

LN-8 and LN-9

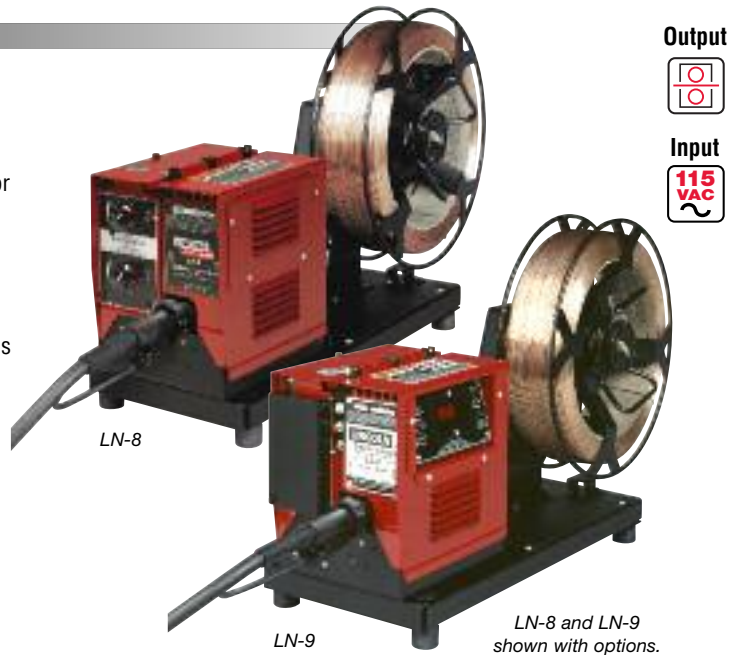
Semiautomatic Wire Feeders

The LN-8 and LN-9 are semiautomatic wire feeders providing dependable performance and reliable operation, making them ideal for shop or field operations. For precise wire feeding and quality welds, the LN-8 and LN-9 feature controlled wire feed speed and voltage during starting for clean, positive starts and reduced stubbing, skipping and spatter.

Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed. These wire feeders are easy to use with a quick release gun and cable connection for easy set up, and large wire feed and voltage control knobs that are easy to adjust with gloved hands.

Processes

Flux-Cored, Submerged Arc



Advantage Lincoln

- Completely enclosed case protects the heavy duty wire drive mechanism from damage, yet allows easy access to drive rolls.
- Rugged and durable design recognized throughout the industry for its long life and years of trouble-free wire feeding.
- Solid state control compensates for wire drag and input line variations to maintain accurate wire feed speed.
- Standard digital meter can be set to read volts, inches or meters/minute on the LN-9.
- Control of wire feed speed and voltage at the wire feeder eliminates the need to return to the power source to adjust procedures.
- Three-year warranty on parts and labor. Two-year extended warranty available in the U.S.

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current/Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in. (mm)			Dimensions H x W x D in. (mm)	Net Weight lbs. (kg)
LN-8	K297	115 VAC 50/60 Hz	600A @ 60%	50-600 (1.3-15.2)	Cored	Solid	Hardfacing	10.9 x 9.8 x 9.6 (227 x 248 x 244)	36 (16.2)
LN-9	K357-1				.045-.120 (1.2-3.0)	.040-3/32 (1.0-2.4)			

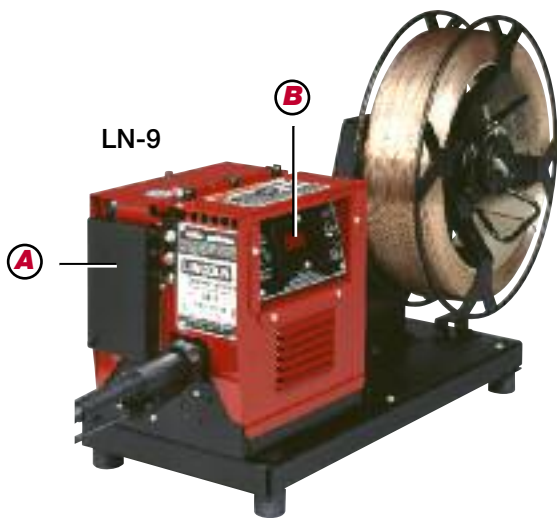
A CLOSER LOOK

FEATURES

- Large wire feed speed and voltage controls that are easy to adjust with gloved hands.
- Can be boom mounted or use optional Universal Wire Reel Stand, Casters, and/or Swivel Platform and mount on power source for extra versatility.
- Compatible with many Lincoln Electric power sources including the CV-400, CV-655, DC-400, DC-600, DC-655, Ranger® 250, Classic® 300, Ranger® 305, Vantage® 300, Vantage® 500, and Air Vantage® 500.
- Optional burnback kit provides adjustable delay of power source output shut off to prevent the electrode from sticking in the weld metal when using high wire feed speeds.

Key Controls

- A) Lockable Control Panel Cover
- B) Digital Meters on LN-9
- C) Voltage Control
- D) 2-Step Trigger Interlock
- E) Amperage Control
- F) Gun Trigger Connector
- G) Wire Feeding Direction Switch



LN-8

REQUIRED OPTIONS

DRIVE ROLL AND GUIDE TUBE KITS

Steel Wire Sizes	LN-8 and LN-9
Solid Wire: .040, .045 - .052 (1.0 - 1.4 mm) 1/16 (1.6 mm)	KP502-052 KP502-1/16
Cored Wire: .045 - .052 (1.0 - 1.4 mm) 1/16 - .062 (1.6 mm) 7/64 - .120" (2.8 - 3.0 mm)	KP502-052C KP502-1/16C KP502-120
Solid or Cored Wire: .068 - 3/32" (1.7 - 2.4 mm)	KP502-3/32
Hardfacing: 7/64" (2.8 mm)	KP502-7/64H

CONTROL CABLES

Cable Type	Description
Wire Feeder Control Cable K1820-10	Male 9 pin to female 14 pin
Wire Feeder Control Cable Extensions K1797-10 - 10 ft. (3.0 m) K1797-25 - 25 ft. (7.5 m) K1797-50 - 50 ft. (15.2 m) K1797-100 - 100 ft. (30.4 m)	Male 14 pin to female 14 pin

WELD POWER CABLES

Order No.	Description
K1840-10	Twist-Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. (3.0 m)
K1842-10	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.0 m)
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.6 m)
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.2 m)
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)

GUN & CABLE ASSEMBLIES



Magnum® 400 shown

Magnum® Gas-Shielded Gun and Cable Assemblies
Available 200-550 amps, air-cooled, gas-shielded welding guns. See publication E12.10



K126 Innershield® Gun shown

Magnum® Self-Shielded Gun and Cable Assemblies
Available 250-600 amps. See publication E12.110



Magnum® Submerged Arc Gun
Rated 600 amps, 15 ft. (4.5 m) cable.
Order K113-1 for 5/64" (2.0 mm) electrode size
Order K113-2 for 3/32" (2.4 mm) electrode size



Mechanized SAW Gun
Rated 600 amps, for 5/64 and 3/32" (2.0 and 2.4 mm) solid electrode. Includes flux valve interlock switch and receptacle for Hand Travel Unit or Squirtmobile. **Order K114**



Flux Cone
Fits K113 submerged arc guns for welding without the Continuous Flux Feed Tank Assembly. **Order K119**

GENERAL OPTIONS



Universal Wire Reel Stand
For use with Lincoln® 10-60 lb. (4.5-27.2 kg) wire packages that use a 2" (51 mm) spindle. Hole in stand fits over lift bail. **Order K1524-3**



Light Duty Caster Kit
Mounts to the K1524-3 wire reel stand. Allows for easy movement of wire feeder. **Order K1556-1**

GENERAL OPTIONS CONT.



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**



Insulated Lift Bail
Allows the entire wire feeder to be hung from a crane or hook. Use with K1524-3. **Order K1555-1**



50-60 lb. Readi-Reel® Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln® electrode to 2" (51mm) spindle. **Order K438**



22-30 lb. Readi-Reel® Adapter
Adapts 22-30 lb. (10-14 kg) Lincoln® Readi-Reels® of electrode to 2" (51mm) spindle. **Order K363P**



50-60 lb. Coil Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln® electrode to 2" (51 mm) spindle. **Order K1504-1**



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



8" O.D. Spool Adapter
For small spools. Permits 8" (200 mm) O.D. spools to be mounted on 2" (51 mm) O.D. spindles. **Order K468**



Plastic Wire Cover
Plastic enclosure for wire packages.
Order K1634-1 for 30-40 lbs. (13.6-19.9 kg)
Order K1634-2 for up to 60 lbs. (27.2 kg)

GENERAL OPTIONS, CONT.



Control Cable to Terminal Strip Adapter
Connects 14-pin control cable to power sources with terminal strip.
Order K1798



Gas Solenoid Kit
Includes solenoid valve and mounting bracket.
Order K437 (below code 9132)
Order K425 (above code 9131)

Wire Feed Speed Meter Kit
Contains an analog meter which indicates welding voltage and wire feed speed directly on a 0-60 volt scale.
Order K261



Burnback Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds. Includes a cold inch switch.
Order K202



Dual Procedure Kit
Allows the use of two welding procedures with one gun. Procedures can be changed by the flick of the switch – even while welding. For LN-9 only
Order K319



Magnetic Flux Screen Separator
For submerged arc welding. Removes foreign magnetic particles from reused flux.
Order K58



Flux Screen
For submerged arc welding. Removes large particles from reused flux. Includes air-driven vibrator.
Order K310



Wire Reel and Flux Tank Assembly
Includes flux tank, undercarriage, and reel and brake assembly in open shroud.
Order K305



GENERAL OPTIONS, CONT.

Continuous Flux Feeding Tank Assembly
For submerged arc welding. Includes air filter, pressure regulator, gauge, tank, 18 ft. (5.4 m) flux hose, funnel and lift bail assembly to mount wire feeder.
Order K320



Undercarriage
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stand.
Order K163



Squirtmobile
Self-propelled trackless carriage carriers K114 Mechanized SAW Gun on long welds for automatic welder economy without high fixtures costs. Requires a K161 Power Pack to drive unit.
Order K62



Mechanized Hand Travel Unit
Carries the K114 Mechanized SAW Gun along the joint at a preset travel speed to help the operator make better welds 10% to 25% faster than with manual travel. Speed range is 7-60 ipm (0.2-1.5 m/min). Requires a K161 Power Pack to drive unit.
Order K110



Power Pack
Includes travel mag-amp circuit required when using either a Squirtmobile or Mechanized Hand Travel Unit with a K114 SAW gun. Mounts near power source. Connect to the power source for input power. 50 ft. (15 m).
Order K161-50



Portable Digital Wire Feed Speed Meter
When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute.
Order K283

CUSTOMER ASSISTANCE POLICY

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