



PROCESS PIPE FIELD WELDING WITH ACTIV8X[®] PIPE[™]



Field welding in the Process Pipe industry can be challenging. Contractors face outdoor elements, difficult welding positions, safety concerns, power-to-arc logistics, welding code requirements and scheduling deadlines. To be successful, contractors must employ welding solutions that are favorable for improving productivity, reducing repair rates and offering ease of portability. The welding solution must be suited for a variety of welding processes, a range of different materials and provide good mobility to reach all areas of the job site.



INCREASE DIAMETER INCHES/DAY

- » STT[®] Field root pass up to 4X+ faster than GTAW in root pass productivity
- » Total time (STT Field + GMAW-P Hot, Fill, Cap) 2X+ Faster than GTAW



PROCESS FLEXIBILITY

- » Full range of welding processes including: STT Field, SMAW, GTAW, GMAW, FCAW-G, GMAW-P, MCAW-P



REDUCE HEAT INPUT

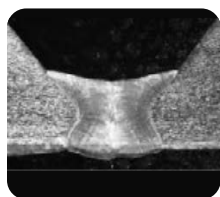
- » STT Field root lowers heat input up to 25% compared to GTAW root



QUALIFIED TO ASME SEC. IX B31.1 AND B31.3

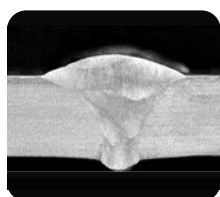
ACTIVE8X PIPE SOLUTION

STT Field is a new field welding technology that offers the ultimate in portability along with the benefits of the proven legacy STT performance for pipe root welding. Keep your projects on time with the Activ8X Pipe and STT Field.



STT FIELD ROOT PASS

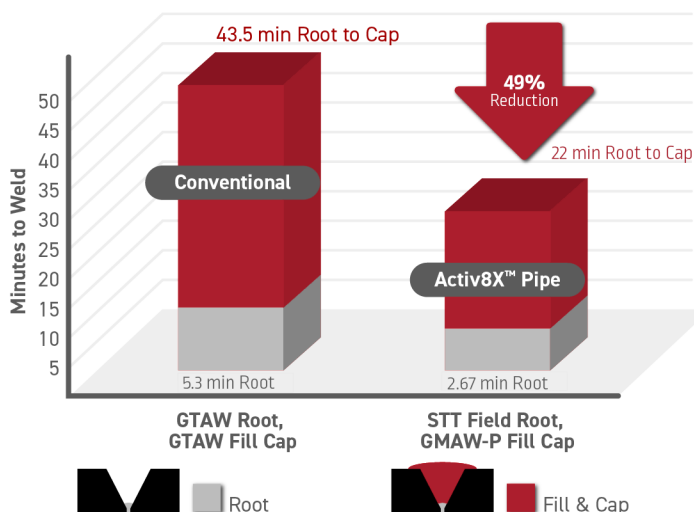
- » STT Field mode
- » No backing gas (SS Pipe)
- » No control cable or sense lead



HOT, FILL & CAP PASSES

- » Use GMAW-P or FCAW-G for carbon steel, stainless steel and chromoly (CrMo) steel
- » System includes traditional welding processes like SMAW and GTAW

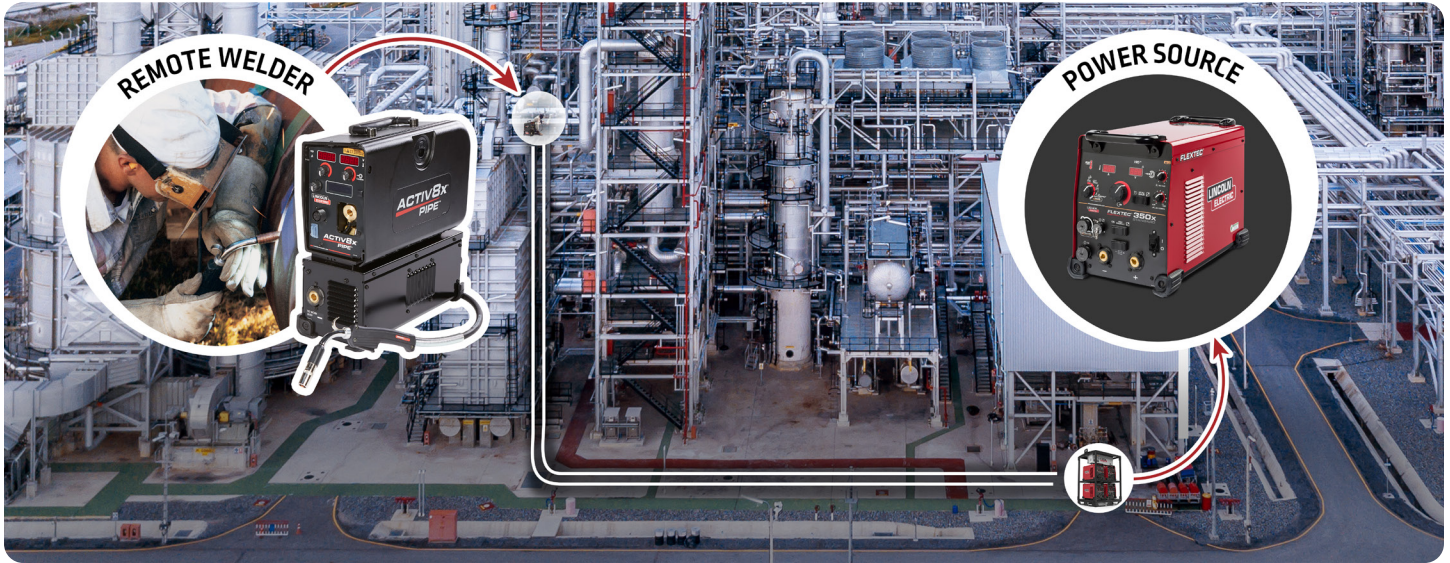
Reduce Weld Time (6" SCH 40 304L)



KEY SOLUTION ATTRIBUTES

- ✓ Improve Safety - no back purge
- ✓ Non Helium Gas – SS shielding gas 98% Ar / 2% CO₂ recommended
- ✓ CS, SS, and CrMo Applications
- ✓ STT Field controls heat input for root welding without backing gas on SS
- ✓ Low Hydrogen Process
- ✓ ASTM G48 corrosion testing results meet typical industry requirements
- ✓ 35% reduction in weight as compared to a shop system

SOLUTION SETUP



SOLUTION COMPONENTS



Activ8X Pipe

For the ultimate in job site portability

- » Compact, portable wire feeder ideal for field welding GMAW and FCAW applications
- » Features STT Field and Pulse waveform outputs, as well CrossLinc® technology for at-the-arc control



Flextec® 350X PowerConnect®

For optimal “across-the-arc” welding output from any input power

- » Rugged, multi-process welder: MIG, TIG, Stick, Flux-Cored, and Carbon arc gouging.
- » PowerConnect® technology allows input power from 200 to 575V, single or three phase, 50 or 60 Hz



Frontier™ 400X

The new frontier of engine-driven weld performance

- » Versatile, multi-process system with 400 amps of output power and 11 kW of auxiliary power
- » Features next-gen, 7 in. user interface, Auto Stop/Start, and CrossLinc technology



SuperArc® L-56® & Red Max® Austenitic Stainless Steel

Industry-leading MIG consumables

- » Industry-leading MIG consumables with consistent and reliable wire feeding and tight chemistry control
- » Lot certification for peace of mind in critical applications

Test Results Disclaimer

Test results for mechanical properties, travel speeds, and heat input 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 depending 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 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.

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