

Featuring Our New  
Magnum EXPRESS™ Package  
(see page ...24)

**MAGNUM**™

# Arc Welding Guns

for Semiautomatic Gas-Shielded Welding

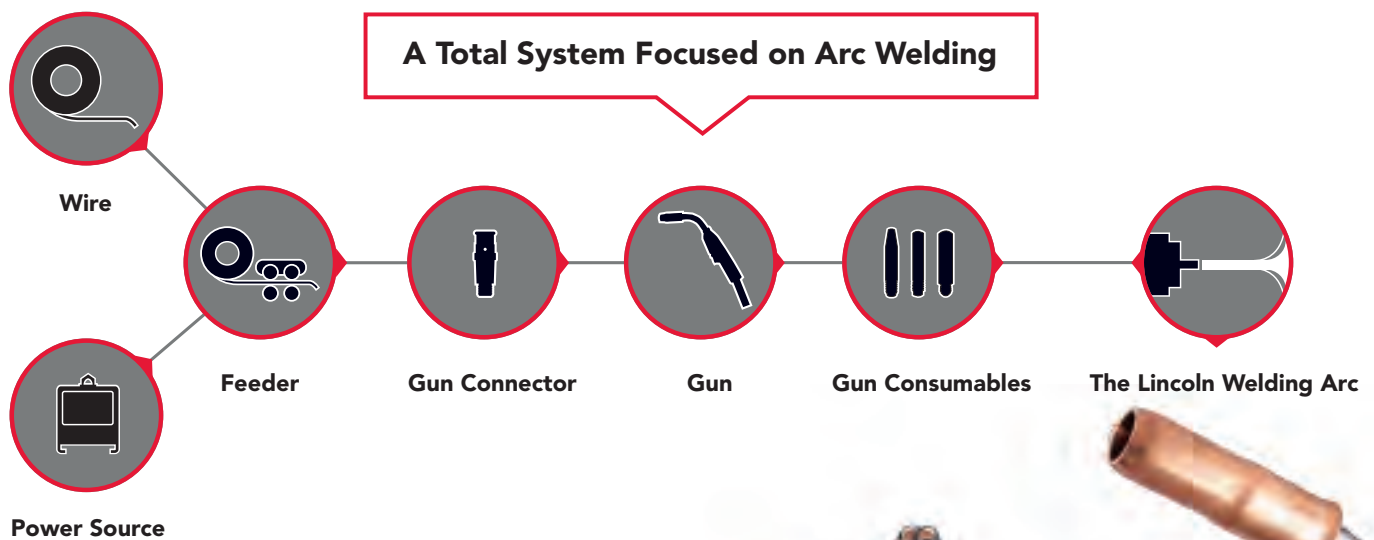
**Optimize Your Welding System!**



**LINCOLN**®  
**ELECTRIC**  
THE WELDING EXPERTS<sup>SM</sup>

# Critical Links: A Systems Approach

Making good welds is a lot like making good music.  
A carefully tuned set of instruments perform together in pleasing harmony.  
A power source, welding wire, wire feeder and a Lincoln Magnum Gun  
perform in harmony to produce one great weld after another.



## Why Choose a Lincoln Welding System?

Productivity, Ease-of-Use, Peace-of-Mind

- Technical assistance, cost reduction and productivity programs

- Hundreds of welding field sales engineers

- Thousands of knowledgeable and responsive Lincoln distributors

- Innovative approach to product designs and customer solutions

- Global presence



# Magnum Guns

## Optimize Your Welding System!

Magnum guns are designed by a total welding systems company. Many other gun companies deliver guns . . . and only guns.

That's not always the best solution. Why? Because the gun is not the only component, or critical link in the welding system.

Here at Lincoln Electric, we design, test and re-test the performance of every component in the arc welding system. We are one of the only manufacturers in the industry that brings welding equipment, wire, parts, service and expertise from a single, focused team.

That means we can commit to delivering total process solutions – from the power source to the wire and feeder – to the gun that delivers the arc.

We study how the gun delivers not only wire, but welding current and shielding gas to the weld – your weld. We assure that our gun is designed to work with the equipment purchased, and that it is rugged enough to work in service for a very long time. Optimize the welding system with Magnum Guns from Lincoln Electric.



What you should  
know about  
**MAGNUM**  
Guns

### Comfortable Handle

- Magnum's Patent Pending Handle grip design provides balance, reduces operator fatigue and offers a sure, confident grip

### Durable Construction

- Three Layer Insulated Gooseneck Construction
- Durable Abrasion-Resistant Gun Cable Outer Jacket
- Proprietary Wound Liner

### Complete Support Systems

- Guaranteed Parts and Service Support wherever you are

### Field Serviceable

- Quick-change gooseneck
- Screw on (Not Crimped) Gun Cable Connections
- Spare Trigger Lead
- One Piece Trigger Assembly

### Adapts to Your Application

- Interchangeable Gun Connectors, Nozzles and Goosenecks
- Large Selection of Industry Standard Nozzle and Contact Tip Types

### Easy to Specify & Order

1. Choose operating amperage range
2. Select a specific gun
3. Select a gun connector
4. Select additional consumables

# Not Only Will Magnum Guns Optimize Your Welding System, But They'll Also Increase...



## PRODUCTIVITY

- One-piece modular trigger assembly is molded out of high heat resistant thermoset material to withstand heat and spatter and ensure long life.
- Gun tube design optimizes fine wire welding performance. The outside of the gun tube is armored with an electrically insulated metal jacket, eliminating wear problems of other softer insulation materials.
- The gun tube is buffed to a high shine which helps reflect radiant heat from the weld.
- Abrasion-resistant, extruded rubber jacket adds strength and long life to the cable.
- Repairable cable connections and a spare internal trigger lead allow user to easily service the cable.
- Liners made with a spring steel jacket and a low friction core are available for feeding aluminum wire.
- The fiberglass handle with non-slip grooves is designed to minimize size and maximize comfort and control.
- Gun cable contains a pure copper conductor with high strand count for cool operation and maximum flexibility.

## EASE-OF-USE

- Can be connected to virtually any wire feeder in the industry.
- Improved, more intuitive part numbers for easier reference and ordering.
- Adjustable hanger provides convenient means for storing guns between welds.
- Magnum gun expendables are compatible with other leading brands.

## PEACE-OF-MIND

- Lincoln Electric provides technical assistance, cost reduction and productivity programs.
- When Magnum guns increase your productivity and welding quality right out of the box...everybody wins.
- The welding gun is the final critical link in your welding performance – why risk all your research and investment on less than Magnum?
- Optimize Your Welding Systems!

**Don't Be Under Gunned!**

**Gun Consumables Match an Industry Standard Design****Rotatable Gooseneck (Gun Tube)**

- Just loosen a single Allen screw to unlock and rotate the gooseneck into a position that is most comfortable for your current job
- Especially useful to complete high quality welds even in tight spaces or awkward joint locations

**One Piece Replaceable Trigger Assembly**

- Easy to replace as a unit—simply plug in a new assembly
- Can also be opened and serviced
- High quality silver contacts for long life and clean electrical signals
- Full travel mechanical trigger mechanism (NOT a micro-switch) can be easily felt through a welding glove

**Rotatable Gun Hanger**

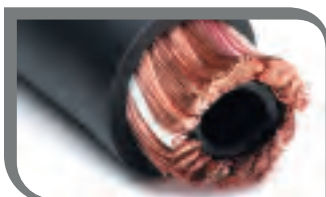
- Hang your gun anywhere, any way

**Comfortable Handle Design**

- Patent Pending Magnum Grip Design—Unique grip design provides balance, reduces operator fatigue and offers a sure, confident grip
- Natural Grip Trigger position feels right from the first minute of the day to the end of the Shift

**Rugged Strain Relief System**

- Enhances feedability by reducing acute gun cable angles
- Protects your cable liner



Pure copper conductor with high strand count for cool operation and maximum flexibility



Gun connectors for all popular feeders



400 amp Dual Procedure and Dual Schedule guns provide an added measure of control on tough applications



## Always Available: Our Quick-turn Pledge

Need gun consumables or parts in a hurry?  
Contact us via phone, fax or email to order  
the parts you need. That's our pledge.



# Gun Consumables

## A Critical Link that Can Make the Difference

- Industry standard design compatibility allows use on competitive guns
- Industry standard part numbers are easy to order
- Wide variety of consumables for every application
- Tight manufacturing tolerances deliver consistent arc performance
- Tested durability delivers long life
- Improved electrical conductivity and wire feedability
- Convenient Packaging Options - Including Bulk Packages



Multiple nozzle & contact tip types for specific applications

## Customize Your Gun!

Choose a gun nozzle for your welding style. Select a gooseneck that will help you get into tight spaces. Whatever your skill level or personal style demands, Lincoln has what you need.

### Nozzles

Fixed, Tip Flush  
Fixed, Tip Recessed  
CT-Coarse Thread  
Slip-On, Adjustable  
Slip-On, Tip Recessed

### Contact Tips

Standard  
Heavy Duty  
Tapered  
Notched

### Gas Diffuser

Standard  
Tip Recessed  
For Slip-On Nozzle  
For Fixed Nozzle  
Specialty

### Nozzle Insulator

Adjustable Slip-on  
Coarse Thread

### Tubes/Goosenecks

60°  
45°  
82°

### Connectors

Lincoln®  
Lincoln Fast-Mate™ (Euro)  
Miller®  
Tweco-Adapted®  
Hobart®  
ESAB®

# Four Easy Steps

Use this quick and easy four step process to select the right gun and all your accessories

1

**Choose operating amperage range:**

Select an amperage range for your application, based on your knowledge of the thickness of material and your equipment capability.

2

**Select a specific gun:**

At a glance, you can choose a wire diameter range and gun type, along with basic wire feeder connection type and gun cable length—and that simply drives you to the right gun for your application.

3

**Select a gun connector (Magnum 200–550):**

Match your gun to your wire feeder by manufacturer and/or gun connector type.

4

**Select additional consumables:**

- Pick up a pack of extra contact tips.
- Choose a nozzle for your welding style.
- Order replacement gas diffusers or gun liners.
- Select a gooseneck that will help you get into tight spaces.

or

**Select a Magnum Express.**





STEP  
**1**

# Choose a Gun with the Right Operating Amperage Range

**200 amps**



## Magnum 200 Gun

A small, lightweight gun intended for light job shop and fabrication applications. Best suited for welding on thin materials using .025–.030" wire.

**300 amps**



## Magnum 300 Gun

This popular Magnum gun is intended for most .035–.045" wire diameter applications in job shops, production or manufacturing. Standard equipment on the current Lincoln Power MIG® 350MP wire feeder/welder.

**400 amps**



## Magnum 400 Gun

With a longer gooseneck and a higher copper strand count cable than the 300, the 400 gun is built for operator comfort when welding with the greater heat levels generated by higher amperage applications. Select the 400 for most .045", .052" or 1/16" MIG, UltraCore™ or Metalshield® (gas-shielded) operations.

**500 or 600 amps**



## Magnum 550 Gun–500 or 600 amps

Choose our 550 gun equipped with 500 or 600 amp consumables for high amperage, large wire diameter welding, including up to .052" and .062" MIG or 3/32–1/8" Outershield® or UltraCore™ (gas-shielded flux-cored) applications.

**100 amps**



## Magnum 100L Gun

Extremely small, lightweight gun that's great for most home, farm and small shop projects, auto-body work and light maintenance or repair applications. Standard equipment on current Lincoln SP-135T and SP-175T, Power MIG® 140T, 140C, 180T and 180C. Includes gun connector.

**250 amps**



## Magnum 250L Gun

Recommended for medium duty job shop and production applications. Standard equipment on the current Lincoln Power MIG 215 and Power MIG 255C wire feeder/welders. Includes gun connector.

**Amperage Rating**

60% Duty Cycle  
CO<sub>2</sub> Shielding Gas  
200 A

**Wire Diameter Range**

.025" - .045"  
(0.6 mm - 1.2 mm)

**Net Weight**

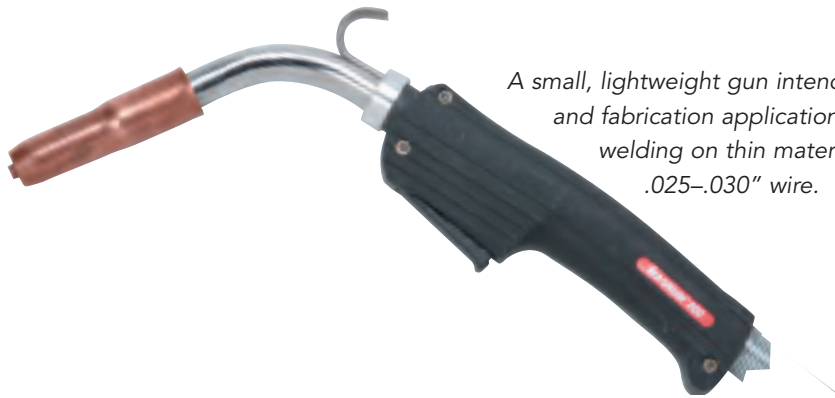
9 - 12 lbs.  
(4.0 - 5.4 kg)



STEP  
**2**

# Select a Gun for Your Application

**MAGNUM**  
**200**  
200 amps



A small, lightweight gun intended for light job shop and fabrication applications. Best suited for welding on thin materials using .025–.030" wire.

## Magnum Guns (200 amps)

GUN	CABLE LENGTH	WIRE DIAMETER .025"–.030" (0.6mm–0.8mm)		WIRE DIAMETER .035"–.045" (0.9mm–1.2mm)		
		GUN CONNECTOR		GUN CONNECTOR		
		Open-End	Gun Package	Open-End	Fast-Mate	Gun Package
Standard	10' (3.0m)	—	—	K497-2	K498-2	—
	12' (3.6m)	—	—	K497-6	K498-6	—
	15' (4.5m)	K497-3	K497-20	K497-1	K498-1	K497-21

### Included Parts

	.025: <b>KP14-25</b> (KP2020-6) .030: <b>KP14-30</b> (KP2020-7)	.035: <b>KP14-35</b> (KP2020-1) .045: <b>KP14-45</b> (KP2020-2)
Contact Tip		
Gas Diffuser	<b>KP52-23</b> (KP2026-2)	<b>KP52</b> (KP2026-1)
Gas Nozzle	<b>KP22-50</b> (KP1935-2)	<b>KP22-50</b> (KP1935-2)
Insulator	<b>KP32</b> (KP2025-1)	<b>KP32</b> (KP2025-1)
Cable Liner	<b>KP42-25-15</b> (KP1934-2)	<b>KP42-4045-15</b> (KP1934-1)
Gun Tube (60°)	KP2028-1	KP2028-1

*Wire Feeder Connector:*

- Open-End: Feeder end of the gun is open. A separate Gun Connector Kit is required. (See Gun Connector Kit Section).
- Fast-Mate™: Also known as Euro-Connect.
- Lincoln 10 Series Pkg.: Includes K466-10 Lincoln 10 Series Gun Connector Kit.



### Optional Feature Gas Tube Kit

Fast Connect Gas Tube Kit provides connection to Lincoln wire feeders.

Order K481



# Choose a Gun Connector

Gun Connectors (200 amps)		
MFG.	WIRE FEEDER MODEL	CONNECTOR KITS FOR STANDARD GUNS
Lincoln	LN-7 Series, LN-742, LN-8, LN-9 Series LN-25 (Up to .052" (1.4 mm) Wire)	K466-1
	LN-8, LN-9 Series, LN-25 (1/16" (1.6 mm) & Larger Wire)	K466-8
	LF-72, LF-74 Series	K466-10
	Power Feed® 10M, LN-10, DH-10, STT-10 LN-15, Power Feed 15M	K466-10
	Power MIG® Series & Wire-Matic™ Series	K466-6
Tweco® Adapted	No. 2, 3 & 4 Guns	K466-2
Miller®	Intellimatic®, Side Kick®, D-51A Porto-MIG®, Millermatic® 130, 300 & 35 (new) S-42GL, S-52A & S-54A Swing Arc®-Dual & Single (new), S-22, S-32S, 52D, 54D & 54E, 60 & 70 Series	K466-3
Hobart®	Dualmatic® 27/70, H3S, H4S & H6S Mega-Conds® 27, 44, 45, 70, 70S	K466-4
	2000 Series, 17 Hefty®	K466-7
ESAB®	Digamig®, EH1, 5 & 11, SEH-4 & 5 SWM11 & 11B, 12, 13, 23, 24, 25, 26, 35 VAM2	K466-5

Included Parts									
	K466-1	K466-2	K466-3	K466-4	K466-5	K466-6	K466-7	K466-8	K466-10
① Connector Assembly	S18645 (a) T7028-234 (b)	S18653 (a) S19762 (b)	S19760 (a) S19761 (b) KP2009-X (c)	S19763 (a) S19765 (b) KP2009-X (c)	S20044	S18653	S18653	S18645-2	S18653
② Control Cable	M15608	—	M16325	M16328	M16520	M16325	—	M15608	M15608
③ Fittings	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	—	T10642-166 T14557-7 T13777-4	—
④ Connector Tools	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 S18845	T11563-4 S18845	T11563-4 (a) S18845 (b)	T11563-4 S18845	T11563-4 S18845

# Gun Connector Included Parts

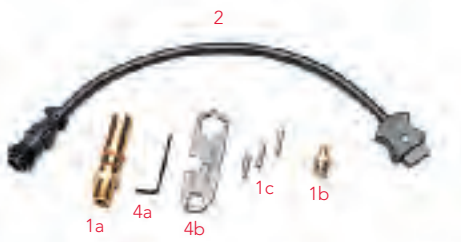
**MAGNUM.**  
**200**  
200 amps



K466-1



K466-2



K466-3



K466-4



K466-5



K466-6



K466-7



K466-8



K466-10

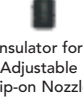
**STEP**  
**4**

# Choose Your Consumables



		Part Number Previous Part Number					
TIP	QTY.	WIRE DIAMETER					
		.025" (0.6mm)	.030" (0.8mm)	.035" (0.9mm)	.040" (1.0mm)	.045" (1.2mm)	3/64" (1.2mm)
Standard Duty	10	KP14-25 KP2020-6B1	KP14-30 KP2020-7B1	KP14-35 KP2020-1B1	KP14-40 KP2020-8B1	KP14-45 KP2020-2B1	KP14A-364 KP2020-9B1
	Bulk	KP14-25-B100 KP2020-6B2	KP14-30-B100 KP2020-7B2	KP14-35-B100 KP2020-1B2	KP14-40-B100 KP2020-8B2	KP14-45-B100 KP2020-2B2	KP14A-364-B100 KP2020-9B2
Heavy Duty	10	— —	— —	KP14H-35 KP2021-1B1	KP14H-40 KP2021-6B1	KP14H-45 KP2021-2B1	KP14H-364 <sup>(1)</sup> KP2021-7B1
	Bulk	— —	— —	KP14H-35-B100 KP2021-1B2	KP14H-40-B100 KP2021-6B2	KP14H-45-B100 KP2021-2B2	KP14AH-364-B100 KP2021-7B2
Tapered	10	KP14T-25 KP2022-5B1	KP14T-30 KP2022-6B1	KP14T-35 KP2022-1B1	KP14T-40 KP2022-7B1	KP14T-45 KP2022-2B1	— —
	Bulk	KP14T-25-B100 KP2022-5B2	KP14T-30-B100 KP2022-6B2	KP14T-35-B100 KP2022-1B2	KP14T-40-B100 KP2022-7B2	KP14T-45-B100 KP2022-2B2	— —
Notched (Alum.)	10	— —	KP2010-3B1 <sup>(1)</sup> —	KP2010-4B1 <sup>(1)</sup> —	— —	— —	KP2010-5B1 <sup>(1)</sup> —
	Bulk	— —	— —	— —	— —	— —	— —

| 10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding



		Part Number Previous Part Number		
NOZZLE	QTY.	NOZZLE DIAMETER		
		.38" (9.5mm)	.50" (12.7mm)	.62" (15.9mm)
Adjustable Slip-on <sup>(1)</sup> Nozzle	1	KP22-37 KP1935-3	KP22-50 KP1935-2	KP22-62 KP1935-1
	Bulk	KP22-37-B25 KP1935-3B1	KP22-50-B25 KP1935-2B1	KP22-62-B25 KP1935-1B1
Insulator for Adj. Slip-on Nozzle	1	KP32 KP2025-1	KP32 KP2025-1	KP32 KP2025-1
	Bulk	KP32-B25 KP2025-1B1	KP32-B25 KP2025-1B1	KP32-B25 KP2025-1B1
Gasless Nozzle	1	KP1947-1 —	KP1947-1 —	KP1947-1 —
	Bulk	— —	— —	— —
Spot Nozzle	1	KP21-62-FAS KP1956-1	KP21-62-FAS KP1956-1	KP21-62-FAS KP1956-1
	Bulk	— —	— —	— —

| 1 = Qty. in pack | Bulk = Qty. of 25 | <sup>(1)</sup> Requires KP32, Nozzle Insulator Assembly

### Gas Diffuser (200 amps)



Gas Diffuser Assembly

Diffuser	QTY.	WIRE DIAMETER			Part Number Previous Part Number	
		.025"–.030" (0.6–0.8mm)	.035"–.045" (0.9–1.2mm)	.025"–.045" (0.6–1.2mm)		
Gas Diffuser Assembly	5	KP52-25 KP2026-2	KP52FN <sup>(1)</sup> KP2026-3	KP2051-1 <sup>(2)</sup> —	or	KP52FN <sup>(1)</sup> KP2026-3
	Bulk	KP52-25-B25 KP2026-2B1	KP52FN-B25 <sup>(1)</sup> KP2026-3B1	KP2051-1B1 <sup>(2)</sup> —	or	KP52FN-B25 <sup>(1)</sup> KP2026-3B1

5 = Qty. in Pack

Bulk = Qty. of 25

<sup>(1)</sup> Permits use of 300 and 400 fixed nozzles with 200 amp gun and cable

<sup>(2)</sup> Permits use of 100 amp contact tips with 200 amp gun and cable

### Gun Tubes (200 amps)



45° Gun Tube



60° Gun Tube



82° Gun Tube

TUBE	QTY.	RATED (AMPS)		
		200	300	400
45°	1	— —	KP1929-2 —	KP1929-1 —
	Bulk	— —	— —	— —
60°	1	KP2028-1 —	KP1928-2 —	KP1928-1 —
	Bulk	— —	— —	— —
82°	1	— —	— —	KP1941-1 —
	Bulk	— —	— —	— —
Gun Tube Insulator	1	— —	— —	— —
	Bulk	— —	— —	— —

1 = Qty. in pack

Bulk = N/A

**NOTE:** 300 & 400 amp gun tubes can be used with 200 amp guns. Use corresponding amperage gas diffuser, nozzle, and nozzle insulator.

### Cable Liner (200 amps)



Cable Liner

LINER	QTY.	DIAMETER				Part Number Previous Part Number	
		.025"–.030" (0.6–0.8 mm)	.030"–.035" (0.8–0.9 mm)	.035"–.045" (0.9–1.2 mm)	Aluminum .035"– 3/64" <sup>(1)</sup> (0.9–1.2 mm)		
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP42-25-15 KP1934-2	KP42-3035-15 KP1934-3	KP42-4045-15 KP1934-1	KP44N-3545-15 <sup>(1)</sup> KP1955-1		
	Bulk	KP42-25-15-B10 KP1934-2B1	KP42-3035-15-B10 KP1934-3B1	KP42-4045-15-B10 KP1934-1B1	KP44N-3545-15-B10 KP1955-1B1		

1 = Qty. in Pack

Bulk = Qty. of 10

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

Recommended maximum cable length for aluminum is 10 ft. (3.0m).

**Amperage Rating**

60% Duty Cycle  
CO<sub>2</sub> Shielding Gas  
300 A

**Wire Diameter Range**

.025" - 5/64"  
(0.6 mm - 2.0 mm)

**Net Weight**

9 - 12 lbs.  
(4.0 - 5.4 kg)

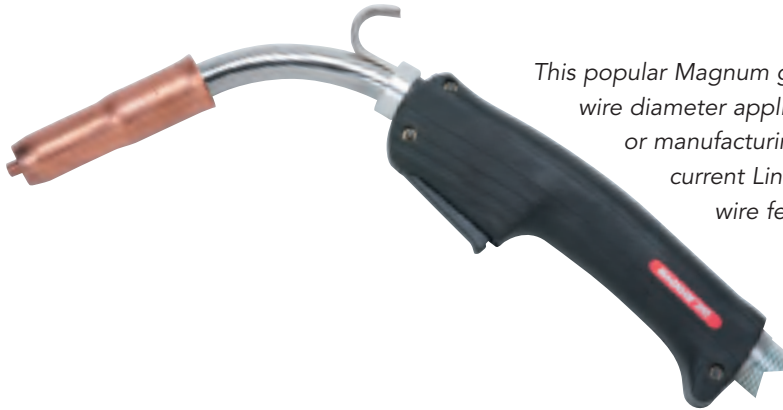




STEP  
**2**

# Select a Gun for Your Application

**MAGNUM**  
**300**  
300 amps



This popular Magnum gun is intended for most .035-.045" wire diameter applications in job shops, production or manufacturing. Standard equipment on the current Lincoln Power MIG® 350MP wire feeder/welder.

## Magnum Guns (300 amps)

GUN	CABLE LENGTH	WIRE DIAMETER		WIRE DIAMETER		WIRE DIAMETER	
		.035"-.045" (0.6mm-0.9mm)		.052"-1/16" (1.3mm-1.6mm)		1/16"-5/64" (1.6mm-2.0mm)	
		GUN CONNECTOR		GUN CONNECTOR		GUN CONNECTOR	
		Open-End	Fast-Mate	Open-End	Fast-Mate	Open-End	Fast-Mate
Standard	10' (3.0m)	K470-1	K478-1	—	K478-3	—	—
	12' (3.6m)	K470-7	—	—	—	—	—
	15' (4.5m)	K470-2	K478-2	K470-4	—	K470-6	—
For LN-25	15' (4.5m)	—	K1802-1	—	—	—	—

### Included Parts

Part	.035: KP14-35 (KP2020-1) .045: KP14-45 (KP2020-2)	.052: KP14-52 (KP2020-3) 1/16: KP14-116 (KP2020-4)	1/16: KP14-116 (KP2020-4) 5/64: KP14-564 (KP2020-5)
Contact Tip			
Gas Diffuser	KP54A (KP2024-1)	KP54A (KP2024-1)	KP54A (KP2024-1)
Gas Nozzle	KP24A-62 (KP1932-1)	KP24A-62 (KP1932-1)	KP24A-62 (KP1932-1)
Insulator	KP34A (KP2023-1)	KP34A (KP2023-1)	KP34A (KP2023-1)
Cable Liner	KP44-3545-15 (KP1933-1)	KP44-116-15 (KP1933-2)	KP44-564-15 (KP1933-3)
Gun Tube (60°)	KP1928-2	KP1928-2	KP1928-2

**Wire Feeder Connector:**

- Open-End: Feeder end of the gun is open. A separate Gun Connector Kit is required. (See Gun Connector Kit Section).

- Fast-Mate™: Also known as Euro-Connect.

- LN-25 Gun Pkg.: Includes K466-1 LN-25 Gun Connector Kit



### Optional Feature

#### Gas Tube Kit

Fast Connect Gas Tube Kit provides connection to Lincoln wire feeders.

Order K481

**STEP**  
**3**

# Choose a Gun Connector

## Gun Connectors (300 amps)

MFG.	WIRE FEEDER MODEL	CONNECTOR KITS FOR STANDARD GUNS	FASTMATE™ ADAPTER KITS FM GUNS
		Single Procedure	Single Procedure
Lincoln	LN-7 Series, LN-742, LN-8, LN-9 Series LN-25 (Up to .052" (1.4 mm) Wire)	K466-1	K489-1
	LN-7 Series, LN-742, LN-8, LN-9 Series LN-25 (1/16" (1.6 mm) & Larger Wire)	K466-8	K489-1
	LF-72, LF-74 Series	K466-10	—
	Power Feed® 10M, LN-10, DH-10, STT-10 LN-15, Power Feed 15M	K466-10	K489-7
	Power MIG® Series & Wire-Matic™ Series	K466-6	K489-8
Tweco® Adapted	No. 2, 3 & 4 Guns	K466-2	K489-4
Miller®	Intellimatic®, Side Kick®, D-51A Porto-MIG®, Millermatic® 130, 300 & 35 (new) S-42GL, S-52A & S-54A Swing Arc®-Dual & Single (new), S-22 S-32S, 52D, 54D & 54E, 60 & 70 Series	K466-3	K489-3
Hobart®	Dualmatic® 27/70, H3S, H4S & H6S Mega-Conds 27, 44, 45, 70, 70S	K466-4	K489-5
	2000 Series, 17 Hefty®	K466-7	K489-5
ESAB®	Digamig®, EH1, 5 & 11, SEH-4 & 5 SWM11 & 11B, 12, 13, 23, 24, 25, 26, 35 VAM2	K466-5	—

*Gun Connector Kits are Included with FM Guns*

Included Parts									
	K466-1	K466-2	K466-3	K466-4	K466-5	K466-6	K466-7	K466-8	K466-10
① Connector Assembly	S18645 (a) T7028-234 (b)	S18653 (a) S19762 (b)	S19760 (a) S19761 (b) KP2009-X (c)	S19763 (a) S19765 (b) KP2009-X (c)	S20044	S18653	S18653	S18645-2	S18653
② Control Cable	M15608	—	M16325	M16328	M16520	M16325	—	M15608	M15608
③ Fittings	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	—	T10642-166 T14557-7 T13777-4	—
④ Connector Tools	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 S18845	T11563-4 S18845	T11563-4 (a) S18845 (b)	T11563-4 S18845	T11563-4 S18845

# Gun Connector Included Parts

**MAGNUM.**  
**300**  
300 amps



K466-1



K466-2



K466-3



K466-4



K466-5



K466-6



K466-7



K466-8



K466-10



K489-1, 2, 3, 4, 5, 7, 8

STEP  
**4**

# Choose Your Consumables

## Contact Tips (300 amps)

Part Number  
Previous Part Number

TIP	QTY.	WIRE DIAMETER				
		.025" (0.6mm)	.030" (0.8mm)	.035" (0.9mm)	.040" (1.0mm)	.045" (1.2mm)
Standard Duty	10	KP14-25 KP2020-6B1	KP14-30 KP2020-7B1	KP14-35 KP2020-1B1	KP14-40 KP2020-8B1	KP14-45 KP2020-2B1
	Bulk	KP14-25-B100 KP2020-6B2	KP14-30-B100 KP2020-7B2	KP14-35-B100 KP2020-1B2	KP14-40-B100 KP2020-8B2	KP14-45-B100 KP2020-2B2
Heavy Duty	10	— —	— —	KP14H-35 KP2021-1B1	KP14H-40 KP2021-6B1	KP14H-45 KP2021-2B1
	Bulk	— —	— —	KP14H-35-B100 KP2021-1B2	KP14H-40-B100 KP2021-6B2	KP14H-45-B100 KP2021-2B2
Tapered	10	KP14T-25 KP2022-5B1	KP14T-30 KP2022-6B1	KP14T-35 KP2022-1B1	KP14T-40 KP2022-7B1	KP14T-45 KP2022-2B1
	Bulk	KP14T-25-B100 KP2022-5B2	KP14T-30-B100 KP2022-6B2	KP14T-35-B100 KP2022-1B2	KP14T-40-B100 KP2022-7B2	KP14T-45-B100 KP2022-2B2
Notched (Alum.)	10	— —	KP2010-3B1 <sup>(1)</sup> —	KP2010-4B1 <sup>(1)</sup> —	— —	— —
	Bulk	— —	— —	— —	— —	— —

10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding



Standard Duty



Heavy Duty



Tapered



Notched

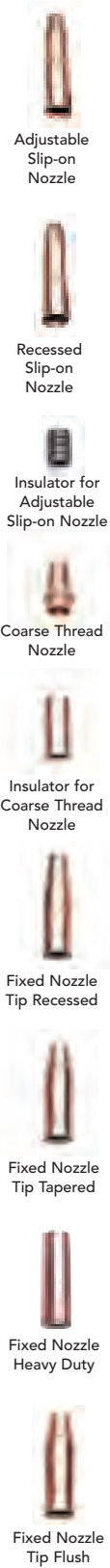
## Contact Tips (300 amps) Continued

TIP	QTY.	WIRE DIAMETER					
		3/64" (1.2mm)	3/64A" (1.2mm)	.052" (1.3mm)	1/16" (1.6mm)	1/16"A (1.6mm)	5/64" (2.0mm)
Standard Duty	10	— —	KP14A-364 <sup>(1)</sup> KP2020-9B1	KP14-52 KP2020-3B1	KP14-116 KP2020-4B1	— —	KP14-564 KP2020-5B1
	Bulk	— —	KP14A-364-B100 <sup>(1)</sup> KP2020-9B2	KP14-52-B100 KP2020-3B2	KP14-116-B100 KP2020-4B2	KP14AH-116 <sup>(1)</sup> KP2021-8B1	KP14-564-B100 KP2020-5B2
Heavy Duty	10	KP14AH-364 <sup>(1)</sup> KP2021-7B1	KP14AH-364 <sup>(1)</sup> KP2021-7B1	KP14H-52 KP2021-3B1	KP14H-116 <sup>(1)</sup> KP2021-4B1	KP14AH-116-B100 <sup>(1)</sup> KP2021-8B2	KP14H-564 KP2021-5B1
	Bulk	KP14AH-364-B100 <sup>(1)</sup> KP2021-7B2	KP14AH-364-B100 <sup>(1)</sup> KP2021-7B2	KP14H-52-B100 KP2021-3B2	KP14H-116-B100 KP2021-4B2	— —	KP14H-564-B100 KP2021-5B2
Tapered	10	— —	— —	KP14T-52 KP2022-3B1	KP14T-116 KP2022-4B1	— —	— —
	Bulk	— —	— —	KP14T-52-B100 KP2022-3B2	KP14T-116-B100 KP2022-4B2	— —	— —
Notched (Alum.)	10	KP2010-5B1 <sup>(1)</sup> —	— —	— —	— —	— —	— —
	Bulk	— —	— —	— —	— —	— —	— —

10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding

**Gas Nozzle/Insulator (300 amps)**

Part Number  
Previous Part Number



NOZZLE	QTY.	NOZZLE DIAMETER			
		.38" (9.5mm)	.50" (12.7mm)	.62" (15.9mm)	.75" (19.1mm)
Adjustable Slip-on Nozzle	1	—	KP24A-50 KP1932-2	KP24A-62 KP1932-1	—
	Bulk	—	KP24A-50-B25 KP1932-2B1	KP24A-62-B25 KP1932-1B1	—
Recessed Slip-on Nozzle	1	KP24A-37-SS KP1932-5	KP24A-50-SS KP1932-4	KP24A-62-SS KP1932-3	—
	Bulk	KP24A-37-SS-B25 KP1932-5B1	KP24A-50-SS-B25 KP1932-4B1	KP24A-62-SS-B25 KP1932-3B1	—
Insulator for Adj. Slip-on Nozzle	1	KP34A KP2023-1	KP34A KP2023-1	KP34A KP2023-1	KP34A KP2023-1
	Bulk	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1
Coarse Thread Nozzle	1	—	—	KP24CT-62-S KP1943-1	KP24CT-75-S KP1943-2
	Bulk	—	—	KP24CT-62-S-B25 KP1943-1B1	KP24CT-75-S-B25 KP1943-2B2
Tip Recessed 1/4" (6.4mm)	1	—	—	KP24CT-62-R KP1943-3	KP24CT-75-R KP1943-4
	Bulk	—	—	KP24CT-62-R-B25 KP1943-3B1	KP24CT-75-R-B25 KP1943-4B1
Insulator for Coarse Thread Nozzle	1	KP34CT KP1946-1	KP34CT KP1946-1	KP34CT KP1946-1	KP34CT KP1946-1
	Bulk	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1
Fixed Nozzles	1	KP23-37 KP1930-1	KP23-50 KP1930-2	KP23-62 KP1930-3	KP23-75 KP1930-4
	Bulk	KP23-37-B25 KP1930-1B1	KP23-50-B25 KP1930-2B1	KP23-62-B25 KP1930-3B1	KP23-75-B25 KP1930-4B1
Tip Recessed	1	KP23T-37 KP1930-5	—	—	—
	Bulk	KP23T-37-B25 KP1930-5B1	—	—	—
Tip Tapered	1	—	—	—	—
	Bulk	—	—	—	—
Heavy Duty	1	—	—	KP23H-62 KP1954-1	KP1954-2
	Bulk	—	—	KP23H-62-B25 KP1954-1B1	—
Tip Flush	1	KP23-37F KP1931-1	KP23-50F KP1931-2	KP23-62F KP1931-3	KP23-75F KP1931-4
	Bulk	KP23-37F-B25 KP1931-1B1	KP23-50F-B25 KP1931-2B1	KP23-62F-B25 KP1931-3B1	KP23-75F-B25 KP1931-4B1

1 = Qty. in pack | Bulk = Qty. of 25 | (1) Requires KP34A, Nozzle Insulator Assembly | (2) Requires KP34CT, Nozzle Insulator Assembly

**STEP**  
**4**

## Consumables Continued...

### Gas Diffuser (300 amps)



Gas Diffuser Assembly

Diffuser	QTY.	WIRE DIAMETER		Part Number Previous Part Number
		.025-.030" (0.6-0.8mm)	.025-5/64" (0.6-2.0mm)	
Gas Diffuser Assembly	1	KP54A KP2024-2	KP54A KP2024-1	
	Bulk	KP54A-B25 <sup>(1)</sup> KP2024-2B1	KP54A-B25 KP2024-1B1	

1 = Qty. in Pack | Bulk = Qty. of 25 | <sup>(1)</sup> Use KP42-25-15 liner with this diffuser when feeding .025"-.030" wire

### Gun Tubes (300 amps)



45° Gun Tube



60° Gun Tube



82° Gun Tube

TUBE	QTY.	RATED (AMPS)	
		300	400
45°	10	KP1929-2 —	KP1929-1 —
	Bulk	— —	— —
60°	10	KP1928-2 —	KP1928-1 —
	Bulk	— —	— —
82°	10	— —	KP1941-1 —
	Bulk	— —	— —

10 = Qty. in pack | Bulk = N/A | **NOTE:** 300 & 400 amp gun tubes can be used with 200 amp guns. Use corresponding amperage gas diffuser, nozzle, and nozzle insulator.

### Cable Liner (300 amps)

LINER	QTY.	DIAMETER		
		.025"–.030" (0.6–.8 mm)	.035"–.045" (0.9–1.2 mm)	Aluminum .035"–3/64" <sup>(2)</sup> (0.9–1.2 mm)
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP42-25-15 <sup>(3)</sup> KP1934-2	KP44-3545-15 KP1933-1	KP44N-3545-15 KP1955-1
	Bulk	KP42-25-15-B10 KP1934-2B1	KP44-3545-15-B10 KP1933-1B1	KP44N-3545-15-B10 KP1955-1B1
26' Length (trim to fit for) - 25' - or less	1	— —	KP44-3545-25 KP1936-1	— —
	Bulk	— —	KP44-3545-25-B10 KP1936-1B1	— —

Part Number  
Previous Part Number



Cable Liner

### Cable Liner (300 amps) Continued

LINER	QTY.	DIAMETER		
		.052"–1/16" (1.3–1.6 mm)	1/16"–5/64" (1.6–2.0 mm)	Aluminum 1/16" <sup>(2)</sup> (1.6 mm)
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP44-116-15 KP1933-2	KP44-564-15 <sup>(1)</sup> KP1933-3	KP44N-116-15 KP1955-2
	Bulk	KP44-116-15-B10 KP1933-2B1	KP44-564-15-B10 KP1933-3B1	— —
26' Length (trim to fit for) - 25' - or less	1	KP44-116-25 KP1936-2	KP44-564-25 KP1936-3	— —
	Bulk	KP44-116-25-B10 KP1936-2B1	KP44-564-25-B10 KP1936-3B1	— —

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> A KP2024-1 Gas Diffuser is required when using a KP44-564-15 Cable Liner in a non-Magnum gun.

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

<sup>(3)</sup> Requires KP54A Gas Diffuser.

**MAGNUM**

**400 Amp**

# EXPRESS™

**MIG Gun**

Ready-Paks®

- Completely Assembled
- Ready to Weld - Right Out of the Box!
- Liner And Other Parts Installed For You!

Ready-Paks® Also Available In Original 400 amp Magnum® Configuration!

EXPRESS™ MIG Gun

- Lightweight, Quick and Agile — All The Muscle Without the Bulk!
- The Pro's Preferred MIG Gun
- 400 amp, Short Neck, 15 ft. Length
- Heavy Duty Expendable Parts

## Industry's Best...

### PRODUCTIVITY

- No assembly, no mistakes.
- Designed to maximize feedability and keep you welding.
- 100% field serviceable.

### EASE-OF-USE

- Interchangeable components and one of the industry's widest array of parts.
- Rotatable goose necks provide easy access to awkward joint locations.
- Can be connected to virtually any feeder in the industry.

### PEACE-OF-MIND

- Engineered to integrate the best features of your welding machine and wire.
- Supported by the industry's largest hands-on sales force.
- Don't be undergunned!

**START WELDING...  
...STOP TINKERING**

**GRAB THE EXPRESS™  
IN THE 400 AMP MAGNUM® READY-PAKS®**

400 AMP EXPRESS™ GUN READY-PAKS® 15 ft. (4.5m) Gun Cable Length.			
Wire Diameter	Gun Connector		
	Lincoln	Miller®	Tweco® Adapted
.035"- .045" (0.6mm-1.2mm)	K541-23 <i>(Includes K466-1 Connector)</i>	K541-21 <i>(Includes K466-3 Connector)</i>	K541-25 <i>(Includes K466-2 Connector)</i>
.052"-1/16" (1.3mm-1.6mm)	K541-24 <i>(Includes K466-8 Connector)</i>	K541-22 <i>(Includes K466-3 Connector)</i>	K541-26 <i>(Includes K466-2 Connector)</i>



STEP  
**2**

# Select a Gun for Your Application

**MAGNUM**  
**400**  
400 amps

With a longer gooseneck and a higher copper strand count cable than the 300, the 400 gun is built for operator comfort when welding with the greater heat levels generated by higher amperage applications. Select the 400 for most .045", .052" or 1/16" MIG, UltraCore™ or Metalshield® (gas-shielded) operations.



Standard



Dual Schedule



Dual Procedure



Short Neck

### Optional Feature Gas Tube Kit

Fast Connect Gas Tube Kit provides connection to Lincoln wire feeders.

Order K481



## Magnum Guns (400 amps)

GUN	CABLE LENGTH	WIRE DIAMETER .035"–.045" (0.6mm–0.9mm)			WIRE DIAMETER .052"–1/16" (1.3mm–1.6mm)			WIRE DIAMETER 1/16"–5/64" (1.6mm–2.0mm)		
		GUN CONNECTOR			GUN CONNECTOR			GUN CONNECTOR		
		Open-End	Fast-Mate	Gun Package	Open-End	Fast-Mate	Gun Package	Open-End	Fast-Mate	Gun Package
Standard	10' (3.0m)	K471-1	K479-1	—	—	—	—	—	—	—
	12' (3.6m)	K471-7	K479-7	—	K471-8	—	—	—	—	—
	15' (4.5m)	K471-2	K479-2	K471-21	K471-4	K479-4	K471-22	K471-6	K479-6	K471-23
	15' (4.5m)	—	—	K2286-1	—	—	—	—	—	—
	20' (6.1m)	K471-10	—	—	K471-11	—	—	—	—	—
	25' (7.6m)	K471-13	—	—	K471-14	—	—	K471-15	—	—
Dual Schedule	15' (4.5m)	K574-1 <sup>(1)</sup>	K575-1 <sup>(1)</sup>	—	K574-2 <sup>(1)</sup>	K575-2 <sup>(1)</sup>	—	—	—	—
	25' (7.6m)	K574-4 <sup>(1)</sup>	—	—	—	—	—	—	—	—
Dual Procedure	15' (4.5m)	K1722-2	K1723-2	—	—	—	—	—	—	—
	25' (7.6m)	K1722-3	K1723-3	—	—	—	—	—	—	—
Short Neck	10' (3.0m)	K541-1	—	—	—	—	—	—	—	—
	15' (4.5m)	K541-3	—	—	—	—	—	—	—	—
	15' (4.5m)	—	—	K541-21	—	—	K541-22	—	—	—
	15' (4.5m)	—	—	K541-23	—	—	K541-24	—	—	—
	15' (4.5m)	—	—	K541-25	—	—	K541-26	—	—	—
<b>Included Parts</b>										
Contact Tip	.035: <b>KP14-35</b> (KP2020-1) .045: <b>KP14-45</b> (KP2020-2) K541-.035: KP14H-35 K541-.045: KP14H-45			.052: <b>KP14-52</b> (KP2020-3) 1/16: <b>KP14-116</b> (KP2020-4) K541-.052: KP14H-52 K541-1/16: KP14H-116			1/16: <b>KP14-116</b> (KP2020-4) 5/64: <b>KP14-564</b> (KP2020-5)			
Gas Diffuser	<b>KP54A</b> (KP2024-1)			<b>KP54A</b> (KP2024-1)			<b>KP54A</b> (KP2024-1)			
Gas Nozzle	<b>KP24A-62</b> (KP1932-1) <b>K541:</b> KP23-62			<b>KP24A-62</b> (KP1932-1) K541: KP23-62			<b>KP24A-62</b> (KP1932-1)			
Insulator	<b>KP34A</b> (KP2023-1) K541: N/A			<b>KP34A</b> (KP2023-1) K541: N/A			<b>KP34A</b> (KP2023-1)			
Cable Liner	10', 12', 15': KP44-3545-15 20', 25': KP44-3545-25			10', 12', 15': KP44-116-15 20', 25': KP44-116-25			10', 12', 15': KP44-564-15 20', 25': KP44-564-25			
Gun Tube (60°)	KP1928-1 Short Neck: KP1928-2			KP1928-1 Short Neck: KP1928-2			KP1928-1 Short Neck: KP1928-2			

**Wire Feeder Connector:**

- Open-End: Feeder end of the gun is open. A separate Gun Connector Kit is required. (See Gun Connector Kit Section).
- Fast-Mate™: Also known as Euro-Connect.

**Gun Packages:**

- K471-x: Includes K466-2 Tweco® Adapted Gun Connector Kit.
- K2286-1: Includes K466-1, LN-25 Gun Connector Kit
- K541-21, 22: Includes K466-3 Miller® Gun Connector Kit
- K541-23: Includes K466-1 Lincoln LN Series Gun Connector Kit (up to .052"/1.4mm diameter)
- K541-24: Includes K466-8 Lincoln LN Series Gun Connector Kit (1/16"/1.6mm & larger diameter)
- K541-25, 26: Includes K466-2 Tweco® Adapted Gun Connector Kit

**Gun Type:**

- Both Dual Schedule and Dual Procedure allow the operator to change procedures at the gun. The Dual Schedule gun uses the trigger as the control and the Dual Procedure gun has a separate switch on top of the gun.

(1) Made to order-contact district office

**STEP**  
**3**

# Choose a Gun Feeder Connector

## Gun Connectors (400 amps)

MFG.	WIRE FEEDER MODEL	CONNECTOR KITS FOR STANDARD GUNS		FASTMATE™ ADAPTER KITS FOR FM GUNS	
		Single Procedure	Dual Procedure/ Dual Schedule	Single Procedure	Dual Procedure/ Dual Schedule
Lincoln	LN-7 Series, LN-742, LN-8, LN-9 Series LN-25 (Up to .052" (1.4 mm) Wire)	K466-1	—	K489-1	—
	LN-7 Series, LN-742, LN-8, LN-9 Series LN-25 (1/16" (1.6 mm) & Larger Wire)	K466-8	—	K489-1	—
	LN-9 with K319 Dual Procedure Kit		See note 1	—	K573-1
	LF-72, LF-74 Series	K466-10	—	—	—
	Power Feed® 10M, LN-10, DH-10, STT-10 LN-15, Power Feed 15M	K466-10	K466-10	K489-7	K489-7
	Power MIG® Series & Wire-Matic™ Series	K466-6	—	K489-8	—
Tweco® Adapted	No. 2, 3 & 4 Guns	K466-2	—	K489-4	—
Miller®	Intellimatic®, Side Kick®, D-51A Porto-MIG®, Millermatic® 130, 300 & 35 (new) S-42GL, S-52A & S-54A Swing Arc®-Dual & Single (new), S-22 S-32S, 52D, 54D & 54E, 60 & 70 Series	K466-3	—	K489-3	—
Hobart®	Dualmatic® 27/70, H3S, H4S & H6S Mega-Conds 27, 44, 45, 70, 70S	K466-4	—	K489-5	—
	2000 Series, 17 Hefty®	K466-7	—	K489-5	—
ESAB®	Digamig®, EH1, 5 & 11, SEH-4 & 5 SWM11 & 11B, 12, 13, 23, 24, 25, 26, 35 VAM2	K466-5	—	—	—

Gun Connector Kits are Included with FM Guns

NOTE 1: LN-9 with K319 Dual Procedure Kit requires K466-8 Gun Connector Kit and K686-3 Adapter Cable for Magnum 400 Dual Procedure Gun

Included Parts	Connector Kits								
	K466-1	K466-2	K466-3	K466-4	K466-5	K466-6	K466-7	K466-8	K466-10
① Connector Assembly	S18645 (a) T7028-234 (b)	S18653 (a) S19762 (b)	S19760 (a) S19761 (b) KP2009-X (c)	S19763 (a) S19765 (b) KP2009-X (c)	S20044	S18653	S18653	S18645-2	S18653
② Control Cable	M15608	—	M16325	M16328	M16520	M16325	—	M15608	M15608
③ Fittings	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	—	—	T10642-166 T14557-7 T13777-4	—
④ Connector Tools	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 (a) S18845 (b)	T11563-4 S18845	T11563-4 S18845	T11563-4 (a) S18845 (B)	T11563-4 S18845	T11563-4 S18845

# Gun Connector Included Parts

**MAGNUM**  
**400**  
 400 amps



K466-1



K466-2



K466-3



K466-4



K466-5



K466-6



K466-7



K466-8



K466-10



K489-1, 2, 3, 4, 5, 7, 8

**STEP**  
**4**

# Choose Your Consumables

## Contact Tips (400 amps)

Part Number  
Previous Part Number

TIP	QTY.	WIRE DIAMETER				
		.025" (0.6mm)	.030" (0.8mm)	.035" (0.9mm)	.040" (1.0mm)	.045" (1.2mm)
Standard Duty	10	KP14-25 KP2020-6B1	KP14-30 KP2020-7B1	KP14-35 KP2020-1B1	KP14-40 KP2020-8B1	KP14-45 KP2020-2B1
	Bulk	KP14-25-B100 KP2020-6B2	KP14-30-B100 KP2020-7B2	KP14-35-B100 KP2020-1B2	KP14-40-B100 KP2020-8B2	KP14-45-B100 KP2020-2B2
Heavy Duty	10	— —	— —	KP14H-35 KP2021-1B1	KP14H-40 KP2021-6B1	KP14H-45 KP2021-2B1
	Bulk	— —	— —	KP14H-35-B100 KP2021-1B2	KP14H-40-B100 KP2021-6B2	KP14H-45-B100 KP2021-2B2
Tapered	10	KP14T-25 KP2022-5B1	KP14T-30 KP2022-6B1	KP14T-35 KP2022-1B1	KP14T-40 KP2022-7B1	KP14T-45 KP2022-2B1
	Bulk	KP14T-25-B100 KP2022-5B2	KP14T-30-B100 KP2022-6B2	KP14T-35-B100 KP2022-1B2	KP14T-40-B100 KP2022-7B2	KP14T-45-B100 KP2022-2B2
Notched (Alum.)	10	— —	KP2010-3B1 <sup>(1)</sup> —	KP2010-4B1 <sup>(1)</sup> —	— —	— —
	Bulk	— —	— —	— —	— —	— —



Standard Duty



Heavy Duty

10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding

## Contact Tips (400 amps) Continued

TIP	QTY.	WIRE DIAMETER					
		3/64" (1.2mm)	3/64A" (1.2mm)	.052" (1.3mm)	1/16" (1.6mm)	1/16"A (1.6mm)	5/64" (2.0mm)
Standard Duty	10	— —	KP14A-364 <sup>(1)</sup> KP2020-9B1	KP14-52 KP2020-3B1	KP14-116 KP2020-4B1	— —	KP14-564 KP2020-5B1
	Bulk	— —	KP14A-364-B100 <sup>(1)</sup> KP2020-9B2	KP14-52-B100 KP2020-3B2	KP14-116-B100 KP2020-4B2	KP14AH-116 <sup>(1)</sup> KP2021-8B1	KP14-564-B100 KP2020-5B2
Heavy Duty	10	KP14AH-364 <sup>(1)</sup> KP2021-7B1	KP14AH-364 <sup>(1)</sup> KP2021-7B1	KP14H-52 KP2021-3B1	KP14H-116 <sup>(1)</sup> KP2021-4B1	KP14AH-116-B100 <sup>(1)</sup> KP2021-8B2	KP14H-564 KP2021-5B1
	Bulk	KP14AH-364-B100 <sup>(1)</sup> KP2021-7B2	KP14AH-364-B100 <sup>(1)</sup> KP2021-7B2	KP14H-52-B100 KP2021-3B2	KP14H-116-B100 KP2021-4B2	— —	KP14H-564-B100 KP2021-5B2
Tapered	10	— —	— —	KP14T-52 KP2022-3B1	KP14T-116 KP2022-4B1	— —	— —
	Bulk	— —	— —	KP14T-52-B100 KP2022-3B2	KP14T-116-B100 KP2022-4B2	— —	— —
Notched (Alum.)	10	KP2010-5B1 <sup>(1)</sup> —	— —	— —	— —	— —	— —
	Bulk	— —	— —	— —	— —	— —	— —



Tapered

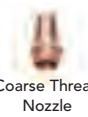
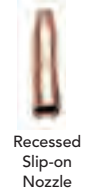


Notched

10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding

**Gas Nozzle/Insulator (400 amps)**

Part Number  
Previous Part Number



NOZZLE	QTY.	NOZZLE DIAMETER			
		.38" (9.5mm)	.50" (12.7mm)	.62" (15.9mm)	.75" (19.1mm)
Adjustable Slip-on <sup>(1)</sup> Nozzle	1	—	KP24A-50 KP1932-2	KP24A-62 KP1932-1	—
	Bulk	—	KP24A-50-B25 KP1932-2B1	KP24A-62-B25 KP1932-1B1	—
Recessed Slip-on <sup>(1)</sup> Nozzle	1	KP24A-37-SS KP1932-5	KP24A-50-SS KP1932-4	KP24A-62-SS KP1932-3	—
	Bulk	KP24A-37-SS-B25 KP1932-5B1	KP24A-50-SS-B25 KP1932-4B1	KP24A-62-SS-B25 KP1932-3B1	—
Adjustable Slip-on Insulator Assembly	1	KP34A KP2023-1	KP34A KP2023-1	KP34A KP2023-1	KP34A KP2023-1
	Bulk	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1	KP34A-B25 KP2023-1B1
Coarse Thread <sup>(2)</sup> Nozzle	1	—	—	KP24CT-62-S KP1943-1	KP24CT-75-S KP1943-2
	Bulk	—	—	KP24CT-62-S-B25 KP1943-1B1	KP24CT-75-S-B25 KP1943-2B2
Tip Recessed 1/8" (3.2mm)	1	—	—	KP24CT-62-R KP1943-3	KP24CT-75-R KP1943-4
	Bulk	—	—	KP24CT-62-R-B25 KP1943-3B1	KP24CT-75-R-B25 KP1943-4B1
Tip Recessed 1/4" (6.4mm)	1	—	—	—	—
	Bulk	—	—	—	—
Insulator for Coarse Thread Nozzle	1	KP34CT KP1946-1	KP34CT KP1946-1	KP34CT KP1946-1	KP34CT KP1946-1
	Bulk	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1	KP34CT-B25 KP1946-1B1
Fixed Nozzles	1	KP23-37 KP1930-1	KP23-50 KP1930-2	KP23-62 KP1930-3	KP23-75 KP1930-4
	Bulk	KP23-37-B25 KP1930-1B1	KP23-50-B25 KP1930-2B1	KP23-62-B25 KP1930-3B1	KP23-75-B25 KP1930-4B1
Tip Recessed	1	KP23T-37 KP1930-5	—	—	—
	Bulk	KP23T-37-B25 KP1930-5B1	—	—	—
Tip Tapered	1	—	—	—	—
	Bulk	—	—	—	—
Heavy Duty	1	—	—	KP23H-62 KP1954-1	KP1954-2
	Bulk	—	—	KP23H-62-B25 KP1954-1B1	—
Tip Flush	1	KP23-37F KP1931-1	KP23-50F KP1931-2	KP23-62F KP1931-3	KP23-75F KP1931-4
	Bulk	KP23-37F-B25 KP1931-1B1	KP23-50F-B25 KP1931-2B1	KP23-62F-B25 KP1931-3B1	KP23-75F-B25 KP1931-4B1

1 = Qty. in pack

Bulk = Qty. of 25

<sup>(1)</sup> Requires KP34A, Nozzle Insulator Assembly

<sup>(2)</sup> Requires KP34CT, Nozzle Insulator Assembly

**STEP**  
**4**

## Consumables Continued...

### Gas Diffuser (400 amps)

Part Number  
Previous Part Number

Diffuser	QTY.	WIRE DIAMETER	
		.025"–.030" (0.6–0.8mm)	.025"–5/64" (0.6–2.0mm)
Gas Diffuser Assembly	1	KP54A KP2024-2	KP54A KP2024-1
	Bulk	KP54A-B25 <sup>(1)</sup> KP2024-2B1	KP54A-B25 KP2024-1B1



Gas Diffuser Assembly

1 = Qty. in Pack | Bulk = Qty. of 25 | <sup>(1)</sup> Use KP42-25-15 liner with this diffuser when feeding .025"-.030" wire

### Gun Tubes (400 amps)

TUBE	QTY.	RATED (AMPS)	
		300	400
45°	10	KP1929-2 —	KP1929-1 —
	Bulk	— —	— —
60°	10	KP1928-2 —	KP1928-1 —
	Bulk	— —	— —
82°	10	— —	KP1941-1 —
	Bulk	— —	— —



45° Gun Tube



60° Gun Tube



82° Gun Tube

10 = Qty. in pack | Bulk = N/A | **NOTE:** 300 & 400 amp gun tubes can be used with 200 amp guns. Use corresponding amperage gas diffuser, nozzle, and nozzle insulator.

### Cable Liner (400 amps)

Part Number  
Previous Part Number

LINER	QTY.	DIAMETER		
		.025"–.030" (0.6–.8 mm)	.035"–.045" (0.9–1.2 mm)	.035"–3/64" <sup>(2)</sup> (0.9–1.2 mm)
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP42-25-15 <sup>(3)</sup> KP1934-2	KP44-3545-15 KP1933-1	KP44N-3545-15 KP1955-1
	Bulk	KP42-25-15-B10 KP1934-2B1	KP44-3545-15-B10 KP1933-1B1	KP44N-3545-15-B10 KP1955-1B1
26' Length (trim to fit for) - 25' - or less	1	— —	KP44-3545-25 KP1936-1	— —
	Bulk	— —	KP44-3545-25-B10 KP1936-1B1	— —



Cable Liner

### Cable Liner (400 amps) Continued

LINER	QTY.	DIAMETER		
		.052"–1/16" (1.3–1.6 mm)	1/16"–5/64" (1.6–2.0 mm)	Aluminum 1/16" <sup>(2)</sup> (1.6 mm)
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP44-116-15 KP1933-2	KP44-564-15 <sup>(1)</sup> KP1933-3	KP44N-116-15 KP1955-2
	Bulk	KP44-116-15-B10 KP1933-2B1	KP44-564-15-B10 KP1933-3B1	— —
26' Length (trim to fit for) - 25' - or less	1	KP44-116-25 KP1936-2	KP44-564-25 KP1936-3	— —
	Bulk	KP44-116-25-B10 KP1936-2B1	KP44-564-25-B10 KP1936-3B1	— —

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> A KP2024-1 Gas Diffuser is required when using a KP44-564-15 Cable Liner in a non-Magnum gun.

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

<sup>(3)</sup> Requires KP54A Gas Diffuser.

**Amperage Rating**

60% Duty Cycle  
CO<sub>2</sub> Shielding Gas  
550 A

**Wire Diameter Range**

.052" - 1/8"  
(1.3 mm - 3.2 mm)

**Net Weight**

12 -23 lbs.  
(5.4 - 10.4 kg)





**STEP**  
**2**

# Select a Gun for Your Application

**MAGNUM**  
**550**  
500 & 600  
amps



Choose our 550 gun equipped with 500 or 600 amp consumables for high amperage, large wire diameter welding, including up to .052" and .062" MIG or 3/32–1/8" Outershield® or UltraCore™ (gas-shielded flux-cored) applications.

## Magnum 550 Gun (500 & 600 amps)

GUN	CABLE LENGTH	WIRE DIAMETER	WIRE DIAMETER		WIRE DIAMETER	
		.035"–.045" (0.9mm–1.2mm)	.052"–1/16" (1.3mm–1.6mm)		5/64"–3/32" (2.0mm–2.4mm)	
		GUN CONNECTOR	GUN CONNECTOR		GUN CONNECTOR	
		600A Open-End	600A Open-End	500A Open-End	600A Open-End	500A Open-End
Standard	10' (3.0m)	—	K598-5	—	—	—
	12' (3.6m)	—	K598-6	—	—	—
	15' (4.5m)	—	K598-7	K598-16	K598-11	K598-17
	25' (7.5m)	K598-4	—	—	—	—
Included Parts						
Contact Tip		.035: <b>KP16S-35</b> (KP2054-1) .045: <b>KP16S-45</b> (KP2054-2)	.052: <b>KP16S-52</b> (KP2054-3) 1/16: <b>KP16S-116</b> (KP2054-4)	.052: KP15H-52 1/16: KP15H-116	5/64: KP16S-564 3/32: KP15S-332	5/64": KP2056-5 3/32": KP2056-6
Gas Diffuser		KP2057-1	<b>KP56S-SW</b> (KP2057-1)	<b>KP55S-SW</b> (KP2058-1)	<b>KP56S-H</b> (KP2057-2)	<b>KP15H-332</b> (KP2058-2)
Coarse Thread Gas Nozzle		M16832-1 .625ID .12REC	M16832-1 .625ID .12REC	<b>KP25CT-62</b> (KP1944-1) .625ID .12REC	M16832-2 .750ID .12REC	<b>KP25-75</b> (KP1944-2) .750ID .12REC
Insulator		<b>KP36CT</b> (KP1946-3)	<b>KP36CT</b> (KP1946-3)	<b>KP35CT</b> (KP1946-2)	<b>KP36CT</b> (KP1946-3)	<b>KP35CT</b> (KP1946-2)
Cable Liner		10', 12', 15': KP45-3545-15 25': KP45-3545-25	10', 12', 15': KP45-116-15 25': KP45-116-25	<b>KP45-116-15</b> (KP1950-3)	KP45H-332-15	KP45H-332-15
Gun Tube 60°		KP1951-1	KP1951-1	KP1951-3	KP1951-2	KP1951-3

Wire Feeder Connector:  
- Open-End: Feeder end of the gun is open. A separate Gun Connector Kit is required. (See Gun Connector Kit Section).



### Optional Feature Magnum 550 Gun Hanger

This rotatable hanger allows you to hang your gun out of harms way at your work station.

Part Number: K620-1



### Optional Feature Gas Tube Kit

Fast Connect Gas Tube Kit provides connection to Lincoln wire feeders.

Order K481

**STEP**  
**3**

# Choose a Gun Connector Magnum 550 (500 & 600 amps)

## Gun Connector/550 Model (500 & 600 amps)

MFG.	WIRE FEEDER MODEL	CONNECTOR KITS FOR STANDARD GUNS
Lincoln	LN-7 Series, LN-8, LN-9 Series (Up to .052" (1.4 mm) Wire)	K613-1
	LN-8, LN-9 Series, (1/16" (1.6 mm) & Larger Wire)	K613-6
	Power Feed® 10M, LN-10, DH-10, STT-10	K613-7
Tweco® Adapted	No. 2, 3 & 4 Guns	K613-2
Miller®	Intellimatic®, Side Kick®, D-51A Porto-MIG®, Millermatic® 130, 300 & 35 (new) S-42GL, S-52A & S-54A Swing Arc®-Dual & Single (new), S-22 S-32S, 52D, 54D & 54E, 60 & 70 Series	K613-3
Hobart®	Dualmatic® 27/70, H3S, H4S & H6S Mega-Conds® 27, 44, 45, 70, 70S	K613-4
	2000 Series, 17 Hefty®	K613-5

Included Parts	K613-1	K613-2	K613-3	K613-4	K613-5	K613-6	K613-7
① Connector Assembly	S18645-1 (a) T7028-234 (b)	S18653-1	S19760-1 (a) S19761-1 (b) KP2095-XX (c)	S19763-1 (a) S19761-1 (b) KP2095-XX (c)	S18653-1 (a)	S18645-3	S18653-1
② Control Cable	M15608	—	M16325	M16328	—	M15608	M15608
③ Fittings	T10642-166 T14557-7 T13777-4	—		T10642-166 (a) T14557-7 (b) T13777-4 (c)	—	T10642-166 (a) T14557-7 (b) T13777-4 (c)	—
④ Connector Tools	T11563-4	T11563-4	T11563-4	T11563-4	T11563-4	T11563-4	T11563-4

# Gun Connector Included Parts

**MAGNUM**  
**550**  
 500 & 600  
 amps



K613-1



K613-2



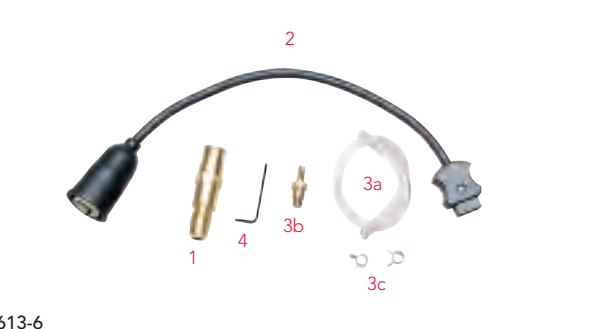
K613-3



K613-4



K613-5



K613-6



K613-7

**STEP**  
**4**

# Choose Your Consumables Magnum 550 (500 amps)

## Contact Tips/550 Model (500 amps)

Part Number  
Previous Part Number

TIP	QTY.	WIRE DIAMETER				
		.035" (0.9mm)	.045" (1.2mm)	3/64" (1.2mm)	.052" (1.3mm)	1/16" (1.6mm)
Flux-Cored, Heavy Duty	10	KP15HFC-35 KP2055-1B1	KP15HFC-45 KP2055-2B1	— —	KP15HFC-52 KP2055-3B1	KP15HFC-116 KP2055-4B1
	Bulk	— —	— —	— —	— —	— —
Solid Wire, Heavy Duty	10	KP15H-35 KP2056-1B1	KP15H-45 KP2056-2B1	KP15AH-364 KP2056-9B1	KP15H-52 KP2056-3B1	KP15H-116 KP2056-4B1
	Bulk	— —	— —	— —	— —	— —

10 = Qty. in pack

Bulk = N/A



Heavy Duty

## Contact Tips/550 Model (500 amps) Continued

TIP	QTY.	WIRE DIAMETER				
		1/16A" (1.6mm)	5/64" (2.0mm)	3/32" (2.4mm)	7/64" (2.8mm)	1/8" (3.2mm)
Flux-Cored, Heavy Duty	10	— —	KP15HFC-564 KP2055-5B1	KP15HFC-332 KP2055-6B1	KP15HFC-764 KP2055-7B1	KP15HFC-18 KP2055-8B1
	Bulk	— —	— —	— —	— —	— —
Solid Wire, Heavy Duty	10	KP15AH-116 KP2056-10B1	KP15H-564 KP2056-5B1	KP15H-332 KP2056-6B1	KP15H-764 KP2056-7B1	KP15H-18 KP2056-8B1
	Bulk	— —	— —	— —	— —	— —

10 = Qty. in pack

Bulk = N/A

### Gas Diffuser/550 Model (500 amps)



Standard



Tip Recessed  
3/32" (2.4mm)



Tip Recessed  
3/16" (4.8mm)



Tip Recessed  
5/8" (15.9mm)

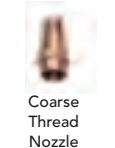
Diffuser	QTY.	WIRE DIAMETER			Part Number Previous Part Number
		.035"–1/16" (0.9–1.6mm)	1/16"–5/64" (1.6–2.0mm)	3/32"–1/8" (2.4–3.2mm)	
Standard	1	KP55SW KP2058-1	KP55 KP2058-2	KP55H KP2058-3	
	Bulk	KP55SW-B10 KP2058-1B1	KP55-B10 KP2058-2B2	KP55H-B10 KP2058-3B1	
Tip Recessed 3/32" (2.4mm)	1	KP55S-SWL <sup>(1)</sup> KP2058-6	—	—	
	Bulk	—	—	—	
Tip Recessed 3/16" (4.8mm)	1	—	—	KP55S-HL <sup>(1)</sup> KP2058-7	
	Bulk	—	—	—	
Tip Recessed 5/8" (15.9mm)	1	KP55S-SW <sup>(1)</sup> KP2058-4	—	KP55S-H <sup>(1)</sup> KP2058-5	
	Bulk	—	—	—	

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> Allows the use of 600 amp KP16 Contact Tips in a 500 amp gun.

### Gas Nozzles/Insulators/550 Model (500 amps)



Coarse  
Thread  
Nozzle



Insulator for  
Coarse  
Thread  
Nozzle

Nozzle/ Insulator	QTY.	NOZZLE DIAMETER		Part Number Previous Part Number
		.62" (15.6mm)	.75" (19.1mm)	
Coarse Thread <sup>(1)</sup> Nozzle	1	KP25CT-62 <sup>(1)</sup> KP1944-1	KP25CT-75 <sup>(1)</sup> KP1944-2	
	Bulk	KP25CT-62-B25 <sup>(1)</sup> KP1944-1B1	KP25CT-75-B25 <sup>(1)</sup> KP1944-2B1	
Insulator for Coarse Thread Nozzle	1	KP35CT KP1946-2	KP35CT KP1946-2	
	Bulk	KP35CT-B25 KP1946-2B1	KP35CT-B25 KP1946-2B1	

1 = Qty. in Pack

Bulk = Qty. of 25

<sup>(1)</sup> Requires KP35CT, Coarse Thread Insulator Assembly.

**STEP**  
**4**

## Consumables Continued...

### Gun Tubes/550 Model (500 amps)



60° Gun Tube  
5° Bend

60° GUN TUBE	QTY.	RATED (AMPS)
		500
5° bend Radius	10	KP1951-3 —
	Bulk	— —

10 = Qty. in pack

Bulk = N/A

### Cable Liner/550 Model (500 amps)



Cable Liner

LINER	QTY.	DIAMETER						Part Number Previous Part Number
		.035"–.045" (0.9–1.2 mm)	Aluminum .035"–3/64" <sup>(1)</sup> (0.9–1.2 mm)	.052"–1/16" (1.3–1.6 mm)	Aluminum 1/16" <sup>(1)</sup> (1.6 mm)	5/64"–3/32" (2.0–2.4 mm)	7/64"–1/8" (2.8–3.2 mm)	
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP45-3545-15 KP1950-1	KP45N-3545-15 KP1950-7	KP45-116-15 KP1950-3	KP45N-116-15 KP1950-8	KP45H-332-15 KP1950-5	KP45-18-15 KP1950-6	
	Bulk	KP45-3545-15-B10 KP1950-1B1	KP45N-3545-15-B10 KP1950-7B1	KP45-116-15-B10 KP1950-3B1	KP45N-116-15-B10 KP1950-8B1	KP45H-332-15-B10 KP1950-5B1	KP45-18-15-B10 KP1950-6B1	
25' Length (trim to fit for) - 25' - or less	1	KP45-3545-25 KP1950-2	— —	KP45-116-25 KP1950-4	— —	— —	— —	
	Bulk	KP45-3545-25-B10 KP1950-2B1	— —	KP45-116-25-B10 KP1950-4B1	— —	— —	— —	

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> For use with aluminum wire. Recommended maximum cable length is 10 ft. (3.0m)

**STEP**  
**4**

# Choose Your Consumables Magnum 550 (600 amps)

**MAGNUM**  
**550**  
600 amps

## Contact Tips (600 amps)

TIP	QTY.	WIRE DIAMETER					Part Number Previous Part Number
		.035" (0.9mm)	.045" (1.2mm)	3/64" (1.2mm)	.052" (1.3mm)	1/16" (1.6mm)	
Heavy Duty	10	KP16S-35 KP2054-1-B1	KP16S-45 KP2054-2B1	KP16AS-364 <sup>(1)</sup> KP2054-9-B1	KP16S-52 KP2054-3B1	KP16S-116 KP2054-4B1	
	Bulk	KP16S-35-B100 KP2054-1B2	KP16S-45-B100 KP2054-2B2	KP16AS-364-B100 <sup>(1)</sup> KP2054-9B2	KP16S-52-B100 KP2054-3B2	KP16S-116-B100 KP2054-4B2	



Heavy Duty

## Contact Tips (600 amps) Continued

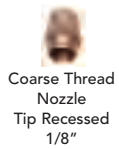
TIP	QTY.	WIRE DIAMETER					Part Number Previous Part Number
		1/16" <sup>(1)</sup> (1.6mm)	5/64" (2.0mm)	3/32" (2.4mm)	7/64" (2.8mm)	1/8" (3.2mm)	
Heavy Duty	10	KP16AS-116 <sup>(1)</sup> KP2054-10B1	KP16S-564 KP2054-5B1	KP16S-332 KP2054-6B1	KP16S-764 KP2054-7B1	KP16S-18 KP2054-8B1	
	Bulk	KP16AS-116-B100 <sup>(1)</sup> KP2054-10B2	KP16S-564-B100 KP2054-5B2	KP16S-332-B100 KP2054-6B2	KP16S-764-B100 KP2054-7B2	KP16S-18-B100 KP2054-8B2	

| 10 = Qty. in pack | Bulk = Qty. of 10 | <sup>(1)</sup> Recommended for aluminum wire welding

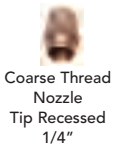
## Gas Nozzle/Insulator (600 amps)

NOZZLE	QTY.	NOZZLE DIAMETER			Part Number Previous Part Number
		.62" (15.9mm)	.75" (19.1mm)	.88" (22.4mm)	
Coarse Thread Nozzle Tip Recessed 1/8"	1	KP26CT-62 <sup>(1)</sup> KP1945-1	KP26CT-75 <sup>(1)</sup> KP1945-2	—	
	Bulk	KP26CT-62-B25 <sup>(1)</sup> KP1945-1B1	KP26CT-75-B25 <sup>(1)</sup> KP1945-2B1	—	
Coarse Thread Nozzle Tip Recessed 1/4"	1	KP26CT-62-R <sup>(1)</sup> KP1945-3	KP26CT-75-R <sup>(1)</sup> KP1945-4	—	
	Bulk	—	KP26CT-75-R-B25 <sup>(1)</sup> KP1945-4B1	—	
Insulator for Coarse Thread Nozzle	1	KP36CT KP1946-3	KP36CT KP1946-3	KP36CT KP1946-3	
	Bulk	KP36CT-B25 KP1946-3B1	KP36CT-B25 KP1946-3B1	KP36CT-B25 KP1946-3B1	
Self-Insulated Gas Nozzle Tip Recessed 1/8"	1	KP1949-4 —	KP1949-5 —	KP1949-6 —	
	Bulk	—	—	—	
Self Insulated Gas Nozzle 1/4"	1	KP26I-62 KP1949-1	KP26I-75 KP1949-2	KP26I-87 KP1949-3	
	Bulk	KP26I-62-B25 KP1949-1B1	KP26I-75-B25 KP1949-2B1	KP26I-87-B25 KP1949-3B1	

| 1 = Qty. in pack | Bulk = Qty. of 25 | <sup>(1)</sup> Requires KP36CT, Coarse Thread Insulator Assembly



Coarse Thread Nozzle  
Tip Recessed 1/8"



Coarse Thread Nozzle  
Tip Recessed 1/4"



Insulator for Coarse Thread Nozzle



Self Insulated Gas Nozzle 1/8"



Self Insulated Gas Nozzle 1/4"

**STEP**  
**4**

## Consumables Continued...

### Gas Diffuser (600 amps)

Part Number  
Previous Part Number

Diffuser	QTY.	WIRE DIAMETER	
		.035"-.1/16" (0.9-1.6mm)	5/64"-.1/8" (2.0-3.2mm)
Gas Diffuser Assembly	1	KP56S-SW KP2057-1	KP56S-H KP2057-2
	Bulk	KP56S-SW-B10 KP2057-1B1	KP56S-H-B10 KP2057-2B1



Gas Diffuser Assembly

10 = Qty. in Pack | Bulk = Qty. of 10

### Gun Tubes (600 amps)

60° GUN TUBE	QTY.	RATED (AMPS)	
		600	
3° Bend Radius	1	KP1951-1	
	Bulk	—	
5° Bend Radius	1	KP1951-2	
	Bulk	—	



60° Gun Tube 3° Bend



60° Gun Tube 5° Bend

1 = Qty. in pack | Bulk = N/A

### Cable Liner (600 amps)

Part Number  
Previous Part Number

LINER	QTY.	DIAMETER					
		.035"-.045" (0.9-1.2 mm)	Aluminum .035"-.3/64" <sup>(1)</sup> (0.9-1.2 mm)	.052"-.1/16" (1.3-1.6 mm)	Aluminum 1/16" <sup>(1)</sup> (1.6 mm)	5/64"-.3/32" (2.0-2.4 mm)	7/64"-.1/8" (2.8-3.2 mm)
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP45-3545-15 KP1950-1	KP45N-3545-15 KP1950-7	KP45-116-15 KP1950-3	KP45N-116-15 KP1950-8	KP45H-332-15 KP1950-5	KP45-18-15 KP1950-6
	Bulk	KP45-3545-15-B10 KP1950-1B1	KP45N-3545-15-B10 KP1950-7B1	KP45-116-15-B10 KP1950-3B1	KP45N-116-15-B10 KP1950-8B1	KP45H-332-15-B10 KP1950-5B1	KP45-18-15-B10 KP1950-6B1
25' Length (trim to fit for) - 25' - or less	1	KP45-3545-25 KP1950-2	— —	KP45-116-25 KP1950-4	— —	— —	— —
	Bulk	KP45-3545-25-B10 KP1950-2B1	— —	KP45-116-25-B10 KP1950-4B1	— —	— —	— —



Cable Liner

1 = Qty. in Pack | Bulk = Qty. of 10 | <sup>(1)</sup> For use with aluminum wire welding. Recommended maximum cable length is 10 ft. (3.0m)





LINCOLN  
ELECTRIC



LINCOLN  
ELECTRIC

TILMAN

LINCOLN  
ELECTRIC  
THE WELDING EXPERTS<sup>SM</sup>

**Amperage Rating**

60% Duty Cycle  
CO<sub>2</sub> Shielding Gas  
100 A

**Wire Diameter Range**

.025" - .045"  
(0.6 mm - 1.2 mm)

**Net Weight**

9 - 12 lbs.  
(4.0 - 5.4 kg)



STEP  
**2**

# Select a Gun for your application

**MAGNUM.**  
**100L**  
100 amps



Extremely small, lightweight gun that's great for most home, farm and small shop projects, auto-body work and light maintenance or repair applications. Standard equipment on current Lincoln SP-135T and SP-175T, Power MIG® 140T, 140C, 180T and 180C. Includes gun connector.

## Magnum Guns (100 amps)

GUN	CABLE LENGTH	WIRE DIAMETER	
		.025"–.035" (0.6mm–0.9mm)	.035"–.045" (0.9mm–1.2mm)
MIG (GMAW)	10' (3.0m)	K530-5 K530-6	— —
Innershield® (FCAW)	10' (3.0m)	—	K530-3
Included Parts			
Contact Tip		.025: <b>KP11-25</b> (KP2039-1B1)	.035: <b>KP11-35</b> (KP2039-3B1)
Gas Diffuser		<b>KP35-50</b> (KP2040-1)	N/A
Gas Nozzle		<b>KP21T-37</b> (KP1942-1)	Gasless: KP1939-1
Insulator		N/A	N/A
Cable Liner		KP1937-3	<b>KP45-40-15</b> (KP1937-1)
Gun Tube 60°		KP2038-1	KP2038-1



MIG



Innershield®

**STEP**  
**3**

# Choose Your Consumables

## Contact Tips (100 amps)

Part Number  
Previous Part Number

TIP	QTY.	WIRE DIAMETER				
		.025" (0.6mm)	.030" (0.8mm)	.035" (0.9mm)	Aluminum .035" (0.9mm)	.045" (1.2mm)
Standard Duty	10	KP11-25 KP2039-1B1	KP11-30 KP2039-2B1	KP11-35 KP2039-3B1	KP2078-1B1 KP2078-1B2	KP11-45 KP2039-4B1
	Bulk	KP11-25-B100 KP2039-1B2	KP11-30-B100 KP2039-2B2	KP11-35-B100 KP2039-3B2	KP2078-1B1 KP2078-1B2	KP11-45-B100 KP2039-4B2
Tapered	10	KP11T-23 KP2052-1B1	KP11T-30 KP2052-2B1	KP11T-35 KP2052-3B1	— —	KP11T-45 KP2052-4B1
	Bulk	— —	— —	— —	— —	— —



Standard Duty



Tapered

10 = Qty. in Pack | Bulk = Qty. of 100

## Gas Diffuser (100 amps)

Part Number  
Previous Part Number

Diffuser	QTY.	WIRE DIAMETER
Gas Diffuser Assembly	1	.025"-.045" (0.6-1.2mm)  KP35-50 KP2040-1
	Bulk	— —



Gas Diffuser Assembly

1 = Qty. in Pack | Bulk N/A

## Gas Nozzle/Insulator (100 amps)

Part Number  
Previous Part Number

NOZZLE	QTY.	NOZZLE DIAMETER		
		.37" (9.4mm)	.50" (12.7mm)	.625" (15.9mm)
Fixed Gas Nozzle	1	KP21-50-F KP1938-1	— —	— —
Tip Flush	Bulk	— —	— —	— —
Tip Recessed		KP21T-37 KP1942-1	KP21T-50 KP1942-2	KP21T-62 KP1942-3
		— —	— —	— —
Gasless Nozzle	1	KP1939-1 —	— —	— —
	Bulk	— —	— —	— —
Spot Nozzle	1	— —	— —	KP21-62-FAS KP1956-1
	Bulk	— —	— —	— —



Fixed Gas Nozzle



Gasless Nozzle



Spot Nozzle

1 = Qty. in pack | Bulk = N/A

**Cable Liner (100 amps)**



Cable Liner

Part Number  
Previous Part Number

LINER	QTY.	DIAMETER		
		.025"–.035" (0.6–0.9 mm)	Aluminum .035" <sup>(1)</sup> (0.9mm)	.035"–.045" (0.9–1.2 mm)
15' Length (trim to fit for)	1	KP1937-3	KP1959-1 <sup>(1)</sup>	KP45-40-15 KP1937-1
- 10' - - 12' - - 15' -	Bulk	KP1937-3B1	—	KP45-40-15-B10 KP1937-1B1

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> Recommended for aluminum wire welding.  
Recommended maximum cable length for aluminum is 10 ft. (3.0m).

**Amperage Rating**

60% Duty Cycle  
CO<sub>2</sub> Shielding Gas  
250 A

**Wire Diameter Range**

.025" - .045"  
(0.6 mm - 1.2 mm)

**Net Weight**

8 lbs.  
(3.6 kg)



STEP  
**2**

# Select a Gun for your application

**MAGNUM.**  
**250L**  
250 amps



Recommended for medium duty job shop and production applications. Standard equipment on the current Lincoln Power MIG 215 and Power MIG® 255C wire feeder/welders. Includes gun connector.

## Magnum Guns (250 amps)

GUN	CABLE LENGTH	WIRE DIAMETER
		.035"–.045" (0.9mm–1.2mm)
250L Adjustable Gas Nozzle	10' (3.0m)	—
	15' (4.5m)	K533-3
Fixed Gas Nozzle	12' (3.6m)	K533-7
250SP Fixed Gas Nozzle	12.5' (3.8m)	K524-5



250L  
Adjustable  
Gas Nozzle



K524-5

### Included Parts

Contact Tip	.035: <b>KP14-35</b> (KP2020-1)
Gas Diffuser	<b>KP52FN</b> (KP2026-3)
Gas Nozzle	Adjustable: <b>KP22-50</b> (KP1935-2) Fixed: KP23-50F (KP1931-2)
Insulator	Adjustable: <b>KP32</b> (KP2025-1) Fixed: N/A
Cable Liner	<b>KP42-4045-15</b> (KP1934-1)
Gun Tube (60°)	KP2015-1

**STEP**  
**3**

# Choose Your Consumables

## Contact Tips (250 amps)

Part Number  
Previous Part Number

TIP	QTY.	WIRE DIAMETER					
		.025" (0.6mm)	.030" (0.8mm)	.035" (0.9mm)	.040" (1.0mm)	.045" (1.2mm)	Aluminum 3/64" (1.2mm)
Standard Duty	10	KP14-25 KP2020-6B1	KP14-30 KP2020-7B1	KP14-35 KP2020-1B1	KP14-40 KP2020-8B1	KP14-45 KP2020-2B1	KP14A-364 <sup>(1)</sup> KP2020-9B1
	Bulk	KP14-25-B100 KP2020-6B2	KP14-30-B100 KP2020-7B2	KP14-35-B100 KP2020-1B2	KP14-40-B100 KP2020-8B2	KP14-45-B100 KP2020-2B2	KP14A-364-B100 KP2020-9B2
Heavy Duty	10	—	—	KP14H-35 KP2021-1B1	KP14H-40 KP2021-6B1	KP14H-45 KP2021-2B1	KP14AH-364 <sup>(1)</sup> KP2021-7B1
	Bulk	—	—	KP14H-35-B100 KP2021-1B2	KP14H-40-B100 KP2021-6B2	KP14H-45-B100 KP2021-2B2	KP14AH-364-B100 KP2021-7B2
Tapered	10	KP14T-25 KP2022-5B1	KP14T-30 KP2022-6B1	KP14T-35 KP2022-1B1	KP14T-40 KP2022-7B1	KP14T-45 KP2022-2B1	—
	Bulk	KP14T-25-B100 KP2022-5B2	KP14T-30-B100 KP2022-6B2	KP14T-35-B100 KP2022-1B2	KP14T-40-B100 KP2022-7B2	KP14T-45-B100 KP2022-2B2	—
Notched	10	—	KP2010-3B1 <sup>(1)</sup>	KP2010-4B1 <sup>(1)</sup>	—	—	KP2010-5B1 <sup>(1)</sup>
	Bulk	—	—	—	—	—	—

10 = Qty. in Pack | Bulk = Qty. of 100 | <sup>(1)</sup> Recommended for aluminum wire welding



Standard Duty



Heavy Duty



Tapered



Notched

## Gas Nozzle/Insulator (250 amps)

Part Number  
Previous Part Number

NOZZLE	QTY.	NOZZLE DIAMETER		
		.38" (9.5mm)	.50" (12.7mm)	.62" (15.9mm)
Adjustable Slip-on <sup>(1)</sup> Nozzle	1	KP22-37 KP1935-3	KP22-50 KP1935-2	KP22-62 KP1935-1
	Bulk	KP22-37-B25 KP1935-3B1	KP22-50-B25 KP1935-2B1	KP22-62-B25 KP1935-1B1
Insulator for Adj. Slip-on Nozzle	1	KP32 KP2025-1	KP32 KP2025-1	KP32 KP2025-1
	Bulk	KP32-B25 KP2025-1B1	KP32-B25 KP2025-1B1	KP32-B25 KP2025-1B1
Gasless Nozzle	1	KP1947-1	KP1947-1	KP1947-1
	Bulk	—	—	—
Spot Nozzle	1	KP21-62-FAS KP1956-1	KP21-62-FAS KP1956-1	KP21-62-FAS KP1956-1
	Bulk	—	—	—

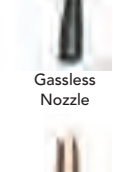
1 = Qty. in pack | Bulk = Qty. OF 25 | <sup>(1)</sup> Requires KP32 (KP2025-1), Nozzle Insulator Assembly



Adjustable Slip-on Nozzle



Insulator for Adjustable Slip-on Nozzle



Gasless Nozzle



Spot Nozzle



### Gas Diffuser (250 amps)



Adjustable Slip-on Nozzle



Fixed Nozzle



Specialty

Diffuser	QTY.	WIRE DIAMETER		
		.025-.030" (0.6-0.8mm)	.035-.045" (.09-1.2mm)	.025-.045" (0.6-1.2mm)
Adjustable Slip-on Nozzle	1	KP52-25 KP2026-2	KP52 KP2026-1	— —
	Bulk	KP52-25-B25 KP2026-2B1	KP52-B25 KP2026-1B1	— —
For Fixed Nozzles	1	KP2051-1 —	KP52PN KP2026-3	KP52FN KP2026-3
	Bulk	— —	— —	KP52FN-B25 KP2026-3B1
Specialty	1	KP2051-1 —	KP2026-3 —	KP2051-1 <sup>(1)</sup> —
	Bulk	— —	— —	KP2051-1B1 —

Part Number  
Previous Part Number

1 = Qty. in Pack | Bulk = Qty. of 25 | (1) Permits use of 100 amp Contact Tips and Nozzles with Magnum 250L Gun Tube

### Gun Tubes (250 amps)



45° Gun Tube



60° Hard Cover



82° Rubber Cover

TUBE	QTY.	RATED (AMPS)
		250
45°	1	KP2041-1 —
	Bulk	— —
60° Hard Cover	1	KP2015-1 —
	Bulk	— —
80° Rubber Cover	1	KP2111-1 —
	Bulk	— —

1 = Qty. in pack | Bulk = N/A | **NOTE:** 300 & 400 amp gun tubes can be used with 200 amp guns. Use corresponding amperage gas diffuser, nozzle, and nozzle insulator.

**STEP**  
**3**

**Consumables Continued...**



<b>Cable Liner (250 amps)</b>						
LINER	QTY.	DIAMETER				Part Number Previous Part Number
		.025"–.030" (0.6–0.8 mm)	.030"–.035" (0.8–0.9 mm)	.035"–.045" (0.9–1.2 mm)	Aluminum .035"–.3/64" <sup>(1)</sup> (0.9–1.2 mm)	
15' Length (trim to fit for) - 10' - - 12' - - 15' -	1	KP42-25-15 KP1934-2	KP42-3035-15 KP1934-3	KP42-4045-15 KP1934-1	KP44N-3545-15 <sup>(1)</sup> KP1955-1	
	Bulk	KP42-25-15-B10 KP1934-2B1	KP42-3035-15-B10 KP1934-3B1	KP42-4045-15-B10 KP1934-1B1	KP44N-3545-15-B10 KP1955-1B1	

1 = Qty. in Pack

Bulk = Qty. of 10

<sup>(1)</sup> Recommended for Aluminum wire welding.  
Recommended maximum cable length for aluminum is 10 ft. (3.0m).

## Recommended Replacement Guns

MACHINE	GUN	PART NUMBER
<b>Commercial/Light Industrial Wire Feed Welders</b>		
Power MIG 140C/140T	Magnum 100L	K530-6
Power MIG 180C/180T	Magnum 100L	K530-6
Power MIG 200	Magnum 250L	K533-7
Power MIG 215	Magnum 250L	K533-7
Power MIG 255	Magnum 250L	K533-7
Power MIG 255C	Magnum 250L	K533-7
Power MIG 300	Magnum 300	K470-2
Power MIG 350MP	Magnum 300	K470-2
SP-100	Magnum 100L	K530-5
SP-100-I	Magnum 100L	K530-5
SP-100-T	Magnum 100L	K530-5
SP-125 Plus	Magnum 100L	K530-5
SP-130-T	Magnum 100L	K530-5
SP-135 Plus	Magnum 100L	K530-5
SP-135T	Magnum 100L	K530-5
SP-140-I	Magnum 100L	K530-5
SP-150	Magnum SP-150	K1879-1
SP-170	Magnum 100L	K530-5
SP-170-I	Magnum 100L	K530-5
SP-170T	Magnum 100L	K530-5
SP-175 Plus	Magnum 100L	K530-5
SP-175T	Magnum 100L	K530-5
SP-200	Magnum 200	K497-2
SP-250	Magnum 250SP	K524-5
SP-255	Magnum 250SP	K524-5
Wirematic 250	Magnum 250L	K533-7
Wirematic 255	Magnum 250L	K533-7
<b>Retail Wire Feed Welders</b>		
Handy Core	Non-Magnum	S2553211
Handy MIG (Early Design)	Non-Magnum	S25351-11
Handy Core (Current Design)	Non-Magnum	S25695-11
Handy Core 100	Non-Magnum	S24355-16
Handy Core 170i	Magnum 100L	K530-5
MIG Pak 10	Magnum 100L	K530-5
MIG Pak 15	Magnum 100L	K530-5
MIG Pak HD	Non-Magnum	S2565-11
Pro 100	Magnum 100L	K530-5
Pro 155	Magnum 100L	K530-5
Pro-Core 100	Magnum 100L	K530-3
Pro-MIG 135	Magnum 100L	K530-5
Pro-MIG 175	Magnum 250L	K524-5
Quick Weld	Non-Magnum	S25532-11
Weldmark 135 Plus	Magnum 100L	K530-5
Weld-Pak 100	Magnum 100L	K530-3
Weld-Pak 100HD	Magnum 100L	K530-3
Weld-Pak 125	Magnum 100L	K530-3
Weld-Pak 155	Magnum 100L	K530-3
Weld-Pak 3200HD	Magnum 100L	K530-3
Weld-Pak 5000HD	Magnum 100L	K530-3
Weld-Pak HD	Non-Magnum	S25532-11



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