

# Magnum<sup>®</sup> Semiautomatic Guns

## Processes

MIG, Pulsed MIG, Flux-Cored

## Product Number

Magnum<sup>®</sup> 100L  
 Magnum<sup>®</sup> 250L  
 Magnum<sup>®</sup> 200  
 Magnum<sup>®</sup> 300  
 Magnum<sup>®</sup> 400  
 Magnum<sup>®</sup> 550

## Amperage Rating @ 60% Duty Cycle <sup>(1)</sup>

100% CO<sub>2</sub> Shielding Gas  
 Magnum<sup>®</sup> 100L: 100A  
 Magnum<sup>®</sup> 250L: 250A  
 Magnum<sup>®</sup> 200: 200A  
 Magnum<sup>®</sup> 300: 300A  
 Magnum<sup>®</sup> 400: 400A  
 Magnum<sup>®</sup> 550: 600A

## Wire Diameter Range in. (mm)

.025 - .045 (0.6 - 1.2)  
 .025 - .045 (0.6 - 1.2)  
 .025 - .045 (0.6 - 1.2)  
 .025 - 5/64 (0.6 - 2.0)  
 .025 - 5/64 (0.6 - 2.0)  
 .035 - 1/8 (0.9 - 3.2)

<sup>(1)</sup> Magnum<sup>®</sup> 100L and 250L are 40% duty cycle.

## Semiautomatic Gas-Shielded Guns

Magnum<sup>®</sup> guns for MIG or flux-cored welding feature our classic curved handle and are available in a number of amperage ranges for use in many applications.

### FEATURES

- ▶ **One-piece modular trigger assembly** - Molded out of high heat resistant material to withstand heat and spatter and ensure long life.
- ▶ **Gun tube design** - Armored with an electrically insulated metal jacket optimizing fine wire welding performance.
- ▶ **Abrasion-resistant, extruded rubber jacket** - Adds strength and long life to the cable.
- ▶ **Classic curved handle** - Lightweight and balanced, providing a comfortable grip to reduce fatigue.
- ▶ **Rotating gun tube and gun hanger clip** - Allow any number of hand positions to reduce fatigue or fit into tight spaces.

### WHAT'S INCLUDED

- ▶ Contact Tip
- ▶ Gas Diffuser
- ▶ Gas Nozzle
- ▶ Insulator
- ▶ Cable Liner
- ▶ Gun Tube (60°)

### GUN REQUIRES

- ▶ Gun Connector Kit

### APPLICATIONS

- ▶ Shop Production
- ▶ Maintenance and Repair
- ▶ Construction



# MAGNUM<sup>®</sup>

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



**Magnum® 100L Gun and Cable Assembly**

Extremely small, lightweight gun that's great for most home, farm and small shop projects, autobody work and light maintenance or repair applications. Includes gun connector.



**Magnum® 250L Gun and Cable Assembly**

Recommended for medium duty job shop and production applications. Includes gun connector.



**Magnum® 200 Gun and Cable Assembly**

A small, lightweight gun intended for light job shop and fabrication applications. Best suited for welding on thin materials using .025-.030 in. (0.6-0.8 mm) wire.



**Magnum® 300 Gun and Cable Assembly**

This popular Magnum® gun is intended for most .035-.045 in. (0.9-1.1 mm) wire diameter applications in job shops, production or manufacturing.



**Magnum® 400 Gun and Cable Assembly**

The Magnum® 400 gun is built for operator comfort when welding with the greater heat levels generated by higher amperage applications. Select the Magnum® 400 gun for most .045-1/16 in. (1.2-1.6 mm) gas-shielded operations. Available in standard, dual schedule, dual procedure and short neck models.



**Magnum® 550 Gun and Cable Assembly**

Choose our 550 gun for heavy duty applications, including up to .052 in. and .062 in. (1.3 and 1.6 mm) MIG or 3/32-1/8 in. (2.4-3.2 mm) gas-shielded flux-cored applications.



**GUN CONNECTOR KITS** Gun Connector Kits are included with Fast-Mate™ Guns and Ready-Pak® Packages only.

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 200, 300 Open End, 400 Open End, Single Procedure
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K466-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K466-8
	LF-72, LF-74 Series, LN-25 PRO	K466-10
	Power Feed® 10 and 25 series	K466-10
	POWER MIG® Series and Power Wave® C300	K466-6
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	K466-2
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



K466-1



K466-8

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 200 Fast-Mate™, 300 Fast-Mate™, and 400 Fast-Mate™, Single Procedure
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K489-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K489-1
	Power Feed® 10 and 25 series	K489-7
	POWER MIG® Series and Power Wave® C300	K489-8



K466-10



K489-7

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 400 Dual Procedure, Dual Schedule
	Power Feed® 10 and 25 series	K466-10

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 400 Fast-Mate™, Dual Procedure, Dual Schedule
Lincoln Electric®	Power Feed® 10 and 25 series	K489-7



K489-8

GUN CONNECTOR KIT		
Wire Feeder Manufacturer	Wire Feeder Model	Magnum® 550 Open End
Lincoln Electric®	LN-7 Series, LN-8, LN-9, LN-25 [Up to .052 in. (1.4 mm) Wire]	K613-1
	LN-8, LN-9 Series, LN-25 [1/16 in. (1.6 mm) and Larger Wire]	K613-6
	Power Feed® 10 and 25 series	K613-7
Tweco® Adapted	No. 2, No. 3, No. 4 Guns (K466), No. 5 (K613)	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	K613-3



K613-6



K613-7

**CABLE LINERS**

MAGNUM® 100L {in. (mm)}		
ft. (m)	.035 (0.9) Aluminum <sup>(1)</sup>	.035-.045 (0.9-1.2)
15 (4.5)	KP1959-1	KP45-40-15



Magnum® 200 and 250L

Magnum® 300 and 400

MAGNUM® 200, 250L and 250SP {in. (mm)}				
ft. (m)	.025-.030 (0.6-0.8)	.030-.035 (0.8-0.9)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>
15 (4.5)	KP42-25-15	KP42-3035-15	KP42-4045-15	KP44N-3545-15 <sup>(1)</sup>



Magnum® 550

MAGNUM® 300 and 400 {in. (mm)}						
ft. (m)	.025-.030 (0.6-0.8)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	.052-1/16 (1.3-1.6)	1/16-5/64 (1.6-2.0)	1/16 (1.6) Aluminum <sup>(1)</sup>
15 (4.5)	KP42-25-15	KP44-3545-15	KP44N-3545-15 <sup>(1)</sup>	KP44-116-15	KP44-564-15	KP44N-116-15 <sup>(1)</sup>
26 (7.9)	—	KP44-3545-25	—	KP44-116-25	KP44-564-25	—

MAGNUM® 550 {in. (mm)}						
ft. (m)	.035-.045 (0.9-1.2)	.035-3/64 (0.9-1.2) Aluminum <sup>(1)</sup>	.052-1/16 (1.3-1.6)	1/16 (1.6) Aluminum <sup>(1)</sup>	5/64-3/32 (2.0-2.4)	7/64-1/8 (2.8-3.2)
15 (4.5)	KP45-3545-15	KP45N-3545-15	KP45-116-15	KP45N-116-15 <sup>(1)</sup>	KP45H-332-15	KP45-18-15
25 (7.6)	KP45-3545-25	—	KP45-116-25	—	KP45H-332-25	KP45-18-25

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

**GUN TUBES**

GUN TUBES				
Use With These Magnum® Guns	Amperage Capacity	Angle		
		45°	60°	82°
Magnum® 100L	100 A		KP2038-1	
Magnum® 200	200 A		KP2028-1	
	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 250L	250 A	KP2041-1	KP2015-1 (Hard cover) KP2111-1 (Rubber cover)	
Magnum® 300 Magnum® 400	300 A	KP1929-2	KP1928-2	
	400 A	KP1929-1	KP1928-1	KP1941-1
Magnum® 550	600 A		KP1951-1 (3 in. radius bend) KP1951-2 (5 in. radius bend)	



45° Gun Tube



60° Gun Tube



82° Gun Tube

**CONTACT TIPS**

<b>CONTACT TIPS 100 A</b>				
Wire Diameter in. (mm)	Standard		Tapered	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP11-25	KP11-25-B100	KP11T-25	—
0.030 (0.8)	KP11-30	KP11-30-B100	KP11T-30	—
0.035 (0.9)	KP11-35	KP11-35-B100	KP11T-35	—
0.035 (0.9) Aluminum	KP2078-1B1 <sup>(1)</sup>	—	—	—
0.045 (1.2)	KP11-45	KP11-45-B100	KP11T-45	—

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



<b>CONTACT TIPS 200 A and 250 A</b>								
Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 <sup>(1)</sup>	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 <sup>(1)</sup>	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 <sup>(1)</sup>	KP14A-364-B100 <sup>(1)</sup>	KP14AH-364 <sup>(1)</sup>	KP14AH-364-B100 <sup>(1)</sup>	—	—	KP2010-5B1 <sup>(1)</sup>	—

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

<b>CONTACT TIPS 300 A and 400 A</b>								
Wire Diameter in. (mm)	Standard		Heavy Duty		Tapered		Notched	
	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100	Pkg. Qty. - 10	Pkg. Qty. - 100
0.025 (0.6)	KP14-25	KP14-25-B100	—	—	KP14T-25	—	—	—
0.030 (0.8)	KP14-30	KP14-30-B100	—	—	KP14T-30	KP14T-30-B100	KP2010-3B1 <sup>(1)</sup>	—
0.035 (0.9)	KP14-35	KP14-35-B100	KP14H-35	KP14H-35-B100	KP14T-35	KP14T-35-B100	KP2010-4B1 <sup>(1)</sup>	—
0.040 (1.0)	KP14-40	—	KP14H-40	KP14H-40-B100	KP14T-40	KP14T-40-B100	—	—
0.045 (1.2)	KP14-45	KP14-45-B100	KP14H-45	KP14H-45-B100	KP14T-45	KP14T-45-B100	—	—
3/64 (1.2)	KP14A-364 <sup>(1)</sup>	KP14A-364-B100 <sup>(1)</sup>	KP14AH-364 <sup>(1)</sup>	KP14AH-364-B100 <sup>(1)</sup>	—	—	KP2010-5B1 <sup>(1)</sup>	—
0.052 (1.3)	KP14-52	KP14-52-B100	KP14H-52	KP14H-52-B100	KP14T-52	KP14T-52-B100	—	—
1/16 (1.6)	KP14-116	KP14-116-B100	KP14H-116	KP14H-116-B100	KP14T-116	—	—	—
5/64 (2.0)	KP14-564	—	KP14H-564	—	—	—	—	—

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

<b>CONTACT TIPS 500 A</b>		
Wire Diameter in. (mm)	Solid Wire, Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP15H-35	—
0.045 (1.2)	KP15H-45	—
0.052 (1.3)	KP15H-52	—
1/16 (1.6)	KP15H-116	—
5/64 (2.0)	KP15H-564	—
3/32 (2.4)	KP15H-332	—

<b>CONTACT TIPS 600 A</b>		
Wire Diameter in. (mm)	Heavy Duty	
	Pkg. Qty. - 10	Pkg. Qty. - 100
0.035 (0.9)	KP16S-35	—
0.045 (1.2)	KP16S-45	—
0.052 (1.3)	KP16S-52	—
1/16 (1.6)	KP16S-116	KP16S-116-B100
5/64 (2.0)	KP16S-564	KP16S-564-B100
3/32 (2.4)	KP16S-332	KP16S-332-B100
7/64 (2.8)	KP16S-764	—
1/8 (3.2)	KP16S-18	—

**GAS DIFFUSERS**

<b>GAS DIFFUSERS 100 A</b>	
Pkg. Qty.	.025-.045 in. (0.6-1.2 mm)
1	KP35-50
25	—



100 A



200 A and 250 A



300 A and 400 A



600 A

<b>GAS DIFFUSERS 200 A</b>			
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
1	KP52-23	KP52FN	KP2051-1 <sup>(2)</sup> or KP52FN <sup>(1)</sup>
25	—	KP52FN-B25	KP2051-1B1 <sup>(2)</sup> or KP52FN-B25 <sup>(1)</sup>

<b>GAS DIFFUSERS 250 A</b>				
Nozzle	Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-.045 (0.9-1.2 mm)	.025-.045 (0.6-1.2 mm)
For Adjustable Slip-On Nozzle	1	KP52-23	KP52	—
For Adjustable Slip-On Nozzle	25	—	KP52-B25	—
For Fixed Nozzle	1	KP2051-1	KP52FN	KP52FN
For Fixed Nozzle	25	—	KP52FN-B25	—
Specialty	1	KP2051-1	—	KP2051-1 <sup>(3)</sup>
Specialty	25	—	—	KP2051-1B1

<b>GAS DIFFUSERS 300 A and 400 A</b>		
Pkg. Qty.	.025-.030 in. (0.6-0.8 mm)	.035-5/64 in. (0.9-2.0 mm)
1	KP2024-2 <sup>(1)</sup>	KP54A
25	—	KP54A-B25

<sup>(1)</sup> Use KP42-25-x liner with this diffuser when feeding .025-.030 in. wire.

<b>GAS DIFFUSERS 600 A</b>		
Pkg. Qty.	.035-1/16 in. (0.9-1.6 mm)	5/64-1/8 (2.0-3.2 mm)
1	KP56S-SW	KP56S-H
25	—	KP56S-H-B10

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

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

<sup>(3)</sup> Permits use of 100 amp contact tips and nozzles with Magnum® 250L gun tube.



**GAS NOZZLES AND INSULATORS**



**Adjustable Slip-On  
Gas Nozzle**



**Coarse Thread  
Gas Nozzle**



**Insulator**

**GAS NOZZLES 100 A**

Nozzle	Pkg. Qty.	.37 Nozzle Diameter	.50 Nozzle Diameter	.625 Nozzle Diameter
Fixed Flush	1	—	KP21-50-F	—
Fixed Recessed	1	KP21T-37	KP21T-50	KP21T-62
Gasless Nozzle	1	KP1939-1	—	—
Spot Nozzle	1	—	—	KP21-62-FAS

**GAS NOZZLES 200 A**

Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter
Adjustable Slip-On	1	KP22-37	KP22-50	KP22-62
Adjustable Slip-On	25	KP22-37-B25	KP22-50-B25	KP22-62-B25
Gasless Nozzle	1	KP1947-1	KP1947-1	KP1947-1
Spot Nozzle	1	KP21-62-FAS	KP21-62-FAS	KP21-62-FAS

**GAS NOZZLES 300 A and 400 A**

Nozzle	Pkg. Qty.	.38 Nozzle Diameter	.50 Nozzle Diameter	.62 Nozzle Diameter	.75 Nozzle Diameter
Adjustable Slip-On	1	—	KP24A-50	KP24A-62	—
Adjustable Slip-On	25	—	KP24A-50-B25	KP24A-62-B25	—
Slip-On Recessed	1	KP24A-37-SS	KP24A-50-SS	KP24A-62-SS	—
Slip-On Recessed	25	—	—	KP24A-62-SS-B25	—
Coarse Thread/Tip Recessed 1/8 in.	1	—	—	KP24CT-62-S	KP24CT-75-S
Coarse Thread/Tip Recessed 1/8 in.	25	—	—	KP24CT-62-S-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	—	—	KP24CT-62-R	KP24CT-75-R
Coarse Thread/Tip Recessed 1/4 in.	25	—	—	KP24CT-62-R-B25	—
Fixed Recessed	1	KP23-37	KP23-50	KP23-62	KP23-75
Fixed Recessed	25	KP23-37-B25	KP23-50-B25	KP23-62-B25	—
Fixed Tapered	1	KP23T-37	—	—	—
Fixed Tapered	25	KP23T-37-B25	—	—	—
Fixed Heavy Duty	1	—	—	KP23H-62	—
Fixed Heavy Duty	25	—	—	KP23H-62-B25	—
Fixed Flush	1	—	KP23-50F	KP23-62F	—
Fixed Flush	25	—	KP23-50F-B25	KP23-62F-B25	—

**GAS NOZZLES 600 A**

Nozzle	Pkg. Qty.	.62 Nozzle Diameter	.75 Nozzle Diameter	.88 Nozzle Diameter
Coarse Thread/Tip Recessed 1/8 in.	1	KP26CT-62	KP26CT-75	—
Coarse Thread/Tip Recessed 1/8 in.	25	—	KP26CT-75-B25	—
Coarse Thread/Tip Recessed 1/4 in.	1	KP26CT-62-R	KP26CT-75-R	—
Self-Insulated/Tip Recessed 1/4 in.	1	—	KP26I-75	—

**INSULATORS**

Nozzle	Pkg. Qty.	200 Amp	300 and 400 Amp	600 Amp
Adjustable Slip-On	1	KP32	—	—
Adjustable Slip-On	25	KP32-B25	—	—
Adjustable Slip-On	1	—	KP34A	—
Adjustable Slip-On	25	—	KP34A-B25	—
Coarse Thread	1	—	KP34CT	—
Coarse Thread	25	—	KP34CT-B25	—
Coarse Thread	1	—	—	KP36CT
Coarse Thread	25	—	—	KP36CT-B25

## PRODUCT SPECIFICATIONS

Gun Model	Gun Rating Amperage/Duty Cycle/Shielding Gas	Cable Length ft. (m)	Wire Diameter .025-.035 in. (0.6-0.9 mm)	Wire Diameter .035-.045 in. (0.9-1.2 mm)			Wire Diameter .052-1/16 in. (1.3-1.6 mm)			Wire Diameter 1/16-5/64 in. (1.6-2.0 mm)	
			Package	Gun Connector			Gun Connector			Gun Connector	
				Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™	Package	Open-End	Fast-Mate™
Magnum® 100L	100A@40% CO <sub>2</sub>	10 (3.0)	K530-5, K530-6 <sup>(1)</sup>	K530-3 (FCAW-SS only)							
Magnum® 200	200A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5)		K497-2 K497-1	K498-1	K497-21 <sup>(3)</sup>					
Magnum® 250L	250A@40% CO <sub>2</sub>	12 (3.6) 15 (4.5)		K533-7 (Fixed Gas Nozzle) K533-3 (Adjustable Gas Nozzle)							
Magnum® 300	300A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5)		K470-1 K470-2		K1802-1 <sup>(2)</sup>	K470-4			K470-6	
Magnum® 400 STANDARD	400A@60% CO <sub>2</sub>	10 (3.0) 15 (4.5) 20 (6.1) 25 (7.6)		K471-1 K471-2 K471-10 K471-13	K479-2	K2286-1 <sup>(2)</sup> K471-21 <sup>(2)</sup>	K471-4 K471-11 K471-14	K479-4	K471-22 <sup>(3)</sup>	K471-6 K471-15	K479-6
Magnum® 400 DUAL SCHEDULE	400A@60% CO <sub>2</sub>	15 (4.5)						K575-2			
Magnum® 400 DUAL PROCEDURE	400A@60% CO <sub>2</sub>	15 (4.5)		K1722-2							
Magnum® 400 SHORT NECK	400A@40% CO <sub>2</sub>	15 (4.5)		K541-3							

<sup>(1)</sup> Includes 4-pin MS-type connection for trigger control. <sup>(2)</sup> Includes K466-1 Gun Connector Kit. <sup>(3)</sup> Includes K466-10 Gun Connector Kit.

Gun Model	Amperage Rating	Cable Length ft. (m)	Wire Diameter .052-1/16 in. (1.3-1.6 mm)	Wire Diameter 5/64-3/32 in. (2.0-2.4 mm)
			Gun Connector 600 A Open-End	Gun Connector 600 A Open-End
Magnum® 550	550A@60% CO <sub>2</sub>	15 (4.5)	K598-7	K598-11

### CUSTOMER ASSISTANCE POLICY

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