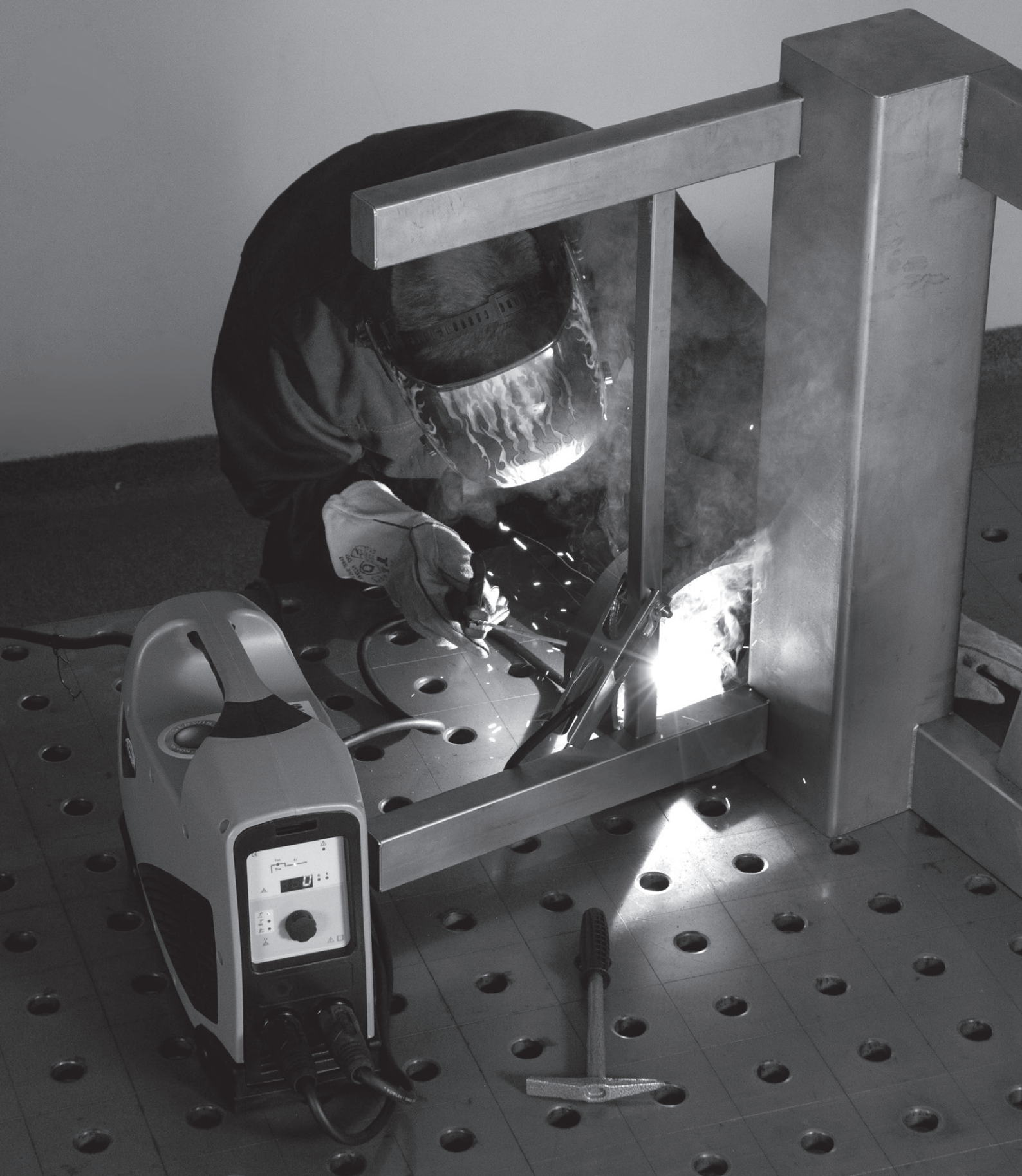


# 01



# WELDING EQUIPMENT AND ACCESSORIES

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## 1. MIG/MAG equipment and torches

### 1.1. MIG/MAG equipment



#### MOST Inverter semi-automatic welding machine Fanmig 175i



Fanmig 175i is the smallest in the family of semi-automatic welding machines MOST, and the first inverter device among them. Allows together with MAG welding to weld with electrode MMA and TIG. Small size and weight make it ideal for repair work, not just for handyman.

Fanmig 175i is an inverter type semi-automat welding unit dedicated for MIG welding in gas shield, MMA (stick) welding with coated electrode or Lift TIG welding. It is possible to weld with reversed polarity e.g. MIG self-shielded flux cored wire. It is a compact unit in which two-roll wire feeder and power source are located in one cover.

The device has excellent welding parameters and a wide range of applications.

It can be used in:

- **MIG / MAG (synergistic/welding)**

Used for welding of carbon steel or stainless steel with recommended wire diameters from 0.6 mm to 1.0 mm.

Wire feed speed can be set from 2 up to 12 m/min., welding current has stepless (fluent) regulation. The wire feeder is dedicated for 5 kg or 1 kg spools, basket spools require an additional adapter.

- **MMA electrode welding**

Recommended electrode diameter from 2.0 to 3.25 mm, 4.0 mm sporadically. Electrodes with rutile or basic coating (open circuit voltage  $U = 56$  V), used for carbon steel or stainless steel.

- **Lift TIG (DC) welding**

The gas valve opens on the torch handle. For welding stainless or carbon steel, recommended diameter of tungsten electrode 1.6 or 2.4 mm.

Model	FANMIG 175i
Main voltage	1x230 V 50/60 Hz
Maximal power consumption	28 A
Effective power	20 A
Power factor	0,73
Power	6,4 kVA
Open circuit voltage $U_0$	56 V
Range of welding current:	
▪ MMA	20–175 A
▪ TIG	10–175 A
▪ MIG	50–175 A
Welding current at duty cycle:	
▪ MIG	175 A/22,8 V /35% 135 A/20,7 V /60% 103 A/19,2 V /100%
▪ MMA	175 A/25% 113 A/60% 87 A/100%
▪ TIG	175 A/35% 135 A/60% 103 A/100%
Welding power regulation	Steeplles
Protection class	IP 23S
Wire feed speed	2–12 m/min
Wire feeder	2-rolls
Wire diameters steel	0,6–0,8–1,0 mm
Spool wire	5 kg
Weight	12,8 kg
Dimensions (LxWxH)	420x220x439 mm
Catalogue no.	51 00 020150

Simple control panel with display



1	Choosing of welding method MMA/LIFT TIG/MIG
2	Controlling wire speed
3	VRD/2-T/4-T switch key
4	Data selection key (effective under MIG mode)
5	Multifunctional data adjusting knob (coarse adjustment by pressing the knob and turning it)
6	Multifunctional data display

**Assembling:** device with earth and electrode cables, wire feeder rollers for 0,8-1,0 mm, and gas nipple.

**Recommended accessories:**

- Torch MIG/MAG M15 SGRIP, M25 SGRIP
- Torch TIG 17V (F175) 4 m: 56 03 011110
- Welding trolley WUS-150 MOST: 50 03 003900



For rollers for wire feeders see page 16.



## Inverter semi-automatic welding machines from series i-FANMIG Fanmig 3200i / 3200i mobil / 2500i

MOST brings you a series of new inverter power source – Fanmig 2500i, Fanmig 3200i and Fanmig 3200i mobil – designed for MIG/MAG welding or coated-electrode MMA.

i-Fanmig is a compact device: source power and wire feeder are placed inside in one cover. Fanmig 2500i and Fanmig 3200i are equipped with chassis with a shell for gas cylinder, while Fanmig 3200i mobil has cover reduced to the size of large wire feeder.

All welding machines have 4-roll wire feeders and are suitable for wire welding that uses 15 kg or 5 kg spools. i-Fanmig devices are designed for light industry and crafts, with usage of gas-cooled welding torch.

There are three operation modes: synergic MAG, manual MIG/MAG and MMA. After selecting the synergistic mode and appropriate program mode, adjustment in one parameter generates changes in other parameters, which are necessary for proper welding techniques. 12 welding programs for MAG welding available.



Scan to visit our website  
<http://www.rywa.eu/f01>



Simple and modern panel control



Two multifunctional knobs to set parameters.

Liquid crystal displays show parameters while setting, and welding parameters in operation mode.

LED (next to display) informs which parameter is shown and its units: A, V, or s.

Program Memory buttons (1-6) allow you to save up to 6 custom programs.

Model	Fanmig 2500i		Fanmig 3200i / Fanmig 3200i mobil	
Type of welding current	MIG/MAG	MMA	MIG/MAG	MMA
Main voltage	3x400 V/ 50/60 Hz	3x400 V/ 50/60 Hz	3x400 V/ 50/60 Hz	3x400 V/ 50/60 Hz
Fuse	16 A	16 A	16 A	16 A
Maximal power consumption I <sub>h</sub>	16,4 A	18,2 A	23,4 A	22,9 A
Effective power I	12,9 A	13,0 A	12,9 A	12,8 A
Range of welding current	20-250 A	30-250 A	20-315 A	30-300 A
Open circuit voltage U <sub>0</sub>	54,4 V	54,4 V	63,1 V	63,1 V
Welding current:				
▪ at 100% duty cycle	210 A	190 A	210 A	190 A
▪ at 60% duty cycle	250 A	230 A	250 A	230 A
▪ at maximum power	60% / 250 A	50% / 250 A	25% / 315 A	20% / 300 A
Welding power regulation	steeples	steeples	steeples	steeples
Wire feeder	4-rolls	4-rolls	4-rolls	4-rolls
Feeding speed	1 – 17 m/min	-	1 – 17 m/min 1 – 15 m/min (mobil)	-
Welding torch cooling	air	air	air	air
Welding torch (optional)	M24 or M25 MOST		M24, M25 or M36 MOST	
Weight	47,6 kg		47,6 kg / 26,6 kg (mobil)	
Protection class	IP 23S		IP 23S	
Insulation class	H		H	
Dimensions (LxWxH)	868 x 500 x 806 mm		868 x 500 x 806 mm / 240 x 650 x 438 mm (mobil)	
Catalogue no.	51 00 023705		51 00 023715 / 51 00 023720 (mobil)	

Equipment is delivered in cardboard box. Delivery includes power-supply plug (CEE 16A), earth cable, gas hose and self-assembly holder for the front panel. Feeder is provided with rolls for steel-wire welding (0,8-1,0 mm).





## MOST semi-automatic welding machines FANMIG IV

MOST proudly presents a series of professional semi-automatic welding machines Fanmig IV MOST designed for industry and crafts. As a result of many tests conducted on selected machines a number of modifications have been made. Upgraded machines are therefore produced under the MOST brand to satisfy both our and customers specific demands. Machines are designed for welding of carbon, stainless steel and aluminum (after retooling the welding torch and feeder). Transformer windings are made of cooper and therefore provide high welding quality. They all have built-in fans for cooling and thermal switches protecting the equipment against overloading. The devices have been equipped with three different kinds of latest technology control panels BASIC, MINOR and SYNERGY.



### Main functions of FANMIG IV semi-automatic welding machines:

- Compact machines with built-in or separated wire feeder (FANMIG 404GP, FANMIG 404WP and FANMIG 504WP),
- 2 or 4 rolls wire feeding systems,
- 3x400 V main voltage,
- Water cooled (WP models) or air cooled,
- Enable welding with solid and fluxed-cored wires, argon or gas mixture shield,
- Standard cable length (source – feeder) 5 m (extended up to 20 m available on request),
- Euro-sockets suitable for any welding torches,
- Ergonomic design, front panel integrated with carrying handle,
- One of front wheels includes a brake (except FANMIG 200-2 BASIC),
- FANMIG MOST machines have 2 years guarantee from the date of purchase.

BASIC control panel



**Functions available with BASIC control panel (model FANMIG 200-2):**

- step regulation of welding current,
- fluent regulation of wire feeding,
- continuous welding, spot and internal welding,
- 2 rolls wire feed mechanisms.

MINOR control panel



**Functions available with MINOR control panel:**

- digital display,
- 4 rolls wire feed mechanisms,
- values for starting (speed of wire, gas pre-flow / gas past-flow and wire burning-off time) are to be set by manufacturer according to specific customers demands,
- adjustment for gas flow and feeding of wire from a new spool,
- all the above mentioned settings can be set on with a single knob on the control panel.

SYNERGY control panel



**Functions available with SYNERGY also include:**

- 9 synergic programs for steel welding (program setting according to welding current A, wire feeding speed m/min or material thickness),
- digital displays of welding current,
- A+V with HOLD function provide values of all adjustable parameters.

Model	FANMIG 200-2 BASIC	FANMIG 280-4N MINOR	FANMIG 320-4N MINOR	FANMIG 400-4N SYNERGY	FANMIG 404GP SYNERGY	FANMIG 404WP SYNERGY	FANMIG 504WP SYNERGY
Main voltage	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V
Fuse	10 A	16 A	25 A	32 A	32 A	32 A	32 A
Range of welding current	60-180 A	40-290 A	40-340 A	40-400 A	40-400 A	40-400 A	60-530 A
Duty cycle	40%	30%	25%	25%	30%	30%	25%
Welding current:							
▪ 60% duty cycle	150 A	210 A	230 A	290 A	320 A	320 A	390 A
▪ 100% duty cycle	130 A	170 A	200 A	240 A	260 A	260 A	330 A
Welding range steps	7	10	12	20	20	20	30
Protection class	IP 23S	IP 23S	IP 23S	IP 23S	IP 23S	IP 23S	IP 23S
Wire feeder	2- rolls	4- rolls	4- rolls	4- rolls	4- rolls separated	4- rolls separated	4- rolls separated
Feeding speed	1-19 m/min	1-19 m/min	1-19 m/min	1-19 m/min	1-25 m/min	1-25 m/min	1-25 m/min
Wire diameters:							
▪ steel	0,6- 1,0 mm	0,8- 1,0 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,6 mm
▪ stainless steel	0,6- 1,0 mm	0,8- 1,0 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,2 mm	0,8- 1,6 mm
▪ aluminum	-	1,0- 1,2 mm	1,0- 1,2 mm	1,0- 1,2 mm	1,0- 1,2 mm	1,0- 1,2 mm	1,0- 1,6 mm
Weight	61 kg	88 kg	99 kg	109 kg	106 + 18 kg	126 + 18 kg	161 + 18 kg
Dimensions (LxWxH)	474x888x561 mm	500x868x806 mm	500x868x806 mm	500x868x806 mm	607x873x803 mm feeder 245x700x450 mm	607x873x803 mm feeder 245x700x450 mm	875x572x874 mm feeder 245x700x450 mm
Catalogue no.	51 00 022200	51 00 022294	51 00 022334	51 00 022420	51 00 023414	51 00 023424	51 00 023504

Delivery set includes earth cables and a power-supply cable (3 m). The cables connect the power source and the feeder (5 m) supplied with Fanmig 404GP, Fanmig 404WP & Fanmig 504WP versions. Other lengths of cables are available on request.

We also offer standard welding torches designed for Fanmig machines. Available torch lengths are 3 m, 4 m and 5 m.

**Welding torch options:**

- FANMIG 200-2 BASIC: M15 or M25 MOST.
- FANMIG 320-4 MINOR, 400-4 SYNERGY: M24 or M36 MOST.
- FANMIG 404GP: M36 MOST or M38 MOST.
- FANMIG 404WP, 504WP SYNERGY: M401 or M501 MOST.





## Inverter semi-automatic welding machine Fanmig 502i



In our offer of equipment under MOST brand we have a new inverter power source for MIG/MAG, TIG DC and MMA coated electrode welding- Fanmig 502i.

The device is a modular weld fixture: power source is mounted on the cooler, on which is installed undercarriage. Separated wire feeder is connected to the standard power source using 5-meter composite cable. Other lengths of intermediate cables are available on request.

Fanmig 502i is designed for industrial welding. Welding current 500 A/40% for both, MIG/MAG welding and for coated electrode MMA welding, is appropriate for every user. The unit can be also used for electro-gouging. TIG DC welding in two options: normal or pulse. TIG arc ignition starts with the grinding of tungsten electrode on material (Liftarc).

Semi-automatic Fanmig 502i is a digitally controlled synergic device. After selecting the synergic mode and appropriate program mode, adjustment in one parameter generates changes in other parameters which are necessary for proper welding techniques.

MMA electrode welding can be conducted after selecting the right program, matching electrode types and diameters. In electrode welding, it is important to have device equipped with VRD function (turn-off option), which reduces the unloaded open circuit approximately to 20 V due to safety reasons. For MIG/MAG, MMA and TIG, it is possible turn off synergic mode and switch to the manual welding. Modern and easy to operate. Panel control and parameters' displays are located on both, wire feeder and power source. Two knobs for setting the welding current and arc length in the front of the wire feeder. Welding program selection is performed on the modern panel, located in the middle of wire feeder. Liquid cooling system is situated at the bottom of the device, which prevents damage of power and electronic equipment in case of leakage. Liquid flow sensor, which protects the welding torch in case there is no coolant circulating.

The unit is characterized by ergonomic work program. Power source situated in the mandrel enables free rotation of the wire feeder. Short and thin shape of the wire feeder makes it suitable for welding in hard-to-reach places. On the device's side, there is a special shelf-hanger, e.g. for intermediate tool storage. Special socket connections which prevent intermediate cables from being pulled out of wire feeder's or power source sockets. The device is equipped with wheels for easy carrying and transportation.



**Assembling:** The device is delivered in cardboard box with power source, cooler, trolley, wire feeder, earth cable, and intermediate cable (5 m). Power supply cable provided with 32 CEE plug.

### Accessories:

- welding torches – recommended torches MOST 501 SGRIP 3; 4 lub 5 m,
- rolls Ø 40 mm (page 16),
- water hose set 10 m- catalogue no. 51 00 024010,
- water hose set 15 m- catalogue no. 51 00 024015.

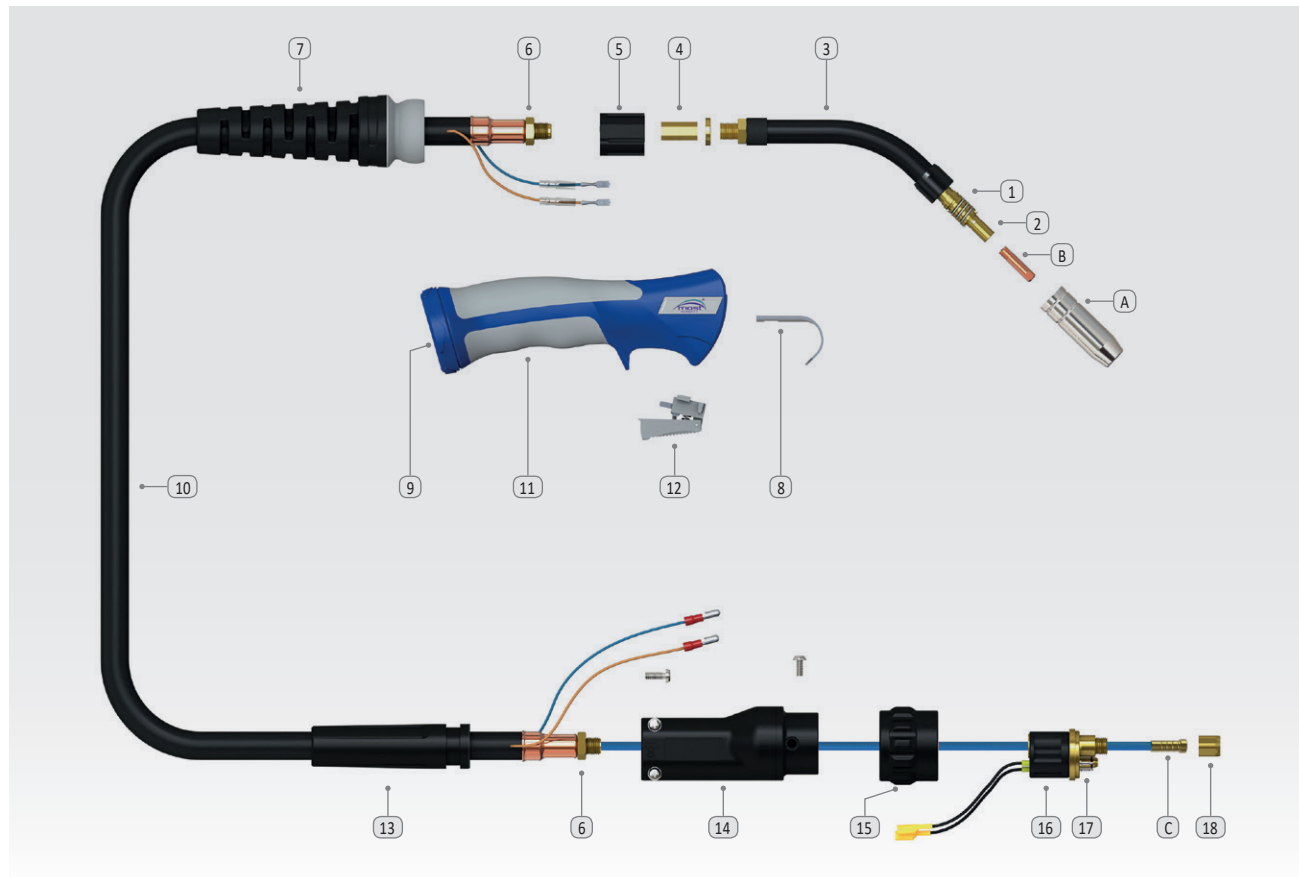
Model	FANMIG 502i
Main voltage	3x400 V / 50/60 Hz
Max. power consumption	38 A
Effective power I <sub>e</sub>	24 A
Power factor	0,9
Open circuit voltage MMA U <sub>o</sub>	72 V
Range of welding current:	
▪ MIG	20- 500 A
▪ MMA	20- 500 A
▪ TIG	5- 500 A
Welding range at 40% / 100% duty cycle	
▪ MIG	500 A (40 V) / 316 A (29,8 V)
▪ MMA	500 A (40 V) / 316 A (32,6 V)
▪ TIG	500 A (30 V) / 316 A (22,6 V)
Welding power source	Stepless/fluient
Protection class	IP 23S
Feeding speed	1-25 m
Feeder	4-rolls
Wire diameters:	
▪ Steel	0,8-0,9-1,0-1,2-1,6 mm
▪ Aluminium	1,0-1,2 mm
▪ Brazing	0,8-0,9-1,0-1,2 mm
Spool of wire	15 kg
Dimensions/weight:	
▪ power source	520x310x500 mm / 36 kg
▪ power source, cooler and trolley	520x940x900 mm / 70 kg
▪ power source, cooler, trolley, feeder and intermediate cables	20x940x1320 mm / 92 kg
Catalogue no.	51 00 023850



1.2. MIG/MAG torches



M15 SGRIP



Model	M15 SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current At 60% duty cycle	180 A- CO <sub>2</sub> 150 A- mix M21
▪ Diameter of wire	0,6- 1,0 mm
Length/ Catalogue no.	3,0 m / 55 08 301530 4,0 m / 55 08 301540 5,0 m / 55 08 301550

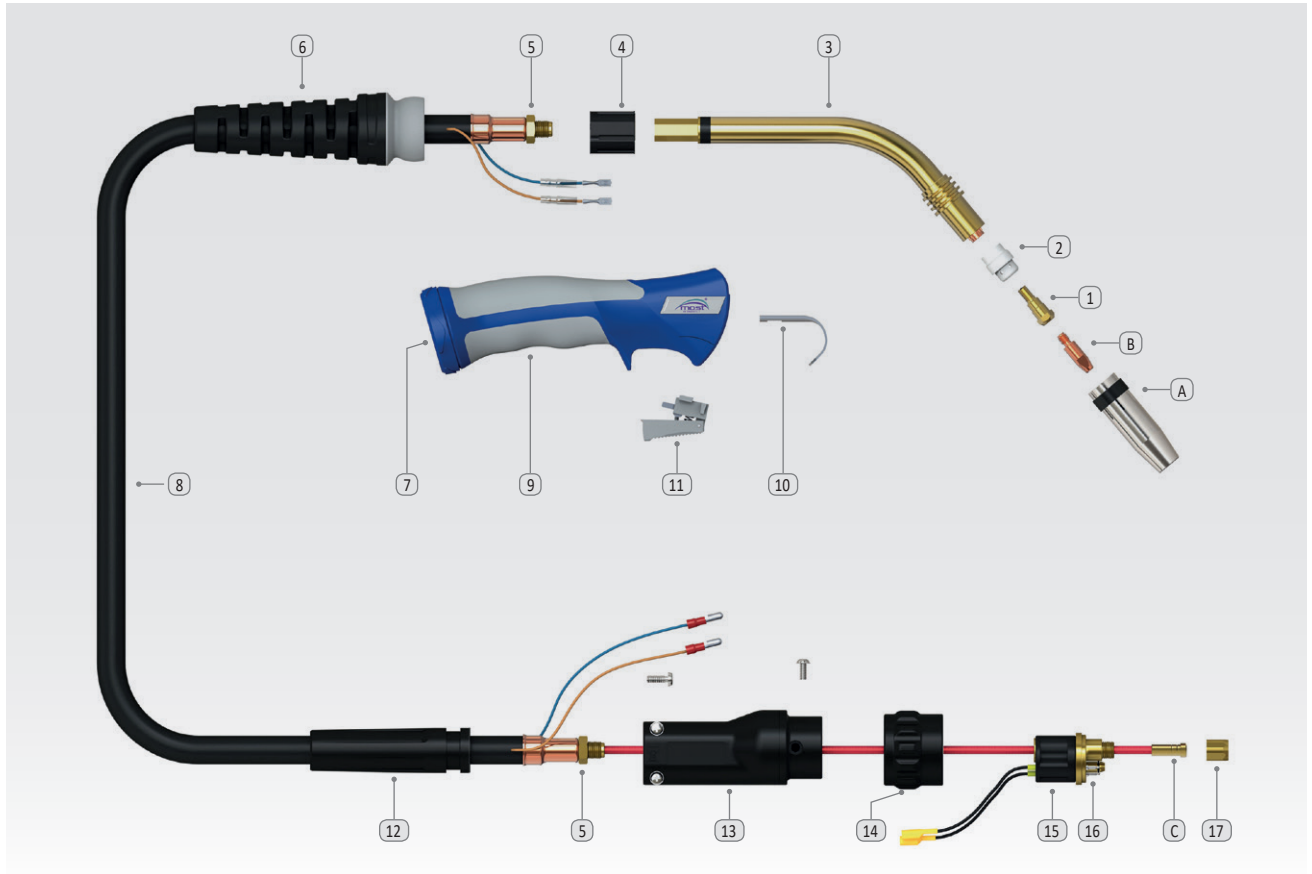
No.	Spare parts	Catalogue no.
A	Cylindrical nozzle Ø16	55 12 300885
	Conical nozzle*	55 12 300890
	Tapered nozzle Ø9,5	55 12 300880
	Gas spot welding nozzle	55 12 300882
1	Spring*	55 13 008340
2	Tip adaptor	55 13 003751
3	Swan neck M-15 without nozzle and tip	55 13 014060

No.	Spare parts	Catalogue no.
4	Hexagonal fitting, brass	55 13 003760
5	Handle location body	55 13 013258
6	Lock nut M10x1	55 13 004309
7	MOST Cable support M15/25 UG8015	55 13 006834
8	MOST Hanger hook UB 2517 (option)	55 13 006836
9	MOST Handle nut UG8008	55 13 006837
10	Cable assembly 3 m	55 13 016090
10.1	Cable assembly 4 m	55 13 016091
10.2	Cable assembly 5 m	55 13 016092
11	MOST Handle kit M GRIP UG2514/KJ/B	55 13 006515
12	MOST Handle trigger M15/501 UG2516	55 13 006517
13	MOST Cable support UC2841 M15/25	55 13 006835
14	MOST Gun plug body housing for euro connector M15/36 UC1518	55 13 006518
15	MOST Euro connector nut M15/501 UC1519	55 13 006519
16	MOST Gun plug body/spring pins UC1528	55 13 006569
17	Gun plug Gun plug O-ring 4x1	55 13 013962
18	Liner nut	55 13 004300
B	Contact tip M6x25	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version



## M24 SGRIP



Model	M24 SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current At 60% duty cycle	250 A - CO <sub>2</sub> 220 A - mix M21
▪ Diameter of wire	0,8 - 1,2 mm
Length/ Catalogue no.	3,0 m / 55 08 302430 4,0 m / 55 08 302440 5,0 m / 55 08 302450

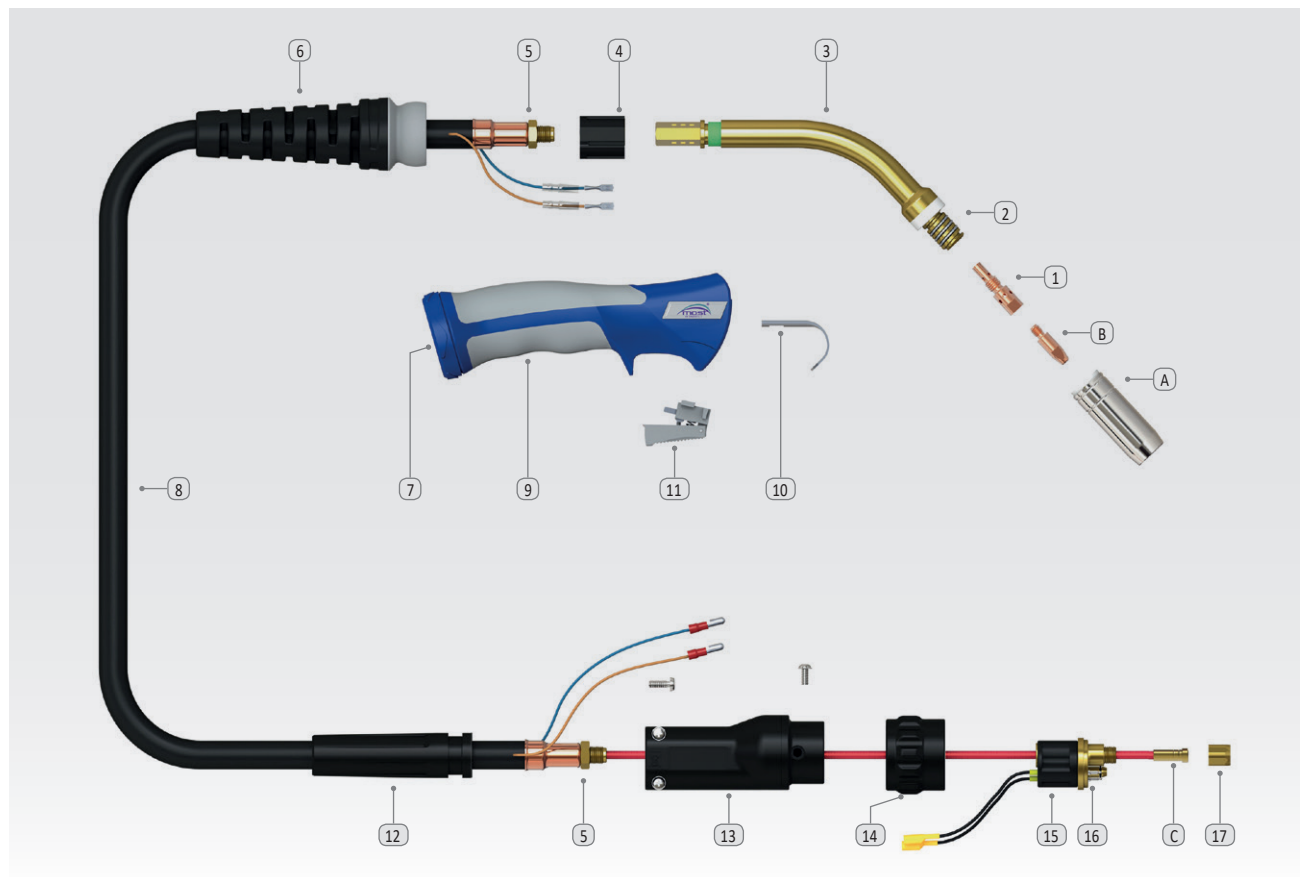
No.	Spare parts	Catalogue no.
A	Cylindrical nozzle 17x63,5 Conical nozzle 12,5x63,5* Tapered nozzle 10x63,5	55 12 300897 55 12 300895 55 12 300896
1	Tip adaptor M6*	55 13 003800
2	Diffuser ceramic M-24* white*	55 13 009460
2.1	Diffuser white M-24	55 13 009465
3	Swan neck M24	55 13 014063

No.	Spare parts	Catalogue no.
4	Handle location body	55 13 013258
5	Lock nut M10x1	55 13 004309
6	MOST Cable support M15/25 UG8015	55 13 006834
7	MOST Handle nut UG8008	55 13 006837
8	MOST Cable assembly M24 3 m	55 13 016093
8.1	MOST Cable assembly M24 4 m	55 13 016094
8.2	MOST Cable assembly M24 5 m	55 13 016095
9	MOST Handle kit M GRIP UG2514/KJ/B	55 13 006515
10	MOST Hanger hook UB 2517 (option)	55 13 006836
11	MOST Handle trigger M15/501 UG2516	55 13 006517
12	MOST Cable support M15/25 UC2841	55 13 006835
13	MOST Gun plug body housing for euro connector M15/36 UC1518	55 13 006518
14	MOST Euro connector nut M15/25 UC1519	55 13 006519
15	MOST Gun plug body/Spring pins UC1528	55 13 006569
16	Gun plug Gun plug O-ring 4x1	55 13 013962
17	Liner nut	55 13 004300
B	Contact tip M6x28	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version



M25 SGRIP



Model	M25 SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current At 60% duty cycle	230 A- CO <sub>2</sub> 200 A- mix M21
▪ Diameter of wire	0,8- 1,2 mm
Length/ Catalogue no.	3,0 m / 55 08 302530 4,0 m / 55 08 302540 5,0 m / 55 08 302550

No.	Spare parts	Catalogue no.
A	Cylindrical nozzle	55 12 300901
	Conical nozzle 15x57*	55 12 300900
	Tapered nozzle 11,5x57	55 12 300904
	Gas spot welding nozzle	55 12 300903
1	Tip adaptor M25*	55 13 003804
2	Spring M25*	55 13 008360
3	Swan neck M-25 without nozzle and tip	55 13 014072

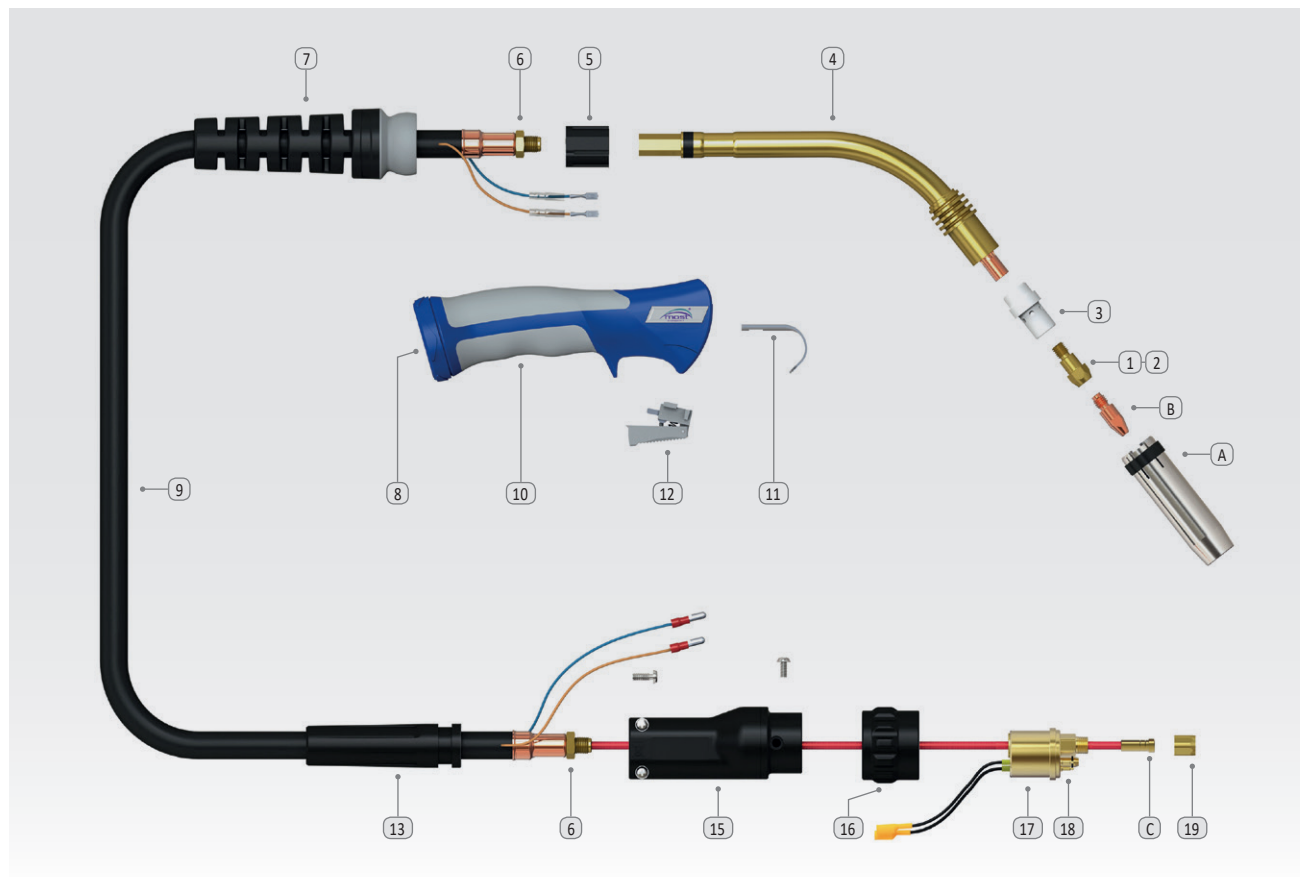
No.	Spare parts	Catalogue no.
4	Handle location body	55 13 013258
5	Lock nut M10x1	55 13 004309
6	MOST Cable support M15/25 UG8015	55 13 006834
7	MOST Handle nut UG8008	55 13 006837
8	Cable assembly M-25 3 m	55 13 016093
8.1	Cable assembly M-25 4 m	55 13 016094
8.2	Cable assembly M-25 5 m	55 13 016095
9	MOST Handle kit MSGRIP UG 2514/KJ/B	55 13 006515
10	MOST Hanger hook UB2517 (option)	55 13 006836
11	MOST Handle trigger M15/501 UG2516	55 13 006517
12	MOST Cable housing M24/25	55 13 006835
13	MOST Gun plug housing for euro connector M15/36 UC1518	55 13 006518
14	MOST Gun plug nut for euro connector M15/501 UC1519	55 13 006519
15	MOST Gun plug body/spring pins	55 13 006569
16	Gun plug O-ring 4x1	55 13 013962
17	Liner nut	55 13 004300
B	Contact tip M6x28	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version





## M36 SGRIP



Model	M36 SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current At 60% duty cycle	300 A- CO <sub>2</sub> 270 A- mix M21
▪ Diameter of wire	0,8- 1,2 mm
Length/ Catalogue no.	3,0 m / 55 08 303630 4,0 m / 55 08 303640 5,0 m / 55 08 303650

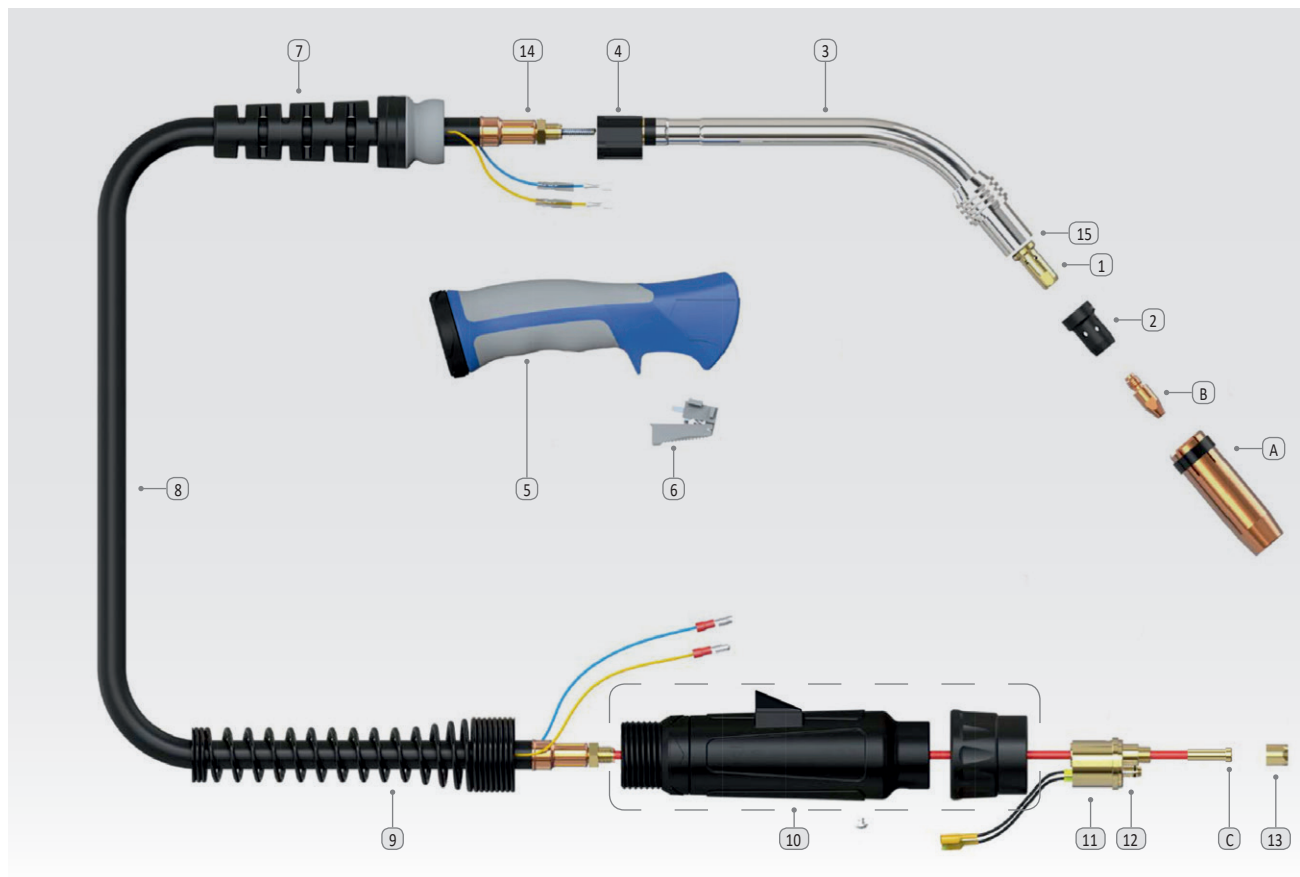
No.	Spare parts	Catalogue no.
A	Cylindrical nozzle 19x84 Conical nozzle 16x84* Tapered nozzle 12x84 Spot welding nozzle	55 12 300915 55 12 300910 55 12 300913 55 12 300917
1	Tip adapter M6x28*	55 13 003806
2	Tip adapter M8x28	55 13 003816
3	Diffuser ceramic M-36 white*	55 13 009486
3.1	Diffuser white M-36	55 13 009485

No.	Spare parts	Catalogue no.
4	Swan neck M36	55 13 014080
5	Handle location body	55 13 013258
6	Lock nut M10x1	55 13 004309
7	MOST Cable support M36 UG8016	55 13 006832
8	MOST Handle nut UG8008	55 13 006837
9	Cable assembly M36 3 m	55 13 016096
9.1	Cable assembly M36 4 m	55 13 016097
9.2	Cable assembly M36 5 m	55 13 016098
10	MOST Handle kit MSGRIP UG2514/KJ/B	55 13 006515
11	MOST Hanger hook UB2517 (option)	55 13 006836
12	MOST Handle trigger M15/501 UG2516	55 13 006517
13	MOST Cable support M36 for euro connector UC3641	55 13 006833
15	MOST Gun plug housing for euro connector M15/36 UC1518	55 13 006518
16	MOST Gun plug nut for euro connector M15/501 UC1519	55 13 006519
17	MOST Gun plug body/spring pins UC1528	55 13 006569
18	Gun plug O-ring 4x1	55 13 013962
19	Liner nut	55 13 004300
B	Contact tip M6x28	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version



**M38 SGRIP**



Model	M38 SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current At 60% duty cycle	350 A- CO <sub>2</sub> 320 A- mix M21
▪ Diameter of wire	1,0- 1,6 mm
Length/ Catalogue no.	3,0 m / 55 08 303830 4,0 m / 55 08 303840 5,0 m / 55 08 303850

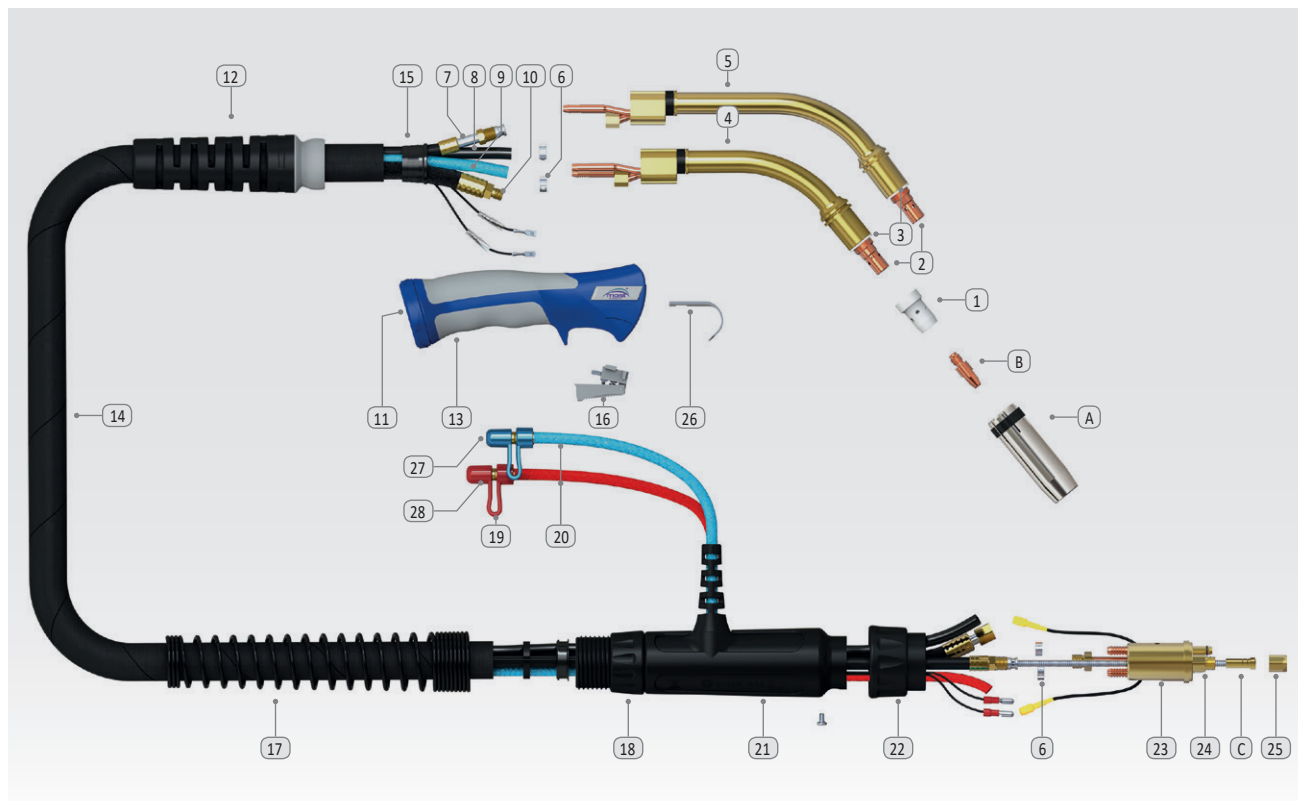
No.	Spare parts	Catalogue no.
A	Cylindrical nozzle 20x76 401/501	55 13 000610
	Conical nozzle 16x76* UB5028HD	55 13 000617
	Conical nozzle 16x76 401/501	55 13 000600
	Tapered nozzle 14x76 401/501	55 13 000615
	Gas spot welding nozzle 401/501	55 13 000613
1	Tip adapter M8 M38 UB3812*	55 13 003820
2	Diffuser black M-38 UB5005H*	55 13 009483

No.	Spare parts	Catalogue no.
2.1	Diffuser white 401/501	55 13 009491
3	Swan neck M38 UG3801*B10	55 13 014079
4	Handle location body	55 13 013258
5	MOST Cable support MSGRIP RYG2514	55 13 006515
6	MOST Handle trigger M15/501 UG2516	55 13 006517
7	MOST Cable support UG8016	55 13 006832
8	Cable assembly M38 3 m	55 13 016099
8.1	Cable assembly M38 4 m	5513016100
8.2	Cable assembly M36 5 m	55 13 016101
9	MOST Cable support for euro connector M38 UC8026	55 13 006841
10	MOST Gun plug housing for euro connector UPA38030EB	55 13 006523
11	MOST Gun plug body/spring pins UC1528	55 13 006569
12	Gun plug O-ring 4x1	55 13 013962
13	Liner nut	55 13 004300
14	Lock nut M10x1	55 13 004309
15	Insulating water 401/501	55 13 013966
B	Contact tip M8x30	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version



## M401 SGRIP / M501 SGRIP



Model	M401 SGRIP	M 501 SGRIP
Cooling	Liquid	Liquid
Technical data according to EN 60 974-7: ▪ Max. current At 60% duty cycle	400 A- CO <sub>2</sub> 300 A- mix M21	520 A- CO <sub>2</sub> 420 A- mix M21
▪ Diameter of wire	0,8- 1,6 mm	0,8- 1,6 mm
Length/ Catalogue no.	3,0 m / 55 08 304013 4,0 m / 55 08 304014 5,0 m / 55 08 304015	3,0 m / 55 08 305013 4,0 m / 55 08 305014 5,0 m / 55 08 305015



We recommend using of special cooling liquids, see page 37.

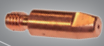
No.	Spare parts	Catalogue no.
A	Cylindrical nozzle 20x76 Conical nozzle 16x76* Tapered nozzle 14x76 Gas spot welding nozzle	55 13 000610 55 13 000600 55 13 000615 55 13 000613
1	Diffuser ceramic 401/501* white	55 13 009493
1.1	Diffuser white 401/501	55 13 009491
2	Tip adaptor M401/501 M6x25	55 13 003991
2.1	Tip adaptor M401/501 M6x29	55 13 003993
2.2	Tip adaptor M401/501 M8x25*	55 13 003990
2.3	Tip adaptor M401/501 M8x29	55 13 003992
3	Insulating washer M401/501	55 13 013966
4	Swan neck M401 SGRIP NUG 4011	55 13 014086
5	Swan neck M501 SGRIP NUG 5002	55 13 014096
6	Water hose clamp GER 9,5	50 15 000095

No.	Spare parts	Catalogue no.
7	Input cable assembly	(3 m) 55 13 006503 (4 m) 55 13 006504 (5 m) 55 13 006505
8	Gas hose assembly black	55 13 015370 (mb)
9	Water hose assembly 5x1,5 blue	51 13 007120 (mb)
10	Cable set	(3 m) 55 13 015968 (4 m) 55 13 015969 (5 m) 55 13 015970
11	MOST Handle nut UG8008	55 13 006837
12	MOST Cable support 401/501 UG 3208	55 13 006831
13	MOST Handle kit MSGRIP UG2514/KI/B	55 13 006515
14	Outer cable set	(3 m) 55 13 015530 (4 m) 55 13 015531 (5 m) 55 13 015532
14.1	Cable assembly	51 13 007201 (mb)
15	MOST Ball joint assembly 401/501 UG 8010	55 13 006830
16	MOST Handle trigger M15/501 UG2516	55 13 006517
17	MOST Spring cable support for euro connector M401/501	55 13 006827
18	MOST Spring cable support nut for euro connection M36/501	55 13 006828
19	Water hose nipple Ø 6	50 14 182003
20	Water outlet hose 5x15 red	51 13 007115
20.1	Water outlet hose 5x1,5 blue	51 13 007120
21	MOST Gun plug housing for euro connector M401/501	55 13 006522
22	MOST Gun plug nut insert for euro connector M15/501 B1519	55 13 006519
23	MOST Gun plug body/Spring fixed pins UB5098	55 13 006570
24	Gun plug O-ring 4x1	55 13 013962
25	Liner nut	55 13 004300
26	MOST Hanger hook UB2517 (option)	55 13 006836
27	Red cap stopper UBD 80320	55 13 006838
28	Blue cap stopper UBD 80320	55 13 006840
B	Contact tip M8x30	(see table page 15)
C	Steel liner	(see table page 15)

\* standard version



## Contact tips for welding torches MIG/MAG



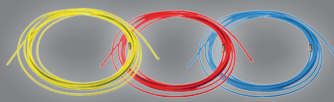
Diameter 	M6x25 (M6 slim)	M6x28 (M6 thick)	M8x30	M6x25 (M6 slim)	M6x28 (M6 thick)	M8x30
	Catalogue no.			Catalogue no. Abicor Binzel		
0,6 mm	55 13 002150	-	-	140.0008	140.0005	-
0,8 mm	55 13 002170	55 13 002180	55 13 002250	140.0059	140.0051	140.0114
1,0 mm	55 13 002320	55 13 002330	55 13 002340	140.0253	140.0242	140.0313
1,2 mm	55 13 002470	55 13 002480	55 13 002490	140.0387	140.0379	140.0442
1,4 mm	-	55 13 002610	55 13 002600	-	140.0516	140.0533
1,6 mm	55 13 002720	55 13 002730	55 13 002800	-	140.0555	140.0587
0,6 mm CuCrZr	55 13 002151	-	-	140.0855	140.0998	-
0,8 mm CuCrZr	55 13 002171	55 13 002190	55 13 002251	140.0062	140.0054	140.0117
1,0 mm CuCrZr	55 13 002321	55 13 002331	55 13 002341	140.0256	140.0245	140.0316
1,2 mm CuCrZr	55 13 002473	55 13 002482	55 13 002491	140.0390	140.0382	140.0445
1,4 mm CuCrZr	-	-	55 13 002602	-	140.0519	140.0536
1,6 mm CuCrZr	55 13 002725	55 13 002731	55 13 002801	-	140.0558	140.0590
0,8 mm al.	55 13 002172	55 13 002210	55 13 002253	141.0002	141.0001	141.0003
1,0 mm al.	55 13 002324	55 13 002335	55 13 002365	141.0007	141.0006	141.0008
1,2 mm al.	55 13 002475	55 13 002484	55 13 002493	141.0011	141.0010	141.0015
1,6 mm al.	55 13 002726	55 13 002732	55 13 002808	-	141.0020	141.0022
Recommended torches	<ul style="list-style-type: none"> <li>▪ MOST M15</li> <li>▪ MB-15</li> <li>▪ Abimig 155</li> </ul>	<ul style="list-style-type: none"> <li>▪ MOST M24/M25/M36</li> <li>▪ MB-24/MB-25/MB-36</li> <li>▪ MB-240D</li> <li>▪ Abimig 255</li> </ul>	<ul style="list-style-type: none"> <li>▪ MOST M401/M501/M38</li> <li>▪ MB-401D/MB-501D</li> <li>▪ Abimig 305/355/405</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 155</li> <li>▪ MB 15</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 255</li> <li>▪ MB-24/MB-25/MB-36</li> <li>▪ MB-240D</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 305/355/405</li> <li>▪ MB-401D/MB-501D</li> </ul>

## Compound contact tips for MIG/MAG welding torches

Unlike traditional contact power tips available on the market (pure copper, copper alloy CuCrZr, silver-plated, nickel plated, etc.), CEPDICUP® tips are made of two materials: alloy inside and pure copper E-Cu on the outside. Advantages of the composite materials and their long lifespan are results of the high conductivity maintenance, characteristic for copper, and the high-strength, abrasion resistance inside layer, connecting the welding wire and tip (DICUP® alloy, C3/80 version). Alloy and process of manufacturing are proprietary. Use of the composite tips is ideal for liquid-cooling MIG/MAG torches in heavy-duty welding and automation. It brings two substantial economic benefits: reduction of number of tips being disposed and minimization of time wasted on tip replacement while welding.

Diameter of wire	M8x30
	Catalogue no.
1,0 mm	55 13 003310
1,2 mm	55 13 003312
Other types of contact tips available on request	

## Steel liner for MIG/MAG welding torches

Diameter	3,0 m	4,0 m	5,0 m	3,0 m	4,0 m	5,0 m
Spiral liners for steel wires	coated				non-coated	
0,8 mm	55 13 012390*	55 13 012400*	55 13 012402*	55 13 012390	55 13 012400	55 13 012402
1,0 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,2 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,6 mm	55 13 012510***	55 13 012530***	55 13 012541***	55 13 012570	55 13 012573	55 13 012575
Teflon liners for aluminum wires						
0,8 mm	55 13 012120*	55 13 012170*	55 13 012175*	55 13 012120*	55 13 012170*	55 13 012175*
1,0 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,2 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,6 mm	55 13 012210***	55 13 012212***	55 13 012214***	55 13 012210***	55 13 012212***	55 13 012214***
1,0-1,2 mm Carbon-teflon-brass	55 13 013010	55 13 013020	55 13 013030	55 13 013010	55 13 013020	55 13 013030
Recommended torches	<ul style="list-style-type: none"> <li>▪ MOST M15/M24/M25/M36/M38/401-501 EVO</li> <li>▪ MB-15AK/MB-24KD/MB-25AK/MB-36KD/GRIP ALW</li> </ul>			<ul style="list-style-type: none"> <li>▪ MOST M401/M501</li> <li>▪ MB-240D/MB-401D/MB-501D</li> </ul>		



Colors \*blue / \*\*red / \*\*\*yellow

## Wire feeder rollers

Type		Ø30 Cooptim	Ø30	Ø37	Ø37	Ø40 Cooptim
Dimension	Diameter	30 mm	30 mm	37 mm	37 mm	40 mm
	Inner diameter	22 mm	14 mm	10 mm	19 mm	32 mm
	Width	10 mm	12 mm	15 (17) mm	12 mm	10 mm
Wire diameter [mm]	0,6- 0,8	51 13 007783	51 13 007796	51 13 007797	51 13 007793	51 13 007792
	0,6- 0,8 Al	51 13 007788	-	-	-	-
	0,8 Al	-	51 13 007805	-	-	-
	0,8- 1,0	51 13 007826	51 13 007810	51 13 007802	51 13 007808	51 13 007819
	0,8- 1,0 Al	51 13 007828	-	51 13 007803	51 13 007809	51 13 007830
	1,0 Al	-	51 13 007811	-	-	-
	1,0- 1,2	51 13 007862	51 13 007860	51 13 007883	51 13 007865	51 13 007880
	1,0- 1,2 Al	51 13 007863	51 13 007861	51 13 007884	51 13 007885	51 13 007879
	1,0/1,2 R	-	51 13 007891	-	51 13 007856	-
	1,0- 1,2 R	51 13 007895	-	-	-	51 13 007866
	1,2	-	51 13 007905	-	-	-
	1,2 Al	-	51 13 007925	-	51 13 007928	-
	1,2- 1,4 R	51 13 007899	-	-	-	-
	1,2- 1,6	51 13 007956	51 13 007930	-	51 13 007931	51 13 007971
	1,2- 1,6 Al	51 13 007960	51 13 007934	-	51 13 007935	51 13 007960
	1,2-1,6 R	-	-	51 30 208966	51 13 007937	-
	1,2/1,4/1,6 R	-	51 13 007918	-	-	-
	1,4/1,6 R	-	51 13 007989	-	-	-
	1,6 Al	-	51 13 007995	-	-	-
	1,6- 2,0	-	-	-	-	51 13 007999
1,6- 2,0 R	-	-	-	-	51 13 007997	
2,0	-	51 13 007998	-	-	-	
2,4- 3,2 R	-	-	-	-	51 13 007991	
Application	MOST	Fanmig 2500i / 3200i / 400 / 600 Fanmig 280/320/400-4 and F200-2	Fanmig I: 190 / 270 C2/C4 / 350 C4 350LWF / 450WWF	Fanmig II: 230 C-2 / 271 C-2	Fanmig II: 271 C-4 / 351 C-4 / 351LWF Fanmig 451WWF	Fanmig 404 / 504 / 604 / 500i / 502i
	LINCOLN ELECTRIC BESTER	some of Magster: 250 4x4 / 250T 315T (Cooptim CWF 4010)	some of Magster: 250 4x4 / 250T / 315 4x4 315T / 350C / 350W / 450C 500 (Type Fortrans)		Powertec: 1 roller: 200C / 250C / 300C feeder LF 22 2 rollers: 300C / 280Pro / 350Pro 420Pro / PT 300 / 360 420 / 500 with external feeder LF 24, 33	some of Magster 350C, 450C, 500W; all of: Magster 351W / 400 Plus/W / 500PlusW 501W (Type Cooptim CWF 5110)
	LORCH		Saprom / C-dialog / P	M-Pro / MicorMIG		
	OZAS ESAB		Minimag 164 / 240 / 320 feeders ZP-10 / 11 / 12 / 15 feeders ZP-20 (older types) Minimag 281 feeders: LKB-260 / 320 / 400 feeders: MEK2/4 / Feed 30, other		Minimag-241 / 341 Magomig with feeders ZP-22 / 30 feeders ZP-30 / 20 OrigoMig / OrigoFeed 30	

Other types of feeder rollers available on request.



Wire feeders recommended for Fanmig machines		
Fanmig 175i		
	0,6-0,8 mm 0,8-1,0 mm	51 13 007801 51 13 007833
Fanmig 3200i mobil		
	0,8-1,0 mm 0,8-1,0 mm Al 1,0-1,2 mm 1,0-1,2 mm Al	51 13 007843 51 13 007844 51 13 007893 51 13 007894

## 2. TIG equipment and torches

### 2.1. TIG equipment



#### Inverter equipment MOST PONTIG 1880 HF / 2220 HF PRO

PONTIG 1880 HF and PONTIG 2220 HF PRO are machines designed for TIG DC welding in argon shield (steel and stainless steel) or coated electrode MMA. Arc ignition can be carried out by the HF ionizer or by friction of the tungsten electrode's end. Big advantage is a clear and easy to use modern panel with welding current display. Control panel is designed for quick and intuitional change of parameters with a single knob. No need to remember the sequence of settings for a given function, which greatly simplifies the welding operation. The knob is designed to set values (e.g. welding current or current fall time), or to switch between functions and working modes. Display on front panel can show welding current, function values or error code if device's work is disturbed.



Model	PONTIG 1880 HF	PONTIG 2220 HF PRO
Main voltage (50/60 Hz)	1 x 230 V +20%/-15%	1 x 230 V +20%/-15%
Range of welding current	10-160 A	10-200 A
Maximum power consumption TIG / MMA	5,4 / 6,7 kVA	6,1 / 7,2 kVA
Welding current TIG / MMA:		
▪ at 45% duty cycle	160 / 160 A	200 / 200 A
▪ at 60% duty cycle	40 / 130 A	150 / 140 A
▪ at 100% duty cycle	120 / 100 A	
Open circuit voltage	80 V	58 V
Protection class	IP23C	IP23
Isolation class	H	H
Dimensions (LxWxH)	320x135x285 mm	430x175x325 mm
Weight	4,9 kg	7,4 kg
Catalogue no.	52 00 005246	52 00 005282

Equipment is delivered in carton box with a gas and earth cables, without TIG torch.

Very modern, ergonomic housing is made of high quality materials. The durability of the housing is reinforced by producer's patented solution called **DDR** (Dual Density Reinforcement).

#### Rubber shields have three basic functions:

- non-slip layer on handle,
- non-slip layer on the sides of the base to increase adhesion to the ground and to protect from accidental fall,
- shock absorbing inside the unit to protect electronic components.

Devices automatically switch to STAND BY mode, if welding does not restart within 15 minutes. It helps to save energy and significantly of some electronic components and reducing the risk of accidental run of the electric arc.

Built-in intelligent ventilation system, which works in case of welding or exceeding specified temperature inside, allows to limit the dust accumulation inside the machine and increases lifetime of rectifiers. Devices are equipped with self-diagnosis system, which shows error codes on the display, in case of their occurrence.

In case of electrode welding there are HOT START and Ant-Stick functions available. TIG DC welding at pulsing current (PONTIG 2220 HF PRO) allows welding of thin metal sheets without distortion and discoloration thanks to less heat induction into the weld. Working at TIG DC with high frequency pulsing current can be regulated from 10 to 500 Hz.

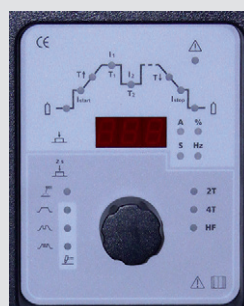
TIG welding torches	Catalogue no.
TIG torch 26 SGRIP (Pontig 2220HF Pro) 4 m	56 01 032628
TIG torch 26 SGRIP (Pontig 2220HF Pro) 8 m	56 01 032630
TIG torch 17 SGRIP (Pontig 1880 HF) 4 m	56 01 081700
Suitcase (black)	52 45 200200

Panel PONTIG 1880 HF MOST – STAND BY mode



- coated electrode welding MMA
- TIG DC welding with direct current
- 2-stroke operating button on TIG torch
- 4-stroke operating button on TIG torch
- arc ignition by HF ionizer (TIG) or by friction of tungsten electrode's end

Panel PONTIG 2220 HF PRO MOST – STAND BY mode



- coated electrode welding MMA
- TIG DC welding with direct current
- TIG DC welding with pulsing current
- TIG welding at high frequently (from 10 to 500 Hz)
- 2-stroke operating button on TIG torch
- 4-stroke operating button on TIG torch
- arc ignition by HF ionizer (TIG) or by friction of tungsten electrode's end





## The first device for TIG welding of aluminium under the brand MOST PONTIG 200 AC/DC

The PONTIG 200 AC / DC is used for TIG and MMA welding. In TIG welding dedicated for carbon, stainless steel, copper and its alloys use DC current or select AC for aluminium and its alloys. Arc ignition is conducted via HF ionizer or by friction of the tungsten electrode (LiftArc).

Setting welding parameters is done on the front panel in an intuitive way, values of adjusted parameters are indicated by LC displays and the appropriate LED. Pulsing current in TIG welding is available in the range of 0.5- 200 Hz. For welding of aluminium with alternative current (TIG AC) positive and negative component of the welding current are controlled. As the inverter device PONTIG 200 AC / DC is characterized by low weight and dimensions.



Accessories	Catalogue no.
Earth and electrode cable 3 m/25 mm <sup>2</sup> (set)	53 99 990103
Earth cable 4 m/35 mm <sup>2</sup>	53 99 000076
Cooling unit MOST Fancool 601 WA	50 03 003805
TIG torch 26 SGRIP (Pontig 200) 4 m	56 01 032615
TIG torch 26 SGRIP (Pontig 200) 8 m	56 01 032616
Argon regulator MOST	62 30 750400
Foot remote control CTRL 3 m 5.0174A	50 10 098595
Gas cylinder cap (Ø6,0 mm)	50 14 182003
Welding trolley WUS-150 MOST	50 03 003900
Welding trolley 5.0513	50 03 003940

Control panel PONTIG 200 AC/DC



Model	PONTIG 200 AC/DC
Main voltage	230 V – 50/60 Hz
Range of welding current	TIG: 5-200 A MMA: 5-170 A
Protect network	16 A
Welding current TIG / duty cycle:	AC: 200 A/20%, 90 A/60%, 70 A/100% DC: 200 A/25%, 110 A/60%, 80 A/100%
Welding current MMA/ duty cycle:	AC: 170 A/20%, 90 A/60%, 70 A/100% DC: 170 A/25%, 110 A/60%, 80 A/100%
Open circuit voltage U <sub>o</sub>	AC: 73 V DC: 68 V
Insulation class	F
Protection class	IP 23S
Dimensions- (LxWxH)	250x470x400 mm
Weight	21,8 kg
Catalogue no.	52 00 005420



PONTIG 200AC/DC  
with trolley 5.0513  
and torch T26 SGRIP MOST



## Tungsten electrodes sharpener WAG 40 MOST

The device is designed only for tungsten electrodes sharpening used in TIG welding. In tungsten electrode welding, the precise sharpening of an electrode is dependent on its diameter, welding current and current intensity. A sharpened electrode guarantees perfect arc ignition and increases its lifetime.

Sharpener WAG 40 MOST is necessary in orbital TIG welding, plasma welding and professional manual TIG welding.

Equipment is delivered in a suitcase, with tungsten electrode handle and clamps for diameters 1,6; 2,4 and 3,2 mm, and set of spanners for sharpener maintenance.

We also offer stationary sharpener Neutrix 90T (Catalogue no. 59 30 000105).



Model	WAG 40 MOST
Power P1	850 W
Main voltage	230 V / 50-60 Hz
Rotation	from 8.000 to 22.000 rot./min
Noise level	88,8 dB (A)
Vibration level	5 m/s
Weight	2,8 kg
Filter cartridge	Disposable filter
Diamond disc	∅ 40 mm (Cat. no. 59 30 000201)
Catalogue no.	59 30 000110

### Functions of the sharpener WAG 40 MOST:

- sharpening of electrodes from 1,0 to 4,0 mm
- adjustment of sharpening angle from 15 to 180°
- possibility to adjust the depth to minimize electrode wear in sharpening
- sharpening of electrodes from 15 mm length
- suitable for sharpening of short electrodes with longer collets (marked L)- additional equipment needed
- suitable to use on the table as well as in hand
- built-in replaceable dust filter (type 8511K1.H12)
- tabletop stand is optional

## Tungsten electrodes MOST for TIG welding

Name/symbol	Marking color	Current	Welding length L=175 mm	Comment	Catalogue no.*
With Thorium 2% WT20	red	DC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm	Slightly radioactive	50 19 92XX17
Pure Wolfram WP	green	AC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm		50 19 93XX17
With Lanthanum WL10	black	AC/DC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm		50 19 91XX17
With Cerium WC20	grey	AC/DC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm		50 19 97XX17
With Lanthanum WL15	gold	AC/DC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm		50 19 94XX17
Multi-Strike	turquoise	AC/DC	∅1,0 / 1,6 / 2,4 / 3,2 / 4,0 mm	Best properties with steel and aluminium	50 19 95XX17
With rare-earth-elements WS20	blue	AC/DC	∅1,0 / 1,6 / 2,0 / 2,4 / 3,0 / 3,2 / 4,0 mm	Recommended electrode substitute WT20	50 19 9750XX

\*) XX- electrode diameter, eg. ∅1.6 mm = 16; 2.4 mm = 24; etc.

AC – alternating current / aluminium welding

DC – direct current / stainless and carbon steel welding

Grinding angle (according to manufacturer instructions)	
Welding power (DC)	Electrode angle
20 A	30°
20-100 A	60°-90°
100- 200 A	90°-120°
> 200 A	120°

Recommended welding current (according to manufacturer instruction)		
Elect. diameter	DC	AC
1,0 mm	3-40 A	5-30 A**
1,6 mm	15-130 A	20-90 A**
2,0 mm	45-180 A	45-135 A**
2,4 mm	70-240 A	70-180 A**
3,2 mm	140-320 A	130-250 A**
4,0 mm	220-450 A	200-320 A**

\*\*) Depending on the type of electrode, and AC balance control parameter







## 2.2. TIG welding torches

## Alternatives for TIG torches

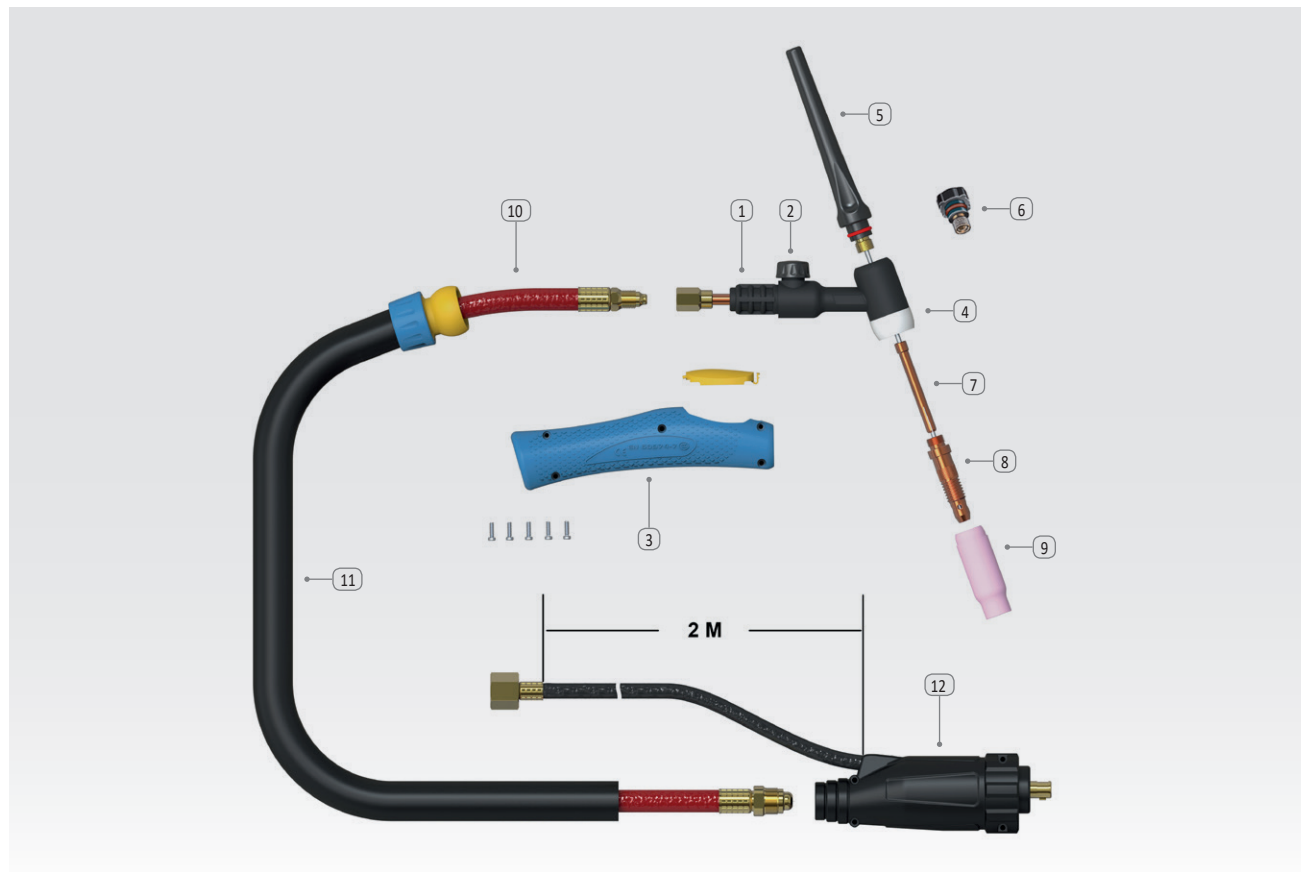
Other TIG handles (due to over-use of materials)							
ABICOR BINZEL	ABICOR BINZEL (stare)	TRAFISTEL	LE	WELDCRAFT	ESAB	LORCH	MOST
ABITIG GRIP 9	SRT-9 / SR-9	TIG-9	LT-9G	CK-9	BTD123 / HW-20ARV / BTF-140 / TXH 121	WLT-9 / i-LTG 900	T9 SGRIP
ABITIG GRIP 17	SRT-17 / SR-17	TIG-17	LT-17G	CK-17	BTD153 / HW-17 / BTF150 / TXH 151	WLT-17 / i-LTG 1700	T17 SGRIP
ABITIG GRIP 20	SRT-20 / SR-20	TIG-20	LT-20W	CK-20	BTD253W / HW-20 / BTF250W / TXH 251W	WWT-20 / i-LTW 3000	T20 SGRIP
ABITIG GRIP 26	SRT-26 / SR-26	TIG-26	LT-26G	CK-26	BTD203 / HW-26 / BTF200 / TXH 201	WLT-26 / i-LTG 2600	T26 SGRIP
ABITIG GRIP 18	SRT-18 / SR-18	TIG-18	LT-18W	CK-18	BTD403W / HW-18 / (BTF400W) / TXH 401W	WWT-18 / i-LTW 1800	T18 SGRIP

## Plugs/connectors

	Plugs	Name	Catalogue no.	Comment
	Gas	Gas connector Fl6 SPA1-1-01 Ø6 mm Gas nipple with nut 1/4 Gas connector 2,7 for LORCH	50 14 182003 50 14 182040 50 14 182006	Faltig + GER 9,5 Esab, Aspa + GER 9,5 LE, Lorch + GER 8,0
	Control	Plug SzR16P2NG5 Plug SzR20P4NG4 Plug Amphenol 2-bolt. Plug 3 bolt. Tuchel 175.0009 Plug 5 bolt. Tuchel 175.0011 Plug 5 bolt. Solter 70608 Plug 2 pin female N-40-130110-01-00	51 13 014495 51 13 014497 51 13 014450 56 13 140140 51 13 014470 51 13 014490 52 45 600020	Faltig-160 Faltig-315 ESAB (0349303269) Faltig 161, 200, 250, 400 LE, Lorch Pontig 1880HF, 2220 Fanmig 175i, 502i, other
	Liquid	Hose plug Ø6 mm	50 14 182003	GER 9,5
	Clamp	GER 9,5 GER 8,0	50 15 000095 50 15 000080	



T17V SGRIP



Model	T17V SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current at 35% duty cycle	95 A AC / 135 A DC
▪ Diameter of tungsten electrode	1,0- 2,4 mm
▪ Gas flow	5-12 l/min
▪ Weight	0,75 kg
Length/ Catalogue no.	4,0 m / 56 01 061704

V- handle with gas valve, without trigger  
 DC- direct current  
 AC- alternating current

No.	Spare parts	Catalogue no.	Alternative marking
1	Torch body SR-17V MOST	56 13 003417	UWP17V
2	Valve SR-17V	56 13 003135	-
3	Handle TIG17V with plug and joint UCKJ100	56 13 007512	UCH100
4	Insulator SR-17/18/26	56 13 014810	18CG
5	Back cap long SR-17/18/26	56 13 003181	57Y02
6	Back cap short SR-17/18/26	56 13 003270	57Y04
7	Collet 1,0 SR-17/18/26	56 13 009930	10N22
	Collet 1,6 SR-17/18/27	56 13 009932	10N23
	Collet 2,0 SR-17/18/28	56 13 009934	-
	Collet 2,4 SR-17/18/29	56 13 009936	10N24
8	Collet body TIG 1,0 SR-17/18/29	56 13 003830	10N30
	Collet body TIG 1,6 SR-17/18/30	56 13 003883	10N31
	Collet body TIG 2,0 SR-17/18/31	56 13 003914	-
	Collet body TIG 2,4 SR-17/18/32	56 13 003921	10N32
9	Ceramic nozzle 6,5x47 #4	56 13 000768	10N50
	Ceramic nozzle 8,0x47 #5	56 13 000770	10N49
	Ceramic nozzle 9,5x47 #6	56 13 000780	10N48
	Ceramic nozzle 11,0x47 #7	56 13 000783	10N47
	Ceramic nozzle 12,5x47 #8	56 13 000784	10N46
10	Cable set TIG17V 4 m	56 13 016160	USL57Y01A
11	Cable cover 35x1,5 [mb]	51 13 015240	-
12	Cable plug TIG17V 10/25	56 13 016412	



Special torches and non-standard parts available on request.  
 For plugs see table on page 20.





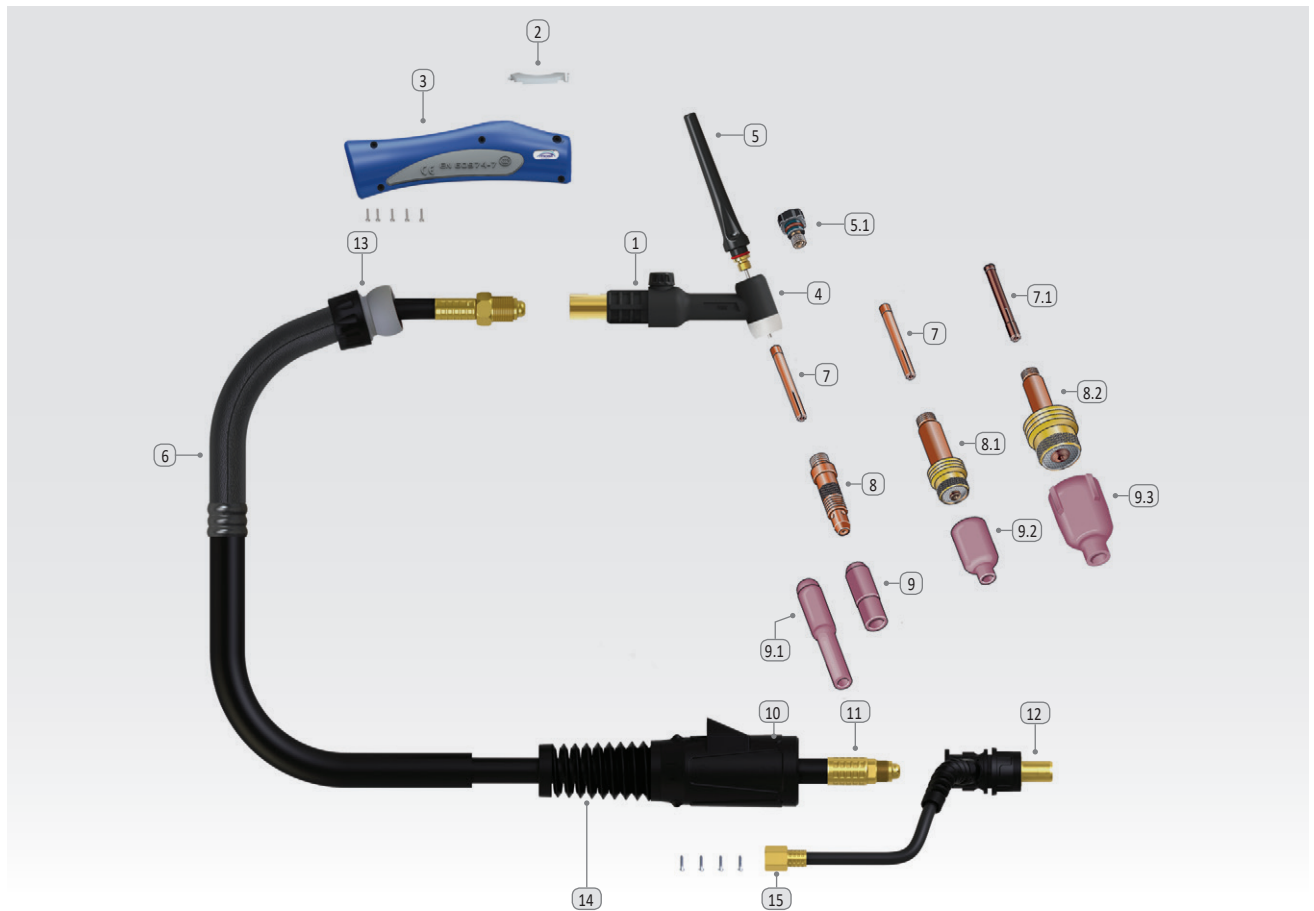
## Spare parts for T26 SGRIP

No.	Spare parts	Catalogue no.	Alternative marking
1	Torch body SR-26 MOST	56 13 003398	
1.1	Torch body SR-26F MOST	56 13 003397	
2	Handle trigger kpl ON/OFF	56 13 200100	UERBS
3	Handle big TIG SGRIP	56 13 200220	RY-ERH200
4	Insulator SR-17/18/26	56 13 014810	18CG
4.1	Laminar insulator	56 13 014812	54N01
4.2	Laminar insulator Jumbo	56 13 017813	54N63 701.1122
5	Back cap long SR-17/18/26	56 13 003181	57Y02
5.1	Back cap short SR-17/18/26	56 13 003270	57Y04
6	Cable cover [mb]	56 13 004596	
6.1	Cable cover 4 m	56 13 200250	USLERC200-40
6.2	Cable cover 8 m	56 13 200251	USLERC200-80
6.3	Cable cover 12 m	56 13 200252	USLERC200-120
7	Collet 1,0 SR-17/18/27 Collet 1,6 SR-17/18/27 Collet 2,0 SR-17/18/28 Collet 2,4 SR-17/18/29 Collet 3,2 SR-17/18/29 Collet 4,0 SR-17/18/29	56 13 009930 56 13 009932 56 13 009934 56 13 009936 56 13 009940 56 13 009942	10N22 10N23 - 10N24 10N25 54N20
7.1	Collet 2,4 Jumbo Collet 3,2 Jumbo	56 13 010024 56 13 010032	702.0009 712.6064
8	Collet body TIG 1,0 SR-17/18/30 Collet body TIG 1,6 SR-17/18/30 Collet body TIG 2,0 SR-17/18/31 Collet body TIG 2,4 SR-17/18/32 Collet body TIG 3,2 SR-17/18/32 Collet body TIG 4,0 SR-17/18/32	56 13 003830 56 13 003883 56 13 003914 56 13 003921 56 13 003952 56 13 003960	10N30 10N31 - 10N32 10N28 406488
8.1	Gas lens body 1, 0 SR-17/18/26 Gas lens body 1,6 SR-17/18/26 Gas lens body 2,4 SR-17/18/26 Gas lens body 3,2 SR-17/18/26 Gas lens body 4,0 SR-17/18/26	56 13 008235 56 13 008252 56 13 008272 56 13 008301 56 13 008310	45V24 45V25 45V26 45V27 45V28
8.2	Gas lens body 2,4 SR-17/18/27 Jumbo Gas lens body 3,2 SR-17/18/27 Jumbo	56 13 008276 56 13 008280	45V64 995795

No.	Spare parts	Catalogue no.	Alternative marking
9	Ceramic nozzle 6,5x47 #4 Ceramic nozzle 8,0x47 #5 Ceramic nozzle 9,5x47 #6 Ceramic nozzle 11,0x47 #7 Ceramic nozzle 12,5x47 #8 Ceramic nozzle 16,0x47 #10 Ceramic nozzle 19,5x47 #12	56 13 000768 56 13 000770 56 13 000780 56 13 000783 56 13 000784 56 13 000786 56 13 000788	10N50 10N49 10N48 10N47 10N46 10N45 10N44
9.1	Ceramic nozzle 8,0x76 #5 Ceramic nozzle 9,5x76 #6 Ceramic nozzle 11,0x76 #7	56 13 001006 56 13 001008 56 13 001010	10N49L 10N48L 10N47L
9.2	Ceramic nozzle 6,5x42 lam. #4 Ceramic nozzle 8,0x42 lam. #5 Ceramic nozzle 9,5x42 lam. #6 Ceramic nozzle 11,0x42 lam. #7 Ceramic nozzle 12,5x42 lam. #8 Ceramic nozzle 19,5x42 lam. #12	56 13 000902 56 13 000900 56 13 000888 56 13 000886 56 13 000884 56 13 000882	54N18 54N17 54N16 54N15 54N14 54N19
9.3	Ceramic nozzle 9,5x48 Jumbo #6 Ceramic nozzle 12,5x48 Jumbo#8 Ceramic nozzle 16,0x48 Jumbo#10 Ceramic nozzle 19,5x48 Jumbo#12	56 13 001115 56 13 001120 56 13 001136 56 13 001119	57N75 57N74 53N88 53N87
10	Power cable with plug 4 m Power cable with plug 8 m Power cable with plug 8 m	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
11	Cable set SR-26 MOST 4 m Cable set SR-26 MOST 8 m Cable set SR-26 MOST 12 m	56 13 200212 56 13 200213 56 13 200214	USL46V28A0B USL46V30A0B USL46V37A0B
12	Cable plug SGRIP	56 13 200261	UNSL3550
13	Gas supply hose nut 1/4"	56 13 200260	UNSL-1-G55
14	Spring cable support	56 13 200262	USLH26-S
15	Gun plug housing	56 13 200263	UNSLH26-H + USLH26-C
16	Ball joint TIG	56 13 200264	UERKJ200



## T26V SGRIP



Model	T26V SGRIP
Cooling	Gas
Technical data according to EN 60 974-7:	
▪ Max. current at 35% duty cycle	125 A AC / 180 A DC
▪ Diameter of tungsten electrode	1,0- 3,2 mm
▪ Gas flow	5-12 l/min
Length/ Catalogue no.	4,0 m / 56 01 062634 8,0 m / 56 01 062638

T26VF SGRIP version with flexible torch body, technical data like for T26 SGRIP.  
Torches are delivered with control plugs.



TIG torches dedicated for specific TIG machines or T26VFX SGRIP with remote control, available on request.

## Spare parts for T26V SGRIP

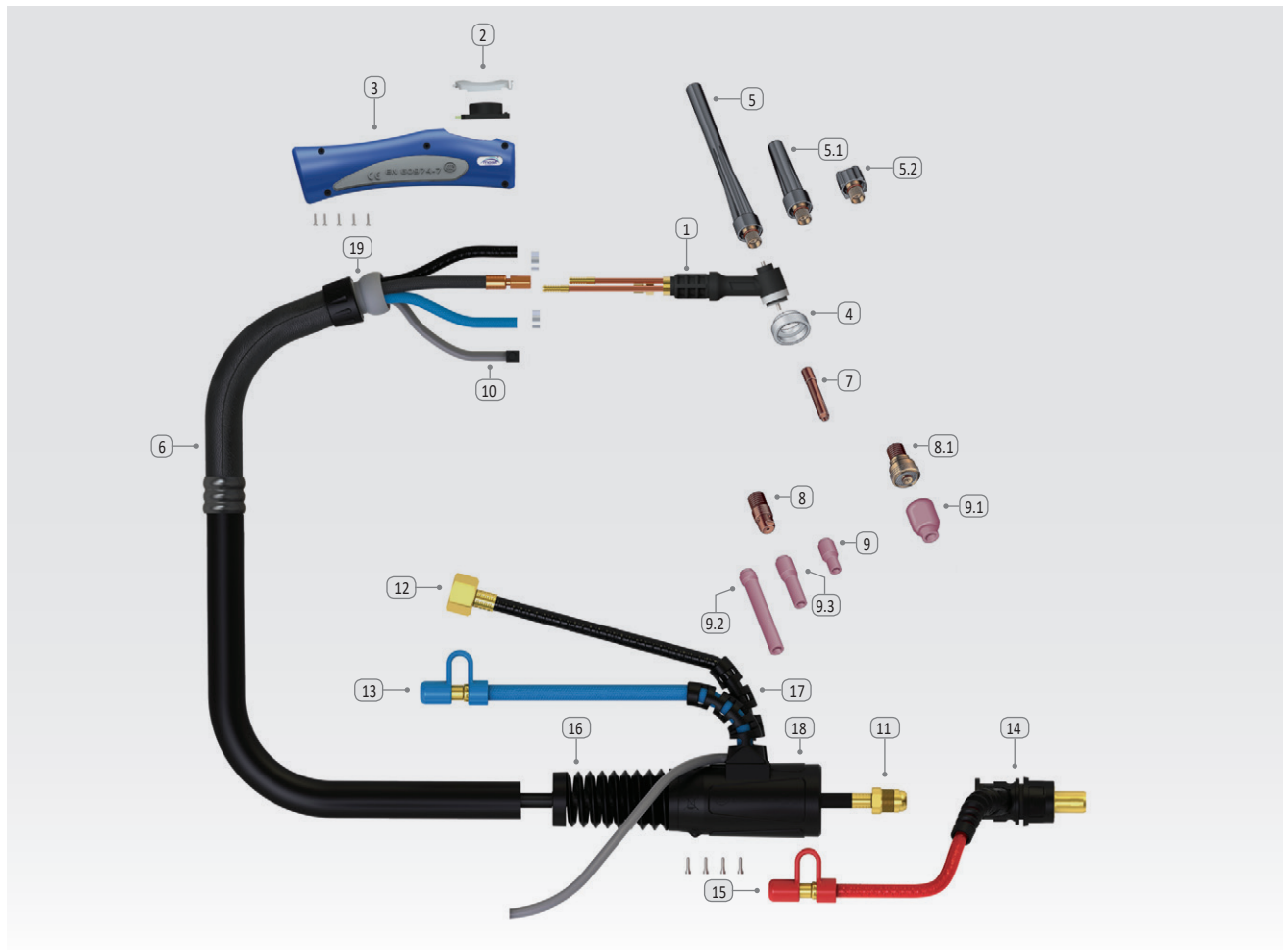
No.	Spare parts	Catalogue no.	Alternative marking
1	Torch body SR-26V MOST	56 13 003363	UWP26V
1.1	Torch body SR-26VF MOST	56 13 003370	UWP26VFX
2	Cover	56 13 200105	UERBS
3	Handle big TIG SGRIP	56 13 200220	RY-ERH200
4	Insulator SR-17/18/26	56 13 014810	18CG
4.1	Laminar insulator	56 13 014812	54N01
4.2	Laminar insulator Jumbo	56 13 017813	54N63 701.1122
5	Back cap long SR-17/18/26	56 13 003181	57Y02
5.1	Back cap short SR-17/18/26	56 13 003270	57Y04
6	Cable cover [mb]	56 13 004596	
6.1	Cable cover 4 m	56 13 200250	USLERC200-40
6.2	Cable cover 8 m	56 13 200251	USLERC200-80
7	Collet 1,0 SR-17/18/27 Collet 1,6 SR-17/18/27 Collet 2,0 SR-17/18/28 Collet 2,4 SR-17/18/29 Collet 3,2 SR-17/18/29 Collet 4,0 SR-17/18/29	56 13 009930 56 13 009932 56 13 009934 56 13 009936 56 13 009940 56 13 009942	10N22 10N23 - 10N24 10N25 54N20
7.1	Collet 2,4 Jumbo Collet 3,2 Jumbo	56 13 010024 56 13 010032	702.0009 712.6064
8	Collet body TIG 1,0 SR-17/18/30 Collet body TIG 1,6 SR-17/18/30 Collet body TIG 2,0 SR-17/18/31 Collet body TIG 2,4 SR-17/18/32 Collet body TIG 3,2 SR-17/18/32 Collet body TIG 4,0 SR-17/18/32	56 13 003830 56 13 003883 56 13 003914 56 13 003921 56 13 003952 56 13 003960	10N30 10N31 - 10N32 10N28 406488
8.1	Gas lens body 1, 0 SR-17/18/26 Gas lens body 1,6 SR-17/18/26 Gas lens body 2,4 SR-17/18/26 Gas lens body 3,2 SR-17/18/26 Gas lens body 4,0 SR-17/18/26	56 13 008235 56 13 008252 56 13 008272 56 13 008301 56 13 008310	45V24 45V25 45V26 45V27 45V28

No.	Spare parts	Catalogue no.	Alternative marking
8.2	Gas lens body 2,4 SR-17/18/27 Jumbo Gas lens body 3,2 SR-17/18/27 Jumbo	56 13 008276 56 13 008280	45V64 995795
9	Ceramic nozzle 6,5x47 #4 Ceramic nozzle 8,0x47 #5 Ceramic nozzle 9,5x47 #6 Ceramic nozzle 11,0x47 #7 Ceramic nozzle 12,5x47 #8 Ceramic nozzle 16,0x47 #10 Ceramic nozzle 19,5x47 #12	56 13 000768 56 13 000770 56 13 000780 56 13 000783 56 13 000784 56 13 000786 56 13 000788	10N50 10N49 10N48 10N47 10N46 10N45 10N44
9.1	Ceramic nozzle 8,0x76 #5 Ceramic nozzle 9,5x76 #6 Ceramic nozzle 11,0x76 #7	56 13 001006 56 13 001008 56 13 001010	10N49L 10N48L 10N47L
9.2	Ceramic nozzle 6,5x42 lam. #4 Ceramic nozzle 8,0x42 lam. #5 Ceramic nozzle 9,5x42 lam. #6 Ceramic nozzle 11,0x42 lam. #7 Ceramic nozzle 12,5x42 lam. #8 Ceramic nozzle 19,5x42 lam. #12	56 13 000902 56 13 000900 56 13 000888 56 13 000886 56 13 000884 56 13 000882	54N18 54N17 54N16 54N15 54N14 54N19
9.3	Ceramic nozzle 9,5x48 Jumbo #6 Ceramic nozzle 12,5x48 Jumbo#8 Ceramic nozzle 16,0x48 Jumbo#10 Ceramic nozzle 19,5x48 Jumbo#12	56 13 001115 56 13 001120 56 13 001136 56 13 001119	57N75 57N74 53N88 53N87
10	Gun plug housing	56 13 200263	UNSLH26-H
11	Cable set SR-26 MOST 4 m Cable set SR-26 MOST 8 m	56 13 200212 56 13 200213	USL46V28A0B USL46V30A0B
12	Cable plug SGRIP	56 13 200261	UNSL3550
13	Ball joint TIG	56 13 200264	UERKJ200
14	Spring cable support	56 13 200262	USLH26-S
15	Gas supply hose nut 1/4" 2 m	56 13 200269	





## T20 SGRIP



Model	T20 SGRIP
Cooling	Liquid
Technical data according to EN 60 974-7:	
▪ Max. current at 100% duty cycle	160 A AC / 225 A DC
▪ Diameter of tungsten electrode	1,0- 3,2 mm
▪ Gas flow	5-12 l/min
Length/ Catalogue no.	4,0 m / 56 01 062004 8,0 m / 56 01 062008 12,0 m / 56 01 062012

T20F SGRIP version with elastic torch, technical data like for T20 SGRIP.  
Torches are delivered without control plugs.



TIG torches dedicated for specific TIG machines or T20F SGRIP with remote control, available on request.

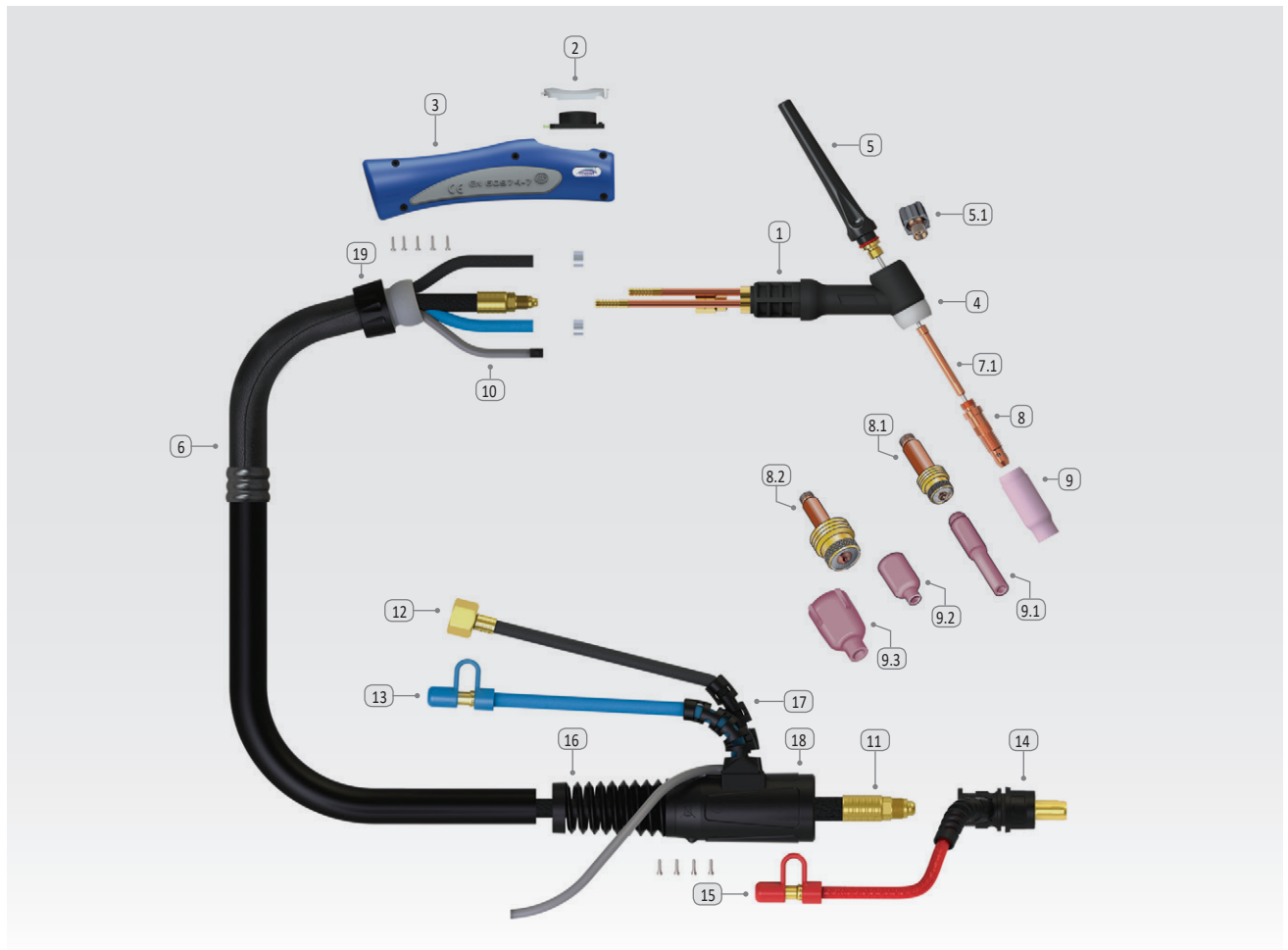
## Spare parts for T20 SGRIP

No.	Spare parts	Catalogue no.	Alternative marking
1	Torch body SR-20W MOST	56 13 003375	-
1.1	Torch body SR-20F MOST	56 13 200008	UWP20FXL
2	Handle trigger kpl ON/OFF	56 13 200100	UER1MS
3	Handle small TSGRIP	56 13 200221	RY-ERH100
4	Insulator SR-9/20	56 13 014806	598882
5	Back cap long SR-9/20	56 13 003170	41V24
5.1	Back cap medium SR-9/20	56 13 003250	41V35
5.2	Back cap short SR-9/20	56 13 003280	41V33
6	Cable cover [mb]	56 13 004594	-
6.1	Cable cover 4 m	56 13 200197	USLERCO100-40
6.2	Cable cover 8 m	56 13 200198	USLERCO100-80
6.3	Cable cover 12 m	56 13 200199	USLERCO100-120
7	Collet 1,0 SR-9/20 Collet 1,6 SR-9/20 Collet 2,0 SR-9/20 Collet 2,4 SR-9/20 Collet 3,2 SR-9/20	56 13 009920 56 13 009922 56 13 009923 56 13 009924 56 13 009927	13N21 13N22 - 13N23 13N24
8	Collet body TIG 1,0 SR-9/20 Collet body TIG 1,6 SR-9/20 Collet body TIG 2,0 SR-9/20 Collet body TIG 2,4 SR-9/20 Collet body TIG 3,2 SR-9/20	56 13 003840 56 13 003881 56 13 003912 56 13 003920 56 13 003950	13N26 13N27 - 13N28 13N29
8.1	Gas lens body 1,0 SR-9/20 Gas lens body 1,6 SR-9/20 Gas lens body 2,4 SR-9/20 Gas lens body 3,2 SR-9/20	56 13 008230 56 13 008250 56 13 008271 56 13 008300	45V42 45V43 45V44 45V45
9	Ceramic nozzle 6,5x30 #4 Ceramic nozzle 8,0x30#5 Ceramic nozzle 9,5x30 #6 Ceramic nozzle 11,0x30 #7 Ceramic nozzle 12,5x30 #8 Ceramic nozzle 16,0x30#10	56 13 000384 56 13 000386 56 13 000390 56 13 000394 56 13 000396 56 13 000398	13N08 13N09 13N10 13N11 13N12 13N13
9.1	Ceramic nozzle 6,5x25,5#4 Ceramic nozzle 8x25,5 #6 Ceramic nozzle 9,5x25,5 #7 Ceramic nozzle 11x25,5 #8	56 13 000908 56 13 000910 56 13 000911 56 13 000912	53N58 53N59 53N60 53N61
9.2	Ceramic nozzle 6,5x63 #4 Ceramic nozzle 8x63 #5	56 13 000914 56 13 000915	796F75 796F76

No.	Spare parts	Catalogue no.	Alternative marking
9.3	Ceramic nozzle 6,5x48 #4 Ceramic nozzle 8x48 #5 Ceramic nozzle 9,5x48 #6	56 13 000947 56 13 000946 56 13 000945	796F71 796F72 796F73
10	Power cable with plug 4 m Power cable with plug 8 m Power cable with plug 12 m	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
11	Cable set 20W SGRIP 4 m Cable set 20W SGRIP 8 m Cable set 20W SGRIP 12 m	56 13 200208 56 13 200209 56 13 200210	USL45V03A0B USL45V04A0B USL45V37A0B
12	Gas supply hose set 4 m Gas supply hose set 8 m Gas supply hose set 12 m	56 13 200187 56 13 200188 56 13 200189	U45V09-GS5 U45V10-GS5 U45V09-37-GS5
13	Water hose blue 4 m Water hose blue 8 m Water hose blue 12 m	56 13 200190 56 13 200191 56 13 200193	UN45V070B-WF1 UN45V080B-WF1 UN45V07-370B-WF1
14	Cable plug TIG 20/18W	56 13 200261	UNSL3550
15	Water hose red	56 13 200192	USL-1-WR1
16	Spring cable support	56 13 200262	USLH26-S
17	Cover assembly	56 13 200265	USLH-1820-S
18	Gun plug housing	56 13 200263	UNSLH26-H + USLH1820-S
19	Ball joint TIG	56 13 200266	UERK100



## T18 SGRIP



Model	T18 SGRIP	T18SC SGRIP
Cooling	Liquid	Liquid
Technical data according to EN 60 974-7:		
▪ Max. current at 100% duty cycle	270 A AC / 380 A DC	290A AC / 410 A DC
▪ Diameter of tungsten electrode	1,0- 4,0 mm	1,0- 4,0 mm
▪ Gas flow	5-12 l/min	5-12 l/min
Length/ Catalogue no.	4,0 m / 56 01 061804 8,0 m / 56 01 061808 12,0 m / 56 01 061812	4,0 m / 56 01 061814 8,0 m / 56 01 061818 12,0 m / 56 01 061822

Torch T18F SGRIP version with flexible torch body, technical data like for T18 SGRIP.  
Torches are delivered without control plugs.



TIG torches dedicated for specific TIG machines, or T18F SGRIP and T18SC SGRIP torches with remote control, available on request.

## Spare parts for T18 SGRIP

No.	Spare parts	Catalogue no.	Alternative marking
1	Torch body SR-18W MOST	56 13 003372	-
1.1	Torch body SR-18F MOST (flexible)	56 13 200010	UWP18FX
1.2	Torch body SR-18SC MOST (hardened)	56 13 200012	UWP18SC
2	Handle trigger kpl. ON/OFF	56 13 200100	UER1MS
3	Handle big TIG SGRIP	56 13 200220	RY-ERH200
4	Insulator SR-17/18/26	56 13 014810	18CG
4.1	Laminar insulator	56 13 014812	54N01
4.2	Laminar insulator Jumbo	56 13 017813	54N63
5	Back cap long SR-17/18/26	56 13 003181	57Y02
5.1	Back cap short SR-17/18/26	56 13 003270	57Y04
6	Cable cover	56 13 004596	-
6.1	Cable cover 4 m	56 13 200250	USLERCO200-40
6.2	Cable cover 8 m	56 13 200251	USLERCO200-80
6.3	Cable cover 12 m	56 13 200252	USLERCO200-120
7	Collet 1,0 SR-17/18/26 Collet 1,6 SR-17/18/27 Collet 2,0 SR-17/18/28 Collet 2,4 SR-17/18/29 Collet 3,2 SR-17/18/29 Collet 4,0 SR-17/18/29	56 13 009930 56 13 009932 56 13 009934 56 13 009936 56 13 009940 56 13 009942	10N22 10N23 - 10N24 10N25 54N20
7.1	Collet 2,4 Jumbo Collet 3,2 Jumbo	56 13 010024 56 13 010032	- -
8	Collet body TIG 1,0 SR-17/18/29 Collet body TIG 1,6 SR-17/18/30 Collet body TIG 2,0 SR-17/18/31 Collet body TIG 2,4 SR-17/18/32 Collet body TIG 3,2 SR-17/18/32 Collet body TIG 4,0 SR-17/18/32	56 13 003830 56 13 003883 56 13 003914 56 13 003921 56 13 003952 56 13 003960	10N30 10N31 - 10N32 10N28 406488
8.1	Gas lens body 1,0 SR-17/18/26 Gas lens body 1,6 SR-17/18/26 Gas lens body 2,4 SR-17/18/26 Gas lens body 3,2 SR-17/18/26 Gas lens body 4,0 SR-17/18/26	56 13 008235 56 13 008252 56 13 008272 56 13 008301 56 13 008310	45V24 45V25 45V26 45V27 45V28
8.2	Gas lens body 2,4 SR-17/18/27 Jumbo Gas lens body 3,2 SR-17/18/27 Jumbo	56 13 008310 56 13 008280	45V64 995795
9	Ceramic nozzle 6,5x47 #4 Ceramic nozzle 8,0x47#5 Ceramic nozzle 9,5x47 #6 Ceramic nozzle 11,0x47 #7 Ceramic nozzle 12,5x47 #8 Ceramic nozzle 16,0x47#10 Ceramic nozzle 19,5x47#12	56 13 000768 56 13 000770 56 13 000780 56 13 000783 56 13 000784 56 13 000786 56 13 000788	10N50 10N49 10N48 10N47 10N46 10N45 10N44

No.	Spare parts	Catalogue no.	Alternative marking
9.1	Ceramic nozzle 8,0x76 #5 Ceramic nozzle 9,5x76 #6 Ceramic nozzle 11,0x76 #7	56 13 001006 56 13 001008 56 13 001010	10N49L 10N48L 10N47L
9.2	Ceramic nozzle 6,5x42 lam #4 Ceramic nozzle 8,0x42 lam #5 Ceramic nozzle 9,5x42 lam #6 Ceramic nozzle 11,0x42 lam #7 Ceramic nozzle 12,5x42 lam #8 Ceramic nozzle 19,5x42 lam #12	56 13 000902 56 13 000900 56 13 000888 56 13 000886 56 13 000884 56 13 000882	54N18 54N17 54N16 54N15 54N14 54N19
9.3	Ceramic nozzle 9,5x48 Jumbo #6 Ceramic nozzle 12,5x48 Jumbo #8 Ceramic nozzle 16x48 Jumbo #10 Ceramic nozzle 19,5x48 Jumbo #12	56 13 001115 56 13 001117 56 13 001116 56 13 001119	57N75 57N74 53N88 53N87
10.	Power cable with plug 4 m Power cable with plug 8 m Power cable with plug 12 m	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
11.	Cable set 18W SGRIP 4 m Cable set 18W SGRIP 8 m Cable set 18W SGRIP 12 m	56 13 200204 56 13 200205 56 13 200206	USL40V64AOB USL41V29AOB USL41V37AOB
12.	Gas supply hose set 4 m Gas supply hose set 8 m Gas supply hose set 12 m	56 13 200184 56 13 200185 56 13 200186	U45V090B-G55 U45V100B-G55 U45V09-370-G55
13.	Water hose blue 4 m Water hose blue 8 m Water hose blue 12 m	56 13 200190 56 13 200191 56 13 200193	U45V070B-WF1 U45V080B-WF1 U4507-370B-WF1
14.	Cable plug SGRIP	56 13 200261	UNSL3550
15.	Water hose red	56 13 200192	USL-1-WR1
16.	Spring cable support	56 13 200262	USLH26-S
17.	Cable assembly	56 13 200265	USLH1820-S
18.	Gun plug housing	56 13 200263	UNSLH26-H
19.	Ball joint TIG	56 13 200264	UERKJ200



### 3. MMA equipment and torches

#### 3.1. MMA equipment



#### Inverter rectifiers MOST PONTE 200

We present you a new source of inverter power under the MOST brand, designed for coated electrode welding. Application of new technologies and modular fixture enabled the weight reduction of rectifier up to 5,0 kg. To make price more attractive, we disabled additional functions that are not necessary for coated electrode welding. However, this solution does not compromise the weld quality. In terms of welding current and electrical arc, Ponte 200 can fully satisfy even the most demanding customers, although this device is very simple to operate.



Model	Ponte 200 MOST
Main voltage (50/60 Hz) +/-15%	1x230 V, 50-60 Hz
Range of welding current	20-200 A
Maximal power consumption I1max	34 A
Welding current at 20% / 60% / 100% duty cycle	200 A / 120 A / 100 A
Open circuit voltage	63 V
Power factor	0,73
Effectiveness	85%
Protection class/insulation	IP 21 / F
Protect network	16 A
Dimensions	320x123x220 mm
Welding socket	10/25 (small)
Weight	5,0 kg
Catalogue no.	53 00 030680
Optional accessories:	
▪ Suitcase for MOST devices	52 45 200200
▪ Thermos for electrode storage MOST	50 00 004400

Delivery includes: cardboard box, welding cables (electrode and earth cables).





## Inverter rectifier PONTE 320 MOST

PONTE 320 MOST is the unit purposed for welding with MMA coated electrodes and TIG DC welding with friction start (LiftArc). Range of welding current up to 320 A and the possibility of welding with cellulose-coated electrodes makes PONTE 320 universal welder for any kind of MMA welding. The device is equipped with a VRD function, which reduces the open circuit voltage to 9 V (at the moment of arc ignition 67 V).

This unit has an intelligent ventilation system, which works in case of welding or exceeding the temperature specified inside. This solution allows to limit the dust accumulation inside the device device.

Model	PONTE 320
Main voltage (50/60 Hz)	3x400 V +/-10%15%
Power $I_{1max}$	26 A
Effective power $I_{eff}$	17 A
Welding current:	
▪ at 40% duty cycle	320 A / 32,8 V
▪ at 60% duty cycle	265 A / 31,2 V
▪ at 100% duty cycle	220 A / 30 V
Range of welding current MMA i TIG	10 – 320 A
Open circuit voltage	62 V
Protection class	IP 23C
Insulation class	H (180°C)
Dimensions	655x275x385 mm
Weight	23 kg
Catalogue no.	
▪ Rectifier Ponte 320 MOST	53 00 040320
▪ Earth and electrode cable 35 mm <sup>2</sup>	53 99 990108
▪ TIG holder 26V SGRIP 4 m MOST	56 01 062634
▪ Argon regulator MOST	62 30 750400
▪ Trolley	50 03 003940

Equipment is delivered in cardboard box, without welding cables.

Delivery includes 4 m power supply cable (4x4 m) with plug. Other various lengths of cable available on request.



Control panel – easy to use control panel designed for quick and intuitional change of parameters by a single knob. No need to memorize the sequence of settings for the given function, which greatly simplifies the welding operation.

Knob is designed to set values. Short press enables setting the parameters values (turning left/right). Press the knob for more than 2 seconds to select the working mode. Device automatically switches to STAND BY mode within 10 minutes, after the last operation is performed. In case of changing the parameters values or arc ignition, device switches to its normal working mode.

Ponte 320 is supported with temperature sensor signaling overheating.





## Inverter rectifier MOST PONTE 2060 VRD



Ponte 2060 VRD MOST is the unit dedicated for welding with MMA coated electrodes and TIG DC welding with friction start. Very modern, ergonomic housing is made of high-quality materials. The durability of the housing is reinforced by producer's patented solution called DDR (Dual Density Reinforcement).

### Function of rubber coat shields are:

- non-slip layer on handle,
- non-slip layer on the sides of the base to increase adhesion to the ground and to protect from accidental fall,
- shock absorbing inside the unit to protect electronic components.

The unit has an intelligent ventilation system, which works in case of welding or exceeding the temperature specified inside. This solution allows to limit the dust accumulation inside and increases PONTE 2060 VRD lifetime. This device is equipped with a self-diagnosis system, which shows error codes on the display in case of their occurrence.

The purpose of the VRD function is to increase the welder's safety in dangerous working environment. Particularly working on wet surfaces or in high atmospheric moisture conditions, to protect against electric shock. The VRD function switches off the power supply in milliseconds after the welding is finished and reduces the voltage on the coated electrodes to the safe level (about 11 V). Restarting the welding process activates the machine to work and allows the striking of the arc.

### The unit is equipped with additional functions which simplify electrode welding:

- HOT START – this function increases value of the current at the time of arc striking, in relation to the set value of welding current to simplify start of working.
- ANTI-STICK – device reduces the current in case of short-circuit and electrode stick, thus allows its separation from the work piece.

PONTE 2060 VRD has a clear control panel with digital display and a knob to choose the type of work MMA, MMA & VRD, TIG DC Lift-Arc.

Model	PONTE 2060 VRD
Main voltage (50/60 Hz)	1x230V ± 15%
Maximal power consumption TIG/MMA	6,1 / 7,2 kVA
Power $I_{max}$	42 A
Power $I_{eff}$	29,7 A
Welding current at duty cycle:	
▪ at 50% duty cycle	200 A / 28 V
▪ at 60% duty cycle	180 A / 27,2 V
▪ at 100% duty cycle	120 A / 24,8 V
Range of welding current MMA and TIG	5 – 200 A
Open circuit voltage (VRD)	68 V
Protection class	IP 23C
Insulation class	H
Dimensions	430x175x325 mm
Weight	7,2 kg
Catalogue no.	53 00 003812
Optional accessories:	
▪ TIG handle 26 V SGRIP MOST, plug 35-50, 4 m	56 01 062634
▪ Argon reducer MOST	62 30 750400
▪ Plastic suitcase (black)	52 45 200200



### 3.2. MMA holders



#### MMA electrode holders

Model	Catalogue no.
COMFORT 200 A MOST	57 00 000200
COMFORT 400 A MOST	57 00 000400
COMFORT 600 A MOST	57 00 000600
OBROTOWY 200 A MOST	57 00 001002
OBROTOWY 400 A MOST	57 00 001004
OBROTOWY 600 A MOST	57 00 001006
160 A/20 MOST*	57 00 001160
200 A/30 MOST*	57 00 001200
250 A/40 MOST*	57 00 001250
300 A/60 MOST*	57 00 001300

\* Welding cable is screwed up by lug. Eye-end fitted.



### 3.3. Dryers and thermos for electrodes



#### MOST dryers and thermos for electrodes

Electrode oven PD 0-20 MOST and PD 0-50 MOST is designed to dry electrodes before welding. Usually electrodes demand drying for 2-3 hours at 350°C. After drying process, electrodes should be kept in a thermos at 100°C. We recommend model GS-6P MOST.

Electrode thermos GS-6P MOST is designed for proper electrode storage after drying at 350°C e.g. in the dryer PD-020 MOST. Usually electrodes should be dried for 2-3 hours at 350°C. After bringing to working place they should be kept at 100°C, which protects them from absorbing moisture again. The device is adapted to a voltage range of 230 V.

Model	Dryer PD 0-20 MOST	Dryer PD 0-50 MOST	Thermos GS-6P MOST
Voltage	230 V	230 V	230 V
Power	1200 W	1600 W	300 W
Capacity	20 kg of electrodes in 4 chambers	50 kg of electrodes in 4 chambers	6 kg of electrodes in 1 chamber
Temperature setting	60-400°C	60-400°C	30-110°C
Weight	14 kg	26 kg	4 kg
Dimensions (LxWxH)	690x215x215 mm	800x310x310 mm	545x305x115 mm
Catalogue no.	50 00 003000	50 00 003026	50 00 003006

Bigger size dryers/ flux dryers also available.



#### Thermos for electrodes MOST

Thermos for electrodes MOST provides passive protection of previously dried electrodes and their temporary storage:

- robust and rigid housing made of PE-LD
- only a quarter of turn needed to close the thermos
- sticker that allows to describe, what is inside of thermos for identification
- effectively replaces unstable carton-packaging for electrodes
- capacity- up to 6.8 kg electrode with length of 450 mm
- maximum temperature of electrodes to be held- 121°C



Catalogue no. 50 00 004400



## 4. Plasma cutting equipment

### 4.1. Plasma cutter



#### Plasma Cutting Unit FanCut 42 MOST

Small, portable inverter unit dedicated for metal cutting. Light weight and 230 V current supply make it perfect choice for assembly works and small production.

The cutter uses a plasma torch ABICut 45 with a central connector 6 m long.

Model	FanCut 42
Voltage	1x230 V / 50-60 Hz
Protect network	16 A
Range of cutting current	20 – 40 A
Cutting current/duty cycle	40A / 50%
	33A / 60%
	28A / 100%
Quality cutting – steel	12 mm
Duty air pressure	5 bar
Maximal pressure	8,5 bar
Air consumption	119 l/min
Arc ignition	pneumatic-contact
Protection class	IP 23S
Dimensions (LxWxH)	148x490x295 mm
Weight	8,4 kg



The unit is delivered with a set of spare parts to the plasma torch (3 electrodes, 8 nozzles, a cover and a distance spring).

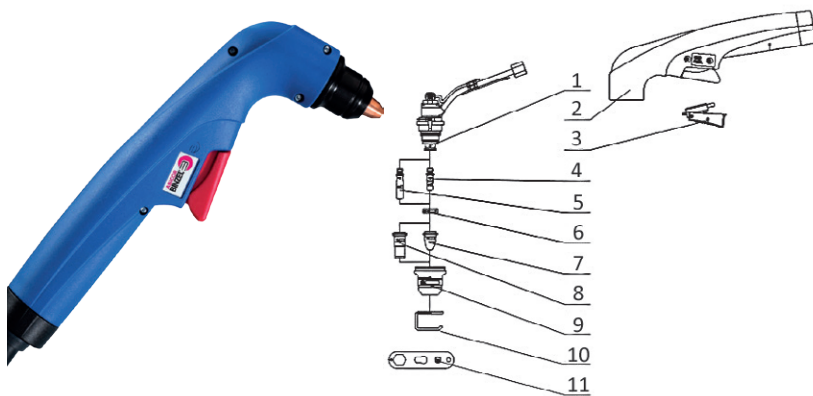
Catalogue no.

Plasma cutter FanCut 42 59 00 250060

Calipers set 742.D121.1 59 00 250103



#### Spare parts for cutting torch ABICut 45 for FanCut 40 / 41 / 42 MOST



No.	Spare parts	Manufacturer's catalogue no.	Catalogue no.
1.	Torch body ABICUT 25K / 45	748.0020.1	59 13 748020
2.	Handle ABICUT	748.0053.1	59 13 748053
3.	Trigger	185.0005	55 13 007360
4.	Short electrode	748.0032.10	59 13 748032
5.	Long electrode	748.0048.10	59 13 748048
6.	Diffuser*	748.0033.2	59 13 748033
7.	Cutting tip standard 0,8 mm	748.0035.10	59 13 748035
8.	Cutting tip long 0,9 mm (pin)	748.0049.10	59 13 748049
9.	Shield cap body ABICUT 45	748.0043.2	59 13 748043
10.	Guide ABICUT 25K/45	748.0050.5	59 13 748050
11.	Key / cutting buggy ABICUT 25K/45/75	748.0059.1	59 13 748059

\* Attention: Please put diffuser in the correct position!



Universal cooling unit for plasma cutters	Catalogue no.
Air filter AT-1000 + clamp	59 00 240036
Paper filter element AT-1000 5303	59 00 240037
Air filter adapter ATA-1000 5304 (in-out nipples)	59 00 240038



## Inverter plasma cutter MOST FanCut 70 / 100



### Catalogue no.

Fancut 70 MOST - 59 00 300070  
Fancut 100 MOST - 59 00 300100

### Available accessories:

Caliper PT-80 Compass Z0134AA - 59 25 000102  
Caliper PT-100 Compass Z0143ZA - 59 25 000104  
Scarf Bevel Cutting set Bevel Tool 51880 - 59 25 000106  
Air filter AT-1000 - 59 00 240036  
Paper filter element AT-1000 - 59 00 240037  
Air filter adapter AT-1000 (in-out nipples) - 59 00 240038

Delivery set includes plasma cutter torch PT-80/PT100 (6 m long), earth cable, mains cable and standard torch consumables kit.



Scan to visit our website  
<http://www.rywal.eu/f01>

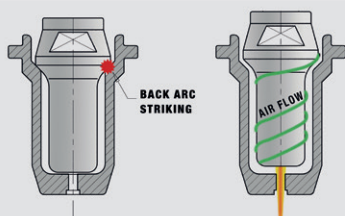
Most proudly presents two new plasma cutters: FanCut 70 and FanCut 100, modern and lightweight units designed for metal cutting by a stream of air plasma. Its lightweight and portability makes this device an ideal choice for manufacturing, repair, etc.

Fancuts are equipped with plasma cutting torch PT-80/100 (6 meters long). These pilot arch torches, thanks to BACK STRIKING technology, guarantee long life of consumables, especially when comparing to high-frequency arc ignition (HF).

Modern and easy to use control panel. Possibility of working in continuous cutting and metal grid cutting operating mode (plasma arc flows through cutting gaps) and electro-gouging. Additional pieces for contact cutting also available (drag tip for direct dragging on the material). Air pressure regulator mounted on the front of cutter.

Model	FanCut 70	FanCut 100
Main voltage: -10% / + 15%	3x400 V / 50-60 Hz	3x400 V / 50-60 Hz
Protect network	16 A	20 A
Max. current I <sub>1</sub>	16 A	21,5 A
Max. efficiently current I <sub>1eff</sub>	12 A	15 A
Power supply (60%)	11 kVA	16 kVA
Cutting current range	20-70 A	20-100 A
Open circuit voltage U <sub>0</sub>	280 V	310 V
Cutting current (at 100% duty cycle) I <sub>2</sub>	55 A	75 A
Cutting current (at 60% duty cycle) I <sub>2</sub>	70 A	100 A
Max. thickness quality cutting carbon steel	25 mm	30 mm
Recommended thickness quality cutting carbon steel	18 mm	22 mm
Separating cut	35 mm	40 mm
Duty air pressure (for torch- length 6 m)	5,5-6,0 bar	5,5-6,0 bar
Plasma gas	Compressed air	Compressed air
Maximal air pressure	10 bar	10 bar
Air consumption	160 l/min	200 l/min
Arc ignition	BACK STRIKING	BACK STRIKING
Welding power regulation	Steeple	Steeple
Insulation class	F	F
Cover protection class	IP 23	IP 23
Standard	EN 60974-1;-10	EN 60974-1;-10
Dimensions (w x l x h)	360x350x630 mm	610x340x680 mm
Weight	25 kg	39 kg

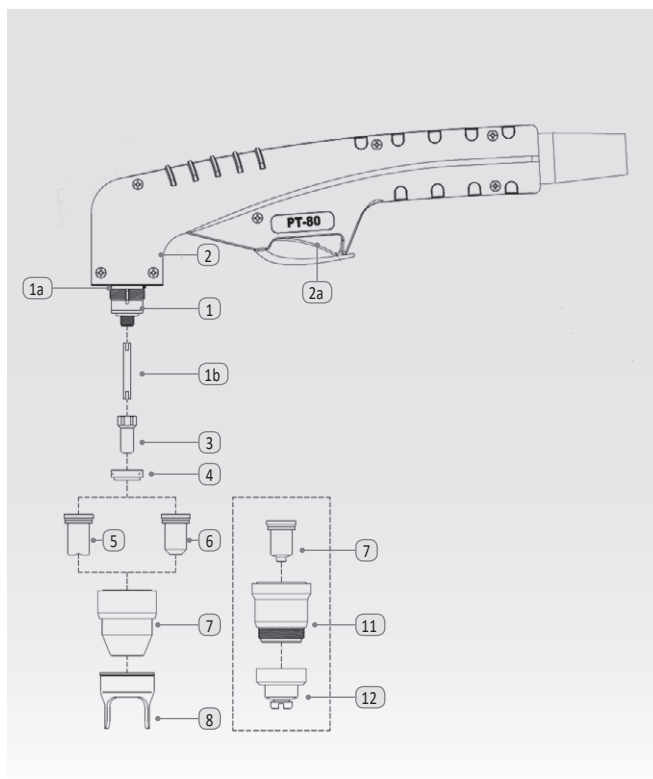
BACK STRIKING technology arc ignition scheme



Control panel

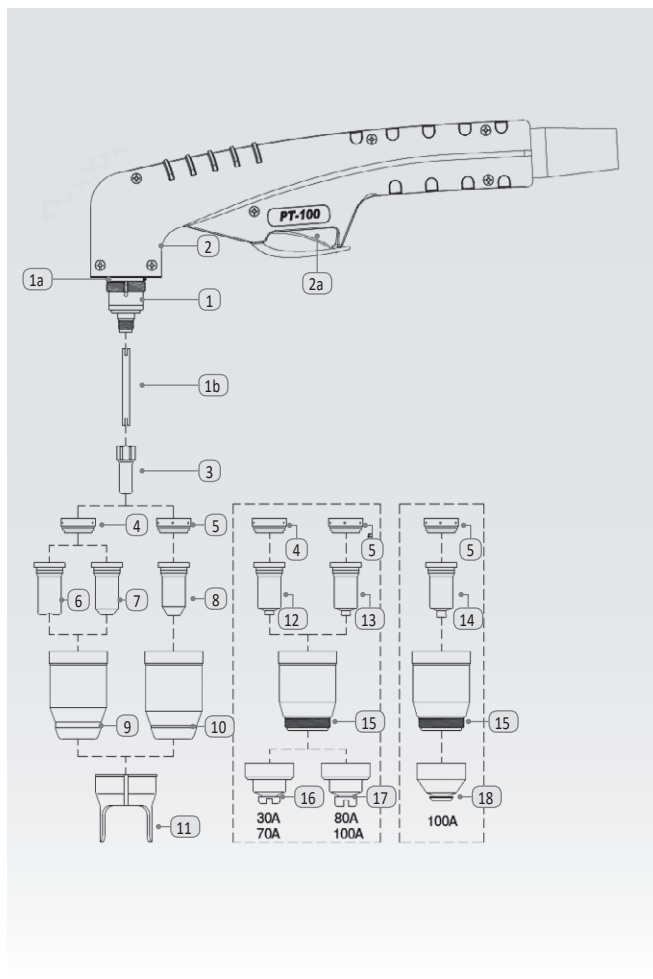


## Plasma torch PT-80 (FanCut 70 MOST)



No.	Spare parts	Catalogue no.
	Plasma torch PT-80 6 m Z0133AA	59 25 000010
1.	Torch tip PT-80 Z0043AA	59 25 000015
1a	O-ring 15x1,5 PT-80 Z0044AA	59 25 000016
1b	Coolant tube PT-80 Z0045AA	59 25 000017
2.	Handle PT-80/100 Z0046AA	59 25 000018
2a	Trigger PT-80/100 Z0222AA	59 25 000019
3.	Electrode PT-80 Z0048AA	59 25 000020
4.	Diffuser PT-80 Z0049AA	59 25 000021
5.	Tip PT-80 contact cutting 0,9 (30A-40A) Z0050AA, back striking	59 25 000022
6.	Tip PT-80 1,0 (40-50A) Z0051AA Tip PT-80 1,2 (60-70A) Z0053AA	59 25 000023 59 25 000024
7.	Double pointed spacer PT-80 Z0055AA	59 25 000025
8.	Guide PT-80 Z0056AA	59 25 000026
9.	Contact tip PT-80 1,0 (40-50A) Z0145AA Contact tip PT-80 1,2 (60-70A) Z0147AA	59 25 000027 59 25 000028
11.	Shield cup body PT-80 (hand) Z0089AA	59 25 000029
12.	Contact tip (guide) PT-80/100 (40-70A) Z0140AA	59 25 000030
	Caliper PT-80 Compass Z0134AA	59 25 000102

## Plasma torch PT-100 (FanCut 100 MOST)



No.	Spare parts	Catalogue no.
	Plasma torch PT-100 6 m Z0042AA	59 25 000070
1.	Torch tip PT-100 Z0057AA	59 25 000075
1a	O-ring 18x1,5 PT-100 Z0058AA	59 25 000076
1b	Coolant tube PT-100 Z0059AA	59 25 000077
2.	Handle PT-80/100 Z0046AA	59 25 000018
2a.	Trigger PT-80/100 Z0222AA	59 25 000019
3.	Electrode PT-100 Z0060AA	59 25 000078
4.	Diffuser PT-100 (30-70A) Z0061AA	59 25 000079
5.	Diffuser PT-100 (80-120A) Z0062AA	59 25 000080
6.	Tip PT-100, contact cutting 0,9 (30A-40A) Z0063AA, back striking	59 25 000081
7.	Tip, cutting PT-100 1,0 (40-50A) Z0064AA Tip, cutting PT-100 1,2 (60-70A) Z0066AA	59 25 000082 59 25 000083
8.	Tip, cutting PT-100 1,5 (100-110A) Z0068AA	59 25 000093
9.	Shield cap PT-100 (30-70A) Z0070AA	59 25 000085
10.	Shield cap PT-100 (80-120A) Z0071AA	59 25 000086
11.	Double pointed spacer PT-100 Z0072AA	59 25 000087
12.	Contact tip PT-100 1,0 (40-50A) Z0093AA, back striking	59 25 000088
13.	Contact tip PT-100 1,5 (100-110A) Z0095AA, back striking	59 25 000089
14.	Tip, gouging PT-100 2,2 (100-120A) Z0092AA, back striking	59 25 000090
15.	Shield cap body PT-100 Z0096AA	59 25 000091
16.	Contact tip PT-80/100 (40-70A) Z0140AA	59 25 000030
17.	Shield cap PT-100 (Hand) (80-120A) Z0097AA	59 25 000092
18.	Shield cap PT-100 gouging PT-80-100 (40-70A) Z0090AA	59 25 000032
	Caliper PT-100 Compass Z0143AA	59 25 000104



## Universal cooling system MOST for cooling of welding torches and plasma cutting torches Fancool 601-WA MOST

Fancool 601 WA MOST is an independent cooling unit for MIG/MAG, TIG and plasma cutting torches. Old type machines with gas cooled welding torches could not weld efficiently with higher current. The solution is to connect Fancool 601 WA MOST to welding machine MIG, TIG or plasma cutters.

This device enables to connect water-cooled torches to many machines, which increases efficiency of welding unit.

Model	Fancool 601-WA MOST
Tank	max 3,0 l
Max. pressure	p= 0,35 MPa (3,5 bar)
Max. flow rate	Q= 8 l/min
Voltage	230 V/ 50 Hz
Power consumption I <sub>1</sub>	1,3 A
Protection class	IP 23S
Weight	16,6 kg
Dimensions W x L x H	244 x 525 x 290 mm
Standard	PN EN 60974-2
Recognized current in auto mode system	60 A (if welding with lower current manual mode is recommended)
Catalogue no.	50 03 003805



To combine welding machine and cooling system, please contact with our service.

## MOST COOL30 - for cooling welding torches and plasma cutting torches

Special cooling liquid to plasma and welding torches MOST COOL 30. High quality substance for cooling all types of liquid-cooled torches for welding and cutting.

- Frost resistant to -30°C, non-conductive, colorless / transparent.
- Protects torch, welding cables, coolers, equipment for welding and cutting in front of electrolytic corrosion.
- Do not interact aggressively with rubber parts, including seals.

Package: 5 L

Catalogue no. 84 23 903005



### Other products

Cooling liquid BTC-15- 5 L (Abicor Binzel)	50 20 792001
Cooling liquid BTC-15- 20 L (Abicor Binzel)	50 20 792002
Cooling liquid LCL 30- 5 L (Lorch)	551.9008.5 50 20 792009



Attention:  
Welding in temperatures below 5°C requires special permits.

## 5. Welding generators

### Synchrone generators IP 23

Durable and reliable generators with wound rotors designed as power source for all units with an extremely high starting current. Equipped with full thermal and overload protection.

### Engines

Industrial engines Honda and B&S Vanguard working in 3000 r./min. range with automatic rotation stabilizer separated from overload, equipped with oil pressure sensors. Some types of generators equipped with diesel engines HATZ rated as the best power source for continuous working.

IP protection XX	
First cipher Protection against touch and foreign bodies	Second cipher Protection against water
0 No particular protection	0 No particular protection
1 Protection against ingress of solid bodies with a diameter over > 50 mm	1 Protection against dripping water
2 Protection against ingress of solid bodies with a diameter over > 12 mm	2 Protection against vertically dripping water. There must be no harmful effects on materials tipped (in a container) up to 15° from its normal position
3 Protection against ingress of solid bodies with a diameter over > 2,5 mm	3 Protection against fine water spray
4 Protection against ingress of solid foreign bodies with a diameter over > 1 mm	4 Protection against water spray
5 Dust protected	5 Protection against water jet



The machines have the CE certificate according to the relevant European Union guidelines. We provide this certificate with each unit.



## Welding generators MOST

Welding generators are the power source where the generator has to provide current for welding using coated electrode MMA. Basic advantage of this solution is perfect cooperation between an engine and a welding machine, and additionally lower price than for a full set consisting of a power generator plus welding equipment. Welding generators are equipped with output sockets 400 V / 230 V and they can be used as a standard power source during welding time breaks.

Model	MOST 220S	MOST 300SE
Welding current	220 A/35%	300 A/35%
Power 3~ max rated	6,7 kVA / 6,5 kVA	10,5 kVA / 10,0 kVA
Power 1~	3,5 kVA	4 kVA
Voltage	230 V 400 V	230 V 400 V
Current 3~	9,6 A	15,2 A
Current 1~	15,2 A	17,3 A
Frequency	50 Hz	50 Hz
Generator	synchron IP 23 brush	synchron IP 23 brush
Engine	Honda, GX390, 4-stroke, 1-cylinder, OHV, 390 cm <sup>3</sup> , cord reverse, rotation 3000/min	Vanguard, HP22, 4-stroke, 2-cylinders, OHV, 627 cm <sup>3</sup> , cord start or starter, rotation 3000/min
Tank and fuel type	6,5 l Pb95/98	20 l Pb95/98
Fuel consumption at 3/4 power	2,7 l/h	3,6 l/h
Work time 3/4 power	2,4 h	5,5 h
Oil amount in bowl	1,3 l	1,7 l
Noise	98 dB	98 dB
Dimensions (L x W x H)	775x565x595 mm	900x645x620 mm
Weight	92 kg	167 kg
Standard equipment	No oil switch, single-phase socket 16 A, triple-phase socket 16 A, thermal switch, welder 220 A (at 35% duty cycle).	No oil switch, single-phase socket 16 A, triple-phase socket 16 A, remote control switch, thermal switch, magnetic with differential voltmeter, frequency meter.
Catalogue no.	50 10 070722	50 10 071030





## 6. Welding accessories



### Welding cables H01N2D (OS1)



Name	Catalogue no.
OS-16	54 60 000016
OS-25	54 60 000025
OS-35	54 60 000035
OS-50	54 60 000050
OS-70	54 60 000070
OS-95	54 60 000095

### Plugs and Connectors (according to PN-EN 60974-12)

Name	Catalogue no.	Picture
Cable plug 10/25 MOST Cable plug 35/50 MOST Cable plug 50/70 MOST Cable plug 70/95 MOST	57 00 007025 57 00 007050 57 00 007070 57 00 007095	 CE
Cable socket 35/50 MOST Cable socket 50/70 MOST Cable socket 70/95 MOST	57 00 007150 57 00 007170 57 00 007195	 CE
Socket for device 10/25 MOST Socket for device 50/70 MOST	57 00 007225 57 00 007270	 CE
Plug to device 50/70 MOST	57 00 007370	 CE

### Earth crocodile clamp according to PN-EN 60974-13



150 A MOST Catalogue no. 57 00 003009  
200 A MOST Catalogue no. 57 00 003010  
300 A MOST Catalogue no. 57 00 003011

### Earth screw-crocodile clamp according to PN-EN 60974-13



600 A MOST Catalogue no. 57 00 004660

### Crocodile brass earth clamp according to EN 60974-13



Croco 300 MOST Catalogue no. 57 00 003014  
Croco 400 MOST Catalogue no. 57 00 003015  
Croco 600 MOST Catalogue no. 57 00 003016

### Welding hammers



300 g spiring MOST Catalogue no. 50 00 001610  
300 g euro MOST Catalogue no. 50 00 001620

### Magnetic triangle



Small triangle blue MOST Cat. no. 57 00 004800  
Big triangle blue MOST Cat. no. 57 00 004850

### Rotating magnetic holders



Torch holder  
MIG MOST Catalogue no. 57 00 004880  
TIG MOST Catalogue no. 57 00 004890

### Basket spool adapter B300



Adapter for basket spool B300  
Catalogue no. 50 00 001103 – one-piece  
Catalogue no. 50 00 001099 – two-piece



## Welding trolley WUS-150 MOST

Welding Trolley is designed to transport dedicated welding machines, and to transport gas cylinders of suitable size and weight in the back side. It is universal solution for transport of welding equipment, that do not have their own gear wheels (e.g., Ponte, Fancut, Pontig, Fanmig 175j, etc.), together with additional equipment such as: welding torches, spare parts, consumables or other tools. Shelves of the trolley and its legs are made of steel. Top shelf has the ability to secure by fastening any welding device against accidental tipping or dropping out of the truck. Back part of the trolley is designed to transport gas cylinder, it is also reinforced. Trolley is equipped with four wheels: two front swivel wheels (one of which has a brake), and two rear wheels on one axis. Hooks on the back side of the trolley secure the gas cylinder with a chain. The chain is included in set. One of the legs has a step break fitted in. The whole construction is powder-coated.



WUS-150 MOST Catalogue no. 50 03 003900



Simple application

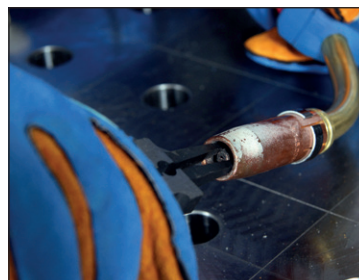
## Welding pliers MOST

Welding pliers MOST are dedicated to fulfill additional and assistant works during MIG/MAG welding process. These small tools allow to cut edge of welding wire, clear gas nozzles and contact tips from spatters and to fix parts of a welding torch in right position, etc.

Welding pliers are offered in two sizes:

Welding pliers 7" (recommended for torch MOST 15 / 24 / 25) Catalogue no. 57 00 004707

Welding pliers 8" (recommended for torch MOST 36 / 401 / 501) Catalogue no. 57 00 004708



## Other products

### Mini quick-connectors for liquids and gases

Mini quick-connectors with back-pressure valve for fast pneumatic and cooling system fitting for a wide range of devices.

Typ	Catalogue no.	Description	Picture
Quick-connector with a thread			
STB SPA 1-1-1/8"	50 14 102001	quick-connector G2 1/8" max pressure 35 bar	
STB SPA 3-4- Ø6	50 14 102002	quick-connector for hose Ø 6,0 mm max pressure 35 bar	
STB SPA 3-2- Ø9	50 14 102003	quick-connector for hose Ø 9,0 mm max pressure 35 bar	
Other connectors			
STB SPA 1-1/12/13 Ø6	50 14 182001	connector Ø 6,0 mm	
STB SPA 1-1/12/13/ Ø9	50 14 182002	connector Ø 9,0 mm	
Plugs for hoses			
501.0126 / 622.0812.0	50 14 182006	nipple 2,7 gaz	
STB SPA 1-1-01	50 14 182003	nipple for hose Ø 6,0 mm	
STB SPA 3-4-01	50 14 182004	nipple for hose Ø 9,0 mm	

### GER type hose clamps (for welding and plasma torches)



Catalogue no.	Type of GER clamps	Range of application
50 15 000061	GER 6,1	4,7 / 5,7 mm
50 15 000066	GER 6,6	5,2 / 6,2 mm
50 15 000070	GER 7,0	5,6 / 6,5 mm
50 15 000075	GER 7,5	5,9 / 7,0 mm
50 15 000080	GER 8,0	6,3 / 7,5 mm
50 15 000083	GER 8,3	6,6 / 7,8 mm
50 15 000087	GER 8,7	7,0 / 8,2 mm
50 15 000090	GER 9,0	7,0 / 8,5 mm
50 15 000095	GER 9,5	7,5 / 9,0 mm
50 15 000100	GER 10,0	8,0 / 9,5 mm
50 15 000105	GER 10,5	8,5 / 10,0 mm
50 15 000110	GER 11,0	8,8 / 10,5 mm
50 15 000113	GER 11,3	9,1 / 10,8 mm
50 15 000120	GER 12,0	9,5 / 11,5 mm
50 15 000123	GER 12,3	9,8 / 11,8 mm
50 15 000128	GER 12,8	10,3 / 12,3 mm
50 15 000133	GER 13,3	10,6 / 12,6 mm
50 15 000140	GER 14,0	11,3 / 13,3 mm
50 15 000145	GER 14,5	11,8 / 13,8 mm
50 15 000150	GER 15,0	12,3 / 14,3 mm
50 15 000155	GER 15,5	12,8 / 14,8 mm
50 15 000160	GER 16,0	13,1 / 15,3 mm
50 15 000165	GER 16,5	13,2 / 15,8 mm
50 15 000175	GER 17,5	14,6 / 16,8 mm
50 15 000185	GER 18,5	15,6 / 17,8 mm
50 15 000195	GER 19,5	16,5 / 18,8 mm
50 15 000207	GER 20,7	17,1 / 20,0 mm

## 7. Welding gauges

Controlling weld bead size allows to reduce manufacturing costs due to proper adjustment of welding parameters and high efficiency of filler metal.

The gauges provide high accuracy of measurements:

- misalignment of internal edges of pipes and sheet,
- gap between pieces of sheets being welded,
- symmetry of filled welds,
- throat of filled welds,
- other weld parameters.

Characteristics:

- metric pitch,
- small size, easy to operate,
- made of stainless steel, which provides precision and reliability,
- pitch resistant to external factors due to chemical treatment,
- possibility of calibrating gauges individually.



### MOST weld gauge



#### Weld gauge MS 1

Bridge-cam gauge

**Application:** measuring the height of the sprue (0-12 mm), measuring the length of the side fillet welds, measuring the thickness of the side fillet welds (0-15), measuring of displacement of flooding (0-5 mm), measuring the bevel angle plates (150°), measuring gap (0,5-5 mm).

**Catalogue no.** EM12110010



#### Weld gauge MS 2

Bridge-cam gauge

**Application:** measuring the height of the sprue (0-15 mm), measuring the length of the side fillet welds, measuring the thickness of the side fillet welds (0-15 mm), measuring of displacement of flooding, measuring the bevel angle plates (80°-160°), measuring gap (0,5-6 mm).

**Catalogue no.** EM12110020



#### Weld gauge MS 3

Bridge-cam gauge

**Application:** measuring of undercut depth (up to 25 mm), measuring the height of the sprue (25 mm), measuring the length of the side fillet welds (25 mm), concavity of fillet welds, check the throat of filled weld, the angle of beveling 0°-60°.

**Catalogue no.** EM12110030



#### Weld gauge MS 4

For accurately measurement fillet welds and butt welds.

**Application:** measurement of the permissible height riser, measurement limit convexity and concavity of fillet welds, measurement of the length of the sides of fillet welds, measuring the height of the sprue.

**Catalogue no.** EM12110040



#### Weld gauge MS 5

For accurately measurement fillet welds and butt welds.

**Application:** measurement of the permissible height riser, measurement limit convexity and concavity of fillet welds, measurement of the length of the sides of fillet welds, measuring the height of the sprue.

**Catalogue no.** EM12110050



#### Weld gauge MS 6

For detailed measurement of most popular fillet weld.

**Application:** The gauge allows to measure welds between 1/8"-1" (3.2 - 25.4 mm), both inch and metric version available.

**Catalogue no.** EM12110060



#### Weld gauge V WAC

For measuring of undercut depth, porosity comparison, amount of porosity (25 mm) and crown height Stainless iron. Metric scale.

**Catalogue no.** EM12110080



#### Weld gauge MS 7

For the rapid measurement of internal edges of sheet metal and welded metal plate gap.

**Application:** The gauge enables the measurement interval in the range of 1 mm to 4 mm in 1 mm increments. Graduation is incised at 1 mm. The instrument is available in inch and metric performance.

**Catalogue no.** EM12110070

## 8. Ceramic backings

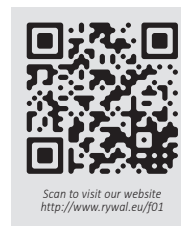
The requirement for better quality of products and higher efficiency of production processes results in high-technological welding action. Inadmissible defects may extensively appear in the root of weld during manual welding with coated electrodes and semi-automatic with gas shielding, such as: slag inclusions, gas blowhole, lack of weld penetration. In automatic welding process with the use of flux, when observation of welding process is infinitesimal and current regulation of parameters is complicated, burn-through of contacts may appear. Therefore welders with the best qualifications are needed to make root of weld or after cutting of root it is necessary to gouge.. Cutting of root and gouging overhead position is carried out in very difficult or after turning the construction which requires some other activities (e.g. stiffening the construction).

The problems can be eliminated by the use of ceramic backings protecting melted metal from the side of the root. Backings are mounted in welded construction by means of non-complicated systems, which is not a very labour-consuming process.

The advantages of using ceramic backings are as follows:

- reduced labor consumption thanks to elimination of whole variety of labour-consuming actions (cutting of root, the gouging, construction turning),
- welding actions can be run on one-side in technically convenient positions,
- possibility of employment of low qualified welders,
- elimination of weld defects in the root of weld and necessity of removing them,

It should be emphasized, that labour consumption constitutes 70-75% of typical welding construction costs and any reduction of it gives significant savings which considerably surpass the cost of purchasing ceramic backings.



### Ceramic backings MOST

No.	Type - dimensions [mm]	Length	Comments
1	<p>MOST LT05 TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm.</p> <p>Packaging: 60 pieces. Catalogue no. 50 49 500550.</p> <p><b>For solid and metal flux wire.</b></p>
2	<p>MOST LT 05TT TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm.</p> <p>Packaging: 60 pieces. Catalogue no. 50 49 500500</p> <p><b>For flux-cored or coated electrode welding.</b></p>
3	<p>MOST LT 06 TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm.</p> <p>Packaging:            Ø 6,0 mm - 250 pieces            Ø 8,0 mm - 160 pieces            Ø 10,0 mm - 120 pieces            Ø 12,0 mm - 100 pieces            Ø 15,0 mm - 75 pieces            Catalogue no.            Ø 6,0 mm - 50 49 500060            Ø 8,0 mm - 50 49 500080            Ø 10,0 mm - 50 49 500100            Ø 12,0 mm - 50 49 500120            Ø 15,0 mm - 50 49 500150</p>



For welding consumables using with ceramic backing – see chapter 10