

# 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



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

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

## 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**

## 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 K3420-2 K3420-3 K3420-4	K3421-1 K3421-2 K3421-3 K3421-4	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)
Magnum® PRO AL G225A Rear Trigger (Includes Gooseneck KP3380-60 and 3/64 in. 550A Contact Tip)	K3355-1 K3355-2 K3355-3 K3355-4	K3356-1 K3356-2 K3356-3 K3356-4			15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)
Magnum® PRO AL G450W Front Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3422-1 K3422-2 K3422-3 K3422-4	K3423-1 K3423-2 K3423-3 K3423-4	450A @ 60% Duty Cycle		15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)
Magnum® PRO AL G450W Rear Trigger (Includes Gooseneck KP3381-60 and 3/64 in. 550A Contact Tip)	K3357-1 K3357-2 K3357-3 K3357-4	K3358-1 K3358-2 K3358-3 K3358-4			15 (4.5) 25 (7.6) 35 (10.6) 50 (15.2)

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

## CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.

**LINCOLN®**  
**ELECTRIC**  
THE WELDING EXPERTS®