**CLASSIC® 300D**

**Processes**
Stick, TIG, MIG(1), Flux-Cored(1), Gouging

(1) With K623-1 Wire Feed Module.

**Product Numbers**
- K1643-11 Classic® 300D (Perkins®) - U.S. and Canada
- K1643-7 Classic® 300D (Perkins®) - Export
- K1643-8 Classic® 300D w/ Wire Feed Module - U.S. and Canada
- K1643-9 Classic® 300D (Kubota®) - U.S. and Canada
- K1643-10 Classic® 300D w/ Wire Feed Module - U.S. and Canada

---

**APPLICATIONS**
- Pipeline
- Construction
- Maintenance and Repair

---

**Excellent for Pipelines, Construction and Maintenance**
The Classic® 300D features proven, simple and rugged construction, along with Lincoln Electric’s well-known pure DC generator design for excellent performance on pipe, construction and maintenance welding.

**FEATURES**
- **Pure DC Generator Welding Output**
  - Produces the welding arc preferred by pipeline operators and contractors for precise control of the arc in demanding code applications.
- **All Copper Windings**
  - Enhances arc stability for a really smooth, high performance arc.
- **Custom Arc® Dial**
  - Dial in the right arc, right now! Kubota® model includes 150 RPM high idle OCV adjustment for enhanced fine tuning on pipe (see inside). Not available on Perkins® model.
- **Five Current Ranges with Overlap**
  - For stick welding and other processes where slope control is desired. Fine-tuning within each range.
- **300 Amps Output @ 60% Duty Cycle**
  - Welds up to 7/32 in. (5.6 mm) Fleetweld® 5P+ cellulosic and Excalibur® low hydrogen electrode.
- **Reliable Industrial Diesel Engines**
  - 4-cylinder, water-cooled, 1800 RPM Perkins® or Kubota® engines run smooth and quiet.
  - Engine gauges allow you to monitor performance at a glance.

**OUTPUT**
- 40-350A DC Welding
- 3000 Watts AC Generator

**Rated Output - Current/Voltage/Duty Cycle**
- 300A DC/32V/60%
- 250A DC/30V/100%

**Number of Cylinders**
4

**HP @ Speed (RPM)**
- Perkins® 32.7 HP @ 1800 RPM
- Kubota® 35.5 HP @ 1800 RPM

**Weight/Dimensions (H x W x D)**
See Back Page

---

**THE LINCOLN ELECTRIC COMPANY**
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.
Ph: +1.216-481-8100 • www.lincolnelectric.com

---

© Lincoln Global, Inc. All Rights Reserved.
PERFORMANCE

Arc Performance
- Arc gouging with up to 3/16 in. (4.7 mm) carbons.
- 2/0 (70 mm²) cable recommended for 200-250 ft. (61-76 m) combined lengths of electrode and work cables.

Generator Performance
- 3,000 total watts of AC power from a 115V or 230V duplex receptacle for power tools and lights.
- Circuit breaker protection. 115V AC 20 amp output will operate up to a 9 in. (229 mm) grinder.
- Weather-protected receptacle covers.
- GFCI (Ground Fault Circuit Interrupter) is sealed from moisture for more reliable operation.

What is Custom Arc®?
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 higher strength 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.
(Activity on Kubota® model only.)

FEATURES
- Choice of two industrial 4-cylinder, smooth-running, water-cooled diesel engines:
  - Perkins® 404D-22
    98.1 dB sound power (Lwa) at rated load.
    73 dBA sound level at 23 ft. (7 m).
  - Kubota® V2403M
    99.9 dB sound power (Lwa) at rated load.
    75 dBA sound level at 23 ft. (7 m).
- Gauges indicate oil pressure, engine temperature and battery charging amps.
- Engine hour meter to track scheduled maintenance.
- All day welding with 16 gallon (60.6 liters) plastic fuel tank with combination fuel cap/fuel gauge.
- Oil drain valve and tube are standard.
- Compact size for installation on truck beds.
- Local/Remote switch and receptacle are factory installed for easy connection of the remote control.

Stick Welding
- Optional K924-4 Remote Control Kit for stick welding. Includes remote box and 100 ft. (30 m) cable. Includes local/remote switch and receptacle for older machine control panels. Make fine current adjustments up to 100 ft. (30 m) from the machine.

Wire Welding
- Optional Wire Feed Module for CV-wire welding. Increases productivity and reduces welding costs. Rated at 300 amps, 35 volts at 60% duty cycle, 325 amps, 34 volts at 35% duty cycle. Recommended wire feeders include LN-25 Ironworker™ or Activ8™ across-the-arc models. Module has 14-pin connector for Lincoln Electric wire feeders that use a control cable with 115V AC input: LN-7 GMA and LN-8. 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 Wire Feed Module installed. Make output adjustments up to 100 ft. (30 m) from the machine.

KEY CONTROLS
1. Current Range Selector
2. On/Off Switch
3. Idler Control
4. Engine Protection Light
5. 230V AC Receptacles & Cover
6. 230V Circuit Breaker @ 15 amps
7. Sealed GFCI Module
8. Engine Temperature Gauge
9. Battery Charging Ammeter
10. Engine Oil Pressure Gauge
11. Custom Arc® High Idle RPM (OCV) Adjustment Dial (Kubota® Model only)
12. 115V Circuit Breaker @ 20 Amps
13. 115V AC Receptacles & Cover
14. Local/Remote Control Switch
15. Local/Remote Receptacle
16. Glow Plug Button
17. Start Button
18. Engine Hour Meter
19. Fine Current Adjustment for Stick Welding
20. 14-Pin Wire Feeder Connector
21. CV Voltage Adjustment for Wire Welding
22. Local/Remote Control Wire for CV-Wire
23. CC-Stick/CV-Wire Switch

Kubota® Model Shown (K1643-10) with Wire Feed Module Controls
• Both engines have glow plugs for cold weather starting.
• Automatic shutdown protection for low oil pressure or high water temperature.
• Electronic engine idler extends engine life and reduces fuel consumption.
• Engine protection/control printed circuit board is trayed and potted to provide a robust environmental shield.
• Single-side engine access for easy routine maintenance.
• Attractive and durable pearlescent gray finish paint.
• Three-year Lincoln Electric warranty (engines are warranted separately by the manufacturers).
• Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.
• Canadian Standards Association (CSA) certified.

Cross-country pipe welding with Classic® 300D.

### MACHINE SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Ordering Information</th>
<th>Description</th>
<th>Rated DC Output(1)</th>
<th>DC Current Fine Adjustment Range</th>
<th>Auxiliary Power(2)</th>
<th>Dimensions</th>
<th>Weight lbs/(kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Classic® 300D (Perkins®)</td>
<td>K1643-11 U.S. and Canada</td>
<td>300 Amp DC Arc Welder</td>
<td>NEMA Ratings: 300A / 320V / 60%</td>
<td>3.000 Watts 60 Hz, AC</td>
<td>37.1 x 24.0 x 65.0 (943 x 610 x 1651)</td>
<td>1354 (614)</td>
<td></td>
</tr>
<tr>
<td>Classic® 300D (Kubota®)</td>
<td>K1643-9 w/ Wire Feed Module U.S. and Canada</td>
<td>All Copper Windings Pure DC Power Generator</td>
<td>98V DC MAX OCV</td>
<td>13 Amps @ 230V</td>
<td>37.1 x 24.0 x 66.4 (943 x 610 x 1687)</td>
<td>1389 (630)</td>
<td></td>
</tr>
</tbody>
</table>

(1) Based on a 10 minute period. High Altitude: Perkins® – For maximum rating, derate the output 2.5% to 3.5% for every 1,000 ft. (300 m). Kubota® – for maximum rating, derate the output 4% for every 1,000 ft (300 m) above 4,900 ft (1500 m).
(2) 115V will operate either 60 Hz, or 50/60 Hz power tools, lights, etc.

### ENGINE SPECIFICATIONS

<table>
<thead>
<tr>
<th>Engine Model</th>
<th>Description</th>
<th>Horsepower &amp; Displacement</th>
<th>Ignition</th>
<th>Dry Capacities</th>
<th>Operating Speeds</th>
<th>Fuel Consumption</th>
</tr>
</thead>
<tbody>
<tr>
<td>Perkins® 404D-22</td>
<td>4 Cylinder, Water-Cooled Diesel, EPA Tier 4i</td>
<td>32.7 HP @ 1800 RPM</td>
<td>Compression Ignited</td>
<td>FUEL: 16 Gals (60.6 liters)</td>
<td>FULL LOAD 300A (1725 RPM)</td>
<td>1.4 Gals/HR 5.2 liters/HR</td>
</tr>
<tr>
<td>Kubota® V2403M</td>
<td>4 Cylinder, Water-Cooled Diesel, EPA Tier 4i</td>
<td>35.5 HP @ 1800 RPM</td>
<td>Compression Ignited</td>
<td>FUEL: 16 Gals (60.6 liters)</td>
<td>FULL LOAD 300A (1800 RPM)</td>
<td>1.3 Gals/HR 5.0 liters/HR</td>
</tr>
</tbody>
</table>

(3) Perkins® warranty is 2 years/2,000 hours, all components, 3 years major components. See warranty for details.
(4) Kubota® engine warranty for U.S. and Canada is 2 years/2,000 hours, 3 years major components. Some limitations exist for Canada. See warranty statement for details.
Ready-Pak® Welding Packages (Assembled)
Order:
K2242-3 Classic® 300D Perkins® Ready-Pak® Package - U.S. and Canada
K2387-3 Classic® 300D Kubota® Ready-Pak® Package - U.S. and Canada

One-Pak® Welding Packages (Unassembled)
Order:
K3247-3 Classic® 300D Perkins® One-Pak® Package - U.S. and Canada
K1864-3 Classic® 300D Perkins® One-Pak® Package - Export
K2386-3 Classic® 300D Kubota® One-Pak® Package - U.S. and Canada

Get a welding package with one order number.

Each Package Contains:
• Classic® 300D (without Wire Feed Module)
• Medium Welder Trailer (K2636-1)
• Duo-Hitch® 2 in. (51 mm) Ball/Lunette Eye Hitch (included)
• Fender and Light Kit (K2639-1)
• Cable Rack (K2640-1)
• Cable Connectors - two (K2487-1)
• Electrode Cable 2/0, two 50 ft. (15.3 m) lengths (K2485-2)
• Electrode Cable 2/0, 10 ft. (3 m) (K2483-2)
• Work Cable 2/0, 50 ft. (15.3 m) (K2484-2)
• 300A Electrode Holder (K909-7)
• 300A Work Clamp (K910-1)

One-Pak® Welding Packages (Unassembled)
(Only major items shown.)
RECOMMENDED ACCESSORIES

GENERAL OPTIONS

Power Plug Kit
Provides two 115V plugs rated at 20 amps each, and two 230V plugs rated at 15 amps each. 115V plugs may not be compatible with common household receptacles.
Order K820D

Spark Arrestor Kit
Attaches to muffler exhaust tube. Virtually eliminates spark emissions.
Order K903-1

Medium Welder Trailer
For heavy-duty road, off-road, plant and yard use. Includes pivoting jack stand, safety chains, and 13 in. (330 mm) wheels. Stiff 30 in. (762 mm) wheels. Includes a Duo-Hitch™ – a 2 in. (.51 mm) Ball/Lunette Eye combination hitch. Overall length 124 in. (3150 mm). Overall width: 60 in. (1524 mm). Overall height: 72 in. (1829 mm). Includes decals (mounted), door hooks, bumpers and latches, door latches, door hooks, bumpers and all required mounting hardware. Fits K6090-9 and -10 Pipeliner® 200D and K1643-1 thru -11 Classic® 300D.
Order K2636-1 Trailer
K2639-1 Fender & Light Kit
K2640-1 Cable Rack

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 -10 Pipeliner® 200D and K1643-1 thru -11 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 lug, headshield, filter plate, work clamp and electrode holder. 400 amp capacity.
Order K704

Remote Control
Remote control rheostat permits machine output changes up to 100 ft. (30 m) from the machine. Includes local/remote switch and receptacle for older machine control panels.
Order K924-4

TIG OPTIONS

PTA-26V TIG Torch
Air-cooled 200 amp torch equipped with valve for gas flow control. 25 ft. (7.6 m) length.
Order K1783-9

Magnum® Parts Kit
For PTA-26V TIG Torch
Magnum® Parts Kit provides all the torch accessories you need to start welding. Parts kit provides collets, collet bodies, a back cap, aluminnozzles and tungsten in a variety of sizes, all packaged in an easy to carry recclosable pack.
Order KP569

TIG Module
Portable, high frequency unit with gas valve for TIG welding. Rated at 300 amps/60% duty cycle.
Order K930-2

Control Cable
Connects welder and TIG Module controls.
Order K936-4

Control Cable Extension
Allows the TIG Module to be operated at distances up to 200 ft. (61 m) from the power source. 45 ft. (13.7 m) length.
Order K937-45

Arc Start™ Switch
Needed if an Amptrol™ is not used when TIG welding. Comes with a 25 ft. (7.6 m) cable. Attaches to the TIG torch for convenient finger control.
Order K814

Contactor Kit
For use with TIG Module and Classic® 300D.
Order K938-1

Contactor Kit
For use with TIG Module and Classic® 300D. Includes a contactor and 5/64 in. (2.0 mm) wire feed module.
Order K691-10

Wire Feed Module
Provides constant voltage (CV) output with excellent arc stability for Innershield® welding and MIG welding. Easy installation. Recommended wire feeder is the LN-25 Ironworker™.
Order KP1696-1

Arc Start™ Switch
For Classic® and Pipeliner® MIG welding with MAXTRAC® drive system. Includes digital meters for wire feed speed/amperage and voltage, gas solenoid, internal contactor and 9/8 in. (2.0 mm) drive roll kit for cored wire. Has 83% reduced wire feed speed capability for 6 o’clock pipe welding with Innershield® wire.
Order K2614-9

K128™ PRO Innershield® Gun
For self-shielded wire with 15 ft. (4.5 m) cable. Order K268-5/64 in. (1.6-2.0 mm) wire. Includes K466-10 Connector Kit.
Order K128-12

Drive Roll and Guide Tube Kit
For .088-.372 in. (2.2-9.4 mm) cored or solid steel wire.
Order KP1697-068

Magnum® PRO 350 Ready-Pak®
15 ft., .035-5/64 in. Magnum® PRO MIG/cored welding guns are rated 100% duty cycle. The guns are designed for high amperage, high duty cycle applications in extreme environments where heat-resistance and fast serviceability are key.
Order K2652-2-10-45

Drive Roll and Guide Tube Kit
For .035 in. and .045 in. (0.9 mm and 1.1 mm) solid steel wire.
Order KP1696-1

Magnum® SG Spool Gun
Hand held semiautomatic wire feeder. Requires SG Control Module. Order K467-25

SG Control Module
The interface between the power source and the spool gun. Provides control of the wire speed and gas flow. For use with a spool gun.
Order K488

Input Cable
(For SG Control Module) For Lincoln engine power sources with 14-pin MS-type connection, separate 115V NEMA receptacles and output stud connectors.
Order K691-10

WIRE FEEDER OPTIONS

Wire Feed Module
Provides constant voltage (CV) output with excellent arc stability for Innershield® welding and MIG welding. Easy installation. Recommended wire feeder is the LN-25 Ironworker™.
Order KP1696-1

Remote Control (Stick & Wire)
For Classic® and Pipeliner® machines that have the wire feed module. Contains a rheostat for stick output, a potentiometer for wire output and 100 ft. (30 m) of control cable.
Order K2464-1

LN-25 Ironworker™ Wire Feeder
Portable CV unit for flux-cored and MIG welding with MAXTRAC® wire drive system. Includes digital meters for wire feed speed/amperage and voltage, gas solenoid, internal contactor and 9/8 in. (2.0 mm) drive roll kit for cored wire. Has 83% reduced wire feed speed capability for 6 o’clock pipe welding with Innershield® wire.
Order K2614-9
# 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 for any updated information.


Manufactured at a facility with certified ISO Quality and Environmental Management Systems.

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Rated Output Current/Voltage/ Duty Cycle</th>
<th>Output Range</th>
<th>Engine</th>
<th>Number of Cylinders</th>
<th>HP &amp; Speed (RPM)</th>
<th>H x W x D inches (mm)</th>
<th>Net Weight lbs. (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Classic® 300D (Perkins®)</td>
<td>K1643-11 U.S. and Canada K1643-7 Export</td>
<td>250A/30V/100% 300A/32V/80%</td>
<td>Welding: 40-350A DC 3,000 watts</td>
<td>Perkins® 404D-22 Diesel EPA Tier 4i</td>
<td>4</td>
<td>32.7 @ 1800</td>
<td>—</td>
<td>1354 (614)</td>
</tr>
<tr>
<td>Classic® 300D (Perkins®) w/Wire Feed Module</td>
<td>K1643-11 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D One-Pak® (Perkins®)</td>
<td>K1643-11 U.S. and Canada K1643-7 Export</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D Ready-Pak® (Perkins®)</td>
<td>K1643-11 U.S. and Canada K1643-7 Export</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D One-Pak® (Kubota®)</td>
<td>K1643-11 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D One-Pak® (Kubota®)</td>
<td>K2386-3 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D Ready-Pak® (Kubota®)</td>
<td>K2387-3 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D (Kubota®)</td>
<td>K1643-9 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
<tr>
<td>Classic® 300D (Kubota®) w/Wire Feed Module</td>
<td>K1643-10 U.S. and Canada</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
<td>—</td>
</tr>
</tbody>
</table>


Manufactured at a facility with certified ISO Quality and Environmental Management Systems.