FLEXTEC® / DLF - 82 READY-PAK®

FAB SHOP WELDING SYSTEM



Shown: K5335-1 Flextec 350XP / DLF-82 Ready-Pak

THE COMPLETE FAB SHOP SYSTEM

The Flextec / DLF Ready-Pak welding systems are the ideal shop solutions for MIG welding applications. Designed to combine the latest welding innovation with easy, operator-focused control features, these complete welding systems deliver the benchmark of simplicity and performance.

Tailored to be shop-floor focused, these systems are easy to order, easy to setup, and easy to operate - providing fab-shops a reliable, field-proven welding system that comes ready to weld, and ready to perform.

Processes »
CV-MIG, Pulsed MIG, CV-FCAW-G

Applications »
Fabrication Shops
Welding Production Facilities
Education and Training Facilities

Output »
DC CC CV

Product Numbers »
K5335-1 -Flextec 350XP / DLF-82 Ready-Pak

K3608-5 - Flextec 500X / DLF-82 Ready-Pak

K5336-4 - Flextec 350X PowerConnect® / DLF-82 Ready-Pak

K5336-5 - Flextec 350X PowerConnect / DLF-82 Education Ready-Pak

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KEY FEATURES

» **Straightforward Ordering & Set-up**
Flextecs are now compatible with Lincoln Electric's DLF-82 digital wire feeder and combined into flexible packages designed for simple ordering, shipping, and setup. Ready-Pak options ship assembled and ready to weld in minutes.

» **Intuitive, Operator-Focused Controls**
Simple power source and wire feeder controls provide easy operation, allowing operators to quickly dial-in the system.

» **Optimized Arc Performance**
Intelligent features such as synergic CV-MIG and Pulsed MIG, along with Auto Settings optimize arc performance for low spatter and improved arc control

» **Reliable Design**
Built on Lincoln Electric's proven Flextec and LF wire feeder platforms, these systems deliver field-proven reliability, backed by trusted industry expertise and support.

DLF-82 WIRE FEEDER

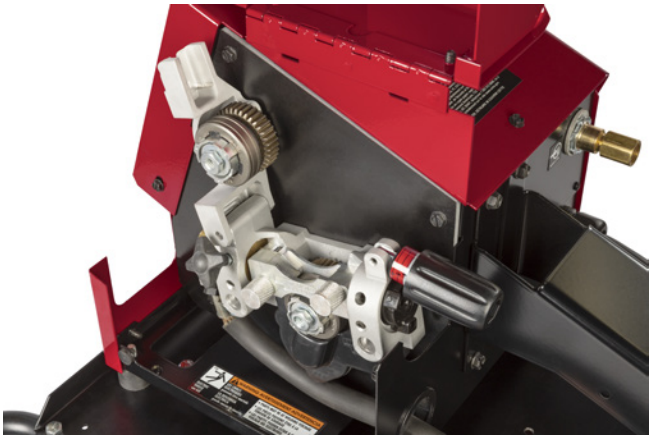


1. Bright digital displays for preset WFS/voltage and actual current/voltage
2. Set up screen for optimum process selection and system settings
3. Weld Mode / Menu selector encoder push button
4. Gun connector (5-pin)
5. Wire reel stand accommodates up to 60-lb spools.
6. Gas purge / trigger interlock - Electronic trigger lock allows for less fatigue during long welds
7. Cold feed for safe loading of wire
8. Memory selection - easily recall up to 4 different weld schedules

ENHANCED WIRE DRIVE SYSTEM

MAXTRAC® Wire Drive System
The field-proven MAXTRAC wire drive system is a standard feature on DLF-82 wire feeders and provides improved wire feeding performance.

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



FLEXTEC / DLF-82 SYSTEM - ADVANCED FEATURES

Synergic Control - Let the system know the wire type, diameter and shielding gas. From there one knob (WFS) is the only adjustment that is needed. For hotter or faster welds, choose higher WFS, for cooler or smaller welds, choose lower WFS. The system does the rest.

Pulsed MIG Modes - Helps reduce spatter for more productivity, minimize fume, and offer a wider operating range for improved weld puddle control and easier out-of-position welding.

Adaptive Arc - When using the pulsed MIG process, small changes to contact tip to work distance (CTWD) will not affect the bead shape as the adaptive arc works to keep the arc length constant.

Auto Settings - Automatically adjust settings based on workpoint for improved performance and less guesswork.

- Run-in Speed - For smooth starts and reduced spatter
- Pre Flow, Post Flow, Burn Back Timers - For additional weld shielding and quality
- Starting Procedure - Helps provide extra wetting when needed at the beginning of the weld
- Crater Fill - Helps reduce crater at the weld end

Arc Control - Options to fine tune the arc with Pinch/Inductance and Pulse Frequency.

Memory Presets - Save up to 4 custom weld settings and quickly recall based on your application.

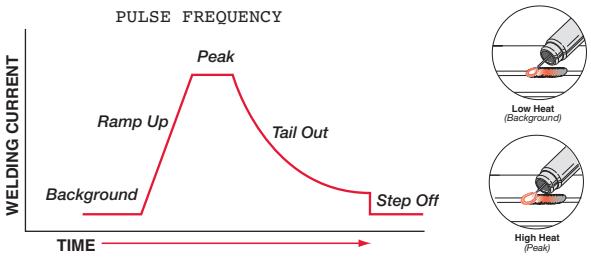
Gun Trigger Memory Recall - Easily change between saved weld settings (such as tack settings and weld settings) right at the weld gun, no need to go back to the welder.

Weld Parameter Limits - Customized high & low limits for WFS, V/Trim, and Arc Control to help increase process control and reduce accidental parameter changes.

Weld Mode Lock Out - Customize the weld mode options available to select (ie, only .045 carbon steel pulse, only .035 stainless CV, etc)

PIN Lockout - Restrict system / parameter changes and reduce chance of accidental changes.

Pulsed MIG



Flextec / DLF-82 Weld Modes

Non-Synergic

FCAW-S
FCAW-G
GMAW (MIG)
MCAW (Metal Core)

	Flextec 350XP / 350X PC	Flextec 500X
Synergic CV		
Steel	.030-.045	.030-1/16
Stainless Steel	.030-.045	.030-1/16
Aluminum	.035-1/16	.035-1/16
Metal Core	.045-.052	.045-1/16
Synergic Pulsed*		
Steel	.035-.052	.035-1/16
Stainless Steel	.035-.045	.035-1/16
Aluminum	.035-1/16	.035-1/16
Metal Core	.045-.052	.045-1/16

*Basic pulse modes only. Pulse on pulse Aluminum is not included and the DLF feeder supports only a push gun.

FLEXTEC POWER SOURCES

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

- Simple, easy-to-use interface. With the Flextec / DLF system, all control is transferred to the DLF wire feeder.
- Flexible, multi-process capabilities
- Reliable, rugged design with trayed and potted pc boards to withstand the harshest fab shop 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

For more information on the Flextec 350XP or Flextec 350X Power Connect - view literature E5.109
For more information on the Flextec 500X - view literature E5.108

READY-PAK PACKAGES

Ready-Pak® packages comes assembled, shipped on a pallet, and ready to weld in minutes. Welding wire and shielding gas must be ordered separately.



Description	Part Number	Flextec 350XP DLF-82 Ready-Pak	Flextec 500X / DLF-82 Ready-Pak	Flextec 350X PowerConnect / DLF-82 Ready-Pak	Flextec 350X PowerConnect / DLF-82 Education Ready-Pak
	Ready-Pak Part #	K5335-1	K3608-5	K5336-4	K5336-5
	Rated Duty Cycle	350A @60%	500A @ 60%	350A @60%	350A @60%
	Input Voltage	380-575V 3-Phase	380-575V 3-Phase	200-575V, 1/3-Phase	200-575V, 1/3-Phase
Flextec 350XP	K4272-2	•			
Flextec 350X PowerConnect	K4273-2			•	•
Flextec 500X	K3607-1		•		
DLF-82 Bench Model	K5282-3	•	•	•	•
Magnum® Pro Curve HDE 350, 045 15ft. Ready-Pak	K4532-2-10-45	•	•	•	•
.035-.045 Reversible Drive Roll Kit	KP1505-1	•	•	•	•
DLF Wire Reel Stand (60-lb)	K5284-1	•	•	•	•
Inverter and Wire Feeder Cart	K3059-4	•	•	•	•
Flowmeter/Regulator, 355-2AR-580110	3100211	•	•	•	•
Locking Foot Kit (Flextec 350X)	K4424-1	•		•	•
DLF-Feeder Cart Mounting Bracket	K5395-1	•	•	•	•
Work/Power Lead Package (Tweco® to Lug/Gc500)	K1803-2	•		•	•
Power Lead 3/0 Lug to Lug 10 Ft.	K1842-10		•		
Work Lead 10ft W/ Ground Clamp Lug to Lug	K2149-1		•		
Foot Kit (Flextec 500x)	K3056-2		•		
Caliber™ 17 Tig Torch - Flex/Valve, 12.5	K4841-17FV-1				•
Tweco Style Cam Lock Adapter, 17 Series	K960-4				•
Foot Amptrol 12 Pin	K870-2				•
Electrode Holder #2, Tweco to EH200 15 Ft.	K5161-2-15				•

DRIVE ROLL KITS

Drive roll kits include drive rolls and wire guides.

Wire Diameter	Solid Wire (V-Groove)	Cored Wire (Knurled)	Aluminum (U-Groove)
.023-0.030	KP1696-030S	-	-
0.035	KP1696-035S	KP1697-035C	KP1697-035A
.035 /.045	KP1696-1	-	-
0.040	KP1696-2	-	KP1695-040A
.045	KP1696-045S	KP1696-045C	
3/64	-	-	KP1695-3/64A
0.052	KP1696-052S	KP1697-052C	-
1/16	KP1696-1/16S	KP1697-1/16C	KP1695-1/16A
.068-.072		KP1697-068	-
5/64		KP1697-5/64	-



Solid Wire (V-groove)
KP1696-045S shown



Cored Wire (Knurled)
KP1697-045C shown



Aluminum (U-Groove)
KP1695-3/64A shown

CONTROL CABLES

An 8ft control cable is included and integrated into the DLF wire feeder. For longer lengths choose a 5-pin digital ArcLink cable extension

Product Name	Product Number	Description	Connection	Use	Length ft (m)
ArcLink Control Cables 	K1543-8	Standard ArcLink® Cable	Male 5-pin to Female 5-pin	ArcLink® compatible Power Wave®, Power Feed®, and Flextec® systems	8 (2.4)
	K4483-8	Ext-Flex ArcLink® Cable			
	K4483-16				16 (4.9)
	K4483-25				25 (7.6)
	K4483-50				50 (15.2)
	K4483-100				100 (30)

FEEDPLATE GUN ADAPTERS

K3344-1	K3345-1 (Included)	K3346-1	K3347-1	K3348-1	K3349-1
Lincoln Electric Compatible gun connector kit K466-1 K613-1 K613-6 K466-8 	Tweco® #2 - #4 Compatible gun connector kit K466-10 K466-2 K466-6 	Tweco® #5 Compatible gun connector kit K613-7 K613-2 	Miller® guns Compatible gun connector kit K466-3 K613-3 	OXO® guns Also requires K3345-1 Adapter 	Magnum® Fast-Mate™ Compatible with single and dual procedure guns. Also requires K3345-1 Adapter 

Tweco® is a registered trademark of Victor Technologies.
Miller® is a registered trademark of Miller Electric Mfg. Co.
Oxo® is a registered trademark of Miller Electric Mfg. Co.

RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Inlet Bushing, Quick Connect Style
Quick connect bulk conduits
Order K3929-1



Wire Straightener
Straightens wire for the better, smoother feeding.
Order K1733-1



60C Coil Adapter
50-60 lb (22.7-27.2 kg) coil adapter for 2 inch spindles
Order K1504-1



Lift Bail
Insulated lift bail for suspending the wire feeder.
Order K3341-1



Protective Wire Spool Cover
Protective wire spool cover.
Order
K1634-4 for use with 30-40 lb. (13.6-18.1 kg) spools
K3340-1 for use with 50-60 lb (22.7-27.2 kg) spools.



Shielding Gas Filter
Protects the gas solenoid and gun from contaminants.
Order KP3103-1

PRODUCT SPECIFICATIONS - POWER SOURCE

Product Name	Product Number	Input Power	Rated Output: Current/ Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Dimensions H x W x D inches (mm)	Weight lbs (kg)
Flextec 350XP	K4272-2	380/460/575 3-Phase 50/60 Hz	350A/34V/60% 300A/32V/100%	25/28/22 21/23/23	5-425A	17 x 13 x 24 (432 x 330 x 609)	82 (37.1)
Flextec 350X PowerConnect	k4273-2	200-208/220- 230/380-415/460/575 3-Phase 50/60 Hz	350A/34V/60% 300A/32V/100%	45/40/23/19/15 37/33/19/16/13			84 (38.1)
		380-415/460/575 1-Phase 50/60 Hz	350A/34V/60% 300A/32V/100%	39/32/26 32/26/22			
		200-208/220-230 1-Phase 50/60 Hz	300A/32V/60% 270A/31V/100%	62/56 54/48			
Flextec 500X	K3607-1	380/460/575/ 3-Phase 50/60 Hz	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)

PRODUCT SPECIFICATIONS - WIRE FEEDER

Product Name	Product Number	Input Power	Rated Output: Current/ Voltage/Duty Cycle	Solid Wire Diameter Ranger in. (mm)	Cored Wire Diameter Range In. (mm)	Wire Feed Speed Range: ipm (m/min)	Dimensions H x W x D inches (mm)	Weight lbs (kg)
DLF-82	K5282-3	40 VDC	500A @ 100% 600A @ 60%	0.023 - 1/16 (0.58 - 1.6)	0.030 - 5/64 (0.76 - 1.98)	50-800 (1.3 - 20.3)	15.9 x 12.0 x 25.6 (403 x 305 x 320)	43 (19.5)

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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LINCOLN® ELECTRIC