

Powerful and Flexible

HYPERFILL WELDING SOLUTION

LINCOLN[®]
ELECTRIC

HYPERFILL SOLUTION

HYPERFILL TWIN-WIRE FCAW WELDING SYSTEM



THE ULTIMATE HIGH-DEPOSITION SOLUTION[#]

The HyperFill[®] Flextec[®] System is a groundbreaking combination of our field-proven Flextec and DLF platforms with the revolutionary HyperFill twin-wire technology. This complete solution is engineered to maximise ease of use, weld productivity, and equipment reliability—all in one integrated package.

Productivity: High-deposition welding—faster, easier, and more efficient.

Weld Quality: Stable arc for precise control of large weld puddles.

Ease of Use: Simple interface with all controls accessible from the DLF wire feeder.

Durability: Rugged design ensures long-term reliability in demanding environments.

Processes

SMAW, GTAW, GMAW, GMAW-P*, FCAW, HyperFill FCAW, SAW, Arc Gouging
*GMAW-P available on 500X HF only

Applications

Fabrication Shops
Welding Production Facilities
Education and Training Facilities

Product Number

Flextec 500X HF HyperFill: K6008-1-HF
Flextec 650X HF HyperFill: K6009-1-HF

KEY FEATURES

Simple

- Streamlined operator panel minimizes setup time with easy process selection.
- Plug in to any 380-600V 3 phase power.

Reliable

- Built on industry proven design elements of other popular Lincoln Electric welders.
- Components designed to run cool for long life in high temperature environments.
- Fully encapsulated and environmentally protected electronics.
- Engineered for outdoor use and harsh environments (IP23 rated).

Flexible

- Compatible with across-the-arc, analog, digital or CrossLinc[™] feeders.

- Premium multi-process arc characteristics work with all DC wire, stick and TIG processes.
- Choice of models to fit any application and budget.
- Lightweight and portable.

CrossLinc[™] Technology

- Full functionality without control cables.
- Enables remote procedure setting at the feeder to improve weld quality.
- Increase arc time with fewer trips to the power source to adjust settings.
- Improves safety by reducing jobsite clutter.

TVT[™] True Voltage Technology

- Gives you the true voltage you set by adjusting the power source to compensate for any voltage drop during welding.

SPECIFICATIONS

[#]Not available in the US.

Machine	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D (mm)	Net Weight (kg)
Flextec 500X HF	K6008-1-HF	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/32/32 33/27/27	5-500A	477 x 356 x 699	62
Flextec 650X HF	K6009-1-HF	380-415/460/575/3/50/60	750A/44V/60% 650A/44V/100%	61/50/40 57/47/38	10-815A	554 x 410 x 770	83

Built for the Fab Shop.

Flextec industrial multi-process welders provide the ideal combination of simplicity, flexibility, and reliability to handle all of your fabrication needs.

- When using a Flextec with a DLF wire feeder, all controls are transferred to the wire feeder. Simple. Easy.
- Flexible, multi-process capabilities
- Reliable, rugged design with trayed and potted PC boards to withstand the harshest environments
- Smart Fans run only as needed to reduce energy usage
- Industry-Leading Warranty – 5 years of full coverage, including parts and labor, with a fast, streamlined claims process

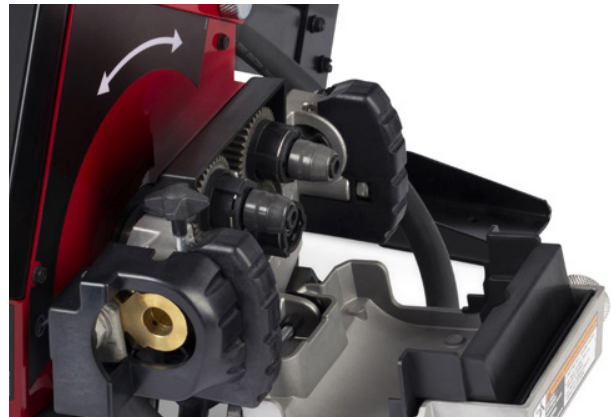


INDUSTRY LEADING
5-YEAR
STANDARD
WARRANTY

ENHANCED WIRE DRIVE SYSTEM

The field-proven feeder brings a robust four-roll drive system to the DLF lineup, delivering faster, more consistent wire feeding performance.

- Patented design for simple, tool-less setup
- Split wire guides provide full wire support and helps eliminate bird nesting
- Convenient, single drive-roll tension adjustment with visual scale
- Interchangeable brass gun connection for optimal arc stability

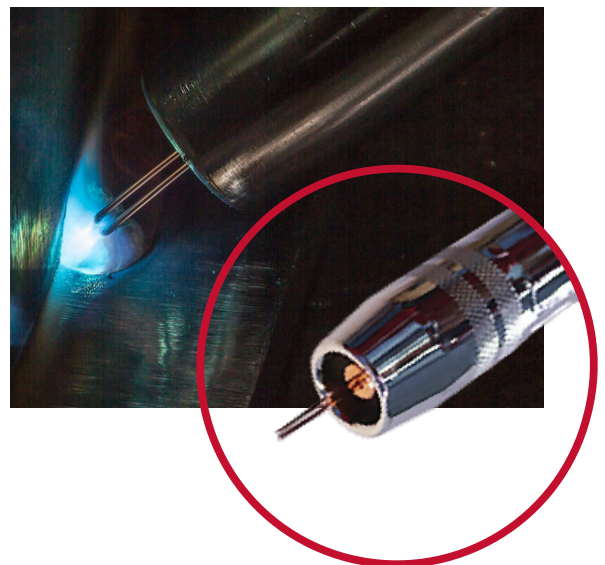


HYPERFILL TWIN-WIRE FCAW

HyperFill FCAW was developed to transform heavy fabrication productivity. This innovative twin-wire FCAW process redefines high-deposition, all-position welding – allowing for bigger welds, faster, easier.

- Higher Productivity – Deposition rates exceeding 13+ lbs/hr
- Superior Quality – Stable arc and smooth transfer for precise puddle control
- Easy Setup – One power source, one feeder, one contact tip
- Better Penetration – Optimized profile for stronger welds

Note: HyperFill Flextec power sources only support HyperFill FCAW welding processes. HyperFill GMAW is not supported at this time.



READY-TO-WELD PACKS



Please note: Accessory images are for illustration purposes only and may represent the range of product, designs may vary.



FLEXTEC 500X SHOWN

FLEXTEC 500X HF READY-TO-WELD PACK

	Part number	Description	Unit
FLEXTEC 500X HF [K6008-1-HF]			
1	K6008-1	Flextec 500X HF	1
2	K5287-1	DLF-84 single base model	1
3	K5991-1	DLF-84 HyperFill reel stand	1
4	K3059-4	Inverter and wire feeder cart	1
5	K3056-2	Locking foot kit (Flextec 500/500P/500X)	1
6	K10349-PG-15M	Interconnection cables, 15m – air cooled – Suits PF-46, PF84, PF25m – twistmate (Image A)	1
7	D-1319-010-1R	Screw right hand thread	1
8	R-2013-027-1R	Quickconnector nipple	1
9	K5384-2-10-047H	Magnum Pro curve HDE 450 .47h.-10, 15 Ft (Image B)	1
10	KP5367-2-HD	HD HyperFill A/C gas diffuser (Image C)	1
11	KP5368-045	HyperFill FCAW 1.2 mm SLOT Tip	1
12	KP5368-052	HyperFill FCAW 1.4 mm SLOT Tip	1
WELDING TORCH COMPONENTS			
13	KP44-332-15	Liner, 3/32, 15' gun [44-332-15] (Image D)	1
14	KP2743-1-62F	Nozzle 550, thread-on, flush 5/8 ID	1
15	KP4388-4	045 Drive roll kit, HyperFill, 2 roll	1
16	KP4482-047-HD	HD dual cam contact tip HyperFill® twin – 1.2mm PK10 (international)	1 PK
17	LE250-RG002	Lincoln flowmeter AR/Co2 – Dial (Image E)	1

FLEXTEC 650X HF READY-TO-WELD PACK

	Part number	Description	Unit
FLEXTEC 650X HF [K6009-1-HF]			
1	K6009-1	Flextec 650X HF	1
2	K5287-1	DLF-84 single base model	1
3	K5991-1	DLF-84 HyperFill reel stand	1
4	K3059-4	Inverter and wire feeder cart	1
5	K3056-2	Locking foot kit (Flextec 500/500P/500X)	1
6	K10349-PG-15M	Interconnection cables, 15m – air cooled – Suits PF-46, PF84, PF25m – twistmate (Image A)	1
7	D-1319-010-1R	Screw right hand thread	1
8	R-2013-027-1R	Quickconnector nipple	1
9	K5384-2-10-047H	Magnum Pro curve HDE 450 .47h.-10, 15 Ft (Image B)	1
10	KP5367-2-HD	HD HyperFill A/C gas diffuser (Image C)	1
11	KP5368-045	HyperFill FCAW 1.2 mm SLOT Tip	1
12	KP5368-052	HyperFill FCAW 1.4 mm SLOT Tip	1
WELDING TORCH COMPONENTS			
13	KP44-332-15	Liner, 3/32, 15' gun [44-332-15] (Image D)	1
14	KP2743-1-62F	Nozzle 550, thread-on, flush 5/8 ID	1
15	KP4388-4	045 Drive roll kit, HyperFill, 2 roll	1
16	KP4482-047-HD	HD dual cam contact tip HyperFill® twin – 1.2mm PK10 (international)	1 PK
17	LE250-RG002	Lincoln flowmeter AR/Co2 – Dial (Image E)	1

ACCESSORIES

Part Number	Description
Cables & Hoses	
K1842-35	Weld Power Cable, 35 ft
94006032	Gas Hose (100m)
K4483-50	ArcLink Cable, 50 ft (Image F)
K4483-100	ArcLink Cable, 100 ft
Undercarriage Components	
K631-1	Four Wheeled Wire Feeder Cart (Image A)
Welding Torches	
K466-10	Torch Connector Kit
K5383-2-10-047H	Magnum Pro Curve 350 HDE HyperFill Ready-Pak 15 ft
K4532-2	Magnum Pro Curve 350 HDE Standard Torch 15 ft
HyperFill Torch Components	
KP2743-1-62R	Recess Nozzle, 5/8 ID
KP2743-1-62S	Stick-Out Nozzle, 5/8 ID
KP2743-1-75R	Recess Nozzle, 3/4 ID (Image C)
KP2743-1-75F	Flush Nozzle, 3/4 ID
KP2743-1-75S	Stick-Out Nozzle, 3/4 ID
Optional Accessories	
K3340-1	Spool Cover (Image E)
K1555-1	Insulated Lift Bale (Image D)
K3341-1	Lift Bale
KP4388-4	HyperFill 2-Roll Drive Roll Kit (0.045/1.2 mm and 0.052/1.4 mm) Cored Wire (Image B)



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CUSTOMER ASSISTANCE POLICY

Lincoln Electric's business 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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice and to the extent permitted by law assumes no liability, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given. The provision of information or advice does not create, expand or alter this warranty. 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 this type of fabrication methods and service requirements. Subject to Change – This information is accurate to the best of our knowledge at the time of printing.

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