

LN-9 AND LN-9 GMA



Semiautomatic Wire Feeders

LN-9 AND LN-9 GMA



LN-9 GMA shown with CV-655 power source, K1524-1 universal wire reel stand, K1504-1 50/60 lb. coil adapter, K163 undercarriage and a Magnum 400 gun and cable assembly with K466-1 connector kit.

The LN-9 and LN-9 GMA are semiautomatic constant speed wire feeders that may be used with a variety of Lincoln DC and constant voltage power sources.

- LN-9 is designed for flux-cored wire without gas (Innershield®) and submerged arc processes. This 2 roll, high torque wire feeder has the power to feed large wires.
- LN-9 GMA is designed for MIG and flux-cored wire with gas (Outershield®). This 2 or 4 roll wire drive system is also available in a boom mounted version.

The LN-9 series wire feeder features controlled wire feed speed and current during starting which provide clean, positive starts and minimizes stubbing, skipping and spatter. These wire feeders provide dependable, interruption-free performance, and rugged and reliable operation, which make the LN-9 series wire feeder ideal for shop or field applications.

ADVANTAGE LINCOLN

- Completely enclosed case protects the heavy duty wire drive mechanism from dirt, dust and damage, but allows easy access to drive rolls.
 - Standard digital meter can be set to read volts, inches or meters/minute.
 - Control circuit features “cold electrode” to provide electrically “cold” electrode when the gun trigger is engaged for an added measure of safety. Power source must be equipped with a contactor.
 - The LN-9 and LN-9 GMA have trigger interlock which permits continued welding without holding the gun trigger. The LN-9 GMA allows stopping the weld without pulling the gun away from the work, thus allowing use of postflow and burnback timers even when employing the trigger interlock feature.
 - Low voltage (24 volts) gun trigger circuit for your safety.
 - Dynamic braking system stops wire feed motor quickly to minimize wire over-runs from welding to the crater.
 - 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 on LN-9 GMA models.
 - Wire feeder operates in any position due to pre-greased bearings. Therefore, the non-fluid lubricant can't leak out.
 - Digital readout wire feed speed and voltage that can be preset.
 - Standard gas solenoid on LN-9 GMA and LN-9F GMA models.
 - 3 year warranty on parts and labor.
 - Manufactured under a quality system certified to ISO 9001 requirements.
- LN-9 model feeds up to 3/32” (2.4mm) solid and .120” (3.0mm) flux-cored wires, from 50-600 inches per minute (1.3-15.3 m/min) wire feed speed.
 - LN-9 GMA models feed up to 1/16” (1.5mm) solid and 5/64” (2.0mm) flux-cored wires, from 80-980 inches per minute (2.0-24.3 m/min) wire feed speed.
 - Unique drive roll design provides positive feeding and quick reloading by simply starting wire into incoming guide tube. The drive rolls and guide tubes are designed for long life and precise wire feeding.
 - 4 roll wire drive system available for additional wire feeding force and easier feeding of softer, competitive flux-cored wires (LN-9 GMA model).

A CLOSER LOOK



Presettable voltage and wire feed speed controls behind locking security door.

Quick release gun and cable connection on LN-9 GMA.

Completely enclosed case keeps drive rolls clean.

Digital Display for easy viewing of adjustable welding parameters.

Optional K1524-1 Universal Wire Reel Stand with K1504-1 Coil Adapter.

TECHNICAL SPECIFICATIONS

Product Name	Solenoid	Ordering Information	Wire Speed Range IPM (m/min)	Wire Size Range in. (mm)		Input	(1) Dimensions Net Weight	H x W x D in. (mm)
				Solid	Cored			
LN-9, 2 roll	Optional	K357-1	50-600 (1.3-15.3)	.030-3/32" (0.6-2.4)	.035-.120" (0.9-3.0)	115 VAC	42 lbs (19 kg)	11.5 x 11.3 x 11.5 (292 x 287 x 292)
LN-9 GMA, 2 roll	Gas	K424-1	80-980 (2.0-24.3)	.023-1/16" (0.6-1.6)	.035-5/64" (0.9-2.0)	50/60 Hz	30 lbs (13.6 kg)	
LN-9 GMA, 4 roll	Gas	K568-2				2.5 Amps	45 lbs (20.4 kg)	
LN-9F GMA 4 roll	Gas	K583-2				59 lbs. (26.8 kg)		

(1) Net weight and dimensions do not include wire reel stand.

DRIVE ROLL AND GUIDE TUBE KITS

Steel Wire Sizes:	LN-9 GMA 2 roll	LN-9 GMA 4 roll	LN-9 2 roll
Solid Wire:			
.023 - .025" (0.6 mm) solid	KP653-025S	KP655-025S	---
.030" (0.8 mm) solid	KP653-030S	KP655-030S	KP502-035
.035" (0.9 mm) solid	KP653-035S	KP655-035S	KP502-035
.040" (1.0 mm) solid	KP653-035S	KP655-035S	KP502-052
.045 - .052" (1.2 - 1.3 mm) solid	KP653-052S	KP655-052S	KP502-052
1/16" (.062") (1.6 mm) solid	KP653-1/16	KP655-1/16	KP502-1/16
.068 - 3/32" (1.7 - 2.4 mm) solid	---	---	KP502-3/32
Cored Wire:			
.035" (0.9 mm) cored	KP653-035C	KP655-035C	---
.045 - .052" (1.2-1.3 mm) cored	KP653-052C	KP655-052C	KP502-052C
1/16" (.062") (1.6 mm) cored	KP653-1/16	KP655-1/16	KP502-1/16C
.068 - 3/32" (1.7-2.4 mm) cored	KP653-3/32 ⁽¹⁾	KP655-3/32 ⁽¹⁾	KP502-3/32
7/64" - .120" (2.8-3.0 mm) cored	---	---	KP502-120
Hardfacing:			
7/64" (2.8 mm) Hardfacing	---	---	KP502-7/64H
Aluminum Wire:			
.035" (0.9 mm)	KP654-035A	KP656-035A	---
3/64" (1.2 mm)	KP654-3/64A	KP656-3/64A	---
1/16" (1.6 mm)	KP654-1/16A	KP656-1/16A	---

(1) LN-9 GMA cored wire maximum feed size is 5/64". Use 3/32" size drive rolls.

CONTROL AND ELECTRODE POWER CABLE ASSEMBLIES

Control Cables

K1820-10

LN-9 to 14-pin power source, 10 ft. long. **Order K1820-10.**

Do Not extend longer than 210 ft. Longer cables may result in inconsistent voltage and wire feed speed control.

Control Cable Extensions

K1797

14-pin to 14-pin extension. For 25 ft. **Order K1797-25.**

For 50 ft. **Order K1797-50.**

Control Cable to Terminal Strip Adapter

K1798

Connects 14-pin control cable to power sources with terminal strip.

Order K1798.

Electrode and Work Weld Cables

Twist-Mate to Lug, 1/0, 350A, 60% duty cycle, 10 ft. **Order K1840-10.**

Twist-Mate to Twist-Mate, 1/0, 350A, 60% duty cycle, 25 ft. **Order K1841-25.**

Twist-Mate to Twist-Mate, 2/0, 350A, 60% duty cycle, 50 ft. **Order K1841-50.**

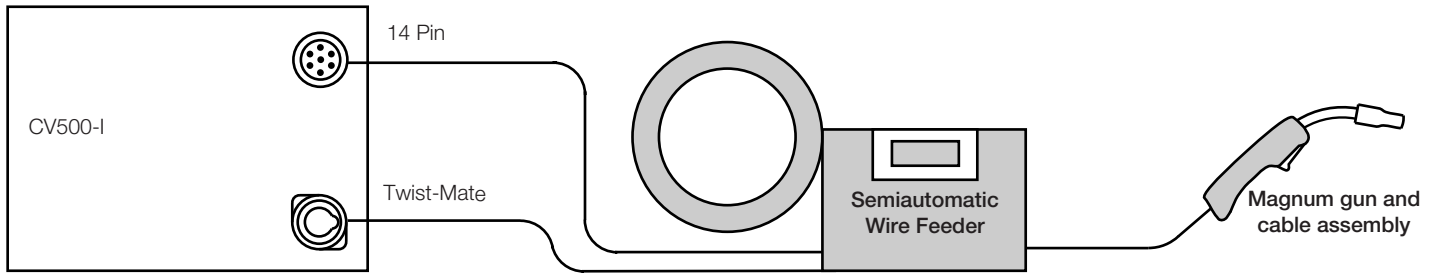
Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. **Order K1842-10.**

Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. **Order K1842-35.**

Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. **Order K1842-60.**

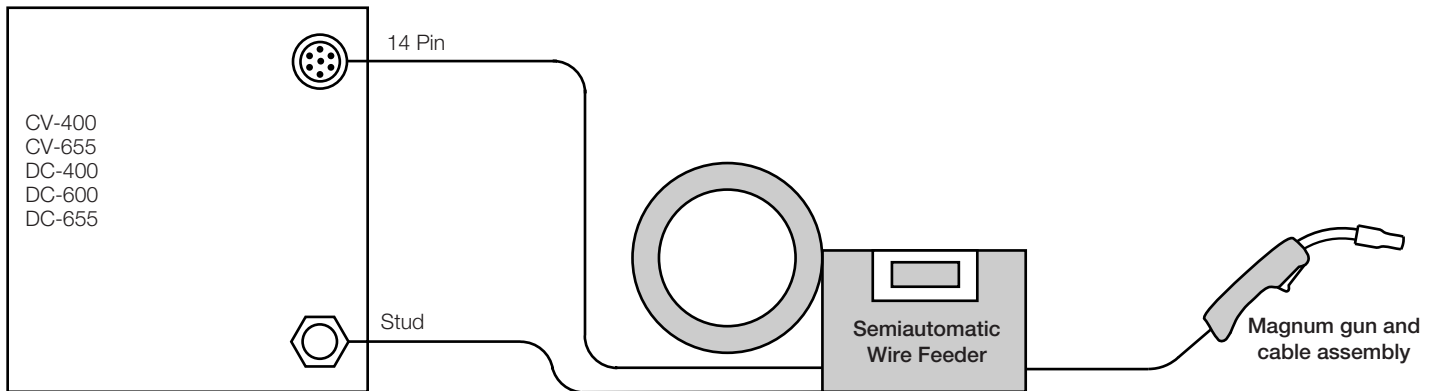
Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. **Order K1842-110.**

CONTROL AND ELECTRODE CABLE ASSEMBLY SELECTION GUIDE



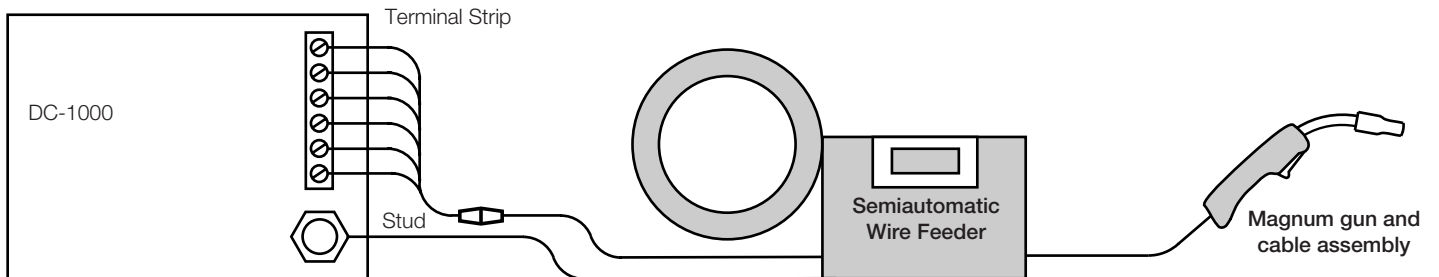
14 Pin MS-Type/ Twist-Mate™ Control and Electrode Cables

- | | | |
|--------|----------|--|
| | K1820-10 | Control Cable, LN-9, 10 ft. |
| 2 each | K1840-10 | Electrode and Work Weld Cable, Twist-Mate to Lug, 10 ft. |



14 Pin MS-Type/ Stud Control and Electrode Cables

- | | | |
|--------|----------|---|
| | K1820-10 | Control Cable, LN-9, 10 ft. |
| 2 each | K1842-10 | Electrode and Work Weld Cable, Lug to Lug, 10 ft. |



Terminal Strip/ Stud Control and Electrode Cable Assembly

- | | | |
|--------|----------|---|
| | K1820-10 | Control Cable, LN-9, 10 ft. |
| | K1798 | Control Cable to Terminal Strip Adapter |
| 2 each | K1842-10 | Electrode and Work Weld Cable, Lug to Lug, 10 ft. |

NOTE A: DO NOT extend control cable longer than 210 feet. Longer cables may result in inconsistent voltage and wire feed speed control.

RECOMMENDED OPTIONS

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.

Order K1524-1.



Insulated Lift Bail

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

Order K1555-1.



Caster Kit - Light Duty

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

Order K1556-1.



Universal 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.



Spindle Adapter For Readi-Reels and Spools

2" O.D. spindle for mounting Readi-Reels and 2" (51mm) I.D. spools up to 60 lb. (27.2 kg) capacity to a K303, or custom installations. Order K162-1.

Spindle Adapter For 14 lb. (6 kg) Innershield Coils

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



Spindle Adapter For Small Spools (10-12.5 lb.)

Permits 8" (203mm) O.D. spools to be mounted on 2" (51mm) O.D. spindles. Order K468.

Readi-Reel® 30 lb. (14 kg) Adapter

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



Readi-Reel® 60 lb. (27.2 kg) Adapter

Adapts 50-60 lb. (22.7-27.2 kg) Lincoln Readi-Reels of electrode to 2" (51mm) spindle. Order K438.



60 lb. (27.2 kg) Coil Adapter

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



Wire Reel Cover Kit

Plastic enclosure for 10 - 44 lb. (4.5 - 20 kg) wire packages. Order K1634-1.

For 10 - 60 lb. (4.5-27.2 kg) wire packages (shown) Order K1634-2.



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.

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.

RECOMMENDED OPTIONS

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 for LN-9.

Order K419 for LN-9 GMA.

GMA Timer Kit (LN-9 GMA only)

Provides delays for preflow and post-flow gas, adjustable burnback, and a purge/cold inch switch. **Order K418.**

Gas Solenoid Assembly

Includes solenoid valve and mounting bracket, to mount solenoid inside LN-9 case. For LN-9 (K357-1) model only, included with GMA models.

Order K425 (for code numbers above 9131).

Order K437 (for code numbers below 9132).

Continuous Flux Feeding Tank

For submerged arc welding. Includes air filter, pressure regulator, gauge, tank, 18 ft. (5.4m) flux hose, funnel and lift bail assembly to mount wire feeder to K163 undercarriage.

Order K320.

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.



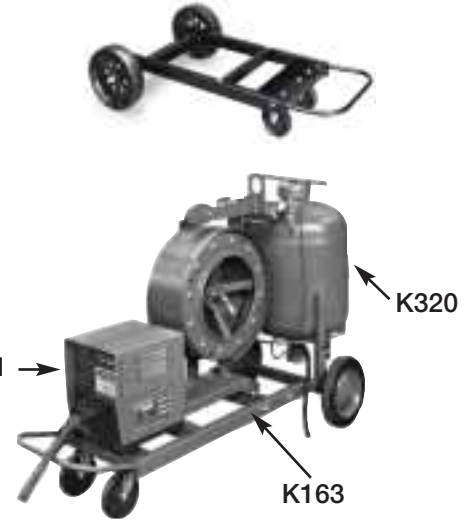
Wire Reel and Flux Tank Assembly

Includes K163 undercarriage, K320 Flux Feeding Tank Assembly and stand. **Order K305.**

Undercarriage

Includes mounting frame, front casters, rear wheels and handle for hand towing.

Order K163.



Magnum MIG and Gas-Shielded, Flux-Cored Guns Designed to be used with gas-shielded (MIG) and gas-shielded, flux-cored (FCAW) continuous feed arc welding wires. Rated 200 to 550 amps and available in cable lengths from 10 to 25 ft. (3.0 to 7.5 m). **For more information, request bulletin E12.10.**



Magnum Self-Shielded, Flux-Cored Guns Designed for welding with self-shielded, flux-cored arc welding (FCAW-SS) continuous feed wires. They are rugged and heavy duty, yet lightweight, flexible and maneuverable. **For more information, request bulletin E12.110.**



Magnum® Submerged Arc Guns

Rated 500 amps, 15 ft. (4.5m) length cable, for 1/16" (1.6mm) electrode size. **Order K112.**

Rated 600 amps, 15 ft. (4.5m) length cable, for 5/64" (2.0 mm) electrode size. **Order K113-1.**

Rated 600 amps, 15 ft. (4.5m) length cable, for 3/32" (2.4mm) electrode size. **Order K113-2.**

Magnum Wire Conduit

Designed for connecting the LN-9 and LN-9 GMA wire feeders to bulk packaging for added mobility. Available in 15, 25, 50 ft (4.5, 7.5, 15 m) or customized length.

Order K565-15, -25, -50, -FT.

LN-9 AND LN-9 GMA ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
LN-9 Wire Feeder - 2 roll	K357-1		
LN-9 GMA Wire Feeder - 2 roll	K424-1		
LN-9 GMA Wire Feeder - 4 roll	K568-2		
LN-9F GMA Wire Feeder - 4 roll	K583-2		
Recommended Options			
Drive Rolls	See Page 4 for sizes		
Control Cables	K1820-10		
Control Cable Extensions	K1797-25, -50		
Control Cable to Terminal Strip Adapter	K1798		
Electrode and Work Weld Cables	See page 4 for details		
Universal Wire Reel Stand	K1524-1		
Universal Swivel Platform	K1557-1		
Insulated Lift Bail	K1555-1		
Undercarriage	K163		
Caster Kit - Light Duty	K1556-1		
Coil Adapter - for 60 lb. Coils	K1504-1		
Spindle Adapter			
for 2" O.D. spools	K162-1		
for 14 lb. coils to 2" spindle	K435		
for 10-12.5 lb. spools to 2" spindle	K468		
Readi-Reel 30 lb. adapter	K363P		
Readi-Reel 60 lb. adapter	K438		
Wire Reel Cover Kit			
for up to 44 lbs.	K1634-1		
for up to 60 lbs.	K1634-2		
Submerged Arc Accessories			
Continuous Flux Feeding Tank Asbly.	K320		
Wire Reel and Flux Tank Asbly.	K305		
Flux Screen	K310		
Magnetic Flux Screen Separator	K58		
Options			
Burnback Timer Kit for LN-9 GMA	K419		
Burnback Timer Kit for LN-9	K202		
Timer Kit for LN-9 GMA	K418		
Gas Solenoid Assembly for LN-9			
for code numbers below 9132	K437		
for code numbers above 9131	K425		
Magnum Guns			
Self-Shielded Flux Cored Guns	Request Bulletin E12.110		
MIG and Gas Shielded Flux Cored Guns	Request Bulletin E12.10		
Magnum Submerged Arc Guns			
rated 500A for 1/16" electrode	K112		
rated 600A for 5/64" electrode	K113-1		
rated 600A for 3/32" electrode	K113-2		
mechanized, 600A, 5/64-3/32" electrode	K114		
Magnum Wire Conduit			
all wires, for LN-9 in 15, 25, 50 ft.	K565-15, -25, -50		
all wires, for LN-9 GMA in 15, 25, 50 ft.	K515-15, -25, -50		
Total:			

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THE LINCOLN ELECTRIC COMPANY
22801 St. Clair Ave.
Cleveland, Ohio 44117-1199

TEL: 216.481.8100 • FAX: 216.486.1751

www.lincolnelectric.com

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