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

<table>
<thead>
<tr>
<th>Deposition Rate*</th>
<th>Deposition Efficiency</th>
<th>Duty Cycle Factors</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weld metal deposition per hour</td>
<td>Ratio of weight of weld metal deposited to the weight used</td>
<td>The ratio of arc hours to clock hours for a welder or welding operator (Arc on Time)</td>
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<tr>
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### Pipeliner Typical Parameters
- 24–29V, 220–240A
- 5.1–7.6 m/min. (200–300 rpm)
ORBITAL WELD HEAD FOR MULTI PASS GMAW/FCAW PIPE WELDING

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**HIGH DEPOSITION RATE WITHOUT SACRIFICING QUALITY – AUTOMATICALLY**

**DEPOSITION RATE**
Weld metal deposition per hour

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**DEPOSITION EFFICIENCY**
Ratio of weight of weld metal deposited to the weight used

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

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**PIPELINER TYPICAL PARAMETERS**
- 24-29V, 220-260A
- 5.1–7.6m/min. (200–300 rpm)
Specifications

Application
Pipe size – 168 mm (6.625") and larger
Pipe wall thickness – unlimited
Flx-Track™ for welding on flat and curved surfaces

OSCILLATION MODULE (LINEAR)
Output rating
0 – 51 mm (2")

Oscillation speed
0 – 2540 mm/min. (100 ipm)

Oscillation dwell
0 – 1 second. Independently adjustable at both stroke endpoints

Cross seam adjustment
± 25 mm (1.0")

OSCILLATION MODULE (PENDULAR)
Allows sockets/fillet welding
Cross seam adjustment
± 20 degrees

Torch vertical motion module
Stroke: 66 mm (2.625") (motorized)
Speed: 1520 mm/min. (60 ipm) maximum

Tractor module
Poly-Track® propulsion (patented)
Speed capability
0 – 762 mm/min. (30 ipm). Higher speed motors available
Travel direction
Switch selectable (on head)

Wire
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)

Water-cooled torch
Amperage capability: 300 amps continuous. Uses standard torch components

Torch adjustment capability
Torch lead/lag adjustment: ± 15 degrees (manual)
Torch tilt adjustment: ± 10 degrees (manual)
Angle bracket (optional): ± 45 degrees (manual)

Dimensions/weights

<table>
<thead>
<tr>
<th>Pipe Type</th>
<th>Axial Length A</th>
<th>Minimum Radial Clearance B</th>
<th>Overall Width C</th>
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</tr>
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<tr>
<td>609 WFOF</td>
<td>38.7cm (15.25&quot;)</td>
<td>24.8cm (9.75&quot;)</td>
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<td>24.1cm (9.50&quot;)</td>
<td>41.3cm (16.25&quot;)</td>
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1 Center of oscillation stroke
2 Center of vertical stroke
3 Weight without wire spool (WFOH). Includes 1.6 kg (3.5 lb.) of Torch Cable Weight (Partial)

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

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

Applications
Gas, Oil, Water Pipelines
Steam Piping
Chemical
Large Diameter Vessels

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

Applications
• Flowlines and Risers
• Offshore Platforms – Jackets and Topsides
• Tubular Structures, Pilings

Pipe size – 168 mm (6.625") and larger
Pipe wall thickness – unlimited
Flx-Track™ for welding on flat and curved surfaces

OPTIONS
• Pendular Oscillator positioned for fillet welds
• Optional Torch Angle Bracket for fillet and socket weld applications

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