



**FLEXCUT**

**LINCOLN  
ELECTRIC**

**125  
FLEXCUT**

[www.lincolnelectric.com](http://www.lincolnelectric.com)

**LINCOLN  
ELECTRIC**

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ELECTRIC**

**FLEXCUT<sup>®</sup> 125**  
AIR PLASMA CUTTING SYSTEM

**LINCOLN<sup>®</sup>  
ELECTRIC**





K4811-1 FlexCut 125 Base Model (w/o Torch)  
BK4300-4 LC125M Machine Plasma Torch (Torch Sold Separately)

# Powerful, 125 Amps

## FlexCut®125

Whether you are running a mid-sized shop or an industrial-scale fabricating operation, you need a plasma cutting system that will give you the cleanest and fastest cuts possible. Rated for 125 amps at 100% duty cycle, the FlexCut 125 plasma cutter not only gives you the cut speed and quality you have come to expect from the FlexCut family of plasma cutters, but an increased level of power.

Built on an inverter platform, the FlexCut 125 plasma cutting machine is a constant-current plasma cutting power source that delivers superior cut quality with minimal dross – which minimizes the need for secondary finishing operations. Add to that our patent-pending torch and consumable designs (providing up to six times longer consumable life than competitors) and the FlexCut 125 has the potential to significantly reduce your operating costs.

The FlexCut 125 initiates the plasma arc with a simple yet reliable touch-start mechanism that eliminates many of the failure problems associated with high-frequency start systems. The control system includes Parts-in-Place™, a feature that ensures that the consumables are in place before starting the cutting process. Switch to plasma marking and use the same set of consumables with either air or nitrogen.



## MAKE THE CUT WITH SPEED AND POWER

### Best Cutting and Marking Performance

The FlexCut 125 is designed to deliver on all fronts as the only machine in its class that allows you to plasma mark. Whether you are piercing up to 1 in. (25 mm) mild steel material in a mechanized cutting application, or cutting expanded metal, you can count on less edge bevel and superior edge quality compared to competing cutting systems.

### Easy to Set, Easy to Use

The sooner your plasma cutting operation can get started, the more productive it will be. The FlexCut 125 plasma cutter requires very little time or effort to get down to the business of cutting. Controls are simple, which makes setup easy, and you can get a consistent and reliable arc without needing to rely on high-frequency start systems. The simple user interface provides a means to configure output pressure based on torch length.

### Low Operating Costs

Keeping costs under control is important to any efficient plasma cutting operation. The FlexCut 125 ensures up to six times longer consumable life and maintains faster cut speeds – both of which deliver higher productivity over less time. The completed cut is virtually dross-free, which means less secondary processing.

#### Processes »

Plasma Cutting, Marking

#### Cutting Type »

Mechanized Cutting

#### Applications »

- Steel Fabrication
- Pipe Cutting
- Structural Steel Fabrication
- Automotive/Transportation
- Maintenance and Repair
- Shipbuilding
- Steel Service Center

#### Output »



#### Input »



#### Product Number »

- K4811-1

# Controls »

## FRONT

1. LCD DISPLAY
2. PRESSURE REGULATOR
3. HOME BUTTON
4. ON/OFF SWITCH
5. TORCH CONNECTION
6. WORK LEAD CONNECTION
7. MENU CONTROL KNOB/BUTTON
8. PURGE

## BACK

9. AIR OR GAS INLET (1/4 IN. NPT QUICK CONNECT)
10. RECONNECT PANEL ACCESS
11. INPUT CORD STRAIN RELIEF
12. 14-PIN CNC INTERFACE



## FLEXCUT 125 - SPECIFICATIONS

| Product Name                                 | Product Number | Input Power Voltage/Phase /Hertz   | Rated Output: Current/ Voltage/Duty Cycle | Input Current @ Rated Output | Output Range   | Air Pressure Required          | Air Flow Rate                                  | H x W x D in (mm)                          | Net Wt. lb (kg) |
|----------------------------------------------|----------------|------------------------------------|-------------------------------------------|------------------------------|----------------|--------------------------------|------------------------------------------------|--------------------------------------------|-----------------|
| FlexCut 125<br>Base Model<br>(w/o Torch)     | K4811-1        | 380-400-415/460/575V/ 3Ph/ 50/60Hz | 125A/175V/100%                            | 3PH/100%<br>40/40//40/33/28  | 3PH<br>20-125A | 90-120 PSI<br>(6.21 -8.27 Bar) | 550 SCFH<br>@90 PSI<br>(260 SLPM<br>@6.21 Bar) | 20.72 X 12.25 X 25.53<br>(526 X 311 X 648) | 118<br>(53.5)   |
| FlexCut 125 CE<br>Base Model<br>(w/o Torch)  | K4811-2        | 380-400-415V/3Ph/ 50/60Hz          |                                           |                              |                |                                |                                                |                                            |                 |
| FlexCut 125 CCC<br>Base Model<br>(w/o Torch) | K4811-3        | 380-400-415/460/575V/ 3Ph/ 50/60Hz |                                           |                              |                |                                |                                                |                                            |                 |

## MECHANIZED CUTTING CAPACITY AT MAX OUTPUT 125A

| Material        | Cutting Capacity                                                                    | Material Thickness in. (mm)                                                                | Travel Speed ipm (mm/min)                                                                                             | Cutting Gas |
|-----------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------|-------------|
| Mild Steel      | Maximum Production Cut Capacity (pierce start)<br>Maximum Cut Capacity (edge start) | 1/4 in. (6 mm)<br>1/2 in. (12 mm)<br>3/4 in. (20 mm)<br>1 in. (25 mm)<br>1-1/2 in. (38 mm) | 210 ipm (5334 mm/min)<br>88 ipm (2235 mm/min)<br>52 ipm (1320 mm/min)<br>32 ipm (812 mm/min)<br>14 ipm (279 mm/min)   | Air         |
| Stainless Steel | Maximum Production Cut Capacity (pierce start)<br>Maximum Cut Capacity (edge start) | 1/4 in. (6 mm)<br>1/2 in. (12 mm)<br>3/4 in. (20 mm)<br>1 in. (25 mm)<br>1-1/2 in. (38 mm) | 260 ipm (6604 mm/min)<br>94 ipm (2387 mm/min)<br>45 ipm (1143 mm/min)<br>25 ipm (635 mm/min)<br>11 ipm (304 mm/min)   | Air         |
| Aluminum        | Maximum Production Cut Capacity (pierce start)<br>Maximum Cut Capacity (edge start) | 1/4 in. (6 mm)<br>1/2 in. (12 mm)<br>3/4 in. (20 mm)<br>1 in. (25 mm)<br>1-1/2 in. (38 mm) | 275 ipm (6985 mm/min)<br>112 ipm (2844 mm/min)<br>62 ipm (1574 mm/min)<br>40 ipm (1016 mm/min)<br>16 ipm (406 mm/min) | Air         |

| FLEXCUT 125 TORCHES, CONSUMABLES AND ACCESSORIES | PRODUCT NUMBER | QUANTITY   |
|--------------------------------------------------|----------------|------------|
| <b>MACHINE TORCHES</b>                           |                |            |
| LC125M Machine Plasma Torch 25 ft (7.5 m)        | K4300-4        |            |
| LC125M Machine Plasma Torch 50 ft (15 m)         | K4300-5        |            |
| LC125M Machine Plasma Torch 75 ft (22.9 m)       | K4300-6        |            |
| LC125 Machine Bevel Plasma Torch 25 ft (7.5 m)   | K4300-7        |            |
| LC125 Machine Bevel Plasma Torch 50 ft (15 m)    | K4300-8        |            |
| LC125 Machine Bevel Plasma Torch 75 ft (22.9 m)  | K4300-9        |            |
| <b>CONSUMABLES-MACHINE CUTTING</b>               |                |            |
| Electrode - (LC125M)                             | BK14300-1      | 5 per pack |
| Swirl Ring - (LC125M)                            | BK14300-13     | 2 per pack |
| Nozzle - (45A) (LC125M)                          | BK14300-7      | 5 per pack |
| Nozzle - (65A) (LC125M)                          | BK14300-8      | 5 per pack |
| Nozzle - (85A) (LC125M)                          | BK14300-9      | 5 per pack |
| Nozzle - (105A) (LC125M)                         | BK14300-10     | 5 per pack |
| Nozzle - (125A) (LC125M)                         | BK14300-11     | 5 per pack |
| Retaining Cap- (LC125M)                          | BK14300-14     | 1 per pack |
| Retaining Cap, CTP- (LC125M)                     | BK14300-15     | 1 per pack |
| Shield Cap - (45A-65A) (LC125M)                  | BK14300-3      | 2 per pack |
| Shield Cap- (85A-105A-125A) (LC125M)             | BK14300-4      | 2 per pack |
| <b>CNC INTERFACE CABLES FOR MACHINE CUTTING</b>  |                |            |
| CNC Interface Cable, FlexCut, 25 ft (7.5 m)      | K4400-25       |            |
| CNC Interface Cable, FlexCut, 50 ft (15 m)       | K4400-50       |            |



K4300-4 LC125M Machine Plasma Torch



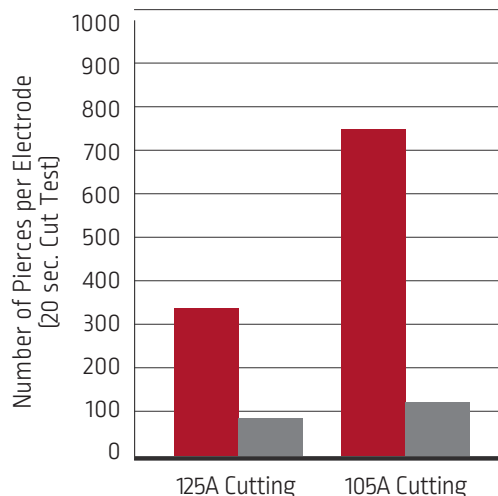
K4300-7 LC125M Machine Bevel Plasma Torch

| FLEXCUT 125 CONSUMABLE KIT                              | PRODUCT NUMBER | QUANTITY |
|---------------------------------------------------------|----------------|----------|
| CONSUMABLES STARTER KIT FOR LC125M MACHINE PLASMA TORCH | BK14300-SK     |          |
| Electrode - (LC125M)                                    |                | 2        |
| Swirl Ring - (LC125M)                                   |                | 1        |
| Nozzle - (45A) (LC125M)                                 |                | 1        |
| Nozzle - (65A) (LC125M)                                 |                | 1        |
| Nozzle - (85A) (LC125M)                                 |                | 1        |
| Nozzle - (105A) (LC125M)                                |                | 2        |
| Nozzle - (125A) (LC125M)                                |                | 2        |
| Retaining Cap, CTP- (LC125M)                            |                | 1        |
| Shield Cap - (45A-65A) (LC125M)                         |                | 1        |
| Shield Cap - (85A-105A-125A) (LC125M)                   |                | 1        |

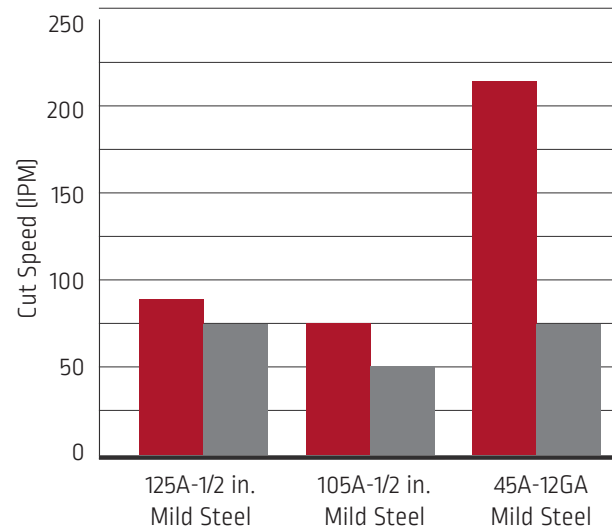




## ELECTRODE LIFE COMPARISON

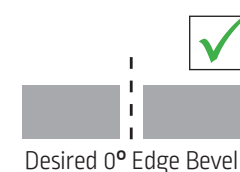
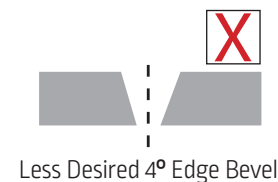
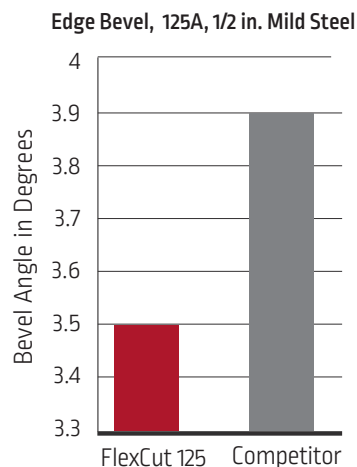
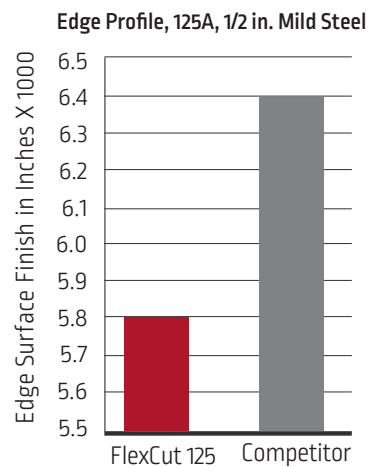
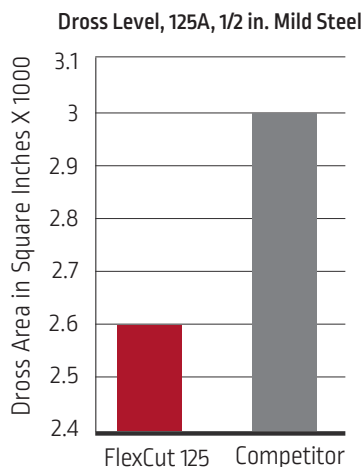


## CUT SPEED COMPARISON



- Longer Consumable Life
- Faster Cut Speeds
- Less Edge Bevel
- Better Cut Quality and Performance

## CUT QUALITY COMPARISONS



■ Lincoln Electric  
■ Competitor

### 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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