

Activ8X™ with CrossLinc® Technology

Rugged. Compact. Connected.



PORTABLE, SEMIAUTOMATIC WIRE FEEDER

Activate your shipbuilding, offshore, or construction operations with the Activ8X portable wire feeder with CrossLinc Technology. Small enough to fit through manways and light enough to carry around the site, the Activ8X wire feeder also allows remote control of the power source without the need for control cables via CrossLinc Technology. This includes True Voltage Technology™ (TVT™) which ensures you get the voltage you set at the arc, even when you are hundreds of feet away from the power source.

Processes

MIG, Flux-Cored

Applications

Construction
Shipyards

Input



Output



Product Number

K3519-2 Activ8X CE (Dinse)

RUGGED.

- Impact resistant, flame retardant case provides rugged durability for tough conditions.
- Potted PC Boards for moisture and corrosion protection.
- Maxtrac® Wire Drive System – Heavy-duty cast aluminum wire drive system provides reliable feeding and durability.
- Tachometer feedback ensures accurate wire feed speed.

COMPACT.

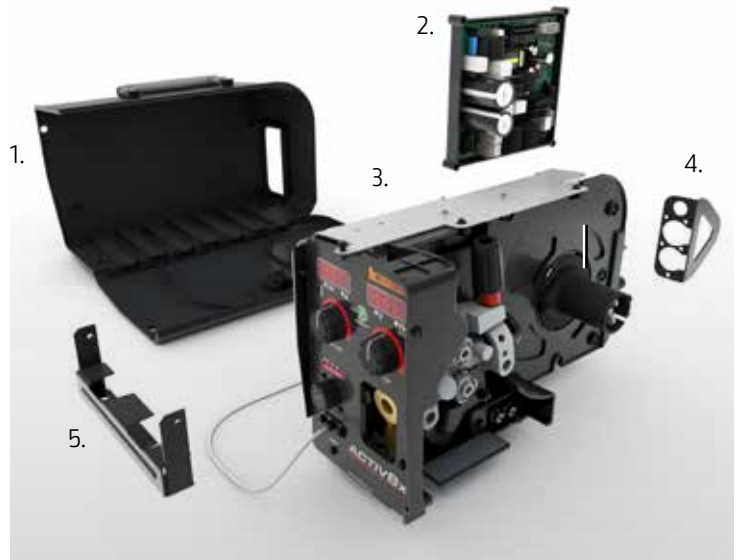
- Lightest construction feeder on the market today.
- Accepts up to 8 in. (203 mm) diameter wire spools.

CONNECTED.

- CrossLinc Technology allows for remote output control over the welding leads. No control cable needed!
- True Voltage Technology™ (TVT™) automatically compensates for voltage drops across long welding cables.

FIELD ARMOR

We understand that when you're on the job anything can happen at any time, and the last thing you want to do is worry about your equipment getting damaged. That's why we designed Field Armor™, protective advancements to your machine's body keeping knobs, cables, and internal mechanisms out of harm's way.



1. Impact resistant, flame retardant case.
2. Potted PC board to protect from the elements.
3. Internal, marine grade aluminum skeleton for superior corrosion and impact resistance.
4. Lift bale for easy lowering through manways and protects gas fittings from incidental contact.
5. Control shield protects control knobs from external damage.

RECOMMENDED POWER SOURCES

Look for the X

The Activ8X wire feeder will work with any CV or CC power source as a simple, across-the-arc feeder. However, when paired together with a CrossLinc Technology compatible power source, communication will be established, and welding output is controlled from the feeder without control cables. CrossLinc Technology compatible feeders and power sources carry an X in their name, i.e. "Activ8X", "Flextec® 350X", etc.



Use CrossLinc Technology to control voltage hundreds of feet away using a standard weld cable with the Activ8X.





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

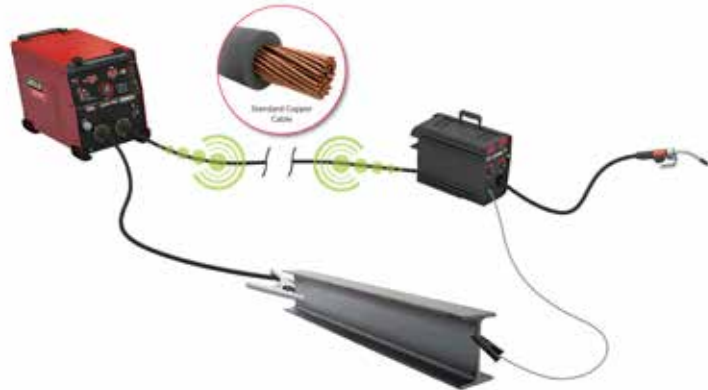
- Full output control at the arc results in the correct settings for every weld.
- True Voltage Technology (TVT) accurately compensates for voltage drop across long cable runs.
- Eliminate unintentional machine adjustments by helpers or other operators.

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.

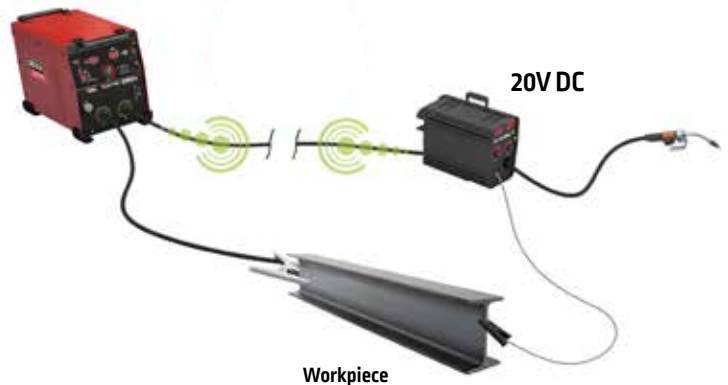


TRUE VOLTAGE TECHNOLOGY (TVT)



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.

24V DC

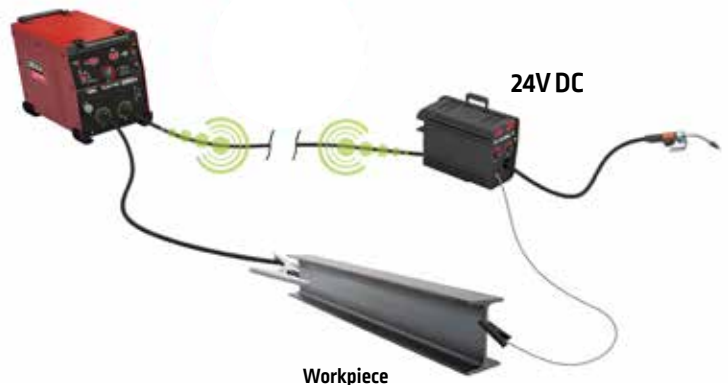


20V DC

Workpiece

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.

28V DC



24V DC

Workpiece

WIRE DRIVE

1. Spool Retainer
2. Spindle Brake
3. MAXTRAC® Drive System
4. 2-Step/trigger Interlock Switch
5. Cold Feed / Gas Purge Switch



CONTROLS

- Hidden Setup Menu
- Voltage Display
- Wire Feed Speed / Amperage Display
- Wire Feed Speed Knob
- Remote Voltage Control Knob



INCOMING CONNECTIONS

- Shielding Gas Inlet with Gas Filter
- Electrode Lead w/ Twist Mate / Dinse style connector





MAXTRAC[®]

Wire Drive System

Patented Dual Spring Pressure Arm

- Easy turn numeric tension indicator
- Set heavy tension for solid steel and stainless steel wire
- Set moderate tension for cored wires
- Set soft tension for aluminum wire
- Wide idler arm hinge delivers improved drive roll clamping pressure

Rigid Cast Aluminum Frame

- Enhances precise drive roll alignment



Twist-Lock Drive Roll Hubs

- Two gear driven rolls
- Fast, tool-less changeovers

Patented Split Wire Guides

- Full support for wire throughout the drive path
- Removable outer wire guide for easy access
- No tools required
- No birdnesting

Brass to Brass Interchangeable Gun Bushings

- More reliable electrical conductivity – no oxide build-up
- More efficient energy transfer – lower voltage drops
- Easily adapt any number of Lincoln Magnum[®], Magnum[®] PRO or competitive guns

Patented Drive Rolls

- For steel - new design delivers 20% more feeding force
- For aluminum - chrome plated to resist build-up

Separate Drive Gear

- Reduces pressure on motor for extended service life

REQUIRED ACCESSORIES

FEED PLATE GUN ADAPTERS

K1500-1	K1500-2 ⁽¹⁾	K1500-3	K1500-4	K1500-5	K489-7
<u>Lincoln Style</u>	<u>Tweco® #2 - #4</u>	<u>Tweco #5</u>	<u>Miller® Guns</u>	<u>OXO® Guns</u>	<u>Fast-Mate™ / Euro Connector</u>
Compatible gun connector kits: K466-1 K613-1 K613-6 K466-8	Compatible gun connector kits: K466-10 K466-2 K466-6	Compatible gun connector kits: K613-7 K613-2	Compatible gun connector kits: K466-3 K613-3		Compatible with weld guns with Fast-Mate™ or Euro connectors
					

⁽¹⁾ Installed in machine.

MAXTRAC DRIVE ROLL & WIRE GUIDE KITS

Description	Product No.
Steel Wire Sizes (includes stainless steel):	
.023-.030 in (0.6-0.8 mm)	KP1696-030S
.035 in (0.9 mm)	KP1696-035S
.045 in (1.2 mm)	KP1696-045S
.052 in (1.4 mm)	KP1696-052S
.035, .045 in (0.9, 1.2 mm)	KP1696-1
.040 in (1.0 mm)	KP1696-2
1/16 in (1.6 mm)	KP1696-1/16S
Cored Wire Sizes:	
.030-.035 in (0.8-0.9 mm)	KP1697-035C
.040-.045 in (1.0-1.2 mm)	KP1697-045C
.052 in (1.4 mm)	KP1697-052C
1/16 in (1.6 mm)	KP1697-1/16C
Steel or Cored Wire Sizes:	
.068-.072 in (1.8 mm)	KP1697-068
5/64 in (2.0 mm)	KP1697-5/64
3/32 in (2.4 mm)	KP1697-3/32
Aluminum Wire Sizes:	
.035 in (0.9 mm)	KP1695-035A
.040 in (1.0 mm)	KP1695-040A
3/64 in (1.2 mm)	KP1695-3/64A
1/16 in (1.6 mm)	KP1695-1/16A

WELD POWER CABLES

Index	Description
K14166-1	Weld Power Cable, TM-TM, 70MM2-10M
K14166-2	Weld Power Cable, TM-TM, 70MM2-15M
K14166-3	Weld Power Cable, TM-TM, 70MM2-5M
K14166-4	Weld Power Cable, TM-TM, 70MM2-30M
K14167-1	Weld Power Cable, TM-TM, 95MM2-30M
K14167-2	Weld Power Cable, TM-TM, 95MM2-5M
K14167-3	Weld Power Cable, TM-TM, 95MM2-10M
K14167-4	Weld Power Cable, TM-TM, 95MM2-15M



K489-7
Fast-Mate EURO Adapter



**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)



**LGS2 MIG/MAG TORCHES
W10429-36-xM**
(x = 3; 4; 5 length in m)



K126-11 (15ft 062-332)
K126-12 (15ft 1/16-5/64)
K126™ PRO Innershield® 350A



Steel Wire Drive Roll Kits
Includes: 2 V groove drive rolls and inner wire guide
KP1696-030S .023-.030 (0.6-0.8MM)
KP1696-035S .035 (0.9MM)
KP1696-045S .045 (1.2MM)
KP1696-052S .052 (1.4MM)
KP1696-1/16S 1/16 (1.6MM)
KP1696-1 .035-.045 (0.9, 1.2MM)
KP1696-2 .040 (1.0MM)



Cored Wire Drive Roll Kits
Includes: 2 knurled drive rolls and inner wire guide
KP1697-035C .030-.035" (0.8-0.9MM)
KP1697-045C .040-.045" (1.0-1.2MM)
KP1697-052C .052" (1.4MM)
KP1697-1/16C 1/16" (1.6MM)
KP1697-068 .068-.072" (1.7-1.8MM)
KP1697-5/64 5/64" (2.0MM)
KP1697-3/32 3/32" (2.4MM)



Aluminum Wire Drive Roll Kits
Includes: 2 polished U groove drive rolls, outer wire guide and inner wire guide
KP1695-035A .035" (0.9 MM)
KP1695-040A .040" (1.0MM)
KP1695-3/64A 3/64" (1.2MM)
KP1695-1/16A 1/16" (1.6MM)



R-2013-027-1R & D-1319-010-1R
KIT Quick Gas Connector

PRODUCT SPECIFICATIONS

Product Name	Product Number	Input Power	Rated Output Current/Voltage/Duty Cycle	Wire Feed Speed Range ipm (m/min.)	Wire Size Range inches (mm)		H x W x D inches (mm)	Net Weight lbs. (kg)
					GMAW	FCAW		
Activ8X CE (Dinse)	K3519-2	15-110 VDC	330A/60%	50-700ipm (1.3-17.8)	.023-.052 (0.6-1.3)	.035-5/64 (0.9-2.0)	11.8 x 7.6 x 19.8 (298 x 193 x 503)	27 (12.2)

CUSTOMER ASSISTANCE POLICY

The business of 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.

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