

SP-135T

Ready To Weld!

Looking for a versatile, value-packed welding partner for your home hobby shop or workshop? Lincoln's SP-135T is a great choice! This lightweight, compact 120V wire feeder/welder breezes through MIG welds on a wide range of materials including mild steel, stainless steel and aluminum. It also handles flux-cored welds on mild steel with ease. Practically everything you need to MIG weld mild steel is right in the box – just install a cylinder of shielding gas and you'll be welding like a pro in no time!



Processes

MIG Flux-Cored

Advantage Lincoln

- Ready To Weld! Includes mild steel MIG wire and adjustable gas regulator and hose kit. Just add shielding gas (sold separately).
- Large easy to set knobs provide 4-position adjustable tap voltage control and continuous full-range control of wire feed speed.
- Capabilities include welding 24 gauge through 3/16" with MIG and up to 5/16" with self-shielded flux-cored wire. Install K549-1 and use Innershield® NR®-211-MP for flux-cored welding. Install K664-2 Aluminum Feeding Kit and Argon shielding gas to weld 22 gauge through 1/8" aluminum.
- Designed to feed .023-.035" (0.6-0.9mm) diameter mild and stainless steel MIG wire, .035" (0.9mm) diameter flux-cored wire and .035" diameter 4043 aluminum MIG wire.
- Welder settings reference chart conveniently located inside wire feed section door makes it easy to set the machine for mild steel welding jobs.
- Gun trigger controlled output feature provides added safety by keeping welding wire electrically "cold" until trigger is pressed.
- Three year Lincoln Warranty on parts and labor. (90 days warranty on gun and cable.

Description

Output



Input



Base Unit Includes

- Magnum® 100L welding gun and 10 ft. (3.0m) cable assembly, with gas nozzle, .023"-.035" (0.6-0.9mm) cable liner and .023/.025" (0.6mm) contact tip.
- 10 ft. (3.0m) work cable and work clamp.
- 6 ft. (1.8m) input power cord with NEMA Type 5-15P plug for connection to standard 120 volt receptacles.
- Guide tubes and reversible drive roll ready to feed Lincoln's .025" (0.6mm), .030" (0.8mm) and .035" (0.9mm) diameter SuperArc™ L-56 MIG wire and .035" (0.9mm) diameter Innershield® NR®-211-MP flux-cored wire.
- Factory installed gas solenoid valve for MIG welding.
- Adjustable gas regulator and 4.5 ft. (1.37m) hose for argon and argon-blend gases. Gas regulator requires an S19298 adapter (sold separately) for use with CO₂ cylinders.
- 2 lb. (0.90kg) spool of .025" (0.6mm) SuperArc L-56 wire.
- Six spare .023/.025" (0.6mm) contact tips.
- Welding handshield with #10 filter plate and clear glass cover plate.
- One-Pak™ includes everything above plus Welding Cart.

Recommended General Options

Welding Cart, Utility Cart, Small Canvas Cover, MIG Wire Drive Roll, Flux-Cored/MIG Wire Drive Roll, .035" Innershield® Welding Kit, .035" Aluminum Welding Kit, Deluxe Adjustable Gas Regulator & Hose Kit

Order

K1873-1 SP-135T 120/1/60
K2301-1 SP-135T One-Pak™ with Welding Cart 120/1/60

TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Dimensions H x W x D inches (mm)	Net Weight lbs. (kg)
SP-135T	K1873-1	120/1/60	90A/19V/20%	20A	25-135A 50-300 ipm WFS (1.2-7.6 m/min) Max. OCV: 29V	12 x 9.75 x 16.5 (305 x 248 x 419)	47 (21.4)

ADVANTAGE LINCOLN, CON'T.

- Adjustable brake spindle accommodates both 8" (200mm) diameter and 4" (100mm) diameter spools of wire.
- Built-in "burnback" function virtually eliminates the wire sticking in the weld puddle at the finish of the weld.
- Engineered and built for dependable service and long service life.
- "Quick Release" idle pressure arm easily adjusts wire tension for positive wire feeding.
- High capacity output filter capacitor for excellent MIG welding using CO₂, argon or argon/CO₂ gas blends.
- Electronic and thermostatic protection from current overload and excessive temperatures.
- CSA NRTL/C approved.
- Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.

PERFORMANCE PLUS

SP-135T WELDING CAPABILITIES																	
Metal To Weld	Process	Weld Appearance	Wire Electrode	Wire Dia.	24ga.	22ga.	20ga.	18ga.	14ga.	12ga.	1/8"	10ga.	3/16"	1/4"	5/16"	3/8"	1/2"
Mild Steel	Self-Shielded Flux-Cored ⁽¹⁾	Good. Slag must be removed.	Innershield® NR-211-MP	.035													
	Gas-Shielded MIG ⁽¹⁾	Excellent. Little or no cleaning.	SuperArc® L-56	.025													
				.030 .035													
Aluminum	Gas-Shielded MIG ⁽¹⁾	Excellent. Little or no cleaning.	SuperGlaze® 4043	.035													

⁽¹⁾The use of the MIG or flux-cored process on thicker materials than recommended can result in welds of poor quality. The welds may appear to be fine, but may lack the fusion necessary to provide a strong weld. This is called "cold casting" or "cold lapping", and is somewhat similar to a cold solder joint. Weld failure may result.

MAGNUM 100L GUN EXPENDABLE PARTS		
Part	Description	Product Number
Magnum™ 100L Gun & Cable Assembly, 10 ft. (3.0m) cable length	.035" (0.9mm) flux-cored wire .023-.035" (0.6-0.9mm) MIG wire and flux-cored wire	K530-3 K530-5 ⁽¹⁾
Cable Liner	.035-.045" (0.9-1.2mm) .023-.030" (0.6-0.8mm) .030-.035" (0.8-0.9mm) .035" (0.9mm) Teflon (Aluminum)	KP1937-1 KP1937-2 KP1937-3 ⁽¹⁾⁽²⁾ KP1959-1 ⁽³⁾
Gas Diffuser		KP2040-1 ⁽¹⁾
Contact Tips	.023/.025" (0.6mm) Standard Duty .030" (0.8mm) Standard Duty .035" (0.9mm) Standard Duty .023/.025" (0.6mm) Tapered .030" (0.8mm) Tapered .035" (0.9mm) Tapered .035" (0.9mm) Aluminum	KP2039-1 ⁽¹⁾ KP2039-2 KP2039-3 ⁽²⁾ KP2052-1 KP2052-2 KP2052-3 KP2078-1 ⁽³⁾
Gas Nozzle	1/2" (12.7mm) Fixed – Tip Flush 3/8" (9.5mm) Fixed – Tip Recessed 1/2" (12.7mm) Fixed – Tip Recessed 5/8" (15.9mm) Fixed – Tip Recessed	KP1938-1 ⁽¹⁾ KP1942-1 KP1942-2 KP1942-3 ⁽³⁾
Gasless Nozzle		KP1939-1 ⁽²⁾
Gun Tube Assembly	(60°)	KP2038-1 ⁽¹⁾

⁽¹⁾Included with SP-135T. ⁽²⁾Included with K549-1 .035" Innershield Welding Kit. ⁽³⁾Included with K664-2 .035" Aluminum Welding Kit.

TOTAL SOLUTION

For MIG welding on mild or stainless steel:

- Properly orient the drive rolls and install the correct contact tip for selected wire diameter. Included with the SP-135T: .023/.025" contact tip and 2 lb. spool of .025" SuperArc™ L-56 wire (other contact tips and wire types/sizes sold separately).
- Obtain shielding gas (sold separately). The gas regulator that comes with the SP-135T is suitable for argon and argon-blend gases. For welding procedures requiring straight CO₂ shielding gas, purchase adapter for the existing regulator or order K586-1 Deluxe Adjustable Gas Regulator and Hose Kit.
- Use electrode positive (DC+) polarity.

For FCAW-S welding on mild steel:

- Properly orient the drive rolls and install .035" contact tip (not included with SP-135T). For convenience, order K549-1 .035"

Innershield Welding Kit. Order KP1884-1 knurled drive roll for better wire feedability.

- Shielding gas is not required with Lincoln's Innershield wire.
- Use electrode negative (DC-) polarity.

For MIG welding on aluminum:

- Order K664-2 .035" Aluminum Welding Kit. Install non-metallic cable liner, contact tip, drive roll and spool of aluminum wire supplied in kit.
- Obtain 100% Argon shielding gas (sold separately). The gas regulator that comes with the SP-135T is suitable for argon and argon-blend gases.
- Use electrode positive (DC+) polarity.

DRIVE ROLL KITS FOR MILD AND STAINLESS STEEL WIRES

Drive Roll	Groove 1	Groove 2
KP665-035 ⁽¹⁾	.023-.025 Smooth (Solid Wire)	.030-.035 Smooth (Solid Wire)
KP1884-1	.023-.025 Smooth (Solid Wire)	.035 Knurled (Flux-Cored Wire)

⁽¹⁾Included with SP-135T.

RECOMMENDED OPTIONS

GENERAL OPTIONS

Welding Cart

Full-featured cart is designed to store and transport a welder, 80 cubic foot gas cylinder, welding cables and accessories. Includes an angled top shelf for easy access to welder controls, a lower tray for added storage space, a sturdy handle and a convenient cable wrap hanger. Included with One-Pak™.

Order K2275-1.



Utility Cart

Heavy duty cart stores and transports welder, 150 cubic foot shielding gas cylinder, welding cables and accessories. Includes stable platforms for welder and gas bottle platform, lower tray for added storage capacity and adjustable height handle.

Order K520



Small Canvas Cover

Protect your machine when not in use. Made from attractive red canvas that is flame retardant, mildew resistant and water repellent. Includes a convenient side pocket to hold welding torch or gun.

Order K2377-1



MIG Wire Drive Roll

For feeding .023"-.025" and .035" solid wire.

Order KP665-035.



Flux-Cored/MIG Wire Drive Roll

For feeding .023"-.025" solid wire and .035" flux-cored wire.

Order KP1884-1.

RECOMMENDED OPTIONS



GENERAL OPTIONS, CON'T.

.035" Innershield® Welding Kit
Includes everything needed for Magnum™ 100L gun and cable to use .035" (0.9mm) diameter flux-cored wire. Includes a contact tip, gasless nozzle, cable liner, and a 10 lb. (4.5kg) spool of .035" (0.9mm) Innershield® NR®-211-MP wire.

Order K549-1.



Deluxe Adjustable Gas Regulator & Hose Kit

Accommodates CO₂, argon or argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3m) gas hose.

Order K586-1.



.035" Aluminum Welding Kit
Includes drive roll, non-metallic cable liner, and contact tips (qty. 6) for feeding .035" (0.9mm) aluminum MIG wire. Also includes 1 lb. spool of SuperGlaze™ 4043 aluminum MIG wire.

Order K664-2.

SP-135T ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
SP-135T 120/1/60	K1873-1		
SP-135T One-Pak™ with Welding Cart 120/1/60	K2301-1		
Recommended General Options			
Welding Cart	K2275-1		
Utility Cart	K520		
Small Canvas Cover	K2377-1		
MIG Wire Drive Roll ⁽¹⁾	KP665-035 ⁽¹⁾		
Flux-Cored/MIG Wire Drive Roll	KP1884-1		
.035" Innershield® Welding Kit	K549-1		
.035" Aluminum Welding Kit	K664-2		
Deluxe Adjustable Gas Regulator & Hose Kit	K586-1		
TOTAL:			

⁽¹⁾ Included with SP-135T.

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 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.

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