

# Pipeliner® 200D

## 200 Amp DC Diesel Engine Driven Welder

The Pipeliner® 200D, our 200-amp diesel engine driven welder, continues the long established reputation of Lincoln's 200 amp pure DC generator welder for the cross-country pipeline welding industry. This is the diesel version of the Pipeliner® 200G gasoline engine driven product. It is similar to the older SA-200 and Classic® I gasoline engine driven products manufactured for years, many of which are still in use today. The Pipeliner® 200D continues to use a DC exciter, as requested by the most discriminating operators. The Pipeliner® 200D runs at a speed slower than the more common 1800 RPM units, making this industrial product unique and especially suited to the needs of cross-country pipeline operators.

### Processes

Stick, Flux-Cored<sup>(1)</sup>, Gouging



### Output



### Input



Kubota

**CUSTOM  
ARC**  
Dial In The Right Arc, Right Now.

### Advantage Lincoln

- **Pure DC Generator Welding Output**
  - Produces the welding arc preferred by pipeline operators and contractors for precise code consistency!
- **DC Exciter**
  - Supplies pure DC current to the welding generator as desired by the most discriminating operators.
- **All Copper Windings**
  - Enhances arc stability for a really smooth, high performance arc.
- **Custom Arc® Dial**
  - Dial in the right arc, right now! 150 RPM high idle OCV adjustment for enhanced fine tuning on pipe. (See inside)
- **Five Current Ranges with Overlap**
  - For stick welding and other processes where slope control is desired. Fine-tuning within each range.
- **200 Amps Output @ 60% Duty Cycle**
  - Welds up to 7/32" (5.6 mm) low hydrogen electrode.
- **Reliable Industrial Diesel Engine**
  - 4-Cylinder water-cooled Kubota® engine with electronic governor for precise speed control.
  - Standard engine gauges allow you to monitor performance at a glance.

### TECHNICAL SPECIFICATIONS

Product Name	Rated Output Current/Voltage/Duty Cycle	Output Range	Engine Model	No. of Cyl.	HP & Speed (rpm)	Dimensions H x W x D inches (mm)	Net Weight lbs (kg)
Pipeliner® 200D	200A DC/40V/60%	40-300 DC 1750 watts DC Auxiliary Power 120V DC	Kubota® V2403M <b>NEW!</b> EPA Tier 4i	4	27.8 @ 1600	45.5 x 24.0 x 68.0 (1156 x 610 x 1727)	1311 (595)

(1) With Wire Feed Module. Rated at 200 amps, 35 volts at 60% duty cycle, 250 amps, 30 volts at 35% duty cycle.

**PERFORMANCE**

**Arc Performance**

- Pure DC generator welding arc is preferred by pipeliners and contractors for precise code consistency.
- DC exciter for supplying pure DC current to the welding generator as desired by the most discriminating operators.
- All copper windings enhance arc stability.
- Custom Arc® 150 RPM high idle (OCV) adjustment range — enhanced fine tuning for performance on pipe.
- 200 amps DC @ 60% duty cycle, 104°F (40°C). Weld up to 7/32" (5.6mm) low hydrogen electrode.
- Gouge with up to 5/32" (4.0 mm) carbons.

**DC Auxiliary Performance**

- 1,750 total watts of DC auxiliary power from a single 120V outlet for grinders and lights. DC power is less likely to bog down a grinder compared to AC power. (Not for use with AC voltage equipment.)



Use the High Idle (OCV) engine speed adjustment dial to change the heat input to the arc:

- Set the arc in the machine's "sweet spot".
- Dial in a softer or more digging arc.
- Reduce root pass internal undercut, especially on X60 and X70 pipe.
- Stack iron faster with low heat and a clear puddle on fill passes.
- Avoid arc breaks. Avoid slag that crowds the arc.
- Control fusion on the cap pass with good puddle size and clarity.

**FEATURES**

- Quiet, smooth-running, 4-cylinder, water-cooled Kubota® industrial diesel engine with electronic governor for precise speed control.
- Noise at 200A/40V rated output: 97.9 dB sound power (Lwa), 73.6 dBA at 23 ft. (7 m)
- Five overlapping current ranges for stick pipe welding and other processes where slope control is desired. Fine-tuning within each range provides precise control.
- Gauges indicate oil pressure, engine temperature and battery charging amps.
- Single-side engine access for easy routine maintenance.
- Oil drain system is standard. Includes ball valve and hose to direct oil beyond the base of the machine.
- Compact size for installation on truck beds.
- Local/Remote switch and remote receptacle are factory installed to allow easy connection of the optional remote control.

**Stick Welding**

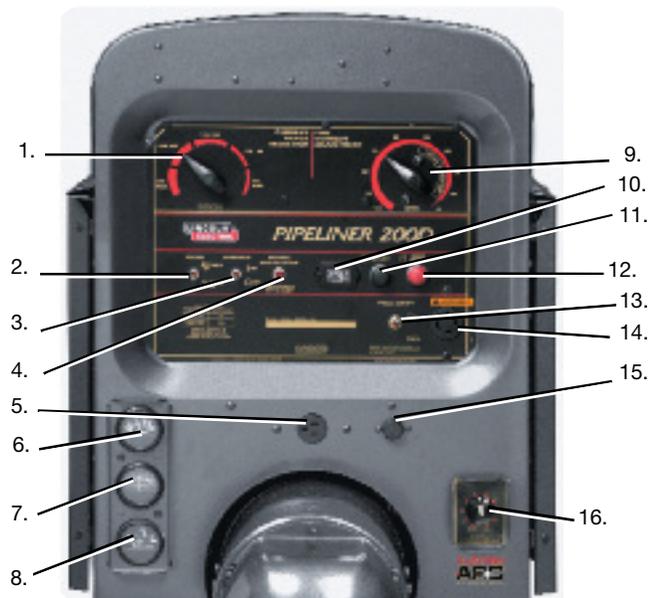
- Optional K924-5 Remote Control Kit for stick welding includes remote box and 100 ft. (30.5m) cable. Make fine current adjustments at the work, not back at the welder.

**Wire Welding**

- Optional Wire Feed Module for CV-wire welding. Increases productivity and reduces welding costs. Use LN-25 or LN-15 Across-The-Arc wire feeders. Built-in contactor for "cold-tip" electrode. (When CV wire welding with optional Wire Feed Module, idler may need to be set to "high" position for low current processes.)
- Optional K2464-1 Remote Control Kit for stick and wire welding. For machines that have the K623-1 Wire Feed Module installed. Make output adjustments up to 100 ft. from the machine.

**Key Controls**

1. Current Range Selector
2. Idler Control Switch
3. On/Off Switch
4. Engine Protection Light
5. 120V DC Receptacle
6. Engine Temperature Gauge
7. Battery Charging Ammeter
8. Engine Oil Pressure Gauge
9. Fine Current Adjustment
10. Engine Hour Meter
11. Start Button
12. Glow Plug Button
13. Local/Remote Control Switch
14. Local/Remote Control Receptacle
15. 15 Amp Fuse for auxiliary receptacle and remote
16. Custom Arc® High Idle Speed (OCV) Adjustment Dial



## A CLOSER LOOK

### QUALITY AND RELIABILITY

- Engine hour meter to track scheduled maintenance.
- Automatic engine shutdown protection for low oil pressure or high water temperature.
- Electronic engine idler extends engine life and reduces fuel consumption.
- Attractive and durable pearlescent gray finish paint.
- Manufactured under a quality system certified to ISO 9001 requirements.
- Three-year Lincoln warranty on welder. (Engine is warranted separately by the manufacturer).

### MACHINE SPECIFICATIONS

Product Name	Ordering Information	Description	Rated DC Output(1) Current/Voltage/Duty Cycle	DC Current Fine Adjustment Range	Generator Power	Dimension H(2) x W x L	Weight lbs. (kg)
Pipeliner® 200D	K6090-11	200 Amp DC Welder  All Copper Windings  Pure DC Power Generator	Lincoln "Plus" Rating 200A /40V/60%  NEMA Rating 200A / 28V / 60%	40 - 300 Amps  220 - Max 160 - 240 120 - 190 80 - 130 Min - 90	1750 Watts DC Auxiliary Power  15 Amps @ 120V DC	45.5 x 24.0 x 68.0 in (1156 x 610 x 1727mm)	1311 (595)

(1) Based on a 10 minute period. High Altitude: For maximum rating, derate the output 4% for every 1,000 ft. (300 m) above 4,900 ft. (1,500 m).

(2) Height is to top of exhaust elbow. Case height is 40.9 in. (1039 mm).

### ENGINE SPECIFICATIONS

Engine Model	Description	Horsepower & Displacement	Ignition	Capacities	Operating Speeds	Fuel Consumption
Kubota® V2403M (Diesel)(3) <b>NEW!</b> EPA Tier 4i	4 Cylinder 4 Cycle Water-Cooled Diesel Engine Cast Iron Cylinders Block / Crank Case	27.8 HP @ 1600 RPM  149 cu in (2.4 ltrs)	Compression Ignited	<b>FUEL:</b> 15 Gals (57 Ltrs)  <b>OIL:</b> 8.0 Qts (7.6 Ltrs)  <b>COOLANT:</b> 9.5 Qts (9.0 Ltrs)	<b>FULL LOAD</b> 1,600 RPM (200A/28V)  <b>HIGH IDLE</b> 1,450-1,600 RPM (adjustable)  <b>LOW IDLE</b> 1,400 RPM	0.9 Gals./Hr 3.4 Ltr/Hr  0.5 Gals/Hr 1.7 Ltr/Hr  0.4 Gals/Hr 1.4 Ltr/Hr

(3) Engine warranty for U.S. and Canada is 2 years/2,000 hours, 3 years major components. Some component limitations exist for Canada. See warranty statement for 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.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.com](http://www.lincolnelectric.com) for any updated information.

## RECOMMENDED OPTIONS

### GENERAL OPTIONS

#### Spark Arrestor Kit

Attaches to muffler exhaust tube. Virtually eliminates spark emissions.  
**Order K903-1**



**NEW!**

#### Medium Welder Trailer

For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13" wheels. Stiff .120" welded rectangular steel tube frame construction is phosphate etched and powder coat painted for superior rust and corrosion resistance. Low sway suspension gives out-standing stability with manageable tongue weight. Wheel bearings are packed with high viscosity, high pressure, low washout Lubriplate® grease. Includes a Duo-Hitch™: a 2" Ball/Lunette Eye combination hitch. Overall width: 60".

#### Order:

**K2636-1** Trailer  
**K2639-1** Fender & Light Kit  
**K2640-1** Cable Rack



#### Service Indicator Kit

Provides a GO/NO-GO visual indication of air cleaner element useful service life. Filter service based on restriction readings allows the longest life possible from the filter and best engine protection.  
**Order K1858-1**



#### Stainless Steel Sheet Metal Kit

Stainless steel roof and doors. Also includes decals (mounted), door latches, door hooks, bumpers and all required mounting hardware. Fits K6090-9 and Pipeliner® 200D and K1643-1 thru -10 Classic® 300D  
**Order K2423-1**

### STICK OPTIONS

#### Accessory Kit

For stick welding. Includes 35 ft. (10.7 m) 2/0 electrode cable with lug, 30 ft. (9.1 m) 2/0 work cable with lugs, headshield, filter plate, work clamp and electrode holder. 400 amp capacity.  
**Order K704**



#### Accessory Kit

For stick welding. Includes 20 ft. (6.1 m) #6 electrode cable with lug, 15 ft. (4.6 m) #6 work cable with lugs, headshield, filter plate, work clamp, electrode holder and sample pack of mild steel electrode. 150 amp capacity.  
**Order K875**



#### Remote Control

Remote control rheostat permits machine output changes up to 100 ft. (30.5m) from the machine. Plugs into receptacle on control panel.  
**Order K924-5**



### WIRE FEEDER OPTIONS

#### Wire Feed Module

Provides constant voltage (CV) output with improved arc stability for Innershield® welding. Recommended wire feeder is LN-25.  
**Order K623-1**



#### Remote Control Kit (Stick & Wire)

For Classic® & Pipeliner® machines that have the wire feed module. Contains a rheostat for stick output, a potentiometer for wire output and 100 ft. (30.5m) of control cable.  
**Order K2464-1**



#### LN-25 PRO Wire Feeder

Portable CC/CV unit for flux-cored and MIG welding with MAXTRAC® wire drive system. Includes Gas Solenoid & Internal Contactor. Requires Wire Feed Module.  
**Order K2613-1**



#### Magnum® 350 Innershield® Gun (for LN-25 PRO)

For self-shielded wire with 15 ft. (4.5m) cable. For .062"-3/32" (1.6-2.4 mm) wire.  
**Order K126-2**



#### Drive Roll and Guide Tube Kit (for LN-25 PRO)

For cored or solid steel wire.  
**Order KP1697-068**  
 for .068"-.072" (1.8 mm)  
**KP1697-5/64**  
 for 5/64" (2.0 mm)



## PIPELINER® 200D ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
<b>NEW!</b> PIPELINER® 200D	K6090-11		
<b>RECOMMENDED GENERAL OPTIONS</b>			
Spark Arrestor Kit	K903-1		
<b>NEW!</b> Medium Welder Trailer with Duo-Hitch™: 2" Ball/Lunette Eye Hitch	K2636-1		
<b>NEW!</b> - Fender & Light Kit	K2639-1		
<b>NEW!</b> - Cable Rack	K2640-1		
Service Indicator Kit	K1858-1		
<b>NEW!</b> Stainless Steel Sheet Metal Kit	K2423-1		
<b>RECOMMENDED STICK OPTIONS</b>			
Accessory Kit, 400 amp	K704		
Accessory Kit, 150 amp	K875		
Remote Control	K924-5		
<b>RECOMMENDED WIRE FEEDER OPTIONS</b>			
Wire Feed Module	K623-1		
<b>NEW!</b> Remote Control Kit (Stick & Wire)	K2464-1		
<b>NEW!</b> LN-25 PRO Wire Feeder	K2613-1		
Magnum® 350 Innershield® Welding Gun	K126-2		
Drive Roll and Guide Tube Kit, .068"-.072" (for LN-25 PRO)	KP1697-068		
Drive Roll and Guide Tube Kit, 5/64" (for LN-25 PRO)	KP1697-5/64		
<b>TOTAL:</b>			

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**ELECTRIC**

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