Magnum® PRO Semiautomatic Guns

Processes
MIG, Pulsed MIG, Flux-Cored

Product Number
K2651-x Magnum® PRO 250
K2652-x Magnum® PRO 350
K2653-x Magnum® PRO 450
K2655-x Magnum® PRO 550

Amperage Rating @ 100% Duty Cycle

PRO 250:	CO_2: 250A	Mixed Gas: 250A
PRO 350:	CO_2: 350A	Mixed Gas: 285A
PRO 450:	CO_2: 450A	Mixed Gas: 325A
PRO 550:	CO_2: 550A	Mixed Gas: 375A

Wire Diameter Range in. (mm)
.035 - 5/64 (0.9 - 2.0)
.035 - 5/64 (0.9 - 2.0)
.035 - 5/64 (0.9 - 2.0)
.035 - 1/8 (0.9 - 3.2)

Cable Length ft. (m)
See Table Below

Semiautomatic Air-Cooled Guns

Magnum® PRO guns for MIG and flux-cored welding are specifically designed and tested for extreme environment welding applications. These guns are built for high amperage, high duty cycle applications where heat-resistance and fast serviceability are key.



Shown K2653-2

FEATURES

- **All Guns Rated at 100% Duty Cycle.**
- **Industrial Grade Construction.**
  - High quality copper and aircraft grade aluminum parts ensure superior electrical contact and heat dissipation.
  - Four trigger leads are standard for fast field repair.
  - Patent-pending Anti-Seize™ tip and diffuser thread design reduces tip and diffuser seizing.
  - New gun cable retention system makes a positive bond that resists pulling apart.
  - Secure-Lock™ gun tube resists rotational slipping.
- **Lincoln Copper Plus™ Contact Tips** - Larger tip diameter and mass improves heat dissipation to increase tip life.
- **Comfort Grip™ Design** - Barrel-style handle is lightweight and balanced, providing a comfortable grip to reduce fatigue no matter how you hold the gun.
- **Lincoln PRO Select™ Gun Selection System** - Choose the right gun based on your actual welding amperage and application, not just your machine rating. Save cost and weight while gaining maneuverability and fatigue-resistance.
- **Simplified Expendable Parts Selection** - 250/350A and 450/550A consumables are interchangeable across all gun models.

WHAT'S INCLUDED

Magnum® PRO 250/350
- Contact Tip (Qty. 1) (KP2744-045)
- 0.625 in. (15.9 mm) Thread-On Gas Nozzle with 1/8 in. (3.2 mm) recess (KP2742-1-62R)
- Thread-On Diffuser (KP2746-1)

Magnum® PRO 450/550
- Contact Tip (Qty. 1) (KP2745-045)
- 0.625 in. (15.9 mm) Thread-On Gas Nozzle with 1/8 in. (3.2 mm) recess (KP2743-1-62R)
- Thread-On Diffuser (KP2747-1)

GUN REQUIRES

- Gun Connector Kit
- Gun Liner

APPLICATIONS

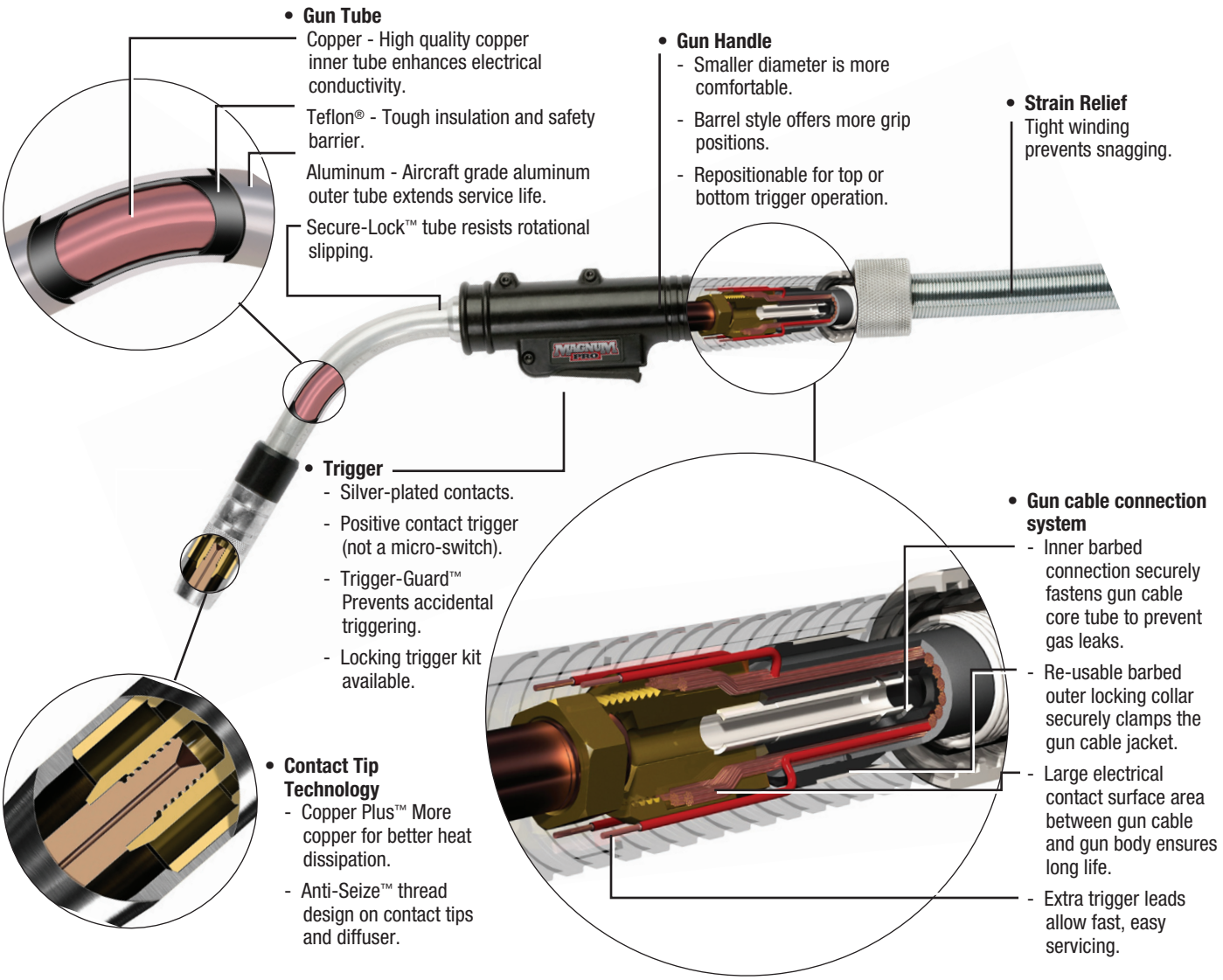
- **Industrial Fabrication**
- **Heavy Equipment**
- **Shipbuilding**
- **Construction**

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THE WELDING EXPERTS®

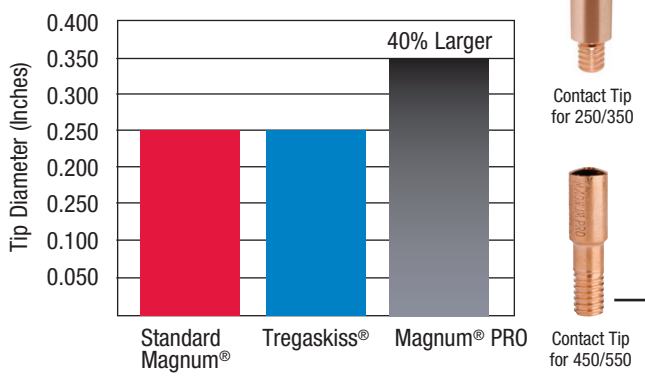
TOP FEATURES



CONTACT TIP TECHNOLOGY

Copper Plus™ Contact Tips
Compare Magnum® PRO tips to Standard Magnum® and Tregaskiss®

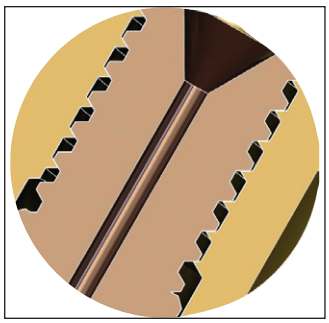
Larger Diameter Means More Copper.
The Result? Greater Heat Dissipation and Longer Life.

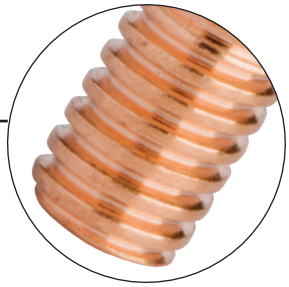



Contact Tip for 250/350

Contact Tip for 450/550

Tregaskiss is a trademark of Tregaskiss, wholly owned subsidiary of Illinois Tool Works.





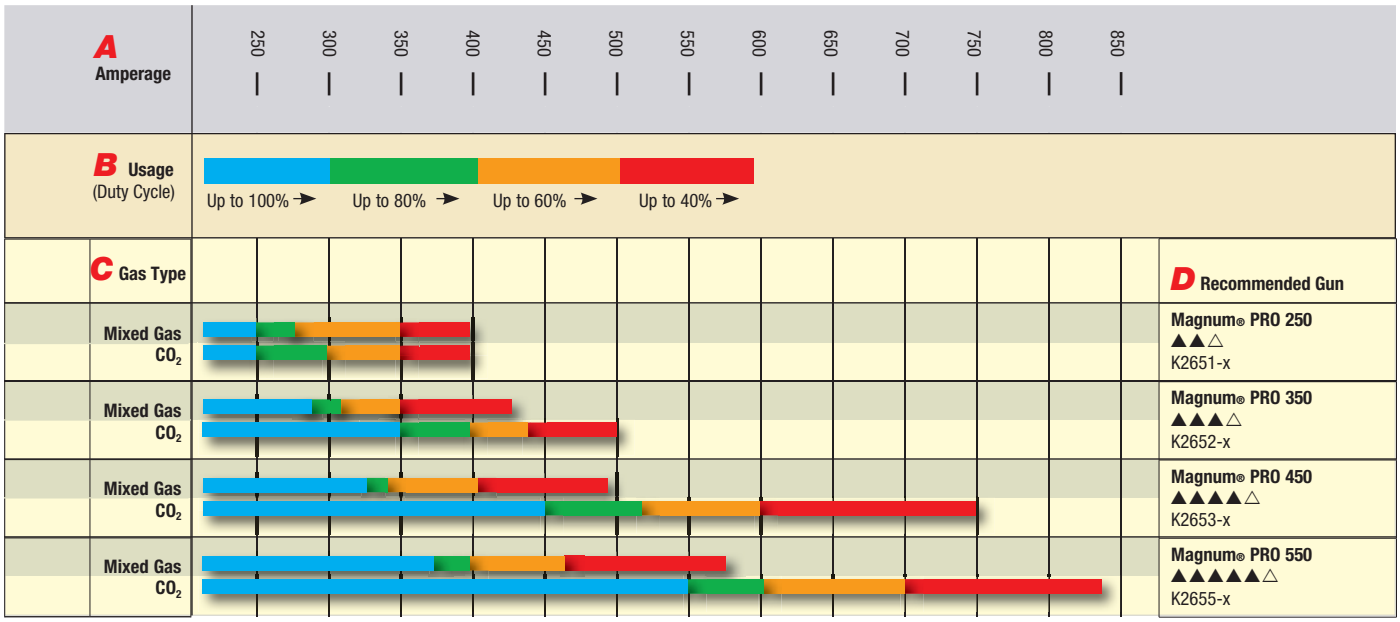
Patent-pending Anti-Seize™ Thread Design

Flattened thread profile increases the thread cross-section where heat typically concentrates and tips fail. The result is reduced melting, fusion, seizing and extended contact tip service life. Longer life and fewer tip changes reduces expendable part and labor costs while increasing arc time. To extend contact tip life even more, optional chrome-zirconium Extended Life™ tips are also available.

STEP 1 MAGNUM® PRO SELECT

SELECT YOUR GUN - DON'T OVERBUY!

A Select Your Amperage | **B** Select Your Usage | **C** Select Your Gas | **D** Select Your Gun



STEP 2

SELECT YOUR GUN CONNECTOR KIT

GUN CONNECTOR KIT			
Manufacturer	**Wire Feeder Model**	**Magnum® PRO 250/350/450**	**Magnum® PRO 550**
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8	K613-6
	LF-72, LF-74 Series, LN-25 PRO	K466-10	K613-7(1)
	Power Feed™ 10 and 25 series	K466-10	K613-7(1)
	POWER MIG® Series and Power Wave® C300	K466-6	NA
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2	K613-2
Miller®	Intellimatic, Sidekick, D-51A, Porto-Mig Millermatic 130, 200, MM-35, S-42GL, S-52A, S-54A, Swing Arc-Dual, Swing Arc-Single S-32S, 52D, 54D, 54E, 60 Series	K466-3	K613-3



K466-10

(1) K1500-3 Gun Receiver Bushing is required for Power Feed 10 series, LF series and LN-25 PRO wire feeders.

STEP 3

SELECT YOUR LINER

MAGNUM® PRO 250/350/450 in. (mm)				
ft. (m)	**.035-.045 (0.9-1.2)**	**.052-1/16 (1.3-1.6)**	**1/16-5/64 (1.6-2.0)**	**Aluminum(2) .035-3/64 (0.9-1.2)**
15 (4.5)	KP44-3545-15	KP44-116-15	KP44-564-15	KP44N-3545-15(2)
26 (7.6)	KP44-3545-25	KP44-116-25	KP44-564-25	–

MAGNUM® PRO 550 in. (mm)					
ft. (m)	**.035-.045 (0.9-1.2)**	**.052-1/16 (1.3-1.6)**	**5/64-3/32 (2.0-2.4)**	**7/64-1/8 (2.8-3.2)**	**Aluminum(2) .035-3/64 (0.9-1.2)**
15 (4.5)	KP45-3545-15	KP45-116-15	KP45H-332-15	KP45-18-15	KP45N-3545-15(2)
26 (7.6)	KP45-3545-25	KP45-116-25	KP45H-332-25	KP45-18-25	–

(2) Recommended for aluminum wire welding.

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EXPENDABLE PARTS

250/350 and 450/550 Magnum® PRO Expendable Parts are interchangeable. Interchanging will require gun tube insulator and gas diffuser changes. Customers may choose to change expendable parts to standardize stocking parts or to make the gun more compact for tight spaces.

Magnum® PRO 350A Guns



Contact Tip for 250/350

CONTACT TIPS 350 A

Wire Diameter in. (mm)	Standard	Standard	Tapered Tip	Tapered Tip
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP2744-025	KP2744-025-B100	KP2744-025T	KP2744-025T-B100
0.030 (0.8)	KP2744-030	KP2744-030-B100	KP2744-030T	KP2744-030T-B100
0.035 (0.9)	KP2744-035	KP2744-035-B100	KP2744-035T	KP2744-035T-B100
0.040 (1.0)	KP2744-040	KP2744-040-B100	KP2744-040T	KP2744-040T-B100
0.045 (1.2)	KP2744-045	KP2744-045-B100	KP2744-045T	KP2744-045T-B100
0.052 (1.3)	KP2744-052	KP2744-052-B100	KP2744-052T	KP2744-052T-B100
1/16 (1.6)	KP2744-116	KP2744-116-B100	KP2744-116T	KP2744-116T-B100
5/64 (2.0)	KP2744-564	KP2744-564-B100	KP2744-564T	KP2744-564T-B100

GAS DIFFUSER 350 A

Pkg. Qty.	Thread-on Standard Duty	Thread-on Light Duty	Slip-on
1	KP2746-1	KP3141-1(1)	KP2746-2
25	KP2746-1-B25	KP3141-1-B25(1)	KP2746-2-B25



Gas Diffuser for 250/350 Thread-on



Gas Diffuser for 250/350 Slip-on

GUN TUBE INSULATOR 250/350 A

Pkg. Qty.	Part Number
1	KP2773-2
25	KP2773-2-B25



Gun tube Insulator 250/350

GAS NOZZLE 350 A

			Gas Nozzle Diameter in. (mm)			
	Nozzle	Pkg. Qty.	Standard 0.375 (9.5)	Standard 0.5 (12.7)	Bottleneck 0.5 (12.7)	Standard 0.625 (15.9)
Thread-on	1/8 (3.2) Recess	1	KP2742-1-38R	KP2742-1-50R	KP3160-1-50R	KP2742-1-62R
		25	KP2742-1-38R-B25	KP2742-1-50R-B25	KP3160-1-50R-B25	KP2742-1-62R-B25
	Flush	1	KP2742-1-38F	KP2742-1-50F	KP3160-1-50F	KP2742-1-62F
		25	KP2742-1-38F-B25	KP2742-1-50F-B25	KP3160-1-50F-B25	KP2742-1-62F-B25
	1/8 (3.2) Stickout	1	KP2742-1-38S	KP2742-1-50S	KP3160-1-50S	KP2742-1-62S
		25	KP2742-1-38S-B25	KP2742-1-50S-B25	KP3160-1-50S-B25	KP2742-1-62S-B25
Slip-on	1/8 (3.2) Recess	1	–	KP2742-2-50R	–	KP2742-2-62R
		25	–	KP2742-2-50R-B25	–	KP2742-2-62R-B25
	Flush	1	–	KP2742-2-50F	–	KP2742-2-62F
		25	–	KP2742-2-50F-B25	–	KP2742-2-62F-B25
	1/8 (3.2) Stickout	1	–	KP2742-2-50S	–	KP2742-2-62S
		25	–	KP2742-2-50S-B25	–	KP2742-2-62S-B25



Bottleneck Gas Nozzle for up to 350 A Thread-on 1/8" (3.2 mm) Recessed



Gas Nozzle for up to 350 A Thread-on 1/8" (3.2 mm) Recessed

GUN TUBE 350 A

Gun Tubes	45º Gun Tube	60º Gun Tube
Magnum® PRO 250	KP2866-45	KP2866-60
Magnum® PRO 350	KP2867-45	KP2867-60

(1) For use with Magnum® PRO 100L KP3075-1-XXX nozzles only

EXPENDABLE PARTS

250/350 and 450/550 Magnum® PRO Expendable Parts are interchangeable. Interchanging will require gun tube insulator and gas diffuser changes. Customers may choose to change expendable parts to standardize stocking parts or to make the gun more compact for tight spaces.

Magnum® PRO 550 A Guns Expendables



Contact Tip for 450/550

CONTACT TIPS 550 A

Wire Diameter in. (mm)	Standard	Standard	Extended Life	Extended Life
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP2745-035	KP2745-035-B100	KP2745-035R	KP2745-035R-B100
0.040 (1.0)	KP2745-040	KP2745-040-B100	NA	NA
0.045 (1.2)	KP2745-045	KP2745-045-B100	KP2745-045R	KP2745-045R-B100
0.052 (1.3)	KP2745-052	KP2745-052-B100	KP2745-052R	KP2745-052R-B100
1/16 (1.6)	KP2745-116	KP2745-116-B100	KP2745-116R	KP2745-116R-B100
0.068-0.072 (1.7-1.8)	KP2745-072	KP2745-072-B100	KP2745-072R	KP2745-072R-B100
5/64 (2.0)	KP2745-564	KP2745-564-B100	KP2745-564R	KP2745-564R-B100
3/32 (2.4)(1)	KP2745-332	KP2745-332-B100	KP2745-332R	KP2745-332R-B100
7/64 (2.8)(1)	KP2745-764	KP2745-764-B100	KP2745-764R	KP2745-764R-B100
1/8 (3.2)(1)	KP2745-18	KP2745-18-B100	NA	NA

(1) 550 only

GAS DIFFUSER 550 A

	Type		
Pkg. Qty.	Thread-on Standard Duty	Thread-on 1/4 in. Recess	Slip-on
1	KP2747-1	KP3155-1	KP2747-2
25	KP2747-1-B25	KP3155-1-B25	KP2747-2-B25



Gas Diffuser for 450/550 Thread-on



Gas Diffuser for 450/550 Slip-on

GUN TUBE INSULATOR 550 A

Pkg. Qty.	Part Number
1	KP2773-1
25	KP2773-1-B25



Gun Tube Insulator 450/550

GAS NOZZLE 550 A

			Gas Nozzle Diameter in. (mm)		
	Nozzle	Pkg. Qty.	Standard 0.625 (15.9)	Bottleneck 0.625 (15.9)	Standard 0.750 (19)
Thread-on	1/8 (3.2) Recess	1	KP2743-1-62R	KP3161-1-62R	KP2743-1-75R
		25	KP2743-1-62R-B25	KP3161-1-62R-B25	KP2743-1-75R-B25
	Flush	1	KP2743-1-62F	KP3161-1-62F	KP2743-1-75F
		25	KP2743-1-62F-B25	KP3161-1-62F-B25	KP2743-1-75F-B25
	1/8 (3.2) Stickout	1	KP2743-1-62S	KP3161-1-62S	KP2743-1-75S
		25	KP2743-1-62S-B25	KP3161-1-62S-B25	KP2743-1-75S-B25
Slip-on	1/8 (3.2) Recess	1	KP2743-2-62R	–	KP2743-2-75R
		25	KP2743-2-62R-B25	–	KP2743-2-75R-B25
	Flush	1	KP2743-2-62F	–	KP2743-2-75F
		25	KP2743-2-62F-B25	–	KP2743-2-75F-B25
	1/8 (3.2) Stickout	1	KP2743-2-62S	–	KP2743-2-75S
		25	KP2743-2-62S-B25	–	KP2743-2-75S-B25



Bottleneck Gas Nozzle for 550 Thread-on 1/8 in. (3.2 mm) Recessed



Gas Nozzle for 550 Thread-on 1/8 in. (3.2 mm) Recessed

GUN TUBE 550 A

Gun Tubes	45° Gun Tube	60° Gun Tube	82° Gun Tube	180° Gun Tube
Magnum® PRO 450	KP2868-45	KP2868-60	KP2868-82	KP2868-180
Magnum® PRO 550	KP2869-45	KP2869-60	—	KP2869-180
	—	KP2869-60SN(2)	—	—

(2) Short neck for up to 3/32 in. wire.

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RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Magnum® PRO Harness Adapter
Required for use with Magnum® PRO Dual Procedure or Dual Schedule guns when adapting to POWER MIG® products, Power Wave® C300, or Miller Electric® wire feeders.
Order K3159-1

SPECIFICATIONS

Product Name	Product Number	Amperage Rating 100% Duty Cycle		Wire Diameter Range		Cable Length ft. (m)	Gun Connector	Gun Liner
		CO_2	Mixed	in.	(mm)			
Magnum® PRO 250	K2651-1	250	250	.035 - 5/64	(0.9 - 2.0)	10 (3.0)	Order Separately	Order Separately
	K2651-2					15 (4.5)		
	K2651-3					20 (6.1)		
	K2651-4					25 (7.6)		
Magnum® PRO 350	K2652-1	350	285	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K2652-2					15 (4.5)		
	K2652-3					20 (6.1)		
	K2652-4					25 (7.6)		
Magnum® PRO 350 Dual Procedure	K3131-1	350	285	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K3131-2					15 (4.5)		
	K3131-3					20 (6.1)		
	K3131-4					25 (7.6)		
Magnum® PRO 350 Dual Schedule	K3132-1	350	285	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K3132-2					15 (4.5)		
	K3132-3					20 (6.1)		
	K3132-4					25 (7.6)		
Magnum® PRO 450	K2653-1	450	325	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K2653-2					15 (4.5)		
	K2653-3					20 (6.1)		
	K2653-4					25 (7.6)		
Magnum® PRO 450 Dual Procedure	K3133-1	450	325	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K3133-2					15 (4.5)		
	K3133-3					20 (6.1)		
	K3133-4					25 (7.6)		
Magnum® PRO 450 Dual Schedule	K3134-1	450	325	.035 - 5/64	(0.9 - 2.0)	10 (3.0)		
	K3134-2					15 (4.5)		
	K3134-3					20 (6.1)		
	K3134-4					25 (7.6)		
Magnum® PRO 550	K2655-1	550	375	.035 - 1/8	(0.9 - 3.2)	10 (3.0)		
	K2655-2					15 (4.5)		
	K2655-3					20 (6.1)		
	K2655-4					25 (7.6)		
Magnum® PRO 550 Dual Procedure	K3135-1	550	375	.035 - 1/8	(0.9 - 3.2)	10 (3.0)		
	K3135-2					15 (4.5)		
	K3135-3					20 (6.1)		
	K3135-4					25 (7.6)		
Magnum® PRO 550 Dual Schedule	K3136-1	550	375	.035 - 1/8	(0.9 - 3.2)	10 (3.0)		
	K3136-2					15 (4.5)		
	K3136-3					20 (6.1)		
	K3136-4					25 (7.6)		
Magnum® PRO 250 Ready-Pak®	K2651-2-6-45	250	250	.035 - .045	(0.9 - 1.2)	15 (4.5)	K466-6	KP44-3545-15
Magnum® PRO 350 Ready-Pak®	K2652-2-10-45	350	285	.035 - .045	(0.9 - 1.2)	15 (4.5)	K466-10	KP44-3545-15
Magnum® PRO 450 Ready-Pak®	K2653-2-10-45	450	325	.035 - .045	(0.9 - 1.2)	15 (4.5)	K466-10	KP44-3545-15

* Ready-Paks® include .035-.045 in. (0.9-1.2 mm) liner

CUSTOMER ASSISTANCE POLICY

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