

POWER MIG® 255XT

Processes

MIG, Flux-Cored

Product Number

K2701-1 208/230

K2701-2 230/460/575

K2702-1 208/230 One-Pak®

Input Power

K2701-1 & K2702-1: 208/230/1/60

K2701-2: 208/230/575/1/60

Input Current at Rated Output

56/52A

Rated Output

250A/26V/40% Duty Cycle

Max. Open Circuit Voltage
40V

Amperage Range

30 - 300 A

Wire Feed Speed

50 - 700 IPM (1.3 - 17.7 m/min)

Weight/Dimensions (H x W x D)

220 lbs. (100 kg)

31.8 x 18.9 x 38.8 in.
(808 x 480 x 985 mm)

POWER MIG®

The Professional's ChoiceSM

The POWER MIG® 255XT sets the standard for MIG and flux-cored welding in light industrial job shop fabrication, maintenance or repair work.

FEATURES

- ▶ **Diamond Core Technology™** – Delivers a forgiving arc, excellent out-of-position arc action, low spatter and a wide voltage sweet spot at a given wire feed speed for steel, stainless steel or aluminum.
- ▶ **MAXTRAC® cast aluminum industrial wire drive** – Features dual driven rolls, regulated wire feed speed control, brass-to brass connections and Lincoln's 100% wire supporting split wire guide system.
- ▶ **Digital meters** - Display, preset voltage and wire feed speed, and actual voltage and preset wire feed speed while welding.
- ▶ **Generous 15 ft. (4.5 m) gun and cable** - Makes it easy to reach your work.
- ▶ **Add a Spool Gun** – The POWER MIG® 255XT is spool gun ready for the premium Magnum® 250LX gun and spool gun capable with the Magnum® SG (requires adapter).
- ▶ **115V auxiliary receptacle** - (208/230V model only) to power a grinder or other auxiliary equipment in your work area.

APPLICATIONS

- ▶ Metal Fabrication
- ▶ Maintenance and Repair
- ▶ Autobody/Farm
- ▶ Light Industrial



Shown K2701-1

WHAT'S INCLUDED

K2702-1 One-Pak® Includes:

- ▶ POWER MIG® 255XT (K2701-1)
- ▶ Magnum® 250LX Spool Gun (K2490-1)
- ▶ Spool Gun Holder (K1738-1)
- ▶ Dual Cylinder Mounting Kit (K1702-1)
- ▶ Extra Regulator (K586-1)

INPUT



OUTPUT



Two Year Extended
Warranty Available
in the U.S.A. and
Canada



KEY CONTROLS

- A. Digital meter displays preset wire feed speed.
- B. Presettable digital wire speed control with fine resolution at low settings.
- C. Digital meter displays preset voltage setting and actual voltage while welding.
- D. Built-in gun holder.
- E. Presettable digital voltage control with fine resolution at low settings.
- F. Angled gun connection for improved feedability.
- G. Second gas solenoid fitting for spool gun use.



A CLOSER LOOK



- A Lockable storage compartment with tool tray stows your welding consumables and valuable personal tools.
- B Built-in gun holder conveniently stores welding gun.
- C Handy MIG Gun Expendables Chart.



Additional Gas Solenoid – Controls Gas Flow to a Spool Gun



Easy Load Gas Cylinder Platform



Timer Functions

Adds 4-step trigger interlock, spot mode, adjustable run-in speed for smoother arc starting, and adjustable burnback time to minimize wire sticking in puddle.



Extra-Length 15 ft. (4.5 m) Gun



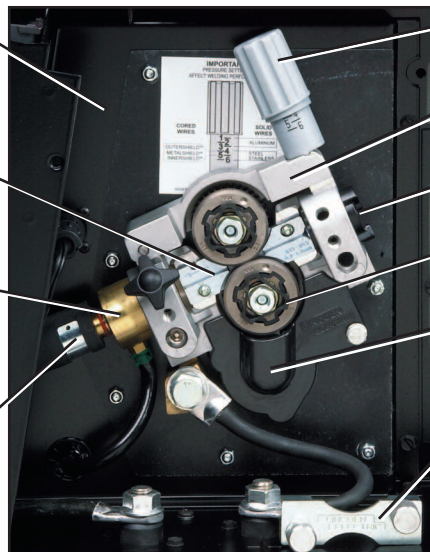
Easy Load Wire Compartment

Internal feedback drive system allows you to maintain constant wire feed speed for consistent welds.

Split guides support the wire through the entire drive system to minimize feeding problems.

Reliable **brass-to-brass gun receiver bushings** provide connectivity to Magnum® or competitive guns. Easier interchangeability, better mechanical support and electrical current transfer.

Angled gun cable connection for improved feedability and reduced gun liner wear.



Easy turn numeric tension indicator with optimized ranges for different wire types.

Wide idler arm hinge provides improved drive roll clamping pressure.

Input bushing protects the wire from damage.

Two gear driven rolls. No tools needed to swap rolls on or off.

Separate drive gear reduces pressure on motor shaft for long life.

Removable outer wire guide for easy access.



A patented heavy duty cast aluminum wire drive system that provide reliable feeding and increased durability.

GUN INFORMATION

Included Magnum® 250L Gun



- Rated 250A @ 60% duty cycle with CO₂ shielding gas.
- Ships equipped to feed .035" – .045" (0.9 – 1.2 mm) solid steel wire. The 250L is capable of feeding .025" – .045" (0.6 – 1.2 mm) wire.
- Extra reach 15 foot (4.5 m) gun cable length.
- Features ergonomic handle, gun hanger clip and 60 degree gun tube.

DRIVE ROLL KITS

| | Wire Size in. (mm) | Order Number |
|----------|-----------------------|-----------------------------|
| Solid | .023-.030 (0.6-0.8) | KP1696-030S |
| | .035 in. (0.9) | KP1696-035S ⁽¹⁾ |
| | .035/.045 combination | KP1696-1 |
| | .040 (1.0) | KP1696-2 |
| | .045 (1.2) | KP1696-045S |
| Cored | .035 (0.9) | KP1697-035C |
| | .045 (1.2) | KP1697-045C |
| Aluminum | 3/64 (1.2) | KP1695-3/64A ⁽²⁾ |

⁽¹⁾ Included with POWER MIG® 255XT.

⁽²⁾ Included in the K1703-1 Aluminum Feeding Kit.

SPOOL GUN CAPABLE MEDIUM DUTY

Magnum® SG Spool Gun – (K487-25)



- 250 Amp 60% Duty Cycle
- 25 ft. (7.6 m) cable length
- Feeds .025 - 3/64 in. (0.6 – 1.2 mm) diameter wire
- Single-Turn remote wire feed speed control at the gun
- Adjustable wire spool brake
- Adjustable drive roll tension

Requires K2445-1 Adapter

SPOOL GUN READY-HEAVY DUTY

Magnum® 250LX Spool Gun – (K2490-1)



- 300 Amp 60% Duty Cycle
- 25 ft. (7.6 m) cable length
- Feeds .025 - 3/64 in. (0.6 – 1.2 mm) diameter wire
- Multi-Turn remote wire feed speed control at the gun
- Deluxe wire spool brake requires no adjustments
- Adjustable drive roll tension
- Ergonomic Sure Grip handle
- Contact tip storage built in spool gun cover
- Easy open wire drive rolls for easy wire loading

No Adapter Required

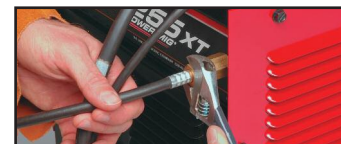
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SPOOL GUN READY!

A second gas solenoid is provided to supply and control gas flow to the spool gun.

Easy as 1-2-3!

1. Connect spool gun control cable to 7-pin Connector (Magnum® SG gun requires K2445-1, 6- to 7-pin control cable adapter plug.)
2. Connect the spool gun power cable to the output terminal.
3. Connect the spool gun gas line to the solenoid gas fitting.

RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES

GENERAL OPTIONS



Magnum® SG Spool Gun
250 Amp, 60% Duty Cycle with 25 ft. (7.6 m) of cable length. Feeds .025 - 3/64 in. (0.6 - 1.2 mm) diameter wire. Single Turn remote wire feed speed control at the gun. Adjustable wire spool brake and adjustable drive roll tension.
Order K487-25
Requires K2445-1 Adapter



Canvas Cover
Protect your POWER MIG® when not in use. Made from red canvas that is flame retardant, mildew resistant and water repellent. Fits any POWER MIG® machine with or without a gas cylinder in the cylinder rack. Will not fit if spool gun holder is attached to the machine.
Order K2378-1



Magnum® Guns
Alternate guns can be used with the POWER MIG®, including Magnum® 200, 300 and 400 MIG (GMAW) models, as well as Magnum® 250XA Fume Extraction Gun.
See Publications E12.10 and E13.10 for details.
Note: Requires K466-6 Adapter Kit.



Magnum® 250LX Spool Gun
300 Amp, 60% Duty Cycle with 25 ft. (7.6 m) of cable length. Feeds .025 - 3/64 in. (0.6 - 1.2 mm) diameter wire. Multi-Turn remote wire feed speed control at the gun. Deluxe wire spool brake requires no adjustments. Adjustable drive roll tension and easy open wire drive rolls for easy wire loading. Ergonomic Sure Grip handle. Contact tip storage built in spool gun cover.
K2490-1
Factory Ready



Magnum® SG Spool Gun Control Cable Adapter
Allows the K487-25 Magnum® SG Spool Gun's 6-pin control cable plug to connect to the POWER MIG® 255XT's 7-pin spool gun control cable receptacle.
Order K2445-1



Magnum® Connection Kit
Permits use of Magnum® 200, 300 and 400 gun and cable assemblies on POWER MIG®.
Order K466-6



8 in. O.D. Spool Adapter
Permits 8 in. (200 mm) O.D. spools to be mounted on 2" (51 mm) O.D. spindles.
Order K468



Dual Cylinder Mounting Kit
Permits side-by-side mounting of two full size gas cylinders, with easy loading. Attaches easily to POWER MIG® undercarriage.
Order K1702-1



Magnum® 250LX Spool Gun Control Cable Extension
Extend your spool gun reach with a 25 ft. (7.6 m) Control Cable Extension. Features a 7-pin female MS-type connector on the spool gun end and a 7-pin male MS-type connector on the power source end.
Order K2519-1



Welding Fume Extractors
Lincoln offers a wide variety of welding fume extraction environmental system solutions, ranging from portable systems easily wheeled around the shop to shop-wide central systems servicing many dedicated welding stations.
Request Publication MC08-70



Spool Gun Holder
Provides neat storage of spool gun.
Order K1738-1

PROCESS CAPABILITIES

| Process | Electrode Wire | Electrode Polarity | Shielding Gas | Minimum Thickness | Maximum Thickness ⁽¹⁾ |
|--|--|--------------------|--|---------------------------------|----------------------------------|
| MIG Mild Steel | .025, .030, .035, .045 in. (0.6, 0.8, 0.9, 1.1 mm) SuperArc® L50, L-56 SuperGlide® S-3, S-6 | DC+ | 100% CO ₂ or Ar/CO ₂ Blend | 24 ga. (.024 in.) (0.6 mm) | 1/2 in. (.500 in.) (19.1 mm) |
| MIG Stainless | .030, .035, .045 in. (0.8, 0.9, 1.1 mm) Blue Max® 308LSi, 309LSi, 316LSi | DC+ | Ar/CO ₂ Blend or (Tri-Mix) | 20 ga. (.036 in.) (0.9 mm) | 1/2 in. (.500 in.) (19.1 mm) |
| MIG Aluminum ⁽²⁾ | 3/64 in. (1.2 mm) SuperGlaze® 4043 and 5356 | DC+ | 100% Argon | 1/16 in. (.063 in.) (1.6 mm) | 1/2 in. (.500 in.) (19.1 mm) |
| Flux-Cored, Gas-Shielded Mild Steel | .035, .045 in. (0.9, 1.1 mm) Outershield® 71M and MC-710 | DC+ | 100% CO ₂ or Ar/CO ₂ Blend | 12 ga. (.109 in.) (2.7 mm) | 1/2 in. (.500 in.) (19.1 mm) |
| Flux-Cored, Self-Shielded Mild Steel | .035, .045 in. (0.9, 1.1 mm) Innershield® NR®-211-MP ⁽²⁾ and NR®-212 | DC- | — | 18 ga. (.050 in.) (1.2 mm) | 3/4 in. (.750 in.) (12.7 mm) |

(1) Lincoln Electric recommends multiple pass welds on 1/2 in. (12.7 mm) material. Consult the appropriate application procedures and guidelines for selecting the correct wire size, gas type and number of passes.

(2) .035 and .045 in. (0.9 and 1.1 mm) NR®-211-MP is only recommended up to 5/16 in. (7.9 mm) thick material.

**For best welding results with Lincoln Electric equipment,
always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.**

CUSTOMER ASSISTANCE POLICY

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THE WELDING EXPERTS®