

# POWER MIG® 215XT

## POWER MIG®. The Professional's Choice™.

The POWER MIG® 215XT offers the autobody and sheet metal fabrication industries top welding performance and a host of professional features not often found at this price. Featuring Diamond Core Technology™, the POWER MIG® 215XT delivers a forgiving arc, excellent out-of-position arc action, a wide voltage sweet spot at a given wire feed speed and low spatter. And, the MAXTRAC® drive system with a patented Split Wire Guide system and tachometer feedback ensures trouble-free wire delivery. The wide 30-250 amp output range, standard 15 foot gun cable, and 115 volt auxiliary power receptacle are uncommon in this class. In addition, the 7 voltage tap ranges make it easy to operate and the locking storage compartment keeps your valuable tools secure. The POWER MIG® 215XT is Spool Gun Ready for Lincoln's light duty Magnum® 100SG Spool Gun. The POWER MIG® 215 XT—truly The Professional's Choice™.



Output



Input



### Spool Gun Ready



Light Duty

### Spool Gun Capable



Medium Duty



Heavy Duty

Processes  
MIG, Flux-Cored



**DIAMOND CORE TECHNOLOGY™**  
Delivers a stable arc across the entire welding range.



## Advantage Lincoln

### Arc Performance:

- **Diamond Core Technology™**, a patented choke design, delivers a forgiving arc, even with large stickout changes, excellent out-of-position arc action, a wide voltage sweet spot at a given wire feed speed for steel, stainless steel or aluminum and low spatter.
- **More Output** – Rated at 215 amps/22 volts @ 30% duty cycle, with an amperage range of 30-250 amps DC, the POWER MIG® 215XT has the highest rating and widest amperage range in its class.

### Superb Quality:

- **MAXTRAC® cast aluminum industrial wire drive** features dual driven rolls, regulated wire feed speed control, easy-turn numeric tension indicator, brass-to-brass connections and Lincoln's 100% wire supporting split wire guide system.
- **Three-year warranty** on parts and labor (90 days warranty on gun).

### Professional Features:

- **Generous 15 ft. (4.5m) gun and cable** assembly makes it easy to reach your work.
- **Seven tapped voltage ranges** make it easy to select the right procedure for your application.
- **Only machine in its class** to feature a 115 volt auxiliary power receptacle.
- **Lincoln's Innovative value-adding features** include an easy-load gas cylinder platform, a locking storage compartment with tool tray for your personal tools and valuables, intuitive input reconnect panel and easy-load wire spindle system with tool-less brake adjustment.

## TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output <sup>(2)</sup>	Output Range	Dimensions H x W x D inches (mm)	Net Weight lbs. (kg)
POWER MIG® 215XT	K2700-1	208/230/1/50/60	215A / 22V <sup>(1)</sup> / 30% 190A / 23V / 40% 170A / 24V / 60%	45/41A 42/38A 39/35A	30-250 Amps DC 50-700 ipm WFS (1.3-17.7 m/min) Max. OCV: 39V	31.8 x 18.9 x 38.8 (808 x 408 x 985)	210 (95)

(1) 21V on 220V 50 Hz input.

(2) Input current is at the rated output with the 115V auxiliary receptacle also drawing 15 amps.

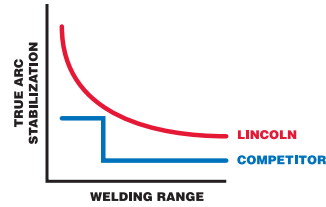
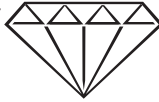


## A CLOSER LOOK

### PERFORMANCE

## DIAMOND CORE TECHNOLOGY™

Delivers a stable arc across the entire welding range.



#### What Is It?

Diamond Core Technology™ is a patented innovative choke design that filters the welding arc. It provides dynamic arc filtering across the entire welding amp range. Other arc stabilization methods are “fixed” – or only working at certain amperages – resulting in harsh arc characteristic changes over the welding range.

#### Results:

- Great starts and low spatter.
- A wide sweet spot for optimal arc performance.

#### Great For:

- Steel, stainless and aluminum.
- Out-of-position work.
- Long arc applications.
- Weaving techniques.

### PROCESS CAPABILITIES

Process	Electrode Wire	Electrode Polarity	Shielding Gas	Minimum Thickness	Maximum Thickness <sup>(1)</sup>
<b>MIG</b> Mild Steel	.025, .030, .035, .045" (0.6, 0.8, 0.9, 1.2 mm) SuperArc® L50, L-56 SuperGlide® S-3, S-6	DC+	100% CO <sub>2</sub> or Ar/CO <sub>2</sub> Blend	24 ga. (.024") (0.6 mm)	5/16" (.312") (7.9 mm)
<b>MIG</b> Stainless	.030, .035, .045" (0.8, 0.9, 1.2 mm) Blue Max® 308LSi, 309LSi, 316LSi	DC+	Ar/CO <sub>2</sub> Blend or (Tri-Mix) 90% He, 7-8% Ar/Balance CO <sub>2</sub>	20 ga. (.036") (0.9 mm)	1/4" (.250") (6.4 mm)
<b>MIG</b> Aluminum <sup>(2)</sup>	3/64" (0.2 mm) SuperGlaze® 4043 and 5356	DC+	100% Argon	1/16" (.063") (1.6 mm)	1/4" (.250") (6.4 mm)
<b>Flux-Cored, Gas-Shielded</b> Mild Steel	.035, .045" (0.9, 1.2 mm) Outershield® 71M and MC-710	DC+	100% CO <sub>2</sub> or Ar/CO <sub>2</sub> Blend	12 ga. (.109") (2.7 mm)	1/2" (.500") (12.7 mm)
<b>Flux-Cored, Self-Shielded</b> Mild Steel	.035, .045" (0.9, 1.2 mm) Innershield® NR®-211-MP <sup>(2)</sup> and NR®-212	DC-	—	18 ga. (.050") (1.2 mm)	1/2" (.500") (12.7 mm)

<sup>(1)</sup> Lincoln Electric recommends multiple pass welds on 1/2" (12.7 mm) material. Consult the appropriate application procedures and guidelines for selecting the correct wire size, gas type and number of passes.

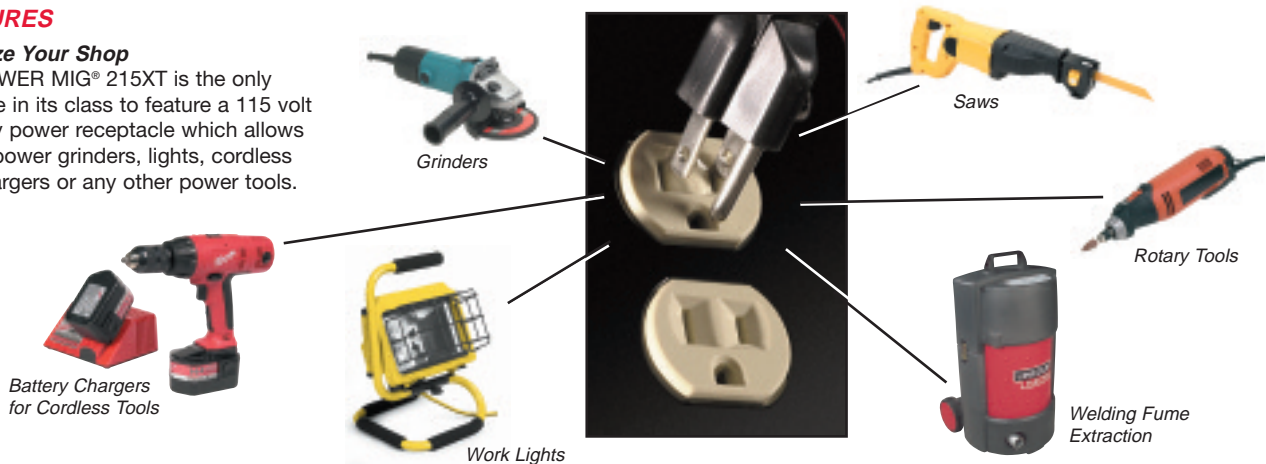
<sup>(2)</sup> .035" and .045" (0.9 and 1.2 mm) NR®-211-MP is only recommended up to 5/16" (7.9 mm) thick material.

<sup>(3)</sup> For .035" (0.9 mm) and 4043 aluminum wire, the spool gun is recommended for best feeding results.

### FEATURES

#### Energize Your Shop

The POWER MIG® 215XT is the only machine in its class to feature a 115 volt auxiliary power receptacle which allows you to power grinders, lights, cordless tool chargers or any other power tools.



**A CLOSER LOOK**

**FEATURES CON T.**

**Compare These Innovations – Make the Professional's Choice<sup>SM</sup>!**

*Convenient operating procedures for MIG welding on mild steel, aluminum and stainless, located inside the POWER MIG<sup>®</sup> 215XT door.*



*Lockable storage compartment with tool tray stows your welding consumables and valuable personal tools.*



*Easy Load Wire Compartment*

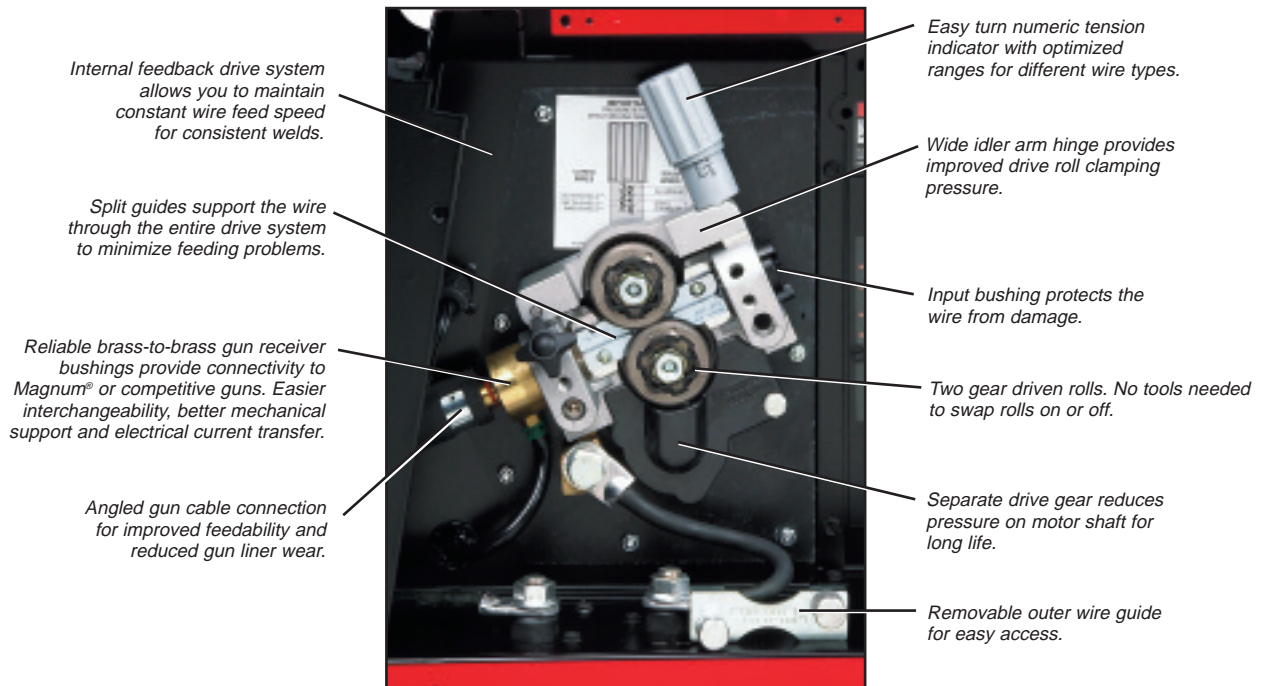


*Built-in undercarriage with Easy Load Gas Cylinder Platform*



*Extra-Length 15 ft. (4.5 m) Gun*

**Professional Heavy Duty Wire Drive System**



## A CLOSER LOOK

### Key Controls

- A. Wide range wire feed speed (WFS) control up to 700 inches per minute (17.7 m/min). Dial calibrated in true inches per minute for easy procedure setting.
- B. Seven voltage taps for wide range voltage control.



### QUALITY AND RELIABILITY

- Thermostatic protection from current overload and excessive temperatures.
- Clear reconnect door permits easy viewing of input voltage.
- Low input current draw for energy-efficient low cost operation.
- Fan-As-Needed™ (F.A.N.™) provides cooling of transformer and other components when welding, reducing power consumption, noise and extending welder life.
- Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.
- Three-year warranty on parts and labor. 90 days warranty on gun and cable.



Printed circuit boards are environmentally-shielded using Lincoln's engineered potting and protective frame trays.



The POWER MIG® 215XT is an excellent choice for sheet metal job shop fabrication, autobody work and maintenance/repair welding.

**WHAT'S INCLUDED**


**K2700-1 Includes:**

- POWER MIG® 215XT.
- Magnum® 250L gun and 15 ft. (4.5 m) “quick-connect” cable assembly equipped with fixed gas nozzle assembly.
- Lockable storage compartment with tool tray for keeping tools safe.
- Work clamp and 10 ft. (3.0 m) cable.
- 10 ft. (3.0 m) 230V input power cable with plug.
- Dual driven drive rolls and split wire guides to support the wire 100%.
- Drive roll and wire guide to feed both .035" & .045" (0.9 & 1.2 mm) wire.
- Gas regulator and hose kit for CO<sub>2</sub> or argon blend gases. (For use with CO<sub>2</sub> shielding gas, order a Lincoln S19298 CO<sub>2</sub> shielding gas bottle adapter.)



**SPOOL GUN SOLUTIONS**

Spool Guns offer an affordable way to reliably feed soft aluminum wire. Since spool guns feed small 4 inch spools of wire a short distance it provides a reliable feeding solution that prevents wire jams and tangles. The POWER MIG® 215XT provides three choices of spool gun solutions from the cost effective light duty Magnum® 100SG for occasional aluminum projects to the premium heavy duty Magnum® 250LX which is designed for day in day out aluminum welding applications.

<b>LIGHT DUTY</b>	<b>MEDIUM DUTY</b>	<b>HEAVY DUTY</b>
<p><b>Magnum® 100 SG Spool Gun</b></p>  <p><b>(K2532-1)</b></p>	<p><b>Magnum® SG Spool Gun</b></p>  <p><b>(K487-25)</b></p>	<p><b>Magnum® 250LX Spool Gun</b></p>  <p><b>(K2490-1)</b></p>
<ul style="list-style-type: none"> <li>• 130 Amp 30% Duty Cycle</li> <li>• 10 ft. cable length</li> <li>• Feeds .030 - .035 in. diameter wire</li> <li>• Wire Feed Speed is set at machine</li> <li>• Fixed wire spool brake with friction pads for 5356 wire</li> <li>• Fixed drive roll tension</li> </ul>	<ul style="list-style-type: none"> <li>• 250 Amp 60% Duty Cycle</li> <li>• 25 ft. cable length</li> <li>• Feeds .025 - 3/64 in. diameter wire</li> <li>• Single Turn remote Wire feed speed control at the gun</li> <li>• Adjustable wire spool brake</li> <li>• Adjustable drive roll tension</li> </ul>	<ul style="list-style-type: none"> <li>• 300 Amp 60% Duty Cycle</li> <li>• 25 ft. cable length</li> <li>• Feeds .025 - 3/64 in. diameter wire</li> <li>• Multi-Turn remote Wire feed speed control at the gun</li> <li>• Deluxe wire spool break requires no adjustments</li> <li>• Adjustable drive roll tension</li> <li>• Ergonomic Sure Grip handle</li> <li>• Contact tip storage built in spool gun cover</li> <li>• Easy open wire drive rolls for easy wire loading</li> </ul>
<p><b>Factory Ready! No Adapter Required!</b></p>	<p><b>Requires K2703-1 Adapter</b></p>	<p><b>Requires K2703-1 Adapter</b></p>

## A CLOSER LOOK

### THE MAGNUM® 250L GUN

- Magnum® 250L gun and cable assembly, shipped with the POWER MIG® 215XT is equipped to feed .035"-.045" (0.9-1.2 mm) solid steel wire.
- Extra reach 15 foot gun cable length.
- Lightweight and flexible for easy maneuverability.
- Fiberglass handle with non-slip grooves to maximize comfort and control.
- Heavy duty gun trigger switch for positive electrical contact and long life.

- Magnum® replacement parts are fully compatible with other leading brands. Industry reference numbers are provided for ease of interchangeability.



#### MAGNUM® REPLACEMENT PARTS

Description	Order No.	Industry Reference No.
<b>Magnum® 250L Gun and Cable Assembly</b>		
<b>Fixed Gas Nozzle Model</b>		
For .035-.045" (0.9-1.2 mm) wire sizes 12 ft. (3.6 m) cable	K533-7	
<b>Adjustable Gas Nozzle Model</b>		
For .035-.045" (0.9-1.2 mm) wire sizes 10 ft. (3.0 m) cable	K533-1	
15 ft. (4.5 m) cable	K533-3	
<b>Cable Liners</b>		
For All Gun Cable Lengths		
.025-.030" (0.6-0.8 mm)	KP1934-2	42-23-15
.030-.035" (0.8-0.9 mm)	KP1934-3	42-3035-15
.035-.045" (0.9-1.2 mm)	KP1934-1 <sup>(1)</sup>	42-4045-15
3/64" (1.2 mm) Aluminum	KP1955-1 <sup>(2)</sup>	42N-3545-15
<b>Contact Tips</b>		
Standard Duty		
.025" (0.6 mm)	KP2020-6	14-23
.030" (0.8 mm)	KP2020-7	14-30
.035" (0.9 mm)	KP2020-1 <sup>(1)</sup>	14-35
.040" (1.0 mm)	KP2020-8	14-40
.045" (1.2 mm)	KP2020-2	14-45
Heavy Duty		
.035" (0.9 mm)	KP2021-1	14H-35
.040" (1.0 mm)	KP2021-6	14H-40
.045" (1.2 mm)	KP2021-2	14H-45
Tapered		
.025" (0.6 mm)	KP2022-5	14T-23
.030" (0.8 mm)	KP2022-6	14T-30
.035" (0.9 mm)	KP2022-1	14T-35
.040" (1.0 mm)	KP2022-7	14T-40
.045" (1.2 mm)	KP2022-2	14T-45
Aluminum		
3/64" (1.2 mm)	KP2010-5 <sup>(2)</sup>	

#### MAGNUM® REPLACEMENT PARTS

Description	Order No.	Industry Reference No.
<b>Fixed Gas Nozzles/Diffuser Assembly</b>		
Fixed (flush)		
3/8" (9.5 mm)	KP1931-1	23-37-F
1/2" (12.7 mm)	KP1931-2 <sup>(1)</sup>	23-50-F
5/8" (15.9 mm)	KP1931-3	23-63-F
Fixed (recessed)		
3/8" (9.5 mm)	KP1930-1	23-37
1/2" (12.7 mm)	KP1930-2	23-50
5/8" (15.9 mm)	KP1930-3	23-62
Requires: Gas Diffuser Assembly		
.025-.045" (0.6-1.2 mm)	KP2026-3 <sup>(1)</sup>	52FN
<b>Adjustable Gas Nozzle/Diffuser Assembly</b>		
Adjustable Slip-On		
3/8" (9.5 mm)	KP1935-3	22-37
1/2" (12.7 mm)	KP1935-2	22-50
5/8" (15.9 mm)	KP1935-1	22-62
Requires:		
Nozzle Insulator Assembly	KP2025-1	32
Gas Diffuser Assembly:		
.023-.030" (0.6-0.8 mm)	KP2026-2	52-23
.035-.045" (0.9-1.2 mm)	KP2026-1	52
<b>Gasless Nozzle/Diffuser Assembly</b>		
(Innershield® Nozzle)	KP1947-1	
Requires:		
Gas Diffuser Assembly	KP2026-1	52
<b>Gun Tube Assembly</b>		
Standard (60°)	KP2015-1 <sup>(1)</sup>	
45°	KP2041-1	

<sup>(1)</sup> Included with POWER MIG® 215XT.

<sup>(2)</sup> Included in the K1703-1 Aluminum Feeding Kit.

#### DRIVE ROLL KITS

Wire Size	Order Number
Solid	.023-.030" (0.6-0.8 mm)
	.035" (0.9 mm)
	.035/.045" combination
	.040" (1.0mm)
	.045" (1.2 mm)
Cored	.035" (0.9 mm)
	.045" (1.2 mm)
Aluminum	3/64" (1.2 mm)

<sup>(1)</sup> Included with POWER MIG® 215XT.

<sup>(2)</sup> Included in the K1703-1 Aluminum Feeding Kit.

**GENERAL OPTIONS**



**Magnum® Connection Kit**  
Permits use of Magnum® 200, 300 and 400 gun and cable assemblies on POWER MIG® 215 XT.  
**Order K466-6**

**POWER MIG® 215XT Spool Gun Adapter**

This kit is designed to allow the Magnum® SG or Magnum® 250LX spool gun to operate with the POWER MIG® 215XT. The kit includes the solenoid, gas lines, wiring harness and gun connection panel. The gun connection panel features a 6 pin MS-type connector for the Magnum® SG spool gun and a 7 pin MS-type connector for the Magnum® 250LX spool gun and a selector switch to choose which gun you are using.  
**Order K2703-1**  
**Note the K2703-1 spool gun adapter disables the Magnum® 100SG capability.**



**Aluminum Feeding Kit**

Conversion kit for welding with 3/64" (1.2 mm) 5356 aluminum wire. Includes drive rolls, contact tips (2), non-metallic wire guides and cable liner.  
**Order K1703-1**



**Spindle Adapter for 8" O.D. Spools**

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



**Dual Cylinder Mounting Kit**

Permits side-by-side mounting of two full size gas cylinders, with easy loading. Attaches easily to POWER MIG® 215XT undercarriage.  
**Order K1702-1**



**Canvas Cover**

Protect your POWER MIG® when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent. Fits any POWER MIG® machine with or without a gas cylinder in the cylinder rack. Will not fit if spool gun holder is attached to the machine.  
**Order K2378-1**



**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**

**Magnum® 100SG Spool Gun**

130 Amp, 30% Duty Cycle with 10 ft of cable length. Feeds .030-.035 inch diameter wire. Wire Feed Speed is set at the machine. Fixed wire spool brake with friction pads for 5356 wire. Fixed drive roll tension.

**Order K2532-1**  
**Factory Ready!**  
**No Adapter Required!**



**Magnum® SG Spool Gun**

250 Amp, 60% Duty Cycle with 25 ft. of cable length. Feeds .025 - 3/64 inch diameter wire. Single Turn remote wire feed speed control at the gun. Adjustable wire spool brake and adjustable drive roll tension.

**Order K487-25**  
**Requires K2703-1 Adapter**



**Magnum® 250LX Spool Gun**

300 Amp, 60% Duty Cycle with 25 ft. of cable length. Feeds .025 - 3/64 inch diameter wire. Multi-Turn remote wire feed speed control at the gun. Deluxe wire spool break requires no adjustments. Adjustable drive roll tension and easy open wire drive rolls for easy wire loading. Ergonomic Sure Grip handle. Contact tip storage built in spool gun cover.

**Order K2490-1**  
**Requires K2703-1 Adapter**



**POWER MIG® 215XT ORDER FORM**

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
<b>POWER MIG® 215XT — 208/230V</b>	<b>K2700-1</b>		
<b>RECOMMENDED GENERAL OPTIONS</b>			
Magnum® Connection Kit	K466-6		
POWER MIG® 215XT Spool Gun Adapter	K2703-1		
Aluminum Feeding Kit	K1703-1		
Spindle Adapter for 8" O.D. Spindles	K468		
Dual Cylinder Mounting Kit	K1702-1		
Canvas Cover	K2378-1		
Welding Fume Extractors	See publication MC05-183		
Magnum® 100SG Spool Gun	K2532-1		
Magnum® SG Spool Gun	K487-25		
Magnum® 250LX Spool Gun	K2490-1		
<b>TOTAL:</b>			

**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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric® is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric® is a responsible 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.