

Power Feed® 84 and Power Feed® 84 Dual

Processes

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

Product Number

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

* See back for details

Input Power

40 VDC

Output Capacity Current/Duty Cycle

600A/60%

Wire Size Range

.025-.120 in. (0.6 - 3.0 mm)⁽³⁾

Wire Feed Speed

50-1200 (1.3-30.4)⁽¹⁾⁽²⁾

Weight/Dimensions (H x W x D)

25.2 x 15.5 x 27.9 (640 x 394 x 709)
single wire drive

Digital Control Semiautomatic 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.

FEATURES

▶ Simple & Customizable Controls –

- New Auto-Settings simplify process setup
- 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

▶ Rugged Design –

- Improved isolation & 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

⁽¹⁾ 20 tooth pinion gear installed in the wire drive as equipped from the factory.

⁽²⁾ To achieve a wire feed speed of 1200, the feeder is configured with a 30 tooth pinion gear

⁽³⁾ Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear



Power Feed 84 Dual and Power Feed 84

RECOMMENDED POWER SOURCES

- ▶ Power Wave® 455M
- ▶ Power Wave 455M/STT®
- ▶ Power Wave S350
- ▶ Power Wave S500
- ▶ Power Wave S700

WHAT'S INCLUDED

Bench Models Include:

- ▶ All bench models include a standard #2 - #4 gun adapter
- ▶ 20 tooth pinion gear
- ▶ All wire feeders with a wire reel stand include a 8 ft. (2.4 m) control cable (K1543-8)
- ▶ All wire feeders without a wire reel stand include a conduit inlet bushing (K3929-1)



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



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



REQUIRED OPTIONS



**4-Roll
Wire Drive
Systems**




Product Number	Description/Wire Size inches (mm)
<i>Solid Wire, Smooth V Groove</i>	
KP1505-030S	.023-.030 (0.6-0.8)
KP1505-035S	.035 (0.9)
KP1505-045S	.045 (1.2)
KP1505-052S	.052 (1.4)
KP1505-1/16S	1/16 (1.6)
KP1505-1	.035, .045 (0.9, 1.2)
KP1505-2	.040 (1.0)
<i>Cored Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C ⁽³⁾	.052 (1.4)
KP1505-1/16C ⁽³⁾	1/16 (1.6)
KP1505-7/64H ⁽²⁾⁽³⁾	7/64 (2.8) Hardfacing (Knurled V Groove with matching Smooth U Groove)
<i>Cored or Solid Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C	.052 (1.4)
KP1505-1/16C	1/16 (1.6)
KP1505-068	.068 -.072 (1.8)
KP1505-5/64	5/64 (2.0)
KP1505-3/32	3/32 (2.4)
KP1505-7/64	7/64 (2.8)
KP1505-.120	.120 (3.2)
<i>Hardfacing Wires, Knurled, Smooth V Groove</i>	
KP1505-7/64C	7/64 (2.8)
KP1505-7/64H	7/64 (2.8) Hardfacing
<i>Aluminum Wire, Smooth U Groove</i>	
KP1507-035A	.035 (0.9)
KP1507-040A	.040 (1.0)
KP1507-3/64A	3/64 (1.2)
KP1507-1/16A	1/16 (1.6)
KP1507-3/32A	3/32 (2.4)

Magnum[®] PRO Gun Ready Pak[®]

Product Name	Product Number	Cable Length
Magnum PRO Curve 200 Ready-Pak (with K466-10 Gun Connector)	K2950-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-6 Gun Connector)	K2951-2-6-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-116	15 (3.0)
Magnum PRO Curve 400 Ready-Pak (with K466-10 Gun Connector)	K2952-2-10-45	15 (3.0)
Magnum PRO 250 (Barrel) Ready-Pak (with K466-6 Gun Connector)	K2651-2-6-45	15 (3.0)
Magnum PRO 350 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2652-2-10-45	15 (3.0)
Magnum PRO 450 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2653-2-10-45	15 (3.0)

REQUIRED OPTIONS

Control Cables and Adapters

	Product Number	Description	Connection	Use	Length ft. (m)	
	ArcLink®/Linc-Net™ Control Cables	K1543-8	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin	For Power Wave/Power Feed Systems	8 (2.4)
		K1543-16	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		16 (4.9)
		K1543-25	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		25 (7.6)
		K1543-50	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		50 (15.2)
		K1543-100	ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		100 (30.4)
		K2683-25	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin	For Power Wave/Power Feed Systems	25 (7.6)
		K2683-50	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		50 (15.2)
		K2683-100	Heavy Duty ArcLink/Linc-Net Control Cable	Male 5-pin to Female 5-pin		100 (30.4)

FEED PLATE GUN ADAPTERS

K3344-1	K3345-1	K3346-1	K3347-1	K3348-1	K3349-1
Lincoln Electric	Tweco® #2 - #4	Tweco® #5	Miller® guns	OXO® guns	Magnum® Fast-Mate™
Compatible gun connector kit K466-1 K613-1 K613-6 K466-8	Compatible gun connector kit K466-10 K466-2 K466-6	Compatible gun connector kit K613-7 K613-2	Compatible gun connector kit K466-3 K613-3		Single and dual procedure guns
					

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Miller® is a registered trademark of Miller Electric Mfg. Co.
Oxo® is a registered trademark of Miller Electric Mfg. Co.

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 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 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



Spool Cover
Order K1634-4 for use with 30-40 lb. spools.
K3340-1 for use with 50-60 lb 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

PRODUCT SPECIFICATIONS

Product Name	Product Number	User Interface	Reel Stand		USB	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 Weight lbs. (kg)	Availability
			Standard	Heavy Duty										
Single Wire Drive														
Power Feed 84	K3328-1							40 VDC	600A/60% (wire drive only)	Solid ⁽³⁾ .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
	K3328-2	•											36 (16.3)	A
	K3328-6	•	•										52 (23.5)	A
	K3328-3	•			•								38 (17.2)	S
	K3328-4	•				•							41 (18.5)	A
	K3328-11	•				•							36 (16.3)	A
	K3328-7	•	•		•								54 (24.4)	P
	K3328-13	•		•	•								62 (28.1)	S
	K3328-12	•			•	•							38 (17.2)	S
	K3328-8	•	•			•							57 (25.8)	A
	K3328-5	•			•	•							43 (19.5)	A
	K3328-9	•	•		•	•							54 (24.4)	A
Dual Wire Drive														
Power Feed 84	K3330-1							40 VDC	600A/60% (wire drive only)	Solid ⁽³⁾ .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
	K3330-2	•											64 (29.0)	A
	K3330-6	•	•										91 (41.2)	A
	K3330-3	•			•								66 (29.9)	S
	K3330-4	•				•							74 (33.5)	A
	K3330-7	•	•		•								93 (42.1)	P
	K3330-8	•	•			•							101 (45.8)	A
	K3330-10	•		•	•								109 (49.4)	P
	K3330-9	•	•		•	•							103 (46.7)	A
	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

All Power Feed 84 units are equipped with a standard #2 - #4 Tweco® gun adapter

⁽¹⁾ 20 tooth pinion gear installed in the wire drive as equipped from the factory.

⁽²⁾ To achieve a wire feed speed of 1200, the feeder is configured with a 30 tooth pinion gear

⁽³⁾ Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion gear

S - In-stock; normally in-stock for immediate shipment

P - One-Pak® of stocked items; normally in-stock for immediate shipment

A - Assemble upon order; typically ships in 5 business days

CUSTOMER ASSISTANCE POLICY

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