

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, and 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.



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

Processes

Stick MIG(1) Flux-Cored(1) Gouging

Advantage Lincoln

- 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 requested by the most discriminating operators.
- All copper windings enhance arc stability.
- 200 amps DC @ 60% duty cycle. Weld up to 7/32" (5.6mm) low hydrogen electrode. Gouge with up to 5/32" (4.0mm) carbons.
- Five overlapping current ranges for stick pipe welding and other processes where slope control is desired. Fine-tuning within each range provides precise control.
- Custom Arc™ 150 RPM high idle (OCV) adjustment range — enhanced fine tuning for performance on pipe. See inside. **NEW!**
- Local/Remote switch and remote receptacle are factory installed to allow easy connection of the remote control.
- Quiet, smooth-running, 4-cylinder, water-cooled Kubota® industrial diesel engine with electronic governor for precise speed control. **NEW!**
- Three-year Lincoln warranty on welder (engine is warranted separately by the manufacturer).

Description

Output **CC** **CV**⁽¹⁾ **1.75 kW** Input **D**

Recommended General Options

Spark Arrestor Kit, Medium Welder Trailer

Recommended Stick Options

Accessory Kit, Remote Control

Recommended Wire Feeder Options

Wire Feed Module, LN-25 Wire Feeder, Remote Voltage Control Kit, Magnum® 350 Innershield Welding Gun, Drive Roll Kit, Magnum 200 MIG Gun, Magnum Gun Connector Kit

Order

K6090-10 Pipeliner 200D

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 V2203M	4	27.8 @ 1600	45.5 x 24.0 x 68.0 (1156 x 610 x 1727)	1302 (590)

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

PERFORMANCE

Arc Performance

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



DC Generator Performance

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



Dial In The Right Arc, Right Now.



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.
- Five overlapping current ranges for stick pipe welding and other processes where slope control is desired. Fine-tuning within each range provides precise control.
- Local/Remote switch and remote receptacle are factory installed to allow easy connection of the remote 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.

- Optional road trailer system is available:
 K953-1 Medium Welder Trailer
 K958-1 2" Ball Hitch
 K958-2 Lunette Eye Hitch
 K959-1 Fender & Light Kit
 K965-1 Cable Storage Rack

Remote Control

- 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. Wire Feed Module has 14-pin connector for using Lincoln LN-25 wire feeder with a K444-2 Remote Voltage Control. 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.)

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	K6090-10	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 15 Amps @ 120V DC	45.5 x 24.0 x 68.0 in (1156 x 610 x 1727mm)	1302 (590)

(1) Based on a 10 minute period.

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

ENGINE SPECIFICATIONS

Engine Model	Description	Horsepower & Displacement	Ignition	Capacities	Operating Speeds	Fuel Consumption
Kubota V2203M (Diesel) ⁽³⁾	4 Cylinder 4 Cycle Water-Cooled Diesel Engine Cast Iron Cylinders Block / Crank Case	27.8 HP @ 1600 RPM 134.1 cu in (2.2 ltrs)	Compression Ignited	FUEL: 15 Gals (57 Ltrs) OIL: 8.0 Qts (7.6 Ltrs) COOLANT: 9.5 Qts (9.0 Ltrs)	FULL LOAD 1,600 RPM (200A/40V) HIGH IDLE 1,600 RPM LOW IDLE 1,400 RPM	0.9 Gals./Hr 3.2 Ltr/Hr 0.4 Gals/Hr 1.4 Ltr/Hr 0.3 Gals/Hr 1.1 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 advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customer's particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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.

RECOMMENDED OPTIONS

GENERAL OPTIONS



Spark Arrestor Kit
Attaches to end of muffler. Virtually eliminates spark emissions.
Order K903-1



Medium Welder Trailer
For heavy-duty road, off-road plant, and yard use.
Order:
K953-1 Trailer
K958-1 2" Ball Hitch
K958-2 Lunette Eye Hitch
K959-2 Fender & Light Kit
K965-1 Cable Rack

STICK OPTIONS



Accessory Kit
For stick welding. Includes 35 ft. (10.7m) 2/0 electrode cable with lug, 30 ft. (9.1m) 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. (6.1m) #6 electrode cable with lug, 15 ft. (4.6m) #6 work cable with lugs, headshield, filter plate, work clamp, electrode holder and sample pack of mild steel electrode. 200 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



LN-25 Wire Feeder
Portable CC/CV unit for flux-cored and MIG welding. Includes gas solenoid & internal contactor. For spools up to 44 lbs. (20 kg).
Order K449



Remote Voltage Control Kit (for LN-25)
Provides 25 ft. (7.5m) of remote output voltage control and output jumper (2 and 4) for Wire Feed Module.
Order K444-2



Magnum® 350 Innershield® Gun (for LN-25)
For self-shielded wire with 15 ft. (4.5m) cable. For .062-3/32" (1.6-2.4mm) wire.
Order K126-2



Drive Roll and Guide Tube Kit (for LN-25)
For .068-3/32" (1.8-2.4mm) cored or solid steel wire.
Order KP653-3/32



Magnum® 200 MIG Gun
For .025" (0.6mm) gas-shielded wire with 15 ft. (4.5m) cable.
Order K497-3



Drive Roll and Guide Tube Kit (for LN-25)
For .023-.025" (0.6mm) solid steel wire.
Order KP653-025S



Magnum® Gun Connector Kit
Connects Magnum MIG gun to LN-25 wire feeder.
Order K466-1

PIPELINER 200D ORDER FORM

PRODUCT DESCRIPTION	ORDER NUMBER	QUANTITY	PRICE
PIPELINER® 200D	K6090-10		
RECOMMENDED GENERAL OPTIONS			
Spark Arrestor Kit	K903-1		
Medium Welder Trailer	K953-1		
- Ball Hitch	K958-1		
- Lunette Eye Hitch	K958-2		
- Fender & Light Kit	K959-1		
- Cable Rack (fits K953-1)	K965-1		
RECOMMENDED STICK OPTIONS			
Accessory Kit, 400 amp	K704		
Accessory Kit, 200 amp	K875		
Remote Control	K924-5		
RECOMMENDED WIRE FEEDER OPTIONS			
Wire Feed Module	K623-1		
LN-25 Wire Feeder	K449		
Remote Voltage Control Kit for LN-25 (25 ft.)	K444-2		
Magnum® 350 Innershield® Welding Gun	K126-2		
Drive Roll and Guide Tube Kit	KP653-3/32		
Magnum® 200 MIG Gun	K497-3		
Drive Roll and Guide Tube Kit	KP653-025S		
Magnum® Gun Connector Kit	K466-1		
	TOTAL:		