

# WELD-PAK® 225i DV STICK WELDER

## DC STICK/TIG WELDER



### KEY FEATURES

The dual voltage Weld-Pak® 225i Stick DV stick/TIG Welder has a 10 to 225 amp DC output that supports mild steel stick electrode diameters from 5/64" to 5/32". Weighing in at 20 lbs., it is lightweight and portable. The case has a tool box top for storing cables or tools. The smooth arc provides strong welds on 12 gauge sheet metal to 5/16" thick steel. It has a 30% duty cycle at 225 amps when connected to 230VAC. Touch Start TIG® welding is supported. A simple display allows you to dial in the weld settings so you can get started quickly and easily on any job, anywhere – maintenance work, fabrication, light structural and everything in between.

#### Processes »

DC Stick, DC Lift TIG

#### Input »



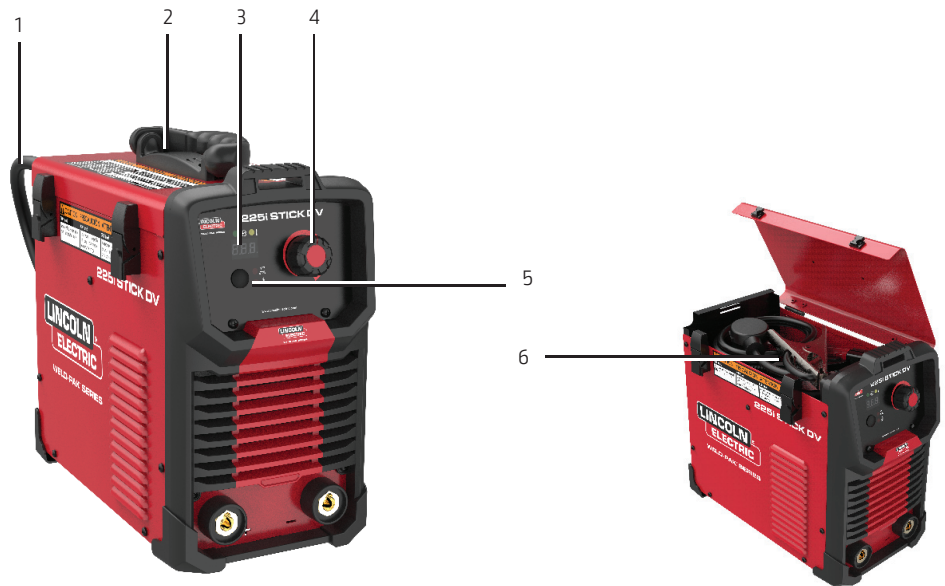
#### Product Number »

225i Stick DV K5419-1



## KEY FEATURES

1. Dual Voltage
2. Lightweight & Portable
3. LED Display
4. Single Knob Control
5. Weld Mode push button
6. Top Storage Compartment



## RECOMMENDED ACCESSORIES

### TIG OPTIONS



#### Twist Mate™ Plug For #6 - #4 Cable

Twist Mate™ plug for connecting welding cable to output terminals. Contains one 25 mm diameter plug.  
**Order K852-25**



#### Twist Mate™ Torch Adapter

For connection of PTA-9 or PTA-17V torches (1 piece cable) to power sources without gas passing through the Twist Mate™ connection. Compatible with PRO-Torch TIG Torches.

**Order K960-1**



#### Parts Kit for TIG Torch

Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box.

**PTA-17 Order KP508**

**PTA-26 and PTW-18  
Order KP509**



#### Caliber™ 17/18/26 Series TIG Torch Expendables Kit - 0.040"-1/8"

Caliber TIG Expendables Kits include all of the front end parts needed to run a Gas Lens set up on 9/20 Series TIG Torches. Caliber TIG Expendables are compatible with both Lincoln Electric and competitive TIG Torches.

**Order KP4760**

### GENERAL OPTIONS

#### Welding Cart



Full-featured cart is designed to store and transport a welder, 80 cubic foot gas cylinder, welding cables and accessories. A sturdy handle can also be used as a convenient cable wrap hanger.  
**Order K2275-3**



#### Welding Table and Workbench

Heavy-duty steel welding accessory features a 21 x 44 in. (533 x 1,117 mm) work surface with strategically located 16mm holes for clamps and squaring blocks, along with multiple slots for cutting and clamping. **Order K5334-1**

## TIG TORCH COMPATIBILITY

| Torch Series | Amperage | TIG Torch Valve       | Adapter | TIG Torch Insert Kit  |
|--------------|----------|-----------------------|---------|-----------------------|
| 17 SERIES    | 150A@60% | K1782-6, -7, -11, -13 | K960-1  | KP508, KP4760-MD, -HD |
| 26 SERIES    | 200A@60% | K1783-7, -9, -11      | K960-1  | KP509, KP4760-MD, -HD |

## PRODUCT SPECIFICATIONS

| Product Name  | Product Number | Input Power Voltage/Phase/Hertz | Rated Output Current/Voltage/Duty Cycle                                                                            | Input Current @ Rated Output | Output Range                    | H x W x D in (mm)                | Net Wt. lb (kg) |
|---------------|----------------|---------------------------------|--------------------------------------------------------------------------------------------------------------------|------------------------------|---------------------------------|----------------------------------|-----------------|
| 225i Stick DV | K5419-1        | 120V/230V/1/60                  | Stick [230V]: 225A/29V/30%<br>Stick [120V]: 65A/22.6V/50%<br>TIG [230V]: 225A/19V/40%<br>TIG [120V]: 95A/13.8V/50% | DC: 28A-230V<br>15A-120V     | 10-225 Amps DC<br>Max. OCV: 82V | 12 x 8 x 14<br>(305 x 203 x 355) | 20<br>(9.1)     |

The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, maintenance of the equipment and the specific welding procedure and application involved. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.

Lincoln Electric Product Claim - Weld fume control products manufactured by The Lincoln Electric Company are designed to be utilized as an engineering safety control to aid in achieving adequate ventilation while conducting welding or its allied processes. The operation of welding fume control equipment is affected by various factors including proper use and positioning of the equipment, and the specific welding procedure and application involved. When the equipment is used as designed - and when properly installed, operated and maintained - it can be a valuable and effective tool to help employers maintain adequate ventilation in the workplace. Lincoln Electric defines adequate ventilation as that which is required to maintain occupational exposure levels below the applicable exposure limits when sound work practices are utilized. Worker exposure level should be checked upon installation and periodically thereafter to be certain it is within applicable OSHA PEL and ACGIH TLV limits.

### 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 information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive 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.

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