

Flex Feed™ 74 HT

Processes

MIG, Flux-Cored, Submerged Arc
(hand-held) and Gouging

Product Number

K3883-XX
17 Product Variations

* See back for details

Input Power

24-42 VAC 50/60 Hz

Output Capacity Current/Duty Cycle

600A/60% (wire drive only)⁽¹⁾

600A/30% (gouging stud)

Wire Size Range

.025-.120 in. (0.6-3.0 mm)⁽²⁾⁽⁴⁾

Wire Feed Speed

50-700 IPM (1.3-12.7 m/min)⁽²⁾⁽³⁾

Weight/Dimensions (H x W x D)

13.3 x 15.5 x 23.6 (338 x 394 x 599)
wire drive only

Semiautomatic Wire Feeder

The Flex Feed™ 74 HT (High Torque) is a heavy duty industrial semiautomatic wire feeder for general and structural fabrication. The Flex Feed wire feeder is designed to be customized for each application.

FEATURES

- ▶ **Simple**
 - Basic and digital user interface streamlines operator setup
- ▶ **Rugged**
 - Improved isolation and environmental protection
 - Robust connection points allow for reliable operation in tough conditions
- ▶ **Modular**
 - Modularity allows for customizable configurations

⁽¹⁾ 600A / 30% (with gouging stud connected)

⁽²⁾ 20 tooth pinion gear installed in the wire drive as equipped from the factory

⁽³⁾ To achieve wire feed speed of 700, the feeder is configured with a 30 pinion gear

⁽⁴⁾ Variation in the wire size range is dependent on the configuration of the 20 or 30 tooth pinion

APPLICATIONS

- ▶ Fabrication
- ▶ Structural
- ▶ Heavy Equipment
- ▶ Construction



*Pictured:
Flex Feed™ 74 HT with basic
and digital user interface*

RECOMMENDED POWER SOURCES

- ▶ Flextec™ 450
- ▶ Flextec 650
- ▶ Invertec® V350 PRO
- ▶ CV-305
- ▶ CV-400
- ▶ DC-400, 600 and 1000
- ▶ Ranger® 250 GXT
- ▶ Ranger 305 G, LPD, D
- ▶ Vantage® 300, 400 and 500
- ▶ Air Vantage® 500

WHAT'S INCLUDED

- ▶ Bench models of the Flex Feed 74 HT include a 10 foot control cable
- ▶ All models include a standard #4 gun adapter
- ▶ Models with the Heavy Duty Wire Reel stand include a lift bail
- ▶ Models without a wire reel stand include K3929-1 quick disconnect inlet bushing



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



KEY CONTROLS

1. Digital display meter for AMPS
2. Wire Feed Speed Knob to increase or decrease feed speed
3. Optional gouge stud shown
4. Preflow Knob
5. Burnback Knob
6. Postflow Knob
7. Digital display meter for voltage
8. Voltage control to adjust the output of the power source
9. Trigger Connector
10. 2/4-Step/Trigger Interlock Switch to enhance operator comfort for long welds



Pictured: Flex Feed 74 HT with basic user interface



REQUIRED OPTIONS



4-Roll Wire Drive Systems



Product Number	Description/Wire Size inches (mm)
<i>Solid Wire, Smooth V Groove</i>	
KP1505-030S	.023-.030 (0.6-0.8)
KP1505-035S	.035 (0.9)
KP1505-045S	.045 (1.2)
KP1505-052S	.052 (1.4)
KP1505-1/16S	1/16 (1.6)
KP1505-1	.035, .045 (0.9, 1.2)
KP1505-2	.040 (1.0)
<i>Cored Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C ⁽³⁾	.052 (1.4)
KP1505-1/16C ⁽³⁾	1/16 (1.6)
KP1505-7/64H ⁽²⁾⁽³⁾	7/64 (2.8) Hardfacing (Knurled V Groove with matching Smooth U Groove)
<i>Cored or Solid Steel Wire, Knurled V Groove</i>	
KP1505-035C	.030-.035 (0.8-0.9)
KP1505-045C	.040-.045 (1.0-1.2)
KP1505-052C	.052 (1.4)
KP1505-1/16C	1/16 (1.6)
KP1505-068	.068-.072 (1.8)
KP1505-5/64	5/64 (2.0)
KP1505-3/32	3/32 (2.4)
KP1505-7/64	7/64 (2.8)
KP1505-.120	.120 (3.2)
<i>Hardfacing Wires, Knurled, Smooth V Groove</i>	
KP1505-7/64C	7/64 (2.8)
KP1505-7/64H	7/64 (2.8) Hardfacing
<i>Aluminum Wire, Smooth U Groove</i>	
KP1507-035A	.035 (0.9)
KP1507-040A	.040 (1.0)
KP1507-3/64A	3/64 (1.2)
KP1507-1/16A	1/16 (1.6)
KP1507-3/32A	3/32 (2.4)

Magnum[®] PRO Gun Ready Pak[®]

Product Name	Product Number	Cable Length
Magnum PRO Curve 200 Ready-Pak (with K466-10 Gun Connector)	K2950-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-6 Gun Connector)	K2951-2-6-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-45	15 (3.0)
Magnum PRO Curve 300 Ready-Pak (with K466-10 Gun Connector)	K2951-2-10-116	15 (3.0)
Magnum PRO Curve 400 Ready-Pak (with K466-10 Gun Connector)	K2952-2-10-45	15 (3.0)
Magnum PRO 250 (Barrel) Ready-Pak (with K466-6 Gun Connector)	K2651-2-6-45	15 (3.0)
Magnum PRO 350 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2652-2-10-45	15 (3.0)
Magnum PRO 450 (Barrel) Ready-Pak (with K466-10 Gun Connector)	K2653-2-10-45	15 (3.0)

FEED PLATE GUN ADAPTERS

K3344-1	K3345-1	K3346-1	K3347-1	K3348-1	K3349-1
Lincoln Electric	Tweco® #2 - #4	Tweco® #5	Miller® guns	OXO® guns	Magnum® Fast-Mate™
Compatible gun connector kit K466-1 K613-1 K613-6 K466-8	Compatible gun connector kit K466-10 K466-2 K466-6	Compatible gun connector kit K613-7 K613-2	Compatible gun connector kit K466-3 K613-3		Single and dual procedure guns
					

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.

Control Cables and Adapters

Product Number	Description	Connection	Use	Length ft. (m)
K1797-10	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	May require K1501-10, K1818-10,	10 (3.1)
K1797-25	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	K1819-10 or K1820-10, depending	25 (7.6)
K1797-50	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin	on the feeder.	50 (15.2)
K1797-100	Wire Feeder Control Cable Extension	Male 14-pin to Female 14-pin		100 (30.4)



RECOMMENDED ACCESSORIES

GENERAL OPTIONS



Inlet Bushing, quick connect style
Included with Flex Feed 74 HT feeders without a wire reel stand.
Order K3929-1



Wire Straightener
Straightens wire for the better, smoother feeding.
Order K1733-1



Wire Reel Stands – Standard Duty
Use for spools up to 44 lbs. (20 kg) max.
Order K3342-1



Wire Reel Stands - Heavy Duty
For Spools up to 44 lbs. (20 kg) and coils up to 60 lbs. (27 kg). Includes K3341-1 lift bail.
Order K3343-1



Lift Bail
Insulated lift bail for suspending the wire feeder. Requires either standard duty or heavy duty wire reel stand.
Order K3341-1



Spool Cover
Order K1634-4 for use with 30-40 lb. spools.
K3340-1 for use with 50-60 lb coils.



Shielding Gas Filter
Protects the gas solenoid and gun from contaminants.
Order KP3103-1

Inverter Cart Mounting Kit
Use for mounting feeder to an inverter cart
Order K4068-1

PRODUCT SPECIFICATIONS

Product Name	Product Number	User Interface		Reel Stand		Gouge Kit	Gun	Input Power	Output Capacity Current/Duty Cycle	Wire Size Range in. (mm)	Wire Feed Speed	H x W x D inches (mm)	Net Weight lbs. (kg)	Availability
		Basic	Digital	Standard	Heavy Duty									
Flex Feed 74 HT	K3883-1	•						24-42 VAC 50/60 Hz	600A/60% ⁽¹⁾ (wire drive only) 600A/30% (gouging stud)	Solid ⁽⁴⁾ .025-3/32 (0.6-2.4) Cored ⁽⁴⁾ : .035-.120 (0.9-3.0)	50-700 (1.3-19.0) ⁽²⁾⁽³⁾	13.3 x 15.5 x 23.6 (338 x 394 x 599) wire drive only	36 (16.3)	S
	K3883-5	•		•			47 (21.3)						P	
	K3883-11	•			•		55 (24.9)						P	
	K3883-3	•				•	44 (19.9)						A	
	K3883-7	•		•		•	55 (24.9)						A	
	K3883-13	•			•	•	63 (28.5)						S	
	K3883-15	•			•	•	.035-.045						75 (34.0)	P
	K3883-16	•			•	•	.052-1/16						75 (34.0)	P
	K3883-17	•			•	•	.062-3/32 FCAW-S						75 (34.0)	P
	K3883-2		•										36 (16.3)	S
	K3883-6		•	•									47 (21.3)	P
	K3883-12		•		•								55 (24.9)	P
	K3883-4		•			•							44 (19.9)	A
	K3883-10		•	•			.052-1/16						59 (26.7)	P
	K3883-9		•	•			.035-.045						59 (26.7)	P
	K3883-8		•	•		•							55 (24.9)	A
	K3883-14		•		•	•							63 (28.5)	A

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S - In-stock; normally in-stock for immediate shipment

P - One-Pak® of stocked items; normally in-stock for immediate shipment

A - Assemble upon order; typically ships in 5 business days

CUSTOMER ASSISTANCE POLICY

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