

Connection Guide

FLEXTEC[®]



Authorized Service and Distributor Locator:
www.lincolnelectric.com/locator

Need Help? Call 1.888.935.3877
to talk to a Service Representative

Hours of Operation:
8:00 AM to 6:00 PM (ET) Mon. thru Fri.

After hours?
Use "Ask the Experts" at lincolnelectric.com
A Lincoln Service Representative will contact you no
later than the following business day.

For Service outside the USA:
Email: globalservice@lincolnelectric.com

Service Parts:
parts.lincolnelectric.com

*All trademarks and registered trademarks are the property of their respective owners.

For use with machines:

Flextec[®] 350X

Flextec[®] 500X

Flextec[®] 650X

Table of Contents

Flextec® 350X

- Flextec® 350X - Analog Feeder, 14-Pin, Air Cooled Standard Gun, GMAW 3
- Flextec® 350X - Analog Feeder, 14-Pin, FCAW-S Gun 4
- Flextec® 350X - Analog Feeder, 9-Pin, Air Cooled Standard Gun, GMAW 5
- Flextec® 350X - Digital Feeder, Air Cooled Standard Gun, GMAW 6
- Flextec® 350X - Digital Feeder, Air Cooled Push-Pull Gun, GMAW 7
- Flextec® 350X - Digital, Water Cooled Push-Pull Gun, GMAW 8
- Flextec® 350X - Digital Feeder, FCAW-S Gun 9
- Flextec® 350X - CrossLinc® Feeder, Air Cooled Standard Gun, GMAW 10
- Flextec® 350X - CrossLinc® Feeder, FCAW-S Gun 11

Flextec® 500X

- Flextec® 500X - Analog Feeder, 14-Pin, Air Cooled Standard Gun, GMAW 13
- Flextec® 500X - Analog Feeder, 14-Pin, FCAW-S Gun 14
- Flextec® 500X - Digital Feeder I, Air Cooled Standard Gun, GMAW 15
- Flextec® 500X - Digital Feeder, Air Cooled Push-Pull Gun, GMAW 16
- Flextec® 500X - Digital Feeder, Water Cooled Push-Pull Gun 17
- Flextec® 500X - Digital Feeder, FCAW-S Gun 18
- Flextec® 500X - Crosslinc® Feeder, Air Cooled Standard Gun, GMAW 19
- Flextec® 500X - Crosslinc® Feeder, FCAW-S Gun 20

Flextec® 650X

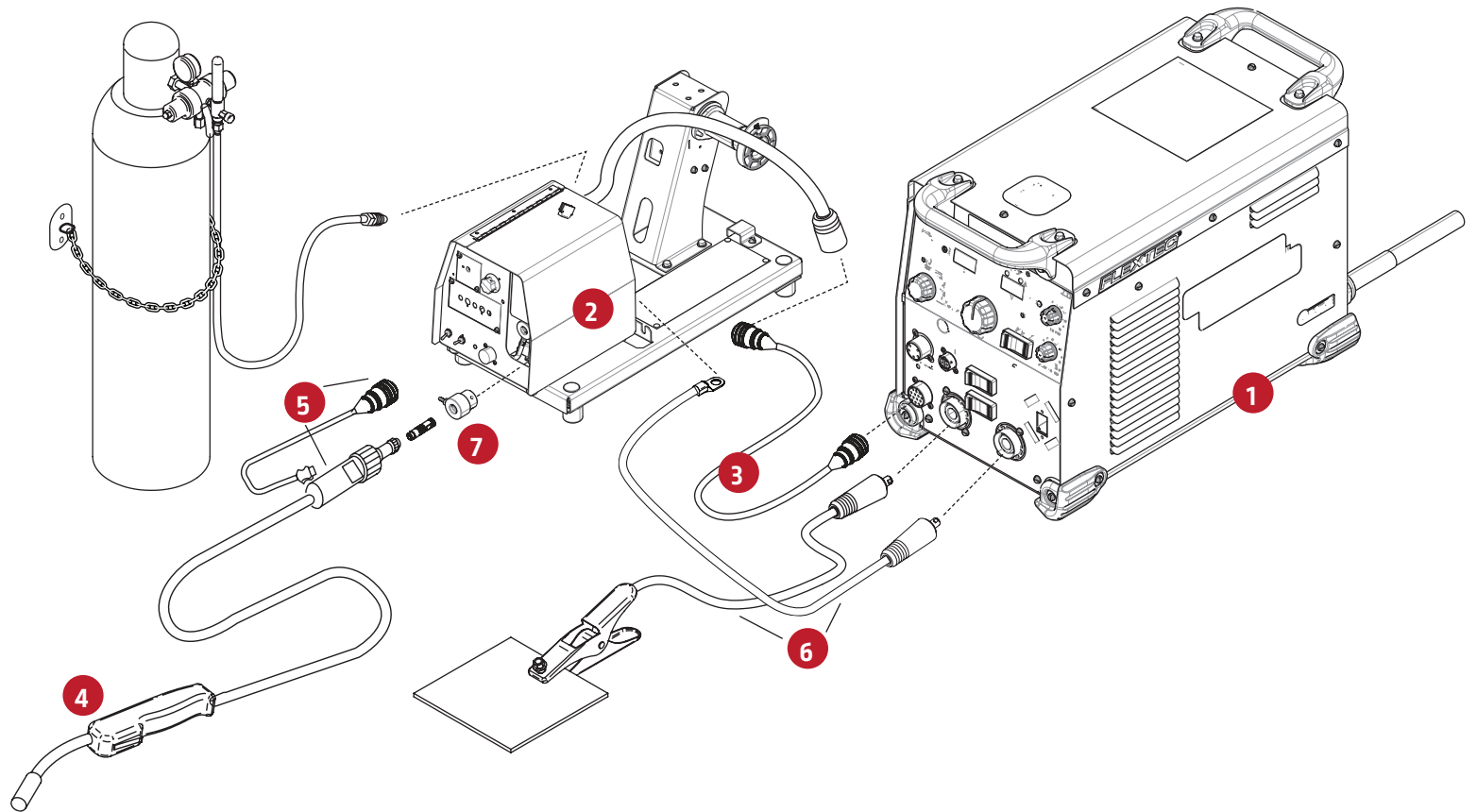
- Flextec® 650X - Analog Feeder, 14-Pin, Air Cooled Standard Gun, GMAW 21
- Flextec® 650X - Analog Feeder, 14-Pin, FCAW-S Gun 22
- Flextec® 650X - Crosslinc® Feeder, Air Cooled Standard Gun, GMAW 23
- Flextec® 650X - Crosslinc® Feeder, FCAW-S Gun 24
- Flextec® 650X - Digital Feeder, Air Cooled Standard Gun, GMAW 25
- Flextec® 650X - Digital Feeder, Air Cooled Push-Pull Gun, GMAW 26
- Flextec® 650X - Digital Feeder, Water Cooled Push-Pull Gun 27
- Flextec® 650X - Digital Feeder, FCAW-S Gun 28

- Wire Feeder Control Cables & Adapters 29
- Electrode and Work Weld Cables 30

Flextec® 350X

- Analog Feeder, 14-Pin,
- Air Cooled Standard Gun
- GMAW

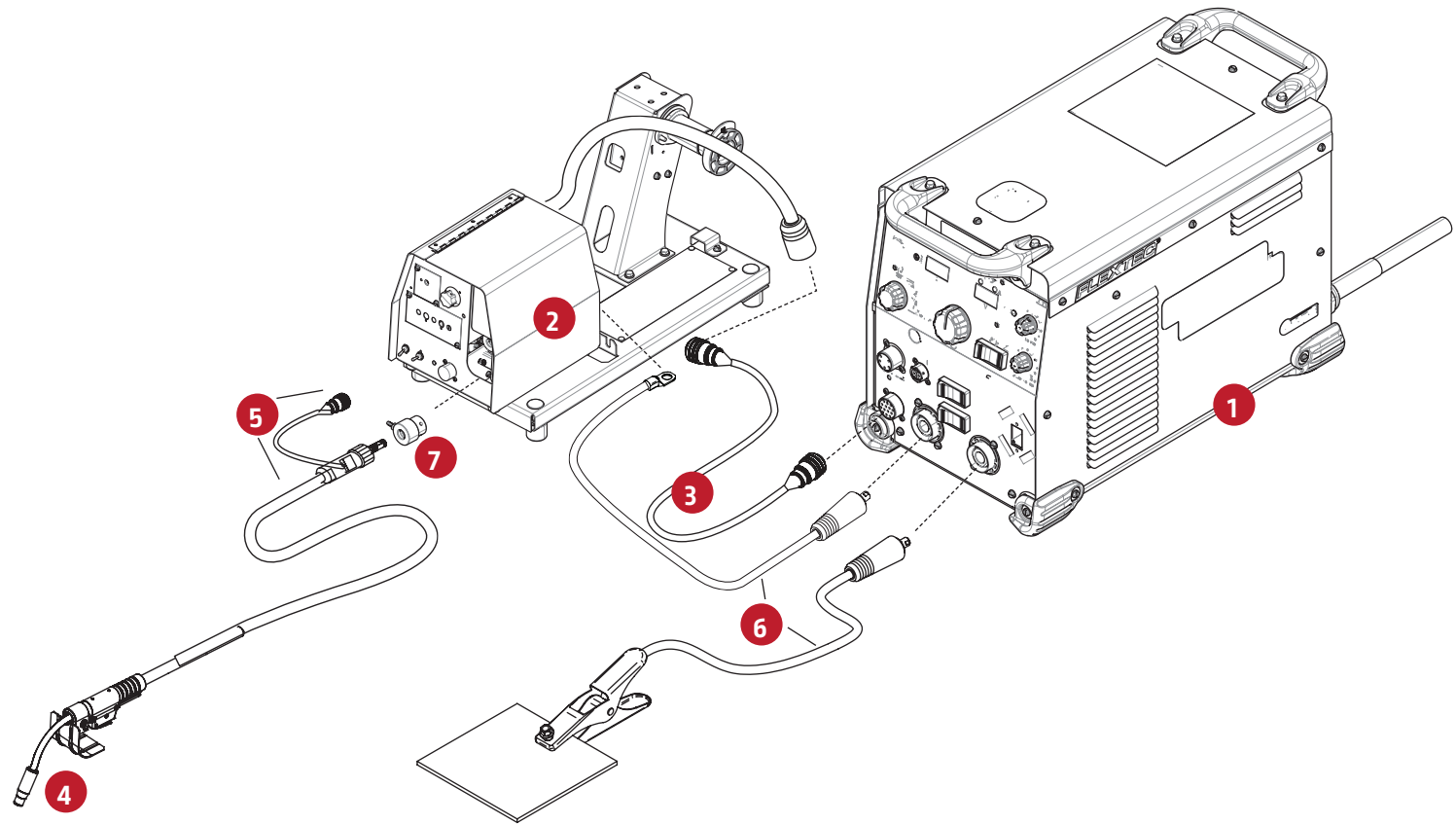
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	LF-72 (HD No Gun)	K2327-7
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10ft. cable included with feeder)
4	Gun	Magnum® PRO Curve 300, 15 ft Ready-pak®, Tweco #4	K2951-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work & Power	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 350X

- Analog Feeder, 14-Pin,
- FCAW-S Gun

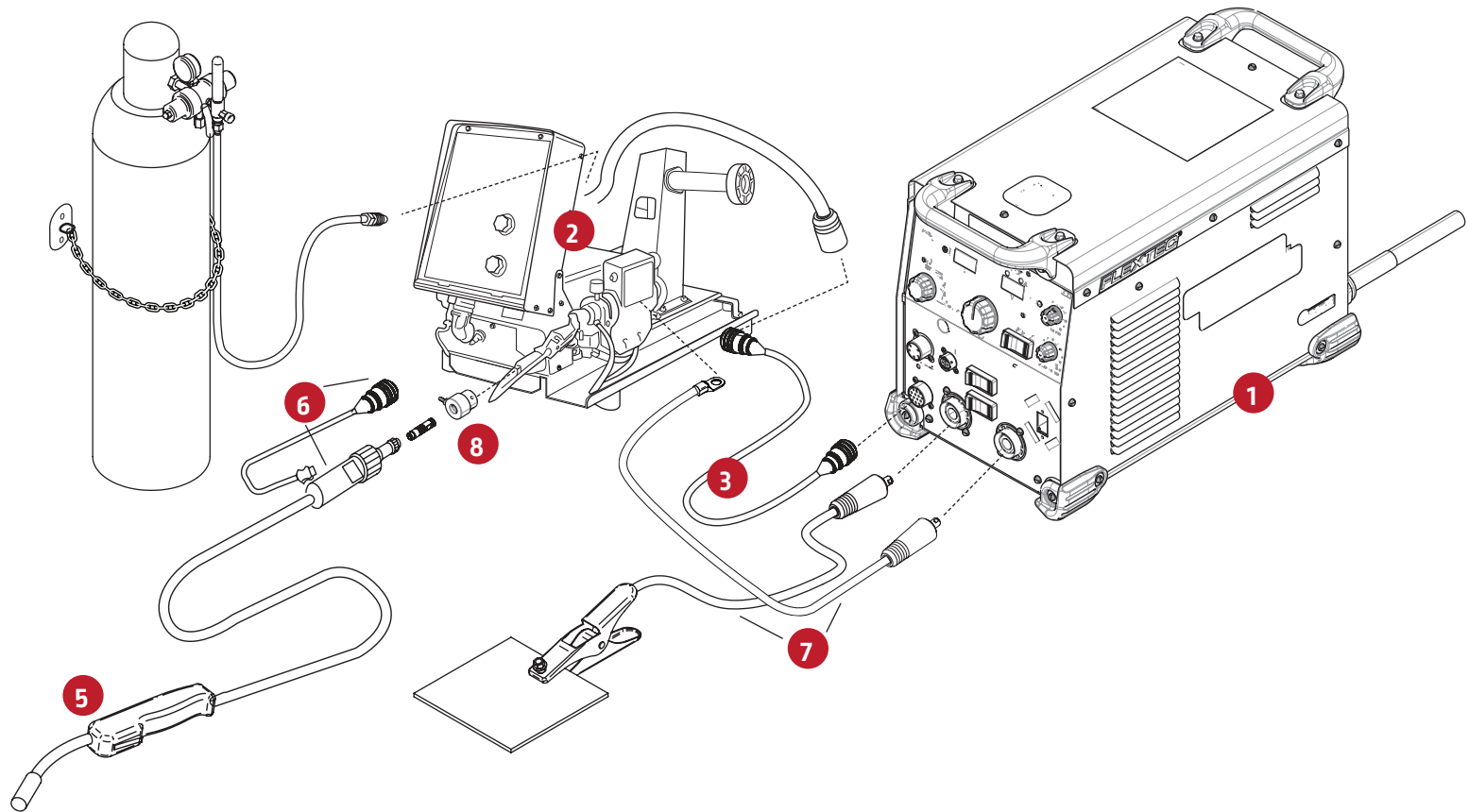
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	LF-74 (HD No gun)	K2426-5
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx
4	Gun	K126 Pro, 15 ft, full assembly 3/16 - 5/64	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work & Power	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 350X

- Analog Feeder, 9-Pin,
- Air Cooled Standard Gun
- GMAW

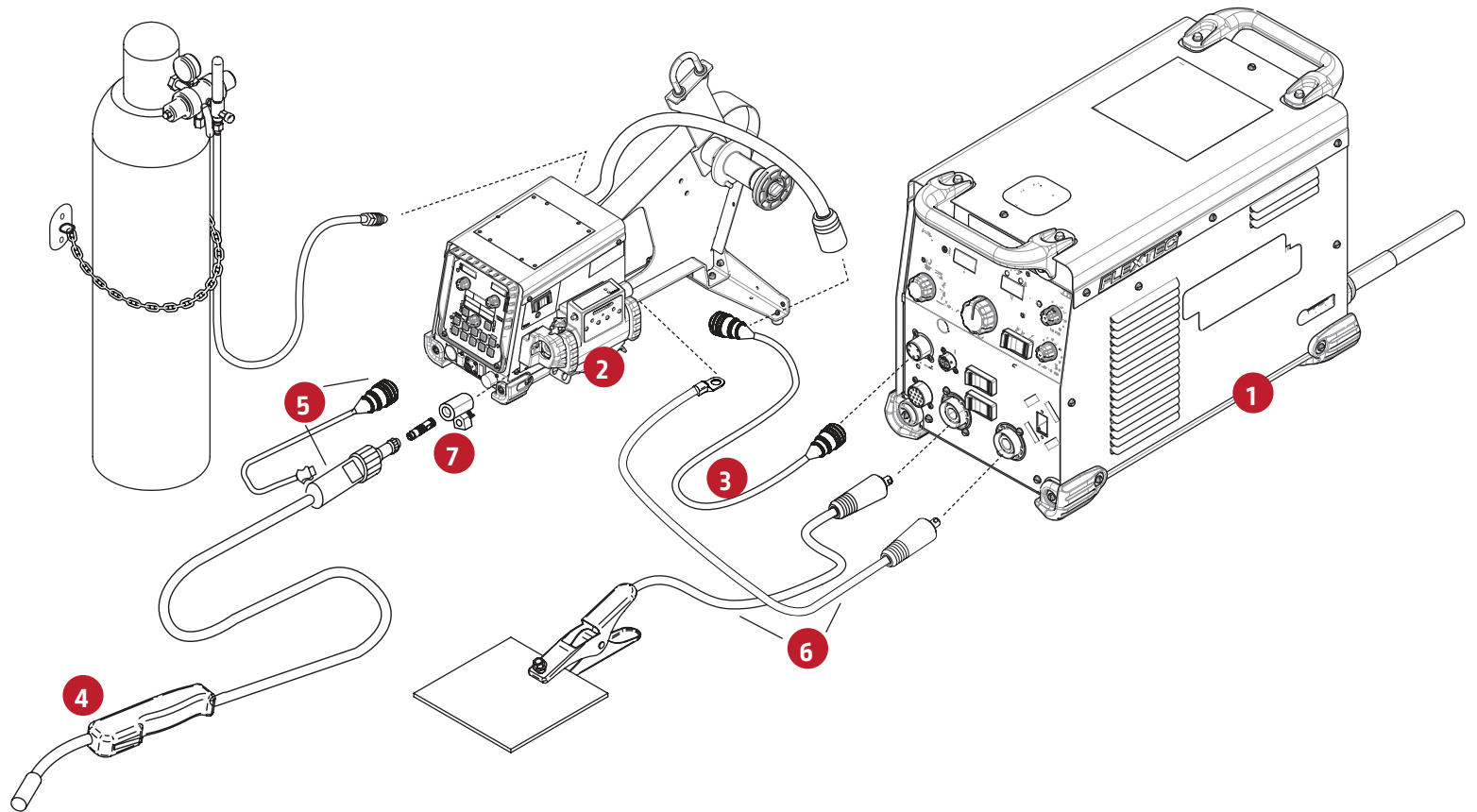
	ITEM	DESC.	K#
1	Machine	Flextec® 350X [8ft. power cord included]	K4272-1
2	Feeder	LN-10	K1559-3
3	Control Cable	Male 14-pin to 9-Pin Female	K1501-10
4	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx
5	Gun	Magnum® PRO Curve 300, 15 ft Ready-pak®, Tweco #4	K2951-2-10-45
6	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
7	Work & Power Cables	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
8	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 350X

- Digital
- Air Cooled Standard Gun
- GMAW

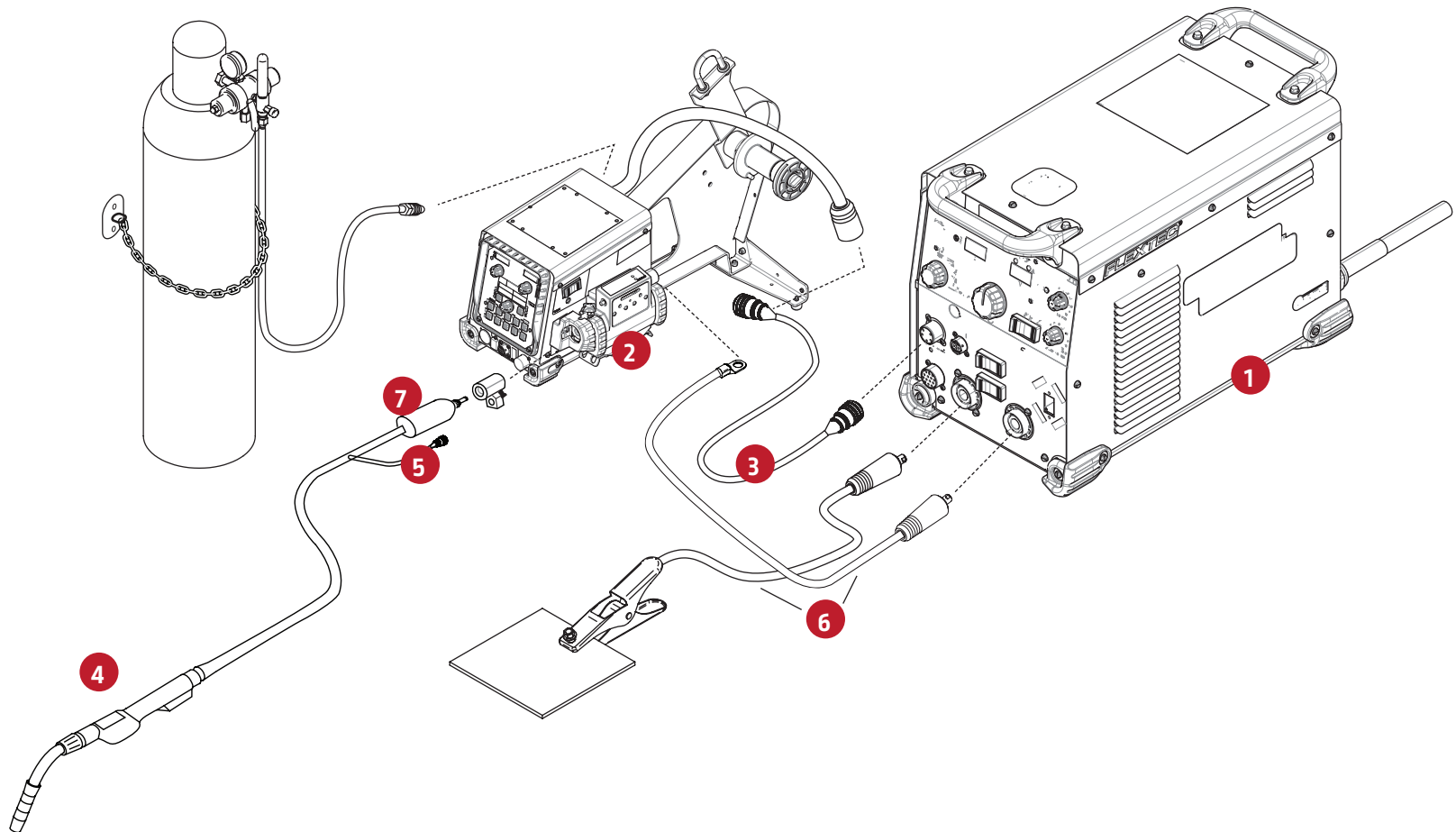
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 ft. cable included with feeder)
4	Gun	Magnum® PRO Curve 300, 15 ft Ready-Pak®, Tweco #4	K2951-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work & Power Cables	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)



Flextec® 350X

- Digital
- Air Cooled Push-Pull Gun
- GMAW

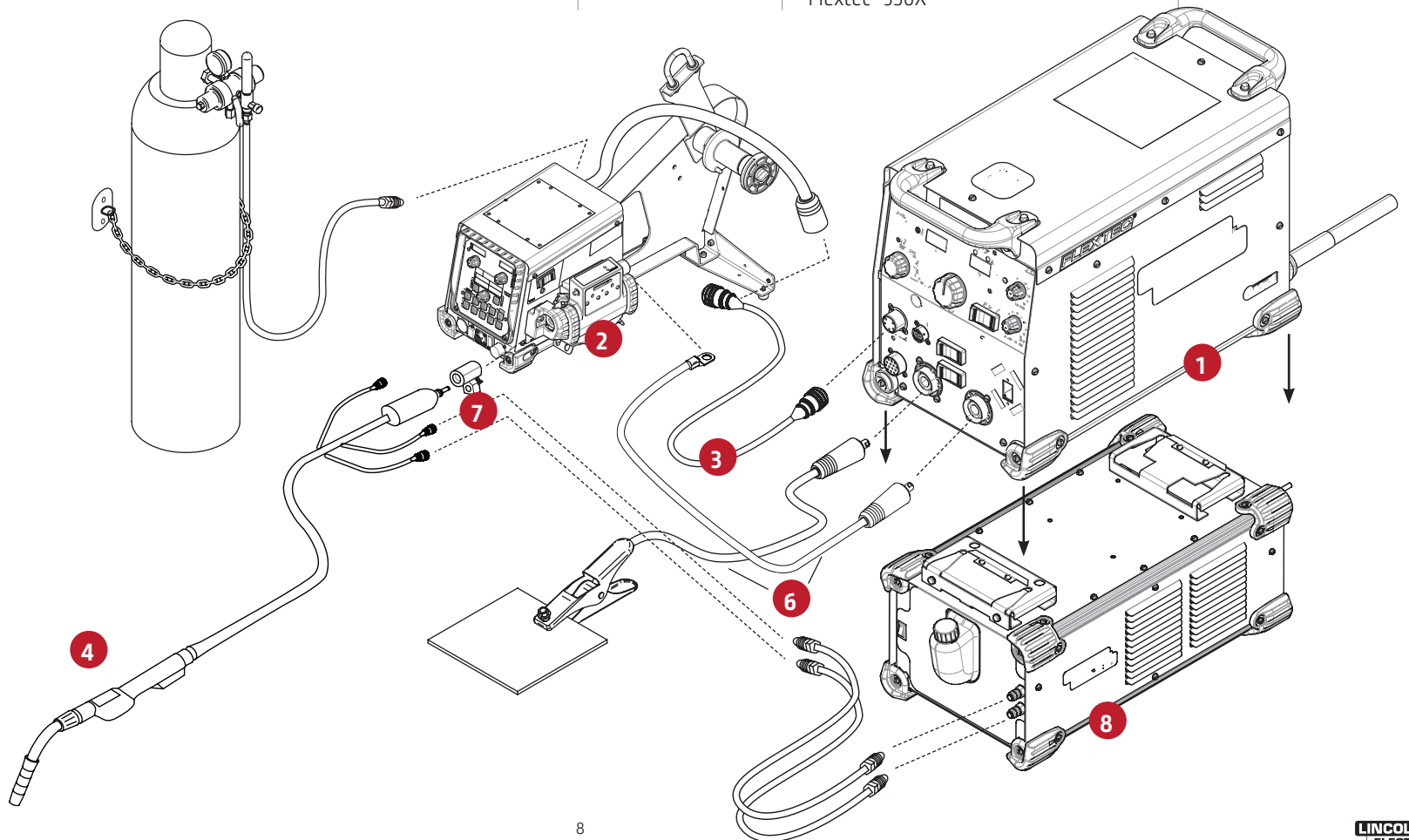
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArLink Male to 5-pin ArLink Female. Standard Duty	K1543-xx (8 ft. cable included with feeder)
4	Gun	Magnum® PRO AL., 12-pin, 25 ft	K3355-2
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Push/Pull Gun)
6	Work & Power Cables	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)



Flextec® 350X

- Digital
- Water Cooled Push-Pull Gun
- GMAW

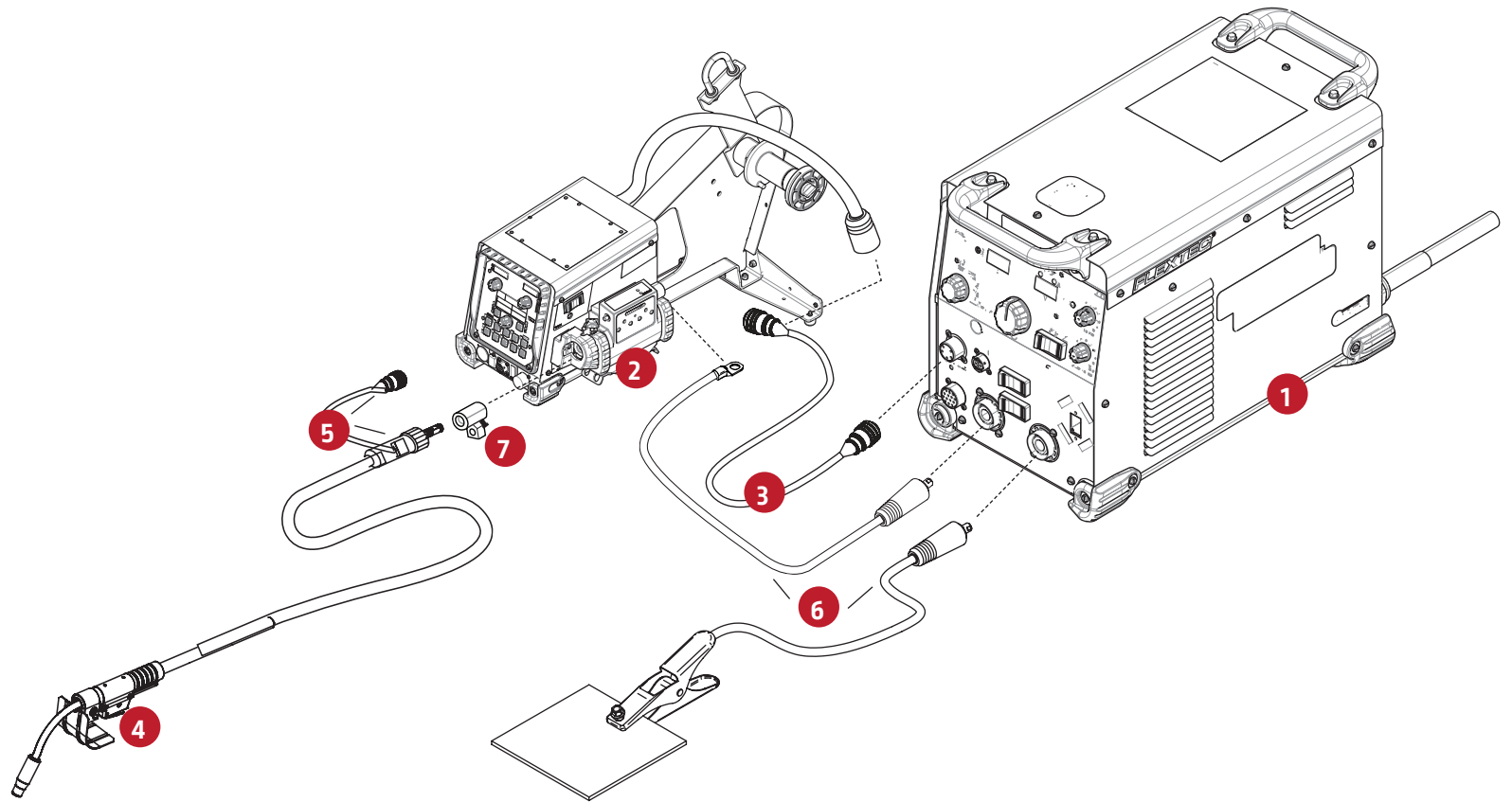
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	PF-84 Single Bench	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 ft. Cable included with feeder)
4	Gun	Magnum® PRO AL. . G450W, 12-pin, 25 ft	K3357-2
5	Gun Connector Kit	na	#N/A
6	Work & Power	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Accessory	Cool Arc 55 Water Cooler (Requires external 115VAC power supply)	K3086-1 (Hoses Included)
9	Accessory	Base Mounting Kit - foot kit for Flextec® 350X	K4424-1



Flextec® 350X

- Digital
- FCAW-S Gun

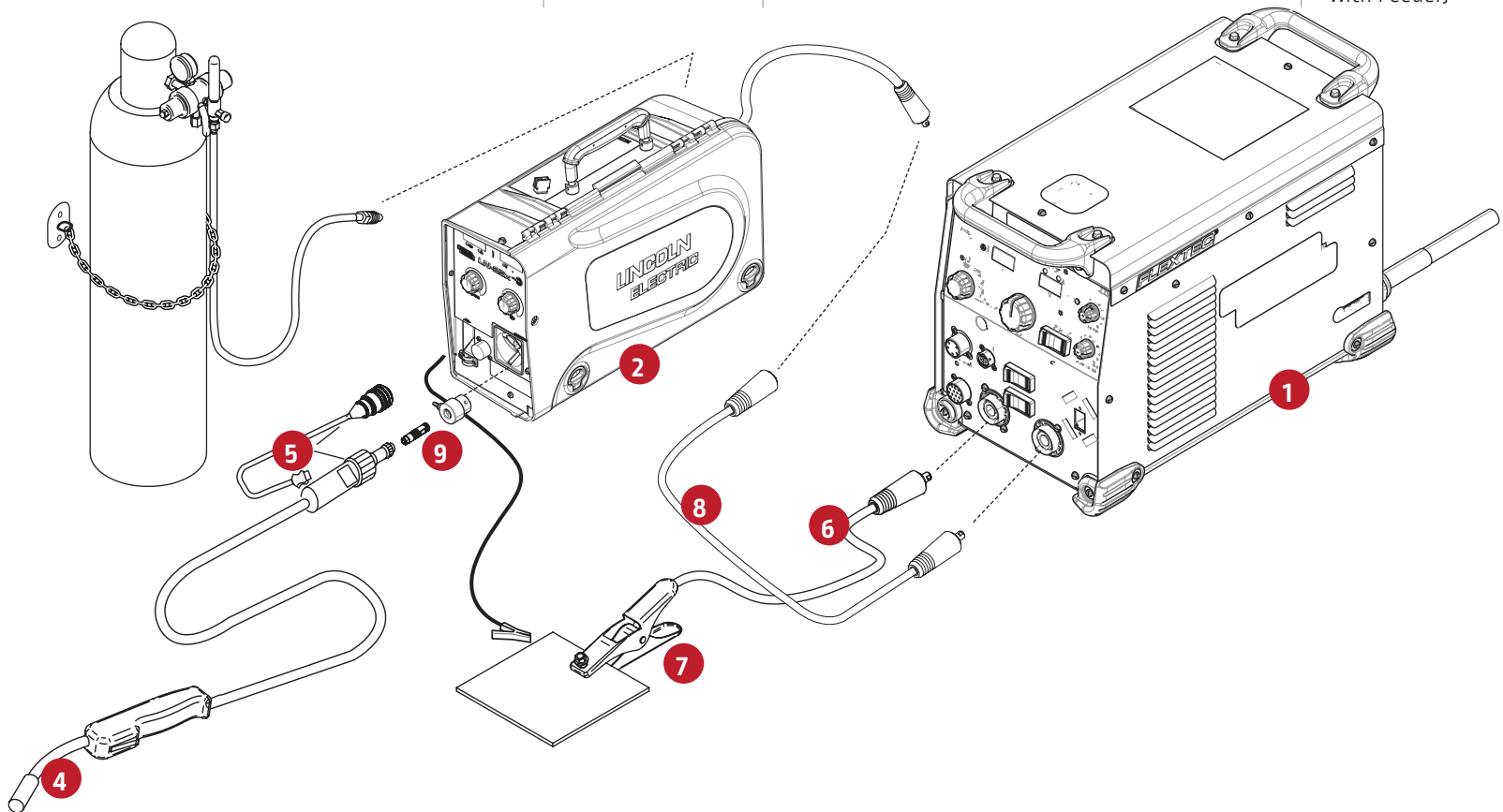
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	PF-84 Single Bench	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (9 ft. Cable included with feeder)
4	Gun	K126 Pro, 15 ft	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work & Power Cables	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)



Flextec® 350X

- CrossLinc®
- Air Cooled Standard Gun
- GMAW

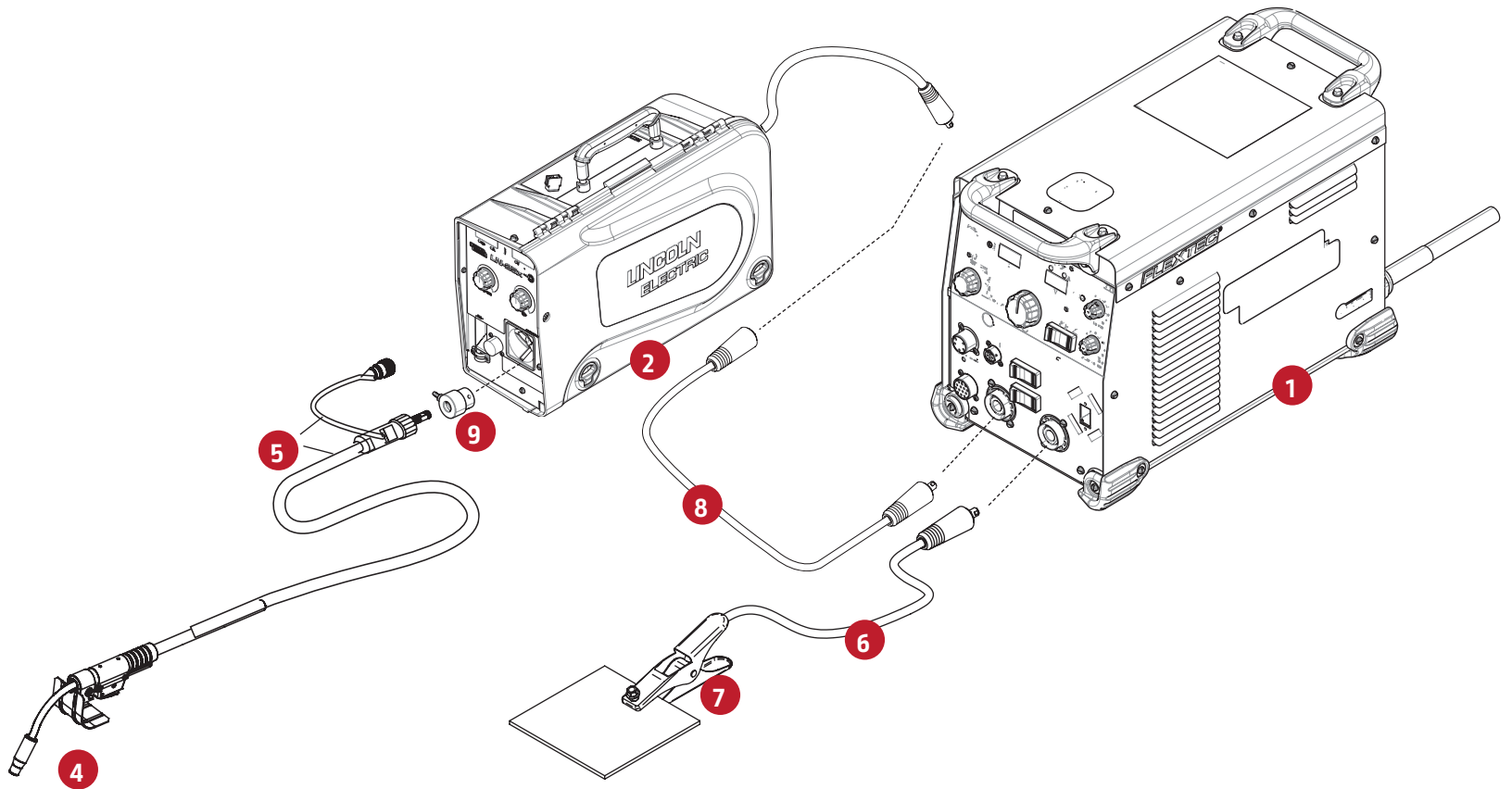
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard or Construction (8ft. power cord included)	K4272-1/K4271-1
2	Feeder	LN-25X	K4267-2
3	Control Cable	None	#N/A
4	Gun	Magnum® PRO Curve 300, 15 ft Ready-Pak®, Tweco #4	K2951-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Tweco®-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K2484-2
7	Work Clamp	GC 500 Work Clamp	k910-2
8	Weld power Cable	Tweco®-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. (15.2 m)	K2485-2
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 350X

- CrossLinc®
- FCAW-S Gun

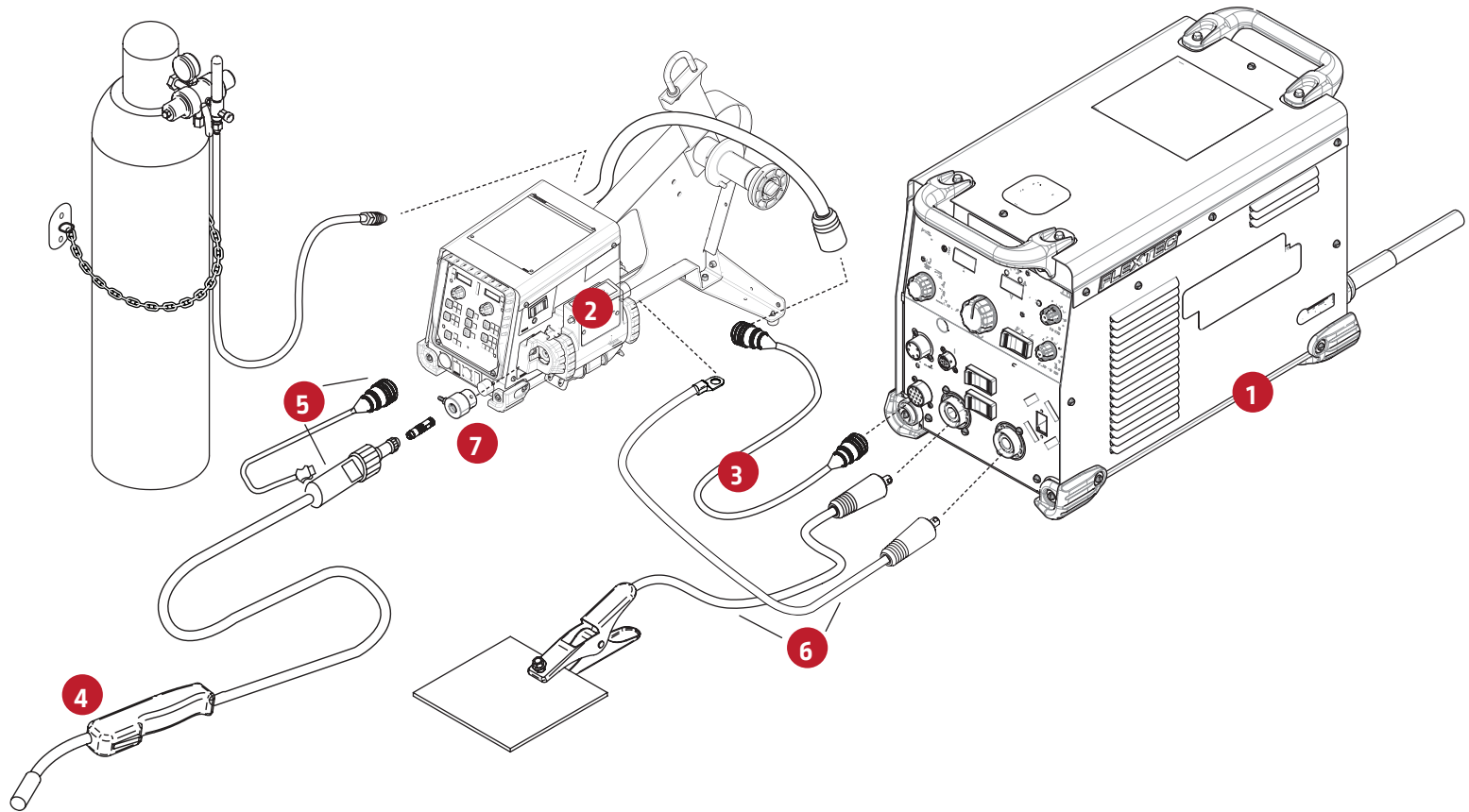
ITEM	DESC.	K#	
1	Machine	Flextec® 350X Standard or Construction (8ft. power cord included)	K4272-1/K4271-1
2	Feeder	LN-25X	K4267-2
3	Control Cable	None	#N/A
4	Gun	K126 Pro, 15 ft, full assembly	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Tweco®-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K2484-2
7	Work Clamp	GC 500 Work Clamp	k910-2
8	Weld power Cable	Tweco®-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. (15.2 m)	K2485-2
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 350X

- Analog Feeder, 14-Pin,
- Air Cooled Standard Gun
- GMAW

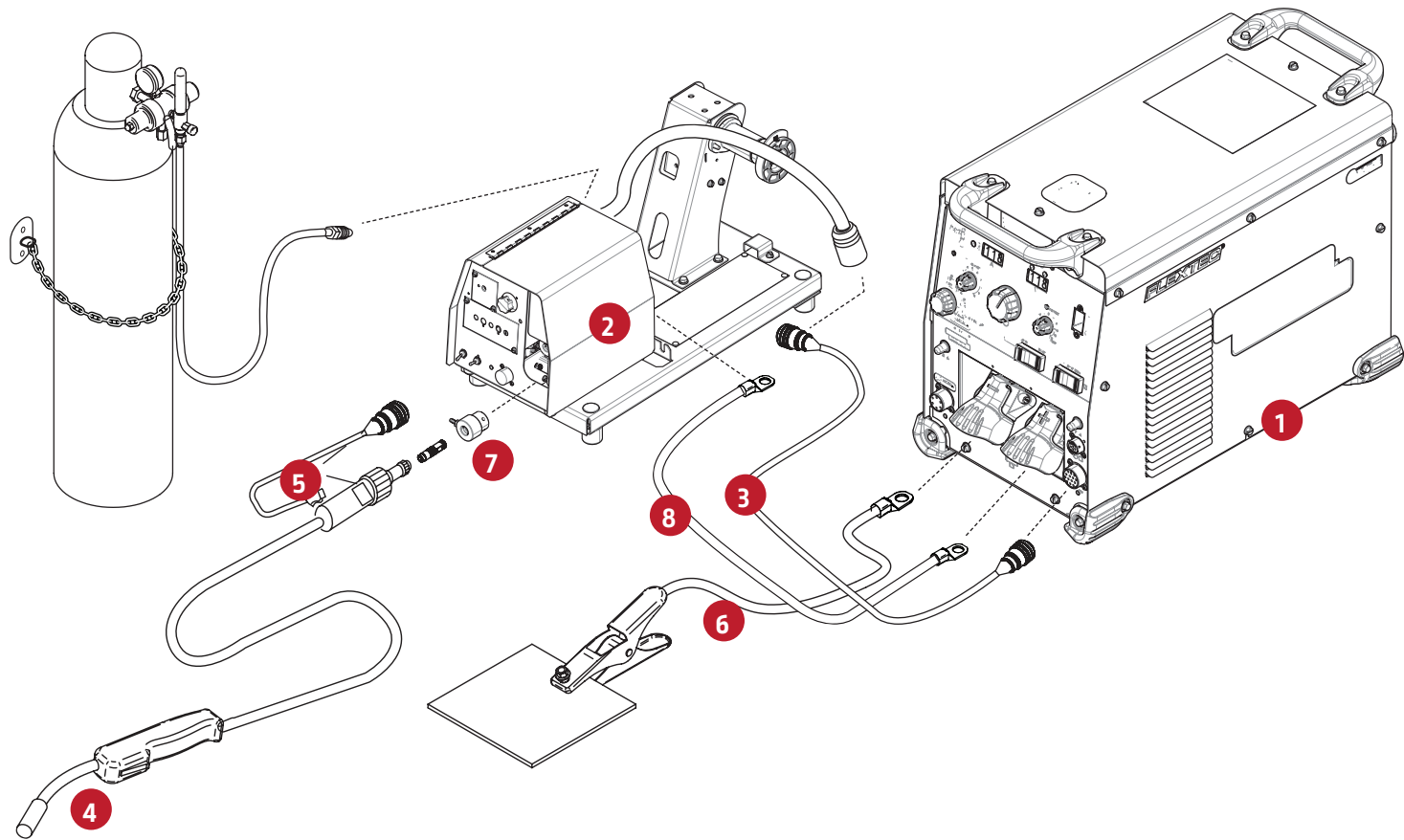
	ITEM	DESC.	K#
1	Machine	Flextec® 350X Standard (8ft. power cord included)	K4272-1
2	Feeder	Flex Feed 84 (HD Wire Reel Stand)	K5000-2
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10ft. cable included with feeder)
4	Gun	Magnum® PRO Curve 300, 15 ft Ready-pak®, Tweco #4	K2951-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work & Power	Tweco to Lug w/Ground Clamp, 2/0, 15 ft work and 10 ft power 350A@60%.	K1803-2
7	Feeder Bushing	10-Series Tweco #2 - #4	K3345-1 (Included with Feeder)



Flextec® 500X

- Analog Feeder, 14-Pin,
- Air Cooled Standard Gun
- GMAW

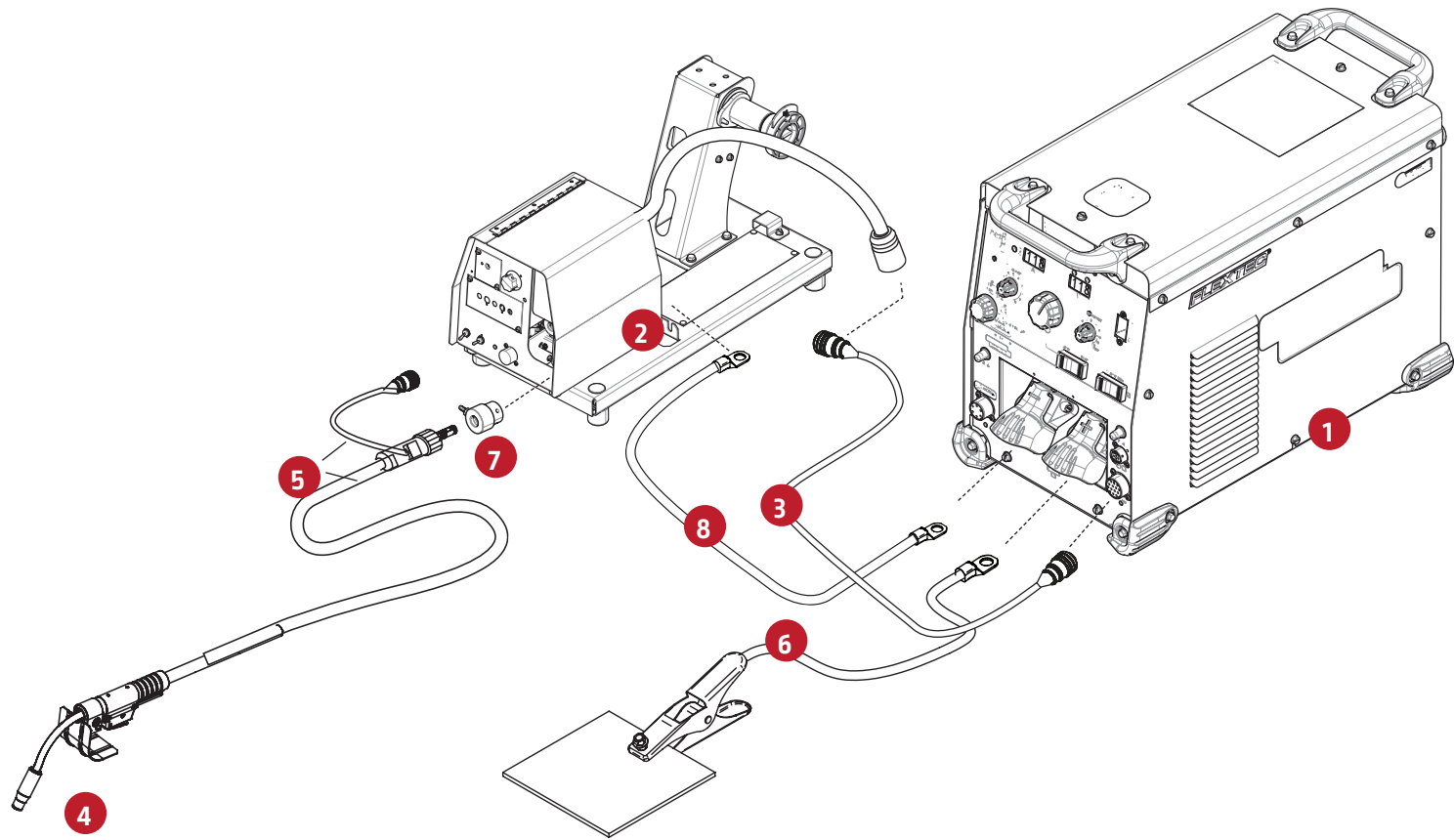
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	LF-74	K2426-5
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Analog Feeder, 14-Pin,
- FCAW-S Gun

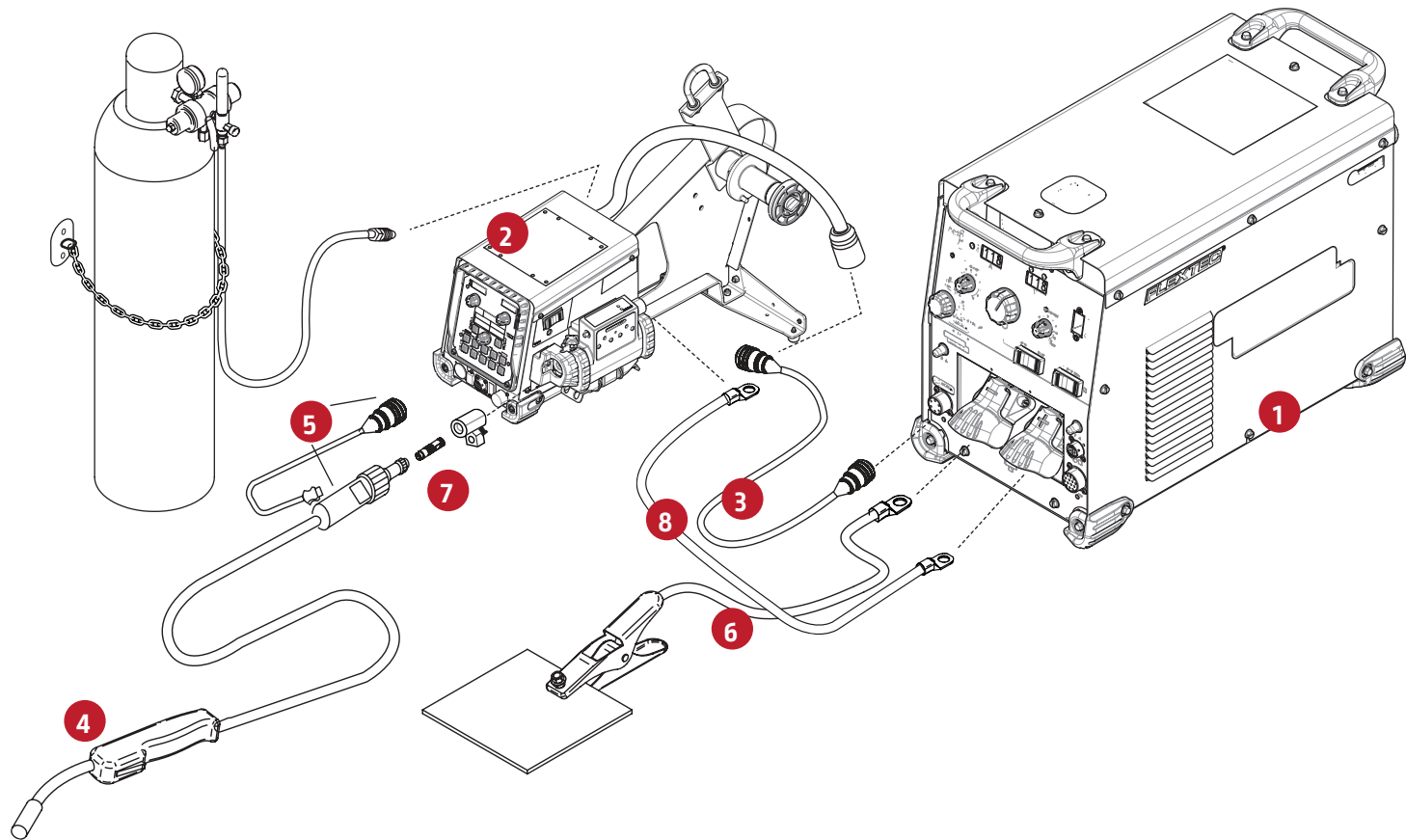
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	LF-74	K2426-5
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10 Ft. Cable Included with Feeder)
4	Gun	K126 Pro, 15 ft	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Digital
- Air Cooled Standard Gun
- GMAW

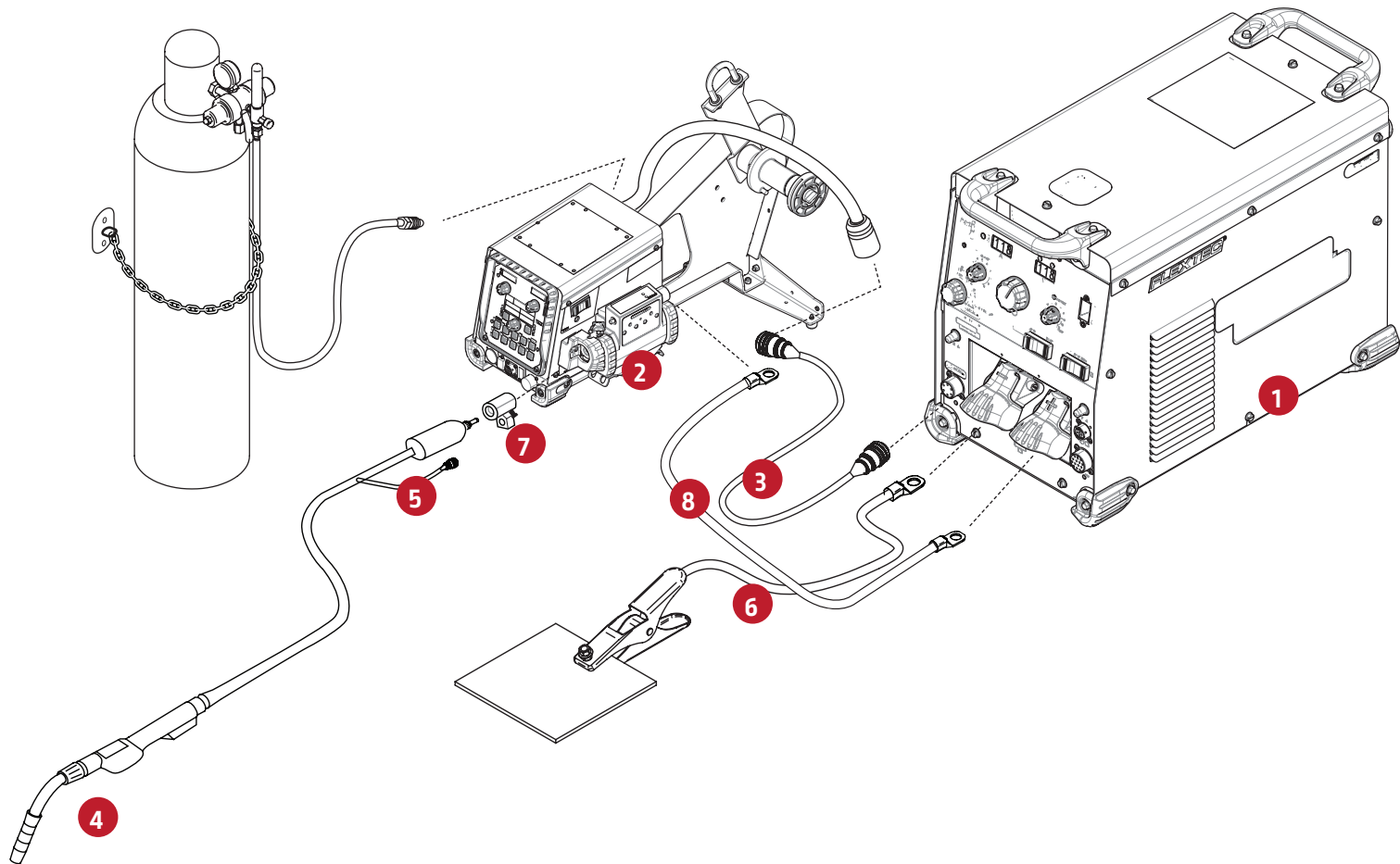
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84-Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Digital
- Air Cooled Push-Pull Gun
- GMAW

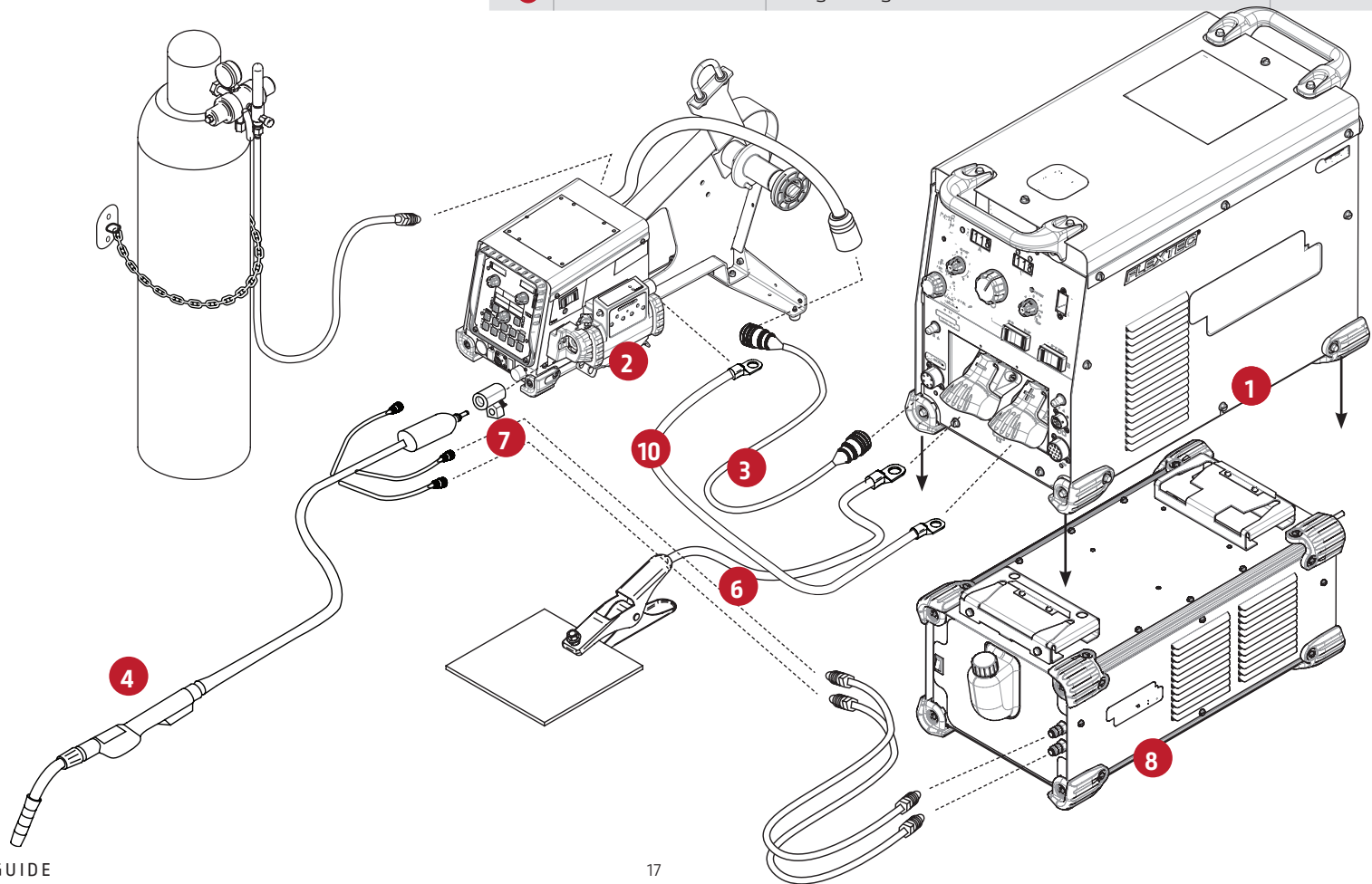
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO AL., 12-pin, 25 ft	K3355-2
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Digital
- Water Cooled Push-Pull Gun

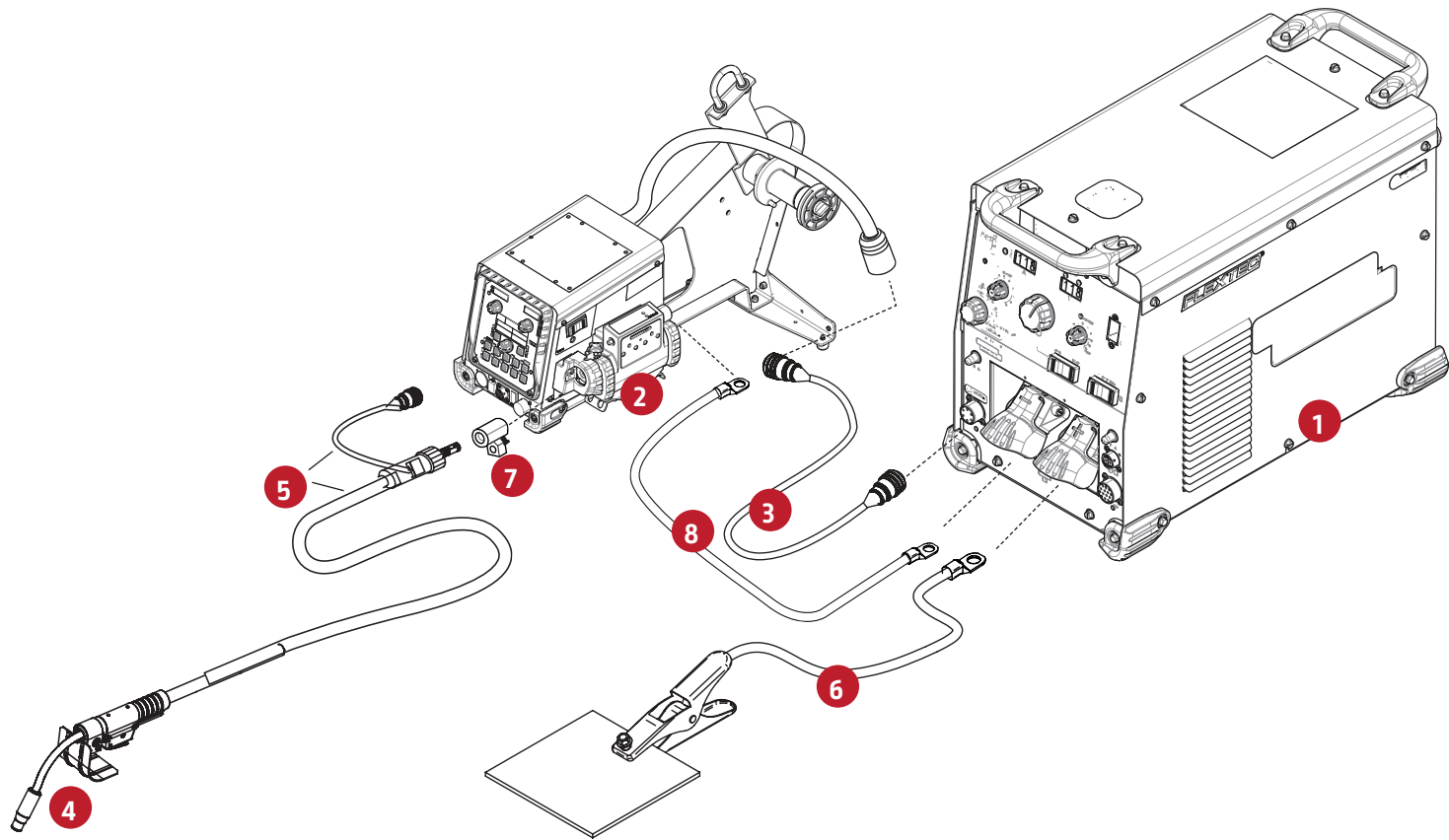
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO AL. . G450W, 12-pin, 25 ft	K3357-2
5	Gun Connector Kit		#N/A
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Accessory	Cool Arc 55 Water Cooler (Requires external 115VAC power supply)	K3086-1 (Hoses Included)
9	Accessory	Base Mounting Kit - foot kit for Flextec® 500/500P	K3056-2
10	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Digital
- FCAW-S Gun

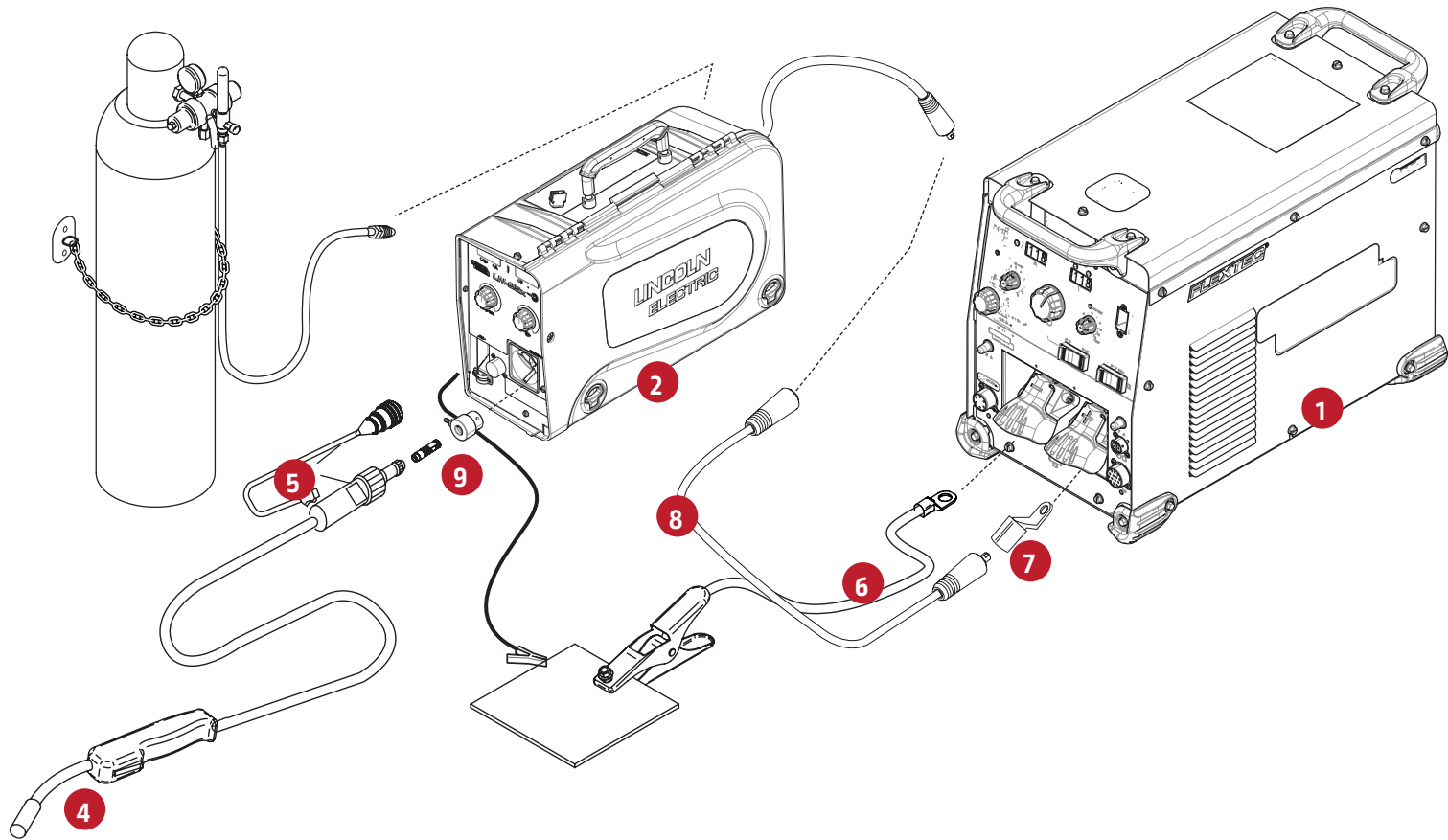
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	K126 Pro, 15 ft	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84-Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 500X

- Crosslinc®
- Air Cooled Standard GMAW Gun

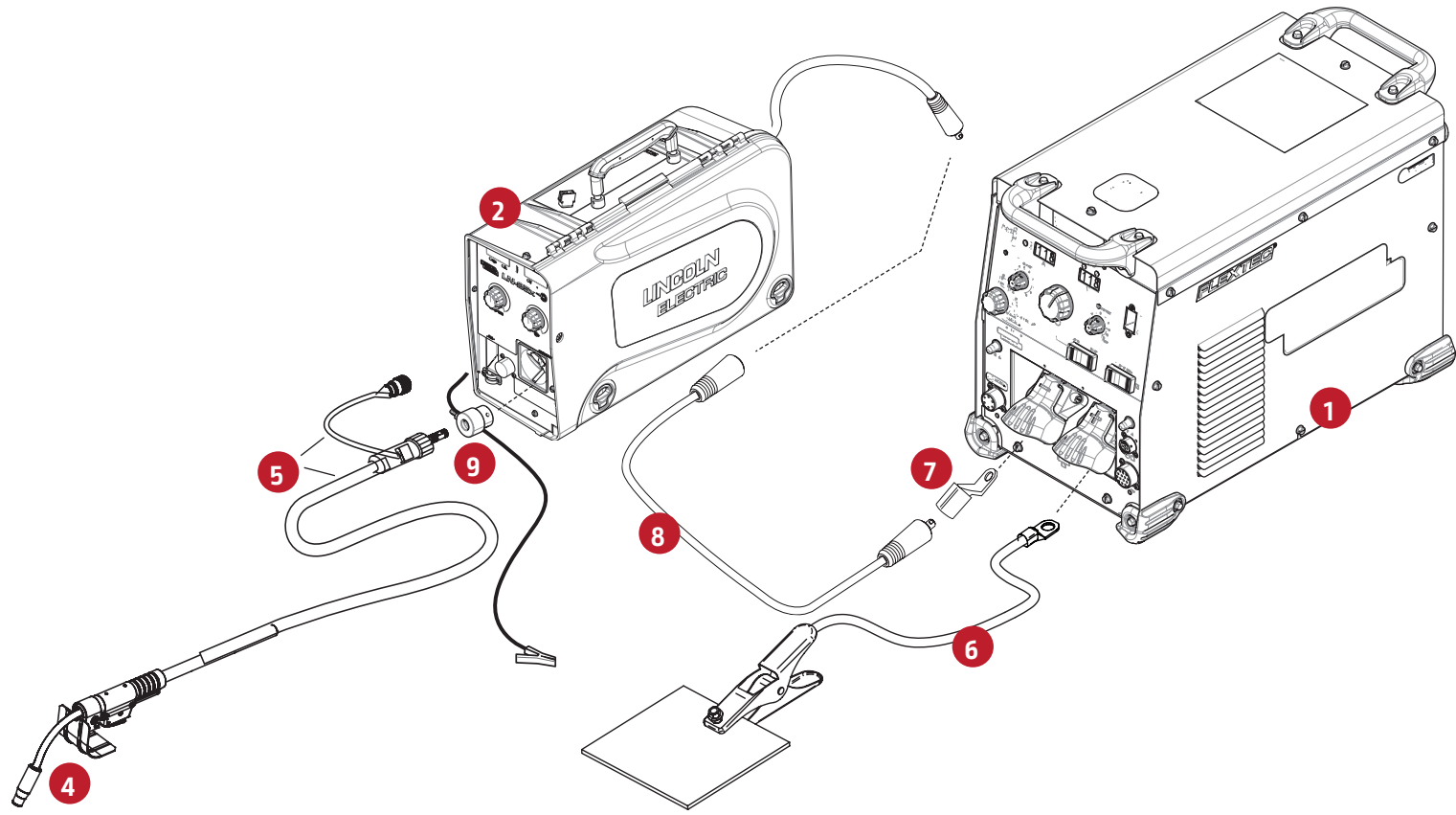
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	LN-25 X	K4267-2
3	Control Cable	None	#N/A
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Adapter	Lug to Tweco Adapter	K2487-1
8	Weld power Cable	Tweco® style male & female (3/0, 600A, 60%) - 50 ft (15.3 m)	K2485-3
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 500X

- Crosslinc®
- FCAW-S Gun

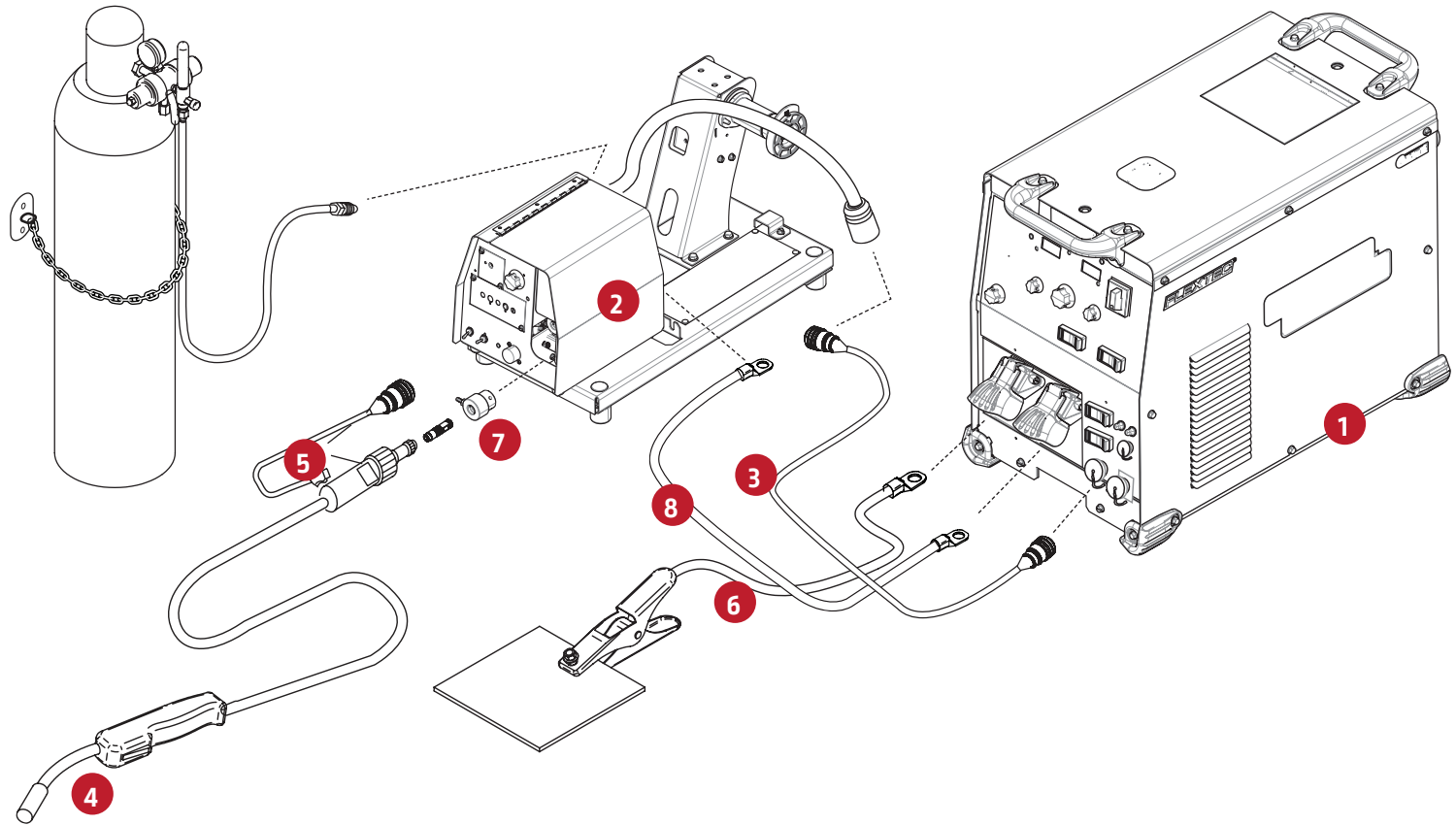
	ITEM	DESC.	K#
1	Machine	Flextec® 500X	K3607-1
2	Feeder	LN-25x	K4267-2
3	Control Cable	None	#N/A
4	Gun	K126 Pro, 15 ft, full assembly	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Adapter	Lug to Tweco Adapter	K2487-1
8	Weld power Cable	Tweco® style male & female (3/0, 600A, 60%) - 50 ft (15.3 m)	K2485-3
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 650X

- Analog Feeder, 14-Pin,
- Air Cooled Standard Gun
- GMAW

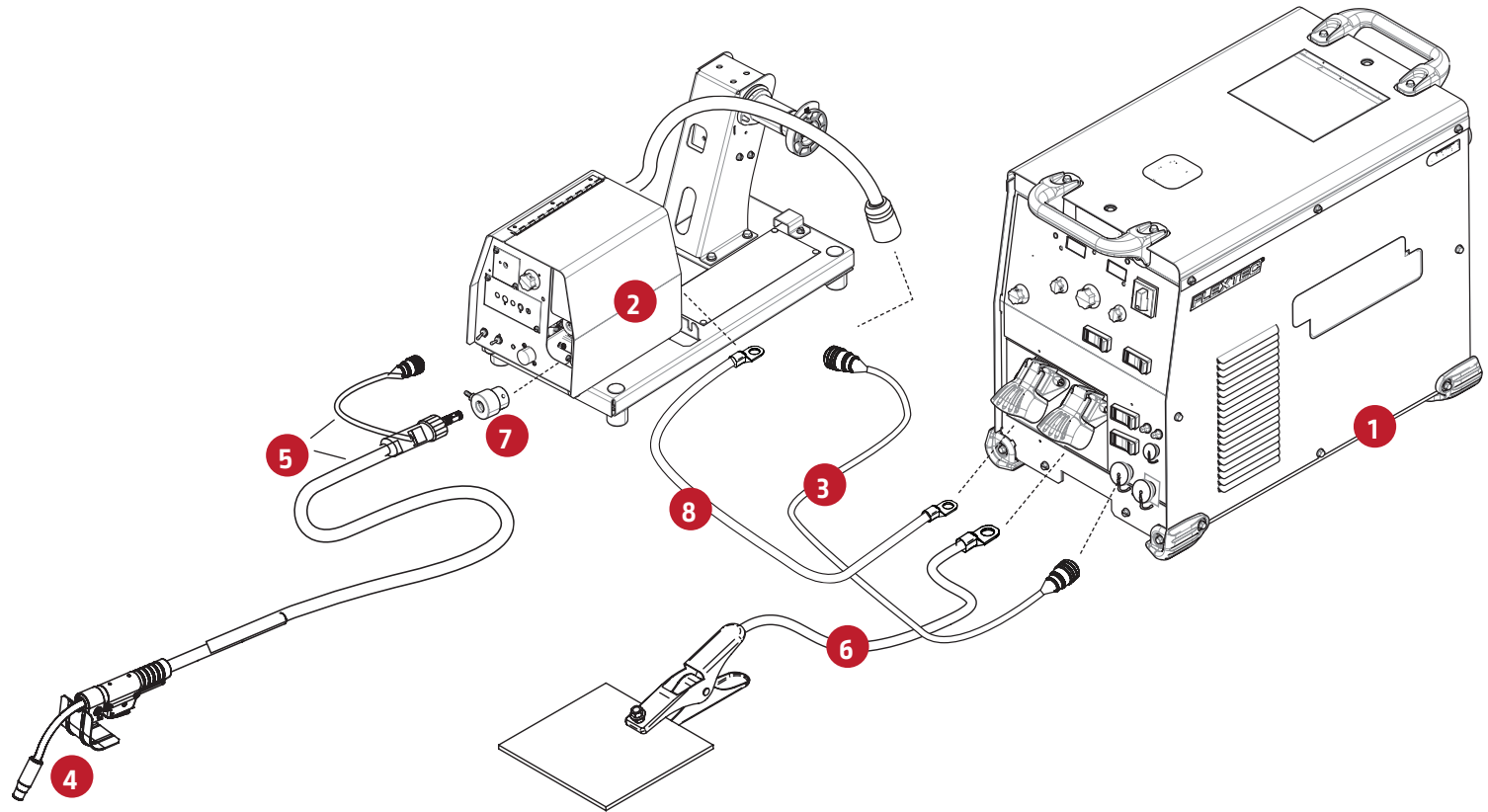
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3425-1
2	Feeder	LF-74	K2426-5
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 650X

- Analog Feeder, 14-Pin
- FCAW-S Gun

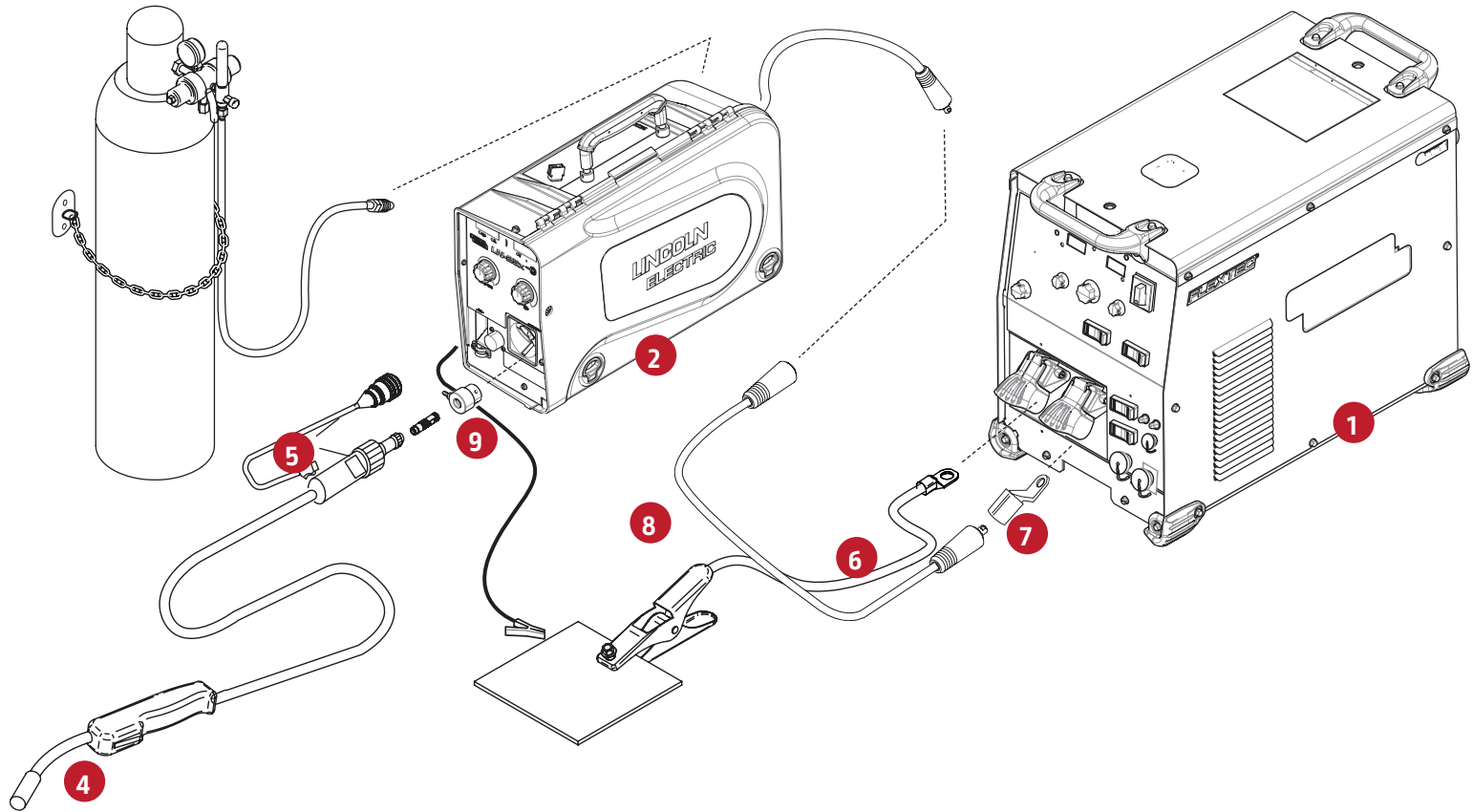
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3425-1
2	Feeder	LF-74	K2426-5
3	Control Cable	14-pin Male to 14- Pin Female Extension	K1797-xx (10 Ft. Cable Included with Feeder)
4	Gun	K126 Pro, 15 ft, full assembly	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 650X

- Crosslinc®
- Air Cooled Standard Gun
- GMAW

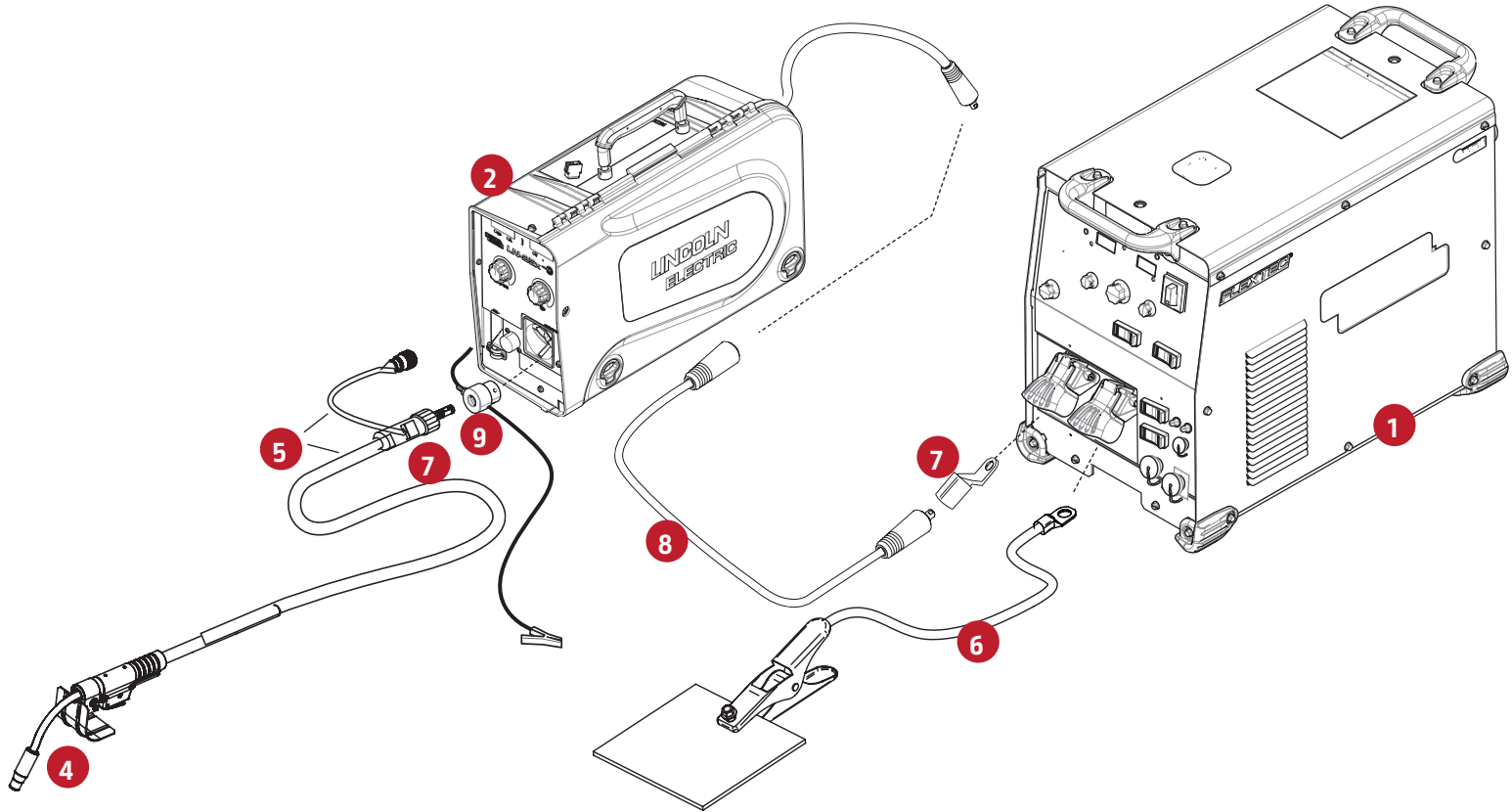
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3425-1
2	Feeder	LN-25x	K4267-2
3	Control Cable	None	#N/A
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Adapter	Lug to Tweco Adapter	K2487-1
8	Weld power Cable	Tweco® style male & female (3/0, 600A, 60%) - 50 ft (15.3 m)	K2485-3
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 650X

- Crosslinc®
- FCAW-S Gun

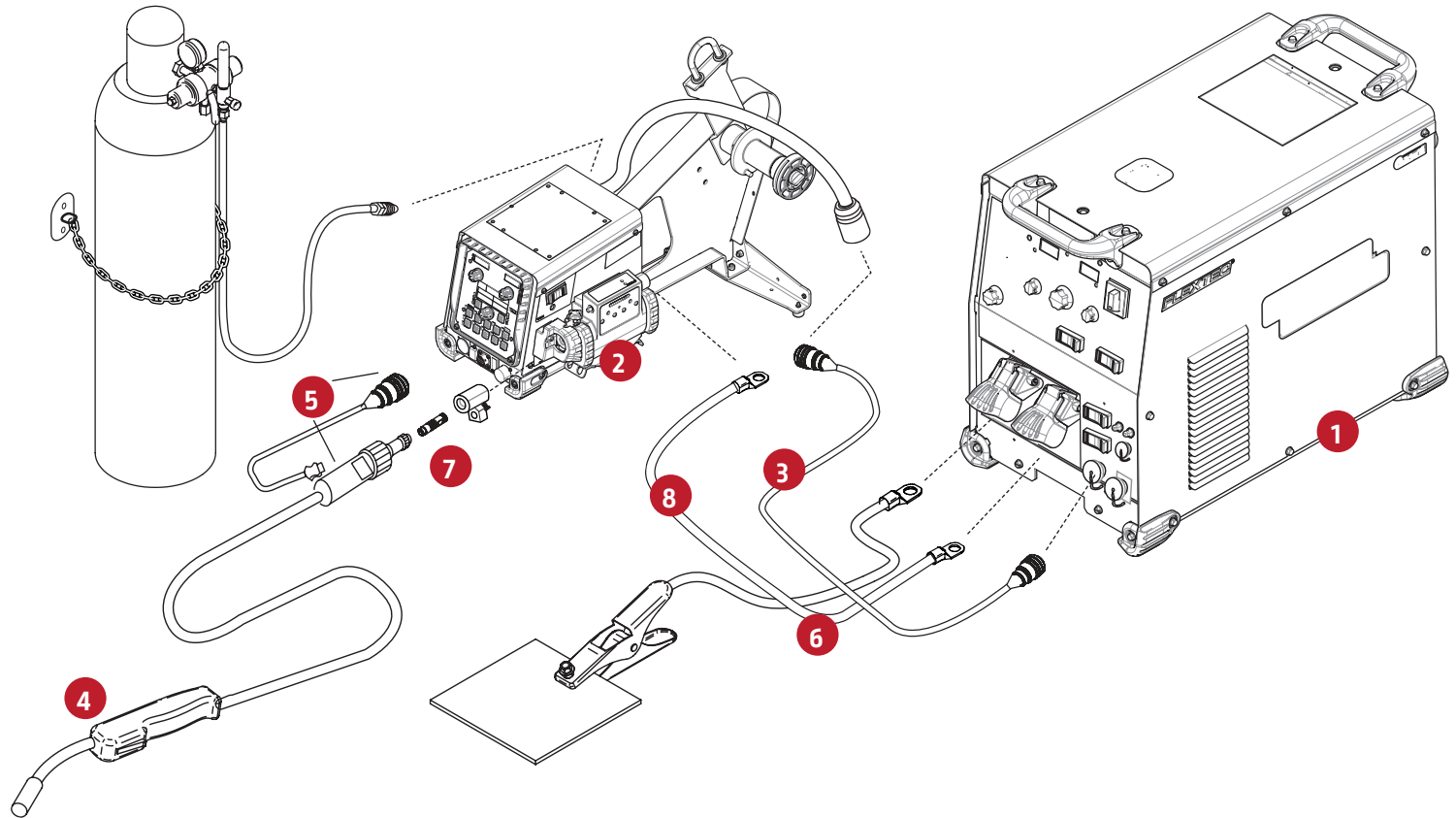
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3425-1
2	Feeder	LN-25x	K4267-2
3	Control Cable	None	#N/A
4	Gun	K126 Pro, 15 ft	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Adapter	Lug to Tweco Adapter	K2487-1
8	Weld power Cable	Tweco® style male & female (3/0, 600A, 60%) - 50 ft (15.3 m)	K2485-3
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)



Flextec® 650X

- Digital
- Air Cooled Standard Gun
- GMAW

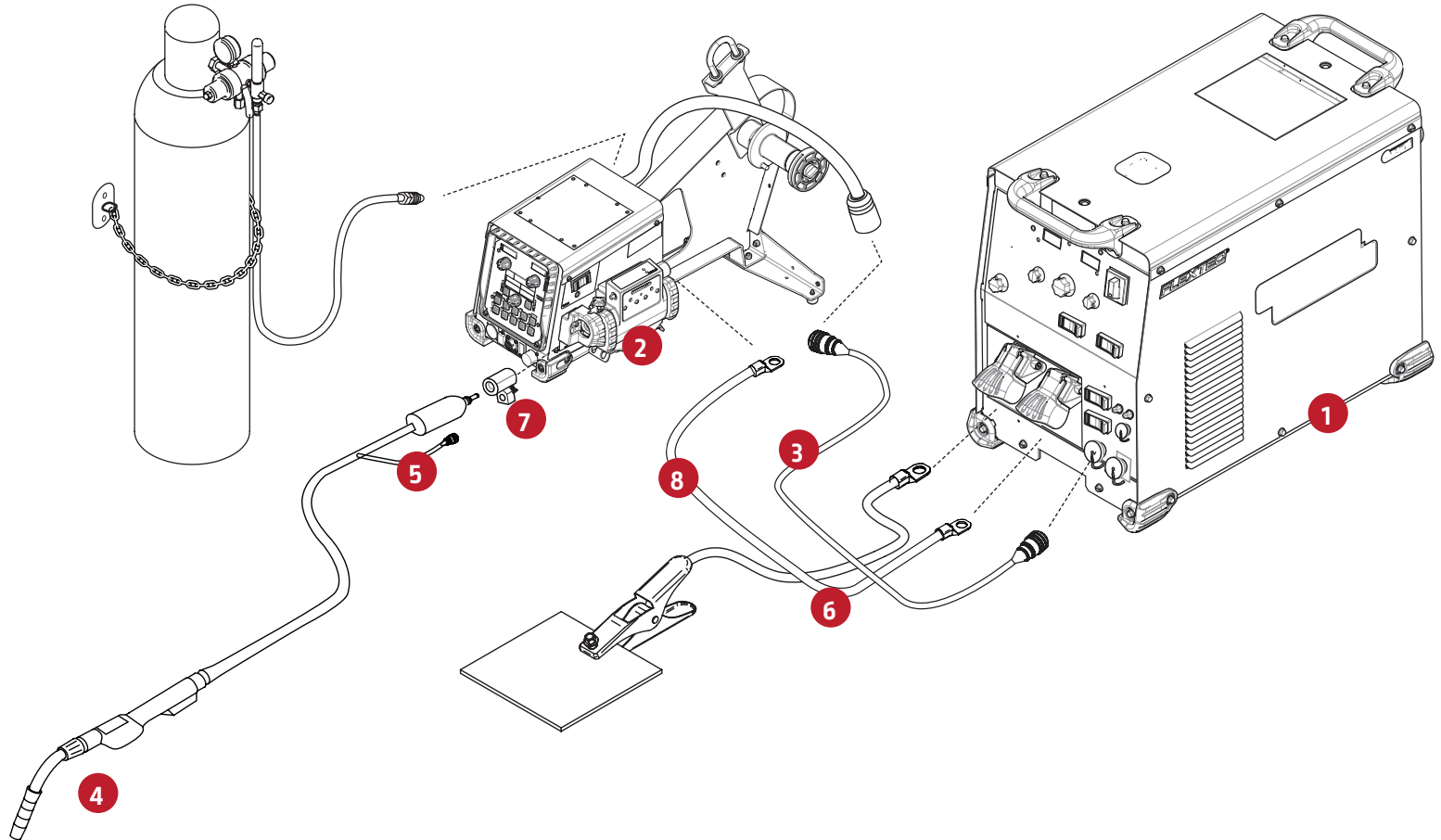
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3607-1/ K3611-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO Curve 400, 15 ft Ready-Pak® Tweco #4	K2952-2-10-45
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84-Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 650X

- Digital
- Air Cooled Push-Pull Gun
- GMAW

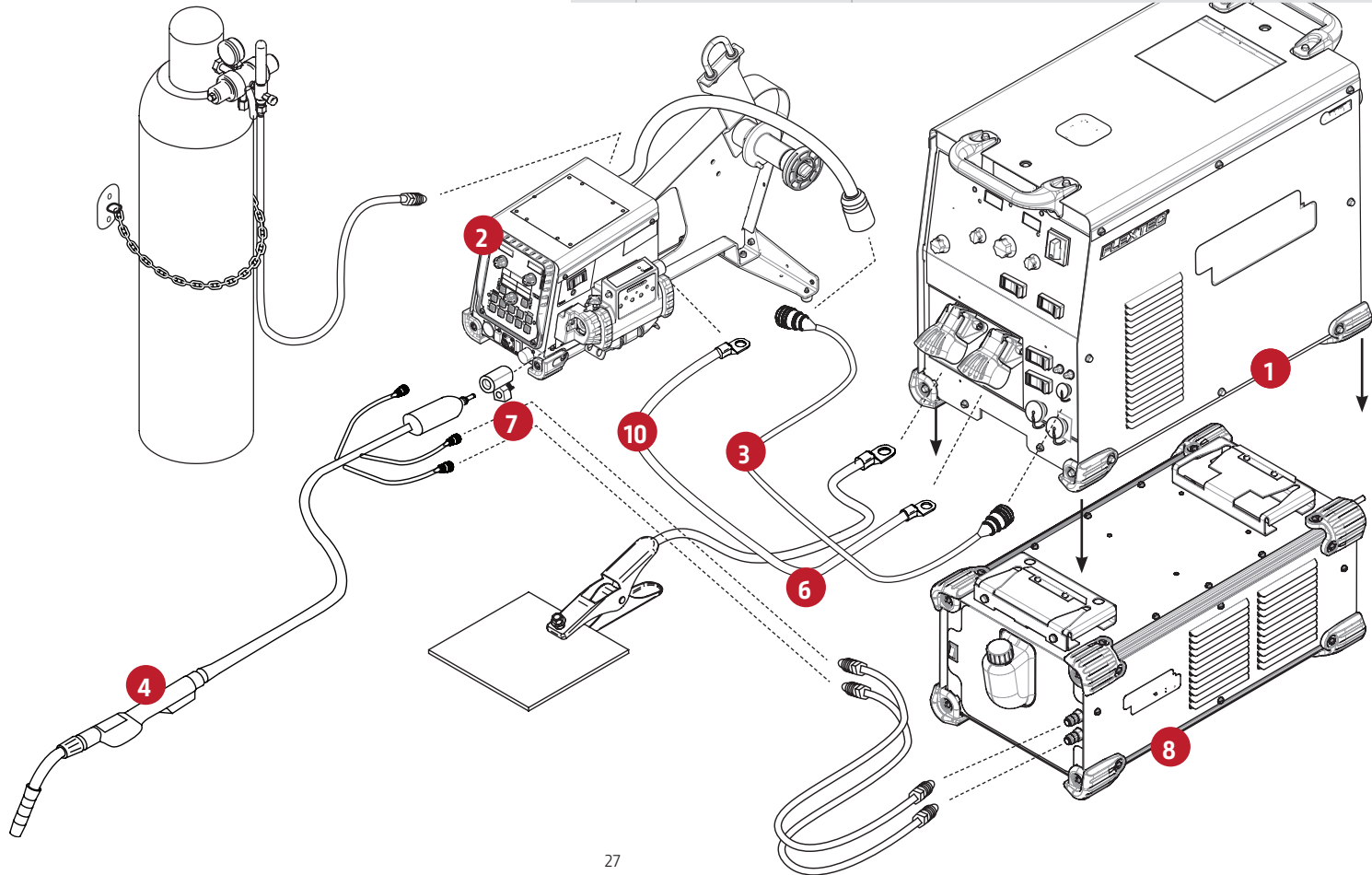
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3607-1/ K3611-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO AL., 12-pin, 25 ft	K3355-2
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 650X

- Digital
- Water Cooled Push-Pull Gun

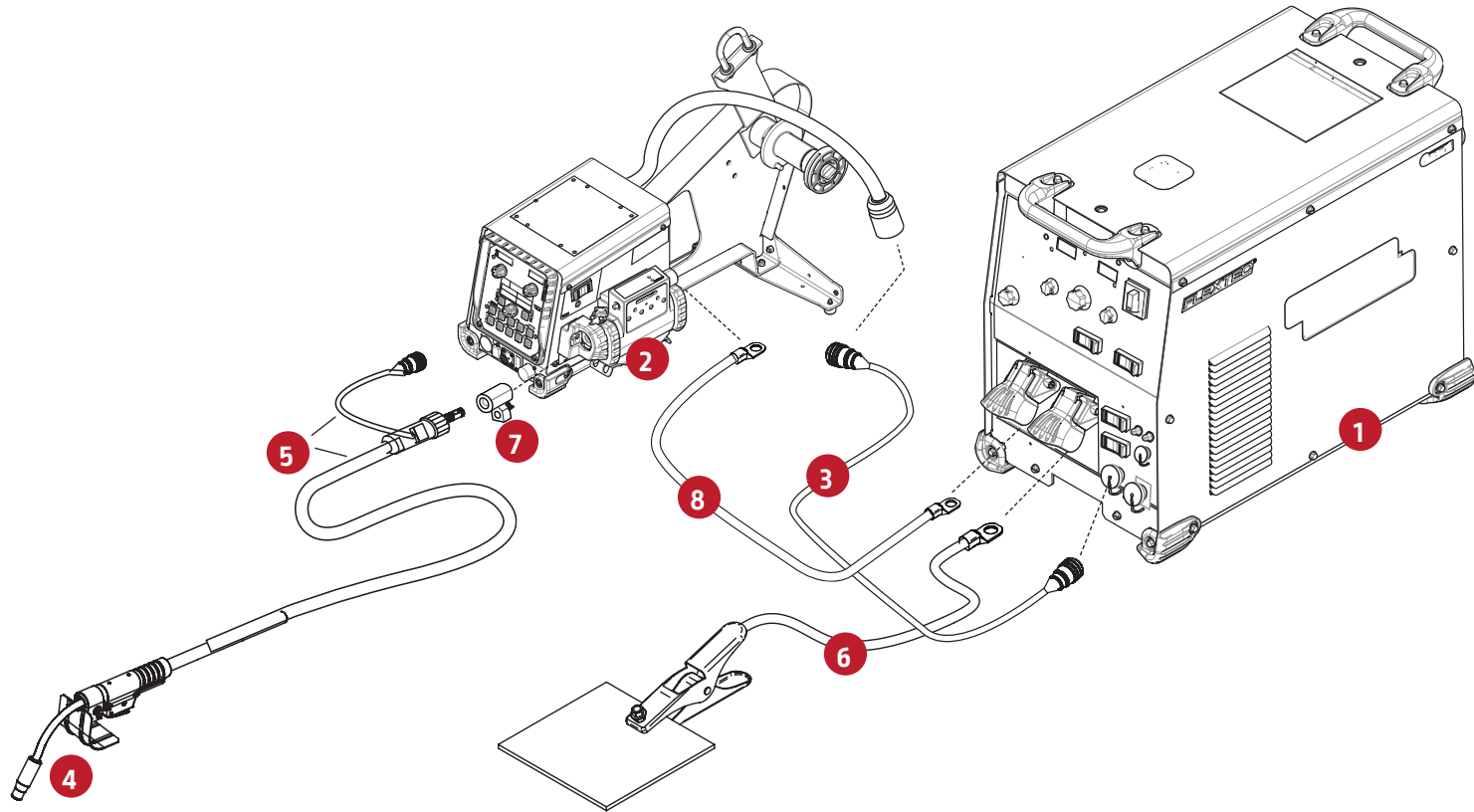
	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K3607-1/ K3611-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	Magnum® PRO AL. . G450W, 12-pin, 25 ft	K3357-2
5	Gun Connector Kit		#N/A
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84 Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Accessory	Cool Arc 55 Water Cooler	K3086-1 (Hoses Included)
9	Accessory	Base Mounting Kit - foot kit for Flextec® 500/500P	K3056-2
10	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Flextec® 650X

- Digital
- FCAW-S Gun

	ITEM	DESC.	K#
1	Machine	Flextec® 650X	K4091-1
2	Feeder	PF-84 Single Bench HD	K3328-13
3	Control Cable	5-pin ArcLink Male to 5-pin ArcLink Female. Standard Duty	K1543-xx (8 Ft. Cable Included with Feeder)
4	Gun	K126 Pro, 15 ft	K126-12
5	Gun Connector Kit	Tweco #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Work cable 15 ft. 4/0 cable lug to lug and ground clamp	K2149-1
7	Feeder Bushing	PF84-Series Tweco #2 - #4	K3345-1 (Included with Feeder)
8	Weld Power Cable	Lug to Lug 4/0 10ft.	K1842-10



Wire Feeder Control Cables & Adapters



K1501-10



K1798



K1797-10



K1543-8



K2683-25



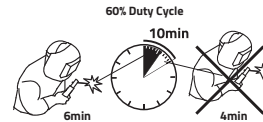
K1785-2



K2709-25

	FEEDER/SYSTEM	PRODUCT NUMBER	LENGTH FT. (M)	CONNECTION	DESCRIPTION	
Wire Feeder Control Cables	LN-10, DH-10	K1501-10	10 (3.1)	Male 14-pin to Female 9-pin	replaced K1502-x, K1503-x	
	LN-7	K1818-10	10 (3.1)	Female 6-pin to Male 14-pin	replaced K404-x, K291-x, K584-x, K594-x, K480-x	
	LN-742, LN-25	K1819-10	10 (3.1)	Female 8-pin to Male 14-pin	replaced K619-x, K592-x, K591-x	
	LN-8, LN-9, NA-3, NA-4, NA-5	K1820-10	10 (3.1)	Female 9-pin to Male 14-pin	replaced K196-x, K595-x, K596-x	
	LT-7	K1822-25	25 (7.6)	Female 9-pin to Male 14-pin	replaced K228-x	
	LN-23P (K316L-2)	K2393-1	25 (7.6)	Male 14-pin to Female 8-pin	Wire Feeder Control Cable	
	LN-23P (K316L-2)	K2393-2	75 (22.8)			
Extensions and Adapters	May require K1501-10, K1818-10, K1819-10 or K1820-10, depending on the feeder. LN-15, FlexFeed, LF-72, LF-74 LN-25 PRO Dual Power	K1797-10	10 (3.1)	Male 14-pin to Female 14-pin	Wire Feeder Control Cable Extension	
		K1797-25	25 (7.6)			
		K1797-50	75 (22.8)			
		K1797-100	100 (30.4)	Female 14-pin control cable to terminal strip	Adapter Cable for Control Cable to Terminal Strip of Power Source	
K1798						
ArcLink®/Linc-Net™ Control Cables	For Power Wave®/ Power Feed® Systems Power Feed 25M, Power Feed 84	K1543-8	8 (2.4)	Male 5-pin to Female 5-pin	ArcLink®/Linc-Net™ Control Cable	
		K1543-16	16 (4.9)			
		K1543-25	25 (7.6)			
		K1543-50	50 (15.2)			
		K1543-100	100 (30.4)		Heavy Duty ArcLink®/Linc-Net™ Control Cable	
		K2683-25	25 (7.6)			
		K2683-50	50 (15.2)			
Submerged Arc/Automation	For synchronizing Power Wave® AC/DC 1000® SD units and connecting MAXsa™ Feed Heads and MAXsa™ Controllers. For use with FANUC® arms having integrated cable. For connecting Control Unit to Wire Drive in LN-10, DH-10 Boom applications.	K1785-2	1.5 (0.46)	Male 14-pin to Female 14-pin	Heavy Duty Control Cable	
		K1785-4	4 (1.2)			
		K1785-8	8 (2.4)			
		K1785-12	12 (3.6)			
		K1785-16	16 (4.9)			
		K1785-25	25 (7.6)			
		K1785-50	50 (15.2)			
	K1785-100	100 (30.4)	Control Cable			
	For external dress of FANUC® robotic arm or hard automation.	K2709-25		25 (7.6)	Male 14-pin to Female 14-pin	Wire Drive Control Cable
		K2709-50		50 (15.2)		
K2709-100		100 (30.4)				

Electrode and Work Weld Cables



CONNECTION	LENGTH FT. (M)	PRODUCT NUMBER	DESCRIPTION
Twist Mate™ to Lug	10 (3.1)	K1840-10	Weld Power Cable, 1/0, 350A, 60% duty cycle
Lug to Lug	10 (3.1)	K1842-10	Weld Power Cable, 3/0, 600A, 60% duty cycle
	35 (10.7)	K1842-35	Weld Power Cable, 3/0, 600A, 60% duty cycle
	60 (18.3)	K1842-60	Weld Power Cable, 3/0, 600A, 60% duty cycle
	110 (33.5)	K1842-110	Weld Power Cable, 4/0, 600A, 60% duty cycle
Twist Mate™ to Twist Mate™	25 (7.6)	K1841-25	Weld Power Cable, 1/0, 350A, 60% duty cycle
	50 (15.2)	K1841-50	Weld Power Cable, 2/0, 350A, 60% duty cycle
Lug to Lug	35 (10.7)	K2163-35⁽¹⁾	Weld Power Cable, 4/0
	60 (18.3)	K2163-60⁽¹⁾	Weld Power Cable, 4/0
Lug to Lug	25 (7.6)	K1796-25	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle
	50 (15.2)	K1796-50	Coaxial Weld Power Cable, 1/0, 350A, 60% duty cycle
	75 (22.8)	K1796-75	Coaxial Weld Power Cable, 1/0, 325A, 60% duty cycle
	100 (30.4)	K1796-100	Coaxial Weld Power Cable, 1/0, 300A, 60% duty cycle
Lug to Lug	100 (30.4)	K2593-100	Coaxial Weld Power Cable, #1, 250A, 100% duty cycle
Tweco® to Lug	50 (15.2)	K2484-2	Weld Power Cable, 2/0, 350A, 60% duty cycle
	50 (15.2)	K2484-3	Weld Power Cable, 3/0, 600A, 60% duty cycle
Tweco® to Tweco®	50 (15.2)	K2485-2	Weld Power Cable, 2/0, 350A, 60% duty cycle
	50 (15.2)	K2485-3	Weld Power Cable, 3/0, 600A, 60% duty cycle

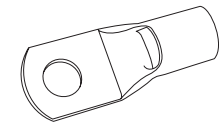
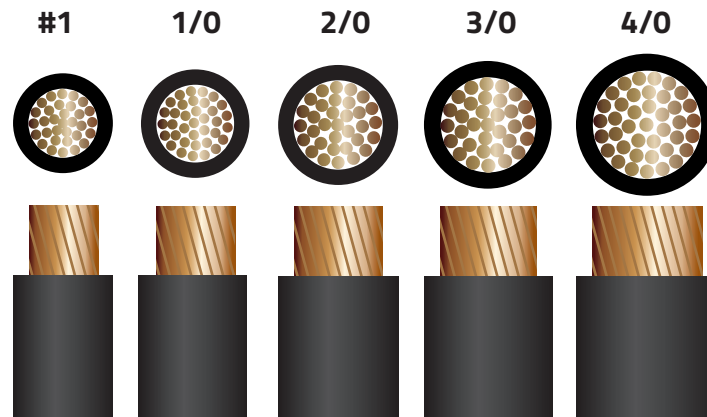
⁽¹⁾ Two cables per package.

RECOMMENDED ELECTRODE & WORK CABLE SIZES FOR ARC WELDING

RUBBER COVERED COPPER - RATED 75 C

CABLE SIZES ARE FOR COMBINED LENGTHS OF ELECTRODE & WORK CABLES

Amperes	% Duty Cycle	0 to 50 Ft.	50 to 100 Ft.	100 to 150 Ft.	150 to 200 Ft.	200 to 250 Ft.
100	20	8	5	3	2	1
125	30	6	5	3	2	1
150	40	6	5	3	2	1
180	20	5	4	3	2	1
180	30	4	4	3	2	1
200	50	3	3	2	1	1/0
200	60	2	2	2	1	1/0
200	100	2	2	2	1	1/0
225	20	4 or 5	3	2	1	1/0
225	30 & 40	3	3	2	1	1/0
250	30	3	3	2	1	1/0
250	40	2	2	1	1	1/0
250	60	1	1	1	1	1/0
250	100	1	1	1	1	1/0
300	60	1	1	1	1/0	2/0
325	100	2/0	2/0	2/0	2/0	3/0
350	60	1/0	1/0	2/0	2/0	3/0
400	60	2/0	2/0	2/0	3/0	4/0
400	100	3/0	3/0	3/0	3/0	4/0
500	60	2/0	2/0	3/0	3/0	4/0
600	60	3/0	3/0	3/0	4/0	2-3/0
600	80	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
600	100	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
650	60	3/0	3/0	4/0	2-2/0	2-3/0
650	80	2-1/0	2-1/0	2-1/0	2-2/0	2-3/0
700	100	2-2/0	2-2/0	2-3/0	2-3/0	2-4/0
800	80	3-1/0	3-1/0	3-1/0	2-3/0	2-4/0
800	100	2-3/0	2-3/0	2-3/0	2-3/0	2-4/0
1000	80	2-4/0	2-4/0	2-4/0	2-4/0	4-2/0
1000	100	3-3/0	3-3/0	3-3/0	3-3/0	3-3/0
1200	80	3-4/0	3-4/0	3-4/0	3-4/0	3-4/0
1200	100	4-4/0	4-4/0	4-4/0	4-4/0	4-4/0
1500	80	4-4/0	4-4/0	4-4/0	4-4/0	4-4/0
1500	100	5-4/0	5-4/0	5-4/0	5-4/0	5-4/0



CABLE LUGS

Product Number	Cable Size (mm ²)
S1119-6	4 (21)
S1119-6	3 (27)
S1119-6	2 (34)
S1119-14	1 (42)
S1119-14	1/0 (53)
S1119-14	2/0 (67)
S1119-1	3/0 (85)
S1119-1	4/0 (107)