

HyperFill® Flextec®

HYPERFILL FCAW WELDING SYSTEM



Shown: Flextec 650X HF and
DLF-84 (Undercarriage Configuration) with
HyperFill Reel Stand



Shown: Flextec 500X HF and
DLF-84 (Cart Configuration) with
HyperFill Reel Stand

THE ULTIMATE HIGH-DEPOSITION SOLUTION

The HyperFill® Flextec® System is a groundbreaking combination of our field-proven Flextec and DLF platforms with the revolutionary HyperFill twin-wire technology. This complete solution is engineered to maximize ease of use, weld productivity, and equipment reliability—all in one integrated package.

Productivity: High-deposition welding—faster, easier, and more efficient.

Weld Quality: Stable arc for precise control of large weld puddles.

Ease of Use: Simple interface with all controls accessible from the DLF wire feeder.

Durability: Rugged design ensures long-term reliability in demanding environments.

Processes »

SMAW, GTAW, GMAW, GMAW-P*, FCAW, HyperFill FCAW, SAW, Arc Gouging

*GMAW-P available on 500X HF only

Applications »

Fabrication Shops
Welding Production Facilities
Education and Training Facilities

Output »



Product Numbers »

K6008-1 Flextec 500X HyperFill
K6009-1 Flextec 650X HyperFill
K5287-1 DLF-84 Base Model
K5991-1 DLF-84 HyperFill Reel Stand

Built for the Fab Shop.

Flextec industrial multi-process welders provide the ideal combination of simplicity, flexibility, and reliability to handle all of your fabrication needs.

- When using a Flextec with a DLF wire feeder, all controls are transferred to the wire feeder. Simple. Easy.
- Flexible, multi-process capabilities
- Reliable, rugged design with trayed and potted PC boards to withstand the harshest environments
- Smart Fans run only as needed to reduce energy usage
- Industry-Leading Warranty – 5 years of full coverage, including parts and labor, with a fast, streamlined claims process

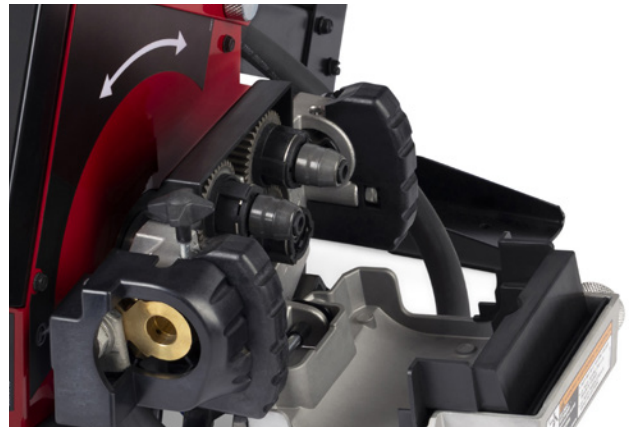


INDUSTRY LEADING
5-YEAR
STANDARD
WARRANTY

ENHANCED WIRE DRIVE SYSTEM

The field-proven feeder brings a robust four-roll drive system to the DLF lineup, delivering faster, more consistent wire feeding performance.

- Patented design for simple, tool-less setup
- Split wire guides provide full wire support and helps eliminate bird nesting
- Convenient, single drive-roll tension adjustment with visual scale
- Interchangeable brass gun connection for optimal arc stability

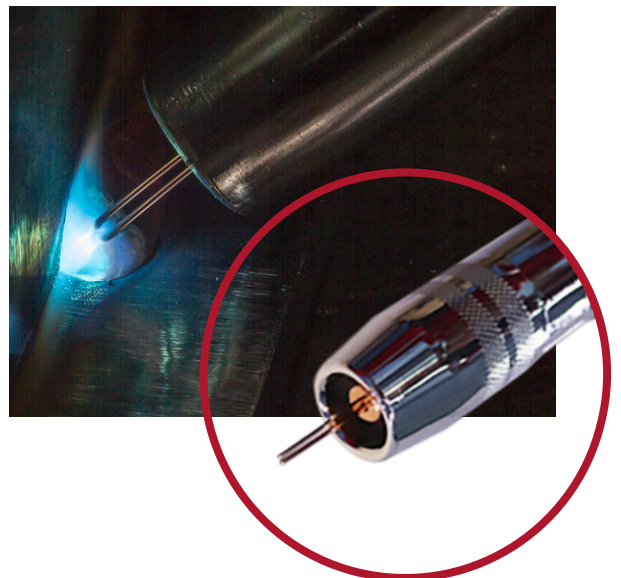


HYPERFILL TWIN-WIRE FCAW

HyperFill FCAW was developed to transform heavy fabrication productivity. This innovative twin-wire FCAW process redefines high-deposition, all-position welding – allowing for bigger welds, faster, easier.

- Higher Productivity – Deposition rates exceeding 13+ lbs/hr
- Superior Quality – Stable arc and smooth transfer for precise puddle control
- Easy Setup – One power source, one feeder, one contact tip
- Better Penetration – Optimized profile for stronger welds

Note: HyperFill Flextec power sources only support HyperFill FCAW welding processes. HyperFill GMAW is not supported at this time.



STEP 1: SELECT A POWER SOURCE

Consider amperage and wire size required for application



Power Source Options

Product Name	Rated Output: Current/Voltage/Duty Cycle	Wire Size	Product Number
Flextec 500X HF	500A/40V/60% 450A/38V/100%	HyperFill FCAW modes for: 1.2 mm (0.045 in.) wire	K6008-1
Flextec 650X HF	750A/44V/60% 650A/44V/100%	HyperFill FCAW modes for: 1.2 mm (0.045 in.) and 1.4 mm (0.052 in) wire	K6009-1

STEP 2: SELECT WIRE FEEDER & MOUNTING CONFIGURATION

Consider mobility requirements of the power source and wire feeder



DLF-84 with CART CONFIGURATION

Product Name	Product Number
Wire Feeder	
DLF-84 Wire Feeder	K5287-1
HyperFill Wire Reel Stand with Plate	K5991-1
Cart Components	
Cart for Inverter and Wire Feeder	K3059-4
DLF Mounting Bracket	K5395-1
Flextec 500X Foot Locking Kit*	K3056-2

*Only required for Flextec 500X HF – Flextec 650X HF comes standard with Foot Locking Kit



DLF-84 with UNDERCARRIAGE CONFIGURATION

Product Name	Product Number
Wire Feeder	
DLF-84 Wire Feeder	K5287-1
HyperFill Wire Reel Stand with Plate	K5991-1
Undercarriage Components	
Four Wheeled Wire Feeder Cart	K163-1

STEP 3: CHOOSE CABLES

Product Name	Product Number
10.6 m (35 ft.)	
Weld Power Cable	K4483-35
ArcLink® Cable	K1842-35
15 m (50 ft.)	
Weld Power Cable	K4483-50
ArcLink Cable	K1842-50
30.5 m (100 ft.)	
Weld Power Cable	K4483-100
ArcLink Cable	K1842-100

STEP 4: SELECT ADDITIONAL ACCESSORIES

Product Name	Product Number
Welding Torch	
Torch 450A air cooled (450A 100% Duty Cycle Mixed Gas)	
Magnum Pro Curve 450 HDE HyperFill Ready -Pak 15ft	K5384-2-10-047H
Magnum Pro Curve 450 HDE standard torch 15ft (includes single arc accessories needed to fit HyperFill liner and accessories)	K4533-2
Torch 350A air cooled (350A 100% Duty Cycle Mixed Gas)	
Magnum Pro Curve 350 HDE HyperFill Ready -Pak 15ft	K5383-2-10-047H
Magnum Pro Curve 350 HDE standard torch 15ft (includes single arc accessories needed to fit HyperFill liner and accessories)	K4532-2
HyperFill Torch Components	
Contact Tips	
HyperFill FCAW 1.2mm SLOT tip	KP5368-045
HyperFill FCAW 1.4mm SLOT tip	KP5368-052
Diffusers	
Air Cooled Diffuser Dual Cam	KP5367-2-HD
Liners	
Liner 2 x 1.2mm	KP44-332-15
Nozzles for both Magnum 350 HDE & 450 HDE 5/8 Dia Opening	
Recess Nozzle (tip 3mm recessed from the nozzle end) 5/8 ID	KP2743-1-62R
Flush Nozzle (tip flush with end of nozzle) 5/8 ID	KP2743-1-62F
Stick Out Nozzle (tip sticks out) 5/8 ID	KP2743-1-62S
Nozzles for both Magnum 350 HDE & 450 HDE 3/4 Dia Opening	
Recess Nozzle (tip 3mm recessed from the nozzle end) 3/4 ID	KP2743-1-75R
Flush Nozzle (tip flush with end of nozzle) 3/4 ID	KP2743-1-75F
Stick Out Nozzle (tip sticks out) 3/4 ID	KP2743-1-75S
Optional Accessories	
Power Feed 25M Portable Suitcase (Feeder for Construction)	
PF25M feeder	K2536-5
PowerFeed 25M HyperFill Dual 5kg coil spindle	K5474-1
HyperFill Cored Drive Rolls 1.2mm x 2 (PF25M)	KP4388-4
Drive Rolls	
HyperFill 2-Roll Drive Roll Kit (0.045 / 1.2 mm) and (0.052 / 1.4 mm) - Cored Wire	KP4388-4
Work, Ground, Or Earth Lead	
Work, Ground, Earth Lead 15 ft. (4.6 m)	KP2149-1

PRODUCT SPECIFICATIONS - WIRE FEEDER

Product Name	Product Number	Input Power	Rated Output: Current/Voltage/Duty Cycle	Solid Wire Diameter Range in. (mm)	Cored Wire Diameter Range In. (mm)	Wire Feed Speed Range: ipm (m/min)	Dimensions H x W x D in. (mm)	Weight lbs (kg)
DLF-84 Base Model	K5287-1	40 VDC	600A @ 60%	0.025 - 3/32 [0.6 - 2.38]	0.035 - 0.120 [0.9 - 3.0]	35 - 1200 [0.89 - 30.5]	12.7 x 13.85 x 15.8 [323 x 352 x 401]	28 [12.7]
DLF-84 HyperFill Reel Stand	K5991-1						24 x 15 x 19 [610 x 381 x 483]	15 [6.8]

PRODUCT SPECIFICATION - POWER SOURCES

Product Name	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 500X HF	K6008-1	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 27.5 [477 x 356 x 699]	136 [62]
Flextec 650X HF	K6009-1		750A/44V/60% 650A/44V/100%	61/50/40 57/47/38	10-815A	21.8 x 16.1 x 29.3 [554 x 410 x 745]	165 [74.8]

For best welding results with Lincoln Electric® equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

CUSTOMER ASSISTANCE POLICY

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