



PIPELINER II 609

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

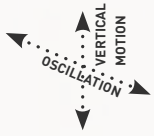
The Magnatech Pipeliner II is designed to make pipe-to-pipe and pipe-to-fitting welds. Interchangeable guide rings mount the head on the pipe, allowing a broad workpiece size range from 168 – 1524 mm (6" – 60") and larger. The Pipeliner II improves productivity by increasing duty cycle, reducing repair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

- Generates high quality welds
- Simple to understand operation
- Can be operated by non-qualified/non-English speaking labor
- Extremely rugged design
- Push-pull system ensures positive wire feeding

PIPELINER II 609

TORCH OSCILLATION (WEAVE)

Width, speed, and endpoint "dwell" independently programmable. Electronic torch "cross seam" steering.



WATER-COOLED TORCH 300 A

PUSH-PULL WIRE FEED HEAD

POSITIVE WIRE DRIVE SYSTEM

Guarantees uniform rotation speed. Two heads can be mounted simultaneously on one guide ring*.

SPECIFICATIONS

*Guide rings come with a one year warranty

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)	
Oscillation stroke amplitude	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 (optional)
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
Cable length	Wire feeder push-pull – 7.6 m (25') standard
Torch adjustment capability	Torch lead/lag adjustment: ± 15 degrees (manual) Torch tilt adjustment: ± 10 degrees (manual) Angle bracket (optional): ± 45 degrees (manual)



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