

FLEX FEED[®] 84 AND FLEX FEED 84 DUAL

An industrial wire feeder for high-productivity, heavy fab applications

Rugged and reliable engineering

- Consistent feeding over long conduit runs
- Handles large-diameter wires (up to 3/32 in. [2.4 mm] solid or .120 in. [3.2 mm] cored wire), well beyond the competition's 5/64-in. capacity
- Gun adapters provide superior electrical connections reducing voltage drops and simplifying connections
- Wire drive circuit board is encapsulated for maximum protection from the elements

Superior process control

- Digital preset for voltage and wire feed speed
- Save repeated procedures in up to four user memories
- Process limits can be set and passcode secured
- Displays actual voltage and current while welding

Safety with every process

- Single model feeders can be ordered with an electrically isolated stud for arc gouging operations
- Dual model can be ordered with a Power Path™ contactor that electrically isolates the non-active wire drive and gun
- User selectable wire retract function physically retracts the wire back into the nozzle to prevent operator injury

Advanced MaxTrac[®] wire drive design

- Rugged cast aluminum feed plate protects wire and ensures consistent wire feeding
- Patented tool-less drive rolls make adjustments and maintenance quick and easy
- Patented tool-less split wire guides ensure uninterrupted feed and prevents birdnesting

Modular design provides flexibility of configurations

- Configure for single, dual, bench or boom setups (convert as workspace needs change)
- Two available wire reel stands; standard (up to 44-lb. spools) or heavy duty (up to 60-lb. coils or spools)
- Built-in interface for hard automation



Processes

GMAW, FCAW, SAW, CAG (Carbon Arc Gouging – available with gouging option installed)

Output



Input



Applications

- Heavy Equipment
- Structural
- Construction
- General Fabrication

Key Accessories

- Drive Roll Kits
 - KP1505-xxxx Solid and/or Cored Wires
 - KP1507-xxxx Aluminum Wires
- Gun Adapter Kits
- K1797-xx Control Cable

Product Highlights

- Displays preset voltage at the feeder
- Records actual arc on time
- Timers for run-in, start, crater, preflow, postflow and burnback

FLEX FEED 84 SPECIFICATIONS

Product Name	Product Number	User Interface	Heavy Duty Wire Reel Stand	Gun Adapter Standard #2-#4	Control Cable	Inlet Bushing	Gouge Stud	Contactors	Input Power	Output Capacity Amps/Duty Cycle	Wire Feed Speed Range	Wire Size Range in (mm)	Dimensions ⁽¹⁾ H x W x D in (mm)	Net Weight lb (kg)
Single Wire Drive														
Flex Feed 84 Single Bench	K5000-2	•	•	•	K1797-10	K1551-2			24-42 VAC 50/60 Hz 10 amps	Wire Drive: 600A/60%	Standard Speed / Installed 20 Tooth Pinion Gear: 35 – 500 in/min (0.9 – 12.7 m/min)	Solid 0.025 – 3/32 (0.6 – 2.4) Cored 0.035 - 0.120 (0.9 – 3.0)	16.5 x 15.5 x 28 (419 x 394 x 711)	56 (25.4)
	K5000-3	•		•	K1797-10	K3929-1	•	•		Wire Drive w/ Contactors 500A/60%				44 (20.0)
Flex Feed 84 Single Boom	K5000-1			•		K3929-1			24-42 VAC 50/60 Hz 10 amps	Gouging Stud: 600A/30%	50-750 IPM can be achieved by installing the 30 tooth pinion gear			36 (16.3)
Flex Feed 84 Single Boom One-Pak [®]	K5000-11	•		•	K1797-25	K3929-1				-				
Dual Wire Drive														
Flex Feed 84 Dual Bench	K5002-2	•	•	•	K1797-10	K1551-2		•	24-42 VAC 50/60 Hz 10 amps	Wire Drive: 600A/60%	Standard Speed / Installed 20 Tooth Pinion Gear: 35 – 500 in/min (0.9 – 12.7 m/min)	Solid 0.025 – 3/32 (0.6 – 2.4) Cored 0.035 - 0.120 (0.9 – 3.0)	16.5 x 22.5 x 30.6 (419 x 572 x 777)	101 (45.8)
	K5002-5	•	•	•	K1797-10	K1551-2				Wire Drive w/ Contactors 500A/60%				97 (44.0)
Flex Feed 84 Dual Boom	K5002-1			•		K3929-1			24-42 VAC 50/60 Hz 10 amps	Gouging Stud: 600A/30%	50-750 IPM can be achieved by installing the 30 tooth pinion gear			64 (29.0)
Flex Feed 84 Dual Boom One-Pak [®]	K5002-11	•		•	K1797-25	K3929-1								-
Boom Control Box Only														
Control Box with User Interface	K5004-1	•											11.1 x 8.7 x 3.6 (282 x 221 x 91)	7 (3.2)

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company 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 information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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 these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

