

FLEXTEC® MULTI-PROCESS WELDERS

FLEXTEC 350X, 500, 500P, 650



LINCOLN
ELECTRIC

It Doesn't Get Much Simpler Than FLEXTEC.

Out on the construction jobsite or in most fabrication shops, it pays to keep it simple. The Flextec platform is designed for that kind of environment. These multi-process welders are easy to setup and easy to operate, yet rugged and flexible enough to be used in construction, fabrication, shipbuilding and other heavy-duty applications.



FLEXTEC FAMILY OVERVIEW

Machine	Input (V)	Output (A)		SMAW	GTAW	GMAW	Pulse	FCAW-G	FCAW-S	SAW	Gouging carbon diameter in. (mm)
		100%	60%								
FLEXTEC 350X Construction	380-575 3 Phase	300	350	•	•	•		•	•		3/16 (4.8)
FLEXTEC 350X Standard	380-575 3 Phase	300	350	•	•	•		•	•		3/16 (4.8)
FLEXTEC 500	380-575 3 Phase	450	500	•	•	•		•	•		3/8 (9.6)
FLEXTEC 500P	380-575 3 Phase	450	500	•	•	•	•	•	•		3/8 (9.6)
FLEXTEC 650	380-575 3 Phase	650	750	•	•	•		•	•	•	1/2 (12.7)

Simple

- Streamlined operator panel minimizes setup time

Reliable

- Built on industry-proven design elements
- Engineered for outdoor use and harsh environments (IP23 rated)

Flexible

- Compatible with portable feeders and bench or boom feeders of all types.
- Choice of models to fit any application and budget

“WE WANT TO HAVE THE BEST EQUIPMENT TO GIVE US THE HIGHEST-QUALITY WELDS, BUT WE ALSO WANT, FROM THE PERFORMANCE SIDE, TO KNOW THAT DESPITE THE ROUGH ENVIRONMENT, IT’S GOING TO START AND OPERATE RELIABLY. **THERE’S NO TIME FOR DOWNTIME.**”

— STEVE KONZEL // DONJON SHIPBUILDING AND REPAIR, ERIE, PA

Processes »

Stick, DC TIG, MIG, Flux-Cored, Arc Gouging

Applications »

Fabrication, Production, Education, Shipbuilding, Construction

Output »



Input »



Product Number »

Flextec 350X:

- K4271-1 350X Construction Model
- K4272-1 350X Standard Model

Flextec 500:

- K4091-1 Base Model

Flextec 500P:

- K4092-1 Base Model

Flextec 650:

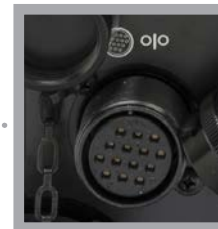
- K3060-1 Base Model

Flexibility



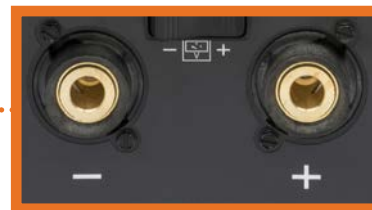
5-pin (Lincoln Electric Power Feed® models)

5-pin high-speed digital communication enables advanced process capability and additional operator controls.



14-pin (Lincoln Electric LF, LN and Flex Feed™ models)

14-pin analog communication enables remote voltage control. (specific models only)



Across-the-arc (Lincoln Electric LN-25 PRO / Activ8® models)

Across-the-arc feeders connect to the power source using the weld cables. No control cable is used, resulting in no voltage control at the feeder.

CrossLinc™

(Lincoln Electric LN-25X model)

CrossLinc is a new Lincoln Electric communication protocol that enables voltage control at the feeder through a standard weld cable.

FEEDER FLEXIBILITY BY FEATURES

• Included • Specific Models Only

Features	WFS Control	Voltage Control	Memories	Setting Lockouts	Advanced U/I Controls	Synergic Modes	Pulsing Capability
5-pin Digital (ArcLink)	•	•	•	•	•	•	•
14-pin Analog	•	•	•				
CrossLinc	•	•					
Across-the-arc	•						

FEEDER FLEXIBILITY BY PRODUCT

Model	Voltage Sensing/Across-the-arc	14-pin Analog	5-pin Digital	CrossLinc
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MACHINES

Flextec 350X Construction	•			•
Flextec 350X Standard	•	•	•	•
Flextec 500	•	•	•	
Flextec 500P	•	•	•	
Flextec 650	•	•		

WIRE FEEDERS

LF-72/74		•		
LN-10/DH-10		•		
Flex Feed™ 74HT		•		
Power Feed® Family			•	
LN-25	•			
LN-25 Pro Dual	•	•		
LN-25X	•			•
Activ8®	•			

FLEXTEC 350X

Construction Controls »

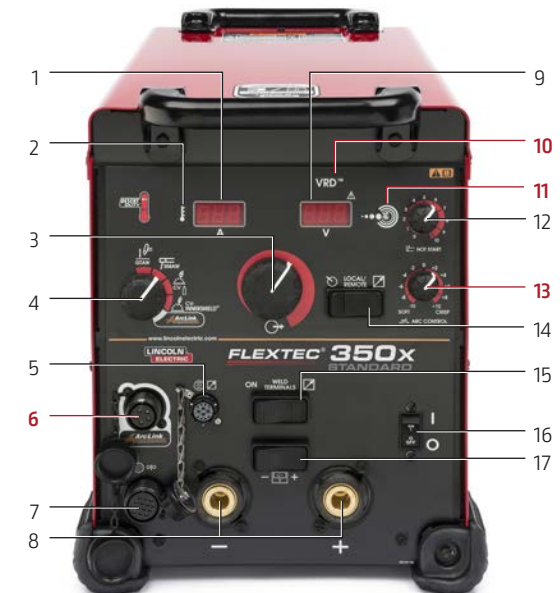
1. Amperage Display
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Remote Output Control (12-pin Universal Connector)
6. Positive and Negative Welding Output Studs (Tweco®-style)
7. Voltage Display
8. VRD™ (Voltage Reduction Device) Indicator Lights
9. CrossLinc™ Indicator Light
10. Hot Start Control Dial
11. Arc Force Control Dial
12. Local/Remote Selector Toggle Switch
13. Power Switch



FLEXTEC 350X

Standard Controls »

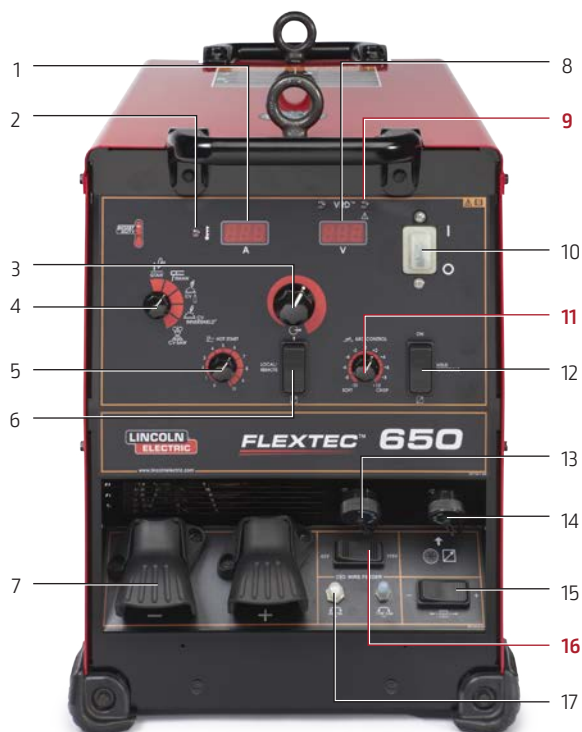
1. Amperage Display
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Remote Output Control (12-pin Universal Connector)
6. 5-pin ArcLink® Wire Feeder Connector
7. 14-pin Wire Feeder Connector
8. Positive and Negative Welding Output Studs (Tweco®-style)
9. Voltage Display
10. VRD (Voltage Reduction Device) Indicator Lights
11. CrossLinc™ Indicator Light
12. Hot Start Control Dial
13. Arc Force Control Dial
14. Local/Remote Selector Toggle Switch
15. Weld Terminals On/Remote Selector Switch
16. Power Switch
17. Wire Feeder Voltmeter Polarity Selection Switch





FLEXTEC 500/500P Controls »

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Hot Start Control Dial
5. Weld Process Selector Switch
6. Local/Remote Selector Toggle Switch
7. Circuit Breaker Reset Button for the 5-pin Wire Feeder Connector
8. **5-pin ArcLink® Wire Feeder Connector**
9. Positive and Negative 1/2 in. (12.7 mm) Welding Output Studs
10. **VRD™ (Voltage Reduction Device) Indicator Lights**
11. Voltage Display Meter
12. Power Switch
13. **Arc Force Control Dial**
14. Weld Terminals On/Remote Selector Switch
15. Circuit Breaker Reset Button for the 14-pin Wire Feeder Connector
16. Remote Output Control (12-pin Universal Connector)
17. 14-pin Wire Feeder Connector
18. Wire Feeder Voltmeter Polarity Selection Switch



FLEXTEC 650 Controls »

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Hot Start Control Dial
6. Local/Remote Selector Toggle Switch
7. Positive and Negative Welding Output Studs
8. Voltage Display Meter
9. **VRD™ (Voltage Reduction Device) Indicator Lights**
10. Power Switch
11. **Arc Force Control Dial**
12. Weld Terminals On/Remote Selector Switch
13. 14-pin Wire Feeder Connector
14. 6-pin Remote Connector
15. Wire Feeder Voltmeter Polarity Selection Switch
16. **115V or 42V Wire Feeder Selector Switch**
17. Circuit Breaker Reset Buttons for the 14-pin Wire Feeder Connector

SPECIFICATIONS

MACHINES	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 lb (kg)
FLEXTEC 350X Construction	K4271-1	380/460/575/3/50/60	350A/34V/60% 300A/32V/100%	26/23/18	5-425A Max OCV 80V DC	17 x 13 x 23 [477 x 356 x 673]	77 [34.9]
FLEXTEC 350X Standard	K4272-1						82 [37.1]
4-Pack Rack FLEXTEC 350X Standard (machines included)	K4280-1			74/68/68		67.25 x 37.5 x 33 [1784 x 952 x 838]	508 [230]
6-Pack Rack FLEXTEC 350X Standard (machines included)	K4281-1			100/90/90		70.25 x 49.5 x 33 [1784 x 1257 x 838]	662 [300]
4-Pack Rack FLEXTEC 350X Construction (machines included)	K4276-1			74/68/68		67.25 x 37.5 x 33 [1784 x 952 x 838]	488 [221]
6-Pack Rack FLEXTEC 350X Construction (machines included)	K4277-1			100/90/90		70.25 x 49.5 x 33 [1784 x 1257 x 838]	632 [287]
FLEXTEC 500	K4091-1	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	18.8 x 14 x 26.5 [477 x 356 x 673]	120 [54]
FLEXTEC 500 with Flex Feed™ 74 HT Ready-Pak®	K4093-1						352 [159.7]
FLEXTEC 500/LF-72 Ready-Pak	K4094-1						347 [157.4]
FLEXTEC 500/LF-74 Ready-Pak	K4095-1						347 [157.4]
FLEXTEC 500 One-Pak®	K4096-1						180 [81.6]
4-Pack Rack FLEXTEC 500 (machines included)	K4098-1			103/75/61A		67.25 x 37.5 x 33.0 [1784 x 952 x 838]	800 [362.8]
6-Pack Rack FLEXTEC 500 (machines included)	K4099-1			138/100/81A		70.25 x 49.5 x 33.0 [1784 x 1257 x 838]	1100 [499]
FLEXTEC 500P	K4092-1	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	18.8 x 14 x 26.5 [477 x 356 x 673]	120 [54]
FLEXTEC 500P with Power Feed® 84 Ready-Pak package	K4097-1						352 [159.7]
FLEXTEC 650	K3060-1	380/460/575/3/50/60	750A/44V/60% 650A/44V/100%	61-50/40 57/47/38	10-815A	21.8 x 16.1 x 29.3 [554 x 409 x 584]	165 [74.8]
FLEXTEC 650/LF-72 Heavy Duty Ready-Pak	K3145-1						395 [179]
FLEXTEC 650/LF-74 Heavy Duty Ready-Pak	K3146-1						395 [179]
FLEXTEC 650/LF-74 Heavy Duty One-Pak	K3147-1						
FLEXTEC 650/LN-10 One-Pak	K3158-1						
4-Pack Rack FLEXTEC 650 (machines included)	K3144-1			202/167/105A		67.7 x 37.5 x 33 [1719 x 952 x 838]	2112 [958]

Packages

FLEXTEC 350X CONSTRUCTION PACKAGES	Product Number	LN-25X One-Pak® K4278-1
LN-25X	K4267-1	•
Drive Roll and Wire Guide Kit 0.045 (1.1 mm) Cored	KP1697-045C	•
Magnum® PRO Curve™ 300 Gun and Cable Ready-Pak - 15 ft (4.5 m)	K2951-2-10-45	•

FLEXTEC 500 PACKAGES	Product Number	Flex Feed 74HT Ready-Pak® K4093-1	LF-72 Heavy Duty Ready-Pak K4094-1	LF-74 Heavy Duty Ready-Pak K4095-1	LF-72 Standard Duty One-Pak K4096-1
Flex Feed™ 74HT, High Torque for larger wire diameters	K3883-13	•			
LF-72 Bench Model, Heavy Duty Wire Reel Stand	K2327-7		•		
LF-72 Bench Model, Standard Duty Wire Reel Stand	K2327-5				•
LF-74 Bench Model, Heavy Duty Wire Reel Stand	K2426-5			•	
Power Feed® 84, Heavy Duty Wire Reel Stand, U/I, USB	K3328-13				
3/0 Welding Cable (10 ft lug to lug)	K1842-10	•	•	•	•
Work Lead Package (15ft) includes GC500 ground clamp	K2149-1	•	•	•	•
Harris® Flowmeter Regulator and Hose	3100211	•	•	•	•
Inverter and Wire Feeder Cart	K3059-2	•	•	•	
Inverter Cart Mounting Bracket Kit – secures 74HT feeder to (K3059-2) Inverter Cart	K4068-1	•			
Flextec 500 / 500P Locking Foot Kit – secures Flextec to the Inverter Cart	K3056-2	•	•	•	
Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak - 15 ft (4.5 m). See Bulletin E12.05	K2952-2-10-45	•	•	•	

FLEXTEC 500P PACKAGES	Product Number	Power Feed 84 Ready-Pak K4097-1
Power Feed® 84, Heavy Duty Wire Reel Stand, U/I, USB	K3328-13	•
3/0 Welding Cable (10 ft lug to lug)	K1842-10	•
Work Lead Package (15ft) includes GC500 ground clamp	K2149-1	•
Harris® Flowmeter Regulator and Hose	3100211	•
Inverter and Wire Feeder Cart	K3059-2	•
Inverter Cart Mounting Bracket Kit – secures 74HT feeder to (K3059-2) inverter cart	K4068-1	•
Flextec 500 / 500P Locking Foot Kit – secures Flextec to the Inverter Cart	K3056-2	•
Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak - 15 ft (4.5 m). See Bulletin E12.05	K2952-2-10-45	•

FLEXTEC 650 PACKAGES	Product Number	LF-72 Heavy Duty Ready-Pak K3145-1	LF-74 Heavy Duty Ready-Pak K3146-1	LF-74 Heavy Duty One-Pak K3147-1	LN-10 One-Pak K3158-1
LF-72 Bench Model, Heavy Duty Wire Reel Stand	K2327-7	•			
LF-74 Bench Model, Heavy Duty Wire Reel Stand	K2426-5		•	•	
LN-10 Bench Model	K1559-3				•
3/0 Welding Cable (10 ft lug to lug)	K1842-10	•	•	•	•
Work Lead Package (15ft) includes GC500 ground clamp	K2149-1	•	•	•	•
Harris® Flowmeter Regulator and Hose	3100211	•	•	•	•
Inverter and Wire Feeder Cart	K3059-2	•	•		
Drive Roll and Wire Guide Kit 1/16 in. (1.6 mm) Cored	KP1505-1/16C		•	•	•
Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak - 15 ft (4.5 m). See Bulletin E12.05	K2952-2-10-45	•	•	•	•
Gun Connector Kit	K466-10		•	•	•
Liner 0.052-1/16 in. (1.3-1.6 mm) dia. 15 ft (4.6 m) length	KP44-116-15		•	•	•



Flextec 650
4-pack Rack
(K3144-1)



Flextec 650/LF-72
Ready-Pak
(K3145-1)



Flextec 350X/LN-25X
One-Pak (K4278-1)

Accessories

			350X	350X	500	500P	650
			Standard Model	Construction Model	Base Model	Base Model	Base Model
	Product Number		K4272-1	K4271-1	K4091-1	K4092-1	K3060-1
• Optional							
GENERAL							
Multi-Process Switch – Easily switch between CC and CV processes (Flextec locking kit recommended)	K3091-1		•	•	•	•	•
12-pin to 6-pin Adapter – Allows 6-pin remote controls (K870, K963-3, K857, K4217-1) to be used with 12-pin Universal Connection	K2909-1		•	•	•	•	
Wireless Foot Pedal with 6-pin Amphenol[†]	K4217-1		•	•	•	•	•
Remote Output Control with 12-pin Universal Connector (25 feet) – Permits remote adjustment of output	K857-2		•	•	•	•	•
Remote Output Control with 6-pin Amphenol Connector (25 feet) – Permits remote adjustment of output [†]	K857		•	•			•
Remote Output Control with 6-pin Amphenol Connector (100 feet) – Permits remote adjustment of output [†]	K857-1		•	•	•	•	•
Foot Amptrol[®] with 6-pin Amphenol connector (25 ft) – Remote current control for TIG welding [†]	K870						•
Foot Amptrol with 12-pin Amphenol connector (25 ft) – Remote current control for TIG welding	K870-2				•	•	
Hand Amptrol Rotary Track Style, 6-pin Amphenol (25 ft) – Remote current control for TIG welding	K963-3		•	•	•	•	•
Flextec CE Filter Kit (380-575 Vac)	K4420-1		•	•			
Flextec CE Filter Kit (380-575 Vac)	K3975-1				•	•	
Flextec CE Filter Kit (380-575 Vac)	K3129-2						•
3/0 Welding Cable – Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft.	K1842-10				•	•	•
Work Lead Package – Lug to Lug, 4/0 cable with GC500 work clamp. 15 ft. (4.6 m) length	K2149-1				•	•	•
Harris[®] Model 355 Flowmeter Regulator and Hose – Includes 10 ft. (3.0 m) hose	3100211		•	•	•	•	•
Inverter and Wire Feeder Cart – Requires K4068-1 mounting bracket for LF, Flex Feed™ and Power Feed [®] Feeders. Requires locking foot kit for Flextecs	K3059-2		•	•	•	•	•
Inverter Cart Mounting Bracket Kit – Use for mounting feeder to the K3059-2 inverter cart	K4068-1		•	•	•	•	•
Flextec 350 Locking Foot Kit – Allows the Flextec to lock to the inverter cart, Multi-Process Switch, Cool-Arc [®] 55 water cooler	K4424-1		•	•			
Flextec 500 / 500P Locking Foot Kit – Allows the Flextec to lock to the inverter cart, Multi-Process Switch, Cool-Arc 55 water cooler	K3056-2				•	•	

[†]Requires the K2909-1 12-pin to 6-pin adapter if used with Flextec 350X, 500, 500P.

			350X	350X	500	500P	650
			Standard Model	Construction Model	Base Model	Base Model	Base Model
			K4272-1	K4271-1	K4091-1	K4092-1	K3060-1
ACCESSORIES	• Optional	Product Number					
WIRE FEEDERS							
LN-25X – Includes CrossLinc communication technology		K4267-1	•	•			
Flex Feed™ 74 HT – Four drive-roll, high-torque, industrial semiautomatic wire feeder for general and structural fabrication		K3883-13	•	•	•	•	•
LF-72 Bench Model, Standard Duty Wire Reel Stand – Two drive roll feeder designed for MIG and cored wire welding in job shop and manufacturing environments		K2327-5	•	•	•	•	•
LF-72 Bench Model, Heavy Duty Wire Reel Stand – Two drive roll feeder designed for MIG and cored wire welding in job shop and manufacturing environments		K2327-7	•	•	•	•	•
LF-74 Bench Model, Heavy Duty Wire Reel Stand – Four drive roll feeder designed for MIG and cored wire welding in job shop and manufacturing environments		K2426-5	•	•	•	•	•
LN-10 Bench Model – Four drive roll feeder designed for maximum versatility in today's demanding industrial environment		K1559-3	•	•	•	•	•
Power Feed® 84, Heavy Duty Wire Reel Stand, U/I, USB – Four drive roll, digital ArcLink® semiautomatic industrial wire feeder built on a modular platform to be used in a variety of applications		K3328-13	•	•	•	•	
Magnum® PRO Curve™ 300 Gun and Cable Ready-Pak - 15 ft (4.5 m) – For MIG or flux-cored welding. Includes Tweco®-style back-end connector kit, liner, diffuser, nozzle, contact tip fully assembled		K2951-2-10-45	•	•			
Magnum® PRO Curve™ 400 Gun and Cable Assembly – For MIG or flux-cored welding. Includes Tweco-style back-end connector kit, liner, diffuser, nozzle, contact tip fully assembled		K2952-2-10-45			•	•	•
Magnum® PRO Guns and Accessories – See publication e12.05		—	•	•	•	•	•

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.

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