FLEXTEC® 350XP CE

SIMPLE. RELIABLE. FLEXIBLE.



Whether in a shop or in the field, the Flextec® 350XP welder is built to perform.

Equipped with CrossLinc® technology, the Flextec® 350X family of machines can be controlled from hundreds of feet away without expensive and inconvenient control cables. Desert Duty® and IP23 rated, they can withstand harsh outdoor conditions and outperform other welders in their class.

In the field, the Flextec® 350XP is a welder's most effective weapon. As a rugged multi-process power source, this model stays reliable and offers much more than other inverter-based welders in its class.

In the shop, the Flextec® 350XP model is built to work with all Lincoln 42V feeders for your factory applications. It is also compatible with Arclink® digital feeders to provide synergic modes, memories, and basic pulsed MIG for seamless connectivity and improved weld performance.

Processes »
SMAW, GTAW, GMAW, GMAW-P*, FCAW, CAC-A (gouging), STT Field**

Applications »
Fabrication, Construction, Shipbuilding, Structural, Pipe

Output »
CC CV | DC | Synergic

Input »
3 PHASE | 50/60 Hz

Product Number »
K5422-1 Flextec 350XP CE

*Pulse requires the use of a compatible ArcLink digital wire feeder.

**STT Field available only when paired with the Activ8X Pipe wire feeder.

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FEATURES

SIMPLE

- Simple interface for ease of use
- CrossLinc technology automatically pairs the accessory with the power source and provides remote output control at the arc without additional remotes or cables[1]

RELIABLE

- Lab tested, field proven ruggedness and durability
- Engineered for outdoor use and harsh environments
- IP23 rated for use in outdoor weather conditions
- Desert Duty rated for operation at temperatures up to 55° C
- Trayed and potted PC boards to help withstand welding dust and humidity

FLEXIBLE

- Multi-process power source for all your welding needs
- Optimized stick welding for both cellulosic and low hydrogen electrodes
- Compatible with CrossLinc, 42V analog, and digital feeders for GMAW and FCAW
- ArcLink enabled to provide synergic pulse modes for reduced spatter, lower heat input, increased productivity, and improved quality [2]
- Touch-Start TIG® for reducing contamination during starts without high frequency

[1] When paired with a CrossLinc technology enabled wire feeder or CrossLinc remote.

[2] Available on the Flextec 350XP when paired with an ArcLink enabled feeder to access pulse modes.

SIMPLE

Flextecs are meant to be easy to use in order to increase productivity and decrease downtime. With a user-friendly control setup, settings can be configured with ease.

Simple Mode Switch

Choose your weld process:
GTAW (TIG)

SMAW (Stick)

CV – gas shielded (MIG)

CV-Innershield® (self-shielded)

ArcLink for access to synergic and pulse modes (when using an ArcLink wire feeder)

Carbon Arc Gouge in Stick or MIG modes

Large Output Control

Located front and center

Remote Control Connection

Plug in for remotes

Welding Terminals

Clearly labeled, quick connections



Dedicated Hot Start

Adjustable to help reduce sticking when stick welding

Local/Remote rocker switch

Choose to have control locally on the machine or remotely when using a wire feeder or remote control

Dedicated Arc Control

Less arc control (less pinch) in short arc wire processes to decrease spatter

More arc control in Stick welding reduces chance of sticking during welding

RELIABLE

Flextecs are built to withstand harsh conditions so that they last to help get the job done. Operating in challenging environments, these machines are durable and protected from the elements.



Tough alloy handles for lifting and impact protection

Lightweight aluminum powder painted case for rust protection

Shock Absorbing Rubber Feet for impact protection



Solid control knobs and rocker switches resistant to damage from spatter and hot welding wires



Automotive grade Molex® connectors, heavy gauge wire, locking tabs for secure connections, rubber boots to help keep contaminants out



Smart fans run at variable speeds to keep components cool



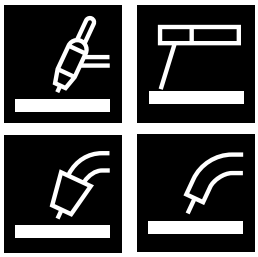
Trayed and potted PC boards for physical and environmental protection

FLEXIBLE

Flextecs are meant to be just that, flexible. With a variety of processes and feeder compatibilities, the Flextec product line is made up of the most versatile welders on the market.

Any Process

GTAW, SMAW, GMAW, GMAW-P,**
FCAW-S, FCAW-G, CAC, STT Field*





*STT Field available on the Flextec 350XP only when paired with the Activ8X Pipe wire feeder.

**Pulse requires the use of a compatible digital ArcLink wire feeder.

CROSSLINC TECHNOLOGY AND TRUE VOLTAGE TECHNOLOGY™ (TVT™)

CrossLinc with True Voltage Technology (TVT) – Improve all aspects of your operation with CrossLinc 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 jobsite

Quality

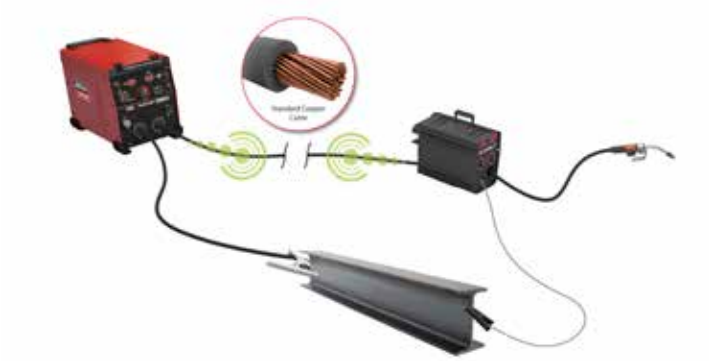
- Full output control at the arc allows the welder to input the correct settings for every weld
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs
- Eliminate unintentional machine adjustments by helpers or other operators

Productivity

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

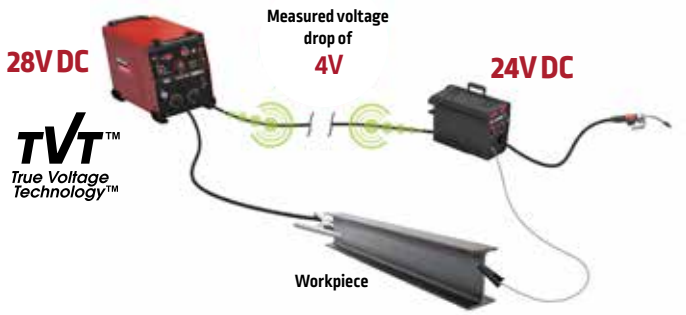
CrossLinc allows for amperage and voltage control at the welding arc to improve control of your operation.

- No need for an additional control cable – communication occurs directly over the weld cables:
  1. Set the desired voltage on the CrossLinc wire feeder
  2. The feeder sends a signal to the CrossLinc power source
  3. The power source will change to the desired voltage

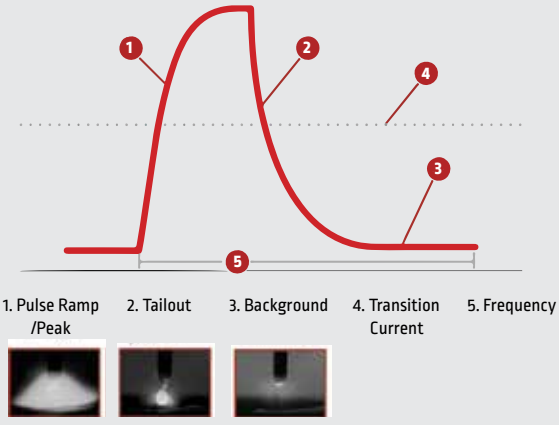


CrossLinc also features True Voltage Technology to compensate for voltage drop across the welding circuit.

- TVT will measure the voltage drop and adjust the power source to compensate for the difference between the desired voltage and actual voltage at the weld:
  1. Preset the wire feeder to the desired voltage
  2. Make a test weld
  3. The system will measure voltage drop and automatically adjust the power source to compensate



PULSE



Pulsed spray is a non-contact transfer method between the electrode and the weld puddle. This means that at no time does the electrode ever touch the puddle. This is accomplished through high-speed manipulation of the electrical output of the welding machine. It is designed to be a spatterless process that will run at a lower heat input than spray or globular transfer methods.

Advantages provided by pulsing machines include:

- Spatter and fume reduction
- Heat reduction
- Improved productivity
- Better control

KEY SYSTEM CONFIGURATIONS

Synergic Pulse Modes Flextec 350XP

Wire Size	Wire Size			
	Steel	Stainless	Metalcore	Aluminum
0.035	•	•		•
0.040	•			
0.045	•	•	•	
3/64				•
0.052	•		•	
1/16			•	•

Compatibilities

Flextec 350XP	
Input Power	380/400/415/3/50/60
CrossLinc Compatible	•
Multi-Process	•
12-Pin accessory Compatible	•
14-Pin Analog Feeder Compatible	•
Arclink Feeder (5-Pin) Compatible	•
Pulse Capable (w/Arclink Feeder)	•

KEY CONTROLS

FLEXTEC 350XP

1. Amperage Display
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Remote Output Control (12-pin Universal Connector)
6. 5-pin ArcLink Wire Feeder Connector
7. 14-pin Wire Feeder Connector
8. Positive and Negative Welding Output Studs
9. Voltage Display
10. VRD (Voltage Reduction Device) Indicator Lights
11. CrossLinc Indicator Light
12. Hot Start Control Dial
13. Arc Control Dial
14. Local/Remote Selector Toggle Switch
15. Weld Terminals On/Remote Selector Switch
16. Power Switch
17. Wire Feeder Voltmeter Polarity Selection Switch



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Single Cylinder Inverter and Wire Feeder Cart
Requires K4068-1 mounting bracket for LF, Flex Feed and Power Feed Feeders. Requires locking foot kit for Flextecs
Order K3059-4



Dual Cylinder Inverter and Wire Feeder Cart
Requires K4068-1 mounting bracket for LF, Flex Feed and Power Feed Feeders. Requires locking foot kit for Flextecs
Order K3059-5



Inverter Cart Mounting Bracket Kit
Use for mounting Flex Feed or Power Feed (to the K3059-4 inverter cart)
Order K4068-1



Flextec 350X Locking Foot Kit
Allows the Flextec to lock to the inverter cart, Multi-Process Switch, Cool Arc® 55 water cooler
Order K4424-1



12-pin to 6-pin Adapter
Allows 6-pin remote controls (K870, K963-3, K857, K4986-1) to be used with 12-pin Universal Connection
Order K2909-1

STICK OPTIONS



Remote Output Control with 12-pin Universal Connector
Permits remote adjustment of output
Order K857-2 (25 ft.)
Order K857-3 (100 ft.)

TIG OPTIONS



Foot Amptrol with 12-pin Amphenol Connector (25 ft)
Remote current control for TIG welding
Order K870-2

WIRE FEEDER OPTIONS



LN-25X CE
Includes CrossLinc communication technology and TVT
Order K4267-4



Activ8X CE
Compact, lightweight, portable feeder with CrossLinc Technology and TVT
Order K3519-2



Activ8X Pipe CE
Wire Feeder for GMAW and FCAW-G welding applications out on the pipeline
Order K5240-1



Flex Feed 74 HT
Four drive-roll, high-torque, industrial semiautomatic wire feeder for general/structural fabrication
See Publication E8.203



Flex Feed 84 Single Bench
Four drive roll feeder with heavy duty wire reel stand for general/structural fabrication
See Publication E8.205



Flex Feed 84 Dual Bench
Four drive roll feeder with heavy duty wire reel stand and contactor for general/structural fabrication
See Publication E8.206



Power Feed 84, Heavy Duty Wire Reel Stand, U/I, USB
Four drive roll, digital ArcLink semiautomatic industrial wire feeder built on a modular platform to be used in a variety of applications
See Publication E8.268

MACHINE SPECIFICATIONS

Product Number	Product Name	Input Power	Rated Output Current/Voltage/ Duty Cycle	Input Current @Rated Output	Output Range	Dimensions HxWxL (mm)	Weight (kg)
K5422-1	Flextec 350XP CE	380-400-415 3-Phase 50/60 Hz	350A/34V/60%	34/32/30	5-425A Max OCV 80V DC	432 x 330 x 609	38.1
			300A/32V/100%	31/26/25			

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LINCOLN® ELECTRIC

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