

# 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]
<b>4-ROLL WIRE DRIVE SYSTEMS</b>		
<b>Solid Wire, Smooth V Groove</b>  *Heavy duty tool-steel drive rolls designed for maximum life. Recommended for automated and high WFS applications.	KP1505-030S	0.023-0.030 [0.6-0.8]
	KP1505-035S	0.035 [0.9]
	KP1505-035R*	
	KP1505-040S	0.040 [1.0]
	KP1505-040R*	
	KP1505-045S	0.045 [1.2]
	KP1505-045R*	
	KP1505-052S	0.052 [1.4]
	KP1505-052R*	
	KP1505-1/16S	1/16 [1.6]
KP1505-1	0.035, 0.045 [0.9, 1.2]	
<b>Cored Steel Wire, Knurled V Groove [Knurled V Groove with matching Smooth U Groove]</b>	KP1505-035C	0.030-0.035 [0.8-0.9]
	KP1505-045C	0.040-0.045 [1.0-1.2]
	KP1505-052C <sup>(3)</sup>	0.052 [1.4]
	KP1505-1/16C <sup>(3)</sup>	1/16 [1.6]
	KP1505-7/64H <sup>(2)(3)</sup>	7/64 [2.8] Hardfacing

Product Name	Product Number	Description/Wire Size, in [mm]
<b>4-ROLL WIRE DRIVE SYSTEMS</b>		
<b>Cored or Solid Steel Wire, Knurled V Groove</b>	KP1505-068 <sup>(3)</sup>	0.068-0.072 [1.7-1.8]
	KP1505-5/64 <sup>(3)</sup>	5/64 [2.0]
	KP1505-3/32 <sup>(3)</sup>	3/32 [2.4]
	KP1505-7/64 <sup>(2)(3)</sup>	7/64 [2.8]
	KP1505-120 <sup>(2)(3)</sup>	0.120 [3.2]
<b>Hardfacing Wires, Knurled, Smooth V Groove</b>	KP1505-7/64C	7/64 [2.8]
	KP1505-7/64H <sup>(2)(3)</sup>	7/64 [2.8] Hardfacing
<b>Aluminum Wire, Smooth U Groove</b>	KP1507-035A	0.035 [0.9]
	KP1507-040A	0.040 [1.0]
	KP1507-3/64A	3/64 [1.2]
	KP1507-1/16A <sup>(3)</sup>	1/16 [1.6]
	KP1507-3/32A <sup>(2)</sup>	3/32 [2.4]
<b>HyperFill</b>	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 <sub>2</sub> /Mixed	Duty Cycle (%) CO <sub>2</sub> /Mixed	Wire Diameter Range in (mm)
<b>Magnum® PRO Curve™ Series Ready-Pak Packages</b>					
200 Series	K2950-2-10-45 <sup>(1)</sup>	15 (4.5)	200/150	60/60	0.035-0.045 in. [0.9-1.2 mm]
300 Series	K2951-2-10-45 <sup>(1)</sup>				0.052-1/16 in. [1.3-1.6 mm]
	K2951-2-10-116 <sup>(2)</sup>				
400 Series	K2952-2-10-45 <sup>(1)</sup>	400/400	60/50	0.025-5/64 [0.6-2.0]	
<b>Magnum® PRO Barrel Guns Ready-Pak Packages</b>					
350 Gun	K2652-2-10-45 <sup>(3)</sup>	15 (4.5)	350/285	100/100	0.035-0.045 [0.9-1.2]
450 Gun	K2653-2-10-45 <sup>(3)</sup>	15 (4.5)	450/325	100/100	0.035-0.045 [0.9-1.2]


<sup>(1)</sup>Includes 0.035-0.045 in. [0.9-1.2 mm] Liner and K466-10 Connector Kit.

<sup>(2)</sup>Includes 0.052-1/16 in. [1.3-1.6 mm] Liner and K466-10 Connector Kit.

<sup>(3)</sup>Includes 0.035-0.045 [0.9-1.2 mm] Liner and K466-10 Connector Kit.

**REQUIRED OPTIONS**

**CONTROL CABLES AND ADAPTERS**

Product Name	Product Number	Description	Connection	Use	Length ft (m)
<b>ArcLink Control Cables</b> 	K4483-8	Extended-Flex ArcLink® Control Cable	Male 5-pin to Female 5-pin	For Power Wave®/Power Feed® Systems, Power Feed 25M, Power Feed 84	8 (2.4)
	K4483-16				16 (4.9)
	K4483-25				25 (7.6)
	K4483-50	Heavy Duty ArcLink® Control Cable			50 (15.2)
	K4483-100				100 (30)

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

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

**RECOMMENDED ACCESSORIES**

**GENERAL OPTIONS**



**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**



**Protective Wire Spool Cover**  
Protective wire spool cover.  
**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) spools.



**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			Input Power	Rated Output: Current/Voltage/Duty Cycle	Wire Feed Speed Range: ipm (m/min)	Wire Size Range in (mm)	H x W x D inches (mm)	Net Wt. lbs (kg)			
			Standard	Heavy Duty	Gouge Kit							Contactor		
<b>Single Wire Drive</b>														
Power Feed 84	K3328-1					40 VDC	600A/60% (wire drive only)	50-750 (1.3-19.0)	SOLID: 0.025-1/16 (0.6-1.6)	25.2 x 15.5 x 27.9 (640 x 394 x 709) single wire drive	36 (16.3)			
	K3328-3	•										50-1200 (1.3-30.4) <sup>(1)</sup>	0.025-0.045 (0.6-1.2) <sup>(1)</sup>	38 (17.2)
	K3328-7	•	•									500A/60% (wire drive w/ gouging kit)	CORED: 0.035-5/64 (0.9-2.0)	54 (24.4)
	K3328-13	•		•								600A/30% (gouging stud)	0.035-1/16 (0.9-1.6) <sup>(1)</sup>	62 (28.1)
	K3328-12	•			•									38 (17.2)
<b>Dual Wire Drive</b>														
Power Feed 84	K3330-1					40 VDC	600A/60% (wire drive only)	50-750 (1.3-19.0)	SOLID: 0.025-1/16 (0.6-1.6)	25.2 x 22.5 x 30.6 (640 x 572 x 777) dual wire drive	64 (29.0)			
	K3330-3	•										50-1200 (1.3-30.4) <sup>(1)</sup>	0.025-0.045 (0.6-1.2) <sup>(1)</sup>	66 (29.9)
	K3330-7	•	•									500A/60% (wire drive w/ gouging kit)	CORED: 0.035-5/64 (0.9-2.0)	93 (42.1)
	K3330-10	•		•								600A/30% (gouging stud)	0.035-1/16 (0.9-1.6) <sup>(1)</sup>	109 (49.4)
	K3330-5	•		•							•			119 (53.9)
<b>Boom Control Boxes Only</b>														
Power Feed 84	K3336-2	•				40 VDC					6.5 (2.9)			
	K3336-3											6.5 (2.9)		

(1) When used with optional 30 tooth pinion gear. 20 tooth pinion gear installed from factory.

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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