

# Magnum<sup>®</sup> PRO AL Push-Pull Guns

## Processes

MIG, Pulsed MIG for Aluminum

## Product Number

See product specification table on back for details

See back for details

## Amperage Rating 100% Argon Gas:

Air-Cooled: 225A @ 60% Duty Cycle

Water-Cooled: 450A @ 60% Duty Cycle

## Wire Diameter Range: in (mm)

0.035 - 1/16 (0.9 - 1.6) Aluminum

## Cable Length: ft (m)

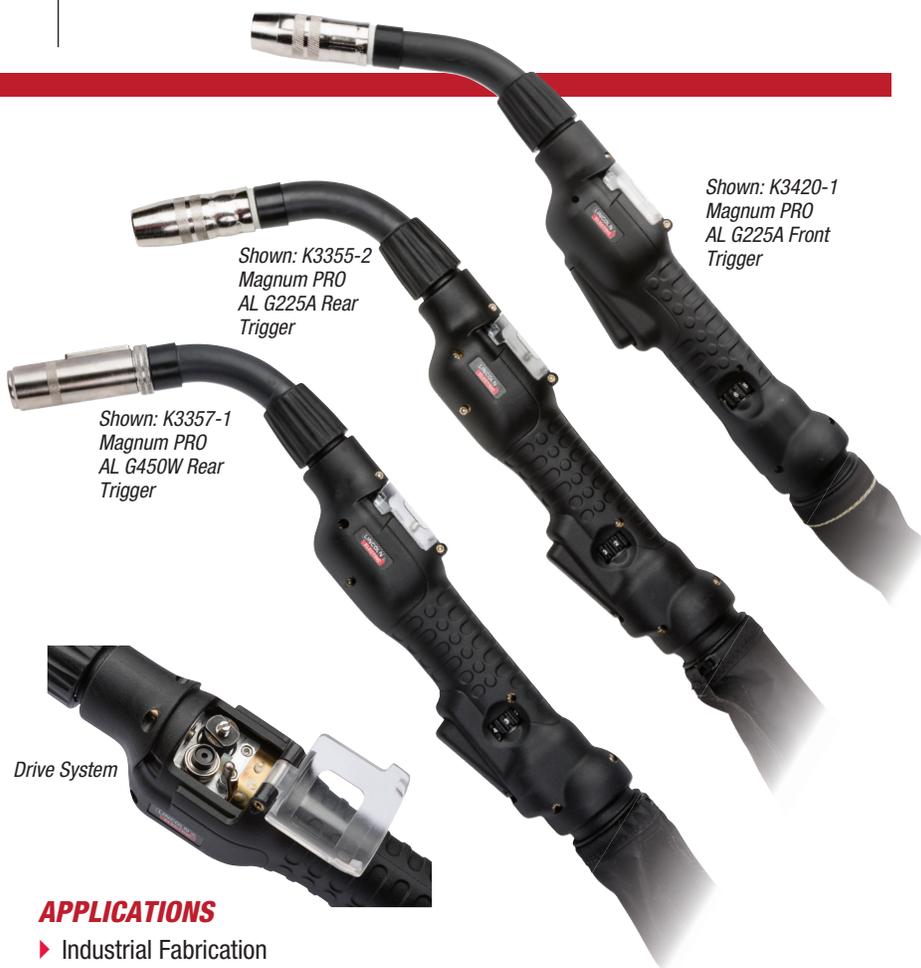
See back for details

## Aluminum Push-Pull Gun

The new Magnum<sup>®</sup> PRO AL models are designed to optimize a push-pull welding operation for aluminum by integrating features that will reduce downtime.

### FEATURES

- ▶ **Superior push-pull wire feeding technology** – Reduces friction in the wire feed path, resulting in smooth feeding and minimizing damage to the wire.
- ▶ **Quick-Change Liner** – Simply remove the set screw to quickly and easily change the liner.
- ▶ **Magnum PRO expendables** – Utilizes common expendables with all Magnum PRO MIG Guns. 550A expendables are standard with the Magnum PRO AL.
- ▶ **Patented EZ-Lock™ system** – Allows you to change or rotate barrels anytime.
- ▶ **Lightweight, ergonomic handle** – Weight distribution is equally balanced between front and back for better feel and control.
- ▶ **Recessed adjustment dial** – Conveniently located on the bottom of the handle to prevent a change while welding.
- ▶ **Flip-up drive roll cover** – Located at the thumb rest for easy access to wire. Quick wire release for easy wire adjustments.
- ▶ **Complete with a insulated groove drive roll and an insulated idler roll** – Provides a consistent arc. Drives will handle aluminum wire from 0.035 - 1/16 in. (0.9 - 1.6 mm) diameter.



### APPLICATIONS

- ▶ Industrial Fabrication
- ▶ Heavy Equipment
- ▶ Automotive

### RECOMMENDED WIRE FEEDERS

- ▶ Power Feed<sup>®</sup> 84
- ▶ Power Feed 25M
- ▶ Power Feed 25M Aluminum

### RECOMMENDED WIRE FEEDER/WELDERS

- ▶ POWER MIG<sup>®</sup> 350MP
- ▶ Power Wave<sup>®</sup> C300

INPUT



OUTPUT



THE LINCOLN ELECTRIC COMPANY

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CONTACT TIPS 350A <sup>(1)</sup>	
Wire Diameter in. (mm)	Order Number
0.035 (0.9)	KP2744-035AT
3/64 (1.2)	KP2744-364AT KP2744-364AT5356 KP2744-364AT-B100 <sup>(1)</sup>
1/16 (1.6)	KP2744-116AT KP2744-116AT5356 KP2744-116AT-B100 <sup>(1)</sup>

(1)Sold in quantity of 100

CONTACT TIPS SPRING LOADED 550A	
Wire Diameter in. (mm)	Order Number
0.035 (0.9)	KP3374-035A
3/64 (1.2)	KP3374-364A

CONTACT TIPS 550A <sup>(1)</sup>	
Wire Diameter in. (mm)	Order Number
0.035 (0.9)	KP2745-035AT
3/64 (1.2)	KP2745-364AT <sup>(1)</sup> KP2745-364AT5356 KP2745-364AT-B100 <sup>(2)</sup>
1/16 (1.6)	KP2745-116AT KP2745-AT5356 KP2745-116AT-B100 <sup>(2)</sup>

(1)This size tip furnished with gun  
(2)Sold in quantity of 100

CONDUIT LINERS	
Description ft (m)	Order Number
Conduit Liner – 15 (4.5)	KP3991-15
Conduit Liner – 25 (7.6)	KP3991-25
Conduit Liner – 35 (10.6)	KP3991-35
Conduit Liner – 50 (15.2)	KP3991-50

JUMP LINERS	
Description in. (mm)	Order Number
Jump Liner 1/16 (1.6)	KP3376-1
Jump Liner 0.035 - 3/64 (0.9 -1.2)	KP3376-3

COOLANT	
Description in. (mm)	Order Number
1 Gallon (order in multiples of 4)	KP3379-4
5 Gallon	KP3379-5

DRIVE ROLLS	
Description in. (mm)	Order Number
Knurled Insulated	KP3990-1
0.035 (0.89) Groove Insulated <sup>(1)</sup>	KP3989-1
3/64 (1.19) & 1/16 (1.59) Groove Insulated <sup>(1)</sup>	KP3989-2

(1) includes drive roll and insulated idler roll assembly

OPTIONAL 6 in. STRAIGHT AND CURVED GUN TUBE ASSEMBLIES		
350A/550A Expendables Compatibility/Threaded Diffuser		
Compatible Guns	Degree	Order Number
Straight, Air- & Water-Cooled	180°	KP3380-180
Air- & Water-Cooled	60°	KP3380-60
Air- & Water-Cooled	45°	KP3380-45 <sup>(3)</sup>
550A Expendables ONLY/Fixed Diffuser		
Straight & Water-Cooled Gun Tube Assembly	180°	KP3381-180 <sup>(1)</sup>
Water-Cooled Gun Assembly	60°	KP3381-60 <sup>(4)</sup>
Water-Cooled Gun Assembly	45°	KP3381-45 <sup>(1)</sup>
Air- & Water-Cooled	60°	KP3988-60 <sup>(2)</sup>
Air- & Water-Cooled	45°	KP3988-45 <sup>(2)</sup>

- (1) Water-Cooled ONLY. Diffuser and nozzles are both water cooled. Use with water-cooled nozzle KP3375-1  
(2) Diffuser is water-cooled. Nozzle is standard air-cooled Magnum PRO 550A Expendable (KP2743-1-62RA)  
(3) Included with K3355-XX and K3356-XX guns  
(4) Included with K3357-XX and K3358-XX guns

IDLER ROLLS	
Description in. (mm)	Order Number
3/64 (1.19) Insulated	KP3992-364
0.035 (0.89) Insulated	KP3992-035
1/16 (1.59) Insulated	KP3992-116

### RECOMMENDED ACCESSORIES



**7-pin to 12-pin Adapter**  
Use for connecting 7-pin push-pull guns such as the Magnum® PRO AL to a 12-pin feeder connector.  
**Order K2910-1**

350A SERIES EXPENDABLES	
Description	Order Number
Gas Diffuser, each	KP2746-1
Gas Diffuser, 25 pcs.	KP2746-1-B25
Insulator, 350A Gun Tube, each	KP3982-1
Insulator, 350A Gun Tube, 25 pcs.	KP3982-1-B25
Gas Nozzle Assembly 5/8 in (15.9 mm)	KP2742-1-62R

For all possible options, reference bulletin E12.09.

550A SERIES EXPENDABLES	
Description	Order Number
Gas Diffuser	KP2747-1A
Insulator, 550A Gun Tube, each	KP3982-2
Insulator, 550A Gun Tube, 25 pcs.	KP3982-2-B25
Gas Nozzle Assembly 5/8 in (15.9 mm)	KP2743-1-62RA

Use with water-cooled nozzle KP3375-1  
For all possible options, reference bulletin E12.09

PRODUCT SPECIFICATIONS						
Product Name	Product Number 12-Pin	Product Number 7-Pin	Amperage Rating 100% Argon Gas	Wire Diameter Range in (mm)	Cable Length ft (m)	
Magnum® PRO AL G225A Front Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip)	K3420-1	K3421-1	225A @ 60% Duty Cycle	0.035 - 1/16 (0.9 - 1.6) aluminum and cored wire	15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)	
	K3420-2	K3421-2				
	K3420-3	K3421-3				
	K3420-4	K3421-4				
Magnum® PRO AL G225A Rear Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip)	K3355-1	K3356-1	450A @ 60% Duty Cycle		15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)	
	K3355-2	K3356-2				
	K3355-3	K3356-3				
	K3355-4	K3356-4				
Magnum® PRO AL G450W Front Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3422-1	K3423-1			15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)	
	K3422-2	K3423-2				
	K3422-3	K3423-3				
	K3422-4	K3423-4				
Magnum® PRO AL G450W Rear Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3357-1	K3358-1			15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)	
	K3357-2	K3358-2				
	K3357-3	K3358-3				
	K3357-4	K3358-4				

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

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