redrockweld
welder & positioner rentals

Jim Walker
Welding Rental Manager

+44 (0) 7498 986404
+44 (0) 141 812 0824

redrockautomation.com
Unit 7B Cartside Avenue, Inchinnan, Scotland, PA4 9RX

LINCOLN FLEXTEC 350

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

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

In the field, the Flextec 350X Construction 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 350X Standard model is built to work with all 42V feeders for your factory applications. It is also compatible with Arclink® digital feeders to provide synergic modes and memories for quick setup and seamless connectivity.

The Flextec 350X PowerConnect model adds the ability to weld with any input voltage between 200 and 600 volts and adds **basic pulsed MIG** output as a standard feature.

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

Applications »
Fabrication, Construction, Shipbuilding, Structural, Pipe

Output »

Input »

Product Number »
K4271-1 Flextec 350X Construction
K4272-1 Flextec 350X Standard
K4273-1 Flextec 350X Power Connect
K4283-1 Flextec 350X Construction
     CE model
K4284-1 Flextec 350X Standard
     CE model

*Pulse and single phase only available on K4273-1 PowerConnect model

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]

· PowerConnect technology automatically adjusts to the input voltage without the need for a manual reconnect[2]

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 (131° F)

· 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 [3]

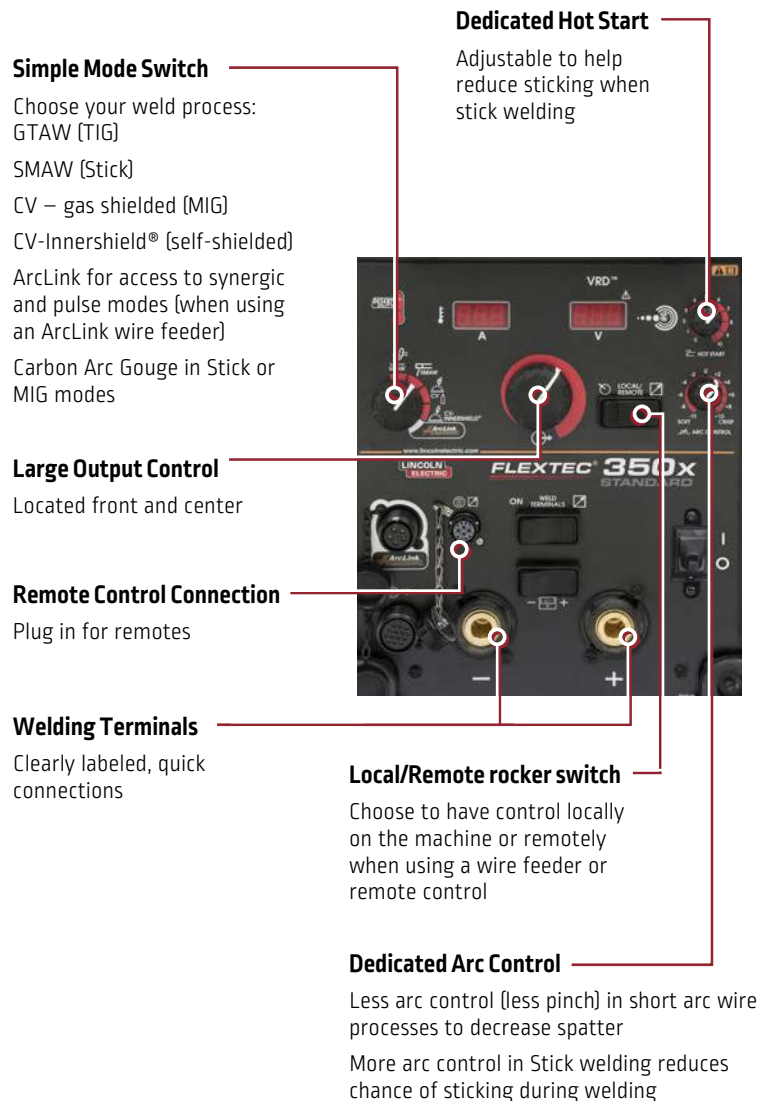· Touch-Start TIG® for reducing contamination during starts without high frequency

[1] Requires CrossLinc technology enabled wire feeder or CrossLinc remote.

[2] Requires K4273-1 PowerConnect model.

[3] Requires K4273-1 PowerConnect model and 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.

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

Trayed and potted PC boards for physical and environmental protection

Tough alloy handles for lifting and impact protection

Lightweight aluminum powder painted case for rust protection

Shock Absorbing Rubber Feet for impact protection

**Smart fans*** run at variable speeds to keep components cool

*Variable speed smart fans are included in the PowerConnect model only.

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
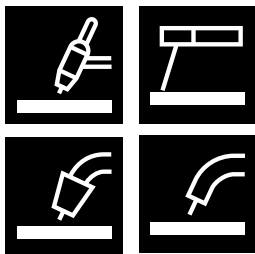
Any Input Voltage

200V
208V
220V
230V
380V
400V
415V
440V
460V
480V
575V
600V

POWERCONNECT TECHNOLOGY

The Flextec 350X PowerConnect model automatically connects to any input power from **200-600 volts single or three phase**. This allows the machine to be used anywhere in the world and to compensate for large fluctuations in incoming voltage.

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

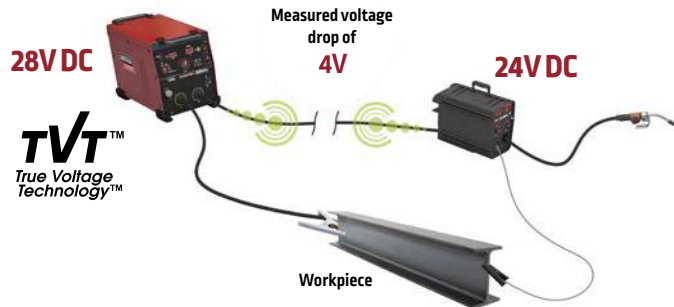· Minimize rework with easy settings adjustments

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

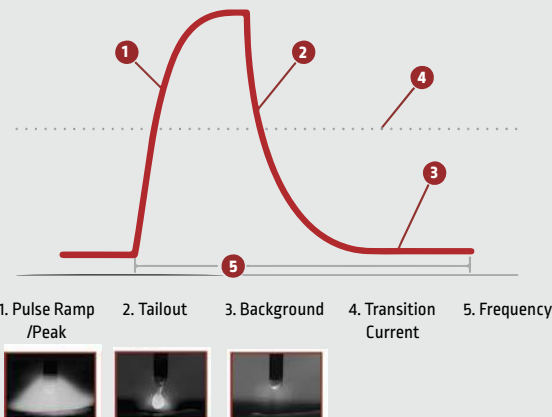3. The power source will change to the desired voltage
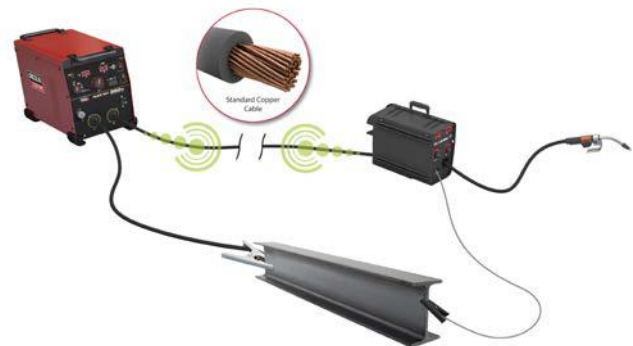
CrossLinc also features True Voltage Technology to compensate for voltage drop across the welding circuit.

· 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

Standard Copper Cable

Measured voltage drop of
28V DC **4V** **24V DC**

TVT™
True Voltage Technology™

Workpiece

PULSE

1. Pulse Ramp /Peak   2. Tailout   3. Background   4. Transition Current   5. Frequency

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

Field Setup

The Flextec 350X Construction was built to excel on site. When paired with a CrossLinc enabled accessory you can control the output right at the arc, without the need for extra cables.
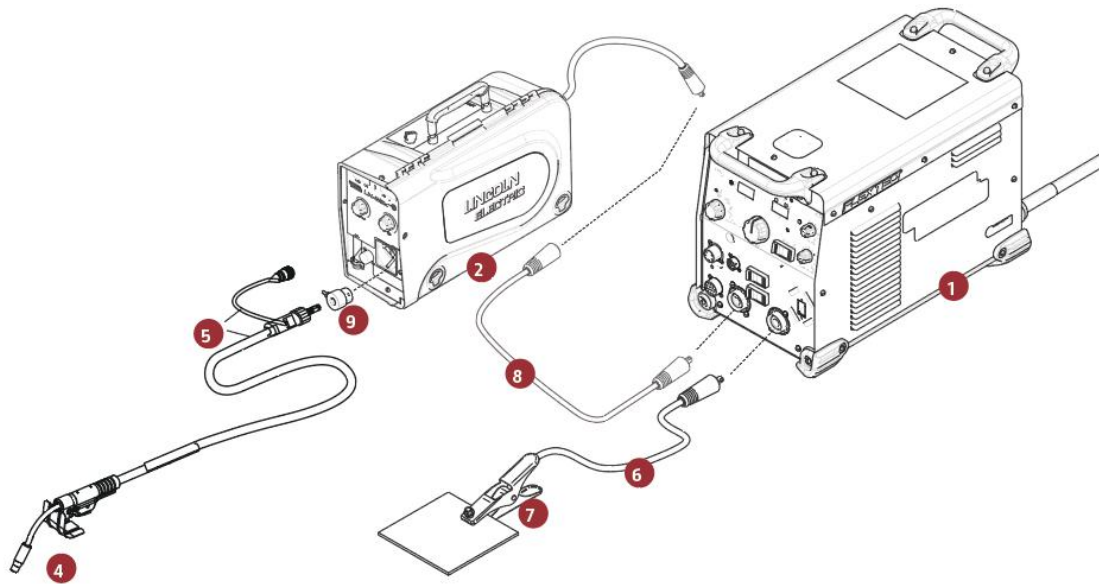
	ITEM	DESC.	K#
1	Machine	Flextec 350X Standard or Construction (8ft. power cord included)	K4272-1/K4271-1
2	Feeder	LN-25X	K4267-2
3	Control Cable	None	#N/A
4	Gun	K126 Pro, 15 ft, full assembly	K126-12
5	Gun Connector Kit	Tweco® #2 - #4 Gun back end for Magnum® PRO Guns	K466-10 (Included with Gun)
6	Work Cable	Tweco-Style male plug and 0.53 in. lug, 2/0, 350A, 60% duty cycle, 50 ft. (15.2 m)	K2484-2
7	Work Clamp	GC 500 Work Clamp	k910-2
8	Weld power Cable	Tweco-Style male plug and female receptacle, 2/0, 350A 60% duty cycle, 50 ft. (15.2 m)	K2485-2
9	Feeder Bushing	10-Series Tweco #2 - #4	K1500-2 (Included with Feeder)

FLEXTEC 350X
Construction Controls »

1. Amperage Display
2. Thermal LED
3. Output Control Dial
4. Weld Process Selector Switch
5. Remote Output Control
   (12-pin Universal Connector)
6. Positive and Negative Welding Output Studs
   (Tweco-style)
7. Voltage Display
8. VRD™ (Voltage Reduction Device)
   Indicator Lights
9. CrossLinc Indicator Light
10. Hot Start Control Dial
11. Arc Control Dial
12. Local/Remote Selector Toggle Switch
13. Power Switch

FLEXTEC 350X
Standard/PowerConnect Controls »

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
   (Tweco-style)
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

WHAT'S INCLUDED

	Description	Product Number	Flextec 350X PowerConnect Tweco (K4273-1)			Flextec 350X Standard Tweco (K4272-1)				Flextec 350X Construction Tweco (K4271-1)
Package Product No.	One-Pak® - shipped as single K#		**K4274-1**	**K4274-2**	**K4274-3**	**K3438-1**	**K3439-1**			**K4278-2**
	Ready-Pak - shipped fully assembled							**K4540-1**	**K4540-2**	
Wire Feeder Model	LF-72 HD	K2327-7				●		●		
	LF-74 HD	K2426-5	●							
	Flex Feed 84 HD	K5000-2		●			●		●	
	LN-25X Tweco no flowmeter	K4267-2								●
	Power Feed 84 HD, USB	K3328-13			●					
Drive Rolls	.035/.045 solid dual groove 2-roll	KP1696-1				●		●		
	.045 Cored 2-roll	KP1697-045C								●
	.035/.045 solid dual groove 4-roll	KP1505-1	●	●	●				●	
	.045 Solid 4-roll	KP1505-045S					●			
Accessories	Magnum Pro Curve 300 15ft	K2951-2-10-45	●	●	●	●	●	●	●	●
	Tweco Cable Package - 10ft work with ground clamp, 10ft elctrode	K1803-2	●	●	●	●	●	●	●	
	Harris Flowmeter Regulator and hose	3100211	●	●	●	●	●	●	●	
	Inverter Cart	K3059-4					●	●	●	

	Description	Product Number
Additional Flextec Models	Flexec 350X PowerConnect (Twistmate)	K3443-1
	Flextec 350X Standard CE (Twistmate)	K4284-1
	Flextec 350X Construction (Tweco)	K4271-1
	Flextec 350X Construction CE (Twistmate)	K4283-1

*All Flextec 350X models except the CCC Model (K3586-1) include 10-ft input cord

Flextec Racks

K3402-1 Flextec 350X Construction 4-pack Rack

K3403-2 Flextec 350X Standard 4-pack rack

K4277-1 Flextec 350X Construction 6-pack rack

K4281-1 Flextec 350X Standard 6-Pack Rack

GENERAL OPTIONS

Multi-Process Switch
Easily change welding process and polarity without changing cables at the machine
Order K3091-1

Flextec350X CE Filter Kit
(380-575 Vac)
Order K4420-1

Weld Cable Package
2, 10ft. 2/0 cables with Tweco plug and lug. Also includes GC500 work clamp
Order K1803-2

Harris® Model 355 Flowmeter Regulator and Hose
Includes 10 ft. (3.0 m) hose
Order: 3100211

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, K4217-1) to be used with 12-pin Universal Connection
Order K2909-1

LC-40
Tweco-Style Plug
(male, 1/0 Thru 2/0)
Order K3416-70

LC-40
Tweco-Style Receptacle
(female, 1/0 Thru 2/0)
Order K3417-70

LC-40HD
Tweco-Style Plug
(male, 3/0 Thru 4/0)
Order K3416-90

LC-40HD
Tweco-Style Receptacle
(female, 3/0 Thru 4/0)
Order K3417-90

STICK OPTIONS

CrossLinc Remote
Adjust voltage or current at the arc. For CrossLinc-equipped welders. See publication MC16-137
Order K4345-1

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

Wireless Foot Pedal with 6-pin Amphenol®
Permits remote adjustment of output[1]
Order K4217-1

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

Hand Amptrol Rotary Track Style, 12-pin Amphenol (25 ft)
Remote current control for TIG welding
Order K963-4

WIRE FEEDER OPTIONS

LN-25X
Includes CrossLinc communication technology and TVT
Order K4267-2

Activ8X
Compact, lightweight, portable feeder with CrossLinc Technology and TVT
Order K3519-1
(See Publication E8.107)

LF-72 Bench Model
Two drive roll feeder designed for MIG and cored wire welding in job shop and manufacturing environments
See Publication E8.11

LF-74 Bench Model
Four drive roll feeder designed for MIG and cored wire welding in job shop and manufacturing environments
See Publication E8.11

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

---

[1] Requires the K2909-1 12-pin to 6-pin adapter if used with Flextec 500X

FLEXTEC 350X - MODEL SELECTION

	Features	Flextec 350X PowerConnect	Flextec 350X Standard	Flextec 350X Construction
Input	Input Power	200-600V/1/3/50/60	380-600/3/50/60	380-600/3/50/60
	3-phase	•	•	•
	1-phase	•		
Feeders	CrossLinc compatible feeders	•	•	•
	14-pin Analog, 42V feeders	•	•	
	5-Pin Digital, 42V feeders	•	•	
Processes	GTAW Touch Start TIG	•	•	•
	SMAW (Stick)	•	•	•
	GMAW (MIG)	•	•	•
	FCAW (Flux cored)	•	•	•
	FCAW-G (Gas shielded Flux-cored)	•	•	•
	GMAW-P (Pulsed MIG)	•		
	Gouging (Recommended)	1/4"	1/4"	1/4"

MACHINE SPECIFICATIONS

Product Number	Product Name	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @Rated Output	Output Range	Dimensions HxWxL in (mm)	Weight lb (kg)
K4271-1	Flextec 350X Construction	380/460/575 3-Phase 50/60 Hz	350A/34V/60%	18/17/17	5-425A Max OCV 80V DC	17 x 13 x 23 (432 x 332 x 584)	77 (34.9)
K4272-1	Flextec 350X Standard		300A/32V/100%	23/20/21			82 (37.1)
K4273-1	Flextec 350X PowerConnect	200-208/220-230/380-415/460/575 3-Phase 50/60 Hz	350A/34V/60%	45/40/23/19/15		17 x 13 x 24 (432 x 330 x 609)	84 (38.1)
			300A/32V/100%	37/33/19/16/13			
		380-415/460/575 1-Phase 50/60 Hz	350A/34V/60%	39/32/26			
			300A/32V/100%	32/26/22			
		200-208/220-230 1-Phase 50/60 Hz	300A/32V/60%	62/56	5-350A Max OCV 67V DC		
			270A/31V/100%	54/48			