

FLEXTEC® 500X

Simple. Reliable. Flexible.



Powerful Performance From the Ground Up

Out in the shipyards, construction sites and fabrication shops, it pays to keep it simple. The Flextec 500X multi-process welder is easy to set up and operate, yet rugged enough to stand up to heavy-duty indoor and outdoor applications.

Basic pulse MIG capability is standard on the Flextec 500X, including weld modes for carbon steel, stainless steel, aluminum and metalcore electrodes.

The Flextec 500X welder is also equipped with CrossLinc® technology giving you the flexibility to control the machine from hundreds of feet away without a control cable.

Processes

SMAW, GTAW, GMAW,
GMAW-P, FCAW, Arc Gouging

Applications

Fabrication, Shipbuilding,
Construction

Input



Output



Product Number

K3607-2

Features

Simple

- Simple interface for ease of use.
- CrossLinc technology eliminates extra cables for simple system setup.¹

Reliable

- IP 23 rating means the Flextec 500X welder will excel in outdoor environments, such as construction sites and shipyards.
- Flextec 500X welder is Desert Duty[®] rated for operation in the harshest environments (up to 55C).
- Durable trayed and potted PC boards for electronics environmental protection

Flexible

- Multi-process power source for all your welding needs.
- Compatible with all 42VAC wire feeders for MIG and Flux-Cored welding
- Arclink[®] enabled power source provides synergic pulse modes.²
- CrossLinc allows for remote control of CV and CC processes without extra cables.³
- Optimized stick welding for both cellulosic and low hydrogen electrodes.
- Touch-start Tig for easy, contamination free starts without high frequency.

Crosslinc technology compatibility

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

(1) Only with CrossLinc enabled

(2) Requires Power Feed[®] wire feeder.

(3) Requires CrossLinc technology enabled wire feeder, or CrossLinc remote.

FLEXIBILITY

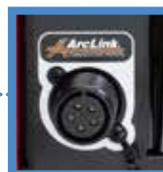
Flextec power sources support multiple weld processes: MIG, TIG, Stick, Gouging and FCAW. Flextec welders can be used with nearly all Lincoln Electric wire feeders due to available feeder communication connections.



CrossLinc technology

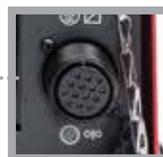
(LN-25X, Activ8X, CrossLinc Remote)

CrossLinc technology communicates through a standard weld cable to enable voltage or current control at the arc without a control cable.



5-pin Control Cable Connection (Lincoln Electric Power Feed wire feeder models)

5-pin high-speed digital communication enables advanced process capability and additional operator controls. Allows compatibility with future wire feeder models.



14-pin (Lincoln Electric LF, LN and Flex Feed[®] models)

14-pin analog communication enables compatibility with most existing Lincoln wire feeders.



Across-the-arc Connection

Across-the-arc feeders connect to the power source using the weld cables. This basic configuration does not use a control cable or CrossLinc Technology, so voltage control is only accessed at the welding power source.



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

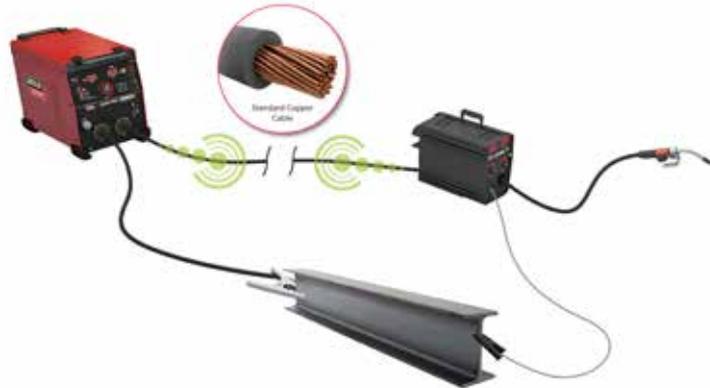
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

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.



FLEXTEC 500X Controls

1. Amperage Display Meter
2. Thermal LED
3. Output Control Dial
4. Hot Start Control Dial
5. Weld Process Selector Switch
6. Local/Remote Output Selector Toggle Switch
7. Circuit Breaker Reset Button for the 5-pin Wire Feeder Connector
8. 5-pin ArcLink Wire Feeder Connector
9. Positive and Negative 1/2 in. (12.7 mm) Welding Output Studs
10. VRD® (Voltage Reduction Device) Indicator Lights
11. CrossLinc indicator light
12. Voltage Display Meter
13. Power Switch
14. Arc Force Control Dial
15. Weld Terminals On/Remote Selector Switch
16. Circuit Breaker Reset Button for the 14-pin Wire Feeder Connector
17. Remote Output Control (12-pin Universal Connector)
18. 14-pin Wire Feeder Connector
19. Wire Feeder Voltmeter Polarity Selection Switch
20. Input Power Cord Strain Relief
21. Input Power Terminal Block
22. Input Fuse
23. Input Power Reconnect
24. Cooling Fan





**Weld Power Cable
Twist Mate to Twist Mate**

K14166-1 (70MM2-10M)
K14166-2 (70MM2-15M)
K14166-3 (70MM2-5M)
K14166-4 (70MM2-30M)
K14167-1 (95MM2-30M)
K14167-2 (95MM2-5M)
K14167-3 (95MM2-10M)
K14167-4 (95MM2-15M)



GRD-400A-70-xM*
Ground cable 400A 70 mm²; x=5/10/15 m



E/H-400A-70-xM*
Electrode holder 400A/70mm²; x=5/10m



K2909-1
12-pin to 6-pin Adapter



K857-2
12-pin Remote Output Control



K3059-4
Inverter and Wire Feeder Cart



K4424-1
Flextec 350x Locking Foot Kit



K4068-1
Inverter Cart Mounting Kit
(required to secure Power Feed®
and Flex Feed™ feeders on the cart)



K10095-1-15M
Remote control (6PIN, 15m)



K10398
Extension cable for remote control box K10095-1-15M



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



K10376
Adapter M14/Dinse (F)

MACHINE SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	H x W x D in (mm)	Net Weight lb (kg)
FLEXTEC 500X	K3607-2	380/460/575/3/50/60	500A/40V/60% 450A/38V/100%	39/31/31 33/27/27	5-500A	18.8 x 14 x 26.5 [477 x 356 x 673]	120 [54]

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