Pipeliner® 200D

Processes
Stick, Flux-Cored(1), Gouging
(1) With Wire Feed Module.

Product Number
K6090-11 - U.S. and Canada
See inside for complete specs

Output Range
40-300A DC Welding
1750 Watts DC Auxiliary Power

Rated Output Current/Voltage/Duty Cycle
200A DC/40V/60%

Number of Cylinders
4

HP @ Speed (RPM)
27.8 HP @ 1600 RPM

Weight/Dimensions (H x W x D)
1311 lbs. (595 kg)
37.1 x 24.0 x 68.0 inches
(943 x 610 x 1727 mm)
45.5 (1156 mm) To Top of Exhaust Tube

Rich Heritage – 200 Amp DC Diesel Welder
The Pipeliner® 200D is a direct descendant of Lincoln Electric’s industry-respected 200 amp pure DC generator welders for cross-country pipeline welding. It features a DC exciter and runs slower than the common 1800 RPM products, as requested by the most discriminating cross-country pipeline operators.

FEATURES
- 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.
- Five Overlapping Current Ranges
  - For stick welding and other processes where slope control is desired. Fine-tuning within each range.
- 200 Amps DC @ 60% Duty Cycle
  - Weld up to 7/32 in. (5.6 mm) low hydrogen electrode.

APPLICATIONS
- Pipeline
- Maintenance and Repair
- Construction

- 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.

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

THE LINCOLN ELECTRIC COMPANY
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Two Year Extended Warranty Available in the U.S.A. and Canada.
**Performance**

**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.

**Features**

- Gouge with up to 5/32 in. (4.0 mm) carbons.
- 1/0 (50 mm²) cable recommended for 200–250 ft. (61–76 m) combined lengths of electrode and work cables.
- Noise at 200A/40V rated output: 97.9 dB sound power (Lwa), 73.6 dBA at 23 ft. (7.0 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 ltrs) plastic fuel tank with combination fuel cap/fuel gauge.
- 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.

**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.)

**Stick Welding**

- Optional K924-4 Remote Control Kit for stick welding. Includes remote box and 100 ft. (30.5 m) cable. Includes local/remote switch and receptacle for older machine control panels. Make fine current adjustments up to 100 ft. (30.5 m) from the machine.

**Wire Welding**

- Optional Wire Feed Module for CV-wire welding. Increases productivity and reduces welding costs. Rated at 200 amps, 35 volts at 60% duty cycle, 250 amps, 30 volts at 35% duty cycle. Use LN-25 PIPE 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. (30.5 m) 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
QUALITY AND RELIABILITY

- Glow plugs for cold weather starting.
- Automatic engine shutdown protection for low oil pressure or high water temperature.
- Electronic engine idler extends engine life and reduces fuel consumption.
- Single-side engine access for easy routine maintenance.
- Attractive and durable pearlescent gray finish paint.
- Manufactured under a quality system certified to ISO 9001 requirements and ISO 14001 environmental standards.
- Three-year Lincoln Electric warranty on welder (engine is warranted separately by the manufacturer).
- 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>Generator Power</th>
<th>Dimensions H x W x L (inches (mm))</th>
<th>Weight lbs (kg)</th>
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</thead>
<tbody>
<tr>
<td>Pipeliner® 200D</td>
<td>K6090-11 U.S. and Canada</td>
<td>200 Amp DC Welder</td>
<td>Lincoln “Plus” Rating 200A /40V/60%</td>
<td>40 - 300 Amps</td>
<td>DC Auxiliary Power 1750 Watts</td>
<td>37.1 x 24.0 x 68.0 (943 x 610 x 1727)</td>
<td>1311 (595)</td>
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<tr>
<td></td>
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<td>All Copper Windings</td>
<td>NEMA Rating 200A / 28V / 60%</td>
<td>220 - Max</td>
<td>15 Amps @ 120V DC</td>
<td>To top of exhaust tube: 45.5 (1158)</td>
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<tr>
<td></td>
<td></td>
<td>Pure DC Power Generator</td>
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<td>160 - 240</td>
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<td>120 - 190</td>
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<td>80 - 130</td>
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<td>Min - 90</td>
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</table>

(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).

ENGINE SPECIFICATIONS

<table>
<thead>
<tr>
<th>Engine Model(2)</th>
<th>Description</th>
<th>Horsepower &amp; Displacement</th>
<th>Ignition</th>
<th>Capacities</th>
<th>Operating Speeds</th>
<th>Fuel Consumption</th>
</tr>
</thead>
<tbody>
<tr>
<td>Kubota® V2403M (Diesel)(2)</td>
<td>4 Cylinder 4 Cycle Water-Cooled, Diesel Engine Cast Iron Cylinders Block / Crank Case</td>
<td>27.8 HP @ 1600 RPM 149 cu in (2.4 ltrs)</td>
<td>Compression Ignited</td>
<td>FUEL: 16 Gals (60.6 Ltrs)</td>
<td>FULL LOAD 1,600 RPM (200A/28V)</td>
<td>0.9 Gals/Hr 3.4 Ltr/Hr</td>
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<td>OIL: 8.0 Qts (7.6 ltrs)</td>
<td>HIGH IDLE 1,450-1,600 RPM (adjustable)</td>
<td>0.5 Gals/Hr 1.7 Ltr/Hr</td>
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<td>COOLANT: 9.5 Qts (9.0 Ltrs)</td>
<td>LOW IDLE 1,400 RPM</td>
<td>0.4 Gals/Hr 1.4 Ltr/Hr</td>
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</tbody>
</table>

(2) 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.

The 800 mile long 48 inch diameter Trans Alaska Pipeline System was constructed using Lincoln Electric Pipeliner® welders.
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

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

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.