

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 |

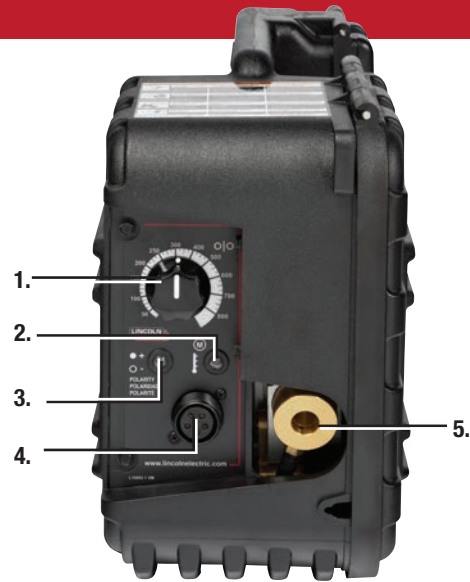


Two Year Extended
Warranty Available in
the U.S.A. and Canada.



FRONT CONTROL PANEL

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

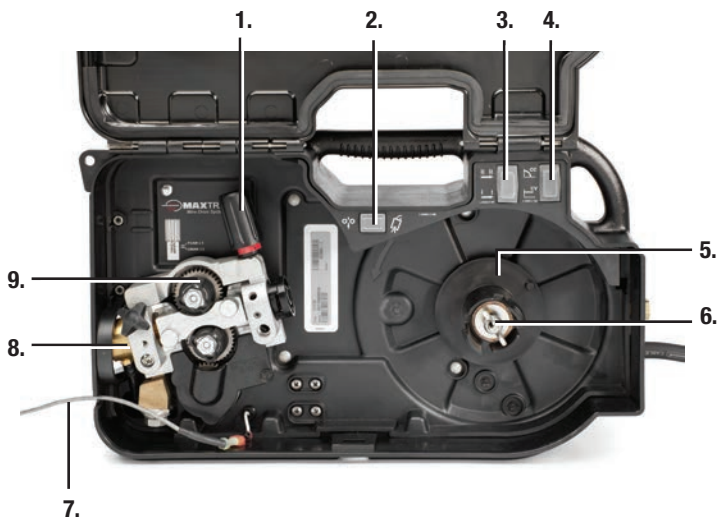


REAR CONNECTIONS

- 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 RECEIVER BUSHINGS				
K1500-1 Gun Receiver Bushing	K1500-2 Gun Receiver Bushing	K1500-3 Gun Receiver Bushing	K1500-4 Gun Receiver Bushing	K489-7 Fast-Mate™ Gun Receiver Bushing
<ul style="list-style-type: none"> • Magnum® PRO Curve™ 200, 300 and 400 with K466-1 connector kit. • Magnum® PRO 250, 350 and 450 with K466-1 connector kit. • Magnum® PRO 550 with K613-1 connector kit. • K126™ PRO Innershield® 	<ul style="list-style-type: none"> • Magnum® PRO 200, 300 and 400 w/K466-10 connector kit. • Magnum® PRO 250, 350 and 450 w/K466-10 connector kit. • Magnum® PRO 550 with K613-7 connector kit. • K126™ PRO Innershield® • Guns with Tweco® #2, #3, and #4 connectors. 	<ul style="list-style-type: none"> • Magnum® PRO 550 with K613-7 connector kit. • K126™ PRO Innershield® • Guns with Tweco® #5 connectors. 	<ul style="list-style-type: none"> • Magnum® PRO 200, 300 and 400 w/K466-3 connector kit. • Magnum® PRO 250, 350 and 450 w/K466-3 connector kit. • Magnum® PRO 550 with K613-3 connector kit. • K126™ PRO Innershield® 	<ul style="list-style-type: none"> • Magnum® with Fast-Mate™ connections. • Handles single and dual procedure guns.
				

Tweco® is a registered trademark of Thermadyne.

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

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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