

# FLEXTEC® 650 SUBARC

HEAVY DUTY APPLICATIONS



## SIMPLE. RELIABLE. FLEXIBLE.

This submerged arc welder delivers up to 815 amps of welding power for a variety of applications, including construction, shipbuilding and heavy fabrication.

The Flextec 650 Subarc will run on a wide range of available voltage input power and is IP23 rated for outdoor operation and storage. Broad SAW wire feeder compatibility is not an issue – The Flextec 650 Subarc will operate with almost any Lincoln Electric® SAW wire feeder and controller.

Simple. Reliable. Flexible. Specify the Flextec 650 Subarc for your heavy duty applications.

### Processes »

Submerged Arc

### Input »



### Output »



### Product Number »

K5441-1



## KEY FEATURES

- Use with a wide range of available 3 phase input power
- Easy one-knob process selection
- Components designed to run cool for long life in high temperature environments
- Up to 815A of output
- Support for 115V and 42V analog wire feeders and controllers
- Support for digital ArcLink controllers
- Supports LT-7 tractor and Cruiser Tractor

## KEY CONTROLS

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Positive and Negative Welding Output Studs
6. VRD (Voltage Reduction Device) Indicator Light
7. Voltage Display Meter
8. Power Switch
9. Local/Remote Output Selector Switch
10. Weld Terminals On/Remote Selector Switch
11. Wire Feeder Voltmeter Polarity Selection Switch
12. Circuit Breaker Reset Buttons for 42V feeders and ArcLink peripherals
13. 42V or 115V Wire Feeder Selector Switch
14. Remote Output Control 12-pin Universal Connector
15. 14-pin Wire Feeder Connector
16. 5-pin ArcLink Connector



## SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/Hertz	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x L (mm)	Net Wt. (kg)
Flextec 650 Subarc CE Model	K5441-1	380/460/575/3/50/60	750A/44V/60%	61/50/40	40-815A (CV)	554 x 410 x 745	165
			650A/44V/100%	57/47/38			
			750A/44V/60%	61/50/40	100-815A (CC)		
			650A/44V/100%	57/47/38			

## RECOMMENDED WIRE FEEDERS AND ACCESSORIES

DIGITAL WIRE FEEDERS AND ARCLINK ACCESSORIES	PRODUCT NUMBER
MAXsa 10 Controller	K2814-4
MAXsa 22 Feed Head	K2370-2
MAXsa 19 Controller	K2626-4
MAXsa 29 Feed Head	K2312-2
Cruiser Tractor	K3048-2
Heavy Duty ArcLink® (5-Pin) Control Cable - 7.6 m (25ft)	K2683-25
Heavy Duty ArcLink® (5-Pin) Control Cable - 15.2 m (50ft)	K2683-50

ANALOG WIRE FEEDERS AND ACCESSORIES	PRODUCT NUMBER
Controller NA-3S	K210-2
Head NA-3S 2,4-5,6 mm (3/32-7/32)	K208A
Head NA-3S 1,6 -2,4 mm (.035-.3/32)	K208B
Head NA-3SF 2,4-5,6 mm (3/32-7/32)	K209A
Head NA-3SF 1,6 -2,4 mm (.035-.3/32)	K209B
Controller NA-5	K356-2
Head NA-5S 2,4-5,6 mm (3/32-7/32)	K346A
Head NA-5SF 2,4-5,6 mm (3/32-7/32)	K347A
LT-7 tractor	K395-1
Control Cable 9-Pin to 14-Pin - 3 m (10ft)	K1820-10