

# ACTIV8X<sup>®</sup> PIPE<sup>™</sup>

## PORTABLE, SEMIAUTOMATIC WIRE FEEDER



Shown:  
Activ8X Pipe Base Unit - K4717-1

### PERFECTLY TUNED FOR PIPE WELDING

The Activ8X<sup>®</sup> Pipe<sup>™</sup> Wire Feeder is the ideal field solution for GMAW and FCAW-G welding applications out on the pipeline. With weld processes specifically optimized for pipe welding, the Activ8X Pipe allows you to take Lincoln Electric's industry-leading root-to-cap weld processes – including STT<sup>®</sup> and Pulsed MIG – right out to the field. In addition, the rugged and compact design provides durability to withstand the harshest conditions, from mud and rain, to extreme heat or cold, delivering the reliability you need to perform in the toughest welding applications.

#### Processes »

STT<sup>®</sup> Field, CV-MIG, CV-FCAW-G, Pulsed MIG

#### Applications »

Cross Country Pipe  
Process Pipe  
Structural Field Welding  
Shipbuilding

#### Output »



#### Product Numbers »

K4717-1 Activ8X Pipe Base Unit (Tweco<sup>™</sup>)\*  
K4968-2 Activ8X Pipe / Magnum<sup>®</sup> PRO Curve<sup>™</sup>  
HDE 250 One-Pak\*\*\*  
K4935-2 Activ8X Pipe / Flextec<sup>®</sup> 350X  
PowerConnect<sup>®</sup> One-Pak  
K5240-1 Activ8X Pipe CE (Twist Mate)

\*Activ8X Pipe supports DC+ processes only

\*\*Activ8X Pipe requires compatible power source.

## KEY FEATURES

- **Excellent Arc Performance**

Optimized arc performance designed specifically for root-to-cap pipe welds, including STT Field and CV/Pulse modes for excellent sidewall fusion, backbead reinforcement, and overall bead profile.

- **Ultimate Control**

Full control over the weld process can be easily made right at the wire feeder - no need to waste time walking back to the power supply for adjustments.

- **Rugged & Portable Design**

Built on Lincoln Electric's proven portable feeder platform the Activ8X Pipe delivers a lightweight, yet dependable solution that can withstand the extreme conditions of field construction applications.

- **Straightforward Setup**

From truck to ditch, setup is fast and easy. Connection between the Activ8X Pipe and power source is as simple as two standard quick-connect weld cables.

## KEY CONTROLS

1. WFS and Volt Meter
2. WFS and Voltage Control
3. CrossLinc® LED
4. Menu Selection Encoder
5. Weld Procedure Display
6. Memory Selection
7. Gun Trigger Connection
8. Gun Connection
9. Work Lead Connection



1. MAXTRAC® Wire Drive
2. Cold Feed / Gas Purge
3. Trigger Interlock Switch
4. Accommodates Up To 8 In. Dia. Spools
5. Lift Bail



1. Shielding Gas Inlet
2. Electrode + (from power source)
3. Work Lead - (from power source)

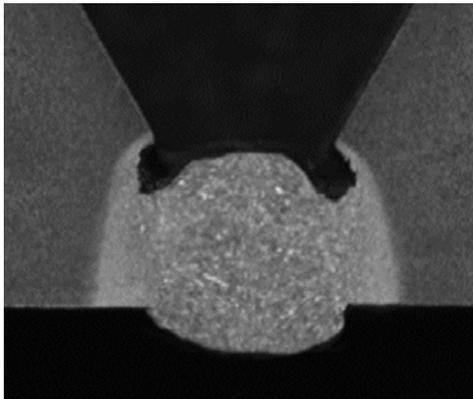
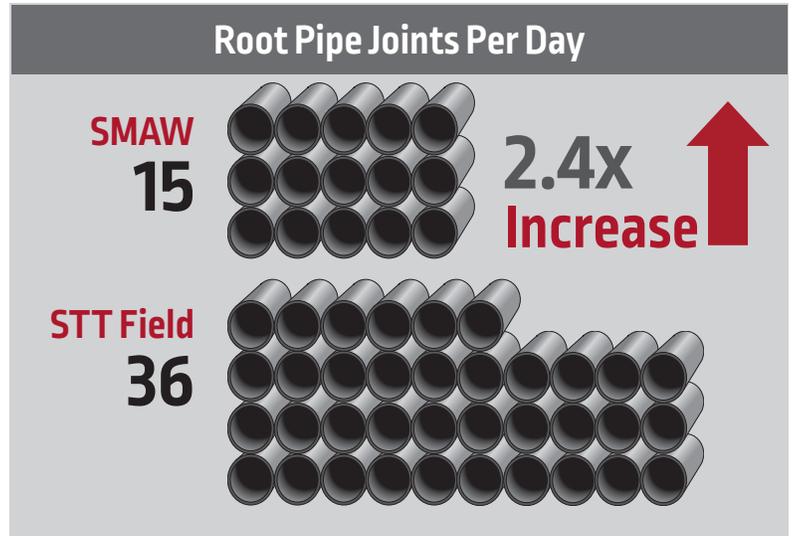


### STT® FIELD

All the industry-proven root pass performance of STT® (SurfaceTension Transfer®), now available right on the construction site with minimal equipment, cables, and setup time

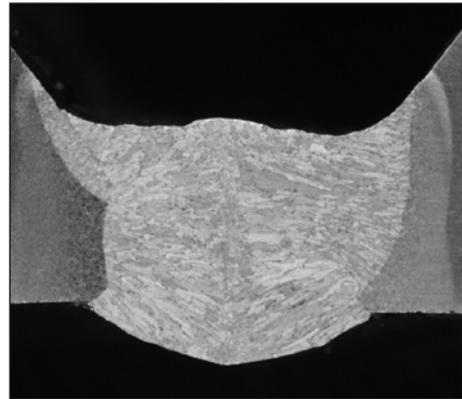
- Breakthrough travel speeds
- Industry-leading arc stability
- Excellent fusion and back bead reinforcement

\*Comparison based on 5G vertical down welding on 18 in. Pipe Joints during a normal 8-hour shift. Includes timing for necessary post-weld cleaning.



#### Traditional Stick Root Pass

- Medium-sized bead
- Convex shape
- Ropy back bead



#### STT Field Root Pass

- Larger bead
- Flat face
- Ideal back bead & fusion

### PULSE TAILORED FOR PIPE

The Activ8X Pipe was engineered to deliver the ideal pulse arc for your pipe welding needs. With built-in technology that monitors machine settings, the Activ8X pipe can automatically adjust the pulse waveform for superior arc performance on fill and cap applications.

- Set a low WFS – Activ8X Pipe auto-adjusts for a narrow, focused arc
- Set a high WFS – Activ8X Pipe auto-adjusts for a wide, soft arc
- Less time adjusting means more time welding

### OPTIMIZED WELD MODES

Loaded with weld modes optimized specifically for field pipe welding applications, the Activ8X Pipe delivers fine-tuned weld modes for maximum performance based on the industry's common filler metal, wire diameters, and gas mixtures.

- Synergic MIG modes optimized for 0.035 in. (0.9 mm), 0.040 in. (1.0 mm), and 0.045 in. (1.2 mm) steel, stainless steel and metal-cored
- Versatility of Non synergic CV for FCAW-G and additional wire alloys

## SYSTEM SETUP FEATURES

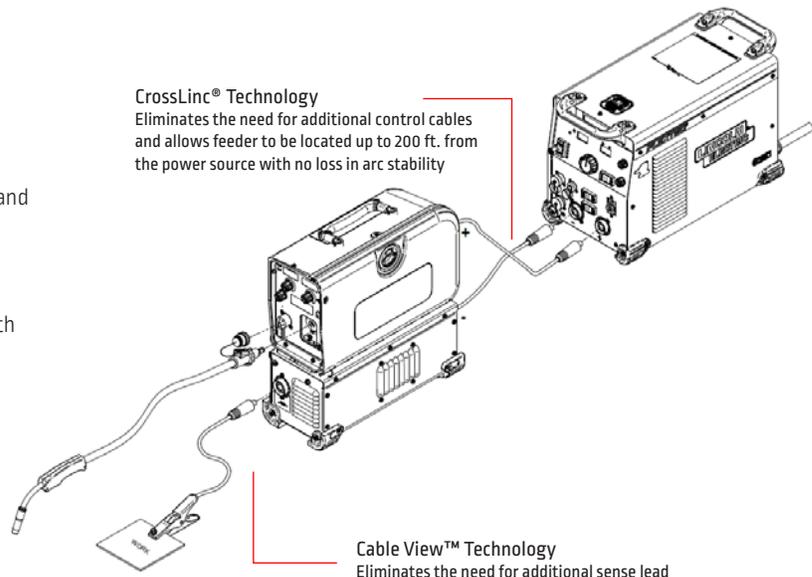
### CROSSLINC® TECHNOLOGY

CrossLinc® feeders enable voltage control at the feeder without the extra cable. The result is greater productivity, safety, and quality. Avoid the negative aspects of across the arc models and adding a control cable, while enjoying all the benefits

- Productivity - Work smarter, reduce movement, and minimize rework
- Safety - Reduce cable clutter and potential trip hazards
- Quality - Meet WPS specifications more easily with greater operator control

### CABLE VIEW™ TECHNOLOGY

With patented Cable View™ Technology, the Activ8X Pipe continuously monitors cable inductance and adjusts the waveform to maintain consistent arc performance **without the need for an additional sense lead**.



## PROCESS CONTROL

### FULL CONTROL WHERE YOU NEED IT

The Activ8X Pipe system allows you to control everything you need right at the feeder. With a straightforward user interface, operators can easily change between processes and have confidence the right parameters are dialed in for every pass.

Easily select and dial in:

- Weld Mode
- Wire Type
- Gas Type
- WFS and Volts (Trim)

### MEMORY OPTIONS

Easily store and select up to four memories for quick process change between root, fill, and cap passes.

### TRUE ENERGY

Patented True Energy® Technology allows for accurate measurement and calculations of total energy (per ASME section IX code) instantaneously throughout the weld. Displayed after each weld, True Energy enables faster heat input calculations for critical welds and logs measurements for the past 20 welds.



## MODELS & PACKAGES AVAILABLE

### Activ8X Pipe - Base - K4717-1

- Activ8X Pipe Feeder with Tweco® Style Connectors (K4717-1)
- 0.035 - 0.045 in. (0.9 - 1.2 mm)
- V-Groove Reversible Drive Roll Kit (KP1696-1)



### Activ8X Pipe One-Pak® - K4968-2

- Activ8X Pipe Feeder with Tweco® Style Connectors (K4717-1)
- Magnum PRO Curve HDE 250 Welding Gun 15ft Ready-Pak® 0.035 - 0.045 in. (0.9 - 1.2 mm) (K4531-2-10-45)
- 0.035 in. (0.9 mm) Tapered Contact Tip (10 ea.) (KP2744-035T)
- 3/8 in. (9.5 mm) Tapered-Flush Nozzle (KP2742-1-38F)
- 0.035 - 0.045 in. (0.9 - 1.2 mm) V-Groove Reversible Drive Roll Kit (KP1696-1)
- 2/0 work lead Tweco to GC500, 15 ft. (K4835-2/0-15)



### Activ8X Pipe & Flextec® 350x PowerConnect® One-Pak® - K4935-2

- Activ8X Pipe Feeder with Tweco Style Connectors (K4717-1)
- Flextec 350X PowerConnect Power Source (K4273-1)
- Magnum PRO Curve HDE 250 Welding Gun 15ft Ready-Pak 0.035 - 0.045 (0.9 - 1.2 mm) (K4531-2-10-45)
- 0.035 in. (0.9 mm) Tapered Contact Tip (10ea.) (KP2744-035T)
- 3/8 in. (9.5 mm) Tapered-Flush Nozzle (KP2742-1-38F)
- 0.035 - 0.045 (0.9 - 1.2 mm) V-Groove Reversible Drive Roll Kit (KP1696-1)
- 2/0 work lead Tweco to GC500, 15ft. (K4835-2/0-15)



## RECOMMENDED POWER SOURCE

### FLEXTEC 350X

Part Number	Description
K4273-1	Flextec 350X PowerConnect (Tweco)
K3443-1	Flextec 350X PowerConnect (Twist Mate)
K5422-1	Flextec 350XP CE-compliant (Twist Mate)

### FRONTIER 400X

Part Number	Description
K3484-1	Frontier 400X (Perkins)
K3484-2	Frontier 400X (Kubota)
K3485-1	Frontier 400X Pipe (Perkins)
K3485-2	Frontier 400X Pipe (Kubota)

## RECOMMENDED ACCESSORIES

### ACTIV8X GUN CONSUMABLES

Part Number	Description
K4531-2-10-45	Magnum PRO Curve HDE 250 Gun package, 15 ft Ready-Pak
KP2744-035T	350A 0.035 in. (0.9 mm) tapered contact tip (10 pack)
KP2744-040	350A 0.040 in. (1.0 mm) ( tapered contact tip (10 pack)
KP2744-045	350A 0.045 in. (1.2 mm) tapered contact tip (10 pack)
KP2742-1-38F	3/8 in. (9.5 mm) 350A tapered flush nozzle thread on
KP2742-1-50F	1/2 in. (12.7 mm) 350A flush nozzle thread on

### WELD CABLES

Part Number	Description
K4835-2/0-15	2/0 work lead Tweco® to GC500 15ft.
K2485-2	2/0 weld cable Tweco Male to Tweco Female, 50ft
K3416-70	Tweco-Style Plug (male 1/0-2/0)
K3417-70	Tweco-Style Receptacle (female 1/0-2/0)

### DRIVE ROLLS

Part Number	Description
<b>Solid Wires</b>	
KP1696-1	0.035 - 0.045 in. (0.9 -1.2 mm) V-Groove MAXTRAC® Drive roll and wire guide kit
KP1696-035S	0.035 in. (0.9 mm) V-Groove MAXTRAC Drive roll and wire guide kit
KP1696-2	0.040 in. (1.0 mm) V-Groove MAXTRAC Drive roll and wire guide kit
KP1696-045S	0.045 in. (1.2 mm) V-Groove MAXTRAC Drive roll and wire guide kit
<b>Cored Wires</b>	
KP1697-045C	0.040-0.045 in. (1.0 - 1.2 mm) Knurled MAXTRAC Drive roll and wire guide kit

## PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output / Voltage / Duty Cycle DC+ Only	Wire Diameter in (mm)	Wire Feed Speed IPM (m/min)	Max Spool Capacity in/diameter lb (kg)	Dimensions H x W x D in (mm)	Net Weight lb (kg)
Activ8X Pipe (Tweco)	K4717-1	60-90VDC, 60V OCV	275A/27V/60%	0.035 - .047 (0.9 - 1.2)	50-700 (1.27-17.8)	Diameter: 8 (203) Weight: 15 (6.8)	18 x 8 x 19 (457 x 203 x 483)	49 (22.2)
Activ8X Pipe CE (Twist Mate)	K5240-1		250A/25V/100%					

For best welding results with Lincoln Electric® equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

#### TEST Results Disclaimer:

Test results for mechanical properties and travel speeds were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means the suitability of any welding consumable and procedure before use in the intended application.

#### 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](http://www.lincolnelectric.com) for any updated information.

### RECOMMENDED WIRE

Part Number	Description	AWS Class
<b>Carbon Steel</b>		
ED028676	0.035 in. (0.9 mm) SuperArc® L-56® 12.5#SP	ER70S-6
ED029042	0.045 in. (1.2 mm) SuperArc L-56 12.5#SP	ER70S-6
ED036531	1.0 mm (0.040 in.) Pipeliner® ER70S-6 10SP	ER70S-6
ED037505	1.2 mm (0.045 in.) Pipeliner ER70S-6 10SP	ER70S-6
<b>Stainless</b>		
ED037201	0.035 in. (0.9 mm) Lincoln® Red Max® 308 LSi 10#SP	ER308SI, ER308LSI
ED037202	0.045 in. (1.2 mm) Lincoln Red Max 308 LSi 10#SP	ER308SI, ER308LSI
ED037347	0.035 in. (0.9 mm) Lincoln Red Max 309LSi 10#SP	ER309SI, ER309LSI
ED037348	0.045 in. (1.2 mm) Lincoln Red Max 309LSi 10#SP	ER309SI, ER309LSI
ED037352	0.035 in. (0.9 mm) Lincoln Red Max 316 LSi 10#SP	ER316SI, ER316LSI
ED037353	0.045 in. (1.2 mm) Lincoln Red Max 316 LSi 10#SP	ER316SI, ER316LSI