

POWER FEED® 84 and POWER FEED® 84 DUAL

DIGITAL SEMIAUTOMATIC WIRE FEEDERS



Shown: Power Feed 84 - Single (K3328-7)
Power Feed 84 - Dual (K3330-7)

ADVANCED PROCESS WIRE FEEDERS

The Power Feed 84 family raises the bar for advanced process feeders by providing comprehensive process adjustability and control in a simple to use, rugged design.

Processes (Power source controlled »

MIG, Pulsed MIG, MIG-STT®, Flux-Cored, Stick, TIG, Gouging, HyperFill™

Output »



Input »



Recommended Power Sources »

Power Wave® 455M, Power Wave 455M/STT®, Power Wave S350, Power Wave S500, Power Wave S700, Flextec® 350X, Flextec 500X, Flextec 650X

Product Number »

K3328-XX Single Feeder Models
K3330-XX Dual Feeder Models
K3336-XX Control Boxes

FEATURES

» Simple & Customizable Controls

- Intelligent auto-Settings simplify process setup and control
- Eight User Memories – Per feed head for complete welding procedure recall
- USB Port – Simplifies machine setup and expands user profiles
- User Interface – Can be customized to display customer specific information
- Contactor and gouge kit isolate the feedheads for additional safety

» Rugged Design

- Improved isolation and environmental protection
- Robust connection points allow for reliable operation in tough conditions

» Modular Platform

- Modularity ensures the feeder can be configured to fit a variety of application needs

KEY CONTROLS

1. Amperage and voltage displays
2. Mode selection and customizable process display
3. Process configuration menus
4. Dual procedure setup
5. Feed head selection
6. User memory selection
7. USB port
8. 12 pin remote connection
9. Gun trigger connector (5 pin amphenol)
10. Cold feed and gas purge



4-ROLL WIRE DRIVE SYSTEMS

Product Name	Product Number	Description/Wire Size, in (mm)
4-ROLL WIRE DRIVE SYSTEMS		
Solid Wire, Smooth V Groove	KP1505-030S	0.023-0.030 [0.6-0.8]
	KP1505-035S	0.035 [0.9]
	KP1505-040S	0.040 [1.0]
	KP1505-045S	0.045 [1.2]
	KP1505-052S	0.052 [1.4]
	KP1505-1/16S	1/16 [1.6]
	KP1505-1	0.035, 0.045 [0.9, 1.2]
Cored Steel Wire, Knurled V Groove (Knurled V Groove with matching Smooth U Groove)	KP1505-035C	0.030-0.035 [0.8-0.9]
	KP1505-045C	0.040-0.045 [1.0-1.2]
	KP1505-052C ^(b)	0.052 [1.4]
	KP1505-1/16C ^(b)	1/16 [1.6]
	KP1505-7/64H ^{(2)(b)}	7/64 [2.8] Hardfacing

Product Name	Product Number	Description/Wire Size, in (mm)
4-ROLL WIRE DRIVE SYSTEMS		
Cored or Solid Steel Wire, Knurled V Groove	KP1505-068 ⁽³⁾	0.068-0.072 [1.7-1.8]
	KP1505-5/64 ⁽³⁾	5/64 [2.0]
	KP1505-3/32 ⁽³⁾	3/32 [2.4]
	KP1505-7/64 ⁽²⁾⁽³⁾	7/64 [2.8]
	KP1505-120 ⁽²⁾⁽³⁾	0.120 [3.2]
Hardfacing Wires, Knurled, Smooth V Groove	KP1505-7/64C	7/64 [2.8]
	KP1505-7/64H ⁽²⁾⁽³⁾	7/64 [2.8] Hardfacing
Aluminum Wire, Smooth U Groove	KP1507-035A	0.035 [0.9]
	KP1507-040A	0.040 [1.0]
	KP1507-3/64A	3/64 [1.2]
	KP1507-1/16A ^(b)	1/16 [1.6]
	KP1507-3/32A ⁽²⁾	3/32 [2.4]
Solid Wire, Extended Life	KP1505-035R	0.035 [0.9]
	KP1505-040R	0.040 [1.0]
	KP1505-045R	0.045 [1.2]
	KP1505-052R	0.052 [1.4]
HyperFill	KP4388-1	0.035-0.040 [0.9 -1.0]
	KP4388-2	0.045 [1.2]


MAGNUM PRO GUN READY-PAK PACKAGES

Product Name	Product Number	Cable Length ft (m)	Rated Current (Amps) CO ₂ /Mixed	Duty Cycle (%) CO ₂ /Mixed	Wire Diameter Range in (mm)
Magnum® PRO Curve™ Series Ready-Pak Packages					
200 Series	K2950-2-10-45 ⁽¹⁾	15 [4.5]	200/150	60/60	0.035-0.045 in. [0.9-1.2 mm]
300 Series	K2951-2-10-45 ⁽¹⁾				0.052-1/16 in. [1.3-1.6 mm]
	K2951-2-10-116 ⁽²⁾				
400 Series	K2952-2-10-45 ⁽¹⁾		400/400	60/50	0.025-5/64 [0.6-2.0]
Magnum® PRO Barrel Guns Ready-Pak Packages					
350 Gun	K2652-2-10-45 ⁽³⁾	15 [4.5]	350/285	100/100	0.035-0.045 [0.9-1.2]
450 Gun	K2653-2-10-45 ⁽³⁾	15 [4.5]	450/325	100/100	0.035-0.045 [0.9-1.2]

⁽¹⁾Includes 0.035-0.045 in. [0.9-1.2 mm] Liner and K466-10 Connector Kit.⁽²⁾Includes 0.052-1/16 in. [1.3-1.6 mm] Liner and K466-10 Connector Kit.⁽³⁾Includes 0.035-0.045 [0.9-1.2 mm] Liner and K466-6 Connector Kit.

REQUIRED OPTIONS

CONTROL CABLES AND ADAPTERS

Product Name	Product Number	Description	Connection	Use	Length ft (m)
	K1543-8	ArcLink®/Linc-Net™ Control Cable	Male 5-pin to Female 5-pin	For Power Wave®/Power Feed® Systems, Power Feed 25M, Power Feed 84	8 [2.4]
	K1543-25				25 [7.6]
	K1543-50				50 [15.2]
	K1543-100				100 [30.4]
	K2683-25	Heavy Duty ArcLink® Control Cable			25 [7.6]
	K2683-50				50 [15.2]
	K2683-100				100 [30.4]

FEED PLATE GUN ADAPTERS COMPATIBLE WITH FLEX FEED™ AND POWER FEED® SERIES FEEDERS

K3344-1	K3345-1	K3346-1	K3347-1	K3348-1	K3349-1
For Lincoln Electric gun power pins Compatible Gun Connector Kits K466-1 K613-1 K613-6 K466-8	for Tweco® #2 - #4 gun power pins Compatible Gun Connector Kits K466-10 K466-2 K466-6	for Tweco® #5 gun power pin Compatible Gun Connector Kits K613-7 K613-2	for Miller® Electric gun power pins Compatible Gun Connector Kits K466-3 K613-3	for OXO® gun power pins	Magnum® Fast-Mate™ Requires use of K3344-1
					

RECOMMENDED ACCESSORIES

GENERAL OPTIONS

Gouging Contactor Kit

Includes contactors and a switch to change electrode power from the feeder to a gouging torch.

Order K3974-1



Inlet Bushing, Quick Connect Style

Included with Power Feed 84 feeders without a wire reel stand.

Order K3929-1



Wire Straightener

Straightens wire for the better, smoother feeding.

Order K1733-1

Coil Adapter

50-60 lb (22.7-27.2 kg) coil adapter for 2 inch spindles. For use with K3343-1 heavy duty wire reel stand.

Order K1504-1



Wire Reel Stands – Standard Duty

Use for spools up to 44 lbs. (20 kg) max.

Order K3342-1



Wire Reel Stands - Heavy Duty

For Spools up to 44 lbs. (20 kg) and coils up to 60 lbs. (27.2 kg). Includes K3341-1 lift bail.

Order K3343-1



Lift Bail

Insulated lift bail for suspending the wire feeder. Requires either standard duty or heavy duty wire reel stand.

Order K3341-1



Dual Reel Stand - HyperFill™

Dual spools and mounting hardware to run HyperFill process.

Order K4630-1



Spool Cover

Insulated lift bail for suspending the wire feeder. Requires either standard duty or heavy duty wire reel stand.

Order

K1634-4 for use with 30-40 lb. (13.6-18.1 kg) spools

K3340-1 for use with 50-60 lb (22.7-27.2 kg) coils.



Shielding Gas Filter

Protects the gas solenoid and gun from contaminants.

Order KP3103-1

Inverter Cart Mounting Kit

Use for mounting feeder to an inverter cart.

Order K4068-1



Gas Flow Sensor Kit

Allows for digital readout of gas flow inside Power Feed 84. Integrates with CheckPoint® Production Monitoring.

Order K3338-1

PRODUCT SPECIFICATIONS

Product Name	Product Number	User Interface	Reel Stand		Gouge Kit	Contactor	Input Power	Output Capacity Current/ Duty Cycle	Wire Size Range in. (mm)	Wire Feed Speed ipm (m/min)	H x W x D inches (mm)	Net Wt. lbs (kg)	Avail- ability
			Standard	Heavy Duty									
Single Wire Drive													
Power Feed 84	K3328-1						40 VDC	600A/60% (wire drive only)	Solid ^(B) .025-3/32 [0.6-2.4]	50-1200 (1.3-30.4) ⁽¹⁾⁽²⁾	25.2 x 15.5 x 27.9 [640 x 394 x 709] single wire drive	36 [16.3]	S
	K3328-3	•						38 [17.2]				S	
	K3328-7	•	•					54 [24.4]	P				
	K3328-13	•		•				62 [28.1]	S				
	K3328-12	•			•			38 [17.2]	S				
Dual Wire Drive													
Power Feed 84	K3330-1						40 VDC	600A/60% (wire drive only)	Solid ^(B) .025-3/32 [0.6-2.4]	50-1200 (1.3-30.4) ⁽¹⁾⁽²⁾	25.2 x 22.5 x 30.6 [640 x 572 x 777] dual wire drive	64 [29.0]	S
	K3330-3	•						500A/60% (wire drive w/gouging kit)				66 [29.9]	S
	K3330-7	•	•					600A/30% (gouging stud)	93 [42.1]			P	
	K3330-10	•		•				109 [49.4]	P				
	K3330-5	•		•		•		119 [53.9]	S				
Boom Control Boxes Only													
Power Feed 84	K3336-2	•					40 VDC					6.5 [2.9]	S
	K3336-3											6.5 [2.9]	S

For best welding results with Lincoln Electric® equipment, always use Lincoln Electric consumables. Visit 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 for any updated information.

The Lincoln Electric Company
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
www.lincolnelectric.com