

# Pipeliner<sup>®</sup> 200D

## Processes

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

(1) With Wire Feed Module.

## Product Number

K6090-11

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 in.

(943 x 610 x 1727 mm)

45.5 (1156 mm) To Top of  
Exhaust Tube

## Rich Heritage – 200 Amp DC Diesel Welder

The Pipeliner<sup>®</sup> 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<sup>®</sup> 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.

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

### APPLICATIONS

- ▶ Pipeline
- ▶ Maintenance and Repair
- ▶ Construction



Dial In The Right Arc, Right Now.



- ▶ **Reliable Industrial Diesel Engine**
  - 4-Cylinder water-cooled Kubota<sup>®</sup> engine with electronic governor for precise speed control.
  - Standard engine gauges allow you to monitor performance at a glance.

### INPUT



### OUTPUT



Kubota



Two Year Extended  
Warranty Available in  
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.

- Gouge with up to 5/32 in. (4.0 mm) carbons.
- 1/0 (50 mm<sup>2</sup>) cable recommended for 200-250 ft. (61-76 m) combined lengths of electrode and work cables.

## FEATURES

- 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.
- 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 K924-4 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.

### DC Auxiliary Performance

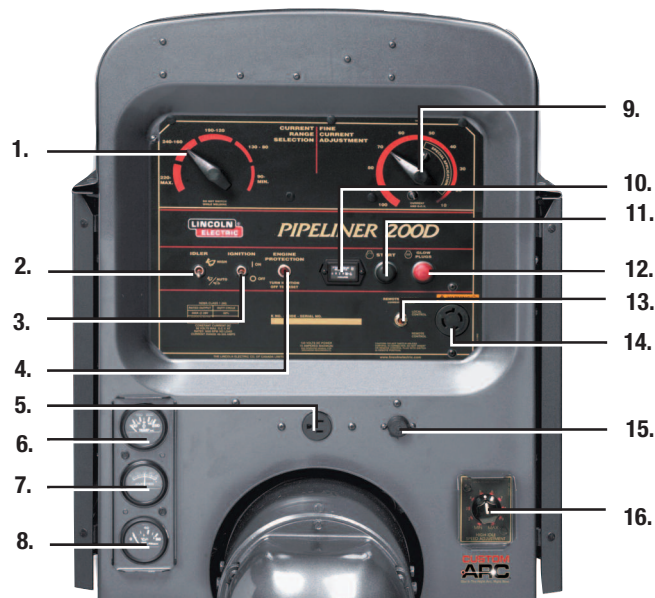
- 1,750 total watts of DC auxiliary power from a single 120V outlet for grinders and lights. DC power is less likely to bog down a grinder compared to AC power. (Not for use with AC voltage equipment.)

### 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 PRO 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

- 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 and ISO 14001 environmental standards.
- Three-year Lincoln Electric 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	Dimensions H x W x L inches (mm)	Weight lbs (kg)
Pipeliners® 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	DC Auxiliary Power 1750 Watts  15 Amps @ 120V DC	37.1 x 24.0 x 68.0 (943 x 610 x 1727)  <i>To top of exhaust tube: 45.5 (1156)</i>	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).

### ENGINE SPECIFICATIONS

Engine Model(2)	Description	Horsepower & Displacement	Ignition	Capacities	Operating Speeds	Fuel Consumption
Kubota® V2403M (Diesel)(2) 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

(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 Pipeliners® welders.



## RECOMMENDED ACCESSORIES TO EXPAND MACHINE CAPABILITIES

### GENERAL OPTIONS



#### 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. wheels. Stiff .120 in. welded rectangular steel tube frame construction is phosphate etched and powder coat painted for superior rust and corrosion resistance. Low sway suspension gives outstanding stability with manageable tongue weight. Wheel bearings are packed with high viscosity, high pressure, low washout Lubriplate® grease. Includes a Duo-Hitch™: a 2 in. Ball/Lunette Eye combination hitch. Overall width: 60 in.

#### 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 -11 Pipeliner® 200D and K1643-1 thru K1643-10 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. (30.5 m) from the machine. Includes local/remote switch and receptacle for older machine control panels.

**Order K924-4**



### 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. (30.5 m) 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**



#### K126 PRO Innershield® Gun (for LN-25 PRO)

For self-shielded wire with 15 ft. (4.5 m) cable. For .062-5/64 in. (1.6-2.0 mm) wire. Includes K466-10 Connector Kit.

**Order K126-12**



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

For cored or solid steel wire.

#### Order

**KP1697-068** for

.068-.072 in. (1.8 mm)

**KP1697-5/64** for

5/64 in. (2.0 mm)



## PRODUCT SPECIFICATIONS

Product Name	Product Number	Rated Output Current/Voltage/Duty Cycle	Output Range	Engine Model	Number of Cylinders	HP@ Speed (rpm)	H x W x D inches (mm)	Net Weight lbs. (kg)
Pipeliner® 200D	K6090-11	200A DC/40V/60%	40-300 DC	Kubota® V2403M EPA Tier 4i	4	27.8 @ 1600	37.1 x 24.0 x 68.0 (943 x 610 x 1727) To top of exhaust tube: 45.5 (1156)	1311 (595)
			1750 watts DC Auxiliary Power 120V DC					

For best welding results with Lincoln Electric equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more 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.

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**LINCOLN**  
**ELECTRIC**  
THE WELDING EXPERTS®