

LN-23P WIRE FEEDER

LN-23P utilizes 14 lb (6.3 kg) coils, making it extremely portable and lightweight. It is ideal for reaching difficult locations, and allows for quick setup, thus reducing labor costs. The LN-23P is designed for feeding .068 through 5/64" (1.7 through 2.0 mm) diameter Innershield® electrode.

Innershield self-shielded, flux cored electrodes permit all-position welding on carbon and some low alloy steels. When used in combination with the LN-23P, these electrodes are excellent for welding on: pipelines and piping, field erection, maintenance and production.

The LN-23P is designed for constant voltage (CV) DC power sources. It has a calibrated wire speed range of 30-170 in./min (.76 - 4.3 m/min) with quick and easy setting of the wire feed and power source voltage control at the LN-23P. The wire feed speed is not affected by the change in arc voltage.

A gun-mounted two-position switch allows for a reduced speed to 83% of the preset speed. This two-speed capability is an advantage for such applications as pipe welding and other joints that require root pass adjustment. Two LN-23Ps may be operated from a single power source, allowing four procedures for such applications as root, hot, fill and cap passes on pipe. Only one wire feeder can be operated at a time.

ADVANTAGE LINCOLN

- Weighs less than 50 lbs (22.7 kg) including optional K345-10 gun and cable and 14 lb (6.3 kg) coil of electrode.
- Electrode and control cable quickly connect to power source.
- No gas or flux feeding equipment needed.



- High, all-position, deposition rates; 4 to 9 lbs/hr (1.8 to 4.0 kg/hr).
- 30 to 100% higher operating factor than stick electrode welding.
- One 14 lb (6.3 kg) coil deposits as much weld metal as 155 sticks; about 18 lbs (8.2 kg) of 5/32" (4.0 mm) E7018.
- Equipped with Trigger Interlock Circuit to reduce operator fatigue.
- Provides "cold" electrode when gun trigger is released if used with power sources that have contactor control. This feature is ideal when welding applications are performed in electrically hazardous conditions, such as wet areas or confined spaces.
- Adjustable wire speed, voltage control and analog voltmeter are standard.
- Completely enclosed wire reel keeps the electrode wire free of contaminants.
- Easy installation - simply connect input cable assembly from LN-23P to CV power source and connect work cable and work sensing lead from power source to work.
- Power source - One LN-23P can be directly connected to a Ranger 250, Ranger 275, Ranger 305G, Classic I, Classic II, Classic III or SA-250 engine welder equipped with a CV adapter.
- 25' (7.6 m) input cable, standard length. (Includes 6 conductor control cables and 1/0 (54 mm²) electrode cable).
- 3 year warranty on parts and labor.
- Manufactured under a quality system certified to ISO 9002 requirements.

Note: A K350-1 Adapter Kit is required to operate either one or two LN-23P's from any Lincoln CV power source. If two LN-23P's are connected to an adapter kit, they can be set for different procedures, but only one can be used at a time.

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Wire Feed Range	Net Weight	Dimensions (H x W x D)
LN-23P	K316L-1	30 - 170 in./min. (.76 - 4.3 m/min.)	35 lbs. (16 kg.), including K345-10 gun (excluding electrode).	20.5 x 9 x 19 in. (521 x 229 x 483 mm.)

REQUIRED EQUIPMENT

K345-10 Gun and Cable Assembly
[10 ft. (3.0 m) long] - Rated 350 amps, 60% duty cycle, 90° nozzle. For .068 through 5/64" (1.7 through 2.0 mm.) Innershield wire and includes reduced speed switch.

K355-10 Gun and Cable Assembly
[10 ft. (3.0 m) long] - For lighter weight and easier handling. Rated 250 amps, 60% duty cycle. For .068 through 5/64" (1.7 through 2.0 mm.) Innershield wire and includes reduced speed switch.

LN-23P Adapter Kit

Required to adapt LN-23P to any Lincoln power source.
Order K350 - for Terminal Strip connection.
Order K350-1 - for 14 Pin connection.



K345-10, K355-10 Gun

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.

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THE WELDING EXPERTS

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