

Activ8™

Processes

GMAW, FCAW

Product Number

K2999-1 Activ8™

K3289-1 Activ8™ One-Pak®

See back for complete specs

Input Power

15-110 VDC

Rated Output Current/Duty Cycle

330A/60%

Wire Feed Speed

50 – 800 ipm (1.3 – 20.3 m/min)

Wire Size Range

GMAW: .023 – .052 in. (0.6 – 1.3 mm)

FCAW: .035 – 5/64 in. (0.9 – 2.0 mm)

Weight/Dimensions (H x W x D)

27 lbs. (12.2 kg)

11.8 x 7.6 x 19.8 in.
(298 x 193 x 503 mm)

Portable, Semiautomatic Wire Feeder

Activate your shipbuilding, offshore, construction or pipe welding operations with the Activ8™ portable wire feeder. Small enough to fit through ship manways and light enough to carry around the site, the Activ8™ is designed for tough welding environments with limited access. Compatible with compact 8 in. (203 mm) wire spools, the Activ8™ can be used with any DC CV or CC power source.

FEATURES

- ▶ **Breakthrough Size and Weight** – Smallest and lightest construction wire feeder on the market today.
- ▶ **Simple Controls** – Wire feed speed knob on the front; booted Cold Feed/ Gas Purge, Trigger Interlock and CV/CC switches inside.
- ▶ **Across-The-Arc Operation (Voltage Sensing)** – Uses a sense lead and a contactor for enabling welding current
- ▶ **Tough Plastic Case** – Molded from a high impact, flame retardant material for high durability and low weight.
- ▶ **MAXTRAC® Wire Drive System** –
 - Dual gear-driven drive system ensures positive feeding performance.
 - Patented wire drive features include tool-less drive roll and wire guide changes for quick spool replacement.
 - A tachometer controlled motor powers the patented drive rolls for smooth, steady feeding without wire slippage.

APPLICATIONS

- ▶ Shipbuilding
- ▶ Construction
- ▶ Pipeline



WHAT'S INCLUDED

K2999-1 Activ8™

- ▶ Internal Contactor
- ▶ Gas Solenoid
- ▶ Arc Sensing Lead & Clip, 15 ft. (4.5 m)
- ▶ Gun Bushing (K1500-2)

K3289-1 Activ8™ One-Pak®

- ▶ Includes everything in K2999-1
- ▶ Magnum® PRO Curve™ 300 Gun 15 ft. (4.5 m) with 1/16 in. (1.6 mm) liner and K466-10 gun connector kit (K2951-2-10-116)

INPUT



OUTPUT



RECOMMENDED POWER SOURCES

- | | |
|----------------------|------------------------|
| ▶ Idealarc® CV-305 | ▶ Ranger® 225 |
| ▶ Idealarc® CV-400 | ▶ Ranger® 250 GXT |
| ▶ Idealarc® CV-655 | ▶ Ranger® 305G, D, LPG |
| ▶ Idealarc® DC-400 | ▶ SAE-300® |
| ▶ Idealarc® DC-600 | ▶ SAE-500® |
| ▶ Idealarc® DC-655 | ▶ Pipeliner® 200D |
| ▶ Invertec® V350-PRO | ▶ Classic® 300D |
| ▶ Flextec™ 450, 650 | ▶ Vantage® 300 |
| ▶ Multi-Weld™ 350 | ▶ Vantage® 400 |
| | ▶ Vantage® 500 |

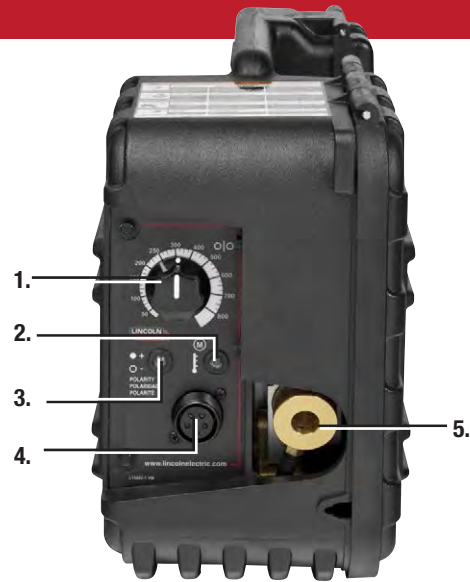


Two Year Extended
Warranty Available in
the U.S.A. and Canada.



FRONT CONTROL PANEL

- 1. Wire Feed Speed Control Knob
- 2. Thermal LED
- 3. Polarity LED
- 4. 5-pin Trigger Connection
- 5. Gun Connection

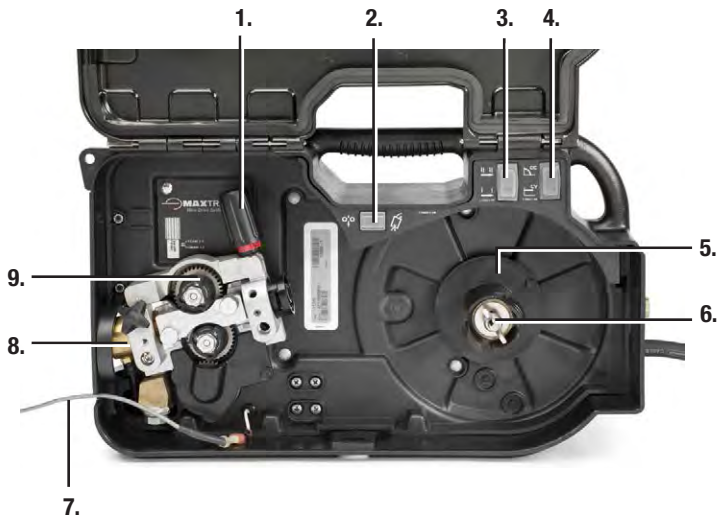


REAR CONNECTIONS

- 1. Shielding Gas Inlet with Gas Filter
- 2. Electrode Lead



DRIVE SYSTEM



- 1. Dual Spring Tension Arm (Wire Tension Adjustment)
- 2. Cold Feed / Gas Purge Switch
- 3. 2-Step / Trigger Interlock Switch
- 4. CV / CC Switch
- 5. Spool Retainer
- 6. Spindle Brake
- 7. Work Sense Lead
- 8. Gun Bushing Assembly
- 9. MAXTRAC® Drive System





- One modular design
- The case can be removed in under two minutes – only eight screws
- Flame retardant material
- Withstands repeated drop testing

WELD POWER CABLES

| Description | Order Number |
|------------------------------------|--------------|
| Twist Mate™ to Lug: | |
| 1/0, 350A, 60% duty cycle, 10 ft. | K1840-10 |
| Twist Mate™ to Twist Mate™: | |
| 1/0, 350A, 60% duty cycle, 25 ft. | K1841-25 |
| 2/0, 350A, 60% duty cycle, 50 ft. | K1841-50 |
| Lug to Lug: | |
| 3/0, 600A, 60% duty cycle, 10 ft. | K1842-10 |
| 3/0, 600A, 60% duty cycle, 35 ft. | K1842-35 |
| 3/0, 600A, 60% duty cycle, 60 ft. | K1842-60 |
| 4/0, 600A, 60% duty cycle, 110 ft. | K1842-110 |



Shown: K1841

DRIVE ROLL & WIRE GUIDE KITS

| Description | Order Number |
|---|--------------|
| Steel Wire Sizes (includes stainless steel): | |
| .023-.030 in. (0.6-0.8 mm) | KP1696-030S |
| .035 in. (0.9 mm) | KP1696-035S |
| .040 in. (1.0 mm) | KP1696-2 |
| .045 in. (1.2 mm) | KP1696-045S |
| .052 in. (1.4 mm) | KP1696-052S |
| 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 |
| Solid Steel or Cored Wire Sizes: | |
| .068-.072 in. (1.7 mm - 1.9 mm) | KP1697-068 |
| 5/64 in. (2.0 mm) | KP1697-5/64 |



Shown: KP1696

FEED PLATE GUN ADAPTERS

| K1500-1 | K1500-2 | K1500-3 | K1500-4 | K1500-5 | Magnum® PRO Fast-Mate™ |
|---|--|--|---|-----------|---|
| Lincoln Electric Compatible gun connector kits K466-1 K613-1 K613-6 K466-8 | Tweco® #2 - #4 Compatible gun connector kits K466-10 K466-2 K466-6 | Tweco #5 Compatible gun connector kit K613-7 K613-2 | Miller® guns Compatible gun connector kits K466-3 K613-3 | OXO® guns | Compatible gun connector kits K489-1 K489-2 K489-7 K489-8 |
| | | | | | |

Tweco® is a registered trademark of Victor Technologies.
Miller® is a registered trademark of Miller Electric Mfg. Co.
Oxo® is a registered trademark of Miller Electric Mfg. Co.

RECOMMENDED ACCESSORIES



Plastic Case
A complete replacement plastic case.
Order K3061-1



Jumper Plug Kit
Required to close the contactor in the power source when the power source is used with a remote output contactor.
Order K484



Incoming Bushing
Connect directly to wire conduit (not included), for use in boom systems, large payoff packages or long distances.
Order K1546-2



Work and Wire Feeder 2/0 Weld Cable Package
Includes Twist Mate™ connectors, work clamps, 15 ft. (4.5 m) work cable and 10 ft. (3.0 m) electrode cable. Rated 350 amps, 60% duty cycle.
Order K1803-1



Work Clamp
Jaws open full 2-1/2 in. (63 mm). Welding cable lug bolts directly to the work clamp. 60% duty cycle
Order K910-1 300 Amp
Order K910-2 500 Amp



Flow Meter Kit
Used to display and control the flow rate of shielding gas to the gun. Includes a valve for flow control. Scaled for CO₂, Argon and Ar/CO₂ blends.
Order K3156-1



Twist Mate™ Cable Plug
For connecting welding cable to output terminal receptacles. For 2/0-3/0 (70-95 mm²) cable.
Order K852-95



Deluxe Adjustable Gas Regulator & Hose Kit
Accommodates CO₂, Argon, or Argon-blend gas cylinders. Includes a cylinder pressure gauge, dual scale flow gauge and 4.3 ft. (1.3 m) gas hose.
Order K586-1



Shielding Gas Filter
Allows shielding gas to flow through while screening dust and debris. Keeps dust from entering the Activ8™ or LN-25 PRO shielding gas handling system or gun cable.
Order KP3103-1



Tweco® Style Cam-Lock Adapter Plug for Work & Electrode Cables
Cable plug for 2/0 (50 mm²) cable.
Order K2946-1



Portable Digital Wire Feed Speed Meter
When clamped on an exposed section of continuously fed electrode, unit reads wire feed speed in inches per minute.
Order K283

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 | | |
| Activ8™ | K2999-1 | 15-110 VDC | 330A/60% | 50-800 (1.3-20.3) | .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) |
| Activ8™ One-Pak® | K3289-1 | | | | | | | |

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

CUSTOMER ASSISTANCE POLICY

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THE WELDING EXPERTS®