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 »

Product Numbers »
K5335-1 - Flextec 350XP / DLF-82 Ready-Pak
K3608-5 - Flextec 500X / DLF-82 Ready-Pak
K5336-1 - Flextec 350X PowerConnect® / DLF-82 Ready-Pak
K5336-3 - Flextec 350X PowerConnect / DLF-82 Education Ready-Pak
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.

### KEY FEATURES

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

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**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
- 20% more feeding force
- 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
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 (i.e., only .045 carbon steel pulse, only .035 stainless CV, etc)

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

Flextec / DLF-82 Weld Modes

<table>
<thead>
<tr>
<th>Non-Synergic</th>
<th>Flextec 350XP / 350X PC</th>
<th>Flextec 500X</th>
</tr>
</thead>
<tbody>
<tr>
<td>FCAW-S</td>
<td>.030-.045</td>
<td>.030-.045</td>
</tr>
<tr>
<td>FCAW-G</td>
<td>.030-.045</td>
<td>.030-.045</td>
</tr>
<tr>
<td>GMAW (MIG)</td>
<td>.035-1/16</td>
<td>.035-1/16</td>
</tr>
<tr>
<td>MCAW (Metal Core)</td>
<td>.045-.052</td>
<td>.045-.052</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Synergic CV</th>
<th>Flextec 350XP / 350X PC</th>
<th>Flextec 500X</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>.035-.052</td>
<td>.035-.052</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>.035-.045</td>
<td>.035-.045</td>
</tr>
<tr>
<td>Aluminum</td>
<td>.035-1/16</td>
<td>.035-1/16</td>
</tr>
<tr>
<td>Metal Core</td>
<td>.045-.052</td>
<td>.045-.052</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Synergic Pulsed*</th>
<th>Flextec 350XP / 350X PC</th>
<th>Flextec 500X</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>.035-.052</td>
<td>.035-.052</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>.035-.045</td>
<td>.035-.045</td>
</tr>
<tr>
<td>Aluminum</td>
<td>.035-1/16</td>
<td>.035-1/16</td>
</tr>
<tr>
<td>Metal Core</td>
<td>.045-.052</td>
<td>.045-.052</td>
</tr>
</tbody>
</table>

*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

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 come assembled, shipped on a pallet, and ready to weld in minutes. Welding wire and shielding gas must be ordered separately.

### Description

<table>
<thead>
<tr>
<th>Description</th>
<th>Part Number</th>
<th>Flextec 350XP DLF-82 Ready-Pak</th>
<th>Flextec 500X / DLF-82 Ready-Pak</th>
<th>Flextec 350X PowerConnect / DLF-82 Ready-Pak</th>
<th>Flextec 350X PowerConnect / DLF-82 Education Ready-Pak</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ready-Pak Part #</td>
<td>K5335-1</td>
<td>K3608-5</td>
<td>K5336-1</td>
<td>K5336-3</td>
<td></td>
</tr>
<tr>
<td>Rated Duty Cycle</td>
<td>350A @ 60%</td>
<td>500A @ 60%</td>
<td>350A @ 60%</td>
<td>350A @ 60%</td>
<td></td>
</tr>
<tr>
<td>Input Voltage</td>
<td>380-575V 3-Phase</td>
<td>380-575V 3-Phase</td>
<td>200-575V, 1/3-Phase</td>
<td>200-575V, 1/3-Phase</td>
<td></td>
</tr>
</tbody>
</table>

- Flextec 350XP: K4272-2
- Flextec 350X PowerConnect: K4273-1
- Flextec 500X: K3607-1
- DLF-82 Bench Model: K5283-3
- 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: 310211
- 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: K2449-1
- Foot Kit [Flextec 500x]: K3056-2
- Caliber™ 17 Tig Torch - FlexValve, 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.

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>Solid Wire (V-Groove)</th>
<th>Cored Wire (Knurled)</th>
<th>Aluminum (U-Groove)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.023-.030</td>
<td>KP1696-0030S</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>.035</td>
<td>KP1696-0035S</td>
<td>KP1697-0035C</td>
<td>KP1697-0035A</td>
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<tr>
<td>.045 / .045</td>
<td>KP1696-0045S</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>.040</td>
<td>KP1696-0040S</td>
<td>KP1697-0040A</td>
<td>-</td>
</tr>
<tr>
<td>.045</td>
<td>KP1696-0045S</td>
<td>KP1696-0045C</td>
<td>-</td>
</tr>
<tr>
<td>3/64</td>
<td>-</td>
<td>KP1697-0064A</td>
<td>-</td>
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<tr>
<td>.052</td>
<td>KP1696-0052S</td>
<td>KP1697-0052C</td>
<td>-</td>
</tr>
<tr>
<td>1/16</td>
<td>KP1696-0116S</td>
<td>KP1697-0116C</td>
<td>KP1695-0116A</td>
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<tr>
<td>.063 - .072</td>
<td></td>
<td>KP1697-0068</td>
<td>-</td>
</tr>
<tr>
<td>5/64</td>
<td></td>
<td>KP1697-05/64</td>
<td>-</td>
</tr>
</tbody>
</table>

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.

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

FEEDPLATE GUN ADAPTERS

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 K1634-1 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

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**PRODUCT SPECIFICATIONS - POWER SOURCE**

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Rated Output: Current/Voltage/Duty Cycle</th>
<th>Input Current @ Rated Output</th>
<th>Output Range</th>
<th>Dimensions H x W x D (inches)</th>
<th>Weight lbs (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flextec 350XP</td>
<td>K4272-2</td>
<td>380/460/575</td>
<td>350A/34V/60% 300A/32V/100%</td>
<td>5/425A</td>
<td>17 x 13 x 24</td>
<td>432 x 310 x 609</td>
<td>82 (37.1)</td>
</tr>
<tr>
<td>Flextec 350X PowerConnect</td>
<td>K4273-1</td>
<td>200-208/220-230/380-415/460/575</td>
<td>350/34V/60% 300A/32V/100%</td>
<td>25/28/22</td>
<td>37 x 33 x 13</td>
<td>19 x 16 x 13</td>
<td>84 (38.1)</td>
</tr>
<tr>
<td>Flextec 500X</td>
<td>K3607-1</td>
<td>380/460/575</td>
<td>500A/40V/60% 450A/38V/100%</td>
<td>5/500A</td>
<td>18.8 x 14 x 27.5</td>
<td>477 x 395 x 69</td>
<td>136 (62)</td>
</tr>
</tbody>
</table>

**PRODUCT SPECIFICATIONS - WIRE FEEDER**

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power</th>
<th>Rated Output: Current/Voltage/Duty Cycle</th>
<th>Solid Wire Diameter Range in. (mm)</th>
<th>Cored Wire Diameter Range in. (mm)</th>
<th>Wire Feed Speed Range: ipm (m/min)</th>
<th>Dimensions H x W x D (inches)</th>
<th>Weight lbs (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>DLF-82</td>
<td>K5282-3</td>
<td>40 VDC</td>
<td>50A @ 100% 60A @ 60%</td>
<td>0.023 - 0.16 (0.58 - 1.6)</td>
<td>0.030 - 5/64 (0.76 - 1.94)</td>
<td>60-800 (1.3 - 20.3)</td>
<td>15.9 x 12.0 x 25.6 (403 x 305 x 320)</td>
<td>43 (19.5)</td>
</tr>
</tbody>
</table>

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**CUSTOMER ASSISTANCE POLICY**

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, and cutting equipment. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications 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, or to provide engineering advice in relation to a specific situation. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers’ particular purpose or any other equivalent or similar warranty is specifically disclaimed.

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