



FLEXCUT™

**LINCOLN
ELECTRIC**

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**125
FLEXCUT™**

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**4
TOP**

FLEXCUT 125

AIR PLASMA CUTTING SYSTEM

**LINCOLN®
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

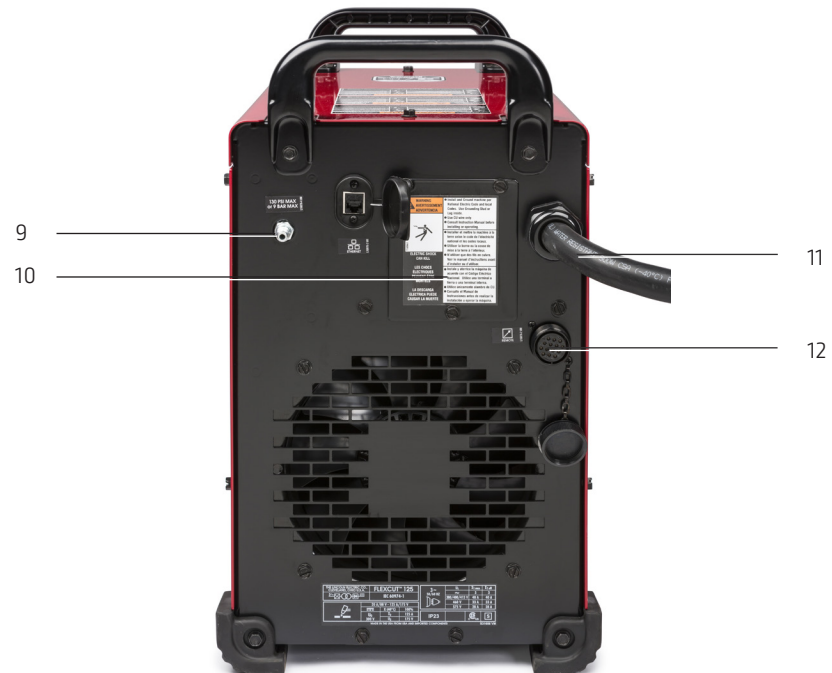
Controls »

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 Base Model (w/o Torch)	K4811-1	380-400-415/460/575V/ 3Ph/ 50/60Hz	125A/175V/100%	3PH/100% 40/40//40/33/28	3PH 20-125A	90-120 PSI (6.21 -8.27 Bar)	550 SCFH @90 PSI [260 SLPM @6.21 Bar]	20.72 X 12.25 X 25.53 (526 X 311 X 648)	118 (53.5)
FlexCut 125 CE Base Model (w/o Torch)	K4811-2	380-400-415V/3Ph/ 50/60Hz							
FlexCut 125 CCC Base Model (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) Maximum Cut Capacity (edge start)	1/4 in. (6 mm) 1/2 in. (12 mm) 3/4 in. (20 mm) 1 in. (25 mm) 1-1/2 in. (38 mm)	210 ipm (5334 mm/min) 88 ipm (2235 mm/min) 52 ipm (1320 mm/min) 32 ipm (812 mm/min) 14 ipm (279 mm/min)	Air
Stainless Steel	Maximum Production Cut Capacity (pierce start) Maximum Cut Capacity (edge start)	1/4 in. (6 mm) 1/2 in. (12 mm) 3/4 in. (20 mm) 1 in. (25 mm) 1-1/2 in. (38 mm)	260 ipm (6604 mm/min) 94 ipm (2387 mm/min) 45 ipm (1143 mm/min) 25 ipm (635 mm/min) 11 ipm (304 mm/min)	Air
Aluminum	Maximum Production Cut Capacity (pierce start) Maximum Cut Capacity (edge start)	1/4 in. (6 mm) 1/2 in. (12 mm) 3/4 in. (20 mm) 1 in. (25 mm) 1-1/2 in. (38 mm)	275 ipm (6985 mm/min) 112 ipm (2844 mm/min) 62 ipm (1574 mm/min) 40 ipm (1016 mm/min) 16 ipm (406 mm/min)	Air

FLEXCUT 125 TORCHES, CONSUMABLES AND ACCESSORIES	PRODUCT NUMBER	QUANTITY
MACHINE TORCHES		
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	
CONSUMABLES-MACHINE CUTTING		
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
CNC INTERFACE CABLES FOR MACHINE CUTTING		
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

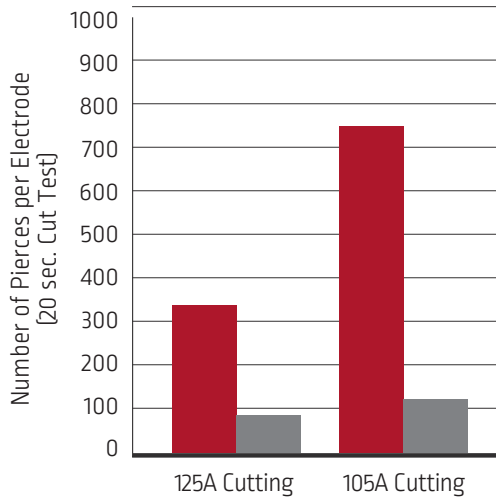


K4300-7 LC125M Machine Bevel Plasma Torch

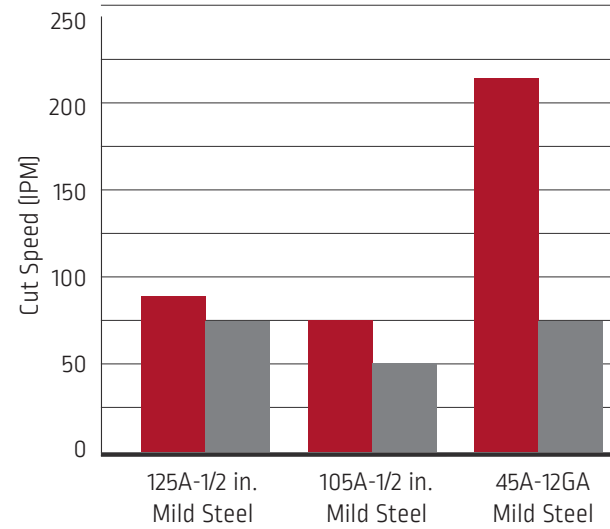
FLEXCUT 125 CONSUMABLE KIT	PRODUCT NUMBER	QUANTITY
CONSUMABLES STARTER KIT FOR LC125M MACHINE PLASMA TORCH	BK14300-SK	
Electrode - (LC125M)		2
Swirl Ring - (LC125M)		1
Nozzle - (45A) (LC125M)		1
Nozzle - (65A) (LC125M)		1
Nozzle - (85A) (LC125M)		1
Nozzle - (105A) (LC125M)		2
Nozzle - (125A) (LC125M)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



ELECTRODE LIFE COMPARISON

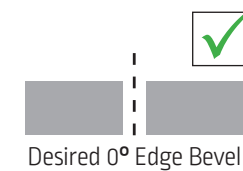
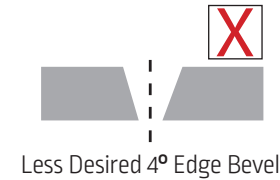
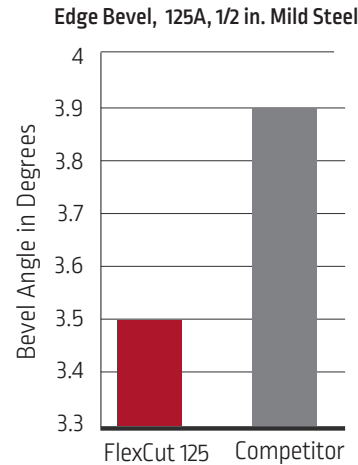
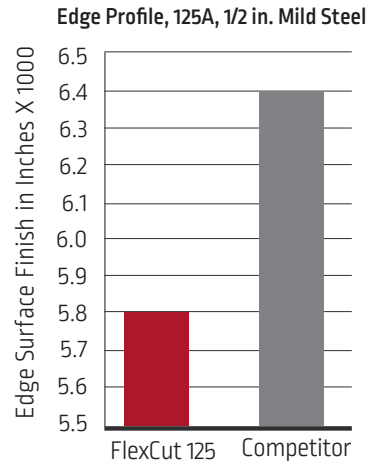
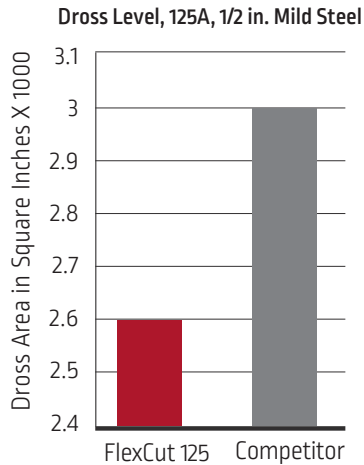


CUT SPEED COMPARISON



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

CUT QUALITY COMPARISONS



■ Lincoln Electric
■ Competitor

CUSTOMER ASSISTANCE POLICY

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