

POWER MIG[®] 216

Processes

MIG, Flux-Cored

Product Number

K2816-2

Input Power

208/230V, 1/60 Hz / 220V, 1/50 Hz

Input Current @ Rated Output

208V:33A at 170A/24VDC/60% Duty Cycle

208V:40A at 216A/22VDC/30% Duty Cycle

230V:30A at 170A/24VDC/60% Duty Cycle

230V:36A at 216A/22VDC/30% Duty Cycle

Rated Output

170A at 24VDC/60% Duty Cycle

216A at 22VDC/30% Duty Cycle

Max. Open Circuit Voltage

36VDC

Amperage Range

30 - 250A

Wire Feed Speed

50 - 700 IPM (1.3 - 17.8 m/min)

Weight/Dimensions (H x W x D)

206.5 lbs. (93.7 kg)

32.56 x 19.15 x 39.92 in.

(827 x 487 x 1,014 mm)

POWER MIG[®] The Professional's ChoiceSM

The POWER MIG[®] 216 offers autobody and sheet metal fabrication shops top welding performance with a host of professional features.

FEATURES

- ▶ **Diamond Core Technology[™]** – Delivers a forgiving arc, excellent out-of-position arc action, low spatter and a wide voltage sweet spot 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 Electric's 100% wire supporting split wire guide system.
- ▶ **More Output and Better Efficiency** – Compare the best in class rated output, wide amperage range and efficiency.
- ▶ **Spool Gun Ready** – Just remove the standard MIG gun and plug in the optional Magnum[®] PRO 100 SG spool gun for enhanced aluminum wire feeding performance.
- ▶ **New! Great Value-Adding Features** –
 - Coil Claw[™] Cable Management system keeps your workstation organized.
 - Convenient top-mounted gun expendables tray.
 - All metal case front.

APPLICATIONS

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



Publication E7.52 | Issue Date 02/14
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SPOOL GUNS

Good
Magnum[®] PRO 100 SG



Better
Magnum[®] SG



Best
Magnum[®] 250LX



WHAT'S INCLUDED

- ▶ Magnum[®] PRO 250L gun and 15 ft. (4.5 m) "quick-connect" cable assembly equipped with fixed gas nozzle assembly.
- ▶ Top-mounted gun expendables tray.
- ▶ Built-in undercarriage with easy-load gas cylinder platform.
- ▶ Work clamp and 10 ft. (3.0 m) cable.
- ▶ 10 ft. (3.0 m) 230V input power cable with plug.
- ▶ Drive roll and wire guide to feed both .035 in. & .045 in. (0.9 & 1.2 mm) wire.
- ▶ Gas regulator and hose kit for argon blend gases. (For use with CO₂ shielding gas, order a Lincoln Electric S19298 CO₂ shielding gas bottle adapter.)
- ▶ Large color coded procedure recommendation sheet.

INPUT



OUTPUT



Two Year Extended
Warranty Available.

THE LINCOLN ELECTRIC COMPANY

22801 St. Clair Avenue • Cleveland, OH. • 44117-1199 • U.S.A
PH: +1.216-481-8100 • www.lincolnelectric.com

LINCOLN[®]
ELECTRIC
THE WELDING EXPERTS[®]

KEY CONTROLS

The POWER MIG® 216 control panel with the calibrated wire feed speed and the seven tap position voltage knob makes it easy to select the right procedure for your application.

The recommended settings are easily identified by the color coded procedural chart permanently mounted inside the wire drive compartment.



1. Power on/off switch
2. Wide range wire feed speed (WFS) control (up to 700 ipm). The dial is calibrated in true inches per minute for easy, accurate procedural change.
3. Seven voltage taps
4. Brass to brass gun connection bushing and work clamp access
5. Gun trigger lead connection

A CLOSER LOOK



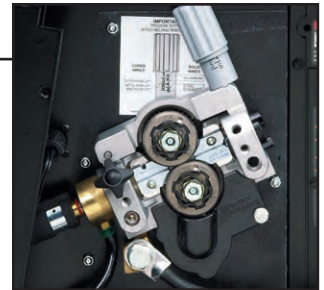
Gun and Drive Expendable Parts Compartment



Easy-Load Wire Compartment



Built-in Undercarriage With Easy-Load Gas Cylinder Platform



Professional Heavy Duty MAXTRAC® Wire Drive System



Coil Claw Keeps Your Workstation Organized



Patented choke technology that produces an outstanding arc with better starts, a wider sweet spot, lower spatter levels and outstanding performance on aluminum and stainless steels.

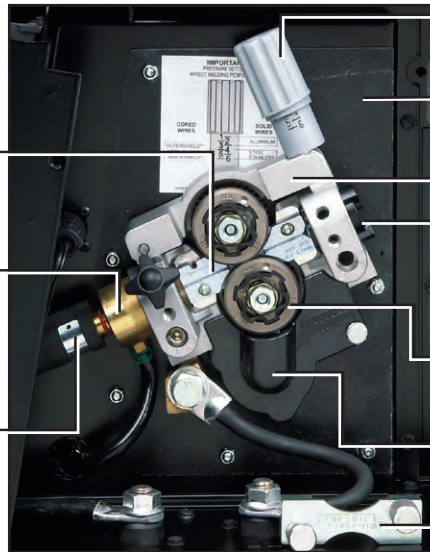
WIRE DRIVE SYSTEM



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.

Internal feedback drive system allows you to maintain constant wire feed speed for consistent welds.

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.

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 | Order Number |
| Solid | .023-.030 in. (0.6-0.8 mm) | KP1696-030S |
| | .035 in. (0.9 mm) | KP1696-035S |
| | .035/.045 in. combination | KP1696-1 ⁽¹⁾ |
| | .040 in. (1.0 mm) | KP1696-2 |
| | .045 in. (1.2 mm) | KP1696-045S |
| Cored | .035 in. (0.9 mm) | KP1697-035C |
| | .045 in. (1.2 mm) | KP1697-045C |

⁽¹⁾ Included with POWER MIG® 216.

| SPOOL GUN READY-LIGHT DUTY | SPOOL GUN CAPABLE-MEDIUM DUTY | SPOOL GUN CAPABLE-HEAVY DUTY |
|---|--|---|
| <p>Magnum® PRO 100 SG Spool Gun – (K3269-1)</p>  | <p>Magnum® SG Spool Gun – (K487-25)</p>  | <p>Magnum® 250LX Spool Gun – (K2490-1)</p>  |
| <ul style="list-style-type: none"> • 130 Amp 30% Duty Cycle • 10 ft. (3.0 m) cable length • Feeds .030 in. – .035 in. (0.8 – 0.9 mm) diameter wire • Wire Feed Speed is set at machine • Fixed wire spool brake with friction pads for 5356 wire • Fixed drive roll tension  | <ul style="list-style-type: none"> • 250 Amp 60% Duty Cycle • 25 ft. (7.6 m) cable length • Feeds .025 in. - 3/64 in. (0.6 – 1.2 mm) diameter wire • Single-Turn remote wire feed speed control at the gun • Adjustable wire spool brake • Adjustable drive roll tension | <ul style="list-style-type: none"> • 300 Amp 60% Duty Cycle • 25 ft. (7.6 m) cable length • Feeds .025 in. - 3/64 in. (0.6 – 1.2 mm) diameter wire • Multi-Turn remote wire feed speed control at the gun • Deluxe wire spool brake requires no adjustments • Adjustable drive roll tension • Ergonomic Sure Grip handle • Contact tip storage built in spool gun cover • Easy open wire drive rolls for easy wire loading |
| Factory Ready! No Adapter Required! | Requires K2703-1 Adapter | Requires K2703-1 Adapter |

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, 1.2 mm) SuperArc® L-50, L-56 SuperGlide® S-3, S-6 | DC+ | 100% CO ₂ or Ar/CO ₂ Blend | 22 ga. (.030 in.) (0.8 mm) | 1/4 in. (.250 in.) (6.4 mm) |
| MIG Stainless | .030, .035, .045 in. (0.8, 0.9, 1.2 mm) SuperArc® 308LSi, 309LSi, 316LSi | DC+ | Ar/CO ₂ Blend or (Tri-Mix) 90% He, 7-8% Ar/Balance CO ₂ | 16 ga. (.060 in.) (1.6 mm) | 5/16 in. (.312 in.) (7.9 mm) |
| MIG Aluminum ⁽²⁾ | 3/64 in. (0.2 mm) SuperGlaze® 4043 and 5356 | DC+ | 100% Argon | 18 ga (.048 in.) (1.2 mm) | 3/16 in. (.187 in.) (4.8 mm) |
| Flux-Cored, Gas-Shielded Mild Steel | .035, .045 in. (0.9, 1.2 mm) Outershield® 71M and MC-710 | DC+ | 100% CO ₂ or Ar/CO ₂ Blend | 12 ga. (.105 in.) (2.5 mm) | 1/2 in. (.500 in.) (12.7 mm) |
| Flux-Cored, Self-Shielded Mild Steel | .035, .045 in. (0.9, 1.2 mm) Innershield® NR®-211-MP ⁽³⁾ and N®-212 | DC- | — | 18 ga. (.050 in.) (1.2 mm) | 5/16 in. (.312 in.) (7.9 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⁾ For .035 in. (0.9 mm) and 4043 aluminum wire, the spool gun is recommended for best feeding results.

⁽³⁾ .035 in. and .045 in. (0.9 and 1.2 mm) NR®-211-MP is only recommended up to 5/16 in. (7.9 mm) thick material.

RECOMMENDED ACCESSORIES



GENERAL OPTIONS

Magnum® Connection Kit

Permits use of Magnum® and Magnum® PRO gun and cable assemblies on POWER MIG®.

Order K466-6



Spindle Adapter for 8 in. O.D. Spools

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

Order K468



POWER MIG® Spool Gun Adapter

This kit is designed to allow the Magnum® SG or Magnum® 250LX spool gun to operate with the POWER MIG®. 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® 100 SG capability.



Dual Cylinder Mounting Kit

Permits side-by-side mounting of two full size gas cylinders, with easy loading. Attaches easily to POWER MIG® 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

PRODUCT SPECIFICATIONS

| Product Name | Product Number | Input Power | Rated Output Current/Voltage/Duty Cycle | Input Current @ Rated Output | Output Range | H x W x D in. (mm) | Net Weight lbs. (kg) |
|----------------|----------------|--------------------------|---|--|---|---|----------------------|
| POWER MIG® 216 | K2816-2 | 208/230/1/60 220/1/50 | 170A/24VDC/60% 216A/22VDC/30% | 208V:33A @ 170A/24VDC/60% 208V:40A @ 216A/22VDC/30% 230V:30A @ 170A/24VDC/60% 230V:36A @ 216A/22VDC/30% | 30-250 Amps 50-700 ipm WFS (1.3-17.8 m/min) Max. OCV 36VDC | 32.56 x 19.15 x 39.92 (827 x 487 x 1014) | 206.5 (93.7) |

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

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