

POWER MIG[®] 256



Processes

MIG, Flux-Cored

Product Number

K3068-1 208/230
K3068-2 230/460/575
K3069-1 208/230 One-Pak[®]

Input Power

K3068-1 & K3069-1: 208/230/1/60
K3068-2: 230/460/575/1/60

Input Current at Rated Output

56 A @ 208 V / 52 A @ 230 V

Rated Output

250A/26V/40% Duty Cycle

Max. Open Circuit Voltage

40V

Amperage Range

30 - 300 A

Wire Feed Speed

50 - 700 IPM (1.3 - 17.7 m/min)

Weight/Dimensions (H x W x D)

220 lbs. (100 kg)
31.8 x 18.9 x 38.8 in.
(808 x 480 x 985 mm)

POWER MIG[®]

The Professional's ChoiceSM

The POWER MIG[®] 256 sets the standard for MIG and flux-cored welding in light industrial job shop fabrication, maintenance or repair work.

FEATURES

- ▶ **Diamond Core Technology[™]** – Delivers a forgiving arc, excellent out-of-position arc stability, low spatter and a wide voltage sweet spot at a given wire feed speed for steel, stainless steel or aluminum.
- ▶ **MAXTRAC[®] cast aluminum industrial wire drive** – Features dual driven rolls, regulated wire feed speed control, brass-to-brass connections and Lincoln's 100% wire supporting split wire guide system.
- ▶ **Digital meters** - For set up, meters display your preset voltage and wire feed speed. During welding, actual voltage is displayed.
- ▶ **New! Magnum[®] PRO gun and cable 15 ft. (4.5 m)** - Makes it easy to reach your work.
- ▶ **Copper Plus[™] contact tips** - Larger tip diameter and mass improves heat dissipation to increase tip life.
- ▶ **Add a spool gun** – The POWER MIG[®] 256 is spool gun ready for the premium Magnum[®] 250LX gun and spool gun capable with the Magnum[®] SG (requires adapter).
- ▶ **115V auxiliary receptacle** - (208/230V model only) to power a grinder or other auxiliary equipment in your work area.
- ▶ **New! Great value-adding features** –
 - Coil Claw[™] Cable Management system keeps your workstation organized.
 - Convenient top-mounted gun expendables tray.
 - All metal case front.

SPOOL GUNS

Better
Magnum[®] SG



CAPABLE

Best
Magnum[®] 250LX



READY

Coil
Claw



Shown K3068-1

APPLICATIONS⁽¹⁾

- ▶ Metal Fabrication
- ▶ Maintenance and Repair
- ▶ Farm/Autobody
- ▶ Light Industrial

INPUT



OUTPUT



MAXTRAC[®]
Wire Drive System

DIAMOND CORE[®]
TECHNOLOGY



Two Year Extended
Warranty Available
in the U.S.A. and
Canada

WHAT'S INCLUDED

K3069-1 One-Pak[®] Includes:

- ▶ POWER MIG[®] 256 with Magnum[®] PRO 250L
- ▶ Magnum[®] 250LX Spool Gun (K2490-1)
- ▶ Dual Cylinder Mounting Kit (K1702-1)
- ▶ Regulator (K586-1)
- ▶ Input Cable

⁽¹⁾ The POWER MIG[®] 256 cannot be powered by an engine-driven welder.



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THE LINCOLN ELECTRIC COMPANY

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LINCOLN[®]
ELECTRIC
THE WELDING EXPERTS[®]

KEY CONTROLS

1. Digital meter displays preset wire feed speed.
2. Wire speed control with fine resolution at low settings.
3. Digital meter displays preset voltage setting and actual voltage while welding.
4. Voltage control with fine resolution at low settings.
5. Angled gun connection for improved feedability.
6. Second gas solenoid fitting for spool gun use.



A CLOSER LOOK



Gun Expendable Parts Compartment



Additional Gas Solenoid – Controls Gas Flow to a Spool Gun



Coil claw Keeps your workstation organized



Easy Load Gas Cylinder Platform



Timer Functions

Adds 4-step trigger interlock, spot mode, adjustable run-in speed for smoother arc starting, and adjustable burnback time to minimize wire sticking in puddle.



NEW!
Magnum® PRO 250L Gun
With long lasting Copper Plus™ contact tips



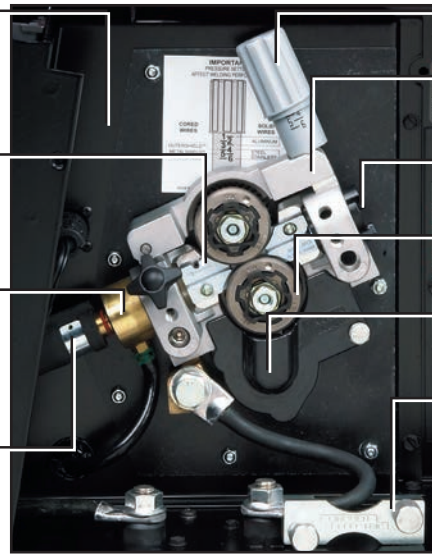
Easy Load Wire Compartment

Internal feedback drive system
Maintains constant wire feed speed for consistent welds.

Split guides support the wire through the entire drive system to minimize feeding problems.

Reliable **brass-to-brass gun receiver bushings** provide connectivity to Magnum® or competitive guns. Easier interchangeability, better mechanical support and electrical current transfer.

Angled gun cable connection for improved feedability and reduced gun liner wear.



Easy turn numeric tension indicator with optimized ranges for different wire types.

Wide idler arm hinge provides improved drive roll clamping pressure.

Input bushing protects the wire from damage.

Two gear driven rolls. No tools needed to swap rolls on or off.

Separate drive gear reduces pressure on motor shaft for long life.

Removable outer wire guide for easy access.



A patented heavy duty cast aluminum wire drive system that provides reliable feeding and increased durability.

GUN INFORMATION


Included Magnum® PRO 250L Gun



- Rated 250A @ 60% duty cycle with CO₂ shielding gas.
- Ships equipped to feed .035 in. – .045 in. (0.9 – 1.2 mm) wire. The Magnum® PRO 250L is capable of feeding .025 in. – .045 in. (0.6 – 1.2 mm) wire.
- Industrial Grade Construction -
 - High quality copper parts ensure superior electrical contact and heat dissipation.
 - Four trigger leads are standard for fast field repair.
 - Patent-pending Anti-Seize™ tip and diffuser thread design reduces tip and diffuser seizing.

DRIVE ROLL KITS		
	Wire Size in. (mm)	Order Number
Solid	.023-.030 (0.6-0.8)	KP1696-030S
	.035 in. (0.9)	KP1696-035S ⁽¹⁾
	.035/.045 combination	KP1696-1
	.040 (1.0)	KP1696-2
	.045 (1.2)	KP1696-045S
Cored	.035 (0.9)	KP1697-035C
	.045 (1.2)	KP1697-045C
Aluminum	3/64 (1.2)	KP1695-3/64A

⁽¹⁾ Included with POWER MIG® 256.

SPOOL GUN CAPABLE MEDIUM DUTY	SPOOL GUN READY HEAVY DUTY
Magnum® SG Spool Gun (K487-25)	Magnum® 250LX Spool Gun (K2490-1)
	
<ul style="list-style-type: none"> • 250A, 60% duty cycle. • .025 - 3/64 in. (0.6-1.2 mm) electrode diameter capability. • Wire feed speeds from 50-650 ipm (1.2-16.5 m/min.). • 25 ft. (7.6 m) gun cable length – compare to the competition. • Adjustable speed control at the handle – allows you to tailor the WFS setting at the gun. • See E12.22 for expendable parts. • Order K487-25 spool gun and K2445-1 control cable adapter. 	<ul style="list-style-type: none"> • 300A, 60% duty cycle. • .025 - 3/64 in. (0.6-1.2 mm) electrode diameter capability. • Wire feed speeds up to 800 ipm (20.3 m/min.). • 25 ft. (7.6 m) gun cable length with 7-pin MS-type connector. • WFS control for fine adjustment of wire feed speed at the gun. • Zippered cable jacket is standard. • See E12.25 for expendable parts. • Order K2490-1.



Adjust speed on the gun and watch the wire feed speed change on the POWER MIG® 256.

Improved Spool Gun Operation!

Set wire feed speed at the gun – see the pre-set wire feed speed displayed on the POWER MIG® 256 meter.

Faster set-up – No more guessing on wire feed speed!

RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Dual Cylinder Mounting Kit
Permits side-by-side mounting of two full size gas cylinders. Attaches easily to POWER MIG® undercarriage.
Order K1702-1



Magnum® SG Spool Gun
250 amp, 60% duty cycle with 25 ft. (7.6 m) cable length. Feeds .025 - 3/64 in. (0.6 - 1.2 mm) 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 K2445-1 Adapter



Magnum® 250LX Spool Gun Control Cable Extension
Extend your reach by 25 ft. (7.6 m). Features a 7-pin female MS-type connector on the spool gun end and a 7-pin male MS-type connector on the power source end.
Order K2519-1



8 in. O.D. Spool Adapter
Permits 8 in. (200 mm) O.D. spools to be mounted on 2 in. (51 mm) O.D. spindles.
Order K468



Canvas Cover
This red canvas cover 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 or Cable Claw™ is attached to the machine.
Order K2378-1



Magnum® SG Spool Gun Control Cable Adapter
Connect the K487-25 Magnum® SG Spool Gun 6-pin control cable plug to the POWER MIG® 256 7-pin spool gun control cable receptacle.
Order K2445-1



Welding Fume Extractors
Lincoln Electric offers a wide variety of welding fume extraction environmental system solutions.
Request Publication MC08-70

WIRE FEEDER OPTIONS



Magnum® PRO Guns
Choose Magnum® PRO GMAW/ FCAW Barrel or Curve™ or fume models or select a K126™ PRO FCAW model.
See publication E12.09



Magnum® 250LX Spool Gun
300 amp, 60% duty cycle with 25 ft. (7.6 m) cable length. Feeds .025 - 3/64 in. (0.6 - 1.2 mm) diameter wire. Multi-turn remote wire feed speed control at the gun. Adjustable drive roll tension and easy open wire drive rolls for easy wire loading. Features built-in contact tip storage.
K2490-1 Factory Ready



Magnum® Connection Kit
Permits use of Magnum® 200, 300 and 400 gun and cable assemblies.
Order K466-6

PROCESS CAPABILITIES

Process	Electrode Wire	Electrode Polarity	Shielding Gas	Minimum Thickness	Maximum Thickness ⁽¹⁾
MIG Mild Steel	.025, .030, .035, .045 in. (0.6, 0.8, 0.9, 1.1 mm) SuperArc® L-50, L-56, SuperGlide® S3, S6	DC+	100% CO ₂ or Ar/CO ₂ Blend	22 ga. (.030 in.) (0.8 mm)	1/2 in. (.500 in.) (19.1 mm)
MIG Stainless	.030, .035, .045 in. (0.8, 0.9, 1.1 mm) Blue Max® 308LSi, 309LSi, 316LSi	DC+	Ar/CO ₂ Blend or (Tri-Mix)	16 ga. (.060 in.) (1.6 mm)	5/16 in. (.312 in.) (7.9 mm)
MIG Aluminum	3/64 in. (1.2 mm) SuperGlaze® 4043 and 5356	DC+	100% Argon	16 ga. (.060 in.) (1.6 mm)	1/2 in. (.500 in.) (19.1 mm)
Flux-Cored, Gas-Shielded Mild Steel	.035, .045 in. (0.9, 1.1 mm) Outershield® 71M	DC+	100% CO ₂ or Ar/CO ₂ Blend	12 ga. (.109 in.) (2.7 mm)	5/16 in. (.312 in.) (7.9 mm)
Flux-Cored, Self-Shielded Mild Steel	.035, .045 in. (0.9, 1.1 mm) Innershield® NR-211-MP ⁽²⁾ and NR-212	DC-	—	18 ga. (.050 in.) (1.2 mm)	3/4 in. (.750 in.) (12.7 mm)

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

(2) .035 and .045 in. (0.9 and 1.1 mm) Innershield® NR-211-MP is only recommended up to 5/16 in. (7.9 mm) thick material.

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle ⁽³⁾	Input Current @ Rated Output	Output Range	H x W x D inches (mm)	Net Weight lbs. (kg)
POWER MIG® 256 One-Pak® Spool Gun Pkg.	K3069-1	208/230/1/60	250A/26V/40%	56/52A ⁽¹⁾	30-300 Amps 50-700 ipm WFS (1.3-17.7 m/min) Max. OCV: 40V	31.8 x 18.9 x 38.8 (808 x 480 x 985)	220 (100)
POWER MIG® 256 Base Unit	K3068-1	208/230/1/60	250A/26V/40%	56/52A ⁽¹⁾	30-300 Amps 50-700 ipm WFS (1.3-17.7 m/min) Max. OCV: 40V		
	K3068-2 ⁽²⁾	230/460/575/1/60		50/24/19A			

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

(2) Does not include input cable.

(3) The POWER MIG® 256 cannot be powered by an engine-driven welder

CUSTOMER ASSISTANCE POLICY

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THE WELDING EXPERTS®