

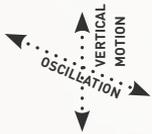


# PIPELINER II 609

**MAGNATECH**

#### TORCH OSCILLATION (WEAVE)

Width, speed, and endpoint "dwell" independently programmable. Torch "cross seam" steering electronica.

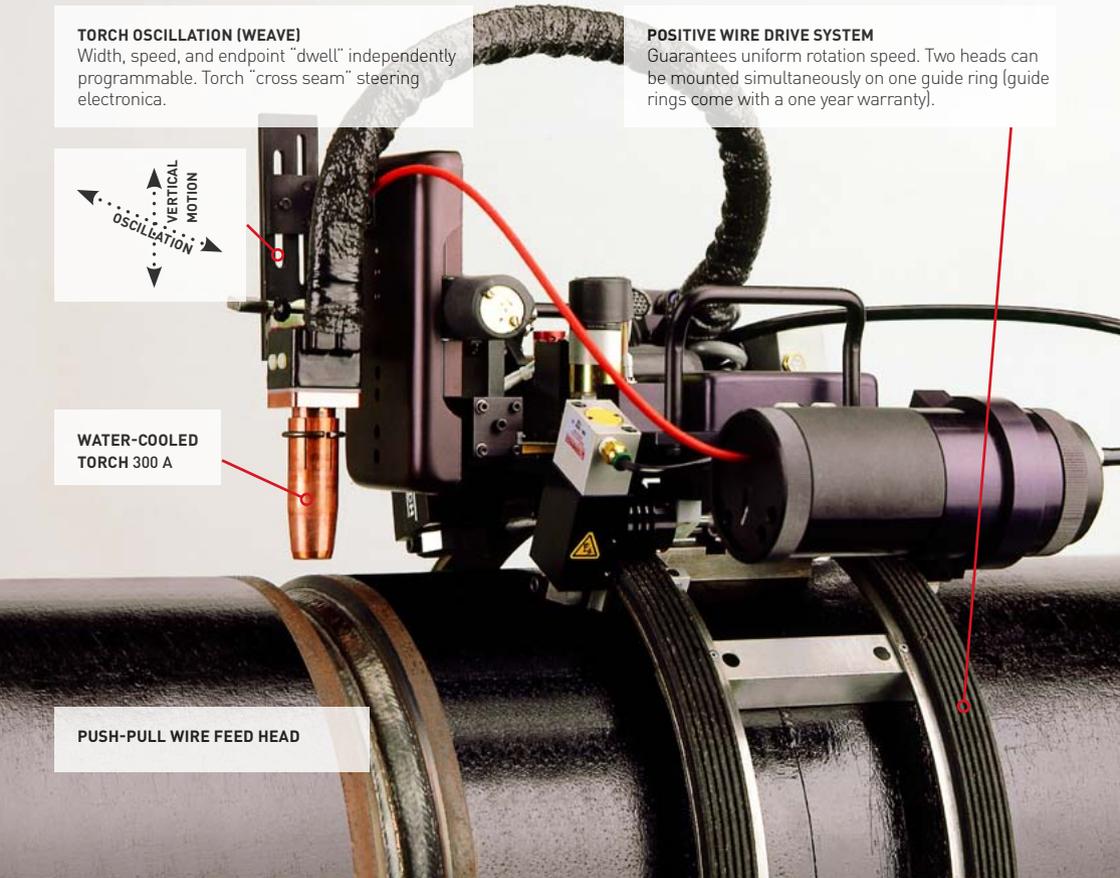


#### POSITIVE WIRE DRIVE SYSTEM

Guarantees uniform rotation speed. Two heads can be mounted simultaneously on one guide ring (guide rings come with a one year warranty).

WATER-COOLED  
TORCH 300 A

PUSH-PULL WIRE FEED HEAD



## ORBITAL WELD HEAD FOR MULTI PASS GMAW/FCAW PIPE WELDING

The Magnatech Pipeliner II is designed to make pipe-to-pipe and pipe-to-fitting welds. Interchangeable guide rings mount the head on the pipe, allowing a broad workpiece size range from 168 – 1524 mm (6” – 60”) and larger. The Pipeliner II improves productivity by increasing duty cycle, reducing repair rates, and producing welds of consistent quality.



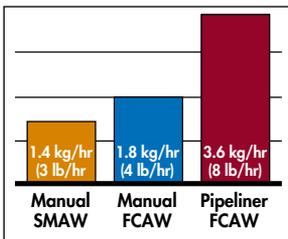
## Features

- Full Function Capability (Torch Rotation, Filler Wire Feed, Motorized Arc Gap Control, Electronic Oscillation)
- Broad Pipe Size Range with change of single component – the Guide Ring
- Water-Cooled Torch uses standard Expendables

## HIGH DEPOSITION RATE WITHOUT SACRIFICING QUALITY – AUTOMATICALLY

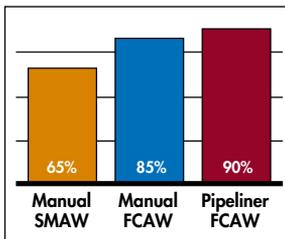
### DEPOSITION RATE\*

Weld metal deposition per hour



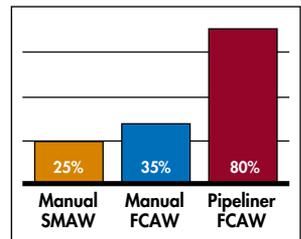
### DEPOSITION EFFICIENCY

Ratio of weight of weld metal deposited to the weight used



### DUTY CYCLE FACTORS

The ratio of arc hours to clock hours for a welder or welding operator (Arc on Time)



### PIPELINER TYPICAL PARAMETERS

- 24–26V; 220–260A
- 5.1–7.6m/min. (200–300 ipm)

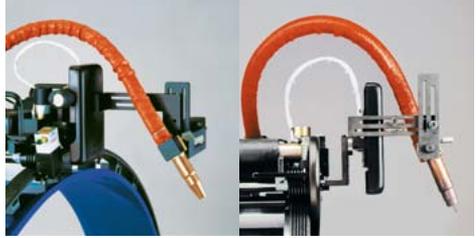
# PIPELINER II 609

## Options

- Pendular Torch Oscillation
- Torch Angle Bracket for Fillet/Socket Welds
- Extension Cables

**LEFT** Optional Pendular Oscillator positioned for fillet welds

**RIGHT** Optional Torch Angle Bracket for fillet and socket weld applications



## FLX-TRACK™

In addition to welding pipework, the Pipeliner is also used for ID and OD welding on larger tanks, vessels, and ductwork.

- Flexible track allows mounting on complex curved surfaces
- Standard 2.3m (7-1/2') Track sections bolt together for longer lengths
- Magnetic or Vacuum attachment

**PIPELINER** mounted on Flx-Track in 3.3m (11 ft.) diameter stainless steel duct



## Applications

- Gas, Oil, Water Pipelines
- Steam Piping
- Chemical
- Large Diameter Vessels
- Flowlines and Risers
- Offshore Platforms – Jackets and Topsides
- Tubular Structures, Piling



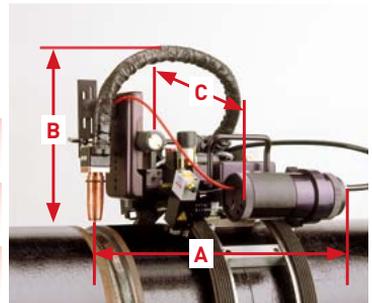
# 609 PIPELINER II

## Specifications

<b>Application</b>	Pipe size – 168 mm (6.625”) and larger Pipe wall thickness – unlimited Flx-Track™ for welding on fl at and curved surfaces
<b>OSCILLATION MODULE (LINEAR)</b>	
<b>Output rating</b>	0 – 51 mm (2”)
<b>Oscillation speed</b>	0 – 2540 mm/min. (100 ipm)
<b>Oscillation dwell</b>	0 – 1 second. Independently adjustable at both stroke endpoints
<b>Cross seam adjustment</b>	± 25 mm (1.0”)
<b>OSCILLATION MODULE (PENDULAR)</b>	
<b>Cross seam adjustment</b>	± 20 degrees
<b>Torch vertical motion module</b>	Stroke: 66 mm (2.625”) (motorized) Speed: 1520 mm/min. (60 ipm) maximum
<b>Tractor module</b>	Poly-Track® propulsion (patented)
<b>Speed capability</b>	0 – 762 mm/min. (30 ipm). Higher speed motors available
<b>Travel direction</b>	Switch selectable (on head)
<b>Wire</b>	Wire diameter: 0.8 – 1.6 mm (0.03 – 0.62”) Wire feed speed: 0.5 – 22 m/min. (20 – 866 ipm) Wire spool size: 15/16 kg (25/33 lbs)
<b>Water-cooled torch</b>	Amperage capability: 300 amps continuous. Uses standard torch components
<b>Torch adjustment capability</b>	Torch lead/lag adjustment: ± 15 degrees (manual) Torch tilt adjustment: ± 10 degrees (manual) Angle bracket (optional): ± 45 degrees (manual)

## Dimensions/weights

	AXIAL LENGTH A <sup>1</sup>	MINIMUM RADIAL CLEARANCE B <sup>2</sup>	OVERALL WIDTH C	WEIGHT <sup>3</sup>
<b>609 WFOF</b>	38.7cm (15.25”)	24.8cm (9.75”)	30.5cm (12”)	9.8 kgs (21.5 lbs)
<b>609 WPPP</b>	37.5cm (14.75”)	24.1cm (9.50”)	41.3cm (16.25”)	11.6 kgs (26.5 lbs)
<b>609 WFOH</b>	66.7cm (26.25”)	26.7cm (10.5”)	36.8cm (14.5”)	14.4 kgs (31.75 lbs)



<sup>1</sup> Center of oscillation stroke

<sup>2</sup> Center of vertical stroke

<sup>3</sup> Weight without wire spool (WFOH). Includes 1.6 kg (3.5 lb.) of Torch Cable Weight (Partial)