

FLEXTEC® 650 SUBARC

HEAVY DUTY APPLICATIONS



Shown: K5441-1

SIMPLE. RELIABLE. FLEXIBLE.

This submerged arc welder delivers up to 815 amps of welding power for a variety of applications, including construction, shipbuilding and heavy fabrication.

The Flextec 650 Subarc will run on a wide range of available voltage input power and is IP23 rated for outdoor operation and storage. Broad SAW wire feeder compatibility is not an issue – The Flextec 650 Subarc will operate with almost any Lincoln Electric® SAW wire feeder and controller or SAW welding process.

Simple. Reliable. Flexible. Specify the Flextec 650 Subarc for your heavy duty applications.

Processes »

Submerged Arc

Input »



Output »



Product Number »

K5441-1



KEY CONTROLS

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Positive and Negative Welding Output Studs
6. VRD (Voltage Reduction Device) Indicator Light
7. Voltage Display Meter
8. Power Switch
9. Local/Remote Output Selector Switch
10. Weld Terminals On/Remote Selector Switch
11. Wire Feeder Voltmeter Polarity Selection Switch
12. Circuit Breaker Reset Buttons for 42V feeders and ArLink peripherals
13. 42V or 115V Wire Feeder Selector Switch
14. Remote Output Control 12-pin Universal Connector
15. 14-pin Wire Feeder Connector
16. 5-pin ArLink Connector
17. Input cord strain relief
18. 115VAC duplex receptacle



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 L in (mm)	Net Wt. lb (kg)
Flextec 650 Subarc CE Model	K5441-1	380/460/575/3/50/60	750A/44V/60%	61/50/40	10-815A	21.8 x 16.1 x 29.3 (554 x 410 x 745)	165 (74.8)
			650A/44V/100%	57/47/38			
			750A/44V/60%	61/50/40			
			650A/44V/100%	57/47/38			

RECOMMENDED ACCESSORIES

DESCRIPTION	PRODUCT NUMBER
DIGITAL ARCLINK	
See Publication E9.181 for other related accessories	
MAXsa 10 Controller	K2814-4
MAXsa 22 Feed Head	K2370-2
MAXsa 19 Controller	K2626-4
MAXsa 29 Feed Head	K2312-2
Cruiser Tractor	K3048-2
ANALOG ACCESSORIES	
See Publication E9.10 for other related accessories	
Controller	K210-2 NA-3S
Head 3/32-7/32 dia	K208A NA-3S
Head .035-3/32 dia	K208B NA-3S
Head 3/32-7/32 dia (fixture builder)	K209A NA-3SF
Head .035-3/32 dia (fixture builder)	K209B NA-3SF



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.

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 for any updated information.