

# NEW! LN-15 Wire Feeder

## Portable, Semiautomatic Wire Feeder

The LN-15 is one of the smallest and most maneuverable wire feeders for the construction, shipbuilding and pipeline industries available on the market today. Through the use of a high temperature, abrasion resistant plastic case, aluminum alloy roll cage and fully encapsulated PC boards, the LN-15 is perhaps the most rugged portable wire feeder in the world.

The LN-15 is available in both Across-The-Arc and Control Cable versions. Both offer outstanding welding performance, including pulse welding, on a wide variety of steel, stainless steel, aluminum and alloy materials.



## Processes

MIG Pulsed MIG Flux-Cored  
STT (Control Cable Model Only)

## Advantage Lincoln

- Both models are designed for MIG, Pulsed MIG, Flux-Cored and Metal-Cored welding processes using lightweight 8" diameter spools. The Control Cable version is also designed for the STT (Surface Tension Transfer) process.
- Rugged patented wire drive system easily feeds .023"-.052" solid and .035"-5/64" cored wires.
- Illuminated digital meters are easy to read in adverse lighting conditions.
- Fully enclosed molded case is heat, spatter and impact resistant.
- Double latch case seals tight to protect drive system and wire from dirt, dust and rain.
- Full body aluminum roll cage provides sturdy impact protection and all-around handles for easy portability.
- Adjustable carrying strap makes it easy to carry and hang.
- Compact unit fits easily through 14" diameter manhole/manway.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Three year warranty on parts and labor.

## Description



## Unit Includes

- K1500-2 Gun Receiver Bushing.
- Carrying Strap.
- Spindle Adapter for 8" O.D. Spools.
- Standard contactor with Across-The-Arc model.

## Required Options

Magnum Gun and Cable Assembly, Drive Roll Kit, Separate Control Cable -10 ft. (Control Cable Model only)

## Recommended Options

Gun Receiver Bushing, 14-Pin Control Cable Extension (25 ft. or 50 ft.), Terminal Strip Adapter Cable, Weld Power Cable

## Recommended Power Source Options

Ranger 8, Ranger 9, Ranger 250, Ranger 305G, Ranger 300 DLX, Commander 300, Commander 500, SAE-400, CV-250, CV-300, CV-400, CV-655, V350-PRO, DC-400, DC-600, DC-655, Invertec STT II

## Order

K1870-1 LN-15 Wire Feeder – Across-The-Arc  
K1871-1 LN-15 Wire Feeder – Control Cable

## Technical Specifications

Product Name	Product Number	Input Power	Rated Output Current / Duty Cycle	Wire Feed Speed Range ipm (m/min)	Wire Size Range in (mm)		Dimensions H x W x D inches (mm)	Net Weight lbs. (kg)
					Solid	Cored		
LN-15 Across-the-Arc	K1870-1	15-110 VDC	300A / 60%	50-700 (1.3-17.8)	.023-.052 (0.6-1.3)	.035-5/64 (0.9-2.0)	12.7 x 8.7 x 23 (356 x 188 x 533)	30 (15.4)
LN-15 Control Cable	K1871-1	42 VAC	500A / 60%					28 (12.7)

# Advantage Lincoln

## EASY TO MOVE

### Compact

Revolutionary design fits easily through 14" diameter manway.



**Lightweight!  
Weighs only  
30 lbs!**

### Easy to Carry or Hang

Adjustable carrying strap for easy hanging at the job site or carrying over the shoulder.



## EASY TO USE

### Easy to set-up

Illuminated digital meters for easy readability in dark conditions or bright sunlight. Large knobs for easy handling – even with gloved hands.



### Easy to adjust

Adjustable flow meter to set, change and monitor gas flow.



Internally mounted cold feed/gas purge switch saves gas, prevents electrical shock, and purges the line.

### Easy to weld

Dual schedule Magnum® 400 guns allow for out-of-position welding by reducing wire feed speed by 17% for welding overhead.

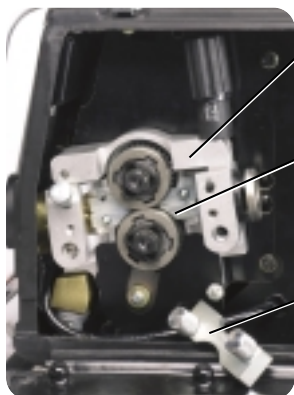
### Easy to monitor

"Hold Last State" feature displays wire feed speed voltage for five seconds after welding has stopped.

### Easy to update

Spindle clamp can be attached or removed with one hand.

## Patented Wire Drive System



Drive rolls flip up for easy access.

Entire wire path is visible for easy access.

Removable outer wire guide for easy access to wire.

- Two gear driven rolls – Each roll has two grooves of the same size to double feed life. No tools needed to snap rolls on or off.
- Revolutionary split wire guide precisely aligns and supports wire through the entire system. Maximizes support and minimizes feeding problems.
- Two piece split wire guide construction provides easy access for inspection, cleaning or changing to different wire sizes.
- Gun receiver bushings provide connectivity to Magnum or competitive guns. Easier interchangeability, better mechanical support and electrical current transfer.
- Input ball bearing bushings protect wire from damage.

**Heavy Duty Cast Aluminum  
Wire Drive System**

# Advantage Lincoln

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## RUGGED

### Strong

Sturdy aluminum roll cage protects feeder from damage.

### Durable

Fully enclosed molded case is heat, spatter, and impact resistant.

### Protected

Fully encapsulated "potted and trayed" PC Boards protect internal systems from heat and humidity.



**3 Year  
Warranty!**



**ISO 9001 certified for quality and customer satisfaction. Designed to IE C60974 - 5, CE and CSA standards. Meets IP23S environmental rating.**

## A Closer Look

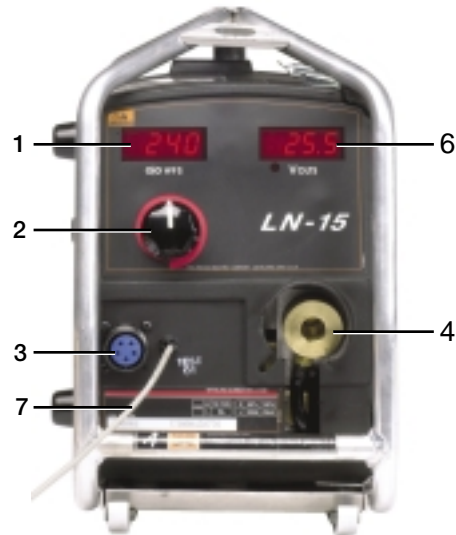
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### Control Cable Model (K1871-1)

Connect a Control Cable (K1819-10) and the electrode welding cable between the power source and the feeder. Features wire feed speed and voltage control on the front of the unit.

### Across-The-Arc Model (K1870-1)

Operates across the arc with a DC power source supplying between 15 VDC and 110 VDC. Simply connect the voltage sense lead to the work, then connect the LN-15 to the electrode cable.



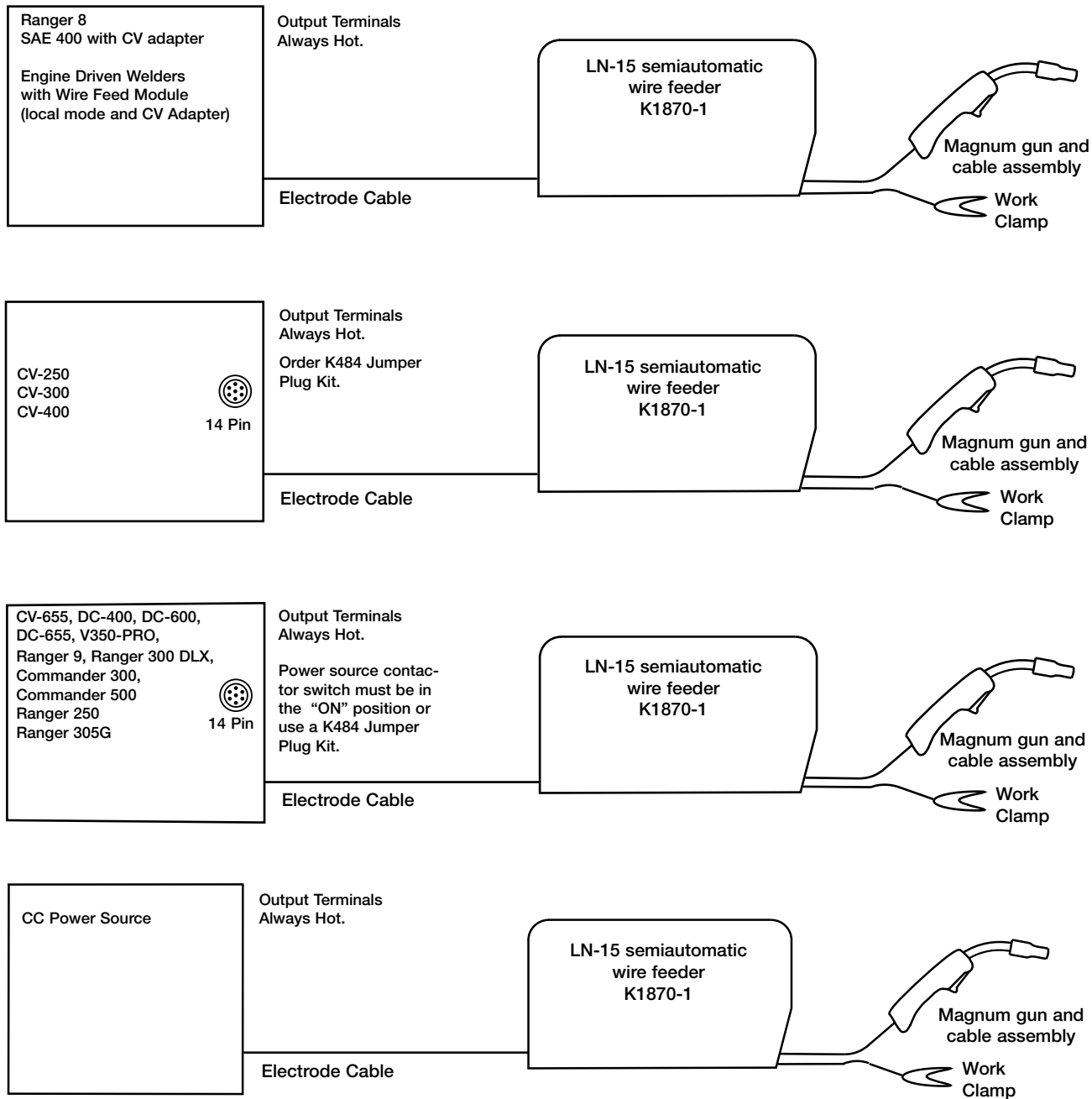
1. Digital Wire Feed Speed Meter
2. Wire Speed Control Knob

3. 5-pin Gun Connection
4. Gun Connection
5. Voltage Control Knob (Control Cable Model Only)

6. Digital Voltage Meter
7. Sensing Lead (Across-The-Arc Model Only)

# Across-The-Arc Set-Up

Typically used for general fabrication, maintenance and repair jobs because it's easy to set up and operate. Requires only one electrical cable to the feeder – less to carry. Internal contactor standard on Across-The-Arc model.

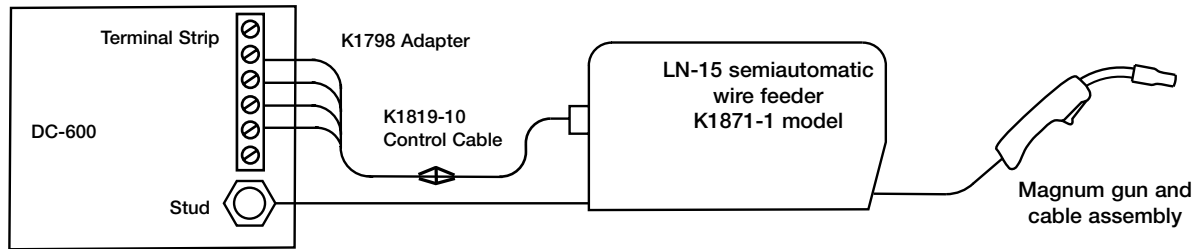
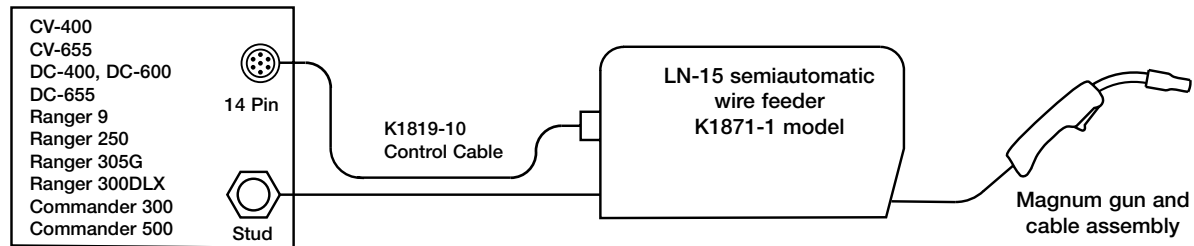
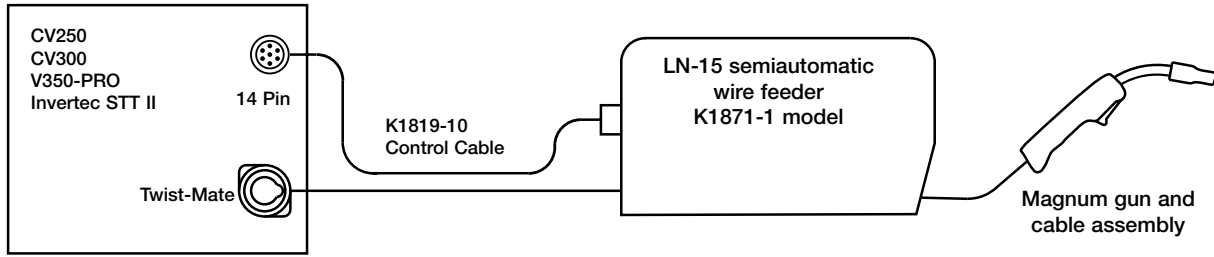


**NOTE:**

A constant voltage (CV) power source is recommended for steel flux-cored arc welding (FCAW) and gas metal arc welding (GMAW) to obtain code quality results. The LN-15 may be used with a constant current (CC) power source for non critical applications where weld quality and deposition properties are not critical.

# Control Cable Set-Up

Typically used for work on ships, buildings, bridges and pipelines where precision and quality are critical. Wire feed and voltage adjustment are done at the feeder for convenience at the job site.



**NOTE:**

For applications requiring cable lengths greater than 10 ft., use control cable extension K1797-25 or K1797-50.

# Gun Receiver Bushings

## Feed Plate Gun Receiver Bushings

K1500-1 Gun Receiver Bushing (Optional)	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)
<ul style="list-style-type: none"> <li>Magnum 200, 300 and 400 gun and cable assemblies with K466-1 connector kit.</li> <li>Lincoln Innershield gun and cable assembly.</li> <li>Fast-Mate™ gun and cable assembly, with K489-2 Fast Mate Adapter Kit.</li> <li>Magnum 550 gun and cable assembly with K613-1 connector kit.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum 200 and 400 fully assembled guns (K497-2x and K471-2x), see below.</li> <li>Magnum 200, 300 and 400 gun and cable assemblies with K466-10 connector kit.</li> <li>Guns with Tweco #2, #3, and #4 connectors.</li> </ul>	<ul style="list-style-type: none"> <li>Magnum 550 gun and cable assembly with K613-7 connection.</li> <li>Guns with Tweco #5 connectors.</li> </ul>

K1500-1 Gun Receiver Bushing (Optional)



K1500-2 Gun Receiver Bushing (Standard)



K1500-3 Gun Receiver Bushing (Optional)



## Drive Roll & Wire Guide Kits

## Weld Power Cables

### Drive Roll & Wire Guide Kits

<b>Steel Wire Sizes (includes stainless steel):</b>	
.023-.030" (0.6-0.8mm)	KP1696-030S
.035" (0.9mm) solid	KP1696-035S
.040-.045" (1.0-1.2mm)	KP1696-045S
.052" (1.4mm)	KP1696-052S
<b>Cored Wire Sizes:</b>	
.030-.035" (0.8-0.9mm)	KP1697-035C
.040-.045" (1.0-1.2mm)	KP1697-045C
.052" (1.4mm)	KP1697-052C
1/16" (1.6mm)	KP1697-1/16C
.068" (1.7mm)	KP1697-068
5/64" (2.0mm)	KP1697-5/64
<b>Aluminum Wire Sizes:</b>	
.035" (0.9mm)	KP1695-035A
.040" (1.0mm)	KP1695-040A
3/64" (1.2mm)	KP1695-3/64A

### Weld Power Cables

<b>Twist-Mate to Lug:</b>	
1/0, 350A, 60% duty cycle, 10 ft.	K1840-10
<b>Twist-Mate to Twist-Mate:</b>	
1/0, 350A, 60% duty cycle, 25 ft.	K1841-25
2/0, 350A, 60% duty cycle, 50 ft.	K1841-50
<b>Lug to Lug:</b>	
3/0, 600A, 60% duty cycle, 10 ft.	K1842-10
3/0, 600A, 60% duty cycle, 35 ft.	K1842-35
3/0, 600A, 60% duty cycle, 60 ft.	K1842-60
4/0, 600A, 60% duty cycle, 110 ft.	K1842-110

## Options



### Magnum® Gas-Shielded Gun & Cable Assemblies

Available 200-550 amps, air-cooled, gas-shielded welding guns. Dual procedure capability with gun trigger lock available on 400 amp gun.  
**See Publication E12.10.**



### Magnum® Self-Shielded Gun & Cable Assemblies

Available 250-600 amps.  
**See Publication E12.110.**

### Control Cable

8-pin female to 14-pin male, 10 ft. (3.0m) long, control cable. (For Control Cable Model Only.)  
**Order K1819-10.**

### 14 -Pin Control Cable Extension

14-pin female to 14-pin male cable used with a K1819-10 control cable when applications require longer distances between the power source and wire feeder.  
For 25 ft. (7.6m)  
**Order K1797-25.**  
For 50 ft. (15.2m)  
**Order K1797-50.**



### Spindle Adapter for 8" O.D. Spools

Included with unit. For small spools. Permits 8" (200mm) O.D. spools to be mounted on 2" (50mm) O.D. spindles.  
**Order K468.**

### Terminal Strip Adapter Cable

Adapter cable for 14-pin control cable to terminal power sources.  
**Order K1798.**



*The rugged, lightweight LN-15 wire feeder is especially suited for the shipbuilding and construction industries.*

