

FLEXTEC® 650X

Multi-Process Power Source for Heavy Duty Applications

Simple

- Use with a wide range of available 3 phase input power
- Easy one-knob process selection
- Fast arc response means smooth arc action and consistent bead appearance
- User weld schedule memory storage allows easy recall of your critical or often repeated weld procedures with applicable feeders⁽¹⁾
- Synergic one knob control over wire feed speed and voltage with applicable feeders⁽²⁾

Reliable

- Components designed to run cool for long life in high temperature environments
- Engineered for outdoor use and harsh environments (IP23 rated)
- Desert Duty® Rated for extreme temperatures up to 55°C

Flexible

- Ideal for large diameter wire or stick welding on thick materials
- Compatible with most Lincoln Electric® feeders, including common bench and boom models, portable across-the-arc models and CrossLinc® or ArcLink®-equipped models
- Premium arc characteristics on all DC wire, stick and TIG processes

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) User weld schedule memory settings available only with Power Feed® and Flex Feed® 84 wire feeders

(2) Synergic control available only with Power Feed wire feeders



Shown
K3425-1

Processes

Stick, TIG, MIG, Flux-Cored, Submerged Arc, Gouging

Output



Input



Applications

- General Fabrication
- Structural
- Power Generation
- Shipbuilding
- Offshore
- Pipeline
- Heavy Fabrication

Product Highlights

- Substantial gouging capability with up to a 1/2 in. (12.7 mm) carbon
- Variable Hot Start and Arc Control adjust for thick, rusty or dirty material, puddle fluidity, bead appearance
- Offered in production-focused Ready-Pak® and One-Pak® packages

Key Accessories

- [K4267-1] LN-25X Portable Wire Feeder
- [K5000-2] Flex Feed® 84 Single Bench Heavy Duty Wire Feeder
- [K2952-2-10-45] Magnum® PRO Curve™ 400 Gun and Cable Ready-Pak®
- [K3059-4] Inverter and Wire Feeder Cart
- [K4345-1] CrossLinc® Remote
- [K3091-1] Multi-Process Switch
- [K3510-1] Flextec 650X 4-Pack Rack

FLEXTEC® 650X - SPECIFICATIONS

Description	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Dimensions H x W x L in (mm)	Weight lb (kg)
Flextec® 650X	K3425-1	380/460/575/3/50/60	750A/44V/60%	61/50/40	10-815A	21.8 x 16.1 x 29.3 (554 x 410 x 745)	165 (74.8)
			650A/44V/100%	57/47/38			

Recommended Wire Feeders

- LN-25X, Activ8® LN-25 PRO
- LF-72, LF-74
- Flex Feed® 74HT, Flex Feed® 84
- Power Feed® 84, Power Feed® 25M
- MAXsa® 10⁽¹⁾ and 19
- LT-7

(1) MAXsa 10 K2814-4 or newer.

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