

# POWER FEED® 25M

## 進階型送線機



### 進階的程序控制

此款輕便型可攜式送線機搭載先進功率，可用於野外和工廠等環境。使用MAXTRAC® 驅動系統，可完全控制與程序記憶預設。Power Feed® 25M 為近乎所有應用提供進階程序焊接。

- 全面化控制 - 雙程序提供輕鬆的程序即時轉換。記憶預設允許操作員可輕鬆喚回8組記憶，並針對指定應用進行操作範圍設定。
- 推拉功能 - 送線均勻以提供優質的鋁焊接表現，連接至送線機的焊槍長度可延伸。
- 堅固的可攜式設計 - 外型輕巧，適用於有限空間與惡劣環境。

#### 焊接工藝 »

MIG, Pulsed MIG, STT®, Flux-Cored, TIG, Gouging, Stick

#### 輸出 »



#### 輸入 »



#### 應用 »

金屬製造  
營造  
造船

#### 產品編號 »

K2536-4 紅色鋁殼  
K2536-5 塑膠殼

## 特色

- » **內部照明** - 照亮焊線驅動幫助操作員於昏暗環境中作業
- » **內部加熱** - 將焊線保溫以控制機器濕度，同時保護焊線
- » **進階程序控制** - 輕鬆進入並控制進階焊接程序參數，使電弧特性最佳化
- » **ArcLink® 通訊** - 業界領先的系統通訊可更快速偵測起弧時間。即插即用，不需其他輔助硬體

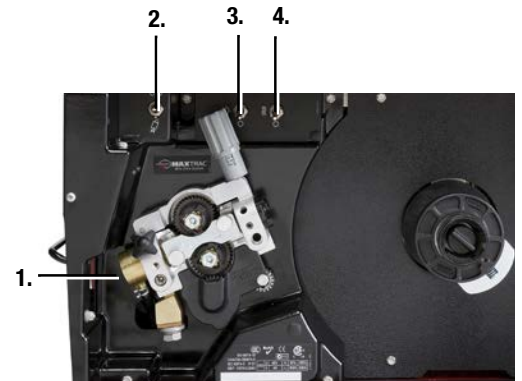
### 建議搭配焊接電源

- » Power Wave® S350
- » Power Wave S500
- » Power Wave S700
- » Flextec® 350X
- » Flextec 500X
- » Flextec 650X

## MAXTRAC® WIRE DRIVE SYSTEM

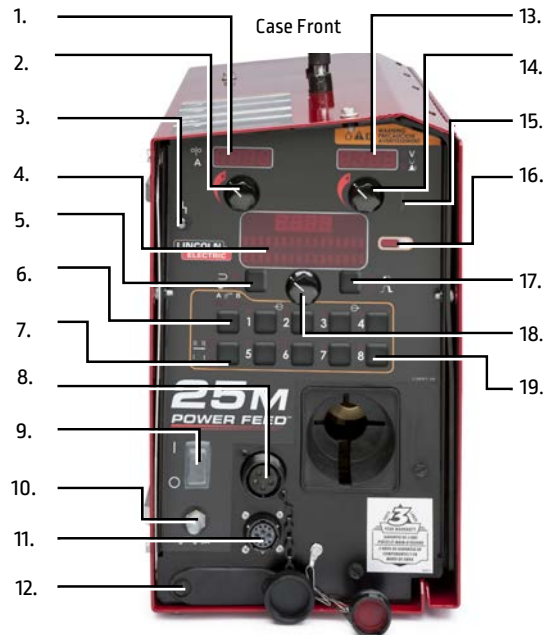


1. **雙齒輪 MAXTRAC® 焊線驅動系統**
  - 兩齒驅動齒輪搭配專利開槽設計。無需工具即可拆卸
  - 創新的獨立焊線導輪可精確校準，支撐焊線通過整個系統。提供最大支撐並將送線問題降至最低
  - 兩片式分線導輪結構提供輕鬆檢查、清潔或更換線徑
2. **氣吹/冷送線開關** - 提供方便的保護氣體氣吹與冷焊線送線
3. **照明開關** - 打開高強度LED以提供送線機內部照明
4. **加熱開關** - 內嵌式的加熱器可保溫內部空氣，防止焊線受潮



## 主要控制

1. **左側顯示器** - 顯示焊線的送線速度或安培
2. **送線速度/安培控制** - 可調整MIG與包藥焊線的送線速度；可調整手電焊與TIG的電流
3. **LED狀態燈** - 持續的綠燈表示與焊接電源間的通訊穩定
4. **主顯示器** - 顯示焊接細節與診斷資訊
5. **電弧控制** - 依據不同參數喜好調整電弧特性
6. **雙程序** - 於焊接中切換兩個焊接程序
7. **2階/4階控制** - 觸發連鎖功能
8. **焊槍開關接頭 (5-pin)** - 僅用於連接推線槍
9. **電源開關** - 防止受到電熱元件影響
10. **3安培斷路器** - 保護12-pin零件
11. **12-pin遠端接頭** - 連接遠端輸出控制或連接推拉槍
12. **水冷管蓋** - 覆蓋選購的水冷管線
13. **右側顯示器** - 顯示電壓或弧長
14. **電壓/弧長連續控制** - 可調整MIG與包藥的電壓；可調整 Pulsed MIG的弧長
15. **溫度LED燈** - 於驅動過熱時亮起
16. **設定** - 於送線機設定完成後亮起
17. **進階程序選項** - 控制焊接前/後的設定以達到最佳電弧啟動與停止
18. **焊接模式搜尋** - 依據母材、程序、保護氣體及其他參數搜尋最佳模式
19. **記憶預設** - 可儲存8組客製化焊接程序



## 配件

### ARCLINK®/LINC-NET™ 控制電纜

長度 ft. (m)	產品描述	訂購編號
8 (2.5)	ArcLink®/Linc-Net® Control Cable	K1543-8
25 (7.6)	ArcLink®/Linc-Net® Control Cable	K1543-25
50 (15.2)	ArcLink®/Linc-Net® Control Cable	K1543-50
100 (30.4)	ArcLink®/Linc-Net® Control Cable	K1543-100
25 (7.6)	Heavy duty ArcLink® Control Cable	K2683-25
50 (15.2)	Heavy duty ArcLink® Control Cable	K2683-50
100 (30.4)	Heavy duty ArcLink® Control Cable	K2683-100

### 焊接電源電纜

長度 ft. (m)	安培	占空比	尺寸	訂購編號
10 (3)	600	60%	3/0	K1842-10
35 (10.5)	600	60%	3/0	K1842-35
60 (18)	600	60%	3/0	K1842-60
110 (33.5)	600	60%	3/0	K1842-110

Note: All sizes are lug to lug connection type.

### 同軸焊接電源電纜<sup>(1)</sup>

長度 ft. (m)	安培	占空比	尺寸	訂購編號
25 (7.6)	350	60%	1/0	K1796-25
50 (15.2)	350	60%	1/0	K1796-50
75 (22.8)	300	60%	1/0	K1796-75
100 (30.4)	250 300	100% 60%	#1 1/0	K2593-100 K1796-100

<sup>(1)</sup> 建議用於送線機與焊接電源間距離較長時的STT® 與pulse焊接

Note: All sizes are lug to lug connection type.

### DRIVE ROLL & WIRE GUIDE KITS

Description in. (mm)	Order Number
<b>Steel Wire Sizes (includes stainless steel):</b>	
0.023-0.030 (0.6-0.8)	KP1696-030S
0.035 (0.9)	KP1696-035S
0.045 (1.2)	KP1696-045S
0.052 (1.4)	KP1696-052S
0.035, 0.045 (0.9, 1.2)	KP1696-1
0.040 (1.0)	KP1696-2
1/16 (1.6)KP1696-1/16S	
<b>Cored Wire Sizes:</b>	
0.030-0.035 (0.8-0.9)	KP1697-035C
0.040-0.045 (1.0-1.2)	KP1697-045C
0.052 (1.4)	KP1697-052C
1/16 (1.6)KP1697-1/16C	
<b>Steel or Cored Wire Sizes:</b>	
0.068-0.072 (1.8)	KP1697-068
5/64 (2.0)	KP1697-5/64
3/32 (2.4)	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
0.035 (0.9)	KP1695-035A
0.040 (1.0)	KP1695-040A
3/64 (1.2)	KP1695-3/64A
1/16 (1.6)KP1695-1/16A	

### Gun Bushings / Feed Plate Gun Adapters

K1500-1 [Comes installed on feeder]	K1500-2	K1500-3	K1500-4	K1500-5	K489-7
Lincoln Electric  Compatible gun connector kits K466-1 K613-1 K613-6 K466-8	Tweco® #2 - #4  Compatible gun connector kits K466-10 K466-2 K466-6	Tweco #5  Compatible gun connector kit K613-7 K613-2	Miller® guns  Compatible gun connector kits K466-3 K613-3	OXO® guns	Magnum® PRO Fast-Mate™ / Euro Connector Compatible gun connector kits K489-1 K489-2 K489-7 K489-8
					

Tweco® is a registered trademark of Victor Technologies.  
Miller® is a registered trademark of Miller Electric Mfg. Co.  
Oxo® is a registered trademark of Miller Electric Mfg. Co.



**Magnum® PRO Curve™**

Choose for MIG or flux-cored welding. Combine our classic curved handle with our Copper Plus™ contact tips and Magnum® PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.

See Publication E12.05



**Magnum® PRO AL Pistol Grip**

Pistol Grip models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

Order K3478-1 (15 ft),  
K3478-2 (25 ft)  
K3478-3 (35 ft)



**Magnum® PRO AL**

Models designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

See Publication E12.14 for more options



**Water Connection Kit**

Includes fittings for use with water-cooled guns and Magnum® coolers. Kit provides for one gun.

Order K590-6



**Deluxe Adjustable Gas Regulator & 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.

Order K586-1



**Portable Feeder Case-Plastic**

Replace a damaged case without replacing the entire unit.

Order K2596-2



**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.

Order K2909-1



**7-pin to 12-pin Adapter**

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

Order K2910-1



**Remote Output Control with 12-pin Universal Connector**

Consists of a control box with choice of two cable lengths. Permits remote adjustment of output.

Order K857-225 ft. (7.6 m)  
Order K857-3100 ft. (30.5 m)

**TIG OPTIONS**



**PTA-17150 Amp**

**Air-Cooled TIG Torch**

Order K1782-2 for 12.5 ft.

(3.8 m) length, 2-cable

Order K1782-4 for 25 ft.

(7.6 m) length, 2-cable



**PTA-26200 Amp**

**Air-Cooled TIG Torch**

Order K1783-2 for 12.5 ft.

(3.8 m) length, 2-cable

Order K1783-4 for 25 ft.

(7.6 m) length, 2-cable



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

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

Order K870-2



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

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

Order K963-4

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	Input Power	Rated Output Current/Duty Cycle	Gearing	Wire Feed Speed Range ipm (m/min)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
						Solid	Cored		
Power Feed 25M Aluminum Case	K2536-4	40 VDC	500A/60%	Standard speed (factory setting)	GMAW: 50-800 [1.3 - 20.3] FCAW: 50-800 [1.3 - 20.3]	0.023-1/16 [0.6-1.6]	0.030-5/64 [0.8-2.0]	14.5 x 8.5 x 23.5 [368 x 216 x 597]	35 [15.9]
Power Feed 25M Plastic Case	K2536-5			Extra-torque	GMAW: 30-400 [0.8-10.2] FCAW: 30-400 [0.8-10.2]	0.023-1/16 [0.6-1.6]	0.030-3/32 [0.8-2.4]		

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

Manufactured at a facility with certified ISO Quality and Environmental Management Systems.

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