**Classi**c® 300 HE

**Processes**
- Stick, TIG, MIG\(^{(1)}\), Flux-Cored\(^{(1)}\), Gouging
  - (1) CV wire welding with K3964-1 Wire Feed Module

**Product Numbers**
- K3198-1 Classic® 300 HE (Kubota®)

See back for complete specs

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**Excellent for Pipelines, Construction and Maintenance**

The Classic® 300 HE 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**
- **Fuel Efficient Industrial Diesel Engine**
  - 3-cylinder, water-cooled, 1800 RPM engine.
  - Big fuel savings compared to previous engine!
    - Kubota®: 15% at 300A, 30% at low idle vs. Classic® 300 D.
  - Fuel gauge on control panel.
- **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.
- **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.

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

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**INPUT**
- **Output**
- **3 kW**

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**EPA Tier 4**

**HP @ Speed (RPM)**
- Kubota® 24.7 HP @ 1800 RPM

**Weight/Dimensions (H x W x D)**
- 1,371 Lbs. (622 kg)
  - 37.1 x 24.3 x 62.8 in.
    (943 x 616 x 1594 mm)
  - To Top of Exhaust Tube
    45.5 in. (1156 mm)

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**THE LINCOLN ELECTRIC COMPANY**
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PERFORMANCE

Arc Performance
- 350 Amp maximum output.
- 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 120V or 240V duplex receptacle for power tools and lights.
- Circuit breaker protection. 120V 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.

FEATURES

- Industrial 3-cylinder, smooth-running, water-cooled diesel engine:
  - Kubota® D1503
- Fuel gauge on control panel to easily monitor fuel level.
- Engine hour meter to track scheduled maintenance.
- Additional engine gauges indicate oil pressure and engine temperature.
- 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 is available 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. Fuel Gauge/Engine Hour Meter
   Engine Temperature Gauge
   Oil Pressure Gauge
3. Engine Battery Charging Light
4. Engine Protection Light
5. Idler Control
6. Run/Stop Switch
7. Start Button
8. Glow Plug Button
9. 240V Circuit Breaker @ 15 amps
10. Sealed GFCI
11. Local/Remote Control Switch
12. Local/Remote Receptacle
13. 120V Circuit Breaker @ 20 Amps
14. 120V AC Receptacles and Cover
15. 240V AC Receptacles and Cover
16. Fine Current and O.C.V. Adjustment for Stick Welding
Both engines have glow plugs for cold weather starting.
Automatic shutdown protection for low oil pressure or high water temperature with indicator light on control panel.
Indicator light for a malfunction of the engine battery charging system.
Electronic engine idler extends engine life and reduces fuel consumption.
ECU (Engine Control Unit for engine protection, idler and governor) is in a sealed housing for a robust environmental shield.
Single-side engine access for easy routine maintenance.
Attractive and durable pearlescent gray finish paint.
Three-year Lincoln Electric warranty (engine is warranted separately by the manufacturer).
Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.
Canadian Standards Association (CSA) certified.

### 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 H x W x L inches (mm)</th>
<th>Weight lbs/kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Classic® 300 HE (Kubota®)</td>
<td>K3198-1</td>
<td>300 Amp DC Arc Welder, All Copper Windings, Pure DC Power Generator</td>
<td>NEMA Ratings: 300A / 32V / 65% 250A / 30V / 100% 90V DC MAX OCV</td>
<td>40 - 350 Amps</td>
<td>3,000 Watts 60 Hz, AC 220 - Max 160 - 240 120 - 190 80 - 130 Min - 90</td>
<td>37.1 x 24.3 x 62.8 (943 x 616 x 1594)</td>
<td>1371 (622)</td>
</tr>
</tbody>
</table>

(1) Based on a 10 minute period. High Altitude: Kubota® – for maximum rating, derate the output 4% for every 1,000 ft (300 m) above 4,900 ft (1500 m).
(2) 120V 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>Kubota® D1503 Diesel(3) EPA Tier 4</td>
<td>3 Cylinder 4 Cycle Water-Cooled Diesel Engine Cast Iron Cylinders Block/Crank Case Electronic Governor</td>
<td>24.7 HP @ 1800 RPM 91.5 cu in (1.5 liters)</td>
<td>Compression Ignited</td>
<td>FUEL: 16 Gals (60.6 liters) OIL: 5.9 Qts (5.6 liters) COOLANT: 7.8 Qts (7.4 liters)</td>
<td>FULL LOAD 300A (1,800 RPM) HIGH IDLE 1,500 RPM LOW IDLE 1,440 RPM</td>
<td>1.1 Gals/Hr 1.3 liters/Hr 0.4 Gals/Hr 1.3 liters/Hr 0.3 Gals/Hr 1.0 liters/Hr</td>
</tr>
</tbody>
</table>

(3) 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 Package (Assembled)
Order:
K2387-5  Classic® 300 HE Kubota® Ready-Pak® Package

One-Pak® Welding Package (Unassembled)
Order:
K2386-5  Classic® 300 HE Kubota® One-Pak® Package

Get a welding package with one order number.

Each Package Contains:
• Classic® 300 HE (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)
**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 K262D

**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.
- 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, Classic® 300 HE, SAE-300®, SAE-300® HE.
- 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

**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, alumina nozzle and tungsten in a variety of sizes, all packaged in an easy to carry replaceable pack.
- Order K909

**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. (61.9 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

**WIRE FEEDER OPTIONS**

**Wire Feed Module**
- Provides constant voltage (CV) output with excellent arc stability for Innershield® and MAG welding. Easy installation. Recommended wire feeder is the LN-25 Ironworker™.
- Order K3864-1

**Input Cable**
- For (SG Control Module)
- Provides control of the wire speed and gas flow. For use with a spool gun.
- Order K488

**Drive Roll and Guide Tube Kit**
- For .035 in. and .045 in. (0.9 mm and 1.1 mm) solid steel wire.
- Order K1697-068

**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 K487-25

**Pro Innershield® Gun**
- Air-cooled 200 amp torch equipped with valve for gas flow control.
- 25 ft. (7.6 m) length.
- The guns are designed for high ampereage, 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 K1697-068-1

**Magnum® PRO 350 Ready-Pak®**
- 15 ft., 0.035/0.045 in. Magnum® PRO MIG flux-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 K1697-068-1

**Magnum® SG Spool Gun**
- Hand held semiautomatic wire feeder. Requires SG Control Module.
- Order K487-25

**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)
- Provides control of the wire speed and gas flow. For use with a spool gun.
- Order K488

**Drive Roll and Guide Tube Kit**
- For .035 in. and .045 in. (0.9 mm and 1.1 mm) solid steel wire.
- Order K1697-068-1
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
THE WELDING EXPERTS

PRODUCT SPECIFICATIONS


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

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