

LN-742 and LN-742H



Semiautomatic Constant Speed Wire Feeders

LN-742 and LN-742H



The LN-742 is a semiautomatic constant speed wire feeder for MIG and flux-cored arc welding. Powered by a new 42 volt motor drive system, the LN-742 is available in standard or high speed models, with either a 2 or 4 roll wire drive system.

Designed for welding procedure flexibility and simplicity, the LN-742's keypad panel provides finger touch control for welding procedure parameters. In addition, a unique arc starting control system allows you to set run-in wire feed speed and acceleration for smooth, clean arc starts. This feature is ideal for critical arc starting on mild and low alloy steels, stainless steels, aluminum, and alloy materials where starting precision is a must.

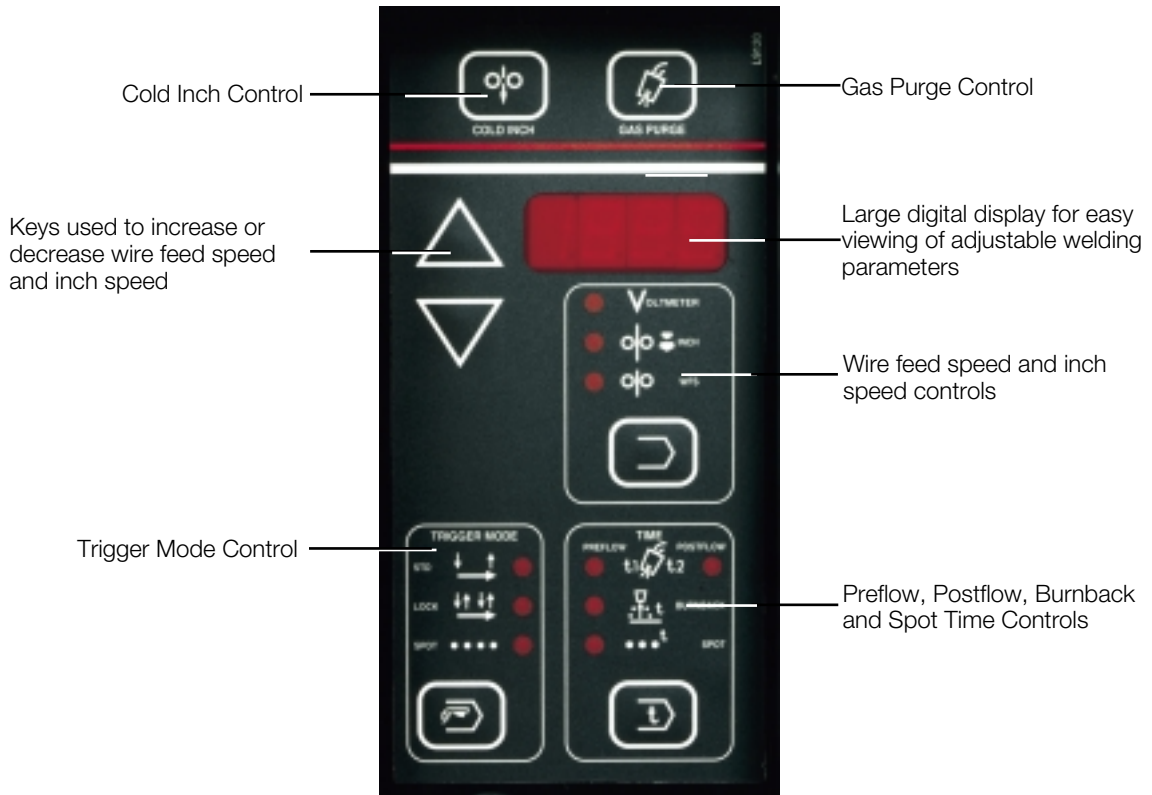
The LN-742's digital meter can be set for English or metric display, allowing

either inches per minute or meters per minute procedure setting. This makes the unit ideal for multinational corporations and contractors who require procedure flexibility.

ADVANTAGE LINCOLN

- LN-742 model feeds up to 1/16" (1.6mm) solid and 3/32" (2.4mm) flux-cored wires, from 50-770 inches per minute (1.27-19.5 m/min) wire feed speed.
 - LN-742H high speed model feeds up to .045" (1.2mm) solid or flux-cored wires, from 80-1200 inches per minute (2.03-30.5 m/min) wire feed speed.
 - 2 or 4 roll wire drive system for positive wire feeding.
- Unique variable wire run-in speed and acceleration provide controlled arc starting. Matches starting performance to power source starting dynamics, wire type, welding procedures, and operator technique.
 - Dynamic braking system stops wire feed motor quickly to minimize crater sticking problems.
 - Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed.
 - Tool-less quick release wire drive tension system and gun cable connections for easy wire or gun changes.
 - Presettable wire feed speed, run-in speed, and cold inch speed.
 - Trigger mode selection for standard 2-step, interlocking 4-step and timed spot welding.
 - Gas solenoid and timer controls for preflow and postflow gas, burnback and spot times.
 - Cold inch and gas purge control.
 - Digital voltmeter with auto-polarity and memory feature to display and recall the last arc voltage reading.
 - Optional remote voltage control kit provides procedure control at LN-742.
 - Optional wire feeder remote control kit provides remote voltage and wire feed speed control up to 16 ft. (5m) from wire feeder. Ideal for boom mounted feeders and where the operator wants control at the arc.
 - 3 year warranty on parts and labor.
 - Manufactured under a quality system certified to ISO 9002 requirements.

A CLOSER LOOK



TECHNICAL SPECIFICATIONS

Product Name	Ordering Information	Wire Speed Range IPM (m/min)	Wire Size Range in. (mm)		Input	Weight (net)	Dimensions HxWxD
			Solid	Cored			
LN-742 2 roll	K617-1	50-770 (1.27-19.5)	.025-1/16" (0.6-1.6)	.045-3/32" (1.2-2.4)	42 VAC 50/60 Hz	24 lbs. (10.9 kg)	10.9 x 9.8 x 9.6 in. (277 x 249 x 244mm)
LN-742H 2 roll	K617-2	80-1200 (2.03-30.5)	.025-.045" (0.6-1.2)	.025-.045" (0.6-1.2)			
LN-742 4 roll	K618-1	50-770 (1.27-19.5)	.025-1/16" (0.6-1.6)	.045-3/32" (1.2-2.4)	4 Amps	28.7 lbs. (13.0 kg)	11.1 x 11.6 x 9.7 in. (282 x 295 x 246mm)
LN-742H 4 roll	K618-2	80-1200 (2.03-30.5)	.025-.045" (0.6-1.2)	.025-.045" (0.6-1.2)			

DRIVE ROLL AND GUIDE TUBE KITS

	2 roll	4 roll
Steel Wire Sizes: .023-.025 (0.6mm) solid .030 (0.8mm) solid .035 (0.9mm) solid .035 (0.9mm) cored .045-.052 (1.2-1.3mm) solid .045-.052 (1.2-1.3mm) cored .052-1/16 (1.3-1.6mm) solid or cored ⁽¹⁾ .068-3/32 (1.7-2.4mm) cored ⁽¹⁾	KP653-025S KP653-030S KP653-035S KP653-035C KP653-052S KP653-052C KP653-1/16 KP653-3/32	KP655-025S KP655-030S KP655-035S KP655-035C KP655-052S KP655-052C KP655-1/16 KP655-3/32
Aluminum Wire Sizes: .035 (0.9mm) 3/64 (1.2mm) 1/16 (1.6mm)	KP654-035A KP654-3/64A KP654-1/16A	KP656-035A KP656-3/64A KP656-1/16A

⁽¹⁾ Not for LN-742H models.

THE TOTAL SOLUTION

Choose from a complete line of Lincoln products to generate the total solution for your welding application:

- CV-250, CV-300, CV-400, CV-655 CV400-I, CV500-I, DC-400, DC-600*, and DC-655.
- Invertec™ V350-PRO and V300-I power sources.
- Ranger 9, Ranger 275, Ranger 300 DLX, Commander 300* and 500* engine driven welders.
- MIG and flux-cored gun and cable assemblies.
- A full line of MIG and FCAW wires.

* Must buy optional 42VAC Kit for Codes below 10500.

REQUIRED OPTIONS

INPUT CABLE ASSEMBLIES

14 Pin/Twist-Mate™ Cables

K591

Rated 400 amps, 60% duty cycle: 2/0 (67mm²) cable with Twist-Mate™ and 14 pin MS-type connector. 10, 25 and 50 ft. (3, 8, 15m) lengths.

Order K591-10, -25, or -50.

K593

Same as K591 but includes gas and water hoses in 10 ft. (3.0 m) length.

Order K593-10.

14 Pin/Stud Cables

K592

Rated 600 amps, 60% duty cycle: 3/0 (85mm²) cable with lugs and 14 pin MS-type connector. 10, 25 and 50 ft. (3, 8, 15m) lengths.

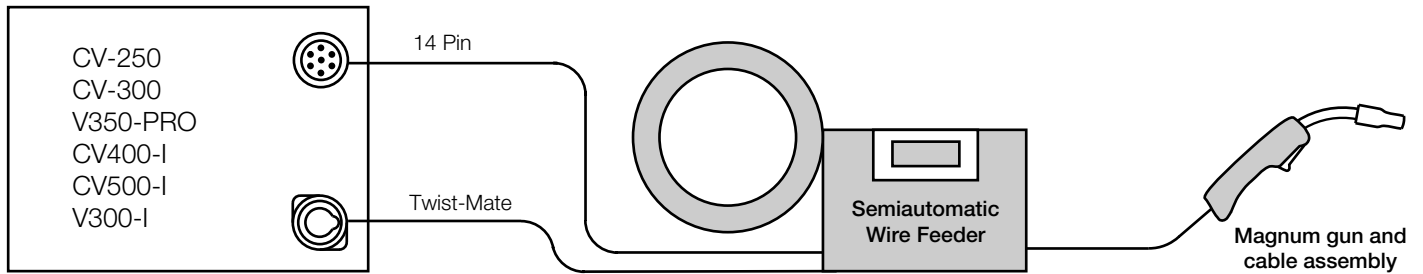
Order K592-10, -25, or -50.

K619

Rated 350 amps, 60% duty cycle: 1/0 cable (53mm²) with lugs and 14 pin MS-type connector. 10, 25 and 50 ft. (3, 8, 15m) lengths.

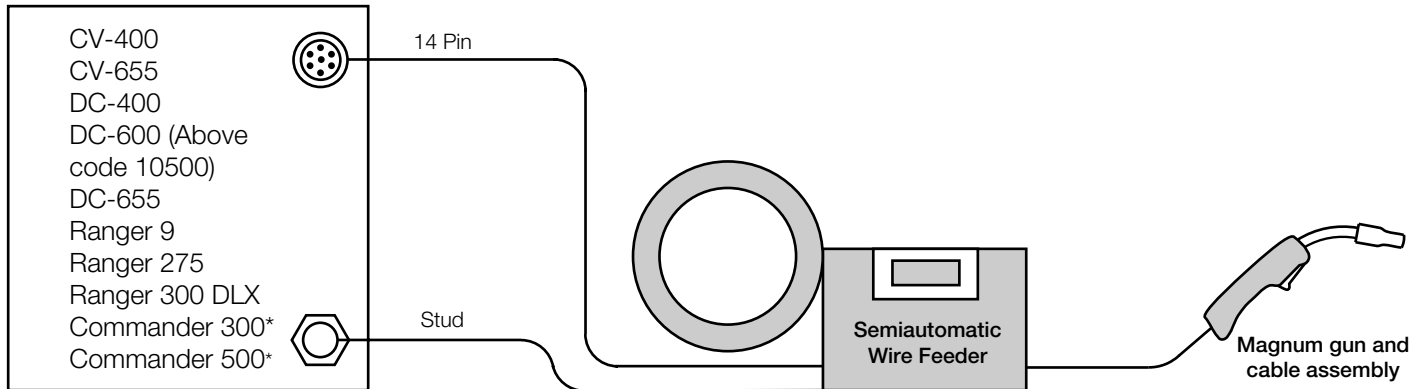
Order K619-10, -25 or -50.

INPUT CABLE ASSEMBLY SELECTION GUIDE



14 Pin/Twist-Mate™ Input Cable Assemblies

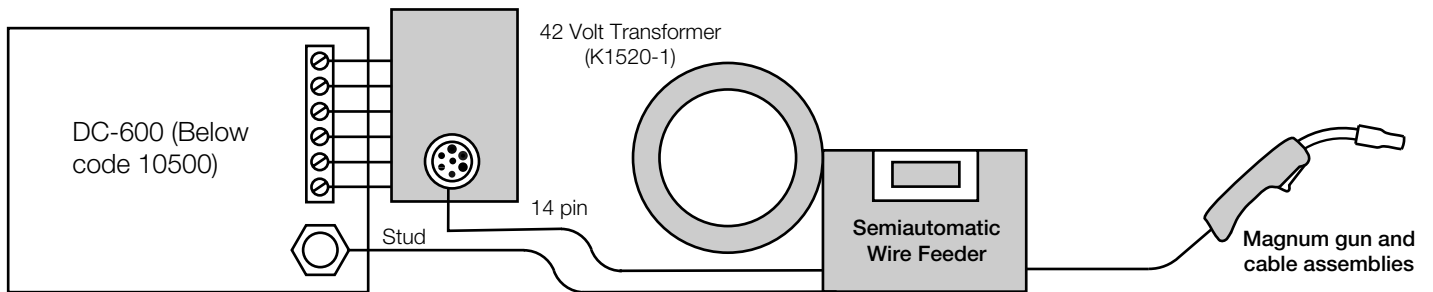
- K591** 400 amp, 60% duty cycle.
- K593** 400 amp, 60% duty cycle. Includes gas and water hoses. 10 ft. (3.0 m) only.



*Requires K1597-2: 42 VAC Kit.

14 Pin/Stud Input Cable Assemblies

- K592** 600 amp, 60% duty cycle.
- K619** 350 amp, 60% duty cycle.



Terminal/Stud Input Cable Assemblies

- K592** 600 amp, 60% duty cycle.
- K619** 350 amp, 60% duty cycle.

NOTE A: Specify length when ordering input cable assemblies. See Required Options.

NOTE B: Connections are for current equipment design. Subject to change without notice.

OPTIONS AVAILABLE

COIL ADAPTER

60 lb. (27.2 kg) Adapter

Adapts 60 lb. (27.2 kg) coils of Lincoln electrode to 2" (51mm) spindle.

Order **K1504-1**.

K1504-1



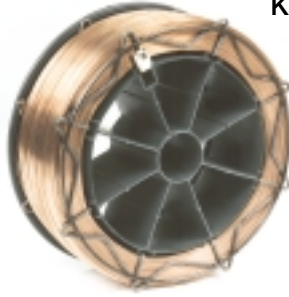
READI-REEL® ADAPTERS

30 lb. (14 kg) Adapter

Adapts 22-30 lb. (10-13.6 kg) Lincoln REDI-Reels of electrode to 2" (51mm) spindle. Order **K363P**.

Quantity of 15, Order **K363P-15**.

K363P



WIRE REEL STAND

For use with 50-60 lb. (22.7-27.2 kg) coils. Includes 1" (25.4mm) spindle, wire reel, lift bail and dust shield.

Order **K303**.

K303



50-60 lb. (27.2 kg) Adapter

Adapts 50-60 lb. (22.7-27.3 kg) Lincoln REDI-Reels of electrode to 2" (51mm) spindle. Order **438**.

Quantity of 15, Order **K438-8**.

K438



SPINDLE ADAPTERS

For REDI-Reels and Spools

2" O.D. spindle for mounting REDI-Reels and 2" (51mm) I.D. spools up to 60 lb. (27.2 kg) capacity to a K303 stand. Order **K162-1**.

For 14 lb. (6 kg) Innershield® Coils

Permits 14 lb. (6 kg) Innershield electrode coils to be mounted on 2" (51mm) O.D. spindles. Order **K435**.

Universal Wire Reel Stand

For use with Lincoln 10-60 lb. (4.5-27.2 kg) wire packages that use a 2" (51mm) spindle. Hole in stand fits over lift bail. Optional swivel platform is K1557-1. Order **K1524-1**.

K1524-1



Water Solenoid Kit

Includes solenoid and fittings for use with water-cooled guns and Magnum water coolers. Order **K590-1**.

Caster Kit - Light Duty

Mounts to the K1524-1 wire reel stand. Allows for easy movement of wire feeder. Order **K1556-1**.

K1556-1



OPTIONS AVAILABLE

Undercarriage

Includes mounting frame, front casters, rear wheels and handle. For use with K303 only. **Order K163.**

Insulated Lift Bail

Allows the entire wire feeder to be hung from a crane or hook. Use with K1524-1. **Order K1555-1.**



Swivel Platform

Mounts to the lift bail on the power source and bottom of the K1524-1. Wire feeder may be lifted off if needed. Compatible with Light Duty Caster Kit. Includes "lazy susan" parts tray. **Order K1557-1.**

K1557-1



Water Solenoid Kit

Includes solenoid and fittings for use with water-cooled guns and Magnum water coolers. **Order K590-1.**

Water Connection Kit

Same as K590-1 except does not include solenoid for water coolers requiring continuous flow. **Order K590-2.**

Magnum® Products, including: 200-550 amps, air-cooled, and water-cooled gas-shielded welding guns.

Fume extraction systems and guns. (K179 not recommended as it would only run full speed).

115V/42V Transformer Kit

Provides a way to use the LN-742 on power sources that have 115V AC available on terminal. **Order K1520-1.**



Swivel Platform For mounting wire feeder on top of suitable Lincoln power sources when using K303 wire reel stand. **Order K178-1.**

K178-1



Innershield Electrode Guns

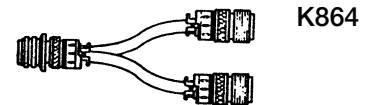
Available 250-600 amps.

ADAPTERS

K864

Y connection adapter for connecting Lincoln 6 pin plug K857 remote

voltage control kit and 14 pin input cable assemblies to power sources with a 14 pin receptacle. **Order K864.**



REMOTE CONTROL KITS

K589-1

Portable pendant connects to LN-742 for remote control of arc voltage and wire feed speed up to 16 ft. (5m) away from wire feeder. **Order K589-1.**

K857

For remote adjustment of output voltage. Consists of a control box, four conductor cable, and 6 pin MS-type (Amphenol) connector.

28 ft. cable - Order K857.

100 ft. cable - Order K857-1.

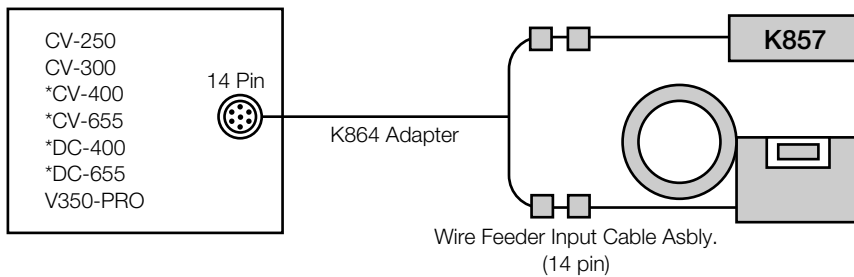
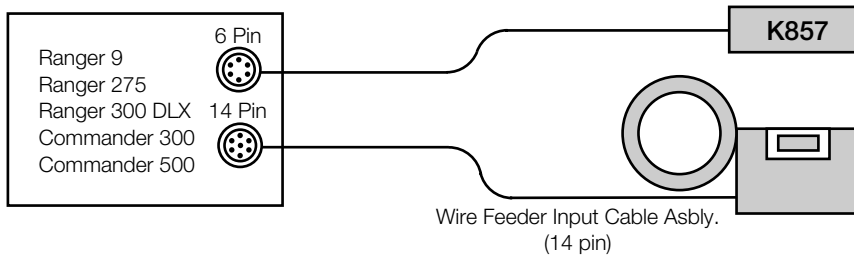
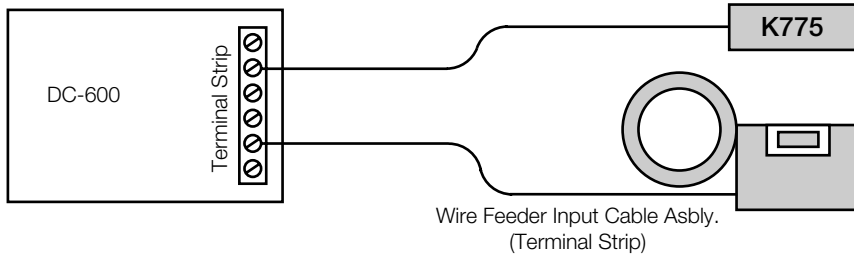
K775

For remote adjustment of output voltage. Consists of a control box with 28 ft. (8.5m) of four conductor cable for terminal strip connection.

Order K775.

RECOMMENDED OPTIONS

REMOTE VOLTAGE CONTROL SELECTION PROCESS



* Equipped with 14 pin MS-type connections as standard, and each model has easy access to terminal strip connection if required.

Subject to change without notice.

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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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