

HELIX TRACKS

FOR ORBITAL & FLAT TRACK WELDING



HELIX Flat Track



HELIX Outside Diameter (OD) Orbital Track



HELIX Inside Diameter (ID) Orbital Track

CONSTRUCTED FOR CONSISTENT WELD HEAD TRAVEL

Being a welding expert means knowing that the equipment assigned to the job site is rugged and extremely durable, whether it's for plate or pipe. Lincoln Electric's HELIX® track is available in three types: flat, orbital outside (OD) and orbital inside (ID).

The steel constructed tracks are engineered to allow easy movement of a weld head with minimal adjustment. Track rings can sustain a wide range of temperatures, which is important when working with preheated pipe or in harsh environments. Quick-release latches (OD tracks) and simple bolts (ID tracks) make assembly and dismantling fast and easy in the field or in the shop.

All orbital track rings can be fitted with shoe extensions of various sizes, allowing for a single track ring to cover a range of different pipe sizes. The flat tracks, either standard or custom sizes, can be equipped with various mounting methods, including bolt-on, magnetic attachments and vacuum cups.

Processes »

MIG, Pulsed MIG,
Flux-Cored, GMAW- STT®
GTAW, HW GTAW

Applications »

Structural, Maritime, Power
Generation,
Pipeline, Process Piping,
Construction

Product Numbers »

See the next page for
complete specs

PRODUCT SPECIFICATIONS

Outside Diameter (OD) Quick-Release Track Rings (8" and up)	Part Number	Sections	Shoes	OD Track Shoe Extensions	Part Number
HELIX TRACK RING 8 in (203 mm)	K52000-08	2	4	Shoe Extension Aluminum .25 in (6.35 mm)	K52060-03
HELIX TRACK RING 10 in (254 mm)	K52000-10	2	4	Shoe Extension Aluminum 0.5 in (122.7 mm)	K52060-05
HELIX TRACK RING 12 in (305 mm)	K52000-12	2	6	Shoe Extension Aluminum 1.0 in (25.4 mm)	K52060-10
HELIX TRACK RING 14 in (356 mm)	K52000-14	2	6	Shoe Extension Aluminum 2.0 (50.8 mm)	K52060-20
HELIX TRACK RING 16 in (406 mm)	K52000-16	2	6	Shoe Extension Aluminum 3.0 in (76.2mm)	K52060-30
HELIX TRACK RING 18 in (457 mm)	K52000-18	2	6	Shoe Extension Stainless Steel 0.25 in (6.35 mm)	K52149-03
HELIX TRACK RING 20 in (508 mm)	K52000-20	2	8	Shoe Extension Stainless Steel 0.5 in (122.7 mm)	K52149-05
HELIX TRACK RING 22 in (559 mm)	K52000-22	2	8	Shoe Extension Stainless Steel 1.0 in (25.4 mm)	K52149-10
HELIX TRACK RING 24 in (610 mm)	K52000-24	2	8	Shoe Extension Stainless Steel 2.0 in (50.8 mm)	K52149-20
HELIX TRACK RING 28 in (711 mm)	K52000-28	2	5	Shoe Extension Stainless Steel 3.0 in (76.2mm)	K52149-30
HELIX TRACK RING 32 in (813 mm)	K52000-32	2	5		
HELIX TRACK RING 36 in (914 mm)	K52000-36	4	6		
HELIX TRACK RING 40 in (1016 mm)	K52000-40	4	6		
HELIX TRACK RING 44 in (1118 mm)	K52000-44	4	8		
HELIX TRACK RING 48 in (1219 mm)	K52000-48	4	8		
HELIX TRACK RING 52 in (1321 mm)	K52000-52	4	8		
HELIX TRACK RING 56 in (1422 mm)	K52000-56	4	10		
HELIX TRACK RING 60 in (1524 mm)	K52000-60	4	10		
HELIX TRACK RING 64 in (1626 mm)	K52000-64	4	10		
HELIX TRACK RING 68 in (1727 mm)	K52000-68	6	12		
HELIX TRACK RING 72 in (1829 mm)	K52000-72	6	12		
HELIX TRACK RING 76 in (1930 mm)	K52000-76	6	12		
HELIX TRACK RING 80 in (2032 mm)	K52000-80	6	12		
HELIX TRACK RING 84 in (2134 mm)	K52000-84	6	15		
HELIX TRACK RING 88 in (2235 mm)	K52000-88	6	15		
HELIX TRACK RING 92 in (2337 mm)	K52000-92	6	15		

Larger sizes can be made to order. For inquiries please call: 1-800-770-0063 or email at orbitalsales@lincolnelectric.com

Outside Diameter (OD) Quick-Release Track Rings	PIPE OD in (mm)					
	Shoe Extension Sizes					
	None	-03	-05	-10	-20	-30
HELIX TRACK RING 8 in (203 mm)	8.30 - 8.75 (210.8 - 222.3)	7.80 - 8.57 (198.1 - 217.7)	7.30 - 8.07 (185.4 - 205.0)	6.30 - 7.07 (160.0 - 179.6)	4.30 - 5.07 (109.2 - 128.8)	X
HELIX TRACK RING 10 in (254 mm)	10.30 - 10.75 (261.6 - 273.1)	9.80 - 10.57 (248.9 - 268.5)	9.30 - 10.07 (236.2 - 255.8)	8.30 - 9.07 (210.8 - 230.4)	6.30 - 7.07 (160.0 - 179.6)	4.30 - 5.07 (109.2 - 128.8)
HELIX TRACK RING 12 in (305 mm)	12.30 - 12.75 (312.4 - 323.9)	11.80 - 12.57 (299.7 - 319.3)	11.30 - 12.07 (287.0 - 306.6)	10.30 - 11.07 (261.6 - 281.2)	8.30 - 9.07 (210.8 - 230.4)	6.30 - 7.07 (160.0 - 179.6)
HELIX TRACK RING 14 in (356 mm)	13.55 - 14.00 (344.2 - 355.6)	13.05 - 13.82 (331.5 - 351.0)	12.55 - 13.32 (318.8 - 338.3)	11.55 - 12.32 (293.4 - 312.9)	9.55 - 10.32 (242.6 - 262.1)	7.55 - 8.32 (191.8 - 211.3)
HELIX TRACK RING 16 in (406 mm)	15.55 - 16.00 (395.0 - 406.4)	15.05 - 15.82 (382.3 - 401.8)	14.55 - 15.32 (369.6 - 389.1)	13.55 - 14.32 (344.2 - 363.7)	11.55 - 12.32 (293.4 - 312.9)	9.55 - 10.32 (242.6 - 262.1)
HELIX TRACK RING 18 in (457 mm)	17.55 - 18.00 (445.8 - 457.2)	17.05 - 17.82 (433.1 - 452.6)	16.55 - 17.32 (420.4 - 439.9)	15.55 - 16.32 (395.0 - 414.5)	13.55 - 14.32 (344.2 - 363.7)	11.55 - 12.32 (293.4 - 312.9)
HELIX TRACK RING 20 in (508 mm)	19.55 - 20.00 (496.6 - 508.0)	19.05 - 19.82 (483.9 - 503.4)	18.55 - 19.32 (471.2 - 490.7)	17.55 - 18.32 (445.8 - 465.3)	15.55 - 16.32 (395.0 - 414.5)	13.55 - 14.32 (344.2 - 363.7)
HELIX TRACK RING 22 in (559 mm)	21.55 - 22.00 (547.4 - 558.8)	21.05 - 21.82 (534.7 - 554.2)	20.55 - 21.32 (522.0 - 541.5)	19.55 - 20.32 (496.6 - 516.1)	17.55 - 18.32 (445.8 - 465.3)	"15.55 - 16.32 (395.0 - 414.5)"
HELIX TRACK RING 24 in (610 mm)	23.55 - 24.00 (598.2 - 609.6)	23.05 - 23.82 (585.5 - 605.0)	22.55 - 23.32 (572.8 - 592.3)	21.55 - 22.32 (547.4 - 566.9)	19.55 - 20.32 (496.6 - 516.1)	17.55 - 18.32 (445.8 - 465.3)
HELIX TRACK RING 28 in (711 mm)	27.55 - 28.00 (699.8 - 711.2)	27.05 - 27.82 (687.1 - 706.6)	26.55 - 27.32 (674.4 - 693.9)	25.55 - 26.32 (649.0 - 668.5)	23.55 - 24.32 (598.2 - 617.7)	21.55 - 22.32 (547.4 - 566.9)
HELIX TRACK RING 32 in (813 mm)	31.55 - 32.00 (801.4 - 812.8)	31.05 - 31.82 (788.7 - 808.2)	30.55 - 31.32 (776.0 - 795.5)	29.55 - 30.32 (750.6 - 770.1)	27.55 - 28.32 (699.8 - 719.3)	25.55 - 26.32 (649.0 - 668.5)
HELIX TRACK RING 36 in (914 mm)	35.80 - 36.25 (909.3 - 920.8)	35.30 - 36.07 (896.6 - 916.2)	34.80 - 35.57 (883.9 - 903.5)	33.80 - 34.57 (858.5 - 878.1)	31.80 - 32.57 (807.7 - 827.3)	29.80 - 30.57 (756.9 - 776.5)
HELIX TRACK RING 40 in (1016 mm)	39.80 - 40.25 (1010.9 - 1022.4)	39.30 - 40.07 (998.2 - 1017.8)	38.80 - 39.57 (985.5 - 1005.1)	"37.80 - 38.57 (960.1 - 979.7)"	35.80 - 36.57 (909.3 - 928.9)	33.80 - 34.57 (858.5 - 878.1)
HELIX TRACK RING 44 in (1118 mm)	43.80 - 44.25 (1112.5 - 1124.0)	43.30 - 44.07 (1099.8 - 1119.4)	42.80 - 43.57 (1087.1 - 1106.7)	41.80 - 42.57 (1061.7 - 1081.3)	39.80 - 40.57 (1010.9 - 1030.5)	37.80 - 38.57 (960.1 - 979.7)
HELIX TRACK RING 48 in (1219 mm)	47.80 - 48.25 (1214.1 - 1225.6)	47.30 - 48.07 (1201.4 - 1221.0)	46.80 - 47.57 (1188.7 - 1208.3)	45.80 - 46.57 (1163.3 - 1182.9)	43.80 - 44.57 (1112.5 - 1132.1)	41.80 - 42.57 (1061.7 - 1081.3)
HELIX TRACK RING 52 in (1321 mm)	51.80 - 52.25 (1315.7 - 1327.2)	51.30 - 52.07 (1303.0 - 1322.6)	50.80 - 51.57 (1290.3 - 1309.9)	49.80 - 50.57 (1264.9 - 1284.5)	47.80 - 48.57 (1214.1 - 1233.7)	45.80 - 46.57 (1163.3 - 1182.9)"
HELIX TRACK RING 56 in (1422 mm)	55.80 - 56.25 (1417.3 - 1428.8)	55.30 - 56.07 (1404.6 - 1424.2)	54.80 - 55.57 (1391.9 - 1411.5)	53.80 - 54.57 (1366.5 - 1386.1)	51.80 - 52.57 (1315.7 - 1335.3)	49.80 - 50.57 (1264.9 - 1284.5)
HELIX TRACK RING 60 in (1524 mm)	59.80 - 60.25 (1518.9 - 1530.4)	59.30 - 60.07 (1506.2 - 1525.8)	58.80 - 59.57 (1493.5 - 1513.1)	57.80 - 58.57 (1468.1 - 1487.7)	55.80 - 56.57 (1417.3 - 1436.9)	53.80 - 54.57 (1366.5 - 1386.1)
HELIX TRACK RING 64 in (1626 mm)	63.80 - 64.25 (1620.5 - 1632.0)	63.30 - 64.07 (1607.8 - 1627.4)	62.80 - 63.57 (1595.1 - 1614.7)	61.80 - 62.57 (1569.7 - 1589.3)	59.80 - 60.57 (1518.9 - 1538.5)	57.80 - 58.57 (1468.1 - 1487.7)
HELIX TRACK RING 68 in (1727 mm)	67.80 - 68.25 (1722.1 - 1733.6)	67.30 - 68.07 (1709.4 - 1729.0)	66.80 - 67.57 (1696.7 - 1716.3)	65.80 - 66.57 (1671.3 - 1690.9)	63.80 - 64.57 (1620.5 - 1640.1)	61.80 - 62.57 (1569.7 - 1589.3)
HELIX TRACK RING 72 in (1829 mm)	71.80 - 72.25 (1823.7 - 1835.2)	71.30 - 72.07 (1811.0 - 1830.6)	70.80 - 71.57 (1798.3 - 1817.9)	69.80 - 70.57 (1772.9 - 1792.5)	67.80 - 68.57 (1722.1 - 1741.7)	65.80 - 66.57 (1671.3 - 1690.9)
HELIX TRACK RING 76 in (1930 mm)	75.55 - 76.00 (1919.0 - 1930.4)	75.05 - 75.82 (1906.3 - 1925.8)	74.55 - 75.32 (1893.6 - 1913.1)	73.55 - 74.32 (1868.2 - 1887.7)"	71.55 - 72.32 (1817.4 - 1836.9)	69.55 - 70.32 (1766.6 - 1786.1)
HELIX TRACK RING 80 in (2032 mm)	79.80 - 80.25 (2026.9 - 2038.4)	79.30 - 80.07 (2014.2 - 2033.8)	78.80 - 79.57 (2001.5 - 2021.1)	77.80 - 78.57 (1976.1 - 1995.7)	75.80 - 76.57 (1925.3 - 1944.9)	73.80 - 74.57 (1874.5 - 1894.1)
HELIX TRACK RING 84 in (2134 mm)	83.80 - 84.25 (2128.5 - 2140.0)	83.30 - 84.07 (2115.8 - 2135.4)	82.80 - 83.57 (2103.1 - 2122.7)	81.80 - 82.57 (2077.7 - 2097.3)	79.80 - 80.57 (2026.9 - 2046.5)	77.80 - 78.57 (1976.1 - 1995.7)
HELIX TRACK RING 88 in (2235 mm)	87.55 - 88.00 (2223.8 - 2235.2)	87.05 - 87.82 (2211.1 - 2230.6)	86.55 - 87.32 (2198.4 - 2217.9)	85.55 - 86.32 (2173.0 - 2192.5)	83.55 - 84.32 (2122.2 - 2141.7)	81.55 - 82.32 (2071.4 - 2090.9)
HELIX TRACK RING 92 in (2337 mm)	91.80 - 92.25 (2331.7 - 2343.2)	91.30 - 92.07 (2319.0 - 2338.6)	90.80 - 91.57 (2306.3 - 2325.9)	89.80 - 90.57 (2280.9 - 2300.5)	87.80 - 88.57 (2230.1 - 2249.7)	85.80 - 86.57 (2179.3 - 2198.9)

Inside Diameter (ID) Quick-Release Track Rings	Part Number	Sections	Shoes	ID Track Shoe Extensions	Part Number
HELIX Track Ring 36 in (914 mm)	K52218-36	6	6	ID Track Shoe Extension 0.5 in (12.7mm)	K52256-05
HELIX Track Ring 39 in (991 mm)	K52218-39	6	6	ID Track Shoe Extension 0.75 in (19.5 mm)	K52256-08
HELIX Track Ring 42 in (1067 mm)	K52218-42	6	6	ID Track Shoe Extension 1.0 in (25.4 mm)	K52256-10
HELIX Track Ring 45 in (1143 mm)	K52218-45	6	6	ID Track Shoe Extension 2.0 in (50.8 mm)	K52256-20
HELIX Track Ring 48 in (1219 mm)	K52218-48	6	6		
HELIX Track Ring 51 in (1295 mm)	K52218-51	6	6		
HELIX Track Ring 54 in (1371 mm)	K52218-54	6	6		
HELIX Track Ring 57 in (1447 mm)	K52218-57	6	6		
HELIX Track Ring 60 in (1524 mm)	K52218-60	6	6		
HELIX Track Ring 63 in (1600 mm)	K52218-63	6	6		
HELIX Track Ring 66 in (1676 mm)	K52218-66	6	6		
HELIX Track Ring 69 in (1752 mm)	K52218-69	6	6		
HELIX Track Ring 72 in (1828 mm)	K52218-72	6	6		
HELIX Track Ring 75 in (1905 mm)	K52218-75	6	6		
HELIX Track Ring 78 in (1981 mm)	K52218-78	6	6		
HELIX Track Ring 81 in (2057 mm)	K52218-81	6	6		
HELIX Track Ring 84 in (2133 mm)	K52218-84	6	6		
HELIX Track Ring 87 in (2210 mm)	K52218-87	6	6		
HELIX Track Ring 90 in (2286 mm)	K52218-90	6	6		
HELIX Track Ring 93 in (2362 mm)	K52218-93	6	6		

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Inside Diameter (ID) Quick-Release Track Rings	PIPE ID in (mm) Shoe Extension				
	None	-05	-08	-10	-20
HELIX Track Ring 36 in (914 mm)	38.71 - 39.72 (983.2 - 1008.9)	39.71 - 40.72 (1008.6 - 1034.3)	40.21 - 41.22 (1021.3 - 1047.0)	40.71 - 41.72 (1034.0 - 1059.7)	42.71 - 43.72 (1084.8 - 1110.5)
HELIX Track Ring 39 in (991 mm)	41.71 - 42.72 (1059.4 - 1085.1)	42.71 - 43.72 (1084.8 - 1110.5)	43.21 - 44.22 (1097.5 - 1123.2)	43.71 - 44.72 (1110.2 - 1135.9)	45.71 - 46.72 (1161.0 - 1186.7)
HELIX Track Ring 42 in (1067 mm)	44.71 - 45.72 (1135.6 - 1161.3)	45.71 - 46.72 (1161.0 - 1186.7)	46.21 - 47.22 (1173.7 - 1199.4)	46.71 - 47.72 (1186.4 - 1212.1)	48.71 - 49.72 (1237.2 - 1262.9)
HELIX Track Ring 45 in (1143 mm)	47.71 - 48.72 (1211.8 - 1237.5)	48.71 - 49.72 (1237.2 - 1262.9)	49.21 - 50.22 (1249.9 - 1275.6)	49.71 - 50.72 (1262.6 - 1288.3)	51.71 - 52.72 (1313.4 - 1339.1)
HELIX Track Ring 48 in (1219 mm)	50.71 - 51.72 (1288.0 - 1313.7)	51.71 - 52.72 (1313.4 - 1339.1)	52.21 - 53.22 (1326.1 - 1351.8)	52.71 - 53.72 (1338.8 - 1364.5)	54.71 - 55.72 (1389.6 - 1415.3)
HELIX Track Ring 51 in (1295 mm)	53.71 - 54.72 (1364.2 - 1389.9)	54.71 - 55.72 (1389.6 - 1415.3)	55.21 - 56.22 (1402.3 - 1428.0)	55.71 - 56.72 (1415.0 - 1440.7)	57.71 - 58.72 (1465.8 - 1491.5)
HELIX Track Ring 54 in (1371 mm)	56.71 - 57.72 (1440.4 - 1466.1)	57.71 - 58.72 (1465.8 - 1491.5)	58.21 - 59.22 (1478.5 - 1504.2)	58.71 - 59.72 (1491.2 - 1516.9)	60.71 - 61.72 (1542.0 - 1567.7)
HELIX Track Ring 57 in (1447 mm)	59.71 - 60.72 (1516.6 - 1542.3)	60.71 - 61.72 (1542.0 - 1567.7)	61.21 - 62.22 (1554.7 - 1580.4)	61.71 - 62.72 (1567.4 - 1593.1)	63.71 - 64.72 (1618.2 - 1643.9)
HELIX Track Ring 60 in (1524 mm)	62.71 - 63.72 (1592.8 - 1618.5)	63.71 - 64.72 (1618.2 - 1643.9)	64.21 - 65.22 (1630.9 - 1656.6)	64.71 - 65.72 (1643.6 - 1669.3)	66.71 - 67.72 (1694.4 - 1720.1)
HELIX Track Ring 63 in (1600 mm)	65.71 - 66.72 (1669.0 - 1694.7)	66.71 - 67.72 (1694.4 - 1720.1)	67.21 - 68.22 (1707.1 - 1732.8)	67.71 - 68.72 (1719.8 - 1745.5)	69.71 - 70.72 (1770.6 - 1796.3)
HELIX Track Ring 66 in (1676 mm)	68.71 - 69.72 (1745.2 - 1770.9)	69.71 - 70.72 (1770.6 - 1796.3)	70.21 - 71.22 (1783.3 - 1809.0)	70.71 - 71.72 (1796.0 - 1821.7)	72.71 - 73.72 (1846.8 - 1872.5)
HELIX Track Ring 69 in (1752 mm)	71.71 - 72.72 (1821.4 - 1847.1)	72.71 - 73.72 (1846.8 - 1872.5)	73.21 - 74.22 (1859.5 - 1885.2)	73.71 - 74.72 (1872.2 - 1897.9)	75.71 - 76.72 (1923.0 - 1948.7)
HELIX Track Ring 72 in (1828 mm)	74.71 - 75.72 (1897.6 - 1923.3)	75.71 - 76.72 (1923.0 - 1948.7)	76.21 - 77.22 (1935.7 - 1961.4)	76.71 - 77.72 (1948.4 - 1974.1)	78.71 - 79.72 (1999.2 - 2024.9)
HELIX Track Ring 75 in (1905 mm)	77.71 - 78.72 (1973.8 - 1999.5)	78.71 - 79.72 (1999.2 - 2024.9)	79.21 - 80.22 (2011.9 - 2037.6)	79.71 - 80.72 (2024.6 - 2050.3)	81.71 - 82.72 (2075.4 - 2101.1)
HELIX Track Ring 78 in (1981 mm)	80.71 - 81.72 (2050.0 - 2075.7)	81.71 - 82.72 (2075.4 - 2101.1)	82.21 - 83.22 (2088.1 - 2113.8)	82.71 - 83.72 (2100.8 - 2126.5)	84.71 - 85.72 (2151.6 - 2177.3)
HELIX Track Ring 81 in (2057 mm)	83.71 - 84.72 (2126.2 - 2151.9)	84.71 - 85.72 (2151.6 - 2177.3)	85.21 - 86.22 (2164.3 - 2190.0)	85.71 - 86.72 (2177.0 - 2202.7)	87.71 - 88.72 (2227.8 - 2253.5)
HELIX Track Ring 84 in (2133 mm)	86.71 - 87.72 (2202.4 - 2228.1)	87.71 - 88.72 (2227.8 - 2253.5)	88.21 - 89.22 (2240.5 - 2266.2)	88.71 - 89.72 (2253.2 - 2278.9)	90.71 - 91.72 (2304.0 - 2329.7)
HELIX Track Ring 87 in (2210 mm)	89.71 - 90.72 (2278.6 - 2304.3)	90.71 - 91.72 (2304.0 - 2329.7)	91.21 - 92.22 (2316.7 - 2342.4)	91.71 - 92.72 (2329.4 - 2355.1)	93.71 - 94.72 (2380.2 - 2405.9)
HELIX Track Ring 90 in (2286 mm)	92.71 - 93.72 (2354.8 - 2380.5)	93.71 - 94.72 (2380.2 - 2405.9)	94.21 - 95.22 (2392.9 - 2418.6)	94.71 - 95.72 (2405.6 - 2431.3)	96.71 - 97.72 (2456.4 - 2482.1)
HELIX Track Ring 93 in (2362 mm)	95.71 - 96.72 (2431.0 - 2456.7)	96.71 - 97.72 (2456.4 - 2482.1)	97.21 - 98.22 (2469.1 - 2494.8)	97.71 - 98.72 (2481.8 - 2507.5)	99.71 - 100.72 (2532.6 - 2558.3)

Flat Track	Part Number
HELIX Flat Track 18 in (457.2 mm)	K52083-18
HELIX Flat Track 48 in (1219 mm)	K52083-48*
HELIX Flat Track 48 in (1219 mm) w/Magnetic Shoes	K52090-1

* HELIX 48" Flat Track includes (3) three 5/16"-18 threaded feet for permanent mounting

ACCESSORIES

Flat Track Shoes	Part Number
Flat Track Magnetic Shoe	K52089-1
Flat Track Vacuum Shoe	K52227-1

ADDITIONAL TRACK OPTIONS

48" Flat Track - The tracks can be bolted together to the length required

Inside Diameter - For inside diameter welding on pipes larger than 30 inches

Partial Tracks - For some pipe sizes, partial tracks are the easiest and most cost-effective solution

Magnetic Shoes - For flat tracks and partial track rings, these magnetic shoes hold the ring on ferrous materials

CUSTOMER ASSISTANCE POLICY

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