

LF-72 and LF-74 Wire Feeders

Processes

MIG, Pulsed MIG, Flux-Cored

Product Number

LF-72

LF-74

See page 6 for specs on all models

Input Power

24-42 VAC 50/60 Hz 9 Amps

Rated Output

LF-72 500 Amps @ 60% Duty Cycle

LF-74 600 Amps @ 60% Duty Cycle

Wire Feed Speed Range ipm (m/min)

50-800 (1.3-20.3)

Wire Size Range

Solid: .023-1/16 in. (0.6-1.6 mm)

Cored: .030-5/64 in. (0.8-2.0 mm)

Weight/Dimensions (H x W x D)

(See page 6)

2-Roll or 4-Roll Heavy Duty Industrial Feeders

Designed for MIG and cored wire welding in job shop and manufacturing environments, the rugged LF-72 and LF-74 wire feeders are built to deliver reliable performance day after day.

FEATURES

- ▶ **Patented MAXTRAC® heavy-duty cast aluminum wire drive system** provides reliable feeding and durability.
- ▶ **Brass-to-brass gun connections** for better electrical conductivity that results in better arc performance.
- ▶ **Totally tool-less drive rolls and wire guide installation.** Two or four gear-driven wire drive rolls slide on and off easily!
- ▶ **Calibrated wire feed speed dial** for precise and accurate settings.

RECOMMENDED LINCOLN ELECTRIC POWER SOURCES

- ▶ CV-305, CV-400-I, CV-400, CV-500-I, CV-655, Invertec® V350-PRO, Invertec® V450-PRO, DC-400, DC-600, DC-655

RECOMMENDED COMPETITIVE⁽¹⁾ POWER SOURCES

(requires K2335-1 competitive adapter)

- ▶ Deltaweld⁽¹⁾, Dimension⁽¹⁾, XMT⁽¹⁾ and CP302⁽¹⁾

⁽¹⁾ Trademarks of the Miller Electric Manufacturing Company

APPLICATIONS

- ▶ Heavy Equipment
- ▶ Fabrication
- ▶ Job Shop



Shown with options:
See page 4 for all models

WHAT'S INCLUDED

All LF-72 and LF-74 Units Include:

- ▶ .035-.045 in. (0.9-1.2 mm) drive roll and wire guide kit.

Select Units Include (see page 6):

- ▶ 10 ft. (3.0 m) control cable with 14-pin female connector.
- ▶ 15 ft. (4.5 m) Magnum® PRO 350 gun and cable assembly with .035-.045 in. (0.9 mm-1.2 mm) liner.
- ▶ Standard-Duty wire reel stand.
- ▶ Heavy-Duty wire reel stand.

INPUT



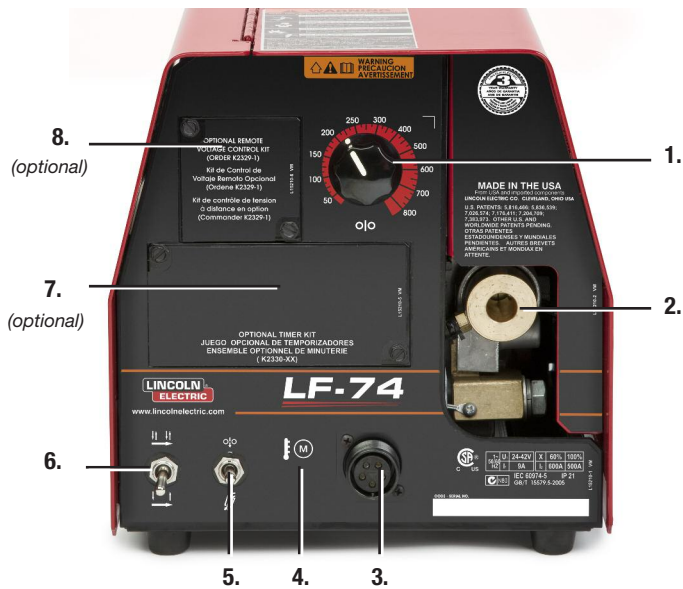
OUTPUT



Two Year Extended Warranty Available.

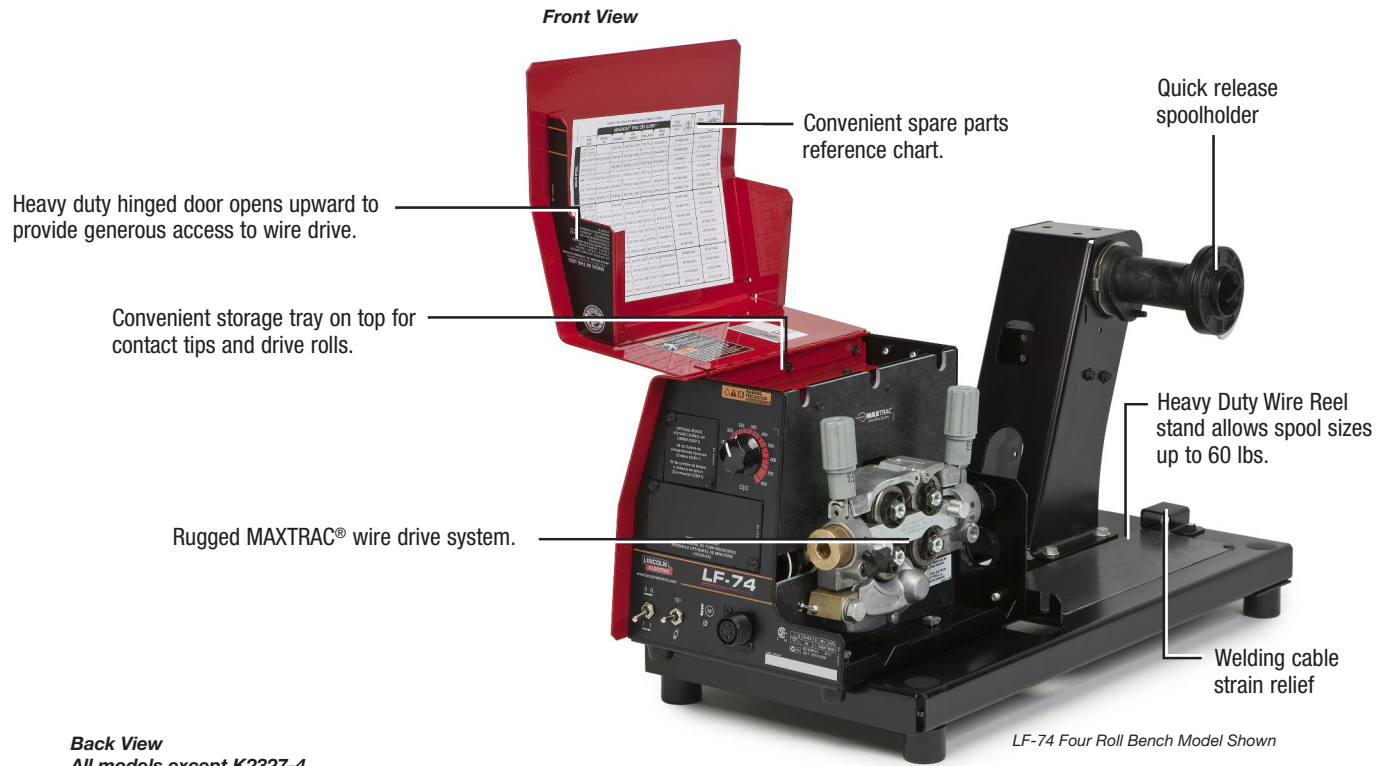


KEY CONTROLS



1. Calibrated Wire Feed Speed Dial
2. Gun Connection (K1500-2)
3. 5-Pin Gun Connection
4. Motor Thermal Protection Light
5. Cold Feed/Gas Purge Switch
6. 2-Step/Trigger Interlock Switch
7. Burnback/Postflow Timer Kit (optional)
8. Remote Voltage Control Kit (optional)

FEATURES



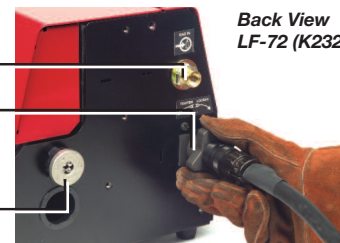
Back View
All models except K2327-4



Gas hose connection inlet.

Control cable connector with Spin-Nut™ for fast, easy, tool-less connection.

Patented ball bearing inlet guide for accurate feeding.



Back View
LF-72 (K2327-4)



MAXTRAC[®]

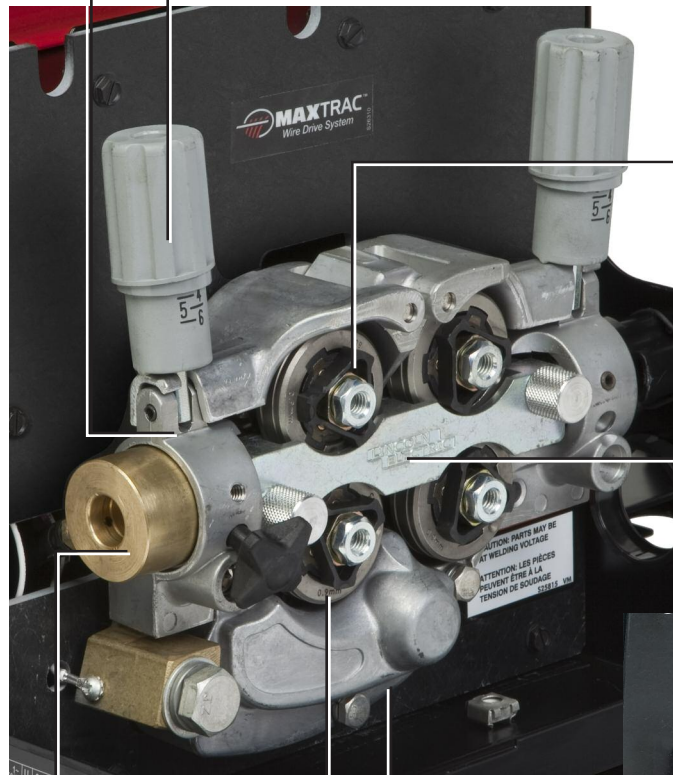
Wire Drive System

Patented Dual Spring Pressure Arm

- Easy turn numeric tension indicator
- Set heavy tension for solid steel and stainless steel wire
- Set moderate tension for cored wires
- Set soft tension for aluminum wire
- Wide idler arm hinge delivers improved drive roll clamping pressure

Rigid Cast Aluminum Frame

- Enhances precise drive roll alignment



LF-74 Four Roll Drive

Twist-Lock Drive Roll Hubs

- Two or four gear driven rolls
- Fast, tool-less changeovers

Patented Split Wire Guides

- Full support for wire throughout the drive path
- Removable outer wire guide for easy access
- No tools required
- No birdnesting

Brass to Brass Interchangeable Gun Bushings

- More reliable electrical conductivity – no oxide build-up
- More efficient energy transfer – lower voltage drops
- Easily adapt any number of Lincoln Magnum[®], Magnum[®] PRO or competitive guns

New Patented Drive Rolls

- For steel - new design delivers 20% more feeding force
- For aluminum - chrome plated to resist build-up

Separate Drive Gear



- Reduces pressure on motor for extended service life



LF-72 Two Roll Drive

OPTIONS

DRIVE ROLL & WIRE GUIDE KITS

Description	 LF-72 Two-Roll	 LF-74 Four-Roll
Solid Wire Sizes (includes stainless steel):		
.023-.030 in. (0.6-0.8 mm)	KP1696-030S	KP1505-030S
.035 in. (0.9 mm)	KP1696-035S	KP1505-035S
.040 in. (1.0 mm)	KP1696-2	KP1505-040S
.045 in. (1.2 mm)	KP1696-045S	KP1505-045S
.052 in. (1.4 mm)	KP1696-052S	KP1505-052S
.035, .045 in. (0.9, 1.2 mm)	KP1696-1 ⁽¹⁾	—
1/16 in. (1.6 mm)	KP1696-1/16S	KP1505-1/16S
Cored Wire Sizes:		
.030-.035 in. (0.8-0.9 mm)	KP1697-035C	KP1505-035C
.045 in. (1.2 mm)	KP1697-045C	KP1505-045C
.052 in. (1.4 mm)	KP1697-052C	KP1505-052C
1/16 in. (1.6 mm)	KP1697-1/16C	KP1505-1/16C
Solid or Cored Wire Sizes:		
.068-.072 in. (1.8 mm)	KP1697-068	KP1505-068
5/64 in. (2.0 mm)	KP1697-5/64	KP1505-5/64
3/32 in. (2.4 mm)	—	KP1505-3/32
Aluminum Wire Sizes:		
.035 in. (0.9 mm)	KP1695-035A	KP1507-035A
.040 in. (1.0 mm)	KP1695-040A	KP1507-040A
3/64 in. (1.2 mm)	KP1695-3/64A	KP1507-3/64A
1/16 in. (1.6 mm)	KP1695-1/16A	KP1507-1/16A

⁽¹⁾ Standard on LF-72.

CONTROL EXTENSION CABLES

Cable Type	Description
Wire Feeder Control Extension Cables	
K1797-10 - 10 ft. (3 m) ⁽¹⁾	Male 14-pin to female 14-pin
K1797-25 - 25 ft. (7.6 m)	
K1797-50 - 50 ft. 15 m)	
K1797-100 - 100 ft. (30 m)	







⁽¹⁾ Standard with all LF-72 (except K2327-4) and LF-74 models.

WELD CABLE REQUIRED

WELD CABLES

Order No.	Description
K1840-10	Twist-Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft.
K1842-10	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. (3.1 m)
K1842-35	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. (10.7 m)
K1842-60	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. (18.3 m)
K1842-110	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. (33.5 m)

FEED PLATE GUN RECEIVER BUSHINGS

K1500-1 Gun Receiver Bushing (Optional)	K1500-2 Gun Receiver Bushing (Standard)	K1500-3 Gun Receiver Bushing (Optional)	K1500-4 Gun Receiver Bushing (Optional)	K1500-5 Gun Receiver Bushing (Optional)	K489-7 Fast-Mate™ Gun Receiver Bushing (Optional)
<p>Magnum® PRO 250, 350 and 450 or Magnum® 200, 300 and 400 gun and cable assemblies with K466-1 connector kit.</p> <p>Magnum® Self-shielded Innershield® gun and cable assembly.</p> <p>Magnum® PRO 550 or Magnum® 550 gun and cable assembly with K613-1 connector kit.</p>	<p>Magnum® PRO 350 Gun Package with 035-045 liner and K466-10 connector kit (K2652-2-10-45)</p> <p>Magnum® PRO 450 Gun Package with 035-045 liner and K466-10 connector kit (K2653-2-10-45)</p> <p>Magnum® 200 and 400 fully assembled guns (K497-2x and K471-2x).</p> <p>Magnum® PRO 250, 350 and 450 or Magnum® 200, 300 and 400 gun and cable assemblies with K466-10 connector kit.</p> <p>Guns with Tweco® #2, #3, and #4 connectors.</p>	<p>Magnum® PRO 550 or Magnum® 550 gun and cable assembly with K613-7 connection.</p> <p>Guns with Tweco® #5 connectors.</p>	<p>Magnum® PRO 250, 350 and 450 or Magnum® 200, 300 and 400 gun and cable assemblies with K466-3 connector kit.</p>	<p>To adapt to OXO® guns.</p>	<p>Magnum® gun and cable assemblies with Fast-Mate connections.</p> <p>Handles both single and dual procedure guns.</p>
					

RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES

GENERAL OPTIONS



Magnum® PRO Gun and Cable Assemblies
250-550 amps, air-cooled, gas-shielded welding guns. See publication E12.01



Magnum® Self-Shielded Innershield® Gun and Cable Assemblies
Available 200-550 amps, air-cooled, gas-shielded welding guns. See publication E12.10



Magnum® Self-Shielded Innershield® Gun and Cable Assemblies
Available 250-600 amps. See publication E12.110



Postflow and Burnback Timer Kit
Provides adjustable delay of power source output shut off to prevent electrode sticking in crater when using high wire feed speeds. Order K2330-1



Remote Voltage Control Kit
Allows arc voltage to be changed at the feeder. Order K2329-1



Incoming Bushing for Lincoln Conduit
Feed Plate Incoming Bushings connect directly to wire conduit (not included), for use in boom system, long distances, or large payoff packages. Bushings can be used with any wire conduit (K515 or K565).
Order K1546-1 for .025-1/16 in. (0.6 - 1.6 mm) wire
Order K1546-2 for 1/16-1/8 in. (1.6 - 3.2 mm) wire



Spindle Adapter for Readi-Reels® and Spools
For fixture and other custom installations. Features 2 in. (51 mm) O.D. spindle for mounting Readi-Reels® and 2 in. (51 mm) I.D. spools up to 60 lb. (27.2 kg) capacity. Order K162-1



Deluxe Adjustable Gas Regulator & Hose Kit
Accommodates CO₂, Argon, or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose. Order K586-1



Harris® Argon Flowmeter/Regulator and Hose Kit
Order 3100211



Adapter for Competitive Power Sources
Allows wire feeder to connect to select Miller Electric® power sources. Order K2335-1



Control Cable to Terminal Strip Adapter
Connects 14-pin control cable to power sources with terminal strip. Order K1798



115V/42V Transformer Kit
Provides a way to use the wire feeder on power sources that have 115V AC available on the terminal strip. Order K1520-1



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 E13.40



Standard Duty Wire Reel Stand
For use with Lincoln 10-44 lb. (4.5-20 kg) wire packages that use a 2 in. (51 mm) spindle. Order K2328-1



Heavy Duty Wire Reel Stand
For use with Lincoln 10-60 lb. (4.5-27.2 kg) wire packages that use a 2 in. (51 mm) spindle. Hole in stand fits over lift bail. Order K1524-3



Swivel Platform
Mounts to the lift bail on the power source and bottom of the Heavy Duty Wire Reel stand. Wire feeder may be lifted off if needed. Compatible with Light Duty Caster Kit. Includes "lazy susan" parts tray. Order K1557-1



14 lb. Innershield® Coil Adapter
Permits 14 lb. (6 kg) Innershield® electrode coils to be mounted on 2 in. (51 mm) O.D. spindles. Order K435



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



Wire Reel Cover Kit
Plastic enclosure for up to 44 lb. (20 kg) wire packages. Order K1634-1



ADDITIONAL OPTIONS FOR FEEDERS EQUIPPED WITH HEAVY DUTY WIRE REEL STAND
Insulated Lift Bail
Allows the entire wire feeder to be hung from a crane or hook. Use with Heavy Duty Wire Reel Stand. Order K1555-1



Caster Kit — Light Duty
Mounts to the Heavy Duty Wire Reel Stand. Allows for easy movement of wire feeder. Order K1556-1



Undercarriage
Includes mounting frame, front casters, rear wheels and handle for hand towing. For use with Wire Reel Stands. Order K163



50-60 lb. Coil Adapter
Adapts 50-60 lb. (22.6-27.2 kg) coils of Lincoln wire to 2 in. (51 mm) spindle. Order K1504-1




Plastic Wire Cover Kit
Plastic enclosure for up to 60 lb. (27.2 kg) wire packages. Order K1634-2

NOTE:
Miller Electric® is not a trademark of The Lincoln Electric Company.

WIRE FEEDER SELECTION GUIDE

LF-72

Number of Rolls: 

Inches Per Minute (m/min):
50-800 (1.3-20.3)

Wire Size:
in. (mm)

Solid .023-1/16 (0.6-1.6)
Cored .030-5/64 (0.8-2.0)

LF-72 Base Model
(no gun, no control cable)
(K2327-4)



For boom mounting
or for use with bulk
consumables.

Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045

LF-72 Bench Model, Standard Duty (K2327-5)
Shown with optional wire.



For most welding needs that
require a rugged
and dependable wire
feed system.

Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Magnum® PRO 350 Gun and Cable Assembly
- Control Cable 10' (3 m)

LF-72 Bench Model, Heavy Duty (K2327-6)
Shown with optional wire.



For applications
requiring up to 60 lb. wire
packages.

Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Magnum® PRO 350 Gun and Cable Assembly
- Control Cable 10' (3 m)

LF-72 Bench Model, Heavy Duty (no gun) (K2327-7)
Shown with optional wire.




For applications
requiring up to 60 lb. wire
packages.

Unit Includes:

- Drive Roll and Wire Guide Kit .035-.045
- Control Cable 10' (3 m)

LF-74

Number of Rolls: 

Inches Per Minute (m/min):
50-800 (1.3-20.3)

Wire Size:
in. (mm)

Solid .023-1/16 (0.6-1.6)
Cored .030-5/64 (0.8-2.0)

LF-74 Base Model
(no gun)
(K2426-4)



For boom mounting
or for use with bulk
consumables.

Unit Includes:

- Drive Roll and Wire Guide Kit
- Control Cable 10' (3 m)

LF-74 Bench Model, Heavy Duty (no gun) (K2426-5)
Shown with optional wire.



For applications
requiring up to 60 lb. wire
packages.

Unit Includes:

- Drive Roll and Wire Guide Kit
- Control Cable 10' (3 m)
- Heavy Duty Wire Reel Stand

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Output Capacity Current / Duty Cycle	Wire Feed Speed Range ipm (m/min.)	Wire Size Range In. (mm)	H x W x D inches (mm)	Net Weight lbs. (kg)
LF-72 Base Model (w/o gun or cable)	K2327-4	24-42 VAC 50/60 Hz 9 Amps	500 Amps @ 60%	50-800 (1.3-20.3)	Solid .023-1/16 (0.6-1.6) Cored .030-5/64 (0.8-2.0)	11.1 x 10.2 x 12.9 (282 x 259 x 328)	24 (11)
LF-72 Bench Model Standard Duty	K2327-5					12.6 x 10.9 x 22.5 (320 x 277 x 572)	52 (24)
LF-72 Bench Model Heavy Duty	K2327-6					15.3 x 13.0 x 27.7 (389 x 330 x 704)	69 (31)
LF-72 Bench Model Heavy Duty (w/o gun)	K2327-7					15.3 x 13.0 x 27.7 (389 x 330 x 704)	63 (29)
LF-74 Base Model	K2426-4					11.1 x 10.2 x 12.9 (282 x 259 x 328)	27 (12)
LF-74 Bench Model Heavy Duty	K2426-5	15.3 x 13.0 x 27.7 (389 x 330 x 704)	63 (29)				

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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