

# Activ8X™ with CrossLinc® Technology

Rugged. Compact. Connected.



Shown:  
Activ8X w/Crosslinc - K3519-1

## PORTABLE, SEMIAUTOMATIC WIRE FEEDER

Activate your shipbuilding, offshore, or construction operations with the Activ8X portable wire feeder with Crosslinc Technology. Small enough to fit through manways and light enough to carry around the site, the Activ8X wire feeder also allows remote control of the power source without the need for control cables via CrossLinc Technology. This includes True Voltage Technology™ (TVT™) which ensures you get the voltage you set at the arc, even when you are hundreds of feet away from the power source.

### Processes »

MIG, Flux-Cored

### Applications»

Construction  
Shipyards

### Output »



### Input »



### Product Number »

K3519-1 Activ8X  
K3564-1 Activ8X / Magnum® PRO Curve 300 One-Pak®  
K3519-2 Activ8X CE (Twist Mate / Dinse)

## RUGGED.

- » Impact resistant, flame retardant case provides rugged durability for tough conditions.
- » Potted PC Boards for moisture and corrosion protection.
- » Maxtrac® Wire Drive System— Heavy-duty cast aluminum wire drive system provides reliable feeding and durability.
- » Tachometer feedback ensures accurate wire feed speed.

## COMPACT.

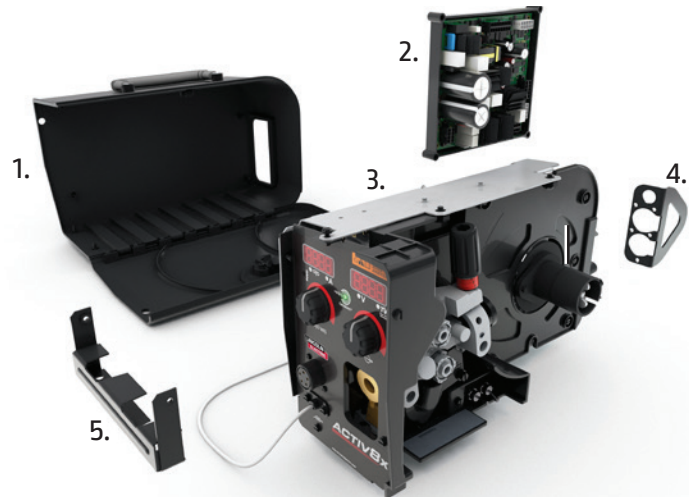
- » Lightest construction feeder on the market today.
- » Accepts up to 8 in. (203 mm) diameter wire spools.

## CONNECTED.

- » CrossLinc Technology allows for remote output control over the welding leads. No control cable needed!
- » True Voltage Technology™ (TVT™) automatically compensates for voltage drops across long welding cables.

## FIELD ARMOR

We understand that when you're on the job anything can happen at any time, and the last thing you want to do is worry about your equipment getting damaged. That's why we designed Field Armor™, protective advancements to your machine's body keeping knobs, cables, and internal mechanisms out of harm's way.



1. Impact resistant, flame retardant case.
2. Potted PC board to protect from the elements.
3. Internal, marine grade aluminum skeleton for superior corrosion and impact resistance.
4. Lift bale for easy lowering through manways and protects gas fittings from incidental contact.
5. Control shield protects control knobs from external damage.

## RECOMMENDED POWER SOURCES

### Look for the X

The Activ8X wire feeder will work with any CV or CC power source as a simple, across-the-arc feeder. However, when paired together with a CrossLinc Technology compatible power source, communication will be established, and welding output is controlled from the feeder without control cables.

CrossLinc Technology compatible feeders and power sources carry an X in their name, i.e. "Activ8X", "Flextec® 350X", etc.



Use CrossLinc Technology to control voltage hundreds of feet away using a standard weld cable with the Activ8X.





**CrossLinc w/True Voltage Technology (TVT)** – Improve all aspects of your operation with CrossLinc Technology and TVT.

### Safety

- Reduce jobsite clutter by removing cumbersome control cables.
- Eliminate unnecessary movement of personnel across the jobsite.
- No need to drag heavy control cables around the site.

### Quality

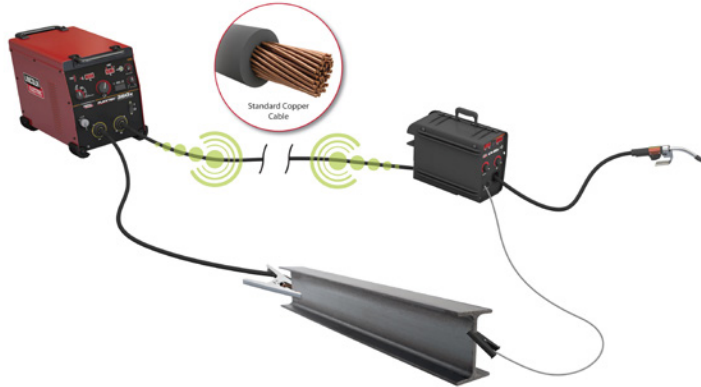
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

### Productivity

- Setup faster with fewer cable connections.
- Eliminate trips to the power source to make procedure adjustments.
- Minimize rework with easy settings adjustments.

### Crosslinc Technology Communicates Settings Directly Over The Weld Cables.

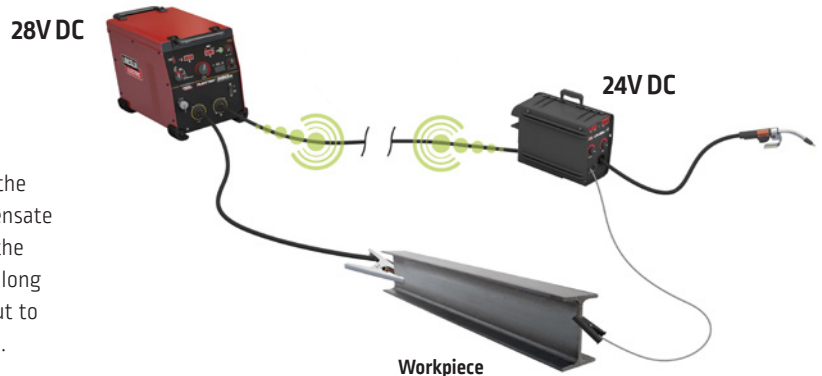
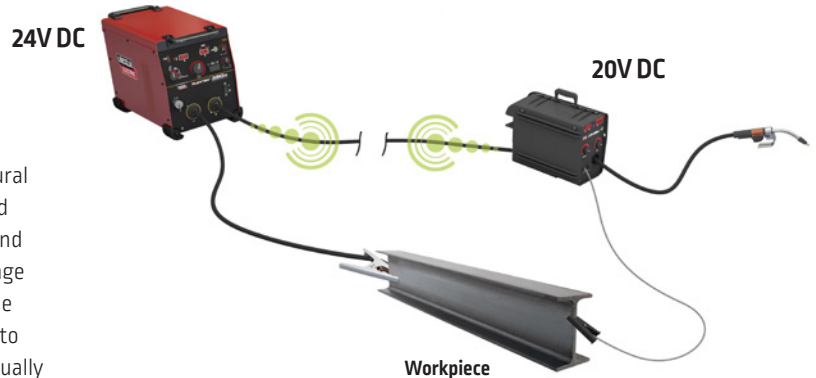
- No additional control cable is needed.
- Pre-set the desired voltage on the feeder.
- The feeder sends the signal to the CrossLinc enabled power source.
- The CrossLinc compatible power source puts out the desired voltage.
- The Activ8X receives the voltage and lets you know the actual voltage at the arc.



## TRUE VOLTAGE TECHNOLOGY (TVT)



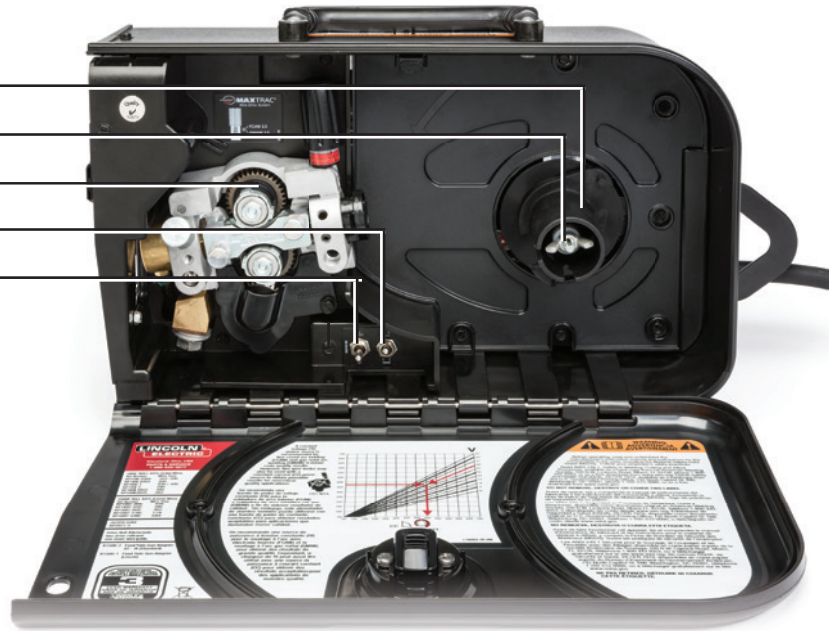
As is common in many outdoor welding applications: (Structural steel, Shipbuilding, Offshore, etc.) the operator can be located hundreds of feet away from the power source. Long cables and multiple connections can create a difference in voltage (voltage drop) between the power source and the weld. In the example to the right, 24volts is set on the welding power source. Due to electrical resistance through long cables, only 20volts are actually available at the arc. This may result in a cold weld.



True Voltage Technology (TVT) sees this drop and gives you the true voltage you set by adjusting the power source to compensate for the voltage drop. In the example below, 24v is preset at the Activ8X wire feeder. TVT senses there is a 4 volt drop due to long weld cables and compensates by increasing the welder output to 28V. The result is the desired 24v available at the welding arc.

## WIRE DRIVE

1. Spool Retainer
2. Spindle Brake
3. MAXTRAC® Drive System
4. 2-Step/trigger Interlock Switch
5. Cold Feed / Gas Purge Switch



## CONTROLS

- Hidden Setup Menu
- Voltage Display
- Wire Feed Speed/Amperage Display
- Wire Feed Speed Knob
- Remote Voltage Control Knob



## INCOMING CONNECTIONS

- Shielding Gas Inlet with Gas Filter
- Electrode Lead w/ Tweco® style connector



\* CE model includes Twist Mate / Dinse connector as standard.

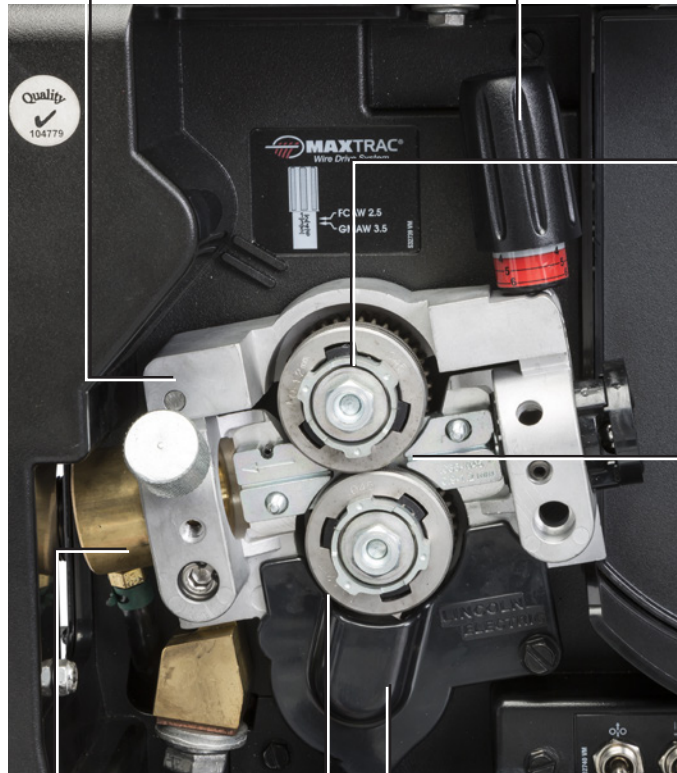
# **MAXTRAC**<sup>®</sup> Wire Drive System

### Patented Dual Spring Pressure Arm

- Easy turn numeric tension indicator
- Set heavy tension for solid steel and stainless steel wire
- Set moderate tension for cored wires
- Set soft tension for aluminum wire
- Wide idler arm hinge delivers improved drive roll clamping pressure

### Rigid Cast Aluminum Frame

- Enhances precise drive roll alignment



### Twist-Lock Drive Roll Hubs

- Two gear driven rolls
- Fast, tool-less changeovers

### Patented Split Wire Guides

- Full support for wire throughout the drive path
- Removable outer wire guide for easy access
- No tools required
- No birdnesting

### Brass to Brass Interchangeable Gun Bushings

- More reliable electrical conductivity – no oxide build-up
- More efficient energy transfer – lower voltage drops
- Easily adapt any number of Lincoln Magnum<sup>®</sup>, Magnum<sup>®</sup> PRO or competitive guns

### Patented Drive Rolls

- For steel - new design delivers 20% more feeding force
- For aluminum - chrome plated to resist build-up

### Separate Drive Gear

- Reduces pressure on motor for extended service life

## REQUIRED ACCESSORIES

### FEED PLATE GUN ADAPTERS

K1500-1	K1500-2 <sup>(1)</sup>	K1500-3	K1500-4	K1500-5	K489-7
<b>Lincoln Style</b>	<b>Tweco® #2 - #4</b>	<b>Tweco #5</b>	<b>Miller® Guns</b>	<b>OXO® Guns</b>	<b>Fast-Mate™ / Euro Connector</b>
Compatible gun connector kits:	Compatible gun connector kits:	Compatible gun connector kits:	Compatible gun connector kits:		Compatible with weld guns with Fast-Mate™ or Euro connectors
K466-1 K613-1 K613-6 K466-8	K466-10 K466-2 K466-6	K613-7 K613-2	K466-3 K613-3		
					

<sup>(1)</sup>Installed in machine.

### MAXTRAC DRIVE ROLL & WIRE GUIDE KITS

Description	Product No.
<b>Steel Wire Sizes (includes stainless steel):</b>	
.023-.030 in [0.6-0.8 mm]	KP1696-030S
.035 in [0.9 mm]	KP1696-035S
.045 in [1.2 mm]	KP1696-045S
.052 in [1.4 mm]	KP1696-052S
.035, .045 in [0.9, 1.2 mm]	KP1696-1
.040 in [1.0 mm]	KP1696-2
1/16 in [1.6 mm]	KP1696-1/16S
<b>Cored Wire Sizes:</b>	
.030-.035 in [0.8-0.9 mm]	KP1697-035C
.040-.045 in [1.0-1.2 mm]	KP1697-045C
.052 in [1.4 mm]	KP1697-052C
1/16 in [1.6 mm]	KP1697-1/16C
<b>Steel or Cored Wire Sizes:</b>	
.068-.072 in [1.8 mm]	KP1697-068
5/64 in [2.0 mm]	KP1697-5/64
3/32 in [2.4 mm]	KP1697-3/32
<b>Aluminum Wire Sizes:</b>	
.035 in [0.9 mm]	KP1695-035A
.040 in [1.0 mm]	KP1695-040A
3/64 in [1.2 mm]	KP1695-3/64A
1/16 in [1.6 mm]	KP1695-1/16A

### WELD POWER CABLES

Description	Product No.	
1/0 Cable	Twist Mate™ to Lug, 1/0, 350A, 60% duty cycle, 10 ft. [3.0 m]	K1840-10
	Twist Mate to Twist Mate, 1/0, 350A, 60% duty cycle, 25 ft. [7.6 m]	K1841-25
2/0 Cable	Tweco-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. [15.2 m]	K2485-2
	Tweco-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. [15.2 m]	K2484-2
	Twist Mate to Twist Mate, 2/0, 350A, 60% duty cycle, 50 ft. [15.2 m]	K1841-50
3/0 Cable	Tweco-Style male plug and female receptacle 3/0, 600A, 60% duty cycle, 50 ft. [15.2 m]	K2485-3
	Tweco-Style male plug and 0.53 lug, 3/0, 600A, 60% duty cycle, 50 ft. [15.2 m]	K2484-3
	Lug to Lug, 3/0, 600A, 60% duty cycle, 10 ft. [3.0 m]	K1842-10
4/0 Cable	Lug to Lug, 3/0, 600A, 60% duty cycle, 35 ft. [10.6 m]	K1842-35
	Lug to Lug, 3/0, 600A, 60% duty cycle, 60 ft. [18.2 m]	K1842-60
	Lug to Lug, 4/0, 600A, 60% duty cycle, 110 ft. [33.5 m]	K1842-110

**ACCESSORIES**

	Product Number	Product Name	Description
	See Publication E12.111	K126 PRO Innershield Gun	350A, 60% duty cycle, air cooled gun for Innershield, flux cored, self shielded, welding. Magnum PRO expendable parts.
	See Publication E12.05	Magnum PRO Curve Semiautomatic Guns	Magnum PRO Curve guns for MIG or flux-cored, gas shielded welding combine our classic curved handle with our Copper Plus contact tips and Magnum PRO gun expendables to deliver long hours of fabrication welding with less frequent tip and gun expendable parts changes.
	K3416-70	Tweco style plug	Male, 1/0 - 2/0
	K3417-70	Tweco style receptacle	Female, 1/0 - 2/0
	K3416-90	Tweco style plug	Male, 3/0 - 4/0
	K3417-90	Tweco style receptacle	Female, 3/0 - 4/0
	K852-70	Twist Mate Plug	Male, 1/0 - 2/0
	K852-95	Twist Mate Plug	Male, 3/0
	K1759-70	Twist Mate Receptacle	Female, 1/0 - 2/0
	K1759-95	Twist Mate Receptacle	Female, 3/0
	K2487-1	Lug to Tweco style adapter	Female Tweco style receptacle that attaches to standard 1/2" output terminals
	K586-1	Deluxe Adjustable Gas Regulator	Deluxe gas regulator for mixed gasses, adapter for CO2 and 10ft. (3.0m) Hose.
	K283	Portable Digital Wire Feed Speed Meter	When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute.
	K3061-1	Plastic Case (Activ8X Feeder)	A complete replacement plastic case for the Activ8 feeders.

**ONE-PAKS®**

Product Number	Product Name	Includes
K3564-1	Activ8X/Magnum PRO Curve 300 One-Pak	Activ8X Feeder, Magnum Pro Curve 300 Gun, .052 in. (1.3 mm) Knurled Drive Rolls

**PRODUCT SPECIFICATIONS**

Product Name	Product Number	Input Power	Rated Output Current/Voltage/ Duty Cycle	Wire Feed Speed Range ipm (m/min.)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
					GMAW	FCAW		
Activ8X	K3519-1	15-110 VDC	330A/60%	50-700ipm (1.3-178)	.023-.052 (0.6-1.3)	.035-5/64 (0.9-2.0)	11.8 x 7.6 x 19.8 (298 x 193 x503)	27 (12.2)
Activ8X CE (Twist Mate / Dinse)	K3519-2							

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