

ACTIV8X[®] PIPE[™] CE

PORTABLE, SEMIAUTOMATIC WIRE FEEDER



PERFECTLY TUNED FOR PIPE WELDING

The Activ8X[®] Pipe[™] CE Wire Feeder is the ideal field solution for GMAW and FCAW-G welding applications out on the pipeline. With weld processes specifically optimized for pipe welding, the Activ8X Pipe CE allows you to take Lincoln Electric's industry-leading root-to-cap weld processes – including STT[®] and Pulsed MIG – right out to the field. In addition, the rugged and compact design provides durability to withstand the harshest conditions, from mud and rain, to extreme heat or cold, delivering the reliability you need to perform in the toughest welding applications.

Processes »

STT[®] Field, CV-MIG, CV-FCAW-G, Pulsed MIG

Applications »

Cross Country Pipe
Process Pipe
Structural Field Welding
Shipbuilding

Output »



Product Number »

K5240-1 Activ8X Pipe CE (Twist Mate)

KEY FEATURES

- **Excellent Arc Performance**

Optimized arc performance designed specifically for root-to-cap pipe welds, including STT Field and CV/Pulse modes for excellent sidewall fusion, backbead reinforcement, and overall bead profile.

- **Ultimate Control**

Full control over the weld process can be easily made right at the wire feeder - no need to waste time walking back to the power supply for adjustments.

- **Rugged & Portable Design**

Built on Lincoln Electric's proven portable feeder platform the Activ8X Pipe delivers a lightweight, yet dependable solution that can withstand the extreme conditions of field construction applications.

- **Straightforward Setup**

From truck to ditch, setup is fast and easy. Connection between the Activ8X Pipe and power source is as simple as two standard quick-connect weld cables.

KEY CONTROLS

1. WFS and Volt Meter
2. WFS and Voltage Control
3. CrossLinc® LED
4. Menu Selection Encoder
5. Weld Procedure Display
6. Memory Selection
7. Gun Trigger Connection
8. Gun Connection
9. Work Lead Connection



1. MAXTRAC® Wire Drive
2. Cold Feed / Gas Purge
3. Trigger Interlock Switch
4. Accommodates Up To 8 In. Dia. Spools
5. Lift Bail



1. Shielding Gas Inlet
2. Electrode + (from power source)
3. Work Lead - (from power source)

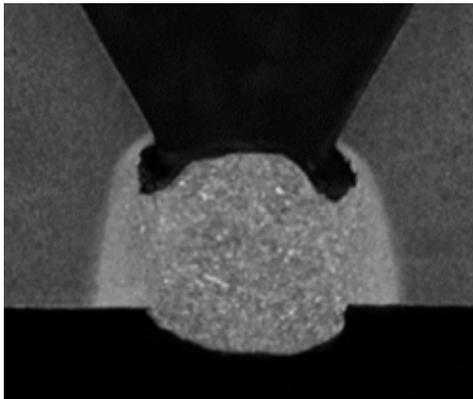
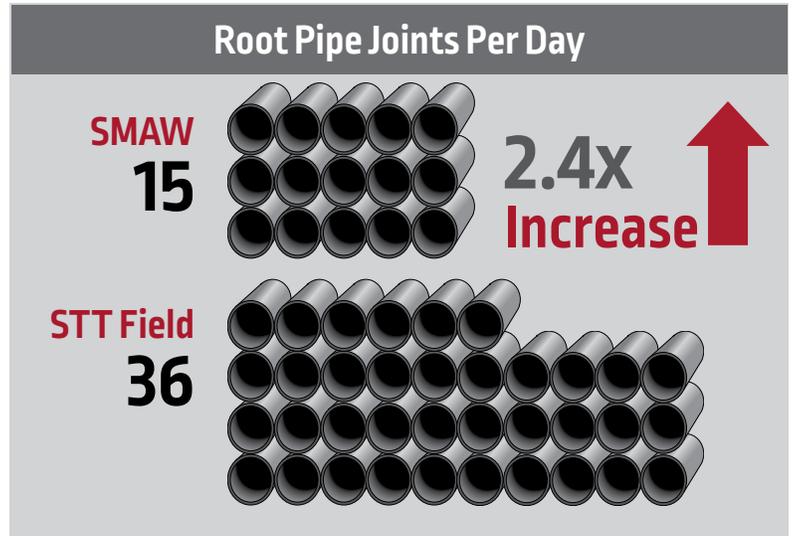


STT® FIELD

All the industry-proven root pass performance of STT® (SurfaceTension Transfer®), now available right on the construction site with minimal equipment, cables, and setup time

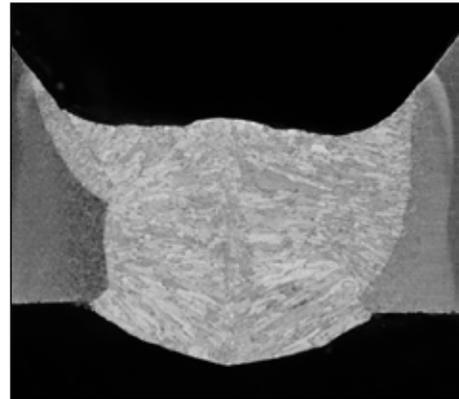
- Breakthrough travel speeds
- Industry-leading arc stability
- Excellent fusion and back bead reinforcement

*Comparison based on 5G vertical down welding on 18 in. Pipe Joints during a normal 8-hour shift. Includes timing for necessary post-weld cleaning.



Traditional Stick Root Pass

- Medium-sized bead
- Convex shape
- Ropy back bead



STT Field Root Pass

- Larger bead
- Flat face
- Ideal back bead & fusion

PULSE TAILORED FOR PIPE

The Activ8X Pipe was engineered to deliver the ideal pulse arc for your pipe welding needs. With built-in technology that monitors machine settings, the Activ8X pipe can automatically adjust the pulse waveform for superior arc performance on fill and cap applications.

- Set a low WFS – Activ8X Pipe auto-adjusts for a narrow, focused arc
- Set a high WFS – Activ8X Pipe auto-adjusts for a wide, soft arc
- Less time adjusting means more time welding

OPTIMIZED WELD MODES

Loaded with weld modes optimized specifically for field pipe welding applications, the Activ8X Pipe delivers fine-tuned weld modes for maximum performance based on the industry's common filler metal, wire diameters, and gas mixtures.

- Synergic MIG modes optimized for 0.035 in. (0.9 mm), 0.040 in. (1.0 mm), and 0.045 in. (1.2 mm) steel, stainless steel and metal-cored
- Versatility of Non synergic CV for FCAW-G and additional wire alloys

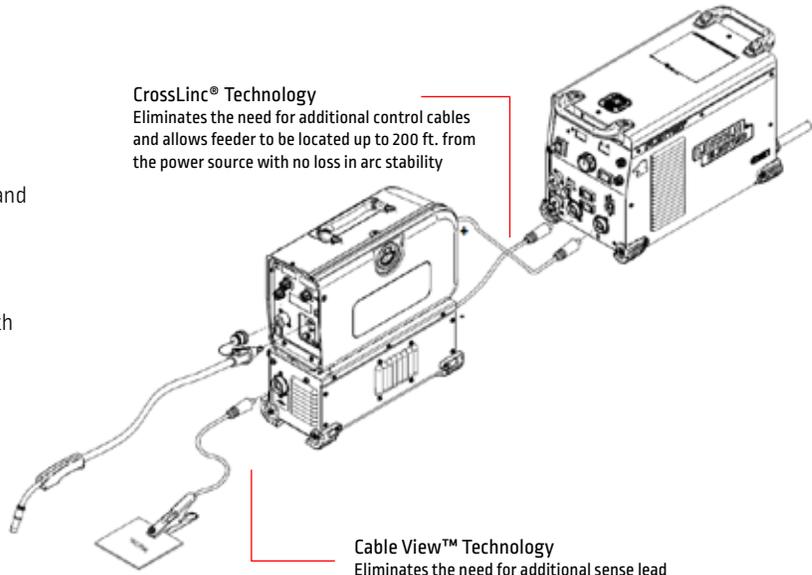
SYSTEM SETUP FEATURES

CROSSLINC® TECHNOLOGY

CrossLinc® feeders enable voltage control at the feeder without the extra cable. The result is greater productivity, safety, and quality. Avoid the negative aspects of across the arc models and adding a control cable, while enjoying all the benefits

- Productivity - Work smarter, reduce movement, and minimize rework
- Safety - Reduce cable clutter and potential trip hazards
- Quality - Meet WPS specifications more easily with greater operator control

CrossLinc® Technology
Eliminates the need for additional control cables and allows feeder to be located up to 200 ft. from the power source with no loss in arc stability



CABLE VIEW™ TECHNOLOGY

With patented Cable View™ Technology, the Activ8X Pipe continuously monitors cable inductance and adjusts the waveform to maintain consistent arc performance **without the need for an additional sense lead.**

Cable View™ Technology
Eliminates the need for additional sense lead

PROCESS CONTROL

FULL CONTROL WHERE YOU NEED IT

The Activ8X Pipe system allows you to control everything you need right at the feeder. With a straightforward user interface, operators can easily change between processes and have confidence the right parameters are dialed in for every pass.

Easily select and dial in:

- Weld Mode
- Wire Type
- Gas Type
- WFS and Volts (Trim)

MEMORY OPTIONS

Easily store and select up to four memories for quick process change between root, fill, and cap passes.

TRUE ENERGY

Patented True Energy® Technology allows for accurate measurement and calculations of total energy (per ASME section IX code) instantaneously throughout the weld. Displayed after each weld, True Energy enables faster heat input calculations for critical welds and logs measurements for the past 20 welds.



RECOMMENDED POWER SOURCE

FLEXTEC 350XP

| Part Number | Description |
|-------------|---|
| K5422-1 | Flextec 350XP CE-compliant (Twist Mate) |



RECOMMENDED ACCESSORIES

DRIVE ROLLS

| Part Number | Description |
|--------------------|--|
| Solid Wires | |
| KP1696-1 | 0.035 - 0.045 in. (0.9 - 1.2 mm) V-Groove MAXTRAC® Drive roll and wire guide kit |
| KP1696-035S | 0.035 in. (0.9 mm) V-Groove MAXTRAC Drive roll and wire guide kit |
| KP1696-2 | 0.040 in. (1.0 mm) V-Groove MAXTRAC Drive roll and wire guide kit |
| KP1696-045S | 0.045 in. (1.2 mm) V-Groove MAXTRAC Drive roll and wire guide kit |
| Cored Wires | |
| KP1697-045C | 0.040-0.045 in. (1.0 - 1.2 mm) Knurled MAXTRAC Drive roll and wire guide kit |

PRODUCT SPECIFICATIONS

| Product Name | Product Number | Input Power | Rated Output / Voltage / Duty Cycle DC+ Only | Wire Diameter (mm) | Wire Feed Speed m/min | Max Spool Capacity diameter | Dimensions H x W x D (mm) | Net Weight (kg) |
|------------------------------|----------------|-------------------|--|--------------------|-----------------------|------------------------------------|---------------------------|-----------------|
| Activ8X Pipe CE (Twist Mate) | K5240-1 | 60-90VDC, 60V OCV | 275A/27V/60% 250A/25V/100% | 0.9 - 1.2 | 1.27-17.8 | Diameter: 203 mm Weight: 6.8 kg | 457 x 203 x 483 | 22.2 |

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.

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