1
11	Trigger & Control Cable Assembly (10 ft.)	9SM12956-10	1
12	Clamp	9SS15922-1	1
13	Nozzle Assembly Insulated Guide	See Pg 57	1
14	Heat Shield Assembly	9SS13037	1
15	Gun Caution Decal	9ST13297	1
16	Thread Protector	KP2089-1	1
17	Round Head Screw (K345 & K355)	9SCF000096	1
18	Round Head Screw	9SCF000119	2
18A	Lock Washer	9ST9695-3	2
18B	Hex Nut	9SCF000042	2
19	Switch & Cable Assembly, (K345 & K355) Includes:	9SS16383-1	1
19A	Switch	9ST13381-6	1
19B	Switch Boot	9ST13938-6	1
19C	Polarized Plug	9SS12020-17	1

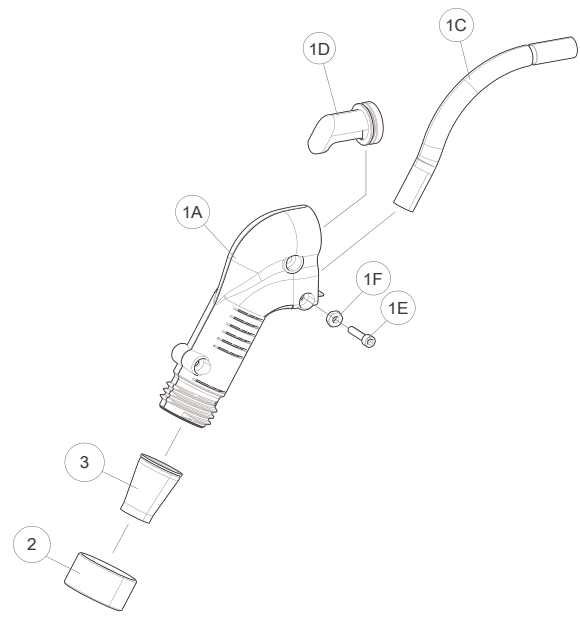
Note: When tip life is limited by tip being fused over, KP2105-[] tips may give a lower overall cost.

\* Discontinued. Use KP2095-15.

# K112 & K113 Sub Arc Gun Assembly



ITEM	DESCRIPTION	Part #	QTY	1	2
Gun & Cable Assembly:					
	600A 5/64 SUB ARC GUN & CABLE-15FT	K113-1		X	.
	600A 3/32 SUB ARC GUN & CABLE-15FT	K113-2		.	X
1	NOZZLE ASSEMBLY	9SM10614-11	1	X	.
1	NOZZLE ASSEMBLY	9SM10614-10	1	.	X
2	CLAMP & FLUX TUBE ASBLY	9SS16165	1	X	X
3	HANDLE	9SM10102-1	1	X	X
4	SOCKET HEAD CAP SCREW	9ST14438	1	X	X
5	GUN CONTROL CABLE	9SM12462-15	1	X	X
6	#8-32X.25PNHS	9SCF000148	4	X	X
7	RETAINING RING	9SS9776-7	1	X	X
8	CLAMP	9SS15921-1	1	X	X
9	CONDUCTOR CABLE - 15 FT	9SL5728-7	1	X	X
9A	CABLE HANDLE ASSEMBLY	9SM14048	1	X	X
9B	CABLE CONNECTOR	9SS12802-14	1	X	X



	NOZZLE ASSEMBLY, INCLUDES:	9SM10614-11	1	X	.
	NOZZLE ASSEMBLY, INCLUDES:	9SM10614-10	1	.	X
	NOZZLE TUBE & HOUSING	9SM10670-9	1	X	.
	NOZZLE TUBE & HOUSING	9SM10670-8	1	.	X
1A	FLUX HOUSING, RIGHT	9SG8006-1	1	X	X
1C	NOZZLE TUBE ASSEMBLY	KP4417-1	1	X	.
1C	NOZZLE TUBE ASSEMBLY	KP4418-1	1	.	X
1D	DEFLECTOR SEAL	9SL16899	1	X	X
1E	SOCKET HEAD CAP SCREW	9ST9447-22	3	X	X
1F	#8-32 HN	9SCF000042	3	X	X
2	NOZZLE COLLAR	9SS12964-2	1	X	X
3	CONE TIP, FLUX, 5/8, SUB-ARC GUN	KP1968-5	1	X	X

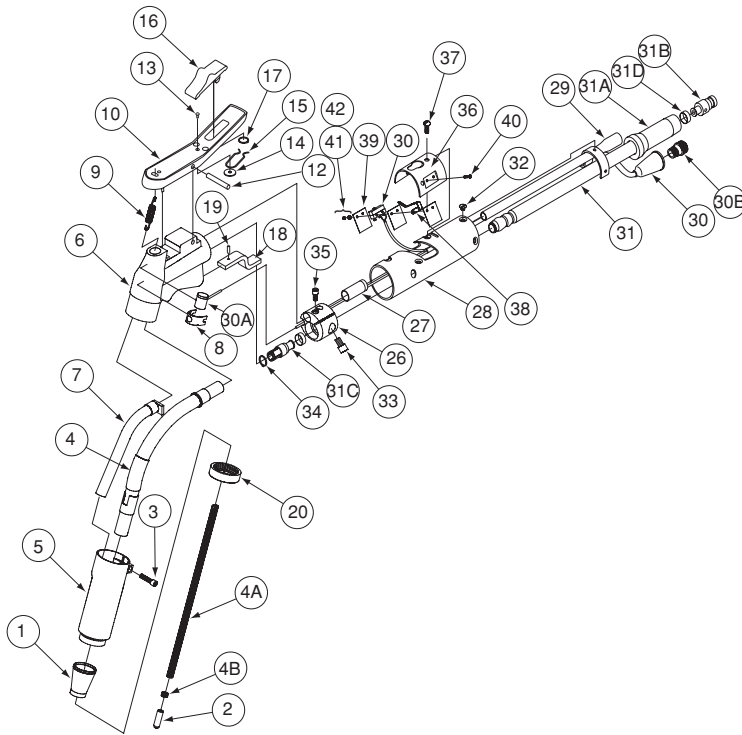
**K119 Flux Cone**

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



\* Discontinued

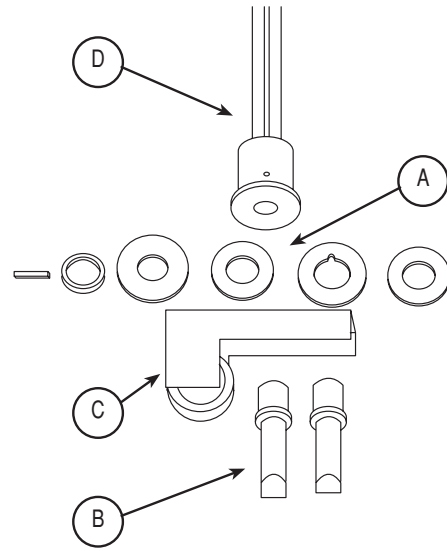
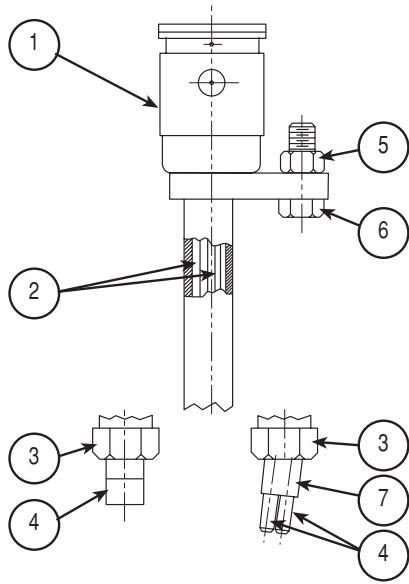
# K114 Squirtgun & Cable



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:	9SL5757-A	1
3	Socket Head Cap Screw	9ST9447-22	1
4	Nozzle, Includes:	9SS13816	1
4A	Tight Wound Steel Spring	9ST12931-2	1
4B	Liner Locking Screw	9ST12932-2	1
5	Gun Tube	9SS13042	1
6	Right & Left Gun Mount	9SL3828	1
7	Flux Shut Off Assembly	9SS11686	1
8	Receptacle Clamp	9ST11521	1
9	Spring	9ST11514	1
10	Lever	9SS11567-1	1
12	Pivot Pin	9ST11546	1
13	Rivet	9ST10167-1	1
14	Plain Washer	9SS9262-39	1
15	Spring Clip	9SS11685	1
16	Trigger	9SS11569	1
17	Snap Ring	9SS9776-16	1
18	Gun Hanger	9ST11523	1
19	Roll Pin	9ST9967-23	1
20	Collar	9SS12964-1	1
	Handle & Conductor Cable Assembly, Includes:	9SL5757-B	1
26	Clamping Ring	9SS12903	1
27	Tube Insulator	9ST11584	1
28	Handle	9SS11629	1
29	Flux Tube	9SS11822	1
30	Control Cable	9SM9473	1
	Micro Switch	9SS12182-1	1
30A	3 Contact Receptacle, Gun End	9ST11155-1	1
30B	5 Contact Receptacle, Wire End	9SS12020-6	1
31	Conductor Cable, Includes:	9SL5728-6	1
31A	Handle & Stiffener, Wire Feeder End	9SM14048	1
31B	Connector, Wire Feeder End	9SS12801-6	1
31C	Connector, Gun End	9SS12802-14	1
31D	Clamping Tube, Both Ends	9SS7748-40	2
32	#8-32 x .1875 FHS	9SCF000133	2
33	Socket Head Screw	9ST9447-8	1
34	Snap Ring	9SS9776-28	1
35	Socket Head Screw	9ST9447-21	1
36	Switch Mounting Plate	9SS11588	1
37	#8-32 x .50 RHS	9SCF000033	3
38	Actuator	9ST11527	1
39	Insulation	9ST11522	3
40	#2-56 x .4375 RHS	9SCF000135	2
41	Lock Washer	9ST9695-10	2
42	#2-56 HN	9SCF000136	2
	Nozzle Extension, 2-1/4" Stickout, (Not Shown)	9SS12891-1	1
	Housing	9SS13028-1	1
	Insert	9ST12329-1	1
	Tip [3/32"]	KP2091-1*	1

\* Discontinued. No longer available

# K129 Sub Arc Tiny Twinarc

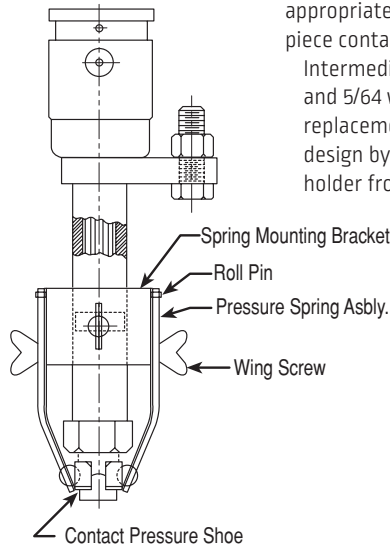


Item	Description	Part #	Qty.
Twinarc - Complete - Includes all:		<b>K129</b>	1
1	Nozzle Body Assembly	<b>9S513164</b>	1
1A	Nozzle Assembly - Stripped Includes Items 1, 3, 5 & 6	<b>M11609</b>	1
1B	Wire Kits Include Items 2, 4, A & B:		
	.045"	<b>KP1901-1</b>	1
	1/16"	<b>KP1901-2</b>	1
	5/64"	<b>KP1901-4</b>	1
	3/32"	<b>KP1901-3</b>	1
2	Guide Tube - 1/16, 5/64 & 3/32 Wire	<b>KP2092-2</b>	2
3	Nozzle Collar	<b>9S513157</b>	1
4	Contact Tip		
	.052" Wire	<b>KP1979-2</b>	1
	1/16" Wire	<b>KP2100-2B1</b>	2
	5/64" Wire	<b>KP2100-4B1</b>	2
	3/32" Wire	<b>KP2100-3B1</b>	2
5	Hex Nut 1/2-13	<b>9SCF000027</b>	1
6	Hex Head Screw 1/2-13 x 1.50	<b>9SCF000052</b>	1
7	Tip Holder - 1/16, 5/64 & 3/32 Wire (Std.), Includes:	<b>KP1988-1</b>	1
7A	Nozzle Insert	<b>KP2094-4</b>	2
7B	Tip Holder - [Special Side-by-Side Wire]	<b>KP2171-1</b>	1

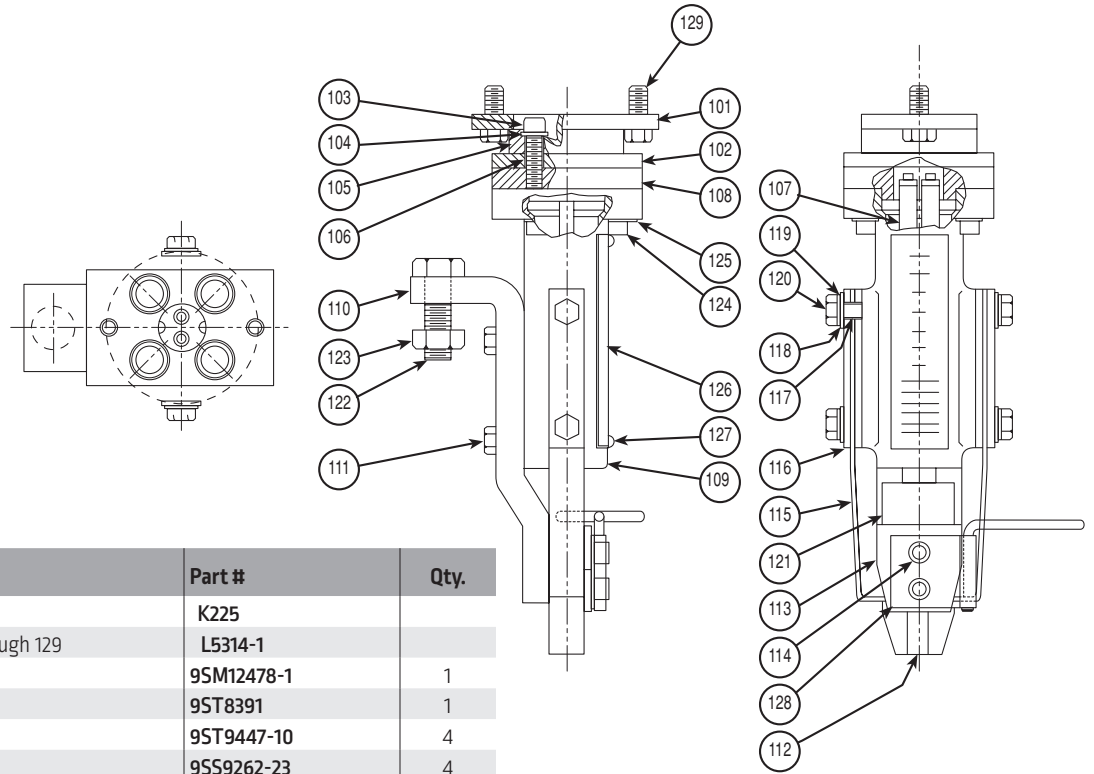
Item	Description	Part #	Qty.
A	Drive Roll - .045 & .052 Wire	<b>KP1888-1</b>	1
A	Drive Roll - 1/16 & 5/64 Wire	<b>KP1888-2</b>	1
A	Drive Roll Assembly - 3/32 Wire, Includes:		
	Outer Drive Rolls	<b>KP1889-1</b>	2
	Center Drive Roll	<b>9S514905</b>	1
	Drive Roll Spacer	<b>9ST12146-1</b>	1
	Drive Roll Key	<b>9SM8776-6</b>	1
B	Wire Guides		
	.045" & .052" Wire	<b>KP1970-1</b>	2
	5/64" & 3/32" Wire	<b>KP1970-3</b>	2
C	Idle Roll Assembly, Includes:	<b>9S513165</b>	1
	Idle Roll	<b>9S518583</b>	1
D	Incoming Wire Guide Assembly	<b>KP2122-1</b>	1

NOTES: Nozzles with spring loaded contact shoes (illustrated on the left) 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.



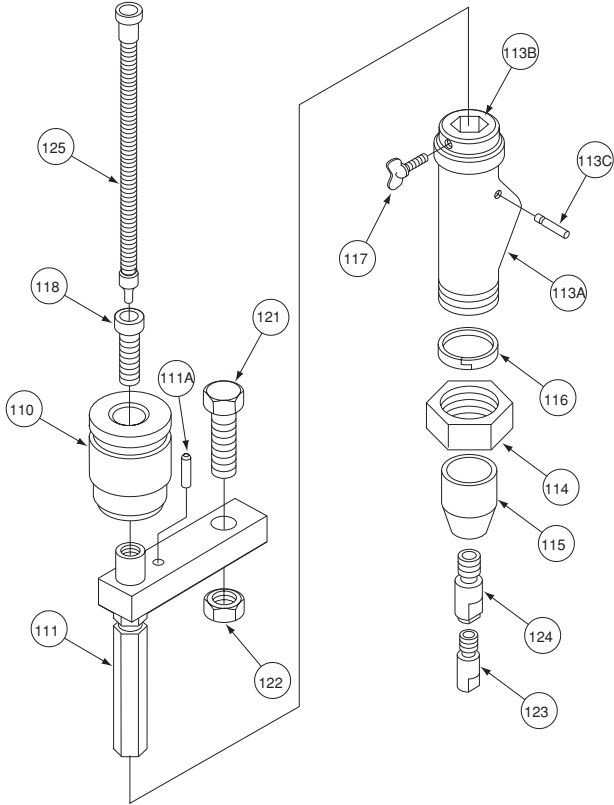
# K225 Sub Arc Twinarc Kit



Item	Description	Part #	Qty.
Twinarc - Complete - Includes All Below		K225	
Nozzle Assembly - Includes Items 101 through 129		L5314-1	
101	Adapter Plate	9SM12478-1	1
102	Adapter Insulation	9ST8391	1
103	Socket Head Screw	9ST9447-10	4
104	Washer	9SS9262-23	4
105	Insulating Washer	9SS10773-12	8
106	Insulating Bushing	9ST8390	4
107	Electrode Guide Tube	KP2084-1	2
108	Socket Plate	9SS9842	1
109	Nozzle Body	9SM7913	1
110	Current Bar	9SS9544	1
111	Hex Head Screw	9SCF000015	4
112	Center Contact Block [.375 Electrode Spacing] [.500 Electrode Spacing] [.625 Electrode Spacing]	9ST10252-1 9ST10252-2 9ST10252-3	1 1 1
113	Line Up Plate	9ST10245	1
114	Socket Head Screw	9ST9447-11	2
115	Spring	9SS7664	2
116	Spring Insulation	9ST8724	4
117	Insulating Bushing	9ST8725	4
118	Washer	9SS9262-23	4
119	Lock Washer	9SE106A-2	4
120	1/4-20 x 1.00 HHCS	9SCF000015	4
121	Contact Jaw	9ST10266	2
122	1/2-13 x 1.50 HHCS	9SCF000052	1
123	1/2-13 HN	9SCF000027	1
124	Socket Head Screw	9ST9447-10	2
125	Washer	9ST10248	2
128	Flux Tube Support Assembly	9ST10684	1
129	5/16-18 x .75 HHCS	9SCF000040	2
Drive Rolls			
	Outer Drive Rolls	KP1889-1	2
	Center Drive Roll	9SS14905	1
	Drive Roll Spacer	9ST12146-1	1
	Idle Roll Assembly	9SS13165	1
	Drive Roll Key	9SM8776-6	1
	Wire Guide Tubes - Upper & Lower	KP1982-1	2

# K231-1 Contact Nozzle Assembly

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

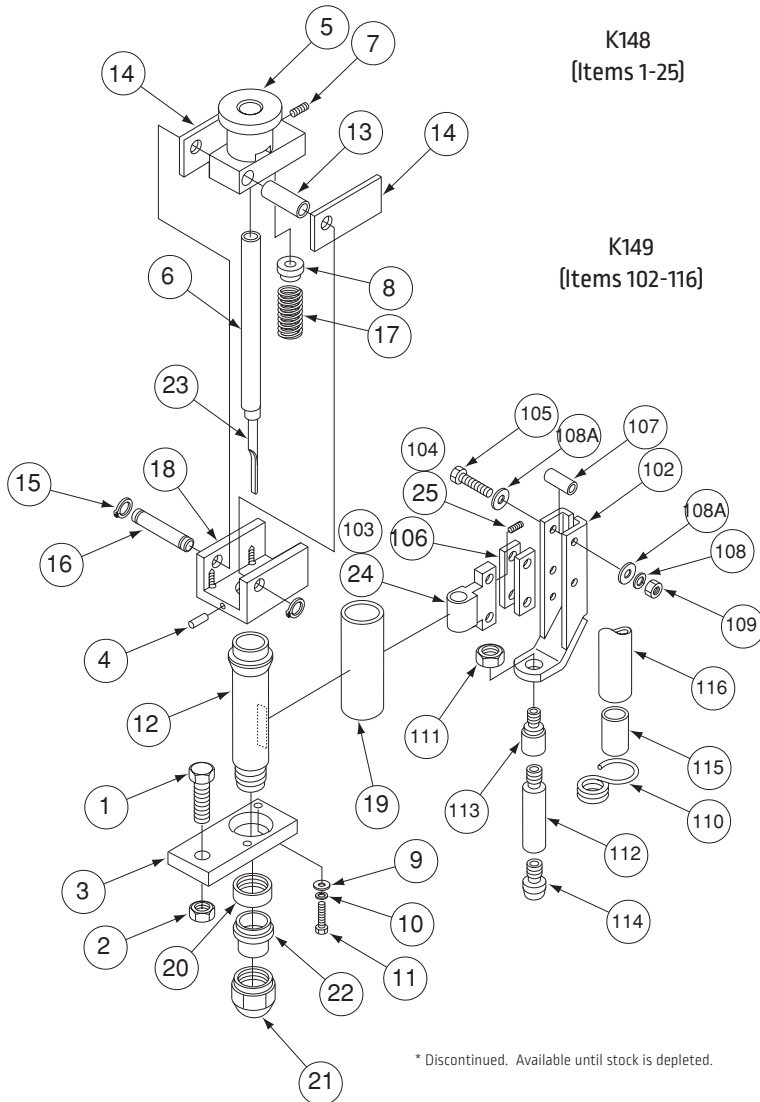


ITEM	DESCRIPTION	Part #	QTY
	*These parts are included with the K231-1		
	For LT-34 ONLY, order Items 119, 120, and 125 separately.		
	Nozzle Assembly	9SM8241-1	
110	Nozzle Insulator	9SS10493-1	1
111	Nozzle Body	9SS10157	1
111A	Roll Pin	9ST9967-10	1
113A	Cone Body Assembly, Includes:	9SM8249	1
113B	Flux Cone Plug	9SS10138	1
113C	Roll Pin	9ST9967-30	1
114	Retaining Nut	9SS10147	1
115	Flux Cone	KP2085-1	1
116	Locking Ferrule	9ST10574	1
117	Thumb Screw	9ST9078-1	1
118	Special Socket Head Screw	9ST10570	1
* 119	Rubber Flux Tube (Not Shown)	9ST10642-2	1
119	Rubber Flux Tube, LT34 Only (Not Shown)	9ST10642-10	1
* 120	Steel Flux Tube (Not Shown)	9ST6996-9	1
120	Steel Flux Tube, LT34 Only (Not Shown)	9SS10487	1
* 121	Hex Head Screw - Lead to Nozzle	9SCF000052	1
* 122	Hex Nut	9SCF000027	1
123	Contact Tip 7/32 Wire Size	KP1962-5B1	1
	3/16 Wire size	KP1962-2B1	1
	* 5/32 Wire Size	KP1962-4B1	1
	* 1/8 Wire Size	KP1962-1B1	1
	3/32 Wire Size	KP1962-3B1	1
	3/32 Wire Size; [3/8-24 Thread] Old Style	KP2082-1B1	1
	* 3/32 Wire Size; [5/16-18 Thread - See Note 1]	KP2100-3B1	1
	5/64 Wire Size; [3/8-24 Thread] Old Style	KP2082-2B1	1
	5/64 Wire Size; [5/16-18 Thread - See Note 1]	KP2100-4B1	1
	1/16 Wire Size; [5/16 -18 Thread - See Note 1]	KP2100-2B1	1
124	Adapter [3/8-24 Female Thread] for 3/32 and 5/64 KP2082 Tips	See Note 2	1
* 124	Adapter [5/16-18 Female Thread] for .035 thru 3/32 KP2100 Tips	KP1992-1	1
* 125	Nozzle Inset for 3/32 and 5/64 Wire (For NA-[ ])	9SS15106-3/32	1
125	Nozzle Inset for 5/64 Wire (For LAF-[ ] & LT-34)	KP2121-2	1
	Nozzle Extension [5.38" long] (For 3/32 & Larger Wire)	KP2721-1	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.

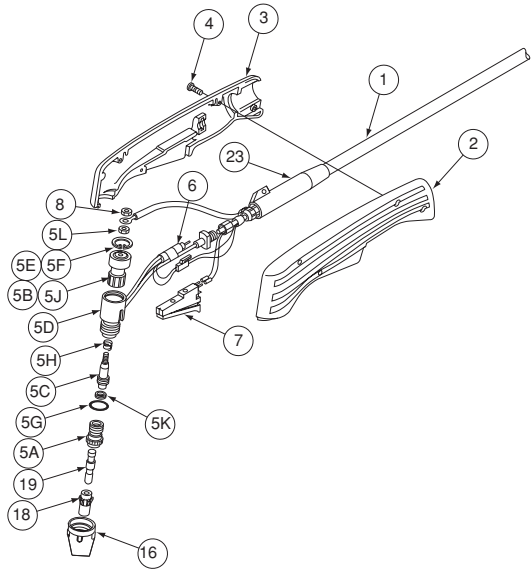
Note 2 This part is no longer available, order Adapter KP1992-1 and the appropriate KP2100 Tips or KP2105 Tips.

# Innershield® K148 Positive Contact Nozzle Parts

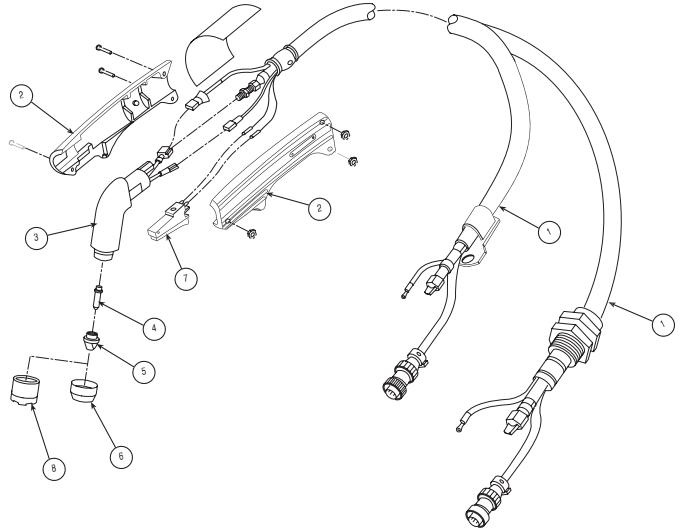


ITEM	DESCRIPTION	Part #	QTY
Contact Nozzle Assembly Includes:		K148-[A], B, C	
1	1/2-13 x 1.5 HHCS	9SCF000052	1
2	1/2-13 HN	9SCF000027	1
3	Cable Connector	9SS12576	1
4	Roll Pin	9ST9967-35	1
5	Pivot Body	9SM10340-1	1
6	Guide Tube Assembly, 3/32"-1/8" Wire	KP1974-1	1
6	Guide Tube Assembly, 5/32-3/16 Wire	KP1974-2	1
6	Guide Tube Assembly, .068-5/64 Wire	KP1974-3	1
7	Set Screw	9SS11604-19	1
8	Insulating Spacer	9ST12157	1
9	Flat Washer	9SS9262-23	2
10	Lock Washer	9SE106A-2	2
11	1/4-20 x 1.00 HHCS	9SCF000015	2
12	Nozzle Body	9SM11327	1
13	Insulating Tube	9ST7028-51	1
14	Insulation	9SS12579	2
15	Snap Ring	9SS9776-25	2
16	Pivot Pin	9ST12158	1
17	Spring	9ST10247-8	1
18	Nozzle Holder	9SS13762	1
19	Window Cover	9SS7748-64	1
20	Thread Protecting Collar	9SS13805	1
21	Nozzle Collar	9SS13804	1
22	Nozzle Tip (3/32-3/16")	KP1973-1	1
22	Nozzle Tip (.068-5/64")	KP1991-1	1
23	Inner Guide	KP1980-1	1
24	Extension Support Arm Mounting Bracket	9SS13758	
25	Set Screw	9SS11604-19	1
Water Cooling Tube Assembly (Not Illustrated)		9ST12928	
K149 Linc-Fill Extension Assembly for 3/32" Wire		K149-3/32	
K149 Linc-Fill Extension Assembly for 1/8" Wire		K149-1/8	
K149 Linc-Fill Extension Assembly for 5/32" Wire		K149-5/32	
Includes:			
102	Extension Arm Assembly	9SS13757	1
103	Mounting Block	9SS13758	1
104	Set Screw	9SS11604-19	1
105	1/4-20 x 1.375	9SCF000118	2
106	Insulation	9ST8477-16	2
107	Insulating Tube	9ST11851-3	2
108	Lock Washer	9SE106A-2	2
108A	Plain Washer	9SS9262-23	2
109	1/4-20 HN	9SCF000017	2
110	Flux Hose Clamp	9ST12929	1
111	1/8-11 HJN	9SCF0000140	1
112	Extension Tube - 2" Long	KP1975-2	1
113	Extension Tube - 1" Long	KP1975-1*	1
114	Extension Tube End (2 3/4 Electrical Stickout)	KP1976-3	1
114	Extension Tube End (2 1/4 Electrical Stickout)	KP1990-1	1
114	Extension Tube End	KP1976-1	1
114	Extension Tube End	KP1976-4	1
114	Extension Tube End	KP1976-2	1
115	Flux Hose	9ST10642-34	1
116	Flux Tube Tip	9SS7748-35	1

# PCT-20 Handheld Torch



# PCT-40 & 60 Torch & Cable



ITEM	DESCRIPTION	Part #	QTY
	PCT 20 Torch & Cable Asbly -15'	K1615-1	1
1	Cable Assembly (15')	NSS	1
1	Cable Assembly (25')	NSS	1
2	Gun Handle (Left & Right)	9SG3110	1
4	Machine Screw	9SS18825-1	1
5	Torch Head Asbly, Includes:	9SM17874	1
5A	Swirl Ring Asbly	9SS22148	1
5B	Insulator	9SS22152	1
5C	Piston	9SS22153	1
5D	Torch Body Asbly	9SS22998	1
5E	Retaining Ring	9SS9776-67	1
	O-Ring	9ST13483-35	2
5G	O-Ring	9ST13483-23	1
5H	Compression Spring	9ST11862-55	1
5J	Seal (Rod & Piston)	9SS23002-1	1
5K	Seal (Rod & Piston)	9SS23002-2	1
5L	#12-28 Br HN	9SCF000206	1
6	Solenoid Assembly	9SS23866	1
	Hose Clamp	9SS20710-13	2
	Pincers (Hose Clamp Crimping Tool)	NSS	
7	Trigger & Housing Assembly	9SS21002	1
8	#12-28 Brass Hex Nut	9SCF000206	1
9	Decal	9SS18750-12	1
	O-Ring	9ST13483-36	1
16	Shield Cup	KP2064-1	1
18	Vortech Nozzle (.028")	KP2062-1B1*	1
19	Electrode	KP2063-1B1*	1

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

**NSS - Not Sold Separately**

ITEM	DESCRIPTION	Part #	QTY
	MAG PCT-60 Torch & Cable Assembly 70°, 60 Amp, 25 Ft.	K871-1	1
	MAG PCT-40 Torch	Discontinued	
1	Cable Assembly 60 Amp, 25 Ft.	L7747-1	1
	50 Ft.	L7747-2	1
1	Cable Assembly 40 Amp, 25 Ft.	L8478-1	1
	50 Ft.	L8478-2	1
	25 Ft.	L8932-1	1
	50 Ft.	L8932-2	1
2	Handle Repair Kit, includes:	9SS19837	1
	Handle, LH	G1974	1
	Handle Nut	9SS18773	3
	Handle, RH	NSS	1
	#6-32 x .75 PHS	9SS18825-1	3
3	Torch Head Molded Assembly	9SM15616	1
4	Electrode	KP2012-1B1*	1
5	Nozzles - PCT-60		
	Cutting .035" (.9 mm) Orifice	KP2008-1B1*	1
	Cutting .042" (1.1 mm) Orifice	KP2008-2B1*	1
	Cutting .052" (1.3 mm) Orifice	KP2008-3B1*	1
	Gouging .078" (2.0 mm) Orifice	KP2008-4B1*	1
	Nozzles - PCT-40		
	Cutting .042" (1.1 mm) Orifice	KP2008-5B1*	1
6	Shield Cup Assembly (PCT-60)	KP2077-1	1
6	Shield Cup Assembly (PCT-40)	KP2014-1	1
7	Trigger Assembly	9SS21002	1
8	Drag Cup Assembly (PCT-60)	KP2075-1	1
8	Drag Cup Assembly (PCT-40)	KP2027-1**	1

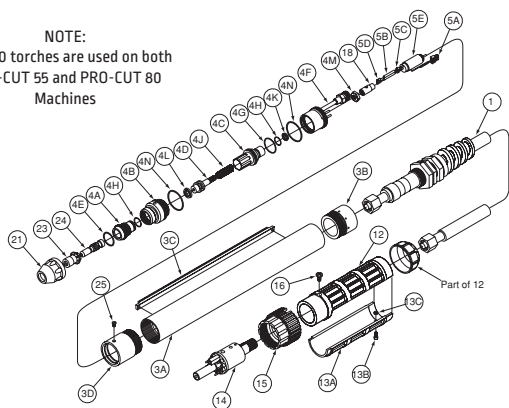
\* Part # listed is a package quantity of 5.

\*\* Discontinued



# PCT-80 Machine Torch

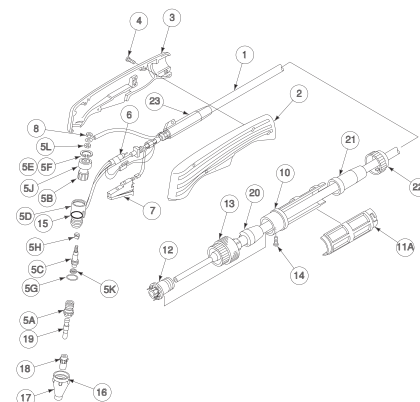
NOTE:  
PCT-80 torches are used on both  
PRO-CUT 55 and PRO-CUT 80  
Machines



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

# PCT-80 Handheld Torch

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

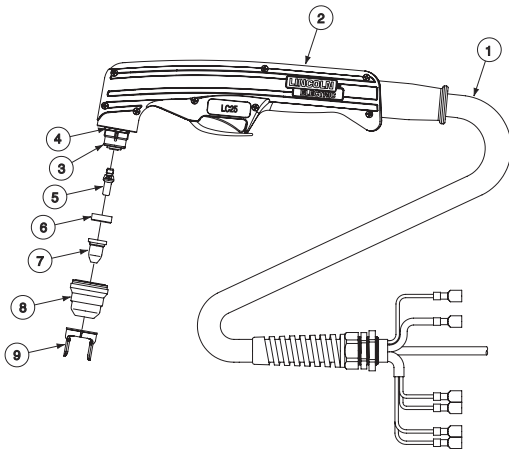


ITEM	DESCRIPTION	Part #	QTY
PCT 80 Torch & Cable Assembly 25'			
		K1571-1	1
PCT 80 Torch & Cable Assembly 50'			
		K1571-2	1
1	Cable Assembly -25'	L10259-1	1
	Cable Assembly -50'	L10259-2	
2	Handle (Left & Right)	9G3110	1
4	Machine Screw	9S518825-1	1
5	Torch Head Assembly, Includes:	9SM17874	1
5A	Swirl Ring Assembly	9S522148	1
5B	Insulator	9S522152	1
5C	Piston	9S522153	1
5D	Torch Body Assembly	9S522998	1
5E	Retaining Ring	9S59776-67	1
5F	O-Ring	9ST13483-35	2
5G	O-Ring	9ST13483-23	1
5H	Compression Spring	9ST11862-55	1
5J	Seal (Rod & Piston)	9S523002-1	1
5K	Seal (Rod & Piston)	9S523002-2	1
5L	#12-28 Brass Hex Nut	9SCF000206	1
6	Solenoid Assembly	9S523866	1
	Hose Clamp	9S520710-13	2
	Pincers (Hose Clamp Crimping Tool)	NSS	
7	Trigger & Housing Assembly	9S521002	1
8	#12-28 Brass Hex Nut	9SCF000206	1
	Decal	9S518750-11	1
10	Handle Top	9S522990-1A	1
11A	Handle Bottom, Includes:	9S524048	1
	#4-40 Socket Head Cap Screw	9ST9447-102	1
	#4-40 Hex Nut	9SCF000002	1
12	Central Adapter Assembly	9S522990-1E	1
13	Collar Nut	9S522990-1F	1
14	Fillister Head Screw	9S522990-1G	1
15	O-Ring	9ST13483-36	1
16	Shield Cup	KP2064-1	1
17	Drag Cup	KP2065-1**	1
18	Nozzle (35 - 60 Amp.)	KP2062-2B1*	1
18	Nozzle (60 - 85 Amp.)	KP2062-3B1*	1
19	Electrode	KP2063-1B1*	1
20	Strain Relief	9S524015	1
21	Cable Boot	9S524773	1
22	Handle Nut	9S522990-1C	1
23	Handle Boot	9SM15751-1	1
	Spring Boot	9S524676-1	1
	Bushing	9S524679-1	1

\* Part # listed is a package quantity of 5. \*\* Part # listed is a package quantity of 6.

\*\*\*= obsolete

# Tomahawk® LC25



ITEM	DESCRIPTION	Part #	QTY
LC25 Torch & Cable Assembly, Includes:			
1	Cable Assembly (10 Ft.)	95S28173-3	1
2	Handle	95S28173-1	1
3	Torch Head (70°)	95S28173-2	1
4	"O" Ring	95S28173-4	1
5	Electrode	KP2842-1	5
6	Swirl Ring	KP2842-4	3
7	Nozzle	KP2842-2	5
8	Retaining Cap	KP2842-3	1
9	Spacer	KP2842-5	2
10	Electrode Key (Not Shown)	95S28173-5	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

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

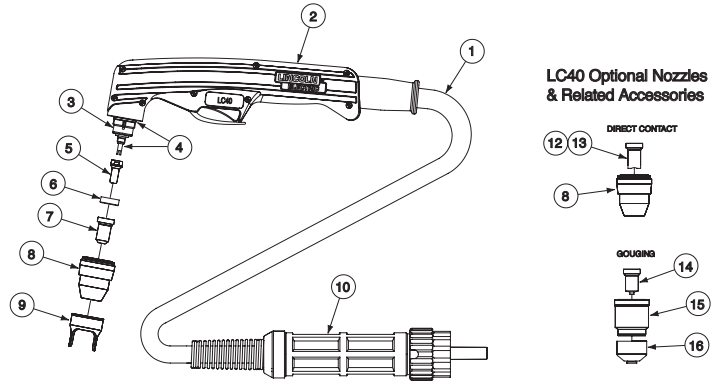


**K2886 - Plasma Circle Cutting Guide Kit**  
For cutting circles from 2" to 40" (50.8 -1016mm) in diameter



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

# Tomahawk® LC40



ITEM	DESCRIPTION	Part #	QTY
LC40 Handheld Plasma Torch (20') (6m), Includes:			
	LC40 Cable (20') (6m)	K2847-1	1
1	LC40 Cable (20') (6m)	95S28174-2	1
2	Handle (Includes Trigger)	95S28173-1	1
3	Torch Head (70°)	95S28174-1	1
4	Cooling Kit (Includes Cooling Tube & O-Ring)	95S28174-3	1
5	Electrode	KP2843-1	5
6	Swirl Ring	KP2842-4	3
7	Nozzle (40A)	KP2843-2	5
8	Retaining Cap	KP2843-5	1
9	Spacer	KP2843-10	2
10	Connector Assembly	95S28174-4	1
11	Electrode Key (Not Shown)	95S28173-5	1

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

## LC 40 TORCH AND CONSUMABLES

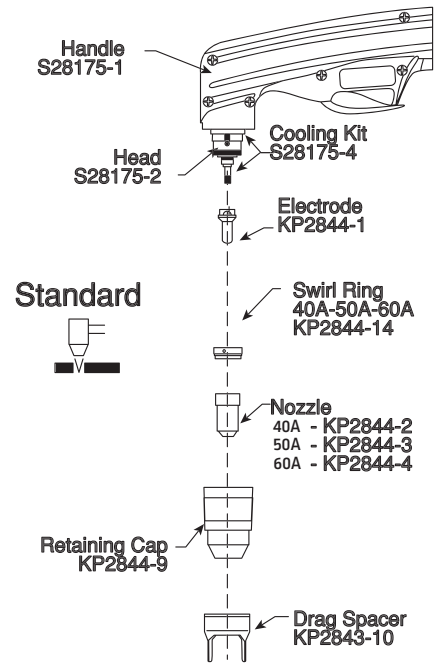
Product Number	Description	
K2847-1	Complete Torch*	
KP2843-1	Electrode	Standard
KP2843-2	Nozzle 40A	Standard
KP2843-3	Nozzle (Contact) 40A	Options
KP2843-4	Nozzle (Gouging)	Options
KP2843-5	Retaining Cap	Standard
KP2843-6	Retaining Cap (Gouging)	Options
KP2843-8	Gouge Shield	Options
KP2843-9	Nozzle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

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

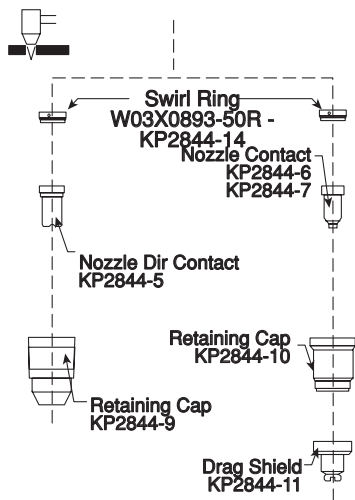
- It is normal for the electrode and nozzle to wear during operation.
- Electrodes should typically be replaced when erosion reaches 0.025 in. (0.65 mm).
- A green and erratic arc will indicate the end of electrode life. The electrode should be immediately replaced.
- It is recommended that the KP2843-1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

# Tomahawk® LC65 Handheld Plasma Torch

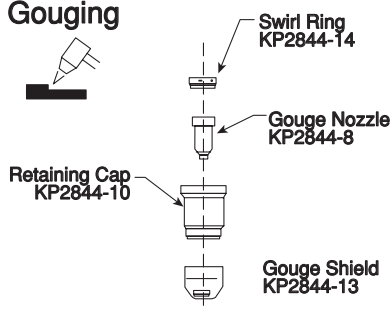
## LC65 Parts



## Contact



## Gouging



Description	Part #	
LC65 Handheld Plasma Torch 25 ft (7.5 m)	K2848-1	
LC65 Handheld Plasma Torch 50 ft (15 m)	K2848-2	
Electrode (60A)	KP2844-1	Standard
Nozzle (60A)	KP2844-4	Standard
Retaining Cap (40A-60A)	KP2844-9	Standard
Drag Spacer	KP2843-10	Standard
Swirl Ring (40,50,60A)	KP2844-14	Standard

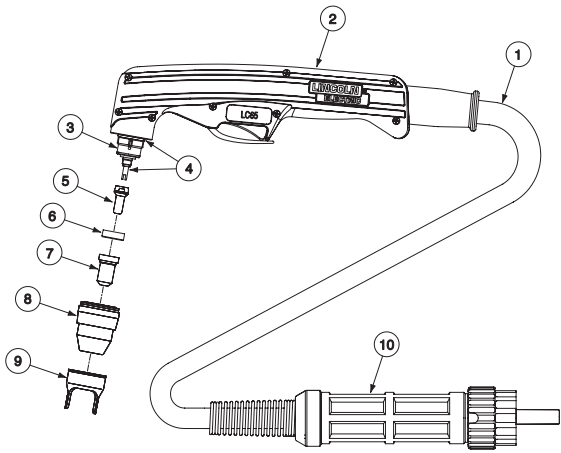
### Optional Nozzles & Related Accessories: (Not Included in K2848-1 or -2)

Nozzle (40A)	KP2844-2	Optional
Nozzle (50A)	KP2844-3	Optional
Nozzle (Direct Contact) (40A)	KP2844-5	Optional
Nozzle (Shielded Contact) (50A)	KP2844-6	Optional
Nozzle (Shielded Contact) (60A)	KP2844-7	Optional
Nozzle (Gouging)	KP2844-8	Optional
Retaining Cap (Shielded Contact)	KP2844-10	Optional
Shield (50,60A)	KP2844-11	Optional
Gouge Shield	KP2844-13	Optional
LC-65M Machine Plasma Torch (25') (7.5m)	K2848-3	
Electrode	KP2844-1	Standard
Nozzle (60A)	KP2844-4	Standard
Retaining Cap (40,60A)	KP2844-9	Standard
Swirl Ring (40,50,60A)	KP2844-14	Standard

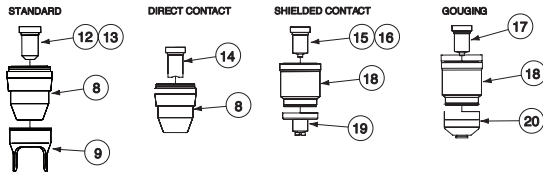
### Optional Nozzles & Related Accessories: (Not Included in K2848-3)

Nozzle (40A)	KP2844-2	Optional
Nozzle (50A)	KP2844-3	Optional
Nozzle (Shielded Contact) (50A)	KP2844-6	Optional
Nozzle (Shielded Contact) (60A)	KP2844-7	Optional
Nozzle (Gouging)	KP2844-8	Optional
Retaining Cap (Shielded Contact)	KP2844-10	Optional
Gouge Shield	KP2844-12	Optional
Drag Spacer	KP2843-10	Optional

# Tomahawk® LC 65 Handheld Plasma Torch

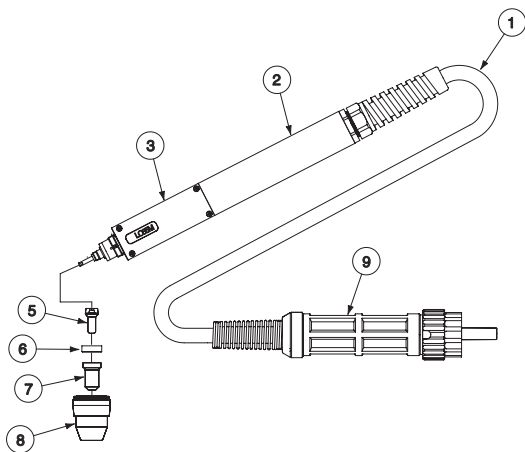


### LC65 Optional Nozzles & Related Accessories

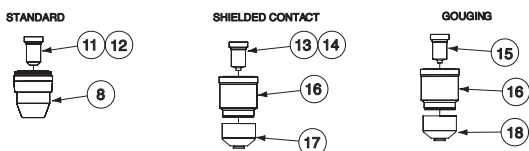


ITEM	DESCRIPTION	Part #	QTY
	LC65 Handheld Plasma Torch (25') (7.5m), Includes:	K2848-1	
1	LC65 Cable (25') (7.5m)	S28175-5	1
	LC65 Handheld Plasma Torch (50') (15m), Includes:	K2848-2	
1	LC65 Cable (50') (15m)	S28175-3	1
2	Handle (Includes Trigger)	S28175-1	1
3	Torch Head (70°)	S28175-2	1
4	Cooling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

# Tomahawk® LC 65M Machine Plasma Torch



### LC65M Optional Nozzles & Related Accessories

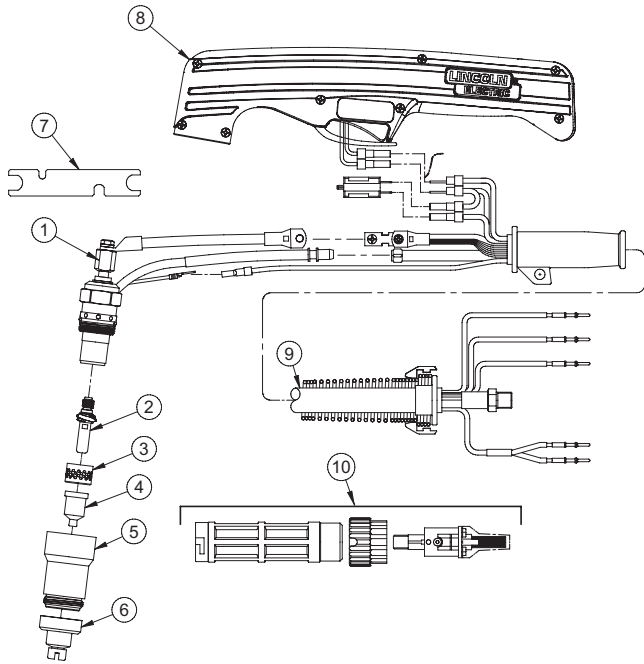


ITEM	DESCRIPTION	Part #	QTY
	LC65M Machine Plasma Torch (25') (7.5m), Includes:	K2848-3	1
1	LC65M Cable (25') (7.5m)	S28175-7	1
2	Positioning Tube	S28175-8	1
3	Torch Head (180°)	S28175-6	1
5	Electrode	KP2844-1	5
6	Swirl Ring (40,50,60A)	KP2844-14	3
7	Nozzle (60A)	KP2844-4	5
8	Retaining Cap (40,60A)	KP2844-9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

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

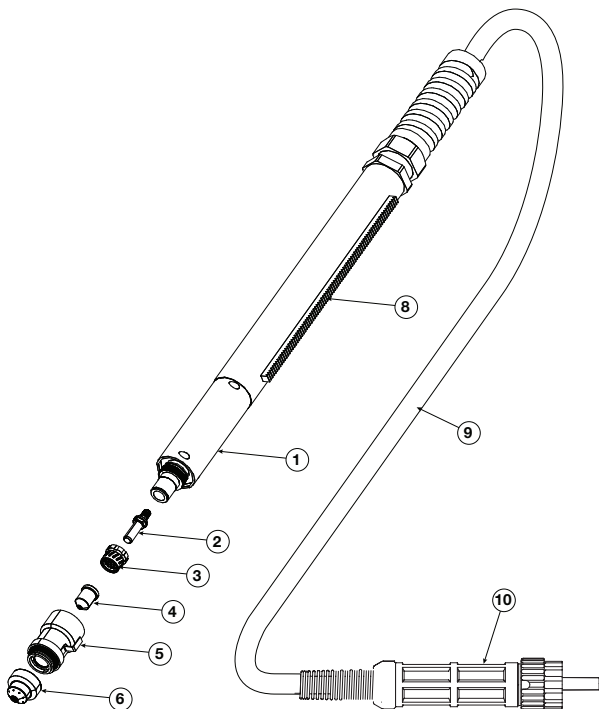
\*\* Part # listed is a package quantity of 2

# Tomahawk® LC105 Handheld Plasma Torch



ITEM	DESCRIPTION	Part #	QTY	1	2
	LC105 TORCH (25 FT.) INCLUDES:	K2849-1		X	.
	LC105 TORCH (50 FT.) INCLUDES:	K2849-2		.	X
1	HEAD (70 DEGREE)	9SS28176-1	1	X	X
2	ELECTRODE (LC105)	KP2845-1	1	X	.
2	ELECTRODE (LC105)	KP4141-1	1	.	X
3	SWIRL RING (LC105)	KP2845-11	1	X	.
3	SWIRL RING (LC105)	KP4141-9	1	.	X
4	NOZZLE - 100A (LC105)	KP2845-8	1	X	.
4	NOZZLE (40A)	KP4141-4	1	.	X
4	NOZZLE (60A)	KP4141-5	1	.	X
4	NOZZLE (80A)	KP4141-6	1	.	X
4	NOZZLE (100A)	KP4141-7	1	.	X
4	NOZZLE (GOUGING) (80A)	KP4141-18	1	.	X
4	NOZZLE (GOUGING) (100A)	KP4141-19	1	.	X
5	RETAINING CAP (CONTACT)	KP2845-10	1	X	.
5	RETAINING CAP (CONTACT)	KP4141-8	1	.	X
6	DRAG SHIELD CAP (40A)	KP2845-2	1	X	.
6	DRAG SHIELD CAP (60-80A)	KP4141-15	1	.	X
6	DRAG SHIELD CAP (100A)	KP4141-16	1	.	X
6	DRAG SHIELD CAP (80-100A)	KP4141-17	1	.	X
7	ELECTRODE KEY (WRENCH)	9SS28173-5	1	X	X
8	HANDLE (INCLUDES TRIGGER)	9SS28175-1	1	X	X
9	LC105 CABLE (50 FT)	9SS28176-3	1	X	X
9	LC105 CABLE (25 FT)	9SS28176-2	1	X	X
10	CONNECTOR ASSEMBLY (HANDHELD TORCH)	9SS28176-7	1	X	X

# Tomahawk® LC105MR Machine Plasma Torch



ITEM	DESCRIPTION	Part #	QTY
	LC105MR TORCH (25FT), INCLUDES:	K2849-3***	
	LC105MR TORCH (50FT), INCLUDES:	K2849-4***	
1	HEAD (180 DEGREE)	9SS28176-5	1
2	ELECTRODE LC105M	KP4141-1	2
3	SWIRL RING LC105M	KP4141-9	1
4	NOZZLE (80A) LC105M	KP4141-6	2
5	RETAINING CAP ASSEMBLY (CTP) LC105M	KP4141-8	1
6	DRAG SHIELD CAP (100A) LC105M	KP4141-15	1
8	POSITIONING TUBE	9SS28175-8	1
9	LC105MR CABLE (25 FT)	9SS28176-6	1
9	LC105MR CABLE (50 FT)	9SS28176-9	1
10	CONNECTOR ASSEMBLY (MACHINE TORCH)	9SS28176-8	1

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

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

\*\*\* Obsolete

# 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 Torches

## PRODUCT SPECIFICATIONS PTA-9, -17, -26 SERIES AIR-COOLED TIG TORCHES

Product Name	Part Number	Rated Amperage	Duty Cycle	Cable Length ft. (m)	Number of Cables	Tungsten Range in (mm)
PTA-9	K1781-1	125	60%	12.5 (3.8)	1	0.020 - 1/8 (0.8 - 3.2)
	K1781-3			25.0 (7.6)		
PTA-9F Ultra-Flex <sup>(1)</sup> Pkg.	K1781-9	125	60%	12.5 (3.8)	1	0.020 - 1/8 (0.8 - 3.2)
PTA-17	K1782-1	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-2			12.5 (3.8)	2	
	K1782-3			25.0 (7.6)	1	
	K1782-4			25.0 (7.6)	2	
PTA-17F	K1782-10	150	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-17FV	K1782-11	150	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-13			12.5 (3.8)		
PTA-17V	K1782-6	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-7			12.5 (3.8)	2	
	K1782-8			25.0 (7.6)	1	
	K1782-9			25.0 (7.6)	2	
PTA-17 Ultra-Flex	K1782-12	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0 mm)
PTA-26	K1783-1	200	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1783-2			12.5 (3.8)	2	
	K1783-3			25.0 (7.6)	1	
	K1783-4			25.0 (7.6)	2	
PTA-26F	K1783-10	200	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-26FV	K1783-11	200	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-26V	K1783-7	200	60%	12.5 (3.8)	2	0.020 - 5/32 (0.5 - 4.0)
	K1783-8			25.0 (7.6)	1	
	K1783-9			25.0 (7.6)	2	

(1) 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.

## PRODUCT SPECIFICATIONS PTW-18, -20 & 20H-320 SERIES WATER-COOLED TIG TORCHES

Product Name	Part Number	Rated Amperage	Duty Cycle	Cable Length ft. (m)	Number of Cables	Tungsten Range in (mm)
PTW-18	K1784-1	350	100%	12.5 (3.8)	3	0.020 - 5/32 (0.5 - 4.0)
	K1784-2			25.0 (7.6)		
PTW-20	K1784-3	250	100%	12.5 (3.8)	3	0.020 - 1/8 (0.5 - 3.2)
	K1784-4			25.0 (7.6)		
20H-320-25R	K4168-2	320	100%	25.0 (7.6)	3	0.020 - 1/8 (0.5 - 3.2)

### What You Need To Get Started

Along with your Pro-Torch TIG torch, you may need to purchase the following accessories to begin welding:

#### TIG Torch Connection Adapter

A variety of adapters exist to connect to a variety of output terminals such as 1/2 in. (12.7 mm) studs, Twist-Mate output terminals and Precision TIG-style connectors.

#### Tungsten Electrode

Your welding supplier can provide you with the proper electrode for your application. Use the Tungsten Electrode chart, as a guide for ordering the appropriate tungsten.

### Expendables

#### Parts Kits

Parts Kits conveniently provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box.

#### Collets

These hold the tungsten firmly in your torch. They are purchased according to the tungsten size and must be used with the proper corresponding collet bodies, or gas lens collet bodies.

#### Collet Bodies and Gas Lens Collet Bodies

Collet bodies hold the collet and tungsten in place. Gas lens collet bodies are used in conjunction with gas lenses when precise control of shielding gas flow is required.

#### Alumina Nozzles

These nozzles, made of high temperature ceramic material, protect the collet body and direct the gas flow to the weld. Choose them according to the chart on this page 7, for your specific application.

#### Back Cap

Each torch comes with one back cap which is sufficient for most applications. PTA-9 and PTW-20 torches include a medium back cap. PTA-17, PTA-26 and PTW-18 torches include a long back cap. The 20H-320-25R includes a medium back cap. However, optional longer or shorter back caps are available for each torch.

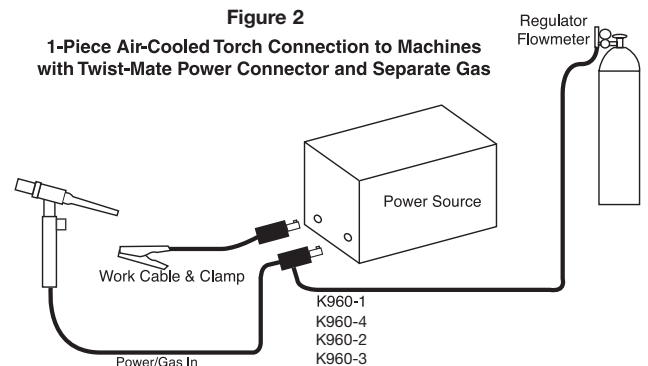
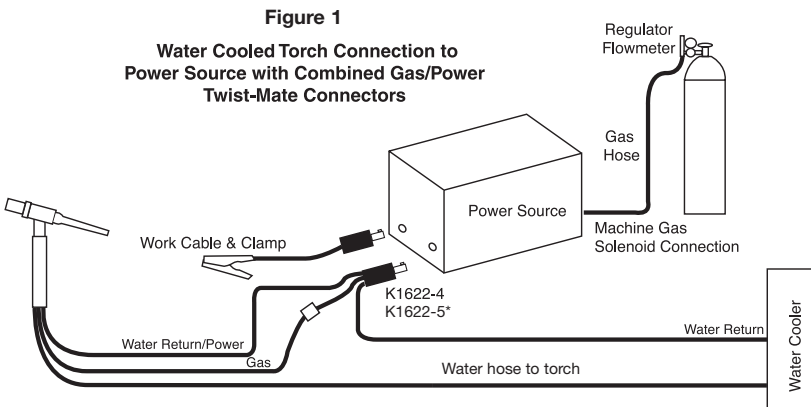
# TIG Torch Connection Adapters

These adapters connect the TIG torch cables to the power source. May be required for certain torches.

DESCRIPTION	PART NO. (INDUSTRY REF.)	FIGURE
<b>PRECISION TIG 275 &amp; 375 POWER SOURCES</b>		
PTA-26, 26V, 26F, 26FV one piece cable	K2166-1	4
PTA-9, 9F, 17F, 17V, 17FV one piece	K2166-3	4
PTA-17V, -26V two piece cable	K2166-2	4
PTW-18, 20 and 20H-320	No adapter required	-
<b>FOR POWER SOURCES WITH 1/2 IN OUTPUT TERMINALS (INCLUDING THE TIG MODULE)</b>		
PTW-18, 20 and 20H-320	K2505-2, K1622-4	-
PTA-26, 26F, 26V, 26FV one piece cable	K2505-2, K1622-3	-
PTA 9 one piece cable	K2505-2, K1622-1	-
PTA-17V, 26V two piece cable	No adapter required	-
<b>FOR SQUARE WAVE TIG 175, PRECISION TIG 225, INVERTEC V160-T, AND ASPECT™ 375 AND POWER SOURCES WITH TWIST-MATE RECEPTACLE (WITH GAS PASS THROUGH)</b>		
PTA-9, -9F, 17, 17F, 17V, 17FV one piece cable	K1622-1	3
PTW-18, 20 and 20H-320	K1622-4, *K1622-5 (recommended for the Aspect 375)	1
PTA-26, 26V, 26F, 26FV one piece cable	K1622-3	3
<b>FOR INVERTEC V155-S AND POWER SOURCES WITH SMALL TWIST-MATE RECEPTACLE AND SEPARATE GAS</b>		
PTA-17V, 17FV one piece cable	K960-2	2
<b>FOR POWER SOURCES WITH TWECO STYLE OUPUT TERMINAL AND SEPARATE GAS</b>		
PTW-18, 20, 20H-320	K1622-6	-
PTA-17V, 17VF one piece cable	K960-4	2
PTA-26V, 26FV one piece cable	K960-3	2
<b>FOR POWER MIG® 210 MP AND POWER SOURCES WITH TWIST-MATE RECEPTACLE AND SEPARATE GAS</b>		
PTA-17V, 17FV one piece cable	K960-1	2



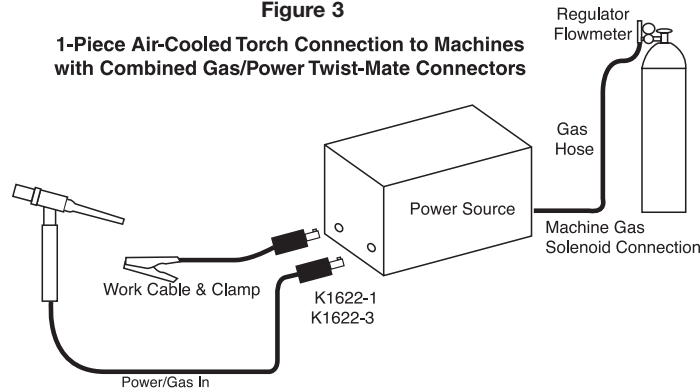
- Use K2505-1 for connecting Twist-Mate Adapter with gas pass through to Twist-Mate receptacle without gas pass through (separate gas).



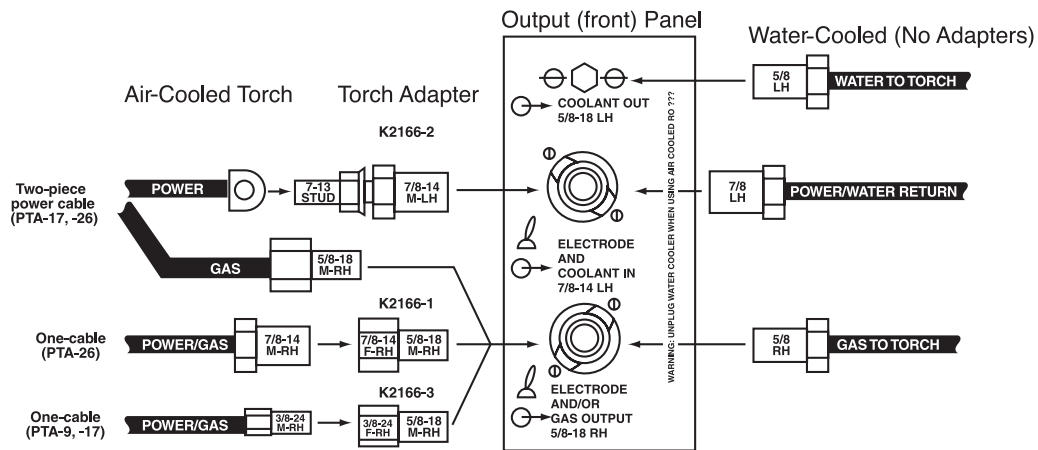


## TIG Torch Connection Adapters continued

**Figure 3**  
1-Piece Air-Cooled Torch Connection to Machines with Combined Gas/Power Twist-Mate Connectors



**Figure 4**  
Precision TIG 275 & 375



## Gas Hook-up Kits

for Connecting Power Sources with 1/2 in. (50.8 mm) output terminals



KP504

### KP504 FOR PTW-18 AND PTW-20

Part #	Industry Std. Part #	Description	
9SS19558-4	40V76	Water Hose	12.5 ft. (3.8m)
9SS19558-1	40V77	Gas Hose	12.5 ft. (3.8m)
9SS19558-5		Water Adapter Fittings	5/8 ft. (15.8mm)
9SS19558-6	11N18	Water Hose Coupler	
9SS19257-1	45V11	Power Cable Adapter	



KP505

### KP505 FOR PTA-9, PTA-9F, PTA-17, PTA-17F, PTA-26 AND PTA-26F

Part #	Industry Std. Part #	Description	
9SS19558-2	-	Gas Hose	18 in. (457mm) from solenoid valve to power cable adapter
9SS19558-1	40V77	Gas Hose	12.5 ft. (3.8m)



KP506

### KP506 (FOR PTA-17V AND PTA-26V)

Part #	Industry Std. Part #	Description	
9SS19558-1	40V77	Gas Hose	12.5 in. (3.8m) with 5/8-18 right hand male fittings.

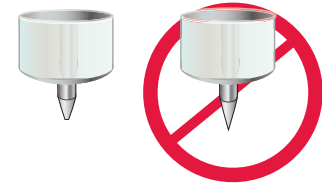
# Tungsten Electrode

Pure Tungsten Is Not Recommended For Inverter Based Power Sources

COLOR	TUNGSTEN TYPES	AC POLARITY	DC POLARITY	APPLICATIONS
Gold	1.5% Lanthanum		•	Good choice for welding titanium, nickel, copper, mild steel and stainless steel
Blue	2% Lanthanum	•	•	Good all around choice for both AC and DC, in welding low alloyed and non-corroding steels, aluminum, magnesium, titanium, nickel, and copper
Grey	2% Ceriated	•	•	
Chartreuse or Purple	1.5% Lanthanum, 0.08% Zirconium, 0.08% Yttrium	•	•	
White	0.08% Zirconiated	•		A very good choice for aluminum or magnesium alloys

TUNGSTEN DIAMETER IN (MM)	CUP SIZE	DC POLARITY AMP RANGE	AC POLARITY AMP RANGE
0.020 [0.50]	3, 4 or 5	2-20	2-20
0.040 [1]	4 or 5	15-80	20-80
1/16 [1.58]	4, 5 or 6	30-140	40-150
3/32 [2.38]	6, 7 or 8	60-220	70-230
1/8 [3.17]	7, 8 or 10	220-325	240-350
5/32 [3.97]	8 or 10	300-420	350-420

## TUNGSTEN SHAPING



Tungsten should have a slightly blunted tip.

## TIG Parts Kits

Parts Kits provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box. Five kits are available.

### KP507 (For PTA-9 Series Air-Cooled Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-2B1	13N21	Collet	0.040 [1.0]
1	KP2029-3B1	13N22	Collet	1/16 [1.6]
1	KP2031-2B1	13N26	Collet Body	0.040 [1.0]
1	KP2031-3B1	13N27	Collet Body	1/16 [1.6]
1	KP2017-1B1	w13N08	Alumina Nozzle	1/4 [6.0]
1	KP2017-2B1	13N09	Alumina Nozzle	5/16 [8.0]
1	KP2017-3B1	13N10	Alumina Nozzle	3/8 [10.0]
1			Tungsten Electrode, 2% Ceriated 0.040 x 7.0 in [1.0 x 178 mm]	
1			Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in [1.6 x 178 mm]	

### KP508 (For PTA-17 Series Air-Cooled Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2036-2B1	57Y04	Back Cap	Short
1	KP2030-2B1	10N22	Collet	0.040 [1.0]
1	KP2030-3B1	10N23	Collet	1/16 [1.6]
1	KP2030-4B1	10N24	Collet	3/32 [2.4]
1	KP2032-2B1	10N30	Collet Body	.040 [1.0]
1	KP2032-3B1	10N31	Collet Body	1/16 [1.6]
1	KP2032-4B1	10N32	Collet Body	3/32 [2.4]
1	KP2016-6B1	10N50	Alumina Nozzle	1/4 [6.0]
1	KP2016-5B1	10N49	Alumina Nozzle	5/16 [8.0]
1	KP2016-4B1	10N48	Alumina Nozzle	3/8 [10.0]
1			Tungsten Electrode, 2% Ceriated .040 x 7.0 in [1.0 x 178 mm]	
1			Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in [1.6 x 178 mm]	
1			Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in [2.4 x 178 mm]	

## TIG Parts Kits continued

## KP509 (PTW-18, PTA-26 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2036-2B1	57V04	Back Cap	Short
1	KP2030-3B1	10N23	Collet	1/16 (1.6)
1	KP2030-4B1	10N24	Collet	3/32 (2.4)
1	KP2030-5B1	10N25	Collet	1/8 (3.2)
1	KP2032-3B1	10N31	Collet Body	1/16 (1.6)
1	KP2032-4B1	10N32	Collet Body	3/32 (2.4)
1	KP2032-5B1	10N28	Collet Body	1/8 (3.2)
1	KP2016-5B1	10N49	Alumina Nozzle	5/16 (8.0)
	KP2016-4B1	10N48	Alumina Nozzle	3/8 (10.0)
	KP2016-2B1	10N46	Alumina Nozzle	1/2 (12.5)
1			Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in (1.6 x 178 mm)	
1			Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in (2.4 x 178 mm)	
1			Tungsten Electrode, 2% Ceriated 1/8 x 7.0 in (3.2 x 178 mm)	

## KP510 (For PTW-20, 20H-320 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-3B1	13N22	Collet	1/16 (1.6)
1	KP2029-4B1	13N23	Collet	3/32 (2.4)
1	KP2029-5B1	13N24	Collet	1/8 (3.2)
1	KP2031-3B1	13N27	Collet Body	1/16 (1.6)
1	KP2031-4B1	13N28	Collet Body	3/32 (2.4)
1	KP2031-5B1	13N29	Collet Body	1/8 (3.2)
1	KP2017-2B1	13N09	Alumina Nozzle	5/16 (8.0)
	KP2017-3B1	13N10	Alumina Nozzle	3/8 (10.0)
	KP2017-4B1	13N11	Alumina Nozzle	1/2 (12.5)
1			Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in (1.6 x 178 mm)	
1			Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in (2.4 x 178 mm)	
1			Tungsten Electrode, 2% Ceriated 1/8 x 7.0 in (3.2 x 178 mm)	

## KP2414-1 Gas Lens Parts Kit (For PTA-9, PTW-20, 20H-320 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-2B1	13N21	Collet	0.040
1	KP2029-3B1	13N22	Collet	1/16 (1.6)
1	KP2029-4B1	13N23	Collet	3/32 (2.4)
1	KP2033-2B1	45V42	Gas Lens Collet Body	0.040
1	KP2033-3B1	45V43	Gas Lens Collet Body	1/16 (1.6)
1	KP2033-4B1	45V44	Gas Lens Collet Body	3/32 (2.4)
1	KP2019-2B1	53N59	Gas Lens Nozzle	#5
	KP2019-3B1	53N60	Gas Lens Nozzle	#6
	KP2019-4B1	53N61	Gas Lens Nozzle	#7
1			Tungsten Electrode, 2% Ceriated 0.040 (1.0 mm)	
1			Tungsten Electrode, 2% Ceriated 1/16 in (1.6 mm)	
1			Tungsten Electrode, 2% Ceriated 3/32 in (2.4 mm)	

Parts shown are not actual size.

# TIG Expendable Parts

COLLET



## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP2029-1B1	13N20	0.020 [0.5]
	KP2029-2B1	13N21	0.040 [1.0]
	KP2029-3B1	13N22	1/16 [1.6]
	KP2029-4B1	13N23	3/32 [2.4]
	KP2029-5B1	45V24	1/8 [3.2]

## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP2030-1B1	10N21	0.020 [0.5]
	KP2030-2B1	10N22	0.040 [1.0]
	KP2030-3B1	10N23	1/16 [1.6]
	KP2030-4B1	10N24	3/32 [2.4]
	KP2030-5B1	10N25	1/8 [3.2]
	KP2030-6B1	54N20	5/32 [4.0]

## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP2031-1B1	13N25	0.020 [0.5]
	KP2031-2B1	13N26	0.040 [1.0]
	KP2031-3B1	13N27	1/16 [1.6]
	KP2031-4B1	13N28	3/32 [2.4]
	KP2031-5B1	13N29	1/8 [3.2]

COLLET BODY



## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP2032-1B1	10N29	0.020 [0.5]
	KP2032-2B1	10N30	0.040 [1.0]
	KP2032-3B1	10N31	1/16 [1.6]
	KP2032-4B1	10N32	3/32 [2.4]
	KP2032-5B1	10N28	1/8 [3.2]
	KP2032-6B1	406488	5/32 [4.0]

## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP2017-1B1	13N08	1/4 [6]	4	1-5/32 in [29.3 mm]
	KP2017-2B1	13N09	5/16 [8]	5	
	KP2017-3B1	13N10	3/8 [10]	6	
	KP2017-4B1	13N11	7/16 [11]	7	
	KP2017-5B1	13N12	1/2 [12.5]	8	
	KP2017-6B1	13N13	5/8 [16]	10	

ALUMINA NOZZLES



## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP2016-6B1	10N50	1/4 [6]	4	1-5/32 in [29.3 mm]
	KP2016-5B1	10N49	5/16 [8]	5	
	KP2016-4B1	10N48	3/8 [10]	6	
	KP2016-3B1	10N47	7/16 [11]	7	
	KP2016-2B1	10N46	1/2 [12.5]	8	
	KP2016-1B1	10N45	5/8 [16]	10	

Parts shown are not actual size.

## TIG Expendable Parts continued

## GAS LENS COLLET BODIES



## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body	KP2033-1B1	45V41	0.020 (0.5)
	KP2033-2B1	45V42	0.040 (1.0)
	KP2033-3B1	45V43	1/16 (1.6)
	KP2033-4B1	45V44	3/32 (2.4)
	KP2033-5B1	45V45	1/8 (3.2)

## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body <sup>1</sup>	KP2034-1B1	45V29	0.020 (0.5)
	KP2034-2B1	45V24	0.040 (1.0)
	KP2034-3B1	45V25	1/16 (1.6)
	KP2034-4B1	45V26	3/32 (2.4)
	KP2034-5B1	45V27	1/8 (3.2)
	KP2034-6B1	45V28	5/32 (4.0)

## ALUMINA GAS LENS NOZZLES



## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle	KP2019-1B1	53N58	1/4 (6)	4	1 in (25.4 mm)
	KP2019-2B1	53N59	5/16 (8)	5	
	KP2019-3B1	53N60	3/8 (10)	6	
	KP2019-4B1	53N61	7/16 (11)	7	

## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle <sup>2</sup>	KP2018-5B1	54N18	1/4 (6)	4	1-5/8 in (41.3 mm)
	KP2018-4B1	54N17	5/16 (8)	5	
	KP2018-3B1	54N16	3/8 (10)	6	
	KP2018-2B1	54N15	7/16 (11)	7	
	KP2018-1B1	54N14	1/2 (12.5)	8	
	KP2018-6B1	54N19	11/16 (17)	Short	1-1/8 in (28.5 mm)

[1] Note: Use of these Gas Lens Collet Bodies requires a KP2037-3B1 (54N01) Gas Lens Insulator

[2] Note: Use of these Alumina Gas Lens Nozzles requires a KP2037-3B1 (54N01) Gas Lens Insulator

## BACK CAPS



## FOR PTA-9, PTW-20 &amp; 20H-320 SERIES TORCHES

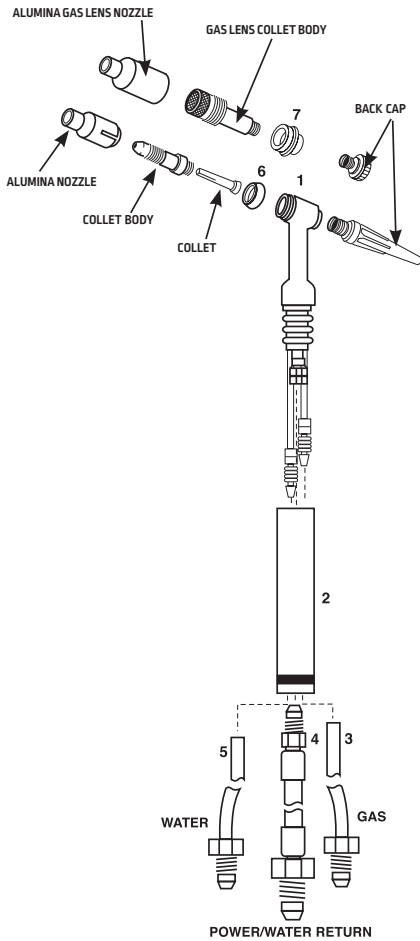
Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Back Caps	KP2035-1B1	41V33	Short
	KP2035-2B1	41V35	Medium
	KP2035-4B1	41V24	Long

## FOR PTA-17, PTA-26 &amp; PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Back Caps	KP2036-1B1	57Y02	Long
	KP2036-2B1	57Y04	Short

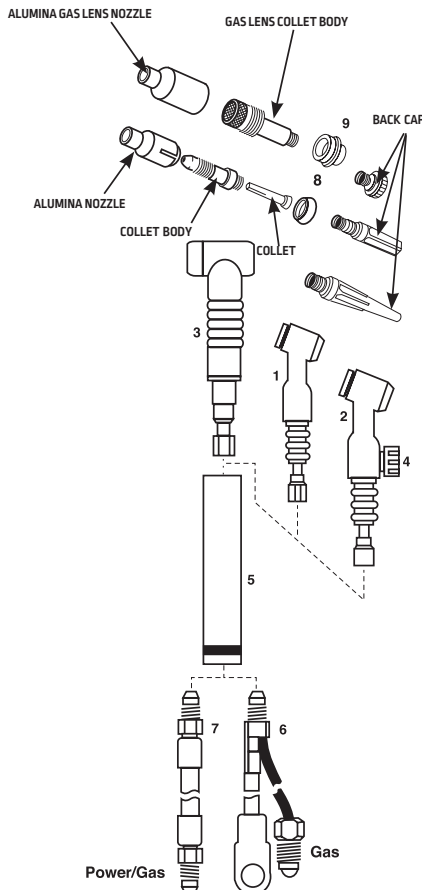
Parts shown are not actual size.

# TIG Replacement Parts



## FOR PTA-18 SERIES & PTW-20 SERIES WATER COOLED TORCHES

Item No.	Part No.	Industry Ref. No.	Description ft. (m)
1	9SS19261-1	—	Torch body with gaskets, PTW-18
1	9SS19262-1	—	Torch body with gaskets, PTW-20
2	9SS19511-2	—	Torch Handle, PTW-18
2	9SS19511-1	—	Torch Handle, PTW-20
3	9SS19512-17	40V75	<b>Gas Hose</b> , 12.5 (3.8), PTW-18
3	9SS19512-20	40V30	<b>Gas Hose</b> , 25 (7.6), PTW-18
3	9SS19512-11	45V09	<b>Gas Hose</b> , 12.5 (3.8), PTW-20
3	9SS19512-14	45V10	<b>Gas Hose</b> , 25 (7.6), PTW-20
4	9SS19512-15	40V64	<b>Power Cable</b> , 12.5 (3.8), PTW-18
4	9SS19512-9	45V03	<b>Power Cable</b> , 12.5 (3.8), PTW-20
4	9SS19512-18	41V29	<b>Power Cable</b> , 25 (7.6), PTW-18
4	9SS19512-12	45V04	<b>Power Cable</b> , 25 (7.6), PTW-20
5	9SS19512-16	40V74	<b>Water Hose</b> , 12.5 (3.8), PTW-18
5	9SS19512-10	45V07	<b>Water Hose</b> , 12.5 (3.8), PTW-20
5	9SS19512-19	41V32	<b>Water Hose</b> , 25 (7.6), PTW-18
5	9SS19512-13	45V08	<b>Water Hose</b> , 25 (7.6), PTW-20
6	9SS19515-7	18CG	Cup Gasket, 2 pack, PTW-18
6	9SS19515-6	598882	Cup Gasket, 2 pack, PTW-20
7	KP2037-3B1	54N01	Gas Lens Insulation, 2 pack, PTW-18



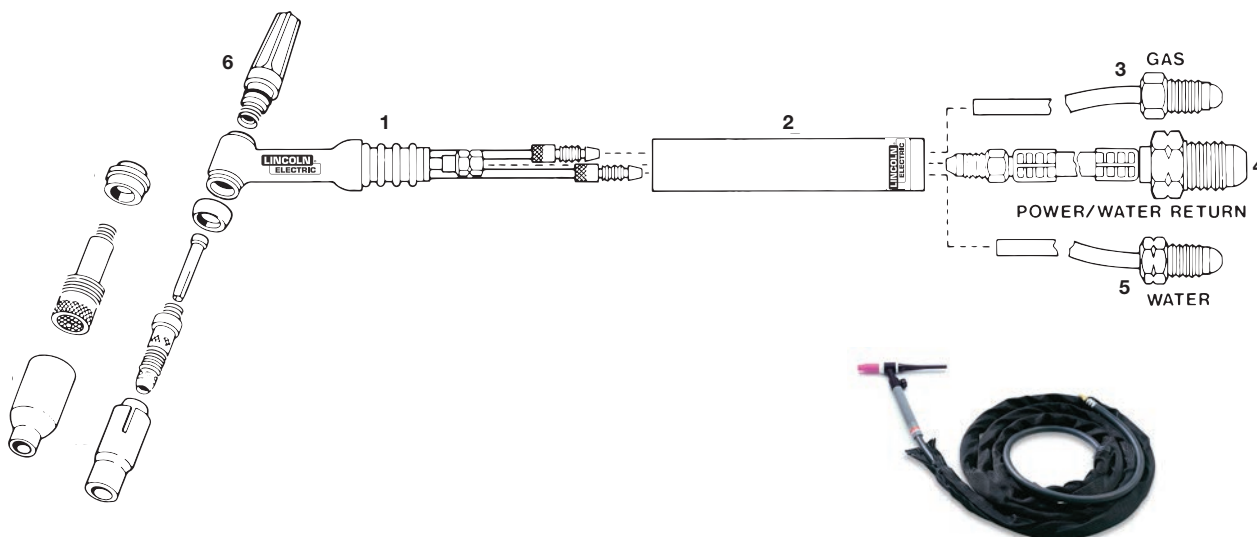
## PTA-9, -17, -26 SERIES AIR-COOLED REPLACEMENT PARTS

Item No.	Part No.	Industry Ref. No.	Description ft. (m)
1	9SS19258-1	—	Torch body with gaskets, PTA-9
1	9SS19259-1	—	Torch body with gaskets, PTA-17
1	9SS19260-1	—	Torch body with gaskets, PTA-26
2	9SS19259-2	—	Torch body with gaskets, PTA-17V
2	9SS19260-2	—	Torch body with gaskets, PTA-26V
3	9SS24923-1	—	Torch Body with gaskets, PTA-17F
3	9SS24925-1	—	Torch Body with gaskets, PTA-26F
4	9SS19515-1	VS-2	Valve Knob with "O" Ring, PTA-17V
4	9SS19515-2	VS-1	Valve Knob with "O" Ring, PTA-26V
5	9SS19511-1	—	Torch Handle, PTA-9, 17, 17V
5	9SS19511-2	—	Torch Handle, PTA-26, 26V
6	9SS19512-2	57Y01-2	Power Cable and Gas, 2Pc, 12.5 (3.8), PTA-9, 17
6	9SS19512-6	46V28-2	Power Cable and Gas, 2Pc, 12.5 (3.8), PTA-26,
6	9SS19512-4	57Y03-2	Power Cable and Gas, 2Pc, 25 (7.6), PTA-9
6	9SS19512-8	46V30-2	Power Cable and Gas, 2Pc, 25 (7.6), PTA-26
7	9SS19512-1	57Y01R	Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-9, 17,
7	9SS19512-5	46V28R	Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-26,
7	9SS19512-3	57Y03R	Power Cable and Gas, 1Pc, 25 (7.6), PTA-9, 17
7	9SS19512-7	46V30R	Power Cable and Gas, 1Pc, 25 (7.6), PTA-26
7	9SS25811-1	57Y01BR	Ultra-Flex Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-9, -17
7	9SS25811-2	46V28BR	Ultra-Flex Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-26
8	9SS19515-6	598882	Cup Gasket, 2 pack, PTA-9
8a	9SS19515-7	18CG	Cup Gasket, 2 pack, PTA-17, 26
9	KP2037-3B1	54N01	Gas Lens Insulation, 2 pack, PTA-26, 17

## TIG Replacement Parts continued

### 20H-320-25R WATER-COOLED 320 AMPS

Item No.	Part No.	Industry Ref No.	Description ft. (m)
1	S31183-4	-	Torch body, red silicone
2	S31183-5	-	Torch handle, fluted
3	S31183-2	45V10R	Gas hose, 25 (7.6)
4	S31183-1	45V04HR	Power cable, 25 (7.6)
5	S31183-3	45V08HR	Water hose, 25 (7.6)
6	KP2035-2B1	41V35	Medium cap
7	-	18CG	Cup gasket



**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.)

### TIG ACCESSORIES

**K814**  
**6-Pin Arc Start™ Switch**  
May be used in place of the Foot or Hand Ampctrl™. 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**  
**6-Pin Hand Ampctrl™**  
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**  
**12-Pin Hand Ampctrl™ with Universal Connector**  
Provides 25 ft. (7.6 m) of remote



current control for TIG welding.

**K870**  
**6-Pin Foot Ampctrl™**  
Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).



**K870-2**  
**12-Pin Foot Ampctrl™ with Universal Connector**  
Provides 25 ft. (7.6 m) of remote current control for TIG welding.



**K2320-1**  
**6-Pin Foot Ampctrl™ Connector Kit**  
Provides 25 ft. (7.6 m) of remote output control for TIG welding. (6-pin plug connection).



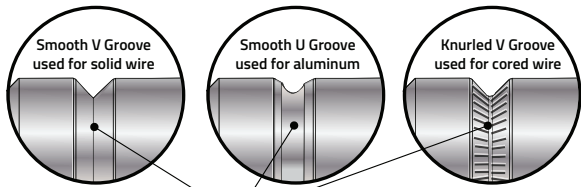
**K2909-1**  
**6-pin to 12-pin Adapter**  
Use for adapting existing 6-pin remote controls such as the K870, K857, and K963-3 to the new 12-pin connector.



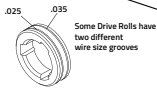
# Drive Rolls

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.

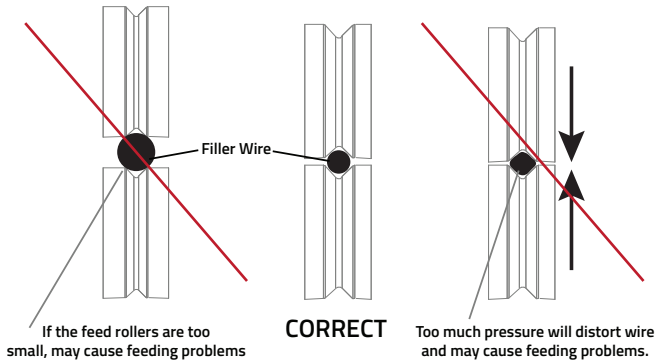


**IMPORTANT!**  
Size facing outward must match the welding wire size.



Some Drive Rolls have two different wire size grooves

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.



## INDUSTRIAL WIRE FEEDERS

AutoDrive 4R90 .....	J	SP-135T .....	C
AutoDrive S .....	H1	SP-140-I .....	C
AutoDrive SA .....	H2	SP-140T .....	P1
AutoDrive 4R100 .....	J	SP-150 .....	E
AutoDrive 4R220 .....	J	SP-170 .....	C
Activ8™ .....	K1	SP-170-I .....	C
Bester Handy MIG .....	B2	SP-170T .....	C
Cruiser (Tractor) .....	L	SP-175 Plus .....	D
DH10 .....	K2	SP-175T .....	C
FlexFeed 74 HT (4 Roll) .....	K2	SP-180T .....	P1
Flex Feed 84 .....	K2	SP-200 .....	E
LF-72 (2 Roll) .....	K1	SP-250 & SP-255 .....	F
LF-74 (4 Roll) .....	K2	STT-10 (4 Roll) .....	J
LN-10 (4 Roll) .....	J	SYNERGIC 7 (4 Roll) .....	I
LN-15 .....	K1	Wire-Matic 250 & 255 .....	F
LN-23P .....	E		
LN-25 .....	E		
LN-25 PRO .....	K1		
LN-25 PRO Dual Power .....	K1		
LN25X .....	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) .....	G		
LN-9 GMA (2 Roll) .....	E		
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 Feed 84 .....	K2		
Power Feed 84 Dual .....	K2		
Power Wave C300 .....	K1		
Power Wave C350 .....	K1		
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 210 .....	N		
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 256 .....	K1		
POWER MIG 260 .....	K1		
POWER MIG 300 .....	K1		
POWER MIG 350MP .....	K1		
SP-100 .....	D		
SP-100-I .....	C		
SP-100T .....	C		
SP-125 Plus .....	D		
SP-130T .....	C		
SP-135 Plus .....	D		

## 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
Mega Force 140iMP .....	P2
MIG Pak 10 .....	C
MIG Pak 15 .....	C
MIG Pak 140 [Code 11440] .....	P1
MIG Pak 140 [Code 11636] .....	P2
MIG Pak 140MP .....	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 175 .....	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

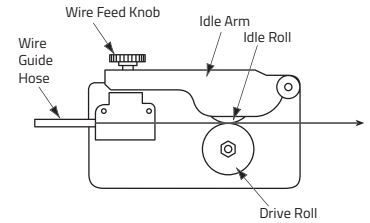
## A - Handy Core 100 (Arcweld Brand), Handy MIG 101 (Arcweld Brand)

Wire Size	Type	Drive Roll	Idle Arm	Idle Roll	Wire Feed Knob	Wire Guide Hose	Gun & Cable Assembly
.023-.035"	Groove 1: .023-.025" Wire Groove 2: .030-.035" Wire	9SS24355-14	9SS24355-7	9SS24355-6	9SS24355-9	9ST10642-120	9SS24355-16

### PARTS FOR 9SS24355-16 GUN & CABLE ASSEMBLY

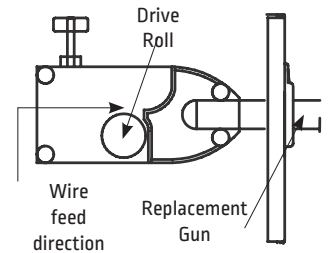
Description	Part Number	Notes
Contact Tips		
.023-.025" Wire	KP11-25	10/Pkg
.030" Wire	KP11-30	10/Pkg
.035" Wire	KP11-35	10/Pkg
Gas Nozzle	KP2080-2*	
Insulated Gun Tube	9SS24355-27	
Gun Trigger	9SS24355-23	
Cable Liner .023-.030"	KP2080-1*	

\* Discontinued. Available until stock is depleted.



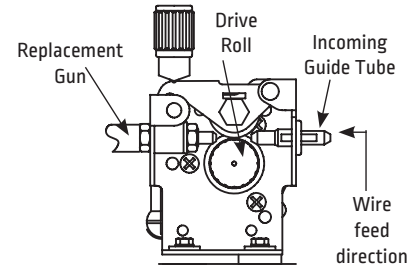
## B1 - Handy Core, MIG Pak HD, Quick Weld, Weld-Pak HD

Wire Size	Type	Drive Roll(s)	Replacement Gun & Cable Assembly
.035" Cored Wire	Groove 1: .035" Knurled Groove 2: .035" Knurled	KP2243-035	9SS25532-11 (FCAW) 9SS25695-11 (GMAW)



## B2 - Handy MIG, Bester Handy MIG

Wire Size	Type	Drive Roll(s)	Incoming Guide Tube	Replacement Gun & Cable Assembly
.023-.030" Solid .035" Cored Wire	Groove 1: .023-.030" Solid Groove 2: .035" Cored Wire	KP2200-1	9SS25351-6	9SS25351-11 (GMAW)

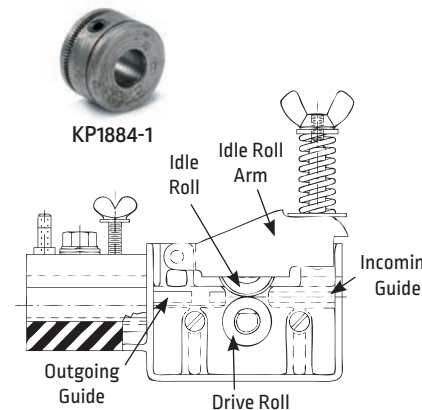


### PARTS FOR 9SS25532-11 GUN & CABLE ASSEMBLY (B-1 WIRE DRIVE), 9SS25695-11 GUN & CABLE ASSEMBLY (B-1 WIRE DRIVE) 9SS25351-11 GUN & CABLE ASSEMBLY (B-2 WIRE DRIVE)

Description	Part Number	Notes
Contact Tips:		
.023-.025" Wire	KP11-25	10/Pkg
.030" Wire	KP11-30	10/Pkg
.035" Wire	KP11-35	10/Pkg
Diffuser:		
Flux Core (Gasless)	KP1939-1	
Gas Nozzle	KP21-50-F	
Gun Trigger	9SS25351-51	

## 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, Weld Pak 175

Wire Size	Type	Drive Roll(s)	Idle Arm	Idle Roll	Incoming Guide Tube	Outgoing Guide Tube
.023-.030" Solid .035" Cored	Groove 1: .023-.025" Smooth Groove 2: .030-.035" Knurled	KP1884-1	L7562	M9300-55	KP2009-10	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>				



<sup>(1)</sup>Also included with K549-2 Innershield Welding Kit. <sup>(2)</sup>Only available with K664-2 Aluminum Welding Kit

# Drive Rolls

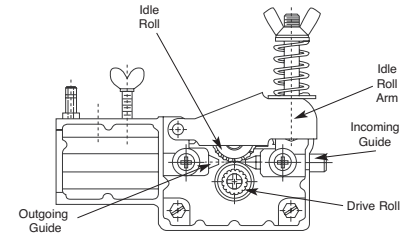
## D - SP-100, SP-125 Plus, SP-135 Plus, SP-175 Plus

### DRIVE ROLL KITS

Groove 1 Wire Size	Groove 1 Type	Groove 2 Wire Size	Groove 2 Type	Drive Roll Kit #
.023-.025"	V-groove	.030-.035"	V-groove	KP1881-1
.035"	Knurled	.035"	Knurled	KP666-035C
.035-.045"	Knurled	.035-.045"	Knurled	KP666-045C(1)

Machine	Incoming Guide	Outgoing Guide	Idle Roll Arm	Idle Roll
SP100 (below code #10000)	KP2006-1	KP2007-1	9SL7562	9SM9300-55*
All other Models & Codes	KP2141-1	KP2140-1		

\*For .035 Aluminum Wire - 9S24219



## 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	-	KP2125-1	KP2124-1
.030"	V-groove	KP653-030S	-	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	-	-
0.12	Knurled	KP653-120C	-	-	-



KP653-035C



KP654-1/16A

### KP654 DRIVE ROLL KITS\*

Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide	Outgoing Guide Insert
.035"	Aluminum	KP654-035A	-	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.

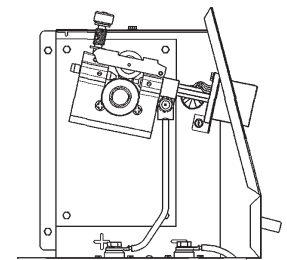
## F - SP-250, SP-255, Wire-Matic 250 & 255

### KP674 DRIVE ROLL KITS

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

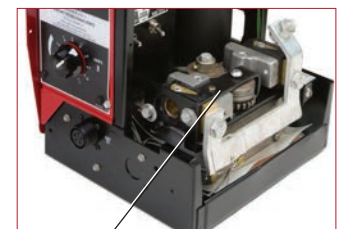
\*Split drive roll design

(2) Use for SP250, SP250-1 or SP255. KP2053-2 for Wire-Matic has been discontinued.



## G - LN-8 (2 Roll), LN-9 (2 Roll), NA-5R (2 Roll),

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

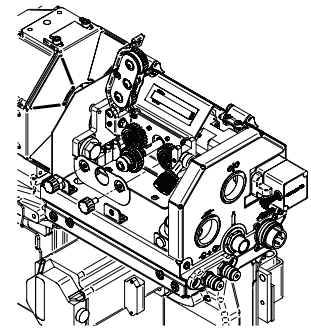


Idle Roll Assembly

# Drive Rolls

## H1 - AutoDrive S

Wire Size	Type	Drive Roll Kit #	GROOVED DRIVE ROLL	Main Drive Gear	Smooth Drive Roll
.035"	Solid	KP4335-035S	S31417-035S	S31418-1	S31419
.040"	Solid	KP4335-040S	S31417-040S	S31418-1	S31419
.045"	Solid	KP4335-045S	S31417-045S	S31418-1	S31419
.052"	Solid	KP4335-052S	S31417-052S	S31418-1	S31419
.035"	Aluminum	KP4335-035A	S31417-035A	S31418-1	S31419
3/64"	Aluminum	KP4335-364A	S31417-364A	S31418-1	S31419
1/16"	Aluminum	KP4335-116A	S31417-116A	S31418-1	S31419



## H2 - AutoDrive SA

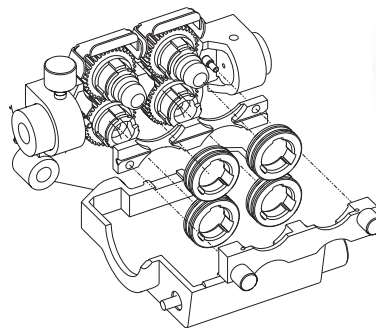
Wire Size	Type	Drive Roll Kit #	GROOVED DRIVE ROLL	Torx Key	Torx Screw	Height Gauge
.035"	Aluminum	KP4414-035A	S29654	T15184	S25930-9	M25236
3/64"	Aluminum	KP4414-364A	S29654-2	T15184	S25930-9	M25236
1/16"	Aluminum	KP4414-116A	S29654-3	T15184	S25930-9	M25236

## 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	KP655-035S	-	-	KP2125-1	KP2124-1
.045 - .052"	Cored	KP655-052C	-	KP2114-2	KP1999-1	KP2124-3
.045 - .052"	Solid	KP655-052S	-	KP2114-2	KP1999-1	KP2124-3
1/16"	Solid/Cored	KP655-1/16	-	-	KP2125-3	KP2124-5
.068 - 3/32"	Cored	KP655-3/32	-	KP655-3/32	KP2125-5	KP2124-8
7/64 - .120"	Cored	KP655-120C*	T13467-120F	-	-	-

## J AutoDrive 4R90, LN-10 (4 Roll), AutoDrive 4R100, AutoDrive 4R220, 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	KP1505-030S
.035"	Solid	KP1505-035S
.030 - .035"	Cored	KP1505-035C
.040	Solid	KP1505-.040S
.040 - .045"	Solid	KP1505-045S
.040 - .045"	Cored	KP1505-045C
.052"	Solid	KP1505-052S
.052"	Cored	KP1505-052C
1/16"	Solid	KP1505-1/16S
1/16"	Cored	KP1505-1/16C
.068 - .072"	Cored	KP1505-068
5/64"	Cored or Solid	KP1505-5/64
3/32"	Cored or Solid	KP1505-3/32
7/64"	Cored or Solid	KP1505-7/64
7/64"	Hardfacing wire	KP1505-7/64H
.120	Cored or Solid	KP1505-120
.040 - .045"	Drive Roll Kit	KP1505-1



KP1505-035S

Not Included with kit Outer guide - KP2071-1



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

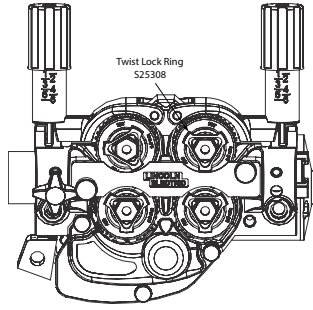
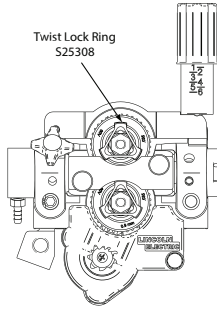
- Pressure Spring: T11862-57
- Knurled Knob Assembly: S22933
- Flex Tube: T10642-226
- Thrust Washer: T14043
- 1/8" Socket: T11563-2
- 7/64" Socket: T11563-6

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

## KP1507 DRIVE ROLL KITS - Aluminum

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

# 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 256, POWER MIG 300, POWER MIG 350MP, LN-25X, POWER MIG 260

**KP1696 DRIVE ROLL KITS - Solid Steel**

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



KP1696-030S

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

**KP1697 DRIVE ROLL KITS - Cored**

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



KP1697-035C

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 - Aluminum**

Wire Size	Type	Drive Roll Kit #	Included with 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	-	KP2071-4	KP2173-4

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



KP1695-035A

**K2 -** FlexFeed 74 HT (4 Roll), LF-74 (4 Roll), Flex Feed 84, DH10, Power Feed 84, Power Feed 84 Dual

**KP1505 DRIVE ROLL KITS - Stainless Steel**

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.

**KP1505 DRIVE ROLL KITS - Cored Drive Roll**

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



KP1505-035C

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

**KP1505 DRIVE ROLL KITS - Solid Steel or Cored Drive Roll**

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

**KP1507 DRIVE ROLL KITS - Aluminum**

Wire Size	Type	Drive Roll Kit #	Included with 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.



KP1507-035A

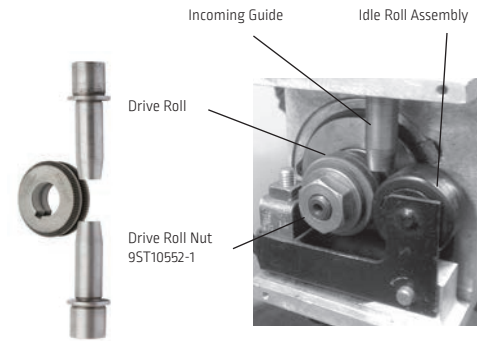
# Drive Rolls

## L - Cruiser [Tractor], MAXsa 22, MAXsa 29, NA-3, NA-4, NA-5, PF-10S

### KP1899 DRIVE ROLL KITS

Wire Size	Type	Drive Roll Kit #	Qty Req.	Incoming Guide	Outgoing Guide	Drive Roll Key	Idle Roll Assembly
3/32-7/32"	Wires	KP1899-1	2	KP2116-2	KP1963-1	9SM8776-5	9SS12475
1/16-3/32"	Wires	KP1899-2	2	-	-		
.035-.052"	Solid Wire	KP1899-3	1	-	-		
.045-.052"	Cored Wire	KP1899-4	2	-	-		

KP1899-X Drive Roll Kits include one drive roll, one incoming tube and one outgoing tube.

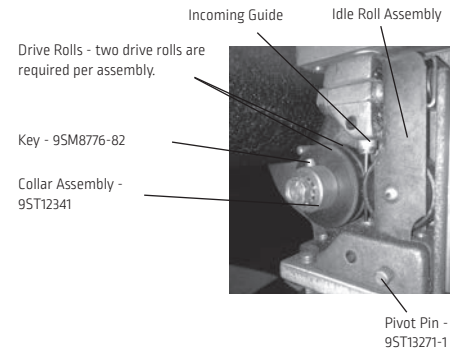


## M - LT-56, LT-7

### Parts Sold Individually

Wire Size	Type	Drive Roll	Qty Incd.	Qty Req.	Incoming Guide	Outgoing Tube	Idle Roll Assembly
.052 -1/16"	Solid & Cored	KP2268-1	1	2	KP1984-1	-	9SS16666-1
.068 -3/32"	Solid & Cored	KP2268-2	1	2	KP1984-1	-	
3/32 -3/16"	Solid & Cored	KP2268-3	1	2	KP1984-1	KP1985-1	
.045"-.052"	Solid & Cored	KP2268-4	1	2	KP1984-1	-	

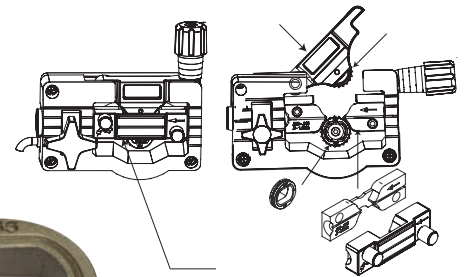
\*Each Drive Roll KP# includes one drive roll - two drive rolls are required per assembly. These Drive Rolls are a split, knurled design.



## N - POWER MIG 140C, POWER MIG 140T, POWER MIG 180C, POWER MIG 180T, POWER MIG 180 Dual, POWER MIG 210

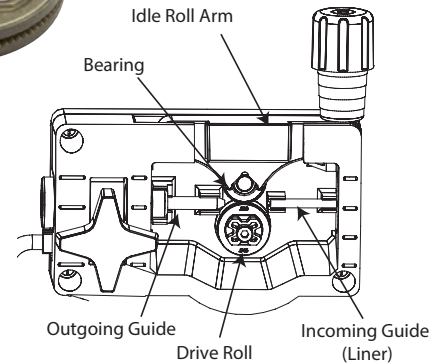
Wire Size	Type	Drive Roll Kit #	Incoming Guide	Outgoing Guide
.025"/.030"	Solid	KP2529-1	KP2531-1	S26899
.035"	Solid	KP2529-2	KP2531-1	S26899
.030"/.045"	Cored	KP2529-3	KP2531-2	S26899

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], MIG Pak 140MP, Mega Force 140iMP, Pro MIG 180 [Code 11937]

Wire Size	Type	Drive Roll Kit #
.025"	Solid	KP2948-1*
.030" - .035"	Solid	KP2948-1*
.030"-.035"	Cored	KP2948-1*
.035"-.045"	Knurled	KP3285-1*

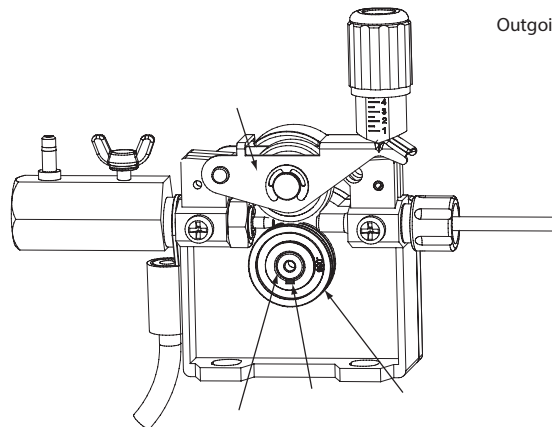
\* Key included with kit.

Not Included with Kit:

Wire Guide Kit KP3199-1

Wire Drive Spare Parts Kit KP3909-1

(Includes Key, Retaining Knob, & Gun Retaining Wing Screw)

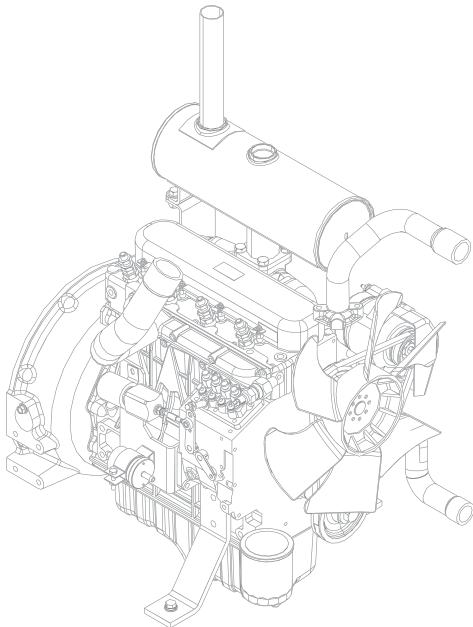


# KUBOTA® SERVICE PARTS

Lincoln Electric now offers service parts for the Kubota® engine V1505 used on the

**Vantage® 300 & Vantage® 400-I.**

**Original Parts from one source.**



**1 Oil Filters**  
**9SS30694-1**  
 Kubota® HH160-32093 Oil Filter

**2 In-Line Fuel Filter**  
**9SS30694-2**  
 Kubota 12581-43012 In-Line Fuel Filter

**3 Filter, Water Separator / Fuel Sediment Element**  
**9SS30694-3**  
 Kubota 15831-43380 Filter, Water Separator/Fuel Sediment Element

**4 V-Belt**  
**9SS30694-4**  
 Kubota 16282-97010 V-Belt, Fan Drive, 37.5-in.

**5 Exhaust Gasket**  
**9SS30694-5**  
 Kubota 15263-12370 Exhaust Gasket

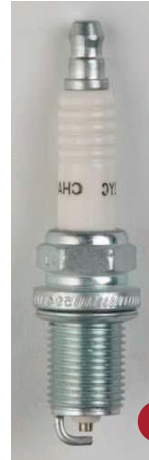
**6 Air Filter**  
**9SM19801-1A**  
 Air Filter

# KOHLER® TUNE UP KIT

K3494-1

Lincoln Electric now offers service parts for the Kohler® engines used on the CH23S, CH730, & ECH740

**Ranger 250 GXT**  
**Ranger 305G**  
**Ranger 225**



**1 Spark Plug**  
 Kohler® 12 132 02

**4 Air Filter Pre-Cleaner**  
 Kohler® 24 083 05

**2 In-Line Fuel Filter**  
**9SS30694-2**  
 Kohler® 24 050 13

**5 Oil**  
 Kohler® 25 357 06

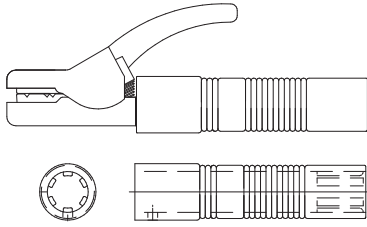
**3 Air Filter**  
 Kohler® 24 083 03

**6 Oil Filter**  
 Kohler® 12 050 01

Kohler is a registered trademark of Kohler Corporation

# Electrode Holders / Work Clamps

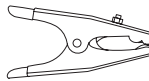

## ELECTRODE HOLDERS



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>®</sup>	T300	Medium duty	300 Amps @ 60% Duty Cycle	5/32" (4.0 mm) and smaller

<sup>®</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	 GC-500 (K910-2)
K910-2	GC-500	500 amps @ 60% Duty Cycle	 GC-300 (K910-1)



### 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(#14 shade), work clamp and electrode holder (EH-400HD).

K852-25 for #4-#6 cable  
 K852-50 for #1-#2 cable  
 K852-70 for 1/0-2/0 (50-70 mm<sup>2</sup>) cable  
 K852-95 for 3/0 (95 mm<sup>2</sup>) cable  
**Twist Mate™ Cable Plug**  
 For connecting welding cable to output terminal receptacles.



K1759-70  
**Twist Mate™ Receptacle**  
 - For 1/0-2/0 (50-70 mm<sup>2</sup>) Cable  
 K1759-95  
**Twist Mate™ Receptacle**  
 - For 2/0-3/0 (70-95 mm<sup>2</sup>) Cable



K2946-1  
**Tweco® Style Cam-Lock Adapter Plug for Work and Electrode Cables**  
 Cable plug for 2/0 (50 mm<sup>2</sup>) cable.



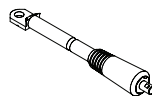
### K875 Accessory Kit, 150 Amp

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(#10 shade), work clamp and electrode holder (EH-200).

K2176-1  
**Twist Mate™ to Lug Adapter**  
 For connection of lugged cable to Twist Mate™ connectors, 18 inch (457 mm) long.



K4198-1  
**Twist Mate™ (male) to Lug Adapter POWER MIG 210**



K2485-2  
**Electrode Cable - 50 Ft, 2/0**  
 K2485-3  
**Electrode Cable - 50 Ft, 3/0 Tweco® to Tweco®**

K2487-1  
**Insulated CT40FS, Lug to Tweco® (Female)**



K2149-1  
**Work Lead Package**  
 15 ft. (4.5 m) 4/0 cable with 1/2 inch (12.7 mm) stud lug and work clamp.



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 200 amp stick holder with 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.

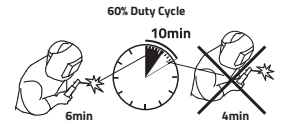


K1803-2  
**Work and Wire Feeder 2/0 Weld Package**  
 Includes Tweco®-style Cam-Lock connectors, work clamps, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.





# Electrode and Work Weld Cables



CONNECTION	LENGTH FT. (M)	PRODUCT NUMBER	DESCRIPTION
Twist Mate™ to Lug	10 (3.1)	<b>K1840-10</b>	Weld Power Cable, 1/0, 350A, 60% duty cycle
Lug to Lug	10 (3.1)	<b>K1842-10</b>	Weld Power Cable, 3/0, 600A, 60% duty cycle
	35 (10.7)	<b>K1842-35</b>	Weld Power Cable, 3/0, 600A, 60% duty cycle
	60 (18.3)	<b>K1842-60</b>	Weld Power Cable, 3/0, 600A, 60% duty cycle
	110 (33.5)	<b>K1842-110</b>	Weld Power Cable, 4/0, 600A, 60% duty cycle
Twist Mate™ to Twist Mate™	25 (7.6)	<b>K1841-25</b>	Weld Power Cable, 1/0, 350A, 60% duty cycle
	50 (15.2)	<b>K1841-50</b>	Weld Power Cable, 2/0, 350A, 60% duty cycle
Lug to Lug	35 (10.7)	<b>K2163-35<sup>(1)</sup></b>	Weld Power Cable, 4/0
	60 (18.3)	<b>K2163-60<sup>(1)</sup></b>	Weld Power Cable, 4/0
Lug to Lug	25 (7.6)	<b>K1796-25</b>	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle
	50 (15.2)	<b>K1796-50</b>	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle
	75 (22.8)	<b>K1796-75</b>	Coaxial Weld Power Cable, 1/0, 325A, 60% duty cycle
	100 (30.4)	<b>K1796-100</b>	Coaxial Weld Power Cable, 1/0, 300A, 60% duty cycle
Lug to Lug	100 (30.4)	<b>K2593-100</b>	Coaxial Weld Power Cable, #1, 250A, 100% duty cycle
Tweco® to Lug	50 (15.2)	<b>K2484-2</b>	Weld Power Cable, 2/0, 350A, 60% duty cycle
	50 (15.2)	<b>K2484-3</b>	Weld Power Cable, 3/0, 600A, 60% duty cycle
Tweco® to Tweco®	50 (15.2)	<b>K2485-2</b>	Weld Power Cable, 2/0, 350A, 60% duty cycle
	50 (15.2)	<b>K2485-3</b>	Weld Power Cable, 3/0, 600A, 60% duty cycle

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

## RECOMMENDED ELECTRODE & WORK CABLE SIZES FOR ARC WELDING

RUBBER COVERED COPPER - RATED 75 C

CABLE SIZES ARE FOR COMBINED LENGTHS OF ELECTRODE & WORK CABLES

Amperes	% Duty Cycle	0 to 50 Ft.	50 to 100 Ft.	100 to 150 Ft.	150 to 200 Ft.	200 to 250 Ft.
100	20	8	5	3	2	1
125	30	6	5	3	2	1
150	40	6	5	3	2	1
180	20	5	4	3	2	1
180	30	4	4	3	2	1
200	50	3	3	2	1	1/0
200	60	2	2	2	1	1/0
200	100	2	2	2	1	1/0
225	20	4 or 5	3	2	1	1/0
225	30 & 40	3	3	2	1	1/0
250	30	3	3	2	1	1/0
250	40	2	2	1	1	1/0
250	60	1	1	1	1	1/0
250	100	1	1	1	1	1/0
300	60	1	1	1	1/0	2/0
325	100	2/0	2/0	2/0	2/0	3/0
350	60	1/0	1/0	2/0	2/0	3/0
400	60	2/0	2/0	2/0	3/0	4/0
400	100	3/0	3/0	3/0	3/0	4/0
500	60	2/0	2/0	3/0	3/0	4/0
600	60	3/0	3/0	3/0	4/0	2-3/0
600	80	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
600	100	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
650	60	3/0	3/0	4/0	2-2/0	2-3/0
650	80	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
700	100	2-2/0	2-2/0	2-3/0	2-3/0	2-4/0
800	80	3-1/0	3-1/0	3-1/0	2-3/0	2-4/0
800	100	2-3/0	2-3/0	2-3/0	2-3/0	2-4/0
1000	80	2-4/0	2-4/0	2-4/0	2-4/0	4-2/0
1000	100	3-3/0	3-3/0	3-3/0	3-3/0	3-3/0
1200	80	3-4/0	3-4/0	3-4/0	3-4/0	3-4/0
1200	100	4-4/0	4-4/0	4-4/0	4-4/0	4-4/0
1500	80	4-4/0	4-4/0	4-4/0	4-4/0	4-4/0
1500	100	5-4/0	5-4/0	5-4/0	5-4/0	5-4/0

**K1842-10**  
Lug to Lug

**K1796-25**  
Lug to Lug Coaxial Weld Power Cable

**K1841-25**  
Twist Mate™ to Twist Mate™

**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]

**#1**

**1/0**

**2/0**

**3/0**

**4/0**

# Control Cables & Adapters

	FEEDER/SYSTEM	LENGTH FT. (M)	PRODUCT NUMBER	DESCRIPTION	CONNECTION
Wire Feeder Control Cables	LN-10, DH-10	10 (3.1)	<b>K1501-10</b>	replaced K1502-x, K1503-x	Male 14-pin to Female 9-pin
	LN-7	10 (3.1)	<b>K1818-10</b>	replaced K404-x, K291-x, K584-x, K594-x, K480-x	Female 6-pin to Male 14-pin
	LN-742, LN-25	10 (3.1)	<b>K1819-10</b>	replaced K619-x, K592-x, K591-x	Female 8-pin to Male 14-pin
	LN-8, LN-9, NA-3, NA-4, NA-5	10 (3.1)	<b>K1820-10</b>	replaced K196-x, K595-x, K596-x	Female 9-pin to Male 14-pin
	LT-7	25 (7.6)	<b>K1822-25</b>	replaced K228-x	Female 9-pin to Male 14-pin
	LN-23P (K316L-2)	25 (7.6)	<b>K2393-1</b>	Wire Feeder Control Cable	Male 14-pin to Female 8-pin
LN-23P (K316L-2)	75 (22.8)	<b>K2393-2</b>			
Extensions and Adapters	May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder.	10 (3.1)	<b>K1797-10</b>	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin
		25 (7.6)	<b>K1797-25</b>		
		75 (22.8)	<b>K1797-50</b>		
	LN-15, FlexFeed, LF-72, LF-74 LN-25 PRO Dual Power	100 (30.4)	<b>K1797-100</b>	<b>K1798</b>	Adapter Cable for Control Cable to Terminal Strip of Power Source
ArcLink®/Linc-Net™ Control Cables	For Power Wave®/ Power Feed® Systems  Power Feed 25M, Power Feed 84	8 (2.4)	<b>K1543-8</b>	ArcLink®/Linc-Net™ Control Cable	Male 5-pin to Female 5-pin
		16 (4.9)	<b>K1543-16</b>		
		25 (7.6)	<b>K1543-25</b>		
		50 (15.2)	<b>K1543-50</b>		
		100 (30.4)	<b>K1543-100</b>		
		25 (7.6)	<b>K2683-25</b>		
	50 (15.2)	<b>K2683-50</b>			
		100 (30.4)	<b>K2683-100</b>		
	25	<b>K4264-25</b>	ArcLink® Cable, Bayonet		
	150	<b>K4264-150</b>			
Submerged Arc/Automation	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)	<b>K1785-2</b>	Heavy Duty Control Cable	Male 14-pin to Female 14-pin
		4 (1.2)	<b>K1785-4</b>		
		8 (2.4)	<b>K1785-8</b>		
		12 (3.6)	<b>K1785-12</b>		
		16 (4.9)	<b>K1785-16</b>		
		25 (7.6)	<b>K1785-25</b>		
		50 (15.2)	<b>K1785-50</b>		
	100 (30.4)	<b>K1785-100</b>	Control Cable		
	For external dress of FANUC® robotic arm or hard automation.	25 (7.6)	<b>K2709-25</b>	Wire Drive Control Cable	Male 14-pin to Female 14-pin
		50 (15.2)	<b>K2709-50</b>		
100 (30.4)		<b>K2709-100</b>			
			<b>K3390-10</b>	Autodrive SA Control Cable 100ID	
			<b>K4130-18</b>	Autodrive SA Control Cable Assembly 100ID	
			<b>K4254-10</b>	Autodrive SA Bracket 100ID	



**K1501-10**

Male 14-pin to Female 9-pin



**K1798**

Adapter Cable for Control Cable to Terminal Strip of Power Source



**K1797-10**

Wire Feeder Control Cable Extension



**K1543-8**

ArcLink®/Linc-Net™ Control Cable



**K2683-25**

Heavy Duty ArcLink®/ Linc-Net™ Control Cable



**K1785-2**

Heavy Duty Control Cable



**K2709-25**

Wire Drive Control Cable

**K2335-1, K2335-2**

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.



# Gas Regulators and Flowmeters



**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.

**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.

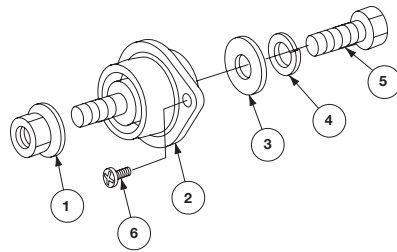


**3100338**  
**Harris® Argon/Helium Flowmeter Regulator**

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.

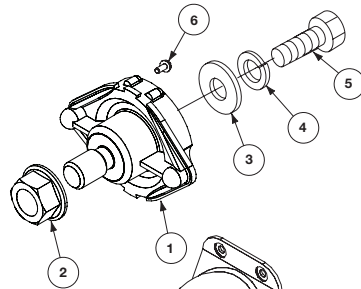


# Power Terminals



**T14166-9**

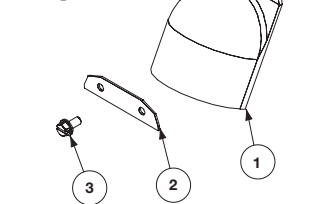
NO	Part Number	Description
1	9ST3960	FLANGE NUT
2	9SS16656-4	OUTPUT TERMINAL ASBLY
3	9SS9262-1	PLAIN WASHER
4	9SE106A-15	LOCKWASHER
5	9ST8930-4	TERMINAL SCREW
6	9SS9225-63	THREAD FORMING SCREW (CUTTING)



**S16656-4 OUTPUT TERMINAL ASSEMBLY**

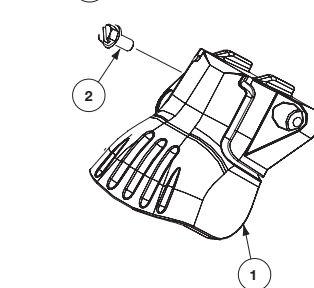
## OUTPUT STUD COVER

NO	Part Number	Description
1	9SM20007	OUTPUT STUD COVER
2	9SS25669	COVER PLATE
3	9SS9225-68	THREAD FORMING SCREW



## POWER WAVE AND FLEXTEC OUTPUT STUD COVER

NO	Part Number	Description
1	9SG6864	OUTPUT STUD COVER
2	9SS9225-100	SELF TAPPING SCREW



**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.



**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.



**K1690-1**  
**GFCI Receptacle Kit**

Includes one UL approved 120V ground fault circuit interrupter duplex type receptacle and installation instructions. Replaces the factory-installed 120V duplex receptacle. Each receptacle of the GFCI duplex is rated at 20 amps. Maximum total current from the GFCI duplex is limited to 20 amps. Two kits required for all 120V receptacles on Bulldog®, Outback® and Ranger® products.



**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.



**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.



# GENUINE FILTER REPLACEMENT

- STEP 1** Select your machine
- STEP 2** Identify the filter indicator location and the filter status
- STEP 3** Select the appropriate Genuine Filter Replacement

	<p><b>MINIFLEX®</b> Portable Welding Fume Extractor</p> <p>K3972-3 K2497-18</p>	<p>Top Control Panel</p>	<p>Activated Carbon Filter (optional) [KP2389-1]</p> 	<p>LongLife-H Filter [KP2390-1]</p> 	<p>Pre-Filter [KP2390-3]</p> 	<p>HEPA Filter [KP2390-4]</p> 	<p>Filter One-Pak® [KP2390-5]</p> 
		<p>Indicator blinks</p>					

	<p><b>MOBIFLEX® 200-M</b> Welding Fume Extraction</p> <p>K1653-4 K1653-5 K2497-12</p>	<p>Front Control Panel</p>	<p>MERV 14 Filter [KP1673-1]</p> 	<p>MERV 16 (HE, Nano) Filter [KP1673-9]</p> 	<p>Activated Carbon Filter (optional and fits over main filter) [KP1852-1]</p> 	<p>Pre-Filter [KP1673-5]</p> 
		<p>Gauge is red while unit is in operation</p>				


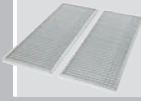
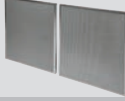



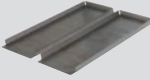
	<p><b>MOBIFLEX® 400-MS</b> Welding Fume Extraction</p> <p>K1741-3 K1741-4 K2497-14</p>	<p>Front Control Panel</p>	<p>MERV 14 Filter [KP1673-2]</p> 	<p>MERV 16 (HE, Nano) Filter [KP1673-10]</p> 	<p>Pre-Filter [KP1673-6]</p> 
		<p>Unable to obtain pressure below 1500 Pa after several cleaning attempts</p> <p>Indicator blinks</p>			


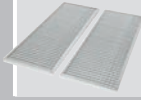
	<p><b>STATIFLEX® 200-M</b> Weld Fume Extraction Base Unit</p> <p>K1654-4 K1654-5 K1654-6</p>	<p>Front Control Panel</p>	<p>MERV 14 Filter [KP1673-1]</p> 	<p>MERV 16 (HE, Nano) Filter [KP1673-9]</p> 	<p>Activated Carbon Filter (optional and fits over main filter) [KP1852-1]</p> 	<p>Pre-Filter [KP1673-5]</p> 
		<p>Gauge is red while unit is in operation</p>				

	<p><b>STATIFLEX® 400-MS</b> Weld Fume Extraction Base Unit</p> <p>K1742-1 K1742-2</p>	<p>Front Control Panel</p>	<p>MERV 14 Filter [KP1673-2]</p> 	<p>MERV 16 (HE, Nano) Filter [KP1673-10]</p> 	<p>Pre-Filter [KP1673-6]</p> 
		<p>Unable to obtain pressure below 1500 Pa after several cleaning attempts</p> <p>Indicator blinks</p>			




Order replacement filters at [weldfumefilters.com](http://weldfumefilters.com)

	<p><b>DOWNFLEX® 100-NF</b> Weld Fume Downdraft Table K2751-9</p>	<p>Suction performance is lower than normal</p>	<p>Spark Arrestor - Set of 2 (optional) [KP2752-12]</p>	
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	<p><b>DOWNFLEX® 200-M</b> Weld Fume Downdraft Table K2751-10 K2751-13 K2751-14</p>	<p>Differential pressure exceeds 1700 Pa</p>	<p>Gauge points to red</p>	<p>Pre-Spark Arrestor - Set of 2 [KP4052-1]</p>	<p>Spark Arrestor - Set of 2 [KP2752-12]</p>	<p>MERV 16 [HE] Filter - Set of 2 [KP2752-16]</p>	<p>Discharge Filter [KP3551-1]</p>	<p>HEPA Filter<sup>(1)</sup> [KP2752-14]</p>	<p>Plasma Cutting Prefilter<sup>(2)</sup> - Set of 2 [KP2752-17]</p>						
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	<p><b>DOWNFLEX® 400-MS/A</b> Weld Fume Downdraft Table K2751-11 K2751-15 K2751-16</p>	<p>Unable to obtain pressure below 1500 Pa after 5 cleaning attempts</p>	<p>Gauge points to red and alarm buzzer sounds</p>	<p>Pre-Spark Arrestor - Set of 2 [KP4052-1]</p>	<p>Spark Arrestor - Set of 2 [KP2752-12]</p>	<p>MERV 16 [HE] Filter - Set of 2 [KP2752-16]</p>	<p>Discharge Filter [KP3551-1]</p>	<p>HEPA Filter<sup>(1)</sup> [KP2752-14]</p>	<p>Plasma Cutting Prefilter<sup>(2)</sup> - Set of 2 [KP2752-17]</p>						
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	<p><b>CIRCULATOR® OR STATIFLEX® 6000-MS</b> Central System</p>	<p>Unable to obtain a pressure below 8 in WG or 1600 Pa after several cleaning attempts</p>	<p>Indicator blinks and alarm buzzer sounds</p>	<p>MERV 14 Filter - Set of 2 [KP3367-1]</p>	<p>MERV 16 [HE] Filter - Set of 2 [KP3368-1]</p>		
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	<p><b>STATIFLEX® FILTER BANK OR STATIFLEX® COMPLETE</b> Central System</p>	<p>Unable to obtain a pressure below 1600 Pa after several cleaning attempts</p>	<p>Indicator light on cleaning control box</p>	<p>MERV 11 Filter [KP3370-1]</p>	<p>MERV 16 [HE] Filter [KP3370-2]</p>	<p>MERV 16 [PTFE] Filter [KP3370-3]</p>			
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Order replacement filters at [weldfumefilters.com](http://weldfumefilters.com)

<sup>(1)</sup> For DownFlex tables equipped with optional HEPA Filter Kit (K2752-1)

<sup>(2)</sup> For DownFlex tables equipped with optional Plasma Cutting Grid (K2752-2)

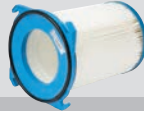


**X-TRACTOR®  
1GC**  
Portable Welding Fume  
Extractor Unit  
K652-1  
K652-2

Replace after several  
cleaning cycles  
(cleaning device is  
manually operated)

Suction performance  
is lower than normal

Filter  
(KP2069-1)

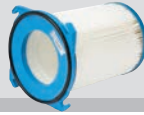


**X-TRACTOR®  
3A**  
Weld Fume Extractor  
K3965-1  
K3965-2

Replace after several  
cleaning cycles

Suction performance  
is lower than normal

Filter  
(KP2069-1)



**X-TRACTOR®  
5A**  
Weld Fume Extractor  
K3966-1  
K3966-2

Replace after several  
cleaning cycles

Suction performance  
is lower than normal

Filter  
(KP2061-1)



**X-TRACTOR®  
8A**  
Weld Fume Extractor  
K3967-1  
K3967-2

Replace after several  
cleaning cycles

Suction performance  
is lower than normal

Filter  
(KP3984-1)



Order replacement filters at [weldfumefilters.com](http://weldfumefilters.com)

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## LINCOLN ELECTRIC TOUCH UP PAINT



Order  
Lincoln Red  
J22XR16517-4337

Lincoln Part #  
E2764-V-R9



Order  
Low Gloss Black  
J22XB19150-4337

Lincoln Part #  
E2764-V-B



Order  
Lincoln Gray  
J22XA15604-4337

Lincoln Part #  
E1389-V-UC



Order  
Gray Pearl  
J22XS16831-4337

Lincoln Part #  
E1389-V-M

Touch up paint & aerosols are available through Sherwin-Williams Company, NOT Lincoln Electric.

PLEASE PHONE ORDERS TO  
216-271-6766  
Sherwin-Williams Company  
10740 Broadway Ave, Suite A  
Garfield Heights, OH 44125



Service Information – FAST & EASY

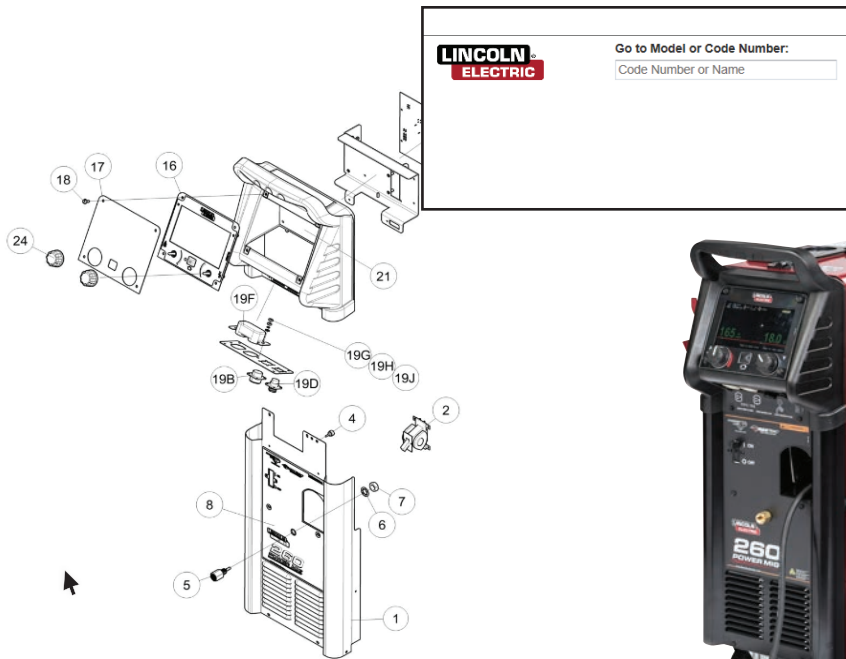
**PARTS.LINCOLNELECTRIC.COM**

The updated Service Navigator makes it easier and faster to find service information and purchase genuine Lincoln parts using state-of-the-art textual and visual navigation. Quickly navigate to service documentation for a particular machine by utilizing the code number filter.



**Features of Service Navigator:**

- >> Detailed dynamic parts diagrams
- >> Up-to-date information
- >> Improved browser compatibility
- >> Tablet supported
- >> Multi-language support



**TWO WAYS TO ACCESS THE SITE:**

1. Go to [parts.lincolnelectric.com](http://parts.lincolnelectric.com)
2. Existing customers log-in on [www.lincolnelectric.com](http://www.lincolnelectric.com) and navigate to Service Center in the side navigation bar.

