



## 2010 Welding & Cutting Equipment Guide

VICTOR. Tweco. THERMAL DYNAMICS. Arcair. THERMAL ARC. TurboTorch. STODDY



INNOVATIVE NEW  
CUTTING EDGE  
PRODUCTS INSIDE

CHECK OUT WHAT WE HAVE TO OFFER

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## **Bringing You The Most Respected Names In Welding.**

Our company is comprised of many of the most respected market leading brands in the welding and metal fabricating industry. Thermadyne® product lines include oxy-fuel welding and cutting torches and regulators, plasma arc cutting and welding systems, arc welding power supplies, hardfacing and welding alloys, a wide array of manual and semi-automatic arc welding torches, tips and accessories, and high pressure gas control products. The scope of Thermadyne products allows the company to serve industries ranging from transportation and construction to mining, energy exploration, and a full range of manufacturing areas.

Thermadyne's business philosophy is founded on a commitment to growth through strategic acquisitions, aggressive new product development, superior quality and reliability, and service excellence on a worldwide basis. Thermadyne remains at the forefront of welding technology holding more than 340 U.S. and foreign patents. Our products are designed to deliver added value for our customers through enhanced safety, improved efficiency and productivity, and an improved working environment.

Service excellence is a long-standing tradition and trademark for Thermadyne companies, and we believe that excellent service is best defined by our customers. While we continually strive to raise our internal service quality standards and measurements, we also listen closely to our customers in all industries. Superior customer care extends far beyond our offices and manufacturing facilities. Thermadyne's field sales representatives and technical support personnel are recognized as the finest in the industry providing unequalled levels of service and customer training.

### Journeyman II

#### Applications

This heavy duty outfit cuts up to 3/4" (19.1mm) or 8" (203.2mm) with optional tips. It welds up to 1/8" (3.2mm) or 3" (76.2mm) with optional nozzles.

#### Journeyman II Components

- ESS4 Series regulators
- 315FC torch handle with built-in flashback arrestors and check valves
- CA 2460 cutting attachment
- W welding nozzle, size: 2
- 1-1-101 cutting tip
- T-grade hose 20' x 1/4" (6.1m x 6.4mm)
- Striker and tip cleaner
- Soft-sided shade 5 goggles



## Victor® Professional Equipment

Victor is committed to providing superior quality and reliability that earn our customers' confidence. Victor equipment and services are recognizably better than those of our competitors by consistently meeting customers expectations and by providing safe, reliable performance.

### Victor Professional Outfits

For Acetylene, Hydrogen & Alternate Fuels

#### Professional Series Welding, Cutting & Heating OUTFITS Standard Features

##### Optimum Safety

- Built-in reverse flow check valves and flashback arrestors
- Includes T grade hose for use with any fuel gas
- Self-reseating relief valve protects regulator

##### Cutting Attachment

- Operates with any fuel gas
- Meets third party listing that conforms to CGA E-4.

### Contender®

#### Applications

This heavy duty outfit cuts up to 3/4" (19.1mm) or 8" (203.2mm) with optional tips. It welds up to 3" (76.2mm) with optional nozzles.

#### Contender Components

- ESS3 Series regulators
- 315FC torch handle with built-in flashback arrestors and check valves
- CA 2460 cutting attachment
- MFA heating nozzle, size: 6
- 1-1-101 cutting tip
- T-grade hose 20' x 1/4" (6.1m x 6.4mm)
- Striker



### Journeyman®

#### Applications

This heavy duty outfit cuts up to 3/4" (19.1mm) or 8" (203.2mm) with optional tips. It welds up to 1/2" (12.7mm) or 3" (76.2mm) with optional nozzles.

#### Journeyman Components

- ESS4 Series regulators
- H 315FC torch handle with built-in flashback arrestors and check valves
- CA 2460 cutting attachment
- W welding nozzles, sizes: 1, 3, 5
- MFA heating nozzle, size: 8
- 1-1-101 cutting tip
- T-grade hose 20' x 1/4" (6.1m x 6.4mm)
- Striker and tip cleaner
- Soft-sided shade 5 goggles



### Contender AF

#### Applications

This heavy duty outfit is capable of cutting up to 8" (204mm) with the appropriate cutting tip.

#### Contender AF Components

- ESS3 Series regulators
- 315FC welding handle with built-in flashback arrestors and check valves
- CA 2460 cutting attachment
- Type 55 heating nozzle, size: 8
- 1-1-GPN cutting tip
- T-grade hose 20' x 1/4" (6.1m x 6.4mm)
- Striker



**Performer<sup>®</sup>**

**Applications**

This medium duty outfit cuts up to 1/2" (12.7mm) or 6" (152.4mm) with optional tips. It welds up to 1/4" (6.4mm) or 1.25" (31.8mm) with optional nozzles.

**Performer Components**

- ESS3 Series regulators
- 100FC torch handle with built-in flashback arrestors and check valves
- CA 1350 cutting attachment
- MFA-1 heating nozzle, size:4
- W-1 welding nozzle, size: 0
- O-3-101 cutting tip
- T-grade hose 12.5' x 3/16" (3.8m x 4.8mm)
- Striker and tip cleaner
- Soft-sided shade 5 goggles



**Professional Series SELECT CUTTING OUTFITS Standard Features**

**For use with any fuel gas**

- One cutting torch, for use with all fuel gases with the proper cutting tip.
- Available with 75° or 90° head angle depending on your need.

**Journeyman<sup>®</sup> Select**

**Applications**

This heavy duty outfit cuts up to 8" (203.2mm) and welds up to 3" (76.2mm) with accessories.

**Components**

- 315FC torch handle with built-in flashback arrestors and check valves
- CA 2460 cutting attachment
- CSR 450 Series regulators
- Available with 75° or 90° head angle



**Portable Tote**

**Applications**

This medium duty portable outfit cuts up to 1/2" (12.7mm) or 4" (101.6mm) with optional tips. It welds up to 1/4" (6.4mm) or 1.25" (31.8mm) with optional nozzles.

**Portable Tote Components**

- CSR 150 Series regulators
- 100FC torch handle with built-in flashback arrestors and check valves
- CA 1350 cutting attachment
- W-1 welding nozzle, size: 1
- Series 3 cutting tip
- T-grade hose 12.5' x 3/16" (3.8m x 4.8mm)
- Striker and goggles

**Optional**

- 10 cu. ft. CGA 200 acetylene cylinder
- 20 cu. ft. CGA 540 oxygen cylinder

\* Requires sufficient acetylene & oxygen supply



**Cutter Select<sup>™</sup> (ST 2600FC)**

**Applications**

This heavy duty outfit cuts up to 8" (203.2mm) with accessories.

**Components**

- ST 2600FC cutting torch with built-in flashback arrestors and check valves
- ESS4 Series regulators
- Available with 75° or 90° head angle



**Cutter Select (ST 1000FC)**

**Applications**

This heavy duty outfit cuts up to 5" (127.0mm) with accessories.

**Components**

- ST 1000FC cutting torch: bottom rear lever position with built-in flashback arrestors and check valves
- CSR 350 Series regulators
- Available with 90° head angle



**Cutter Select (ST 900FC)**

**Applications**

This heavy duty outfit cuts up to 5" (127.0mm) with accessories.

**Components**

- ST 900FC cutting torch: top rear lever position with built-in flashback arrestors and check valves
- CSR 350 Series regulators
- Available with 75° or 90° head angle



See our full line catalog or visit us on the web at [www.victorequip.com](http://www.victorequip.com) for more information.

Industrial Gas Equipment Catalog (Form No. 65-2007)



**Ordering Information**

Outfits

Part No.	Description	Torch Handle	Welding Nozzle	Cutting Attachment	Cutting Tip	Heating Nozzle	Oxygen Regulators	Fuel Gas Regulator	Hose	Accessories
0384-2035	Journeyman - Edge	H 315FC	(W) 1,3,5	CA 2460	1-1-101	8-MFA	ESS4-125-540	ESS4-15-300	20' X 1/4"	Striker, Goggles & Cleaners
0384-2036	Journeyman - Edge	H 315FC	(W) 1,3,5	CA 2460	1-1-101	8-MFA	ESS4-125-540	ESS4-15-510	20' X 1/4"	
0384-2040	Journeyman II - Edge	315FC	(W) 2	CA 2460	1-1-101	-	ESS4-125-540	ESS4-15-300	20' X 1/4"	
0384-2041	Journeyman II - Edge	315FC	(W) 2	CA 2460	1-1-101	-	ESS4-125-540	ESS4-15-510	20' X 1/4"	
0384-2050	Contender <sup>®</sup> - Edge	315FC	-	CA 2460	1-1-101	6-MFA	ESS4-125-540	ESS3-15-510	20' X 1/4"	Striker
0384-2051	Contender <sup>®</sup> - Edge	315FC	-	CA 2460	1-1-101	6-MFA	ESS4-125-540	ESS4-15-300	20' X 1/4"	
0384-2052	Contender <sup>®</sup> AF- Edge	315FC	-	CA 2460	1-1-GPN	8-55	ESS4-125-540	ESS3-15-510LP	20' X 1/4"	
0384-0812	Journeyman Select	315FC	-	CA 2460 - 90°	-	-	CSR 450D-540	CSR 460A-510	-	-
0384-0813	Journeyman Select	315FC	-	CA 2461 - 75°	-	-	CSR 450D-540	CSR 460A-510	-	-
0384-0814	Journeyman Select	315FC	-	CA 2460 - 90°	-	-	CSR 450D-540	CSR 460A-300	-	-
0384-2045	Performer <sup>®</sup> - Edge	100FC	(W-1) 0	CA 1350	0-3-101	4-MFA-1	ESS3-125-540	ESS3-15-510	12.5' X 3/16"	Striker, Goggles & Cleaners
0384-2046	Performer <sup>®</sup> - Edge	100FC	(W-1) 0	CA 1350	0-3-101	4-MFA-1	ESS3-125-540	ESS3-15-300	12.5' X 3/16"	Striker, Goggles & Cleaners

**Outfits - Straight Torches**

Part No.	Description	Torch/Head Handle°	Oxygen Regulator	Fuel Gas Regulator	Fuel Gas
0384-2060	ST 2600FC Cutter Select - Edge	ST 2600FC 21" 90°	ESS4-125-540	ESS4-15-510	Acetylene
0384-2061	ST 2600FC Cutter Select - Edge	ST 2600FC 21" 90°	ESS4-125-540	ESS4-15-300	Acetylene
0384-2062	ST 2600FC Cutter Select - Edge	ST 2600FC 21" 90°	ESS4-125-540	ESS4-40-510LP	Propane/Natural Gas, Propylene
0384-0859	ST 1000FC Cutter Select	ST 1000FC 21" 90°	CSR 350D-540	CSR 360A-510	Acetylene
0384-0860	ST 1000FC Cutter Select	ST 1000FC 21" 90°	CSR 350D-540	CSR 360A-300	Acetylene
0384-0853	ST 900FC Cutter Select	ST 900FC 21" 90°	CSR 350D-540	CSR 360A-510	Acetylene
0384-0854	ST 900FC Cutter Select	ST 900FC 21" 90°	CSR 350D-540	CSR 360A-300	Acetylene
0384-0855	ST 901FC Cutter Select	ST 901FC 21" 75°	CSR 350D-540	CSR 360A-510	Acetylene
0384-0857	ST 900FC Cutter Select	ST 900FC 21" 90°	CSR 350A-540	CSR 361B-510	Propane/Natural Gas, Propylene

**Portable Tote Kits**

Part No.	Description	Torch Handle	Welding Nozzle	Cutting Attachment	Cutting Tip	Heating Nozzle	Oxygen Regulators	Fuel Gas Regulators	Accessories
0384-0936	Portable Tote w/Cyl	100FC	(W-1) 1	CA 1350	0-3-101	-	CSR 150CR-540	CSR 160AR (MC)	"T" Grade 12.5' X 3/16" Hose, Goggles & Lighter
0384-0935	Portable Tote w/o Cyl	100FC	(W-1) 1	CA 1350	0-3-101	-	CSR 150CR-540	CSR 160AR (MC)	

**Victor<sup>®</sup> Professional Regulators / Flowmeters**

**700 Series**

**Single & Two Stage Cylinder Type Regulators**

- Extra heavy duty
- High flow rate – Up to 11,800 SCFH
- Forged brass body and housing cap
- 2.5" gauges – brass
- 3.25" diaphragm – stainless steel
- Manifold models available



**SR 350 Series**

**Single Stage Cylinder Type Regulators**

- Medium duty
- Forged brass body and housing cap
- 2.5" gauges – brass
- 2.75" diaphragm – fabric reinforced neoprene



**EDGE™ – ESS4 Series**

**Single Stage Regulators**

- Heavy duty
- High capacity
- Forged brass body & Zinc-Aluminum housing cap
- High impact ABS gauge guard
- SLAM impact absorbing safety knob
- Color-coded adjustment knob for quick gas identification
- Meets or exceeds CGA E-4, UL 252 and ASTM G-175 Promoted Ignition Test



**SR 250 Series**

**Single & Two Stage Cylinder Type Regulators**

- Medium duty
- Forged brass body and housing cap
- 2.0" gauges – brass
- 1.75" diaphragm – fabric reinforced neoprene



**450 Series**

**Single & Two Stage Cylinder Type Regulators**

- Heavy duty
- Medium/high capacity
- Forged brass body and housing cap
- 2.5" gauges – brass
- 3.25" diaphragm – stainless steel



**EDGE – ESS3 Flow Gauges**

**Single Stage Regulator Flowmeter**

- Medium capacity
- Forged brass body & Zinc-Aluminum housing cap
- High impact ABS gauge guard
- SLAM impact absorbing safety knob
- Color-coded adjustment knob for quick gas identification
- Meets or exceeds CGA E-4, UL 252 and ASTM G-175 Promoted Ignition Test



**EDGE – ESS3 Series**

**Single Stage Regulators**

- Medium capacity
- Forged brass body & Zinc-Aluminum housing cap
- High impact ABS gauge guard
- SLAM impact absorbing safety knob
- Color-coded adjustment knob for quick gas identification
- Meets or exceeds CGA E-4, UL 252 and ASTM G-175 Promoted Ignition Test



EDGE™ SERIES

**VICTOR**<sup>®</sup>  
Professional

Check out our **NEW** innovative line of Victor Professional EDGE Series regulators for all gas types.

Welcome to life on the EDGE!



[www.VictorEdge.com](http://www.VictorEdge.com)

**AF 250 / CF 253**

**Flowgauge Regulators**

- Medium duty
- Forged brass body and housing cap
- 2" brass gauges
- Delrin bushing
- Sintered inlet filter
- 1.75" diaphragm



**SR 4**

**Single Stage Piston Style Regulator**

- High pressure delivery 50 to 4500 PSIG
- Machined body and cap
- 2.5" gauges
- Delrin bushing



**HRF 2400**

**Single Stage Regulator Flowmeter**

- Regulator/Flowmeter combination in one compact unit
- Ideal for MIG/TIG applications
- Calibrated tube at 25 PSIG
- Cover tube contains over pressure protection



**S 700 / S 350 / S 250**

**High Volume Station Regulators**

- Extra heavy duty (S 700), Medium/heavy duty (S 350) and Light duty (S 250)
- Forged brass body and housing cap
- Maximum inlet pressure:  
S 700 - 350 PSIG  
S 350 - 200 PSIG  
S 250 - 200 PSIG
- Delrin bushing



**DFM 150 Dual Flow**

**Dual Flow Regulator Flowmeter**

- Designed to monitor two separate processes of gas flow
- Brass body
- Teflon seat
- Sintered inlet filter
- Lexan cover tubes
- Brass piston
- Aluminum ball (flowmeter version)



**L 700 / L 350 / L 250**

**High Volume Line Regulators**

- Heavy duty (L 700), medium/heavy duty (L 350) and light duty (L 250)
- Forged brass body and housing cap
- Maximum inlet pressure: 350 PSIG
- Delrin bushing



**See page 18 for ordering information on available gauge guards.**



**Victor® Professional Torch Handles**

**Professional Series TORCH HANDLE Standard Features**

- Covers a full range of welding, cutting and heating needs.
- Safety - Built-in flashback arrestors and reverse flow check valves.
- Threaded assembly for economical service.
- Meets third party listing that conforms to CGA E-4.

**HD 310C**

**Victor Heavy Industry Torch Handle**

The HD 310C is compatible with high capacity heating nozzles and is performance matched to the CA 2460 Series cutting attachment.

- Built-in reverse flow check valves



**H 315FC / 315FC**

**Heavy Duty Torch Handles**

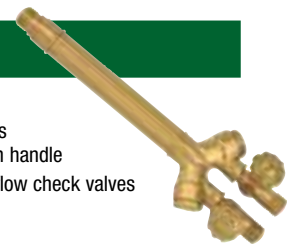
- The CA 2460 Series cutting attachment is performance matched to both the H 315FC and 315FC torch handle
- H 315FC is a high flow torch handle
- Built-in flashback arrestors and reverse flow check valves



**100FC**

**Medium Duty Torch Handle**

- The CA 1350 Series cutting attachment is performance matched to the 100FC torch handle
- Built-in flashback arrestors and reverse flow check valves



**Victor Professional Cutting Attachments**

**Professional Series CUTTING ATTACHMENT Standard Features**

**For use with any fuel gas**

- One cutting attachment or torch, for use with all fuel gases with the proper cutting tip.

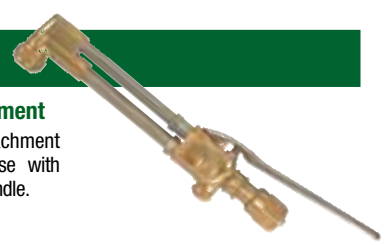
**CA 2460 Series**

**Heavy Duty Cutting Attachment**

The CA 2460 Series cutting attachment is performance matched for use with H 315FC and the 315FC torch handle.

**Head Angles:** 75°, 90°, 180°

**Cutting Range:** 8" (200 mm)



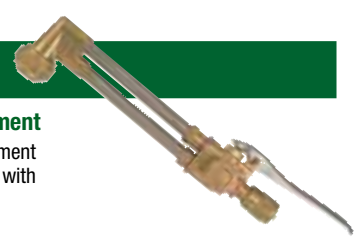
**CA 1350 Series**

**Medium Duty Cutting Attachment**

The CA 1350 Series cutting attachment is performance matched for use with the 100FC torch handle.

**Head Angles:** 75°, 90°, 180°

**Cutting Range:** 6" (152 mm)



**Victor Professional Nozzles**

**Type MFA (Acetylene)**

**Heavy Duty Heating Nozzle**

Multi-flame heating head for heat treating, straightening & priming.

- Sizes 12 & 15 for use with HD 310C torch handle and 3/8" hose
- Smaller sizes available for use with 300 Series torch handles



**Type MFA-1 (Acetylene)**

**Medium Duty Heating Nozzle**

Multi-flame heating head for heat treating, straightening & priming.

- Use with 100 Series torch handles



**Type MFN (Propane / Natural Gas)**

**Heavy Duty Heating Nozzle**

Multi-flame heating head for heat treating, straightening & priming.

- Sizes 12, 15 & 20 for use with HD 310C torch handle and 3/8" hose
- 300 Series torch handles use size 8 & 10
- 100 Series torches use Type MFN-1



**Type 55 (All Alternate Fuel Gases)**

**Heavy Duty Heating Nozzle**

Multi-flame heating head for heat treating, straightening & priming.

- Sizes 10, 15 & 20 for use with HD 310C torch handles and 3/8" hose
- Smaller sizes available for use with 300 Series torch handles



**Type W (Acetylene)**

**Heavy Duty Heating Nozzle**

General purpose welding & pre-heating.

- 65° tip angle
- Use with 300 Series torch handles



**Type W-1 (Acetylene)**

**Medium Duty Heating Nozzle**

General purpose welding & pre-heating.

- Use with 100 Series torch handles



## Victor<sup>®</sup> Heavy Industry Straight Cutting Torches

### HC 1500C

**Straight Cutting Torch without Built-in Flashback Arrestors. With Reverse Flow Check Valves**

*For Use with Propane or Pressurized Natural Gas ONLY*

#### Features

- Cutting capacity: 48" (121.9cm)
- Extra heavy duty
- 3-hose design

#### OPTIONS

**Head Angles:** 90°, 180°  
**Torch Lengths:** 56", 84", 96"



### HC 1400

**Straight Cutting Torch without Built-in Flashback Arrestors. Without Reverse Flow Check Valves**

*For Use with Propane or Pressurized Natural Gas ONLY*

#### Features

- Cutting capacity: 30" (76.2cm)
- Use of high flow flashback arrestors is recommended
- Use accessory reverse flow check valves
- 2-tube heavy duty design

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 27", 36", 48", 60", 72", 96"



### HC 1200C

**Straight Cutting Torch without Built-in Flashback Arrestors. With Reverse Flow Check Valves**

*For Use with Propane or Pressurized Natural Gas ONLY*

#### Features

- Cutting capacity: 18" (45.7cm)
- Use of high flow flashback arrestors is recommended
- Best for high flow applications
- 2-tube design

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 21", 36", 48", 60", 72", 84", 96"



### HC 1100C



**Straight Cutting Torch without Built-in Flashback Arrestors. With Reverse Flow Check Valves**

*For Use with Propane or Pressurized Natural Gas ONLY*

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 21", 36", 48", 60", 72"

#### Features

- Cutting capacity: 14" (35.5cm)
- Use of high flow flashback arrestors recommended
- Use Victor Series 1 cutting tips for alt. fuel (not for acetylene)
- Low pressure mixer
- Built-in reverse flow check valves on Oxygen and fuel gas inlet
- Ideal for scrap cutting
- Available with Harris-Style head
- Use Victor Bulldog™ cutting tips for best performance
- 3-tube lightweight design



## Victor Professional Straight Cutting Torches

### Professional Series STRAIGHT CUTTING TORCH Standard Features

#### For use with any fuel gas

- One cutting attachment for use with all fuel gases with the proper cutting tip.

### ST 2600FC

#### Straight Cutting Torch

- Uses Series 1 cutting tips
- For use with any fuel gas

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 17", 21", 27", 36", 48", 72"  
**Cutting Capacity:** 8" (203.2mm)



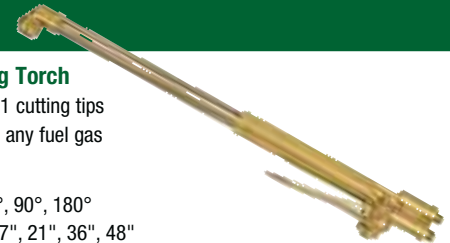
### ST 1000FC

#### Straight Cutting Torch

- Uses Series 1 cutting tips
- For use with any fuel gas

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 17", 21", 36", 48"  
**Cutting Capacity:** 5" (127mm)



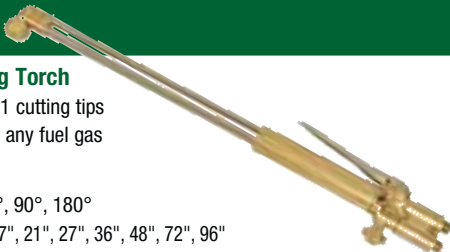
### ST 900FC

#### Straight Cutting Torch

- Uses Series 1 cutting tips
- For use with any fuel gas

#### OPTIONS

**Head Angles:** 75°, 90°, 180°  
**Torch Lengths:** 17", 21", 27", 36", 48", 72", 96"  
**Cutting Capacity:** 5" (127mm)



## Straight Torch Users Guide

Torch Series	Gas Type	Cutting Capacity*
CST 800FC**	Multi-Fuel	4"
ST 900FC	Multi-Fuel	5"
ST 1000FC	Multi-Fuel	5"
ST 2600FC	Multi-Fuel	8"
HC 1100C	Propane/Natural Gas	14"
HC 1200C	Propane/Natural Gas	18"
HC 1400	Propane/Natural Gas	30"
HC 1500C	Propane/Natural Gas	48"

\*with optional tips.

\*\*not shown.



# WORK WITH THE BEST

NAME: *Harry Cazett*

PROFESSION: *Welder/Fabricator*

COMPANY: *Harry's Welding Service*

## JOURNEYMAN WELDER AND HIS TORCH

**JOB EXPERIENCE:** Upon finishing welding school Harry Cazett purchased a Victor® Journeyman® torch. That same torch has lasted the entire length of his career as a water pipeline welder. In 1972 he opened Harry's Welding Service, leasing out his welding truck to water companies. Nowadays Cazett is still in business for himself, taking contract jobs doing maintenance and repair on all sizes of water pipeline from 2" to 48".

**TOOL OF CHOICE:** Victor Journeyman Torch

**WHY THE VICTOR JOURNEYMAN?** "Because in the 39 years since I purchased my Journeyman, I've never had one problem. I have to give credit to my Journeyman. It's helped me get to where I am today."

*"Victor has helped me tell my story"*



*Harry carries the torch... will you?*

# VICTOR®



**THERMADYNE®**, A GLOBAL CUTTING AND WELDING LEADER, joins the American Welding Society in encouraging individuals to practice the art, craftsmanship and professions of welding, metalworking and fabrication. Victor®, Thermal Dynamics®, Thermal Arc®, Arcair®, Tweco®, Stody®, CIGWELD® and TurboTorch® are among the Thermadyne® family of brands that you can count on for safety, reliability and quality.

[www.thermadyne.com](http://www.thermadyne.com)



**American Welding Society**  
Sustaining Company Member



## Victor® Professional Automation Equipment

Victor is committed to providing superior quality, reliable automation equipment that earn our customers' confidence. The following illustrates our offerings for quality automated gas equipment. Victor, committed to providing the best in quality, safety and reliability.

### Victor Professional Machine Torches

Victor machine torches are available in two and three hose models. Three hose torches are a high performance "straight through" design that minimizes turbulence and improves cut quality. Accessory reverse flow check valves are supplied for use at the torch inlet connections.

#### MT 200 Series

##### Machine Cutting Torch\*

- Uses Series 1 cutting tips
- Two-hose torch

##### OPTIONS

**Gas:** Acetylene, Propane, Natural Gas and other Pressurized Fuel Gases

**Torch Lengths:** 8.5", 14"

**Cutting Capacity:** 7" (178mm)

\*Gear racks sold separately.



#### MT 300 Series

##### Machine Cutting Torch\*

- Uses Series 1 cutting tips
- Three-hose torch

##### OPTIONS

**Gas:** Acetylene, Propane, Natural Gas and other Pressurized Fuel Gases

**Torch Lengths:** 14", 22.5"

**Cutting Capacity:** 12" (305mm)

\*Gear racks sold separately.



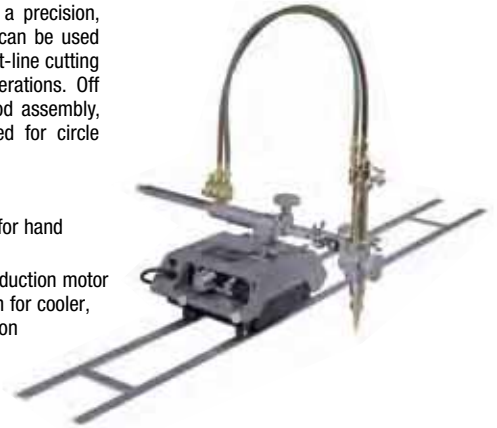
### Victor Professional Cutting Machine

#### VCM 200 Portable Cutting Machine

The versatile VCM 200 is a precision, tractor-type machine that can be used on its own track for straight-line cutting and a variety of welding operations. Off track and with a radius rod assembly, the VCM 200 can be used for circle cutting.

##### Features

- Large thumb screws for hand tight adjustments
- Constant speed AC induction motor located opposite torch for cooler, more efficient operation
- Dual drive controls & direct speed readout
- Cone disc drive
- Counter-balanced design for torch racking distance up to 18" (45.7cm) from the machine
- Speed constant over wide range of temperatures
- Torch holder designed for 1.375" (35mm) diameter torches



### Victor Professional Machine Accessories

#### Model BHA 2

Adjustable head adds flexibility to machine cutting torches by allowing bevel cuts without changing the position of the torch. Can be set at any angle from 0° to 90° on either side of vertical.

- Uses Series 1 cutting tips
- Optional **pre-heat attachment** is available for use with the BHA adjustable head attachment. The pre-heat attachment uses replacement tip ends



#### Model 591

Strip cutter for use with machine cutting torches only. It is designed to accept two tips for use with a common torch.

- Uses Series 1 cutting tips.
- Adjustable for cutting strips from 1.25" (32mm) to 12" (305mm) wide and thickness up to 3" (76mm)



#### Gear Racks

- For Use with MT 200 and MT 300 Series cutting torches
- Available in 10" (254mm) and 18" (457mm) lengths
- 32 pitch





## Victor® CutSkill® Equipment

Victor manufactures CutSkill products for the frequent user. Victor CutSkill, quality products at an affordable price.

### Victor CutSkill Outfits

#### CutSkill® Series Welding & Cutting OUTFITS Standard Features

- Toolbox
- Torch handle with built-in flashback arrestors and check valves
- Includes RM grade hose, striker and soft-sided goggles

### CutSkill 450

#### Applications

This heavy duty outfit cuts up to 3/4" (19.1mm) or 6" (152.4mm) with optional tips. It welds up to 1/8" (3.2mm) or 3" (76.2mm) with optional nozzles.

#### Components

- RC 450 Series regulators
- WH 370FC-V torch handle with built-in flashback arrestors and check valves
- CA 370-V cutting attachment
- 2-UM welding nozzle
- Series 1 cutting tip
- RM-grade hose 25' x 1/4" (7.6m x 6.4mm)
- Toolbox
- Striker and soft-sided goggles



### CutSkill 350

#### Applications

This heavy/medium duty outfit cuts up to 3/4" (19.1mm) or 6" (152.4mm) with optional tips. It welds up to 1/8" (3.2mm) or 3" (76.2mm) with optional nozzles.

#### Components

- RC 350 Series regulators
- WH 370FC-V torch handle with built-in flashback arrestors and check valves
- CA 370-V cutting attachment
- 2-UM welding nozzle
- Series 1 cutting tip
- RM-grade hose 25' x 1/4" (7.6m x 6.4mm)
- Toolbox
- Striker and soft-sided goggles



### CutSkill 250

#### Applications

This medium duty outfit cuts up to 1/2" (12.7mm) or 5" (127.0mm) with optional tips. It welds up to 5/64" (2.0mm) or 1.25" (31.8mm) with optional nozzles.

#### Components

- RC 250 Series regulators
- WH 270FC-V torch handle with built-in flashback arrestors and check valves
- CA 270-V cutting attachment
- 0-UM-1 welding nozzle
- 0-3-101 cutting tip
- RM-grade hose 20' x 3/16" (6.1m x 4.8mm)
- Toolbox
- Striker and soft-sided goggles



### CutSkill 250AF

#### Applications

Capable of cutting up to 5" (127mm) with appropriate cutting tip.

#### Components

- RC 250 Series regulators
- WH 270FC-V torch handle with built-in flashback arrestors and check valves
- CA 270-V cutting attachment
- Heating nozzle: 6-MFN-1
- Cutting tip: 1-3-GPN
- T-grade hose 20' x 3/16" (6.1m x 4.8mm)
- Toolbox
- Striker and soft-sided goggles



### CutSkill Portable Tote

#### Applications

This medium duty portable outfit has a rugged patented design with a molded plastic carrying case and cuts up to 1.25" (31.8mm) or welds up to 3/32" (2.4mm).

#### Components

- SR 150 CR regulator
- SR 160 AR regulator
- WH 270FC-V welding torch with built-in flashback arrestors and check valves
- CA 270-V cutting attachment
- 2-UM-1 welding nozzle
- 0-3-101 cutting tip
- Twin RM-grade hose 12.5' x 3/16" (3.81m x 4.8mm)

#### Optional

- 10 cu. ft. CGA 200 acetylene cylinder
- 20 cu. ft. CGA 540 oxygen cylinder



## Victor® CutSkill Regulators / Flowmeters

### CutSkill Series REGULATOR / FLOWMETER Standard Features

- A Wide Variety of Delivery Ranges and Gases.
- Two Year Warranty

### RC 450 Series

#### Single Stage Cylinder Type Regulator

- Heavy duty
- Forged brass body & housing cap
- 2.5" gauges
- Stem type seat mechanism
- Stainless steel diaphragm
- Maximum inlet pressure: 3000 PSIG
- 9/16"-18 outlet connection
- Internal relief



### RC 350 Series

#### Single Stage Cylinder Type Regulator

- Medium to heavy duty
- Forged brass body & housing cap
- 2.5" gauges
- Delrin bushing
- Neoprene diaphragm
- Maximum inlet pressure: 3000 PSIG



### RC 250 Series

#### Single Stage Cylinder Type Regulator

- Medium duty
- Forged brass body & housing cap
- 2" gauges
- Delrin bushing
- Neoprene diaphragm
- Maximum inlet pressure: 3000 PSIG



### 1400 Series

#### HRF Flowmeter

- Single stage piston design
- Argon, Argon/CO<sub>2</sub> Mix & CO<sub>2</sub> models
- Maximum inlet pressure: 3000 PSIG
- 25 PSIG or 80 PSIG preset pressure
- Up to 50 CFH for Argon and up to 38 CFH for CO<sub>2</sub> delivery
- Available in CGA 320 & 580 inlet connections
- Optional MIG kit available with 10' Hose (3m)



## TPR 250 Purging Regulator

### Single Stage Purging Regulator

- Forged brass body & housing cap
- Stem type seat mechanism
- Neoprene diaphragm
- Maximum inlet pressure: 3000 PSIG



## Victor CutSkill Handles / Attachments

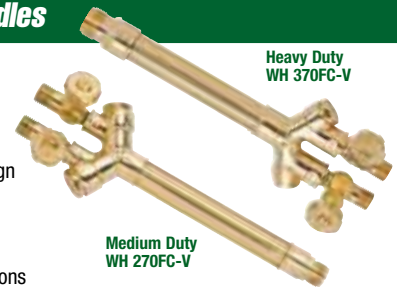
### CutSkill Series TORCH HANDLES Standard Features

- For cutting attachments, welding tips and heating assemblies.
- Built-in reverse flow check valves and flashback arrestors for added operator safety.

### CutSkill Torch Handles

#### Features

- Built-in reverse flow check valves and flashback arrestors
- Tube within a tube design
- Three piece "Y" rear assembly with threaded connection
- 9/16"-18 hose connections
- Stainless steel ball valves



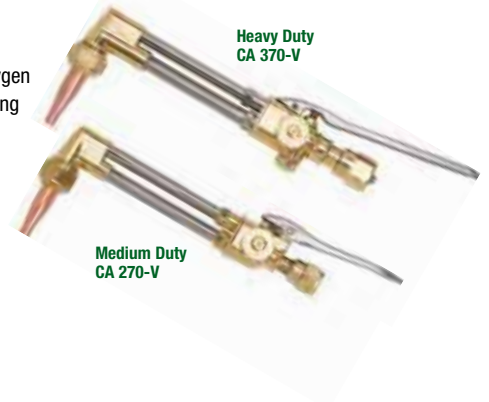
### CutSkill Series CUTTING ATTACHMENTS Standard Features

- For use with any fuel gas
- For use with acetylene, propane, butane, Liquid Air fuel gas, natural gas (2 PSI & above) and propylene.

## CutSkill Cutting Attachments

#### Features

- Universal mixer
- Easy-on cutting oxygen
- Stainless steel cutting oxygen lever and ball valve
- Head angle: 90°
- Cutting Range: 6" CA 370-V, 5" CA 270-V





## Victor® FirePower Equipment

Victor manufactures FirePower products for the light-duty contractor or the do-it-yourself handyman.

### Victor FirePower Outfits

#### FirePower 350

##### Applications

This heavy/medium duty outfit cuts up to 3/4" (19.1mm) or 5" (127.0mm) with optional tips. It welds up to 1/8" (3.2mm) or 3" (76.2mm) with optional nozzles.

##### Components

- RF 350 heavy/medium duty regulators
- WH 370 FC-FS torch handle with built-in flashback arrestors and check valves
- CA 350-FS cutting attachment
- 2-UM-350 welding nozzle
- 1-1-101 cutting tip
- R-grade hose 25' x 1/4" (7.6m x 6.4mm)
- Striker and goggles



#### FirePower 250

##### Applications

This medium duty outfit cuts up to 1/2" (12.7mm) or 3" (76.2mm) with optional tips. It welds up to 5/64" (2.0mm) or 3" (76.2mm) with optional nozzles.

##### Components

- RF 250 medium duty regulators
- WH 270FC-FS torch handle with built-in flashback arrestors and check valves
- CA 250-FS cutting attachment
- 0-UM-250 welding nozzle
- 0-3-101 cutting tip
- R-grade hose 12.5' x 3/16" (3.8m x 4.8mm)
- Striker and goggles



### Victor FirePower Regulators

#### RF 350 Series

##### Single Stage Cylinder Type Regulator

- Heavy/Medium duty
- Forged brass body
- Stem type seat mechanism
- Neoprene diaphragm
- Internal relief
- Maximum delivery pressure: 125 PSIG



#### RF 250 Series

##### Single Stage Cylinder Type Regulator

- Medium duty
- Forged brass body
- Stem type seat mechanism
- Neoprene diaphragm
- Internal relief
- Maximum delivery pressure: 125 PSIG



### Victor FirePower Handles / Attachments

#### FirePower Torch Handles

##### Features

- Built-in reverse flow check valves and flashback arrestors
- Victor tube within a tube design
- Three piece "Y" rear assembly with threaded connection
- 9/16"-18 hose connections
- Stainless steel ball valves



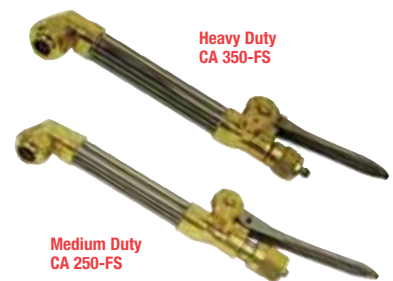
Heavy Duty  
WH 370FC-FS

Medium Duty  
WH 270FC-FS

#### FirePower Cutting Attachments

##### Features

- Universal mixer
- Triangular tube design
- Stainless steel cutting oxygen lever and ball valve
- Head angle: 90°
- Cutting Range:  
5" CA 350-FS  
3" CA 250-FS







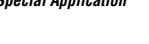


Heavy Duty  
CA 350-FS

Medium Duty  
CA 250-FS

**Acetylene**

- One Piece** *General Purpose*  
Series 1 Type **101**  
Hand & machine torch cutting. 
- One Piece** *General Purpose*  
Series 1 Type **101L**  
Extra length 10" tip. 
- One Piece** *General Purpose*  
Series 1 Type **101<sup>30°</sup>**  
Hand cutting & machine torch cutting, 30° angle with torch perpendicular. 
- One Piece** *General Purpose*  
Series 3 Type **101**  
Hand cutting. (Series 3 for small cutting head) 
- One Piece** *Special Application*  
Series 1 Type **108**  
Boiler tube removal. Short tip to insert inside tube or confined area. 
- One Piece Bent** *Special Application*  
Series 1 Type **112**  
Cutting close to bulkheads, hand cutting of rivet heads. 45° angle with torch perpendicular. 
- One Piece Bent** *Special Application*  
Series 1 Type **118**  
Deseaming, gouging, weld preparation, removing defective welds, rivet washing. 
- One Piece Bent** *Special Application*  
Series 3 Type **118**  
Deseaming, gouging, weld preparation, removing defective welds, rivet washing. (Series 3 for small cutting head) 

**Propylene**

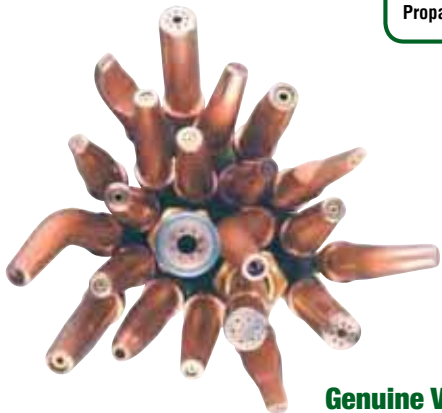
- Two Piece** *General Purpose*  
Series 1 Type **GPP**  
Hand & machine torch cutting. 
- Two Piece** *General Purpose*  
Series 3 Type **GPP**  
Hand cutting. (Series 3 for small cutting head) 
- Two Piece** *Special Application*  
Series 1 Type **HPP**  
Heavy pre-heat for scrap, bevel and other heavy pre-heat requirements. 
- Two Piece** *Special Application*  
Series 1 Type **BTMP**  
High performance bevel tip for use with mild steel, HSLA, T-1, HY-80 
- One Piece Bent** *Special Application*  
Series 1 Type **GTB**  
Gouging tip. 
- One Piece** *General Purpose*  
Series 1 Type **303MP**  
Hand & machine torch cutting. 
- One Piece** *General Purpose*  
Series 1 Type **MTHP**  
High speed machine cutting up to 8" (203.7mm). 

**Propane & Natural Gas**

- One Piece** *General Purpose*  
Series 1 Type **200**  
Hand & machine torch cutting. 
- One Piece** *Special Application*  
Series 1 Type **207**  
Rivet washing. 
- Two Piece Bent** *Special Application*  
Series 1 Type **GTB**  
High performance gouging tip. 
- One Piece Bent** *Special Application*  
Series 1 Type **218**  
Deseaming, gouging, weld preparation, removing defective welds, rivet washing. 
- One Piece Bent** *Special Application*  
Series 1 Type **244**  
Cutting close to bulkheads, rivet washing 
- One Piece** *Special Application*  
Series 1 Type **MCN**  
Coarse spline for extra heavy pre-heat and wide kerf for demolition, ripping and rail car repair. 
- Two Piece** *General Purpose*  
Series 1 Type **GPN**  
Hand & machine torch cutting. 
- Two Piece** *General Purpose*  
Series 3 Type **GPN**  
Hand torch cutting. (Series 3 for small cutting head) 
- One Piece** *Special Application*  
Series 1 Type **HDNL**  
Extra length. Mill and foundry, scrap cutting under severe conditions. 
- Two Piece** *Special Application*  
Series 1 Type **MTHN**  
High speed machine cutting up to 10" (254mm). 
- Two Piece** *Special Application*  
Series 1 Type **HPN**  
Heavy pre-heat for scrap, bevel and other heavy pre-heat requirements. 
- Two Piece** *Special Application*  
Series 1 Type **BTN**  
High performance bevel tip for use with mild steel, HSLA, T-1, HY-80. 
- Two Piece** *Special Application*  
Series 1 Type **CSN**  
Coarse spline for scrap cutting. 

**Look for Victor® Color Coded Packages**

- Acetylene (Red)
- Propylene (Orange)
- Natural Gas (Blue)
- Propane (Blue)



**Genuine Victor Professional Tips are available in a wide variety of types and sizes.**  
**Genuine Victor CutSkill® Tips are also available in a wide variety of competitive styles, types and sizes.**

Acetylene

CUTTING TIP SERIES 1-101, 3-101

Metal Thickness	Tip Size	Cutting Oxygen		Preheat Oxygen		Acetylene*		Speed (ipm)	Kerf Width (in)
		Pressure (PSIG)	Flow (SCFH)	Pressure (PSIG)	Flow (SCFH)	Pressure (PSIG)	Flow (SCFH)		
1/8"	000	20-25	20-25	3-5	3-5	5-11	28-32	0.04	
1/4"	00	20-25	30-35	3-5	3-5	6-11	27-30	0.05	
3/8"	0	25-30	35-40	3-5	3-5	6-11	24-28	0.06	
1/2"	0	30-35	40-45	3-6	3-5	9-16	20-24	0.06	
3/4"	1	30-35	40-45	4-7	3-5	8-13	17-21	0.07	
1"	2	35-40	40-50	4-8	3-6	10-18	15-19	0.09	
2"	3	40-45	50-60	5-10	4-9	14-24	12-15	0.11	
3"	4	40-50	50-60	5-10	5-11	18-28	9-12	0.12	
4"	5	45-55	60-60	6-12	6-13	22-30	8-11	0.15	
6"	6	45-55	60-60	6-15	8-14	25-35	6-8	0.15	
10"	7	45-55	70-80	6-20	10-15	25-35	4-5	0.34	
12"	8	45-55	90-100	7-25	10-15	25-35	3-5	0.41	

WELDING NOZZLE FLOW DATA

Metal Thickness	Tip Size	Drill Size	Oxygen Pressure (PSIG)		Acetylene Pressure (PSIG)		Acetylene Consumption (SCFH)	
			Min.	Max.	Min.	Max.	Min.	Max.
Up to 1/32"	000	75 (0.022)	3	5	3	5	1	2
3/64"	00	70 (0.028)	3	5	3	5	1.5	3
5/64"	0	65 (0.035)	3	5	3	5	2	4
3/32"	1	60 (0.040)	3	5	3	5	3	6
1/8"	2	56 (0.045)	3	5	3	5	5	10
3/16"	3	53 (0.050)	4	7	3	6	8	18
1/4"	4	49 (0.075)	5	10	4	7	10	25
1/2"	5	43 (0.089)	6	12	5	8	15	35
3/4"	6	36 (0.106)	7	14	6	9	25	45
1 1/2"	7	30 (0.128)	8	16	8	10	30	60
2"	8	29 (0.136)	10	19	9	12	35	75
3"	10	27 (0.144)	12	24	12	15	50	100
4"	12	25 (0.149)	18	28	12	15	80	160

\* Oxygen consumption is 1.1 times that of Acetylene under neutral flame conditions. Gas consumption data is merely for estimating purposes. It will vary greatly on the material being welded and the particular skill of the operator.  
 Pressures are approximate for hose length up to 625 ft. Increase pressures for longer hose lengths about 3 PSI per 25 ft.

MFA HEATING NOZZLES

Tip Size	Acetylene		Oxygen		BTU per Hour
	Pressure (PSIG)	Flow (SCFH)	Pressure (PSIG)	Flow (SCFH)	
4	6-10	6-20	8-12	7-22	See Below
6	8-12	14-40	10-15	15-44	
8	10-15	30-80	20-30	33-88	
10	12-15	40-100	30-40	44-110	
12"	12-15	60-150	50-60	66-165	
15"	12-15	90-220	50-60	99-244	

\* Use Model HD 310C torch and 3/8" hose.

Propylene

CUTTING TIP CHART  
CUTTING TIP SERIES GPP, HPP

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)**	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed (IPM)	Kerf Width
1/8"	000	20-25	5-5	24-28	.04	
1/4"	00	20-25	5-5	21-26	.05	
3/8"	0	20-30	5-5	20-24	.06	
1/2"	0	25-35	5-5	18-22	.06	
3/4"	1	30-35	5-5	15-20	.08	
1"	2	35-40	5-5	14-18	.09	
1 1/2"	2	40-45	5-5	12-16	.09	
2"	3	40-45	5-5	10-14	.10	
2 1/2"	3	45-50	5-5	8-12	.10	
3"	4	40-50	5-5	6-11	.12	
4"	5	45-55	5-5	7-10	.14	
5"	5	50-55	5-5	6-9	.14	
6"	6	45-55	5-5	6-9	.17	
8"	6	55-55	5-5	5-8	.18	
10"	7	55-55	5-5	5-8	.34	
12"	8	50-70	5-5	4-6	.41	
15"	10	50-70	5-5	4-6	-	
18"	12	45-65	5-5	4-6	-	

FOR 3/8 HOSE MACHINE TORCHES ONLY  
SEE REVERSE SIDE

CUTTING TIP SERIES MTHP  
(High Speed Machine Cutting)

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)**	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed (IPM)	Kerf Width
1/4"	00	55-55	5-5	23-30	.05	
3/8"	00	55-55	5-5	22-29	.05	
1/2"	0	55-55	5-5	20-28	.06	
3/4"	0	55-55	5-5	18-26	.06	
1"	1	55-55	5-5	17-24	.07	
1 1/4"	1	55-55	5-5	16-20	.07	
1 1/2"	1	55-55	5-5	15-18	.09	
2"	2	55-55	5-5	14-15	.09	
2 1/2"	2	55-55	5-5	10-13	.09	
3"	2	55-55	5-5	9-11	.09	
4"	3	55-55	5-5	7-10	.11	
5"	3	55-55	5-5	6-8	.11	
6"	3	55-55	5-5	5-7	.11	
7"	4	55-55	5-5	5-6	.14	
8"	4	55-55	5-5	5-6	.14	
9"	5	55-55	5-5	4-5	.18	
10"	5	55-55	5-5	3-5	.18	

SEE BELOW

SEE BELOW

NOTICE The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200/MT 300 Series	N/A	5 PSIG-UP

NOTICE These speeds and pressure settings apply only to mild steel in good condition. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

CAUTION High gas withdrawal rates may require cylinder manifolding. Consult your gas supplier.

Propane & Natural Gas

CUTTING TIP SERIES GPN, HPN

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)**	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed (IPM)	Kerf Width
1/8"	000	20-25	5-5	24-28	.04	
1/4"	00	20-25	5-5	21-26	.05	
3/8"	0	25-30	5-5	20-24	.06	
1/2"	0	30-35	5-5	18-22	.06	
3/4"	1	30-35	5-5	15-20	.08	
1"	2	35-40	5-5	14-18	.09	
1 1/2"	2	40-45	5-5	12-16	.09	
2"	3	40-45	5-5	10-14	.10	
2 1/2"	3	45-50	5-5	8-12	.10	
3"	4	40-50	5-5	6-11	.12	
4"	5	45-55	5-5	6-12	.14	
5"	5	50-55	5-5	6-12	.14	
6"	6**	45-55	5-5	5-9	.17	
8"	6**	55-55	5-5	5-8	.18	
12"	8**	60-70	5-5	4-6	.24	

SEE BELOW

NOTICE \*The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200N Series	N/A	8oz.-UP
MT 300N Series 000-6	20-55 PSIG	8oz.-UP
ST 900C Series	N/A	5 PSIG-UP
ST 1600C/ST 1700C Series	N/A	1 PSIG-UP
ST 1800C-ST 1900C Series	N/A	1 PSIG-UP
STN 2300C Series	N/A	2 PSIG-UP

\*\* For best results use ST 1600C-ST 1900C or ST2600FC series torches and 3/8" hose when using tip size 6 or larger.

\*\*\* All pressures are measured at the regulator using 25' x 1/4" hose through tip size 5 and 25' x 3/8" hose for tip sizes 6 and larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

CUTTING TIP SERIES MTHN  
(High Speed Machine Cutting)

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)**	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed (IPM)	Kerf Width
1/4"	00	55-55	5-5	23-30	.05	
3/8"	00	55-55	5-5	22-29	.05	
1/2"	0	55-55	5-5	20-28	.06	
3/4"	0	55-55	5-5	18-26	.06	
1"	1	55-55	5-5	17-24	.07	
1 1/2"	1	55-55	5-5	16-20	.07	
2"	2	55-55	5-5	15-18	.09	
2 1/2"	2	55-55	5-5	10-13	.09	
3"	2	55-55	5-5	9-11	.09	
4"	3	55-55	5-5	7-10	.11	
5"	3	55-55	5-5	6-8	.11	
6"	3	55-55	5-5	5-7	.11	
7"	4	55-55	5-5	5-6	.14	
8"	4	55-55	5-5	5-6	.14	
9"	5	55-55	5-5	4-5	.18	
10"	5	55-55	5-5	3-5	.18	

SEE BELOW

SEE BELOW

NOTICE The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen (PSIG)	Preheat Fuel (PSIG)
MT 200N Series	N/A	8oz.-UP
MT 300N Series	10-25 PSIG	8oz.-UP

NOTICE Data compiled using mild steel as test material. \* Pressure is measured at the torch inlet on MTH Series Tips. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

(For use only with MT400HC & MT600N Series)

MT400HC Series					
Length of Bevel	Tip Size	IPM	Oxygen Pressure	Fuel Pressure	Cutting Qty. Pressure
1	4	10-18	60-75	8-10	N/A
1 1/2	4	8-16	60-75	8-10	
2	4	6-14	60-75	8-10	
2 1/2	4	5-12	60-75	8-10	
3	5	6-11	60-75	8-12	
3 1/2	5	5-10	60-75	8-12	
4	5	4-8	60-75	8-12	
4 1/2	5	4-8	60-75	8-12	
5	6	3-8	65-85	8-15	N/A
5 1/2	6	3-7	65-85	8-15	
6	6	3-6	65-85	8-15	

MT600N Series					
Length of Bevel	Tip Size	IPM	Oxygen Pressure	Fuel Pressure	Cutting Qty. Pressure
1	4	10-18	35-65	10-12	40-60
1 1/2	4	8-16	35-65	10-12	40-60
2	4	6-14	35-65	10-12	40-60
2 1/2	4	5-12	35-65	10-12	40-60
3	5	6-11	35-65	10-12	40-65
3 1/2	5	5-10	35-65	10-12	40-65
4	5	4-8	35-65	10-12	40-65
4 1/2	5	4-8	35-65	10-12	40-65
5	6	3-8	35-65	10-12	45-75
5 1/2	6	3-7	35-65	10-12	45-75
6	6	3-6	35-65	10-12	45-75

NOTE: Bevels of 30° to 75° are possible on mild and most alloy steel without a preheat attachment

### Safety Accessories

#### Check Valves

- Help prevent gases traveling back into the fuel supply or oxygen system, creating a mixed gas condition
- Will not stop a flashback alone



#### Torch Models

**CTO & CTF** Torch – Check Valves Pair Pack (Oxygen and Fuel)

**CTO** Torch – Check Valve (Oxygen)

**CTF** Torch – Check Valve (Fuel)

#### Regulator Models

**CRO & CRF** Regulator – Check Valves Pair Pack (Oxygen and Fuel)

**CRO** Regulator – Check Valve (Oxygen)

**CRF** Regulator – Check Valve (Fuel)

#### FlameBuster™ Torch Flashback Arrestors

- Built-in reverse flow check valves
- Designed to prevent flashback from torch to hose
- For use with **MOST** Oxy-Fuel welding & cutting torches
- Greater flow than competitive models

#### Torch Models

**FB-1** Pair Pack for Torch (Oxygen & Fuel) Flashback Arrestors

**FB-0** (Oxygen) Torch Flashback Arrestor

**FB-F** (Fuel) Torch Flashback Arrestor



**FB-1**  
Pair Pack for Torch  
Flashback Arrestors  
(Oxygen & Fuel)



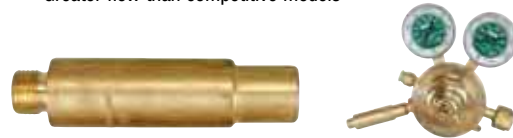
**FB-0**  
Torch Flashback  
Arrestor  
(Oxygen)



**FB-F**  
Torch Flashback  
Arrestor  
(Fuel)

#### FlameBuster Regulator Flashback Arrestors

- Built-in reverse flow check valves
- Designed to prevent flashback from hose to regulator
- For use with **MOST** Oxy-Fuel welding & cutting regulators
- Greater flow than competitive models



**FB-OR** Regulator Flashback Arrestor (Oxygen)



**FB-FR** Regulator Flashback Arrestor (Fuel)

#### Regulator Models

**FBR-1** Pair Pack for Regulator (Oxy/Fuel)

**FB-OR** (Oxygen) Regulator Flashback Arrestor

**FB-FR** (Fuel) Regulator Flashback Arrestor

#### Vanguard™ Replacement Cartridge

##### For Flashback Arrestors

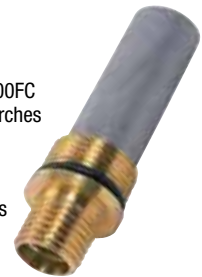
- Replacement Flashback Arrestor Cartridge (for both gases)
- Cartridges for use with Victor® 315FC, 100FC, and CST 800FC Torch Handles and Victor Straight Cutting Torches

##### Replacement Cartridge Models

**0657-0036** Pair Pack for use with 315FC, 100FC, and CST 800FC Torch Handles

**0656-0046** Pair Pack for use with ST 2600FC, ST 1000FC, ST 900FC

**H 315FC** – Refer to Master Catalog



See the Victor Industrial Catalog (65-2007) for complete information.

#### Regulator Gauge Guards

An added safety feature designed to help protect Victor's most popular industrial regulators. Also helps reduce costly repairs of damaged gauges.

Part No.

##### 250 Series

1429-0068 Steel Gauge Guard Green-Oxygen  
1429-0069 Steel Gauge Guard Red-Acetylene

##### 350 Series

1429-0066 Steel Gauge Guard Green-Oxygen  
1429-0067 Steel Gauge Guard Red-Acetylene

Part No.

##### 450 Series

1429-0056 Steel Gauge Guard Green-Oxygen  
1429-0057 Steel Gauge Guard Red-Acetylene



**Safety Accessories**

**Kwik-Connect™ Torch/Hose Connectors**

- Built-in reverse flow check valves
- Quickly and safely connect torch to hose
- Designed to prevent mismatching of Oxygen and fuel
- For use with **MOST** Oxy-Fuel welding & cutting torches

**Torch/Hose Models**

**KCO** (Oxygen) Kwik-Connect

**KCF** (Fuel) Kwik-Connect

**KC-1** Pair Pack Kwik-Connect (Oxygen and Fuel)



**KCO** Kwik-Connect (Oxygen)

**KCF** Kwik-Connect (Fuel)

**KC-1**  
Pair Pack  
Kwik-Connect  
(Oxygen and Fuel)

**FlameBuster Plus Flashback Arrestor**

*with Kwik-Connect for Torches & Regulators*

- Built-in reverse flow check valves
- Designed to prevent flashbacks
- For use with **MOST** Oxy-Fuel welding & cutting torches & regulators
- Greater flow than competitive models

**Torch Models**

**FBP-O** Torch Flashback Arrestor w/ Kwik-Connect (Oxygen)

**FBP-F** Torch Flashback Arrestor w/ Kwik-Connect (Fuel)

**FBP-1** Pair Pack Torch Flashback Arrestors w/ Kwik-Connect (Oxygen and Fuel)



**FBP-F** Torch Model (Fuel)



**FBP-O** Torch Model (Oxygen)

**FBP-1**  
Pair Pak  
Torch Flashback Arrestor  
(Oxygen & Fuel)

**Regulator Models**

**FBP-OR** **Not Shown** Regulator Flashback Arrestor w/ Kwik-Connect (Oxygen)

**FBP-FR** **Not Shown** Regulator Flashback Arrestor w/ Kwik-Connect (Fuel)

**FBPR-1** Pair Pack – **Not Shown** Regulator Flashback Arrestors w/ Kwik-Connect (Oxygen and Fuel)

**Victor CutSkill Flashback Arrestors**

- Built-in reverse flow check valves
- Designed to prevent mismatching of Oxygen and fuel
- 100% factory tested to insure maximum reliability

**Pair Paks**

**FBT-2** (Oxy/Fuel) Torch Mount

**FBR-2** (Oxy/Fuel) Regulator Mount

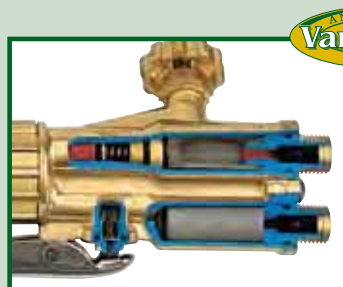


**Don't Leave Safety to Chance!**

Insist on using torches with built-in Flashback Arrestors and Check Valves.



**Victor® Torch Handle**  
with Built-in  
Flashback Arrestors  
and Check Valves



**Victor Straight Torch**  
with Built-in  
Flashback Arrestors  
and Check Valves



**Victor Equipment Reference Guide**

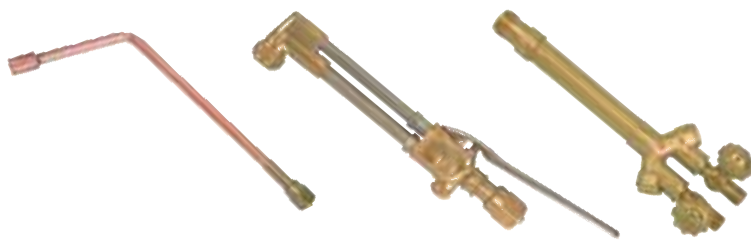
OUTFITS	REGULATORS			HANDLES	CUTTING ATTACHMENTS	CUTTING TIPS	
	OXYGEN	FUEL	GAS				
<b>EXTRA / HEAVY DUTY</b>							
<b>Victor Professional</b>							
Journeyman® Series Journeyman II Series	ESS4-125-540	ESS4-15-300 ESS4-15-510	→	315FC H 315FC HD 310C*  *HD310C – not included in any outfit, built-in flashback arrestors not included.	CA 2460 90° CA 2461 75° CA 2462 180°	1-101	GPN GPP
Journeyman Select Series	CSR 450 D-540	CSR 460A-510 CSR 460A-300 CSR 461B-510	→				
Contender® Contender® AF	ESS3-125-540	ESS3-15-300 ESS3-15-510 ESS3-15-510LP	→				
<b>Victor CutSkill®</b>							
CS450 Series	RC 450-125-540	RC 450-15-510 RC 450-15-300	→	WH 370FC-V	CA 370-V 90°	3-101	3-GPN 3-GPP
CS350 Series	RC 350-125-540	RC 350-15-510 RC 350-15-300	→				
<b>Victor FirePower®</b>							
FP350 Series	RF 350-125-540	RF350-15-510 RF350-15-300	→	WH 370FC-FS	CA 350-FS 90°		
<b>MEDIUM DUTY</b>							
<b>Victor Professional</b>							
Performer® Series	ESS3-125-540	ESS3-15-510 ESS3-15-300	→	100FC	CA 1350	3-101	3-GPN 3-GPP
Portable Tote Series	SR 150CR-540	SR 160AR-(MC)	→				
<b>Victor CutSkill®</b>							
CS250 Series CS250 Series AF	RC 250-125-540	RC 250-15-510 RC 250-15-300 RC 250-40-510LP	→	WH 270FC-V	CA 270-V	3-101	3-GPN 3-GPP
Portable Tote Series	SR 150CR-540	SR 160AR-(MC)	→				
<b>Victor FirePower®</b>							
FP250 Series	RF 250-125-540	RF 250-15-510 RF 250-15-300	→	WH 270FC-FS	CA 250-FS		
<b>LIGHT DUTY</b>							
<b>Victor Professional</b>							
Current Victor Outfits do not Contain a J-28 or J-40 Torch Handle				J-28 J-40	CA 1260 90°	3-101	3-GPN 3-GPP

Color Code:

Acetylene
Natural Gas / Propane
Propylene



WELDING / BRAZING NOZZLES, MIXERS, TIPS		HEATING NOZZLES	
<p>TIPS W ET RTE TE</p>	<p>TIPS RTEN TEN</p>	<p>MIXERS / TIP TUBES FE DFE UN UM Mixer Series</p>	<p>MIXERS / TIP TUBES FE DFE UN</p>
<p>TIPS W-1 ET ET-1 TE</p>	<p>TIPS TEN</p>	<p>MIXERS / TIP TUBES UN-1 FE-1 UM-1 Mixer Series</p>	<p>MIXERS / TIP TUBES UN-1 FE-1</p>
<p>TIPS W-J, ET, TE</p>	<p>TIPS TEN</p>	<p>MIXERS / TIP TUBES UN-J, DFE-1 FE-J, UM-J</p>	<p>MIXERS / TIP TUBES UN-J, UNN-J DFE-1, FE-J</p>



### Industrial Regulator Matrix

#### Delivery / Flow Ranges

Pressure Delivery					
PSIG	15	40	80	125	200
SR 700	•			•	•
EDGE ESS4	•	•		•	•
SR 450	•	•		•	•
EDGE ESS3	•	•		•	•
SR 350	•			•	•
SR 250	•	•	•	•	•
SR 5/6	•	•		•	•
VTS 700	•			•	•
VTS 450	•	•	•	•	•
VTS 250	•	•	•	•	•
VGS 450/350	•	•	•		

Pipeline					
PSIG	15	40	80	125	200
L 700	•		•	•	•
L 350	•		•	•	•
L 250	•	•	•	•	•
S 700				•	•
S 350	•	•	•	•	•
S 250	•	•	•	•	•

Flow Control								
SCFH	15	35	40	50	80	100	150	200
ESS3-FG			•					
AF 250		•	•					
HRF 2400			•	•			•	
DFM 150				•			•	
SR 310, 312						•		•
HSR			•	•				
HVTS	•			•			•	•
FM								•

• Denotes Delivery Availability

Supported by manufacturing and engineering expertise of Victor Equipment Company and a recently completed, multi-million dollar, state-of-the-art assembly and testing facility, Victor Specialty Products provides unsurpassed product quality and performance in a timely manner.

**With Victor Specialty Products, you will experience:**

- Expanded global product offering
- Improved product performance featuring “flow straightening technology”
- Guaranteed product quality and reliability
- Service excellence
- Global Sales Support

Victor Specialty Products is committed to exceeding industry standards with ongoing certifications and programs including:

- ISO 9001 Registered.
- Helium Leak Rate Certification
- CGA compliant with all CGA E-4 testing, including E-4, 7.1 “Oxygen Ignition Test.”

**Victor<sup>®</sup> Specialty Products**

Proven service to specialty gas and manifold markets for over 92 years.

**SG500 Series**

**Single Stage Stainless Steel Regulator**

The SG500 Series is the top range of high purity regulators. With their 316L stainless steel bodies and other wetted components, PCTFE seats and metal to metal diaphragm seals, they are suitable for all purity levels of inert gases as well as corrosive and toxic gases. Available in single stage, dual stage and line models.



**GP270 Series**

**General Purpose**

The GP 270 Series regulators are general purpose chrome plated forged brass body regulators for inert and other non-corrosive gases. Their neoprene diaphragms provide excellent responsiveness in many general laboratory applications including pressure testing, purging, blanketing, etc.



**HP500 Series**

**Single Stage Stainless Steel Regulator**

The HP500 Series are ultra high purity brass barstock body regulators suitable for all purity levels of inert and other non-corrosive gases. The 316L stainless steel diaphragms and metal to metal diaphragm seals protect the gases being controlled from external contamination and leakage.



**Laser Assist Regulator**

The D1-Dome Load regulator is designed for high flow and high pressure applications such as Laser Assist Gas and other high flow applications. The benefit of self loading dome load regulator is that the flow characteristics remain constant through the full range of flow requirements with minimal droop. The self loading design of the D-1 provides outlet pressures up to 550 psig and flow capacity in excess of 10,000 scfh.



**HP270 Series**

The HP 270 Series regulators are medium purity chrome plated forged brass body regulators for inert and other non-corrosive gases up to a grade 4.5 (99.995% pure). The large stainless steel diaphragm and large seat provide high flow with responsiveness and excellent regulating characteristics.



**PDS600 Series**

The PDS600 Series manifold system is a simple high purity switchover designed to provide a continuous supply of high purity gas to the laboratory or process plant. Available in brass or 316 stainless steel, the PDS600 is the solution to supplying pure gases to critical applications. Designed for use with one cylinder per side or with a multi-cylinder manifold.



**See our full line catalogs for high purity instrumentation (Form No. 56-0874) and gas manifolds (Form No. 81-2104) or visit us on the web at [www.victorhpi.com](http://www.victorhpi.com) for more information.**

**VM Series Manifold**

The VM Series manifolds are truly the most versatile available for industrial, medical, flammable and oxidizing gases. The high flow capacity and ease of operation make the VM manifolds the choice for a multitude of applications. Standard with local visual alarms and optional remote audio/visual alarms that provide notification when the reserve side is in operation and cylinders need to be changed.

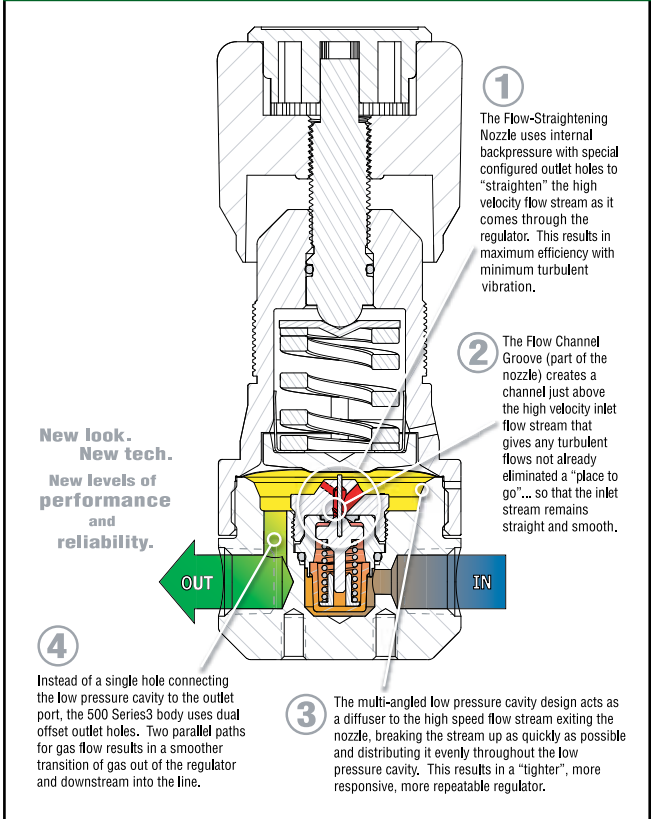


**VHP2000 Series**

The VHP2000 is an enclosure style pressure differential manifold ideal for indoor or outdoor installation. The standard system comes with a local visual alarm and optional remote alarms that provide visual and audible alarms anywhere an alarm signal is desired. Brass or stainless steel construction makes the VHP2000 an extremely versatile system suitable for a variety of high purity gases.



**500 Series<sup>3</sup> High Purity Regulator**





## Victor<sup>®</sup> Medical

Leader in medical oxygen market, delivering quality and outstanding service at a fair price.

### RESPI-LITE I Series

The Respi-lite I Series of regulators are lightweight compact medical oxygen regulators featuring an anodized aluminum exterior with brass internal components. The click style adjustment (0-8 LPM or 0-15LPM) and integral CGA870 yoke make these regulators ideally suited for respiratory patients at home or in a healthcare facility.



### SLIMLITE II<sup>®</sup> Series

The SLIMLITE II Series of regulators are sleek and light. The combination of anodized aluminum and full brass core construction with unibody design, incorporates a flow control regulator with a built-in yoke for durability and convenience.



### O<sub>2</sub>n Demand V Conserver

The O<sub>2</sub>n Demand V is a demand style dual cannula conserver for the active patient to make mobility a little easier and more convenient. No batteries are required for operation. Thus, the unit can operate in various temperatures and conditions without fear of failure. With it's pneumatic operating system, the patient receives oxygen during the entire inhalation cycle of the breathing cycle; not during exhalation. With 22 flow settings (11 conserve & 11 continuous) the O<sub>2</sub>n Demand V is suitable for a broad range of patients. The lighter weight (13.6 OZ.) and smaller size (4.75" long) of the O<sub>2</sub>n Demand V will cause less fatigue and the 4:1 conserving ratio allows longer cylinder life than other comparable conserving devices.



### VMG Series Regulators

The VMG-Series of flow gauge regulators provides superior performance. Pediatric flow gauges are scribed in both LPM & CC/M. All VMG models are built with high impact resistant Noryl<sup>®</sup> bonnets and contoured ABS adjusting knobs. High visibility gauges with enlarged numbers provide dependable and precise flow rate settings throughout the entire flow range.



### Victor Medical Flowmeters

Victor Medical flowmeters are made of highly durable medical grade Lexan<sup>™</sup> to minimize breakage.

- Large numerals for adjustment ease
- Lexan<sup>™</sup> inner and outer tubes avoid breakage
- Calibrated at 50 PSIG inlet pressure



### O<sub>2</sub>n Demand IV Conserver

The O<sub>2</sub>n Demand IV is a pulse style conserving device designed to deliver a controlled pulse dose of oxygen at the beginning of inspiration, regardless of breath rate. The single lumen design allows the use of standard single lumen cannulas. Its single lumen pulse design makes it the quietest and most accurate conserver on the market, making it less irritating to the patient. With a conserving ratio of up to 6:1 the O<sub>2</sub>n Demand IV maximizes ambulatory time while maintaining peak levels of oxygenation. The unit also offers the highest number of conserving and continuous flow settings available, making it suitable for a broader range of patients.



See our full line catalog or visit us on the web at [www.victormed.com](http://www.victormed.com) for more information.



**Victor Medical**  
Medical Gas Equipment Catalog  
(Form No. 68-9902)



**KEY APPLICATIONS**

- HVAC
- REFRIGERATION
- MAINTENANCE AND REPAIR
- PLUMBING



See our full line catalog or visit us on the web at [www.turbotorch.com](http://www.turbotorch.com) for more information.



**TurboTorch®**  
HVAC/R and Plumbing Equipment Catalog  
(Form No. 56-1252)

Air Fuel Equipment

**Self Lighting Torches & Tips**



**TX-500**  
**(0386-1299)**  
ProPak with TX-504 Self-Lighting Torch, and TX-504 and TX-503 Tips.



**STK-99**  
**(0386-0851)**  
STK-99 Self Lighting Hand Torch

**EXTREME®**  
Swirl Combustion Tip  
Concentrates Heat – Reduces  
Brazing Time by **40%**



**TX-503**  
**(0386-1297)**  
EXTREME Self Lighting Hand Torch



**PL-3A**  
**(0386-0874)**  
Air/Acetylene Self Lighting Tip



**PL-8A**  
**(0386-0819)**  
Air/Acetylene Self Lighting Tip



**TX-504**  
**(0386-1293)**  
EXTREME Self Lighting Hand Torch



**PL-5A**  
**(0386-0818)**  
Air/Acetylene Self Lighting Tip



**T-503 EXTREME**  
**(0386-1298)**  
Replacement Tip for TX-503 Self Lighting Hand Torch

Self Lighting Torches					Self Lighting Tips					
MODEL	TX-500	TX-503	TX-504	STK-99	PL-3A	PL-5A	PL-8A	PL-12A	T-504	T-503
<b>GAS</b>	Disposable Propane Tanks				Air Acetylene					
<b>BASIC BRAZING</b>	•	•	•	•	•	•	•	•	•	•
<b>HANDYMAN</b>	•	•	•	•	•	•	•	•	•	•
<b>HVAC</b>	•	•	•	•	•	•	•	•	•	•
<b>MAINTENANCE &amp; REPAIR</b>	•	•	•	•	•	•	•	•	•	•
<b>PLUMBING</b>	•	•	•	•	•	•	•	•	•	•
<b>REFRIGERATION</b>	•	•	•	•	•	•	•	•	•	•
<b>BRAZE/WELD</b>	3/4" - 4"	1/8" - 3"	3/4" - 4"	1/4" - 3"	1/4" - 1"	3/4" - 1 1/2"	1" - 2"	2" - 4"	3/4" - 4"	1/8" - 3"

See our full line catalog (Form No. 56-1252) or visit us on the web at [www.turbotorch.com](http://www.turbotorch.com) for more information.

Air Fuel Equipment

**Swirl Air Acetylene Kits & Tips**



**X-3B**  
(0386-0335)  
Flexible kit brazes light medium gauge steel.



**A-3**  
(0386-0101)



**PL-8ADLX-MC KIT**  
(0386-0834)



**X-5B**  
(0386-0338)  
Flexible lighter duty kit.



**PL-5ADLX-MC KIT**  
(0386-0832)



**PL-12ADLX-B KIT**  
(0386-0836)

**Manual Lighting Torches & Tips**



**STK-1**  
(0386-0408)  
Manual Lighting Hand Torch



**STK-11**  
(0386-1283)  
Manual Lighting Hand Torch



**ST-3 EXTREME**  
(0386-0171)  
Size 3 Hand Torch Tip



**STK-9**  
(0386-0403)  
Manual Lighting Hand Torch



**ST-1 EXTREME**  
(0386-0170)  
Size 1 Hand Torch Tip



**ST-11 EXTREME**  
(0386-1282)  
Double Barrel Hand Torch Tip

Swirl Air Acetylene Kits & Tips						Manual Lighting Torches & Tips					
MODEL	X-3B	X-5B	PL-5ADLX	PL-8ADLX	PL-12ADLX	STK-1	STK-9	STK-11	ST-1	ST-3	ST-11
GAS	Air Acetylene					Manual Lighting Torches & Tips					
BASIC BRAZING	•	•	•	•	•	•	•	•	•	•	•
HANDYMAN	•		•			•	•	•	•	•	•
HVAC	•	•	•	•	•	•	•	•	•	•	•
MAINTENANCE & REPAIR						•	•	•	•	•	•
PLUMBING	•	•	•	•	•	•	•	•	•	•	•
REFRIGERATION				•	•	•	•	•	•	•	•
BRAZE/WELD	1½" - 3"	2" - 3½"	¾" - 1½"	1" - 2"	2" - 3½"	1⅛" - ¾"	¾" - 2½"	⅛" - 7/8"	⅛" - 7/8"	⅜" - ¾"	⅜" - ¾"



TurboTorch by VICTOR													
MODEL	TTV-100-C	TTV-100-CP	TTV-100-CPT	TTV-J-A	TTV-J-AP	TTV-J-APT	TTV-J-AM	TTV-J-ST	TTV-J-STP	TTV-J-STPT	TTV-J-AC	TTV-J-ACP	TTV-J-ACPT
DESCRIPTION	Medium Duty Oxy-Fuel Cutting, Brazing, Heating Equipment Only	Medium Duty Oxy-Fuel Cutting, Brazing, Heating Plastic Tote Without Tanks	Medium Duty Oxy-Fuel Cutting, Brazing, Heating Plastic Tote With Tanks	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Equipment Only	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Plastic Tote Without Tanks	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Plastic Tote With Tanks	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Metal Tote Without Tanks	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Specialty Equipment Only	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Specialty Plastic Tote Without Tanks	Light Duty Oxy-Fuel and Air-Fuel Brazing, Heating Specialty Plastic Tote With Tanks	Light Duty Oxy-Fuel and Air-Fuel Cutting, Brazing, Heating Equipment Only	Light Duty Oxy-Fuel and Air-Fuel Cutting, Brazing, Heating Plastic Tote Without Tanks	Light Duty Oxy-Fuel and Air-Fuel Cutting, Brazing, Heating Plastic Tote With Tanks
NEW PART NO.	0386-1337	0386-1335	0386-1336	0386-1340	0386-1338	0386-1339	0386-1341	0386-1344	0386-1342	0386-1343	0386-1347	0386-1345	0386-1346
OLD MODEL/PN#	D.N.E.	110-01FP 0386-0038	110-01FPT 0386-0479	D.N.E.	CWK-5 0386-0055	CWK-5T 0386-0058	D.N.E.	D.N.E.	D.N.E.	D.N.E.	D.N.E.	D.N.E.	D.N.E.
BASIC BRAZING	•	•	•	•	•	•	•	•	•	•	•	•	•
HANDYMAN				•	•	•					•	•	•
HVAC	•	•	•	•	•	•							
MAINTENANCE & REPAIR							•	•	•	•	•	•	•
PLUMBING							•	•	•	•	•	•	•
REFRIGERATION				•	•	•	•	•	•	•			
Cut	3/4"	3/4"	3/4"								3/8"	3/8"	3/8"
Braze/Weld	5/64" - 2 5/8"	5/64" - 2 5/8"	5/64" - 2 5/8"	1/4" - 1/2"	1/4" - 1/2"	1/4" - 1/2"	1/4" - 1/2"	1/8" - 7/8"	1/8" - 7/8"	1/8" - 7/8"	3/16" - 3/4"	3/16" - 3/4"	3/16" - 3/4"

See our full line catalog (Form No. 56-1252) or visit us on the web at [www.turbotorch.com](http://www.turbotorch.com) for more information.

Air Fuel Equipment

**Nitrogen Purge Kit**



**0386-1370**

The ideal kit for HVAC and refrigeration installers and service technicians, the TurboTorch® Nitrogen Purge Kit gives professionals the tools they need to get the job done right. It's perfect for purging HVAC and refrigeration lines, leak testing, flushing drainage lines, cleaning coils and components, and even inflating tires.

**Deluxe Portable Torch Kit**

**0386-1397**

The Deluxe Portable Torch Kit is designed to hold essential solder equipment and tools while providing the comfort and convenience necessary for easy handling and transporting. The kit includes a durable, soft tool bag, self-lighting PS-3T tip, ergonomic torch handle, STK-R regulator and 12 ft hose. It also features four bonus items: a hose clamp, PS-4T tip, PL-812 torch shield and a roll of premium Viper SX solder.



**Viper™ Brazing Alloys, Solders and Fluxes**

TurboTorch's Viper is a complete line of brazing alloys, high silvers, solders and fluxes. These products are ideal for a variety of applications and deliver all the quality and performance professionals have come to expect from TurboTorch.

**VIPER™**

**TurboTorch's  
NEW complete  
line of premium  
brazing alloys,  
solders  
and fluxes.**



**Check out the TurboTorch catalog for more information.**

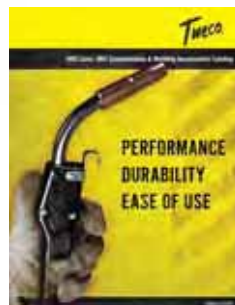


**Check out pages 30-31 for a reference chart on our favorite, top of the line MIG guns.**

**Or see our full line catalog or visit us on the web at [www.tweco.com](http://www.tweco.com) for more information.**

## Tweco® Arc Welding Accessories

Tweco, a brand of St. Louis-based Thermadyne Industries Inc., is the world's largest supplier of welding accessories. The Tweco line includes an extensive array of products from the basic manual welding tools and accessories to MIG guns, consumables, and a complete selection of products for precision robotic welding applications. Tweco is an ISO 9001 registered company.



**Tweco Professional**  
Arc Welding Equipment & Consumables Catalog  
(Form No. 64-2103)

## Make the Switch. Increase Productivity.

### TWECO ADVANTAGE

- Excellent performance with high productivity & low downtime
- Superior durability with long lasting guns
- Exceptional ease of use with operator appeal

### TWECO MIG GUN PORTFOLIO

- Broad range of products for different applications
- Air-cooled and water-cooled MIG guns
- Specialty guns for pulse welding
- Specialty guns for aluminum welding
- Specialty guns with smoke & fume extraction features

### TWECO OFFERS SUPERIOR FEATURES AND BENEFITS

- Ergonomic design to reduce operator fatigue
- Excellent customer support to answer all your technical questions
- Widest range of MIG gun consumables in the industry
- Meet a broad range of your application needs

### TWECO TRUST

- Industry standard for over 40 years
- Over 2 million MIG guns sold
- Most trusted MIG gun in the industry

## TWECO ADVANTAGE. TWECO TRUST.

Visit [www.twecotrust.com](http://www.twecotrust.com)



**THERE'S A LOT OF CHOICES OUT THERE.  
I CHOOSE TWECO  
EVERY TIME.**

COMPANY: DAE Industries  
INDUSTRY: Commercial & Military  
Aircraft Aviation

**BUSINESS PROFILE:** DAE Industries designs, fabricates and installs aircraft engine stands, docking and maintenance stands, and aircraft maintenance tooling, and is always looking to increase productivity with the equipment its welders use.

**TOOL OF CHOICE:** Tweco® Spray Master® MIG Guns

**WHY THE TWECO SPRAY MASTER?** "The Spray Masters have proven to be extremely dependable and tough, with zero failures to date," says DAE Fabrication Manager, Dennis Cook. "We've experienced a 60-70% increase in total consumable life, which has created less downtime when changing out parts."

*"This gun doesn't overheat, so we can remain productive"*

**DAE Industries carries the torch... will you?**



TRUSTED BY AMERICAN LABOR  
[www.twecotrust.com](http://www.twecotrust.com)

**THERMADYNE**, A GLOBAL CUTTING AND WELDING LEADER, joins the American Welding Society in encouraging individuals to practice the art, craftsmanship and professions of welding, metalworking and fabrication. Victor®, Thermal Dynamics®, Thermal Arc®, Arcair®, Tweco®, Stoodly®, CIGWELD® and TurboTorch® are among the Thermadyne family of brands that you can count on for safety, reliability and quality.  
[www.thermadyne.com](http://www.thermadyne.com)



# MIG Gun Selection Guide

MIG Guns

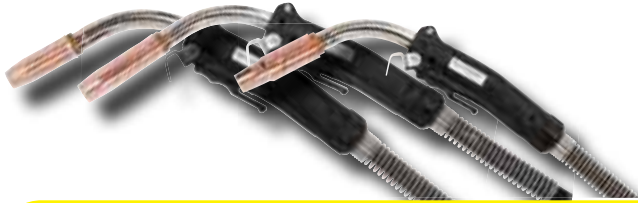
Wire Diameter in. (mm)	Amperage Range					Recommended	Alternate	
	30-100	100-200	200-300	300-400	>400			
Solid Wire - Mild Steel and Stainless Steel	.023" - .030" (0,6 - 0,8)	CO <sub>2</sub> 75-25					MINI-MIG	Professional No.1
	.035" (0,9)	CO <sub>2</sub> 75-25					Spray Master® 250 & Professional No.2	Compact Eliminator® 250 & Smoke Master® 250, Eliminator Spool Gun 300
	.045" (1,2)	CO <sub>2</sub> Higher Argon mixture					Spray Master 350 & Professional No.4	PulseMaster™ Air-Cooled 350, Compact Eliminator 450, Supra® XT 450, TUFF-N-LITE 350, Smoke Master 450, Eliminator Spool Gun 300
	.052" (1,3)	Higher Argon mixture					Spray Master 450 & Professional No.5	PulseMaster Air-Cooled 450, Compact Eliminator 450, Standard Eliminator 450, Supra XT 450, Smoke Master 450, Supra Water-Cooled 450
	1/16" (1,6)	Higher Argon mixture					Spray Master 450 & Professional No.6	PulseMaster Air-Cooled 450, PulseMaster 500, Compact Eliminator 450, Standard Eliminator 450, Supra Water-Cooled 450, Standard Water-Cooled 600

Wire Diameter in. (mm)	Amperage Range					Recommended	Alternate	
	30-100	100-200	200-300	300-400	400-650			
Flux cored Wire	.030" (0,8)	Self-shielded					Professional No.1	Spray Master 250
	.035" (0,9)	Self-shielded CO <sub>2</sub> or 75-25					*FLUXCORED SEFC 350 & Spray Master 250	Compact Eliminator 250, Professional No.2
	.045" (1,2)	Self-shielded CO <sub>2</sub> or 75-25					*FLUXCORED SEFC 350 & Spray Master 350	Professional No.2, Compact Eliminator 250, 450, Supra XT 450, TUFF-N-LITE 350
	.052" (1,3)	CO <sub>2</sub> or 75-25					*FLUXCORED SEFC 450 & Spray Master 450	Professional No.4, Compact Eliminator 450, Standard Eliminator 450, Supra XT 450
	1/16" - 5/64" (1,6 - 2,0)	Self-shielded CO <sub>2</sub> or 75-25					*FLUXCORED SEFC 450 & Spray Master 450	Professional No.5, Compact Eliminator 450, Standard Eliminator 450
	3/32" (2,4)	Self-shielded CO <sub>2</sub> or 75-25					*FLUXCORED SEFC 450 & Professional No.6	Professional No.5, Compact Eliminator 450, Standard Eliminator 450

\*FLUXCORED SEFC Series MIG Guns are to be used only with Self-Shielded wire.

Wire Diameter in. (mm)	Amperage Range					Recommended	Alternate	
	30-150	150-250	250-350	350-450	>450			
Solid Wire - Aluminum	.030" (0,8)	Argon					Eliminator Spool Gun 300 & MINI-MIG	Professional No.1
	.035" (0,9)	Argon					Eliminator Spool Gun 300 & Spray Master 250	PulseMaster Air-Cooled 350, Professional No.2, Compact Eliminator 250
	3/64" (1,2)	Argon					PulseMaster Air-Cooled 350 & Spray Master 250	PullMaster™ 300, Professional No.3, Compact Eliminator 250, TUFF-N-LITE 350
	1/16" (1,6)	Argon					PulseMaster Air-Cooled 450 & Spray Master 350	PullMaster 300, Professional No.4, Compact Eliminator 450, Standard Eliminator 450, TUFF-N-LITE 350
	3/32" (2,4)	Argon					PulseMaster Air-Cooled 450 & Spray Master 450	PullMaster 300, PulseMaster Water-Cooled 500, Professional No.4, Compact Eliminator 450, Supra Water-Cooled 450

When welding with aluminum wire, standard MIG gun length of 12ft. should not be exceeded and conduit liners/contact tips made specifically for aluminum wires should be used.



## Spray Master<sup>®</sup> Series

- Operator appeal with ergonomic handle to reduce operator fatigue
- Field repairable
- Lower heat in the handle and conductor tube
- Wide welding applications with spray and pulse welding modes
- 80% duty cycle, mixed gases
- Models: 250 Amp, 350 Amp, 450 Amp



## Professional No. Series

- Operator appeal and industry standard for 40+ years
- Heavy duty and rugged
- Field repairable
- Improved with longer life consumables
- 60% duty cycle, CO<sub>2</sub>
- Models: No.1 180 Amp  
No.2 200 Amp  
No.3 300 Amp  
No.4 400 Amp  
No.5 500 Amp  
No.6 600 Amp



## PulseMaster<sup>™</sup> Series

- One-touch, on-the-fly controls with standard and “smart” capabilities
- Exceptional weld bead using twin pulse welding parameters
- Exceptional operator appeal and reduced operator fatigue
- 60% duty cycle, CO<sub>2</sub>
- Models: 350 Amp, 450 Amp



## Eliminator<sup>®</sup> Series

- Operator appeal with ergonomic handle
- Field repairable
- Ball & socket conductor tube with articulating feature
- No-thread contact tip with improved interface between tip & diffuser
- 60% duty cycle, CO<sub>2</sub>
- Models: 250 Amp, 450 Amp



## Special Feature Series

- Smoke Master<sup>®</sup> to reduce fumes and smoke from the welding process
- Flux cored guns to weld with self-shielded, gasless flux cored wires
- Water-cooled guns for welding with comfort at higher amperages



## Spool Gun Series

- Eliminator Spool gun with pistol grip and hold 4” wire spools; 300A at 60% duty cycle
- PullMaster<sup>™</sup> push-pull gun with pistol grip, available in standard and “smart” version; 300A at 60% duty cycle

## Consumables

Tips, Diffusers, Nozzles, Conductor Tubes and Wire Conduit to meet all your MIG gun needs. Here is just a sampling of our complete line. . .

### Contact Tips

#### Eliminator® Style Contact Tips



EL16T SERIES

EL16 SERIES

#### Standard Contact Tips for Traditional and Spray Master® Guns Standard, Tapered & Heavy Duty Styles



11 SERIES

14T SERIES

16S SERIES

#### Chrome Copper "RZ" Contact Tips



14RZ-45

16RZT-45



### Nozzles

#### Eliminator Style Nozzles



EL221 SERIES

EL22CT SERIES

REL22CT SERIES

#### Standard Nozzles for Traditional and Spray Master Guns Standard, Tapered & Heavy Duty Styles



21 SERIES

22 SERIES

HD22 SERIES

23 SERIES

23T SERIES

23H SERIES

24A SERIES

24AT SERIES

24CT SERIES

34CT SERIES

#### Optional Nozzles



21-62-FAS

25CT-125-FAS

### Diffusers

#### Eliminator Style Diffusers



EL52

EL52CT

#### Diffusers for Traditional Style Guns



51

52

54A

#### Heavy Duty Diffuser for Spray Master Guns



EL52CT-16

### Wire Conduit

#### Wire Conduits for All Guns

Eliminator, Traditional & Spray Master



42-3035-15

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**Knucklehead™**  
Flexible Conductor Tubes

**Conductor Tubes**

Conductor Tubes for Eliminator, Traditional & Spray Master Guns  
45° and 60° Tube Angles



**MS63-60S**



**64EX-45**



**35-60-60**



**64J-60**

**Flexible Conductor Tubes**

KNUCKLEHEAD™ CONDUCTOR TUBES						
Amp/Model	Bend Angle	Standard Cons.	Eliminator Cons.	Long Reach (2" longer)	Part Number	Stock Number
<b>PROFESSIONAL SPRAY MASTER® SERIES</b>						
250	60°	x			MS62SFLX3-60	1620-1341
	80°	x			MS62SFLX4-80	1620-1342
350	60°	x			MS63SFLX3-60	1630-1197
	80°	x			MS63SFLX4-80	1630-1198
450	60°	x			MS64SFLX3-60	1640-1307
	80°	x			MS64SFLX4-80	1640-1308
	60°	x		x	MS64SFLX3-60LR	1640-1309
	80°	x		x	MS64SFLX4-80LR	1640-1310
<b>PROFESSIONAL CHOICE NO. SERIES</b>						
Mini	80°	x			3560SFLX4-80	1600-1141
No. 1	80°	x			61SFLX4-80	1610-1105
No. 2	60°	x			62SFLX3-60	1620-1105
	80°	x			62SFLX4-80	1620-1106
No. 3	60°	x			64SFLX3-60	1640-1112
	80°	x			64SFLX4-80	1640-1113
No. 4	60°	x		x	64SFLX3-60LR	1640-1121
	80°	x		x	64SFLX4-80LR	1640-1122
<b>PROFESSIONAL ELIMINATOR® SERIES</b>						
250	60°		x		EL62SFLX3-60	1620-1115
	80°		x		EL62SFLX4-80	1620-1116
450	60°		x		EL64SFLX3-60	1640-1143
	80°		x		EL64SFLX4-80	1640-1144
			x	x	EL64SFLX4-80LR	1640-1149
<b>STANDARD WELDSKILL® SERIES</b>						
250	60°	x			62SFLX3-60	1620-1105
	80°	x			62SFLX4-80	1620-1106
400	60°	x			64SFLX3-60	1640-1112
	80°	x			64SFLX4-80	1640-1113
	60°	x		x	64SFLX3-60LR	1640-1121
	80°	x		x	64SFLX4-80LR	1640-1122

Outer Jacket Repair Kit  
250 Amp - Part No. FLXSJ-RK (Stock No. 1620-1345)  
350/450 Amp - Part No. FLXLJ-RK (Stock No. 1640-1385)  
(Repair Kits include the neoprene outer jacket and stainless steel straps)

**NEW Tweco® MIG Gun Website**

Visit our web site [www.twecotrust.com](http://www.twecotrust.com) to see why the Spray Master and No. 4 MIG guns are still the industry choice for dependability and reliability. See how a busy manufacturer with multiple welding and fabrication stations discovered the benefits of converting to Tweco Spray Master MIG guns. Learn how you can benefit your customer by converting or upgrading them to the Professional line of Tweco MIG guns.

[www.twecotrust.com](http://www.twecotrust.com)

**Tweco Professional**

Switch to Tweco and Be More Productive

HOME
PROMO DETAILS
VOICE OF THE CUSTOMER
FEATURED PRODUCT: #4
FEATURED PRODUCT: SPRAY MASTER
HOW TO ORDER

**Make the Switch. Increase Productivity.**

Tweco MIG guns are the choice of professional welders. For decades...one of the most trusted names in arc welding.

Nothing compares to the highest quality of a Tweco MIG gun. Nothing of course, except another Tweco.

We take care of our guns so that you don't have to. You can focus on running your business.

For decades they've set the industry standard in dependability and reliability. With a rich history of producing top quality professional guns like the Spray Master and one of the highest selling MIG guns of all time, the #4 MIG, it's easy to see why Tweco is one of the most trusted names in arc welding. Nothing compares to the true craftsmanship of a Tweco gun. Nothing of course, except another Tweco.

**Tweco, trusted by professional welders.**

To learn more about Tweco products click here.



Send this link to a friend

## Manual Arc Welding Equipment

### TwecoTong® Electrode Holders

200, 250, 300, 350, 400 & 500 Amp

- Copper alloy body
- Reversible top and bottom insulators
- Efficient 6-position jaw patterns
- Fully insulated/protected springs
- Ball-point cable connection

**A-532**  
(200A)



**A-316**  
(250A)



**A-732**  
(300A)



**A-14**  
(350A)



**A-14-HD**  
(400A)



**A-38-HD**  
(500A)



### Tweco-Tite® Electrode Holder

400 Amp

**4TT**  
(400A)



### Ground Clamps

Steel, Copper & Flat Ground Clamps

- Steel ground clamp (300A & 500A)
- Copper ground clamp (200A, 300A & 500A)
- Flat ground clamp (200A & 300A)



**SGC-500**  
(500A)



**GC-300**  
(300A)



**FGC-500**  
(500A)

### Heavy Duty Rotary Ground Devices

400, 600, 800, 1500 & 2000 Amp

- Available with 1, 2 or 3 heads
- Simple tension adjusting bolt for maximum efficiency
- No brushes, springs or mercury
- 2" shaft



**RG-440**  
(1500A)



**GCGR-140**  
(400A)

### Roto-Work Grounding Clamps

500, 600, 1200 & 2000 Amp

- Work in conjunction with rotary ground devices
- Large tightening screws and ample contact surface area for efficient operation



**WCGR-1200**  
(1200A)



**GC-600-75**  
(Clamp Only)

## Switchable Magnetic Ground Clamps

Do you want to save time and money? Add convenience in welding with the Switchable Magnetic Ground Clamp from Tweco. Designed for use in flat and pipe applications, Switchable Magnetic Ground Clamps are easy to operate, easy to mount and can withstand heat up to 176° F (80° C). Turn the knob clockwise and you instantly have a secure grip.



Part Number	Description
SMGC200	200 Amp
SMGC300	300 Amp
SMGC600	600 Amp

## Terminals and TwecoLugs

### Screw-on Terminals

- Fit 1/2" (12.7mm) terminal size
- 3 sizes available



### Female Terminals

- 17/32" (13.5mm) stud hole size
- Various configurations available



## Cable Connectors

### MPC & Whip Cable Connectors

- Positive cam action optimizing interfacing
- Heat and oil resistance covers
- Zinc plated cover and ball-point cable screws
- Various cable capacities & packages available



## Ball-Point Connection Type Lugs

- 17/32" (13.5mm) stud hole size
- Various configurations available



## TwecoLugs®

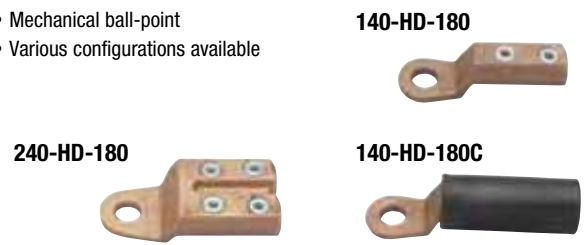
### Crimp & Solder Type

- 150A, 225A, 250A & 325A Rating
- 50A, 70A & 90A Rating (Power Cable Lugs)
- Various cable sizes available



## Heavy Duty Type Lugs

- Mechanical ball-point
- Various configurations available





## Tweco® Quick Robotics

Welcome to world class Tweco Robotics MIG guns and accessories. The engineers at Tweco have worked overtime to continue the tradition of delivering best in class robotic MIG guns and accessories that will provide the reliability and value you expect from Tweco.

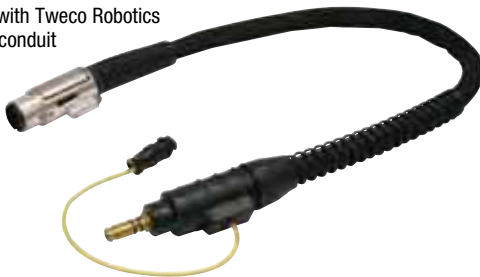
### Robotic MIG Guns and Accessories

#### QRL Series Robotic MIG Gun

##### 400 Amp Lightweight Air-Cooled MIG Gun

The new Tweco Robotics Quick Robotic Light Weight MIG Gun (QRL) offers the ideal MIG gun for "Table Top" robots. It is designed for everyday applications that require a lighter weight and smaller profile for robotic welding MIG gun functions.

- Quick conductor tube lock for easy conductor tube replacement
- 40% lighter than the QRA series MIG gun
- E-stop cable with connections
- Smaller physical profile
- Compatible with existing mount arms, and uses current conductor tubes and consumables
- External protective sleeve
- Precision front case assembly (gives high repeatability to mount and conductor tube)
- Furnished with Tweco Robotics R45-3545 conduit



#### QRA Series Robotic MIG Gun

##### 600 Amp Air-cooled MIG Gun

Tweco Robotics QRA Series air-cooled MIG gun body and cable assemblies provide many features that will enhance your robotic welding application. MIG gun body and cable assemblies are furnished with these standard features:

- Improved quick tube locking
- Standard 1 1/8" (41.28mm) Ø mounting cartridge sleeve
- Precision front case assembly (gives high repeatability to mount and conductor tube)
- Inch switch mounted in a molded housing on the front MIG gun case
- E-stop cable with connections
- Both front and rear heavy cable support springs
- Kevlar®/Nylon outer protective cable Cover
- Internal protective sleeve
- Internal purge hose for spraying Protex® antisplatter compound through the conductor tube and nozzle
- Furnished with Tweco Robotics R45-116 conduit
- Furnished with a Tweco®, Miller® or Lincoln® Rear Connector Plug

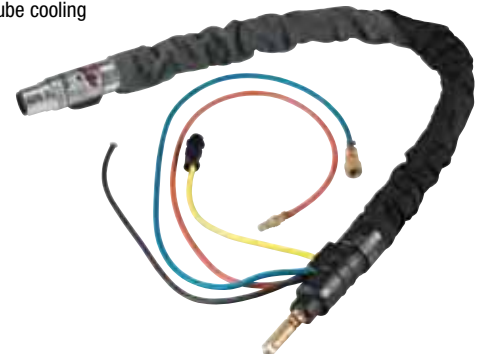


#### QRW / QRWA Series Robotic MIG Gun

##### 600 Amp Water-cooled & Water/Air-Cooled MIG Gun

Tweco Robotics water-cooled MIG gun body and cable assemblies are offered in two (2) configurations. The QRW Series features a water-cooled cable assembly while the QRWA Series features an air-cooled cable assembly. Both accept the QTRW series water-cooled conductor tube. The QRWA Series provides maximum cooling at the conductor tube end with a rugged, trouble free cable assembly.

- Water shut-off valves located in the MIG gun body assembly
- Color Coded "water-in" and "water-out" hoses for easier hook-up
- Water hose quick connections
- High flow rate – QRWA Series – for improved conductor tube cooling
- Larger water lines – QRW – for improved conductor tube cooling



## RDM Series Deflection Mount

### RDM 2000 Series

Tweco® Robotics RDM-2000 Series — is a safety device designed to act as a switch between the conductor tube and the robot.

- Available in Three (3) models:  
Part No. RDM-2000-S (Stock No. 3500-1155) – light duty  
Part No. RDM-2000-M (Stock No. 3500-1156) – medium duty  
Part No. RDM-2000-H (Stock No. 3500-1157) – heavy duty
- Units come standard with an air assist feature allowing the robot technician to increase the break-away pressure when required
- E-Stop cable assembly- 18" long - Part No. RDM2000-JC (Stock No. 3044-1842) comes standard with the unit



## Cleaning Station Accessories

### QWT-3 Wire Trim Unit

For use with QRC-2000



QWT-3

### QRM-3 Anti-Spatter Mist Applicator

For use with QRC-2000



QRM-3

## QRC™-2000 Nozzle Cleaning Station

The QRC Nozzle Cleaning Station has an advanced Rotary Impact Drive (RID) system which removes the spatter, allowing the cleaned MIG gun nozzle to continue the welding process. It also has a unique self-exhaust PDE cleaning system that keeps debris from the reamer blade area. The revolutionary clamp mechanism on the QRC-2000 system provides precise clamping on the nozzle.

- Rotary Impact Drive (RID) system
- Dual stage pneumatic clamping device ensures positive, secure clamping on the nozzle
- Easy to program
- Two-stage cam plate (2.5" cylinder) is a solid block with universal arm
- Pneumatic Drive Exhaust (PDE) system blows air through vent holes on the incline housing which helps prevent slag buildup in shaft area
- Uses only half the air consumption of other cleaning stations
- Total stroke inside nozzle 2" (50.8mm)
- Reamer blade (QRC-100), five clamp blocks and programming tools included with the unit



QRC-2000

## QRM-100 Anti-Spatter Mist Applicator

Reduce spatter build up in your MIG nozzle. Removal of spatter made easier. Provide better gas flow and improved weld quality.



QRM-100

## Tweco Water Coolers

### TC900 & TCV900 Series

Enhance your water-cooled MIG welding process by incorporating a water-cooler from Tweco Products.

- Vertical or horizontal models available
- Designed for MIG guns up to 800 Amps and TIG torches up to 500 Amps
- Stainless steel construction eliminates coolant contamination due to electrolyte and chemical reactions
- High efficiency radiator design pulls outside air through radiator
- Available with either gear or vane pumps.
- Pump bypass to tank on rotary gear pump – keeps pump from overheating
- Vane pumps are equipped with a bypass to eliminate excessive pump wear



TC900



TCV900

**See our full line catalog or visit us on the web at [www.tweco.com](http://www.tweco.com) for more information.**

**Tweco Robotics**  
Quick Robotic MIG Guns & Accessories Catalog  
(Form No. 64-2203)





## Tweco® Fixed Automation

Tweco Robotics offers a complete line of automation MIG guns with or without cable assemblies. The product line consists of both air-cooled and water-cooled MIG guns and cable assemblies.

**QF — TAM — RA — WRS**

Each series offers something different that will meet your specific MIG fixed automation welding application specifications.

Thermadyne is excited to offer you incredible choices and innovation in fixed automation MIG welding equipment. Only the quality you come to expect from Tweco.

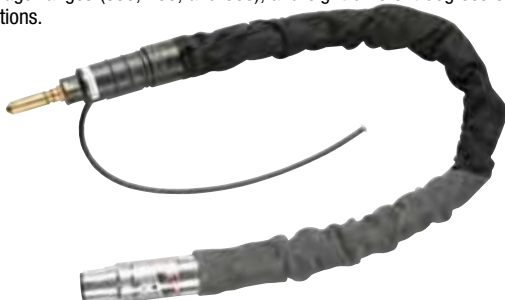
## Fixed Automation MIG Guns and Accessories

### QF Series Fixed Automation MIG Gun

#### QFA Air-cooled / QFW Water-Cooled

This series of Automation MIG guns is offered with and without cable assemblies. The series incorporates some of the same features found on the Tweco Robotics QR series MIG gun assemblies. Offered for use in MIG air-cooled and water-cooled welding applications.

Welding applications using the air-cooled QF series MIG guns can take advantage of the eight different bend configurations of air-cooled QTR66 conductor tubes. Welding applications requiring the water-cooled QF series MIG guns utilizes the water-cooled QTRW series conductor tubes, which are available in three different amperage ranges (300, 400, and 600), and eight different degrees of bend configurations.



### TAM Series Fixed Automation MIG Gun

#### 400 Amp & 500 Amp Air-Cooled

This series of Automation MIG guns is offered with and without a cable assembly. The series is only offered for air-cooled welding applications. There are two amperage ranges available, 400 and 500 Amps @ 60% duty cycle, both are offered with and without a cable assembly.

Mounting of this particular series is directly to the 1 1/8" (28.58mm) outside diameter of the MIG gun barrel. The outer surface of the MIG gun body is insulated from the inner tube by a polyester molding compound providing excellent dielectric properties.

TAM series with cable assemblies are offered in lengths of 2 ft. (0.61m) to 15 ft. (5m).

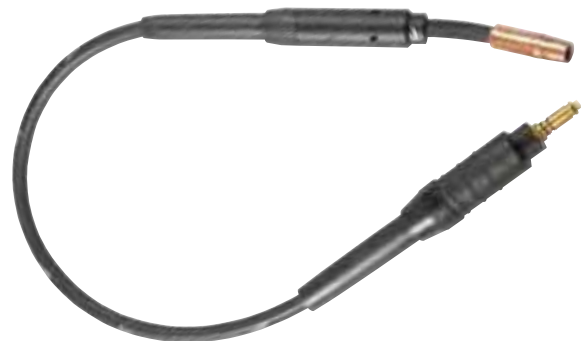


### RA Series Fixed Automation MIG Gun

#### 400 Amp & 600 Amp Air-Cooled

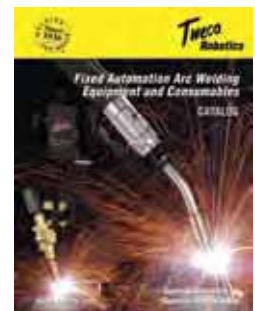
This series of Automation MIG guns are offered only with a cable assembly and strictly for air-cooled welding applications. There are two amperage ranges to choose from, 400 and 600 Amps @ 60% duty cycle. Mounting surface is the outer diameter of the 1 5/8" (41.28mm) plastic case.

Five different bend configuration conductor tubes are available to choose from in each amperage range. The conductor tubes are keyed into the brass body of the assembly allowing a conductor tube to be replaced and the adjustments to be minimal when going from one tube configuration to another.



**See our full line catalog or visit us on the web at [www.tweco.com](http://www.tweco.com) for more information.**

**Tweco Robotics**  
Fixed Automation Arc Welding  
Equipment & Consumables Catalog  
(Form No. 64-2603)

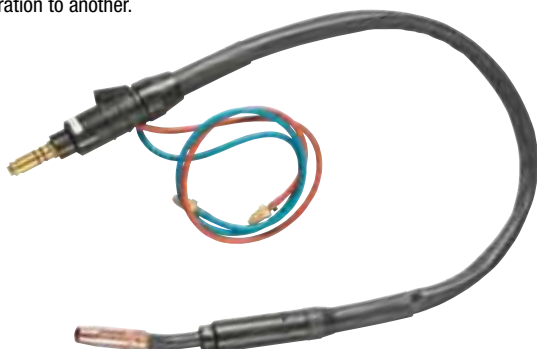


**WRS Series Fixed Automation MIG Gun**

**400 Amp & 600 Amp Water-Cooled**

This series of Automation MIG guns are offered only with a cable assembly and strictly for air-cooled welding applications. There are two amperage ranges to choose from, 400 and 600 Amps @ 60% duty cycle. Mounting surface is the outer diameter of the 1 5/8" (41.28mm) plastic case.

Five different bend configuration conductor tubes are available to choose from in each amperage range. The conductor tubes are keyed into the brass body of the assembly allowing a conductor tube to be replaced and the adjustments to be minimal when going from one tube configuration to another.



**Tweco® Water Coolers**

**TC900 & TCV900 Series**

Enhance your water-cooled MIG welding process by incorporating a water-cooler from Tweco Products.

- Vertical or horizontal models available
- Designed for MIG guns up to 800 Amps and TIG torches up to 500 Amps
- Stainless steel construction eliminates coolant contamination due to electrolyte and chemical reactions
- High efficiency radiator design pulls outside air through radiator
- Available with either gear or vane pumps.
- Pump bypass to tank on rotary gear pump – keeps pump from overheating
- Vane pumps are equipped with a bypass to eliminate excessive pump wear



**TCV900**



**TC900**

**TJ-2 Tri-Just**

An ideal holding fixture that provides a means to locate and hold your MIG gun in place.



**TJ-2 TRI-JUST**

**QRM-100 Anti-Spatter Mist Applicator**

Reduce spatter build up in your MIG nozzle. Removal of spatter made easier. Provide better gas flow and improved weld quality.



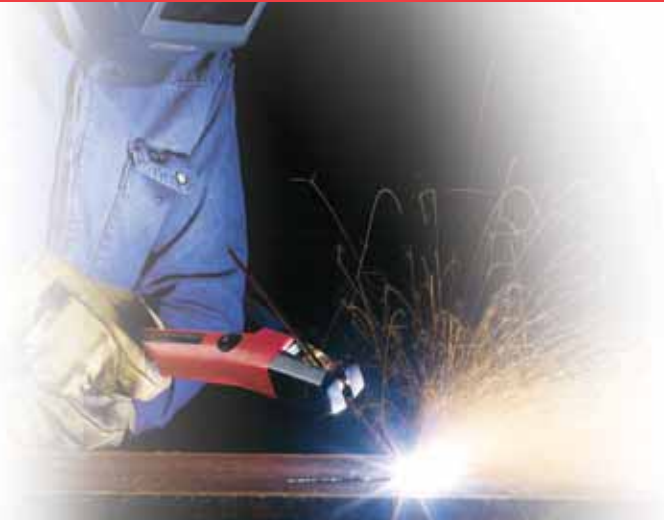
**QRM-100**

**TJ2-KB Keyed Bracket**

MIG gun bracket for use with TJ-2 TRI-JUST.



**TJ2-KB**



**Arcair® Air Carbon Arc Gouging**

Arcair provides a complete line of air-carbon arc products for the wide-ranging gouging needs of fabrication plants, shipyards, railroads and farms to name a few. Arcair is proud to be an ISO 9001 registered company.

**Arc Gouging Equipment**



**Angle-Arc® Gouging Torches**

**Light to Extra Heavy Duty Manual Gouging Torches**

- Natural 15° torch angle
- 360° swivel cable
- Positive grip handle
- Reduced weight
- High quality cable hoses
- Rugged construction



**K5000**  
(Extra Heavy Duty)



**K4000**  
(Heavy Duty)



**K3000**  
(Medium Duty)



**K2000**  
(Light Duty)

**K-Series Gouging Torches**

**Medium & Extra Heavy Duty Straight Handle Manual Gouging Torches**

- Reliable torch design
- Swivel cable
- Positive grip handle
- Reduced weight
- High quality cable hose
- Rugged construction



**K-5**  
(Extra Heavy Duty)



**K-3**  
(Medium Duty)

**Tri-Arc® Gouging Torch**

**Foundry Gouging Torch**

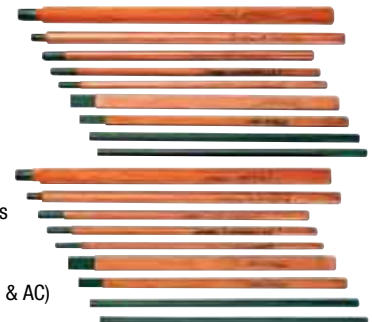
- No torch air valve
- 340° swivel cable
- Positive grip handle
- Optimum weight
- High quality cable hose
- Rugged construction



**Gouging Electrodes**

**Electrodes for Any Application**

- Excellent arc stability
- Superior metal removal rate
- Cool operation
- Uniform diameter
- Clean machine-like grooves or cuts
- Copperclad and plain
- Jointed, flat or pointed (DC & AC)



**Protex® Metalworking Chemicals**

**For Various Applications**

- Anti-Spatter
- Alclean aluminum cleaner
- Tip-Dip
- Zinc rich cold galvanizing
- Available in convenient container sizes from ounces to 55 gallon drums to meet your needs



**Slice<sup>®</sup> Exothermic Cutting Systems**

**Slice Utility Pack**

**Part No. 63-991-026**

The SLICE Utility Pack permits you to use the exothermic cutting process to cut virtually any metallic, non-metallic or composite material. The package has the basic items needed to do a cutting job packed in a rugged tool box. Just supply oxygen and an ignition source and you are ready to cut.



**Slice Cordless Striker Pack**

**Part No. 63-991-032**

The SLICE Cordless Striker Pack uses two small lead-acid batteries to supply a current surge sufficient enough to ignite both the 1/4" (6.4mm) and 3/8" (9.5mm) bare SLICE Cutting Rods. It includes one ignitor and charger. Available in 120 volt, AC only.



**Slice Industrial Pack**

**Part No. 63-991-021**

The Industrial SLICE Pack provides the versatility of exothermic cutting and accommodates a larger oxygen cylinder to extend your cutting time. The industrial cart is capable of carrying a 9" (229mm) diameter cylinder. The Industrial SLICE Pack includes SLICE torch and striker assemblies with 10 ft. (3m) oxygen hose and power cables.



**Slice Complete Pack**

**Part No. 63-991-002**

The SLICE Complete Pack comes in an aluminum carrying case with everything needed to quickly complete an exothermic cutting job. This model is well suited to the emergency type cutting situations where seconds count. With this unit you get the torch, rods, striker, 12-volt battery with charger, 6" (152mm) collet extension and shield, regulator and an empty 55 cubic foot oxygen bottle.



**Slice Battery Pack**

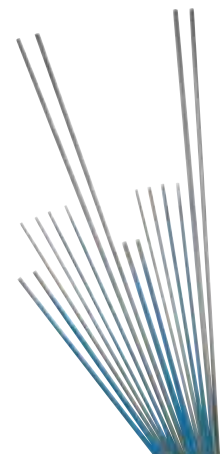
**Part No. 63-991-003**

The SLICE Battery Pack comes in a rugged tool box. As with the Utility Pack, you get all the basic items needed to do a cutting job such as torch, striker and rods. Also included in the Battery Pack is a 12-Volt rechargeable SLICE Battery Box Assembly.



**Slice Exothermic Cutting Rods**

- Flux coated and uncoated
- 1/4" and 3/8" diameter
- Varying lengths
- Designed specifically for use with slice cutting systems



**Visit us on the web at [www.thermadyne.com/arcair](http://www.thermadyne.com/arcair) for more information.  
And look for our new Arcair comprehensive products catalog coming soon.**

**Automated Metal-Removal Systems**

**Arcair-Matic® N6000**

The Arcair-Matic N6000 Metal-Removal System was designed to provide the best levels of control, uniformity and productivity in automated gouging of steels and other metals with the air carbon arc process. Usage of the N6000 System has expanded to a wide variety of new and unique jobs. The N6000 system measures minute variations in the arc voltage or amperage, compares them with preset standards, and takes immediate action through its feedback control maintaining the precise arc gap for optimum gouging.

Groove depth is maintained within a tolerance  $\pm 0.025"$  (0.635mm). The N6000 System is ideally suited for metal fabrication, particularly in weld joint preparation, where it is used to prepare uniform "U" or "J" grooves. The System is also used extensively for backgouging of seams and for removing defective welds and cracks.

- Gouging that is five times faster than hand held torches
- Gouges more accurate and consistent
- Automatic grooves that require less grinding than manually made grooves
- Economical J-groove and U-groove edge preparations



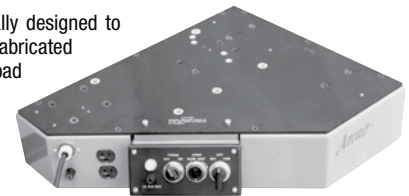
**Titan® Machine Carriage**

**N6000 Grooving Kits Packages Include:**

- Titan machine carriage
- Lifting bracket
- One 10' track assembly
- Three magnet & support bars
- Cable & hose clamp assembly
- Horizontal rack assembly
- Vertical adjustment assembly
- Automatic controller
- 1600 Amp contactor
- Torch head
- Air regulator
- 2 each 4' (1.2m) power cables
- 14" (356mm) interconnect cable
- 10' (3m) remote pendant assembly
- 3' (1m) motor cable assembly
- 4' (1.2m) air hose assembly
- Pertinent fasteners
- Clamps and hardware package

The Grooving Kit is designed for flat work only such as deck plates. It is completely self-contained and easily moved as a single unit with a forklift or crane from workpiece to workpiece.

The Outrigger Kit is specifically designed to travel along the web plate on fabricated bridge girders used for railroad and highway bridges.



**Arcair® CutSkill® Arc Gouging Equipment**

**CutSkill Arc Gouging Torches**

**CS3000 & CS4000 Gouging Torches**

- Two designs; select the one you need
- 7' and 10' cables, available with torch body & separately for both the CS4000 and CS3000
- Rugged, lasting reliability
- Ideal for most metals
- Speeds up weld removal, backgouging, edge preparation, defect repair & many other metal removal jobs
- 360° swivel promotes free movement to position the torch, more efficient natural angles, and a more natural movement of the arm and wrist
- Ergonomically designed handle



CS3000

**Arcair®**  
CutSkill®

**CutSkill Arc Gouging Carbons**

Arcair is now proud to introduce the Arcair CutSkill line of carbons. Arcair CutSkill carbons are your alternative if you are looking for quality and value. Arcair CutSkill carbons have been developed by the same engineers who have made the Arcair "Redbox" Professional carbon electrode the world's leading carbon for over fifty years.

- Pointed Carbons**
- Jointed Carbons**
- Hollow Carbons**



**The Arcair CutSkill Advantage:**

- Faster gouging
- Leading metal removal rates
- Reduced slag
- Cool operation
- Minimized environmental impact
- Different types of electrodes to fit your application
- Easy to operate
- Versatile

**Arcair®**  
CutSkill®



# #1 FOR A REASON

NAME: Tom Wermert

PROFESSION: Product Line Manager,  
Welding Products

COMPANY: Thermadyne Industries

**JOB EXPERIENCE:** With 35 years of experience across all levels of the welding and cutting industries, Tom Wermert still has the same devotion for work as he did at age 20. As Product Line Manager for Thermadyne® Welding Products, Wermert puts equipment through rigorous testing to ensure only the highest quality product makes it to the market.

**TOOL OF CHOICE:** Arcair® Angle-Arc® K4000 Manual Gouging Torch

**WHY THE ARCAIR ANGLE-ARC K4000?** “If anyone understands what it takes to make professional-grade tools it’s me,” says Wermert. “Products like the K4000 don’t become the industry standard by accident. The K4000’s ability to handle heavy-duty metal removal applications like weld preparations in fab shops and shipyards are second to none.”

*“Arcair remains the number one name in air carbon arc manual torches”*

*Tom carries the torch...will you?*



## Arcair®

[www.thermadyne.com/arcair](http://www.thermadyne.com/arcair)



**THERMADYNE®** A GLOBAL CUTTING AND WELDING LEADER, joins the American Welding Society in encouraging individuals to practice the art, craftsmanship and professions of welding, metalworking and fabrication. Victor®, Thermal Dynamics®, Thermal Arc®, Arcair®, Tweco®, Stody®, CIGWELD® and TurboTorch® are among the Thermadyne® family of brands that you can count on for safety, reliability and quality.

[www.thermadyne.com](http://www.thermadyne.com)



**American Welding Society**  
Sustaining Company Member

## Thermal Dynamics® Offers a Full Line of Automation Equipment to Meet The Most Demanding Applications.

### CUTMASTER® A-Series Automation

With all the advantages of the 1Torch® and proven CUTMASTER reliability, the new CUTMASTER A-Series delivers the best in productivity, precision, and performance in Automation. Systems feature CNC interface, 1Torch with ATC® Quick Disconnect and Diagnostic LED's to name a few.

#### A40

- ¼" (6mm) production capacity
- 20-40 Amps, 60 Amps max, adj
- Duty Cycle: 80% @ 40A  
100% @ 30A
- SL100 SV 1Torch with SureLok® Technology
- CNC interface



#### A60

- ⅜" (10mm) production capacity
- 20-60 Amps, 80 Amps max, adj
- Duty Cycle: 80% @ 60A  
100% @ 50A
- SL100 SV 1Torch with SureLok® Technology
- CNC interface



#### A80

- ½" (12mm) production capacity
- 30-80 Amps, 100 Amps max, adj
- Duty Cycle: 80% @ 80A  
100% @ 70A
- SL100 SV 1Torch with SureLok® Technology
- CNC interface



#### A120

- ⅝" (15mm) production capacity
- 30-120 Amps, 120 Amps max, adj
- Duty Cycle: 80% @ 120A  
100% @ 100A
- SL100 SV 1Torch with SureLok® Technology
- CNC interface



### Auto-Cut® Series Conventional Automation

The Thermal Dynamics Auto-Cut Series delivers premium cut performance on both mild steel and non-ferrous materials. The power supplies are designed for reliable, low cost operation. Features like the XT™-301 consumable parts cartridge and the Machines Status Message Center make the Auto-Cut units easy to operate.

#### Auto-Cut 100

- ⅝" (15mm) production cut
- ¾" (20mm) maximum cut
- 1" (25mm) edge start
- Duty Cycle: 100% @ 100A @ 160V
- 10-100 Amps
- XT-301 torch and leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC



#### Auto-Cut 200

- 1" (25mm) production cut
- 1¼" (30mm) maximum cut
- 2" (50mm) edge start
- Duty Cycle: 100% @ 200A @ 160V
- 10-200 Amps
- XT-301 torch and leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC



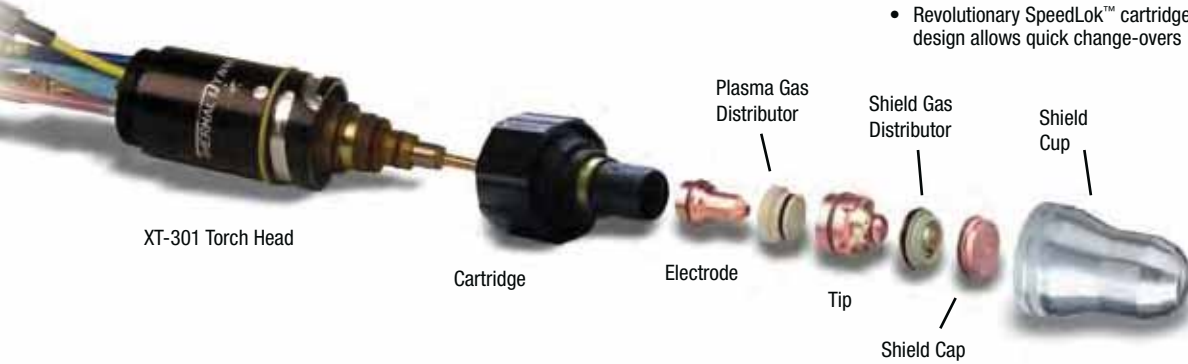
#### Auto-Cut 200<sub>2</sub>

- 1" (25mm) production cut
- 1½" (40mm) maximum cut
- 2" (50mm) edge start
- Duty Cycle: 100% @ 200A @ 180V
- 10-200 Amps
- XT-301 torch and leads
- Water Mist Secondary (WMS)
- **High speed oxygen cutting**
- CE, CSA, CCC



## XT™ Torch Technology for Maximum Performance

Patented XT Torch Technology brings plasma cutting to new levels of precision and productivity. The design of the XT-301 torch and consumable cartridge ensure precise relocation of components after a process change.



### XT-301 Torch

- 'Leakless' torch head design
- Self-centering components
- Excellent cuts on all metals
- Longer parts life with MaximumLife® consumables
- Keyless consumables cartridge
- Revolutionary SpeedLok™ cartridge design allows quick change-overs



### Auto-Cut® 300

- 1¼" (30mm) production cut
- 1½" (40mm) maximum cut
- 2¾" (70mm) edge start
- Duty Cycle: 100% @ 300A @ 180V
- 10-300 Amps
- XT-301 torch and leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC



### GCM-1000 – Gas Control

Plasma and secondary gas pressures and WMS (Water Mist Secondary) flows are precisely controlled at the power supply with dedicated regulators.



### Auto-Cut 300<sub>2</sub>

- 1½" (40mm) production cut
- 1¾" (45mm) maximum cut
- 3" (75mm) edge start
- Duty Cycle: 100% @ 300A @ 180V
- 10-300 Amps
- XT-301 torch and leads
- Water Mist Secondary (WMS)
- **High speed oxygen cutting**
- CE, CSA, CCC



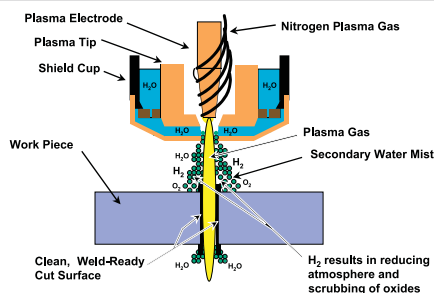
### GCM-2000 – Gas Control

Manually controlled plasma and shield gases with dedicated regulators, pressure gauges and flowmeters.



### Water Mist Secondary (WMS)

- Low operating costs
- Dross-free cutting
- Oxide free surface
- Easy to use



### SC-11

- Manual torch up/down
- Actual and preset voltage display
- Pierce delay
- Arc voltage input to 200V
- Status LEDs
- Corner lockout



### Ultra-Cut® Series High Precision Automation

The Thermal Dynamics® Ultra-Cut Series delivers premium precision plasma cutting on mild steel and non-ferrous alloys. With consumable parts for precision cutting from gage to 3" (75mm) it's the only plasma system you will need.



#### Ultra-Cut 100

- 1/2" (12mm) production cut
- 5/8" (15mm) maximum cut
- 3/4" (20mm) edge start
- Duty Cycle: 100% @ 100A @ 180V
- 10-100 Amps
- XT™-300 torch and leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC



#### Misc. Control Modules

##### GCM-2010 Gas Control Module

- Plasma and secondary gas control
- Dedicated regulators, flowmeters and gauges
- Digitally controlled



##### RAS-1000 Remote Arc Starter

- Water-cooled negative HF coil
- Rated to 300 Amps



#### Ultra-Cut 200

- 1" (25mm) production cut
- 1 1/2" (40mm) maximum cut
- 2 1/2" (62mm) edge start
- Duty Cycle: 100% @ 200A @ 180V
- 10-200 Amps
- XT-300 torch and leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC



#### DFC-3000

Designed specifically for use with Ultra-Cut systems, the automated Digital Flow Control consists of three separate modules:

- **DMC-3000**  
Central Manifold Control
- **DPC-3000**  
Digital Pressure Control
- **TSC-3000**  
Touch Screen Controller



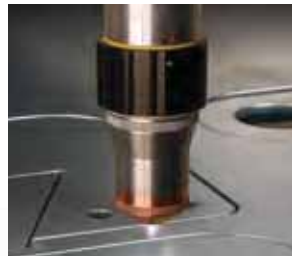
#### Ultra-Cut 300

- 1 1/2" (40mm) production cut
- 1 3/4" (45mm) maximum cut
- 3" (75mm) edge start
- Duty Cycle: 100% @ 300A @ 180V
- 10-300 Amps
- XT-300 torch and leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC



#### XT-300 Torch

- 'Leakless' torch head design
- Self-centering components
- Precision cuts on all metals
- Extreme parts life with XT™ consumables
- Keyless consumables cartridge
- Revolutionary SpeedLok™ cartridge design allows quick change-overs



### Unique 'Keyless' Consumables Cartridge

The unique Consumables Cartridge houses consumable parts only, no built-in head/torch body to drive replacement costs up. Changing cartridges is fast and easy - a couple of twists and the unique 'rapid engagement' retaining collar threads release the cartridge. Down-time is reduced to seconds and you can change from one process to another or from one application to another quickly and easily.



**SC-3000 Height Control**

- Torch height adjustable in distance and voltage
- Built-in collision sensor
- Arc voltage range
- Easy to operate
- Pierce retract



**PAK® 45**

- 3" (75mm) maximum cut
- 3/4" (20mm) piercing
- Duty Cycle: 100% @ 400A @ 200V
- 50-400 Amps
- Liquid cooled torch
- N<sub>2</sub>, Ar-H<sub>2</sub>, plasma
- CE, CSA, CCC



**TA-500/1000**

- 6" (150mm) maximum cut
- 2" (50mm) piercing
- Duty Cycle Cycle: 100% @ 500A/1000A @ 200V
- Paralleled to 1000 Amps
- Liquid cooled torch
- N<sub>2</sub> Plasma
- Heavy non-ferrous



The **TA-500 System** is specifically designed for high-performance, machines-mounted production cutting.





## CUTMASTER, Why TRUE?

The new CUTMASTER® TRUE™ Series has been designed with the idea that the recommended cut capacity should also be the TRUE cut capacity.

The TRUE Series eliminates the concept of having to “buy up” – purchasing a machine larger than you actually need.

With the introduction of the CUTMASTER TRUE Series, a machine with a recommended cut capacity of ½" (12mm) will cut ½" material ALL DAY EVERY DAY.

### TRUTHS

**#1: True Confidence** – The CUTMASTER® TRUE™ Series microprocessor controlled front panel LED's assure extreme operator confidence and error free use from setup to clean up.

**#2: True Strength** – The CUTMASTER TRUE Series allows you to work all day at our recommended cut capacity. But when you need that extra punch, you can be confident that it's there.

**#3: True Protection** – As if a 4 YEAR unlimited power supply warranty wasn't enough, the CUTMASTER TRUE Series is the only line of plasma cutting machines that features TRUE GUARD™ – a rugged roll bar for added durability

**#4: True Tip** – The Thermal Dynamics CUTMASTER TRUE Series plasma system offers the only 60 Amp drag cutting tip on the market today.

**#5: True Flexibility** – The new MULTI-VOLTAGE CUTMASTER TRUE Series features the flexible, patented 1Torch®. There's one set of consumable parts for the entire range of machines, lead extensions provide cutting up to 100' (30.5m) from power supply, and the flexibility to move quickly from hand to mechanized cutting with the change of a torch. (Add PCB for CNC interface.)

**#6: True Portability** – The CUTMASTER TRUE Series offers lighter, more portable machines without compromising performance.

### CUTMASTER 39

- ¼" (6mm) recommended cut capacity
- ⅝" (15mm) maximum cut
- Auto pilot restart for expanded metal
- 20-30 Amps, adjustable
- Duty Cycle: 35% @ 30A
- SL60® 1Torch
- Weighs 39 lbs.
- Applications: plumbing / HVAC, auto body / marine repair, home shop, rental fleets, metal building & roof construction



### CUTMASTER 52

- ½" (12mm) recommended cut capacity
- 1⅞" (30mm) maximum cut
- Auto pilot restart for expanded metal
- 60 Amp drag tip
- 20-60 Amps, adjustable
- Duty Cycle: 40% @ 60A
- SL60 1Torch
- Weighs 43 lbs.
- Applications: construction, maintenance/repair, fabrication



### CUTMASTER 82

- ¾" (20mm) recommended cut capacity
- 1½" (40mm) maximum cut
- Auto pilot restart for expanded metal
- 20-80 Amps, adjustable
- Duty Cycle: 40% @ 80A
- SL60 1Torch
- Weighs 43 lbs.
- Applications: heavy fabrication, manufacturing, contractors



### CUTMASTER 102

- 1" (25mm) recommended cut capacity
- 1¾" (45mm) maximum cut
- Auto pilot restart for expanded metal
- 20-100 Amps, adjustable
- Duty Cycle: 60% @ 100A
- SL100® 1Torch
- Weighs 62 lbs.
- Applications: heavy fabrication, manufacturing



### CUTMASTER 152

- 1¼" (30mm) recommended cut capacity
- 2" (50mm) maximum cut
- Auto pilot restart for expanded metal
- 20-120 Amps, adjustable
- Duty Cycle: 80% @ 120A
- SL100 1Torch
- Weighs 62 lbs.
- Applications: heavy fabrication, manufacturing



**Superior Performance Features**

TRUE GUARD™ roll bar provides easy transportation and protects the front and rear of the power supply for unmatched durability.

Lightweight design improves portability (Reduced nearly 50%).

Universal selectable input power from 208 to 460 VAC ± 10%, single or three phase, 50 or 60 Hz.

Color Coded LEDs indicate pressure status and setup errors.



The industry's only 60 Amp Drag Tip

All user controls are conveniently located on the front panel.

Trigger feature prevents hand fatigue during long cuts. Auto Pilot Restart feature instantly reignites the pilot arc while cutting expanded metals.

Convenient storage compartment for spare and consumable parts

Multiple Torch Capability (Hand, Mechanized, Automation)

Note: Features apply to 52, 82, 102 and 152 models only.

**Ordering Information**

Product Description	Catalog No.		Catalog No.	
<b>Plasma Cutting Systems</b>	<b>110/230V</b>			
<b>CUTMASTER® 39</b> with SL60® 75° hand torch, 20 ft. (6.1m) lead	<b>1 phase</b>			
	<b>1-3830</b>			
	<b>208/230V</b>	<b>460V</b>	<b>208/230V</b>	<b>460V</b>
	<b>1 Phase</b>	<b>3 Phase</b>	<b>1 Phase</b>	<b>3 Phase</b>
<b>CUTMASTER 52</b> with SL60 75° hand torch, 20 ft. (6.1m) lead	<b>1-5130-1</b>	<b>1-5130-2</b>	<b>1-1130-1</b>	<b>1-1130-2</b>
<b>CUTMASTER 52</b> with SL60 75° hand torch, 50 ft. (15.2m) lead	<b>1-5131-1</b>	<b>1-5131-2</b>	<b>1-1131-1</b>	<b>1-1131-2</b>
<b>CUTMASTER 52</b> with SL100® 180° machine torch, 25 ft. (7.6m) lead*	<b>1-5132-1</b>	<b>1-5132-2</b>	<b>1-1132-1</b>	<b>1-1132-2</b>
<b>CUTMASTER 52</b> with SL100 180° machine torch, 50 ft. (15.2m) lead*	<b>1-5133-1</b>	<b>1-5133-2</b>	<b>1-1133-1</b>	<b>1-1133-2</b>
<b>CUTMASTER 102</b> with SL100 75° hand torch, 20 ft. (6.1m) lead	<b>1-1330-1</b>	<b>1-1330-2</b>	<b>1-1730-1</b>	<b>1-1730-2</b>
<b>CUTMASTER 102</b> with SL100 75° hand torch, 50 ft. (15.2m) lead	<b>1-1331-1</b>	<b>1-1331-2</b>	<b>1-1731-1</b>	<b>1-1731-2</b>
<b>CUTMASTER 102</b> with SL100 180° machine torch, 25 ft. (7.6m) lead*	<b>1-1332-1</b>	<b>1-1332-2</b>	<b>1-1732-1</b>	<b>1-1732-2</b>
<b>CUTMASTER 102</b> with SL100 180° machine torch, 50 ft. (15.2m) lead*	<b>1-1333-1</b>	<b>1-1333-2</b>	<b>1-1733-1</b>	<b>1-1733-2</b>
<b>Torch Leads Packages</b>	<b>Hand</b>		<b>Auto</b>	<b>Mech.</b>
SL60, 75° 20 ft. (6.1m) torch/leads	7-5204			7-5213
SL60, 75° 50 ft. (15.2m) torch/leads	7-5205			7-5214
SL100, 75° 20 ft. (6.1m) torch/leads	7-5206			7-5215
SL100, 75° 50 ft. (15.2m) torch/leads	7-5208		7-4001	7-5215
SL60, 90° 20 ft. (6.1m) torch/leads	7-5260		7-4002	
SL60, 90° 50 ft. (15.2m) torch/leads	7-5260**		7-4003	7-5216
SL100, 90° 20 ft. (6.1m) torch/leads	7-5263			
SL100, 90° 50 ft. (15.2m) torch/leads	7-5263***			
<b>Torch Accessories</b>				
Pinion Assembly	9-8310			
Automation Interface Kit (TRUE Series 82,102 and 152)	7-2827			
			* Systems include machine torch with 1 <sup>3</sup> / <sub>8</sub> " (34.9mm) diameter/32 pitch, rack mounting tube, hand pendant control and pinch block. Pinion assembly to be ordered as an accessory.	
			** Use 7-5260 with 7-7545 for a SL60, 50 ft. (15.2m)	
			*** Use 7-5263 with 7-7545 for a SL100, 50 ft. (15.2m)	

**AirCut® 15C**

- 1/8" (3mm) recommended cut capacity
- 3/16" (5mm) maximum cut
- Built-in air compressor
- 15 Amps, fixed
- Duty Cycle: 35% @ 15A
- PCH-10 torch
- Light duty – 29 lbs.



**PAK® 200**

- 1/2" (40mm) recommended cut capacity
- 2 3/4" (70mm) maximum cut
- 35-200 Amps, adjustable
- Duty Cycle: 100% @ 200A
- PCH-200 torch
- Liquid-cooled torch
- Dual gas capacity



## 1Torch® RPT® Torches

1Torch – the most innovative and reliable, high performance replacement torch available today. No other torch performs so well with so many major brands of power supplies, often with cutting results better than the original manufacturer's torch:

- Easily attached to virtually all manufacturers' systems with superior performance
- Includes the SureLok® electrode locking system permitting quick, precise changes of consumables
- Out-of-the-box ready for all modes of operation including Drag Shield Cutting, Standoff Cutting and Drag Tip Cutting
- No moving consumable parts
- Standard set of consumables for all power supplies

All you need is the 1Torch RPT torch and the appropriate Adapter Kit. Each torch comes complete with easy-to-install instructions.

### ATC® Quick Disconnect Option

If you need additional flexibility, the 1Torch RPT torch is also available with ATC (Advanced Torch Connector). This quick disconnect enables you to change out a damaged torch, convert from a hand to machine torch, or put on a different sized torch in a matter of seconds and no tools are required to complete the task. You can also customize the length of your leads by adding ATC Lead Extensions in 15 ft. (4.6m), 25 ft. (7.6m) or 50 ft. (15.2m) lengths.



### 1Torch SL60®

(Brochure #63-2217 / 63-2530 for SL55)

- Light / Medium duty torch
- 30-80 Amp capacity
- Available in 75° or 90° (not for SL55) torch head configuration
- Standard connection or ATC quick disconnect available (not for SL55)



### 1Torch SL100®

(Brochure #63-2217 / 63-2530 for SL80)

- Medium / Heavy duty torch
- 40-120 Amp capacity
- Available in 75°, 90° or 180° (not for SL80) torch head configurations
- Standard connection or ATC quick disconnect available (not for SL80)



## Torch Adapter Kits

The model of the plasma cutting system must be known to determine the adapter kit required.

Power Supply Model	Catalog Number
<b>ESAB®</b>	
PCM-SMi, 500i, 625i, PCS-43	7-3425
PCS-53, 80, 90	7-3435
ESP-100i	7-3426
PCM-750i, 875, 1000i, 1125	7-3429
Sidewinder 30,55,105	7-3434
Powercut® 650	7-3464
Powercut 875, 1125	7-3465
Powercut 1250, 1500	7-3462
<b>HYPERTHERM®</b>	
Max®40, HT®40 (H/F Start) Max 70, 80, 100 (w/ & w/o Q.D.)	7-3430
Max 42*, 43*, 40cs*, Powermax®600*, 800*, 900* (w/o Q.D.)	7-3454
Powermax 1100*	7-3455
Powermax 1000*, 1250*	7-3461
Max 40cs* (w/o Q.D.)	7-3476
Powermax 380*	7-3477
Powermax 600* (w/o Q.D.)	7-3480
Powermax 800*, 900*(w/o Q.D.)	7-3481
Powermax 1650*	7-3483
Powermax 350*	7-3484
Powermax 190C*	7-3485
<b>L TEC®</b>	
PCM-31, SMi, 32i/34i, VPi PCM-500i, 625i, PCS-80i	7-3425
PCM-50A, 70, 80, 52i/54i, 82i/84i ESP-100i, PCM-50, PCM-100 (Single Gas) PCM-50, P-MC-100 (Dual Gas)	7-3426
PCS-40	7-3430
PCM-750i, 1000i	7-3435
PCM-101	7-3436
<b>MILLER®</b>	
Plazcut 60†/Zipcut	7-3432
Spectrum® 250D, 500, 750	7-3433
Spectrum 700, 1000,1250,PLUS	7-3430
Spectrum 3080*	7-3456
Spectrum 650*, 701*, 2050*	7-3457
Spectrum 300*	7-3476
Spectrum 375*	7-3477
Spectrum 625*	7-3478
<b>THERMAL DYNAMICS</b>	
PAK® 3XR, 5XT, 6XR, 7XR, 625XR, 750XR	7-3446
PAK 8XR, 10XR, 1000XR, 1250XR, PakMaster® 75, 100	7-3434
PakMaster 50XL/XLP, 75XL/XLP, 100XL/XLP, CUTMASTER® 50, 75, 80XL, 100	7-3447
PakMaster 25, 38XL, EconoPAK® 25, Drag-Gun® 38, PAK 4Xi, 6Xi, PAK 2XT, Dynapak® 110	7-3443
PakMaster 50 w/Smart Torch (Q.D)	7-3445
EconoPAK 50	7-3449
EconoPAK 100	7-3450
PAK 5	7-3444
PAK 10	7-3436

\*Non-HF Systems.

†The Miller PlazCut machines with Serial Numbers beginning JE are not compatible with 1Torch® RPT Torches.

NOTES: Each Adapter Kit includes connection fitting, electrical connectors and installation instruction sheets for the selected power supply.

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## 1Torch® Consumable Parts Application Guide

For SL60® / SL100® Manual Cutting and Gouging Operations.



**Drag Tip Cutting** The preferred method of cutting light gauge metal up to 1/4" (6mm) thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 Amps or less, now with Thermal Dynamics® TRUE Cut Drag Tip Series™ technology it is possible to cut up to 60 Amps. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 Amps).



**Standoff Cutting** The preferred method of cutting metal thicker than 1/4" (6mm) and at current levels above 60 Amps. Provides maximum visibility and accessibility. Use the single piece shield cup for 'standoff' cutting (with the torch tip 1/8" (3mm) to 1/4" (6mm) from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.



**Drag Shield Cutting** This is an operator -friendly method of cutting between 70 to 120 Amps while maintaining a constant standoff distance. For metal thickness greater than 1/4" (6mm), simply drag the shield cup in contact with the work piece. Use the shield cup body with the appropriate drag shield cup matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.



**Gouging** A simple method of metal removal by angling the torch to a lead angle of 35°-45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the amount of material removed and the profile of the gouge. You can use the shield cup body with either the gouging shield cap or the shield deflector. Also, you can use the single piece shield cup.

Gouging Profiles				
	Output Range	Depth	Width	Profile
Tip A	40 Amps (max)	Shallow	Narrow	
Tip B	50 - 100 Amps	Deep	Narrow	
Tip C	60 - 120 Amps	Moderate	Moderate	
Tip D	60 - 120 Amps	Shallow	Wide	
Tip E	120 Amps	Moderate	Wide	

1Torch, a trademark of Thermal Dynamics Corporation, is registered with the U.S. Patent and Trademark Office, and is the subject of trademark registrations and pending applications in numerous other countries. For information on trademark registrations of Thermal Dynamics Corporation, contact the local trademark offices in the countries of interest.

## 1Torch Consumable Parts Selection Guide

For SL60 / SL100 Manual Cutting and Gouging Operations. Various front-end parts are available for different applications. The electrode and start cartridge remain the same for all applications.



Current Range	Mode Of Operation	Amps	Electrode	Start Cartridge	Tip	Shield Cup	Shield Cup Body	Drag Shield Cup	Deflector	Single Shield Cup
20-40 Amps	Drag Tip (Cutting)	20A			9-8205	9-8216				
		30A			9-8206	9-8216				
	Standoff Cutting	40A			9-8207	9-8216				
50-60 Amps	Standoff Cutting	20A			9-8205		9-8237		9-8243	
		30A			9-8206		9-8237		9-8243	
	Drag Shield Cutting	40A	9-8215	9-8213	9-8207		9-8237			
70-100 Amps	Standoff Cutting	50-55A			9-8208	9-8218				
		60A			9-8209	9-8218				
	Drag Shield Cutting	50-55A	9-8215	9-8213	9-8210		9-8237	9-8235*		
120 Amps	Standoff Cutting	60A			9-8211		9-8237		9-8243	
		70A			9-8212		9-8237		9-8243	
	Drag Shield Cutting	70A	9-8215	9-8213	9-8211		9-8237	9-8235*		
120 Amps	Standoff Cutting	80A			9-8211	9-8218				
		90A-100A			9-8212	9-8218				
	Drag Shield Cutting	80A			9-8211		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212		9-8237	9-8235*		
120 Amps	Standoff Cutting	70A			9-8231		9-8237		9-8243	
		80A			9-8211		9-8237		9-8243	
	Drag Shield Cutting	90A-100A			9-8212					

## Accessories

Thermal Dynamics® offers accessories to help improve cutting performance.

### Torch Cutting Guides / Guide Kits

#### Cutting Guide Kit (Deluxe)

Cat. No. 7-8910

Cuts circles from 2.125" (54mm) to 41.5" (1054mm) with proper cutting attachments.

This kit includes easy add-on attachments to fit most Thermal Dynamics torches for precise straight line, circle cutting and beveling. Includes Carrying Case, Radius/Roller Kit (7-7501), Circle Cutting Guide Kit (7-3291), Magnetic Pivot, Suction Pivot.



#### Circle Cutting Guide Kit

Cat. No. 7-3291

Cuts 2.125" (54mm) to 27.75" (705mm) circles (using magnetic attachment) when cutting or beveling is required. For use with most Thermal Dynamics torches. Guide shown with optional pivot (7-3148).



#### Radius / Roller Cutting Guide Kit

Cat. No. 7-7501

This easy-to-use guide cut circles from 3" (76mm) up to 28.75" (730mm). Maintains a consistent height off the work piece whether you are using the circle cutting attachment for cutting circles or the roller guide feature to improve your straight-line cutting.

Both novices and experts will see noticeable improvement in quality, speed and parts life. Can be used with most Thermal Dynamics torches.



#### Torch Guide / Circle Cutting Attachment

Cat. No. 7-7505

Cuts 3.5" (89mm) to 29" (737mm) circles. Designed for use with the PCH/M-120 Torch, this accessory can be used as either a Roller Guide or a Circle Cutting Guide.



#### Straight Line Cutting Guide

Cat. No. 7-8911

Introducing a new cutting guide accessory suitable for all hand torches, PCH-10 through PCH-102. This versatile, straight line cutter is for hand held systems and it cuts vertical, 90°, or bevel cuts. Its consistent standoff improves cut quality and maximizes overall performance. Produces more efficient straight line cuts. Lightweight, minimum set up time and no power required. Magnetic mounts ensure placement and ease of use. Optional suction plates available for non-magnetic applications (i.e. aluminum and stainless steel). The Cutting Guide Kit includes: 4 ft. (1.2m) standard rail Torch Holder and Busing Heavy Duty Magnets (2 ea.) Slide Assembly Wheels and Fasteners. Optional 4 ft. (1.2m) extensions (9-7971) available.



### Torch Cutting Guides (cont.)

#### Universal Standoff Cutting Guide

Cat. No. 9-8422

A great new standoff guide specifically designed to fit all shield cup designs for PCH-62, PCH-102, SL60® and SL100® RPT® torches. Adjustable standoff height.



#### CUTMASTER® TRUE™ Series Standoff Cutting Guides

Cat. No. 9-8281 (CUTMASTER 52, 82, 102 & 152)

New standoff guides designed to fit the SL60 & SL100 torches specific to the CUTMASTER TRUE Series systems. The standoff is preset.



### Miscellaneous Torch Accessories

#### Leather Leads Cover

15 ft. (4.6m)	9-1258
20 ft. (6.1m)	9-1260
25 ft. (7.6m)	9-1270
50 ft. (15.2m)	9-1280



These leads covers are suitable for both 1Torch® and SureLok® leads. Snaps make it easy to install. Snap two covers together for wider torches.

#### Trigger Guard Kits

SureLok Torches (PCH-62 & PCH-102)

Cat No. 9-8418 - Short Trigger Guard

Cat No. 9-8419 - Long Trigger Guard

1Torch (SL60 & SL100)

Cat No. 9-8420 - Short Trigger Guard

Cat No. 9-8421 - Long Trigger Guard



These guards offer additional protection from accidental activation or damage to the torch switch.

#### Remote Pendant Control

Cat No. 7-3460 - 20 ft. (6.1m)

Remote Pendant Control for your mechanized application.



#### Hand Pendant Extension

Cat No. 7-7744 - 25 ft. (7.6m)

#### ATC® Lead Extensions\*

15 ft. (4.6m)	7-7544
25 ft. (7.6m)	7-7545
50 ft. (15.2m)	7-7552

Available for any system using 1Torch with ATC Quick Disconnect. Leads Extensions enable you to customize your lead length to suit the cutting job.



\* Note: For use with hand & mechanized torches only. Will not work with automation torch & leads.

**Air Filter/Air Filter Kits**

For improved consumable parts life and overall performance, Thermal Dynamics recommends Air Filter Kits be used on all plasma cutting systems.

**Single Stage Air Filter Kit**

Cat. No. 7-7507 (Filter Body 9-7740, Hose 9-7742, Filter Element 9-7741)

For use with shop compressed air systems, this in-line filter will not allow moisture or water to pass through the filter element even if it becomes completely saturated. This hi-tech filter element actually blocks the absorption of water to increase performance and improve consumable parts life.



**Two Stage Air Filters**

Cat. No. 7-7502

For PakMaster 150XL Systems

Cat. No. 7-7500

For CUTMASTER 1Series™ and PakMaster® Systems

Cat. No. 9-9387

For CUTMASTER TRUE Series and A-Series

The Two Stage Air Filter will remove moisture and contaminants from the air stream when using compressed air. The filter is capable of filtering to at least 5 microns. The filter assembly is pre-assembled at the factory and need only be installed on the power supply.



**First Stage Element**

Cat. No. 9-1021

**Second Stage Element**

Cat. No. 9-1022

**Portable Gear**

**Multi-Purpose Cart**

Cat. No. 7-8888

Designed for most portable manual cutting systems such as the CUTMASTER 39, 52, 82 or any other similar sized systems.

This rugged steel cart has easy rolling 8" (203mm) diameter wheels along with 3" (76mm) front mounted casters. This cart also serves as an excellent showroom display stand.



**Miscellaneous Accessories**

**Plasma Cutting Techniques DVD**

Cat. No. 9-1253



**Welding Gloves**

Cat. No. 9-1250



**Automation Accessories**

**Automation Interface Kit\***

Cat. No. 9-8311

\* Note: Required for SC-11 torch height control

**CNC Harness Cable**

Cat. No. 9-9385

**CNC Interface Cable**

25 ft. (7.6m) 9-8312

50 ft. (15.2m) 9-8313

75 ft. (22.8m) 9-8315

100 ft. (30.5m) 9-8316

**Pinion Assembly**

Cat. No. 7-2827 1 3/8" (35mm) Diameter

125 ft. (38.0m) 9-8317

**Torch Coolant**

**Extra Cool™ Coolant**

Cat. No. 7-3580

Resists freezing down to +10°F (-12°C)



**Ultra Cool™ Coolant**

Cat. No. 7-3581

Resists freezing down to -27°F (-33°C)

**Extreme Cool™ Coolant**

Cat. No. 7-3582

Resists freezing down to -65°F (-51°C)

**De-I Cool™ Coolant**

Cat. No. 7-3583

De-ionized water mixture for use where freezing protection is not required.



## Inverter Arc Welders

### NEW 95 S Portable DC Welder

#### 95 S

- 115V, 1ph, 50/60 Hz.
- 95 Amps welding output
- Simple & easy, ready to weld package
- Ultralight and portable – 10 lbs.
- Perfect for hobbyists, maintenance & repair, and light fabrication
- Available in Stick and Stick/TIG packages (shown)



## Thermal Arc® Welding Systems

Thermal Arc is on the move! The Thermal Arc family of arc welding products has been completely overhauled, re-engineered and expanded to meet your expectations in performance, reliability and value.

### Inverter Arc Welders

#### Professional ArcMaster® Series

##### ArcMaster 185 ACDC

- 208-230V, 1ph, 50/60 Hz.
- 5-185A (DC/TIG), 10-185A (AC/TIG)
- 5-160A (DC/Stick), 10-160A (AC/Stick)
- AC/DC Stick, HF/Lift TIG
- Job save and load
- Complete packages available



##### ArcMaster 200 ACDC

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-200A (DC/TIG), 10-200A (AC/TIG)
- 5-160A (DC/Stick), 10-160A (AC/Stick)
- AC/DC Stick, HF/Lift TIG
- Job save and load
- Complete packages available



##### ArcMaster 300 ACDC

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-300A (DC), 10-300A (AC/TIG)
- AC/DC Stick, HF/Lift TIG
- Job save and load
- Complete packages available



##### ArcMaster 300TS

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-300 Amps welding output
- DC Stick, HF/Lift TIG
- Job save and load
- Complete packages available



**GOLD WARRANTY**  
5 Year\*

Most newly redesigned Thermal Arc arc welding power supplies come with a powerful 5 year warranty on parts, 3 years on labor.

\* Limited warranty, refer to warranty schedule for details.

**Professional ArcMaster® Series**

**ArcMaster 400S**

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-400 Amps welding output
- DC Stick, Lift TIG
- Complete packages available



**ArcMaster 400MST**

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-400A, 10-36V
- DC Stick, HF/Lift TIG, MIG
- Job save and load
- Complete packages available



**ArcMaster 400MSTP**

- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-400A, 10-36V
- DC Stick, HF/Lift TIG, MIG, Pulse MIG
- Job Save and Load
- Complete packages available



**MIG Arc Welders**

**WeldSkill® Fabricator® Series**

**Fabricator 140**

- 120V, 1ph, 60 Hz.
- 30-140 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Complete packages available



**Fabricator 180**

- 230V, 1ph, 60 Hz.
- 30-180 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Complete packages available



**Fabricator 190**

- 230V, 1ph, 60 Hz.
- 30-190 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Complete packages available



**Fabricator 210**

- 208-230V, 1ph, 60 Hz.
- 20-250 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Complete packages available



**Fabricator 251**

- 208-230V, 1ph, 60 Hz.
- 20-300 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Complete packages available



**Fabricator 281**

- 208-230V, 1ph, 60 Hz.
- 20-300 Amps welding output
- DC Flux Cored, MIG
- 2 roll wire feed system
- Includes removable wire feeder



**THERMAL ARC**  
WeldSkill®

Inverter / MIG Arc Welders

**MIG Arc Welders**

**Professional Synergic Pulse Series**

**PowerMaster 320SP**

- 208/230/400/460V, 1ph, 50/60 Hz.
- 5-320 Amps welding output
- DC Stick, TIG, MIG, SmartMIG™, PulseMIG, TwinPulse®, CAG
- Built-in wirefeeder
- Complete packages available



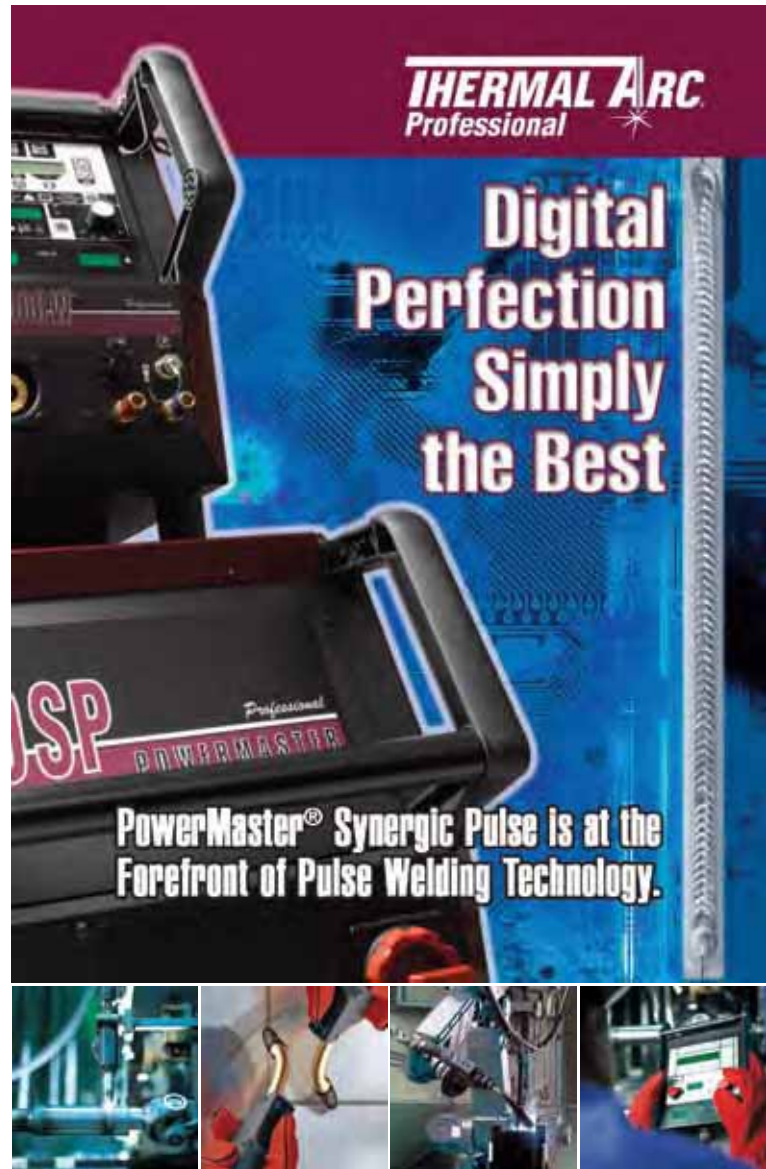
**PowerMaster 400SP**

- 208/230/400/460V, 1/3ph, 50/60 Hz.
- 5-400 Amps welding output
- DC Stick, TIG, MIG, SmartMIG, PulseMIG, TwinPulse, CAG
- Integrated or remote wirefeeder
- Complete packages available
- Available with remote wirefeeder
- Automation model available



**PowerMaster 500SP**

- 208/230/400/460V, 1/3ph, 50/60 Hz.
- 5-500 Amps welding output
- DC Stick, TIG, MIG, SmartMIG, PulseMIG, TwinPulse, CAG
- Remote wirefeeder
- Complete packages available
- Automation model available



## Plasma Arc Welders

### Professional Series

#### Ultima® 150

- 208-460V, 1/3ph, 50/60 Hz.
- 0.5-15A (Low), 5-150A (High)
- DC Plasma Arc Welding
- Smooth DC Arc
- Pilot arc, Current limiter
- Preview set current
- Simple interface
- Includes unit, quick change torch, spare parts kit, coolant



#### WC-100B Console

- Pilot Arc Starting
- Automatic/Manual Operation
- LED display Amp/Volt display
- Shield gas flowmeters
- Hi/Lo pilot current switch



#### HE-100A Coolant Recirculator

- For Thermal Arc torches up to 300A
- High efficiency, non-ferrous internal construction
- Reusable metal filter
- 1.75 gal. (6.6L) coolant capacity



#### WC-1 Controller

- Compact micro-processor system
- For use with Ultima 150 or WC-100B
- Accurate & repeatable parameter control
- Pulser controls warpage, penetration and weld puddle
- Sloper function
- Two programmable outputs (plasma power source & cold wire feed motor drive control)
- 32 user selectable weld schedules



#### WF-100 Wire Capstan Feeder

- Compact, lightweight precision feeder
- Robotic or automation fixture applications
- Weighs less Than 6 lbs.
- Better wire drive contact by wrapping wire around wire drive wheel



## Wire Feeders

### Professional Series

#### Hefty II CC/CV

- 15-100 VDC, voltage sensing
- 8 Amps max input current
- 50-700 IPM (1.3-17.8m/min.)
- 0.024" - 5/64" (0.6-2.0mm)
- 2 gear driven feed rolls
- 30 lbs. (13.6kg) max spool size



# Signature Products Selection Guide

Signature Products

Wear Mode	Product	Base Metal	General Use	PROCESS			
				GTAW	SMAW	FCAW	GMAW
Build-up & Joining Alloys	Stoody® Build-up	Carbon steel	Build-up			●	●
	Stoody Build-up LH	Carbon steel	Build-up		●		
	Nicomang™	Manganese steel	Build-up & Joining		●	●	●
	Versalloy™ Plus	Carbon & Manganese steel	Build-up, repair & joining (Joining Carbon Steel to Stainless steel)		●		
	Stoody 110	Carbon & Manganese steel	Build-up & repair			●	●
	Stoody 2110	Carbon & Manganese steel	Build-up & repair		●		
	Castweld 55	Cast iron	Joining, Build-up & repair		●	●	
	Castweld 99	Cast iron	Joining, Build-up & repair		●		
Metal to Metal Alloy	Stoody 1105	Carbon & Low alloy steel	Metal to Metal wear		●		
	Super Build-up	Carbon & Low alloy steel	Metal to Metal wear			●	●
Metal to Earth Alloy "Moderate Abrasion"	Stoody 19	Carbon & Low alloy, and Manganese steel	Severe abrasion, low impact		●		
	Stoody 965	Carbon & Low alloy, and Manganese steel	Moderate abrasion, high impact			●	●
	Stoody 31	Carbon & Manganese steel	Moderate abrasion, moderate impact		●		
	Stoody 101HC	Carbon & Low alloy and Manganese steel	Severe abrasion, low impact			●	
	Stoody 121	Carbon & Low alloy and Manganese steel	Moderate to severe abrasion, & moderate impact			●	●
Metal to Earth Alloy "Extreme Abrasion"	Stoody 130	Carbon & Low alloy steel	Extreme Abrasion & low impact			●	
	Vancar™	Carbon & Low alloy steel	Extreme Abrasion & low impact		●	●	●
	Acetylene Tube Borium (ATB Bare)	Carbon & Low alloy steel	Extreme Abrasion & low impact	Oxy-Acetylene			
Temperature Abrasion Corrosion	Stoodite 6	Carbon & Low alloy and Stainless Steel	High temperature abrasion & corrosion resistance	●	●		●
	Stoodite 21	Carbon & Low alloy and Stainless Steel	High temperature abrasion & corrosion resistance	●	●		●

See our full line signature products catalog (Form No. 2102A) or visit us on the web at [www.stoody.com](http://www.stoody.com) for more information. (part numbers, data sheets, etc.)

*We've made it simple*

AVAILABLE SIZES		APPLICATIONS
Wire	Electrodes	(Partial Listing)
0.045", 1/16", 3/32", 7/64"		Hammers, Carbon Steel Shovel Pads, Shaft, Rolls, Pump Parts
	1/8", 5/32", 3/16", 1/4"	Tractor Rollers, Steel Shovel Pads, Tractor Idlers, Sprockets, Shafts
0.045", 1/16", 3/32"	1/8", 5/32", 3/16", 1/4"	Dredge Pumps Parts, Crusher Jaws, Impact Breaker Bars, Hammers
	3/32", 1/8", 5/32"	General purpose Stainless, good for joining Stainless to dissimilar metals
0.045", 1/16", 3/32", 7/64"		Shovel Teeth, Turbine Cone, Shovel Pads, Crusher Rolls, Drive Tumblers
	1/8", 5/32", 3/16", 1/4"	Steel Frogs, Switch Points, Hammers, Shovel Teeth, Roll Crushers
1/16", 3/32"	3/32", 1/8", 5/32"	Joining build-up, and repair of cast iron parts Pump Impellers, Pump Castings, Housings, Engine blocks and Heads
	3/32", 1/8", 5/32"	Similar applications as Castweld 55 with focus on hairline cracks
	1/8", 5/32", 3/16", 1/4"	Tractor Rollers & Idlers, Idler Sprockets, Drive Tumblers, Churn Drills
0.045", 1/16", 7/64"		Gear Teeth, Sprockets, Steel Shovel Pads, Carbon Steel Shafts
	1/8", 5/32", 3/16", 1/4"	Crusher Rolls, Dredge Parts, Pump Shells, Impellers, Impact Breaker Scrapers
0.045", 1/16"		Tillage Tools, Dredge Parts, Shedder Knives, Extruder Screws
	1/8", 5/32", 3/16", 1/4"	Bucket Arms, Chain Links, Rolling Mill Guides, Pulley, Scrapers, Blades
0.045", 1/16", 5/64"		Bucket Slides & Lips, Blades, Clam Shell bucket, Augers, Scraper Sides
0.045", 1/16", 5/64"		Scraper Slides, Scraper Cutters Vibrator Ditcher Shanks, Pot Hole Augers
1/16", 7/64"		Muller Plows, Chisel Plow, Ammonia Injectors, Raymond Mill Plows
1/16", 3/32", 7/64"	5/32", 3/16"	Farm Drill Points, Dry Cement Pump Screws, Drill Pipe Stabilizer, Paddles
	1/8", 5/32", 3/16", 1/4"	Plow Points, Cane Knives, Teeth, Tool Drill Bits
0.045", 1/16", 3/32"	1/8", 5/32", 3/16", 1/4", 5/16" (also in bare rod)	Valves Trim, Pump Sleeves, Engine Valves, Pulp Digester Blades, Dies
0.045", 1/16"	1/8", 5/32", 3/16", 1/4", 5/16" (also in bare rod)	Cavitation Applications, Hot Working Dies, Turbine Runners, Valve Seat



### Stoody® Hardfacing & Welding Wires

Stoody is the world's leader in the production of welding wires and electrodes used to combat various types of wear and corrosion. Our extensive family of products includes Iron, Nickel, Cobalt, Tungsten and Vanadium based alloys. Some of the major industries we serve are power generation, mining, construction, railroad, steel, foundry, oil and gas production and exploration as well as the pulp and paper industry.

### Stainless Steel Flux Cored Wires

#### BRILLIANT 410NiMo T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with Argon/CO<sub>2</sub> gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters. AWS classification A5.22-95 410NiMoT1-4.

Stoody 410NiMoT-1 AP wires can be used to join martensitic stainless steels such as 410 used in valve and pump manufacturing. These wires can also be used for the repair and joining of CA-6NM castings.

**Typical Composition:**

Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

#### BRILLIANT 2209 T-1 AP

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 2209T-1 AP wires can be used to weld duplex stainless steels which contain approximately 22% Chromium. The composition is balanced to achieve a microstructure of approximately 50% ferrite and 50% austenite in the weld deposit. AWS classification A5.22-95 E2209TO-X.

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum, Nitrogen

**Typical Deposit Characteristics:**

Tensile Strength, Ksi (MPa) ..... 122 (842)  
 Yield Strength, Ksi (Mpa)..... 101 (670)  
 Elongation (%)..... 27.5  
 Charpy Impact Toughness @ -40°F (-40°C) ..... 33ft-lbs (20 Joules)

### Interactive CD-ROM with Hardfacing Solutions

STOODY EXPRESS 3 is the industry's first interactive CD-Rom for hardfacing alloy selection. Program includes Alloy Advisor, application Recommendations, and data sheets for all Stoody Products. Tap into Stoody's 87 years of hardfacing industry experience and technical support.

Call Stoody Customer Care or visit our website to request a **FREE** copy of this CD and other information on STOODY.



**Typical Deposit Characteristics:**

Tensile Strength, Ksi (MPa) ..... 134 (880)  
 Yield Strength, Ksi (Mpa)..... 118 (776)  
 Elongation (%)..... 19  
 Charpy V-Notch Toughness @ 32°F (0°C) ..... 25ft-lbs (34 Joules)

Part Number	Packaging	Wire Diameter		Shielding Gas	Welding Parameters	
		in.	mm		Amps	Volts
11921000	33# WB, VP	1/16	1.6	75% Ar, 25% CO <sub>2</sub>	190-250	26-27

Part Number	Packaging	Wire Diameter	
		in.	mm
11892000	33# WB, LLW	0.045	1.2
11892100	33# WB, LLW	1/16	1.6

0.045" (1.2mm)					
Amps		130 <sup>1</sup>	165 <sup>1</sup>	190 <sup>1</sup>	220 <sup>2</sup>
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

1/16" (1.6mm)					
Amps		170 <sup>1</sup>	210 <sup>1</sup>	250 <sup>1</sup>	300 <sup>2</sup>
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

**Notes:**

Electrical stick-out 1/2"      1. Flat and vertical welding      2. Flat welding only

## 308L T-1 AP

Stoody® AP stainless steel wires are designed for welding in all positions with either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 308LT-1 AP wires can be used to join AISI 301, 302, 304 commonly used in the chemical industry and food processing applications. AWS classification A5.22-95 E308LT1-X.

### Typical Deposit Chemistry:

Carbon, Manganese, Silicon, Chromium, Nickel

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa) .....	88 (610)	86 (600)
Elongation (%) .....	39	41
Yield Strength, Ksi (Mpa) .....	63 (435)	60 (415)

Part Number	Packaging	Wire Diameter	
		in.	mm
11953600	25# WB	0.035	0.9
11819000	33# WB	0.045	1.2
11819100	33# WB	1/16	1.6

0.035" (0.9mm)					
Amps		100 <sup>1</sup>	120 <sup>1</sup>	150 <sup>1</sup>	170 <sup>2</sup>
Volts		25	26	27	27
WFS	in/min	275	374	480	600
	(m/min)	(6.9)	(9.5)	(12.2)	(15.3)

0.045" (1.2mm)					
Amps		130 <sup>1</sup>	165 <sup>1</sup>	190 <sup>1</sup>	220 <sup>2</sup>
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	(5.8)	(8.7)	(11.3)	(14.4)

1/16" (1.6mm)					
Amps		170 <sup>1</sup>	210 <sup>1</sup>	250 <sup>1</sup>	300 <sup>2</sup>
Volts		25	26	27	28
WFS	in/min	115	195	245	320
	(m/min)	(3.9)	(4.9)	(6.2)	(8.2)

### Notes:

Electrical stick-out 1/2"      1. Flat and vertical welding      2. Flat welding only

## 308L T-1 FH

Stoody FH stainless steel , flux cored wires are designed for flat and horizontal welding applications, using either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly ripped bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 308LT-1 FH wires can be used to join AISI 301, 302, 304 commonly used in the chemical industry and food processing applications. AWS classification A5.22 E308LT0-X.

### Typical Deposit Chemistry:

Carbon, Manganese, Silicon, Chromium, Nickel

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa) .....	87 (600)	84 (573)
Elongation (%) .....	37	38
Yield Strength, Ksi (Mpa) .....	62 (430)	60 (415)

Part Number	Packaging	Wire Diameter	
		in.	mm
11703100	35# WB, VP	0.035	0.9
11869400	33# WB, VP	0.045	1.2
11869300	33# WB, VP	1/16	1.6

0.035" (0.9mm)			
	Low	Optimum	High
Amps	120	150	180
Volts	24	25/26	28
WFS	in/min	375	460
	(m/min)	(9.5)	(11.7)

0.045" (1.2mm)			
	Low	Optimum	High
Amps	135	200	250
Volts	23	26	31
WFS	in/min	200	350
	(m/min)	(5.0)	(8.9)

1/16" (1.6mm)			
	Low	Optimum	High
Amps	200	250	300
Volts	24/26	26/28	28/30
WFS	in/min	175	250
	(m/min)	(4.5)	(6.4)

### Notes:

- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

### 309L T-1 AP

Stoody® AP stainless steel wires are designed for welding in all positions with either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 309LT-1 AP wires can be used to join AISI 309 steels. It is also used to join AISI 304 to carbon and low alloy steels. AWS classification A5.22 E309LT1-X.

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Nickel

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa) .....	88 (610)	86 (600)
Elongation (%).....	34	38
Yield Strength, Ksi (Mpa).....	69 (480)	64 (440)

Part Number	Packaging	Wire Diameter	
		in.	mm
11953400	25# WB	0.035	0.9
11819300	33# WB	0.045	1.2
11819400	33# WB	1/16	1.6

**0.035" (0.9mm)**

Amps	100 <sup>1</sup>	120 <sup>1</sup>	150 <sup>1</sup>	170 <sup>1</sup>
Volts	25	26	27	27
WFS	in/min	275	374	480
	(m/min)	(6.9)	(9.5)	(12.2)

**0.045" (1.2mm)**

Amps	130 <sup>1</sup>	165 <sup>1</sup>	190 <sup>1</sup>	220 <sup>2</sup>
Volts	24	26	26	27
WFS	in/min	227	315	445
	(m/min)	(5.8)	(8.7)	(11.3)

**1/16" (1.6mm)**

Amps	170 <sup>1</sup>	210 <sup>1</sup>	250 <sup>2</sup>	300 <sup>2</sup>
Volts	25	26	27	28
WFS	in/min	115	195	245
	(m/min)	(3.9)	(4.9)	(6.2)

**Notes:**

- 3/8" - 1/2" (10 - 12mm) Electrical stick-out.      1. Flat and vertical welding
- 2. Flat welding only

### 309L T-1 FH

Stoody FH stainless steel, flux cored wires are designed for flat and horizontal welding applications, using either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly rippled bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 309LT-1 FH wires can be used to join AISI 309 steels. It is also used to join AISI 304 to carbon and low alloy steels. AWS classification A5.22 E308LTO-X.

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Nickel

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa) .....	84 (585)	83 (580)
Elongation (%).....	34	33
Yield Strength, Ksi (Mpa).....	61 (420)	61 (420)

Part Number	Packaging	Wire Diameter	
		in.	mm
11703400	25# WB, VP	0.035	0.9
11869600	33# WB, VP	0.045	1.2
11869500	33# WB, VP	1/16	1.6

**0.035" (0.9mm)**

	Low	Optimum	High
Amps	120	150	180
Volts	24	25/26	28
WFS	in/min	375	460
	(m/min)	(9.5)	(11.7)

**0.045" (1.2mm)**

	Low	Optimum	High
Amps	135	200	250
Volts	23	26	31
WFS	in/min	200	350
	(m/min)	(5.0)	(8.9)

**1/16" (1.6mm)**

	Low	Optimum	High
Amps	200	250	300
Volts	24/26	26/28	28/30
WFS	in/min	175	250
	(m/min)	(4.5)	(6.4)

**Notes:**

- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

## 316L T-1 AP

Stoody® AP stainless steel wires are designed for welding in all positions with either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody 316LT-1 AP wires can be used to join AISI 316 and 316L commonly used in the rubber, chemical, petrochemical and dye industries. AWS classification A5.22 E308LT1-X.

### Typical Deposit Chemistry:

Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa).....	88 (610)	86 (600)
Elongation (%).....	36	39
Yield Strength, Ksi (Mpa).....	66 (460)	62 (430)

Part Number	Packaging	Wire Diameter	
		in.	mm
11953500	25# WB	0.035	0.9
11819600	33# WB	0.045	1.2
11819700	33# WB	1/16	1.6

### 0.035" (0.9mm)

Amps	Volts	WFS	100'	120'	150'	170'
			25	26	27	27
			275	374	480	600
			(6.9)	(9.5)	(12.2)	(15.3)

### 0.045" (1.2mm)

Amps	Volts	WFS	130'	165'	190'	220'
			24	26	26	27
			227	315	445	565
			(5.8)	(8.7)	(11.3)	(14.4)

### 1/16" (1.6mm)

Amps	Volts	WFS	170'	210'	250'	300'
			25	26	27	28
			115	195	245	320
			(3.9)	(4.9)	(6.2)	(8.2)

### Notes:

1/2" Electrical stick-out.      1. Flat and vertical welding      2. Flat welding only

## 316L T-1 FH

Stoody FH stainless steel, flux cored wires are designed for flat and horizontal welding applications, using either 100% CO<sub>2</sub> (X=1) or Argon/CO<sub>2</sub> (X=4) gas mixtures. These wires exhibit a spray like arc transfer with very low levels of spatter, a slag system that is essentially self-releasing, a smooth evenly ripped bead appearance, and deposition rates which are obtained at lower levels of heat input than competitive products.

Stoody 316LT-1 FH wires can be used to join AISI 316 and 316L commonly used in the rubber, chemical, petrochemical and dye industries. AWS classification A5.22 E316LT0-X.

### Typical Deposit Chemistry:

Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

<b>Typical Deposit Characteristics:</b>	<b>75 AR/25 CO<sub>2</sub></b>	<b>100% CO<sub>2</sub></b>
Tensile Strength, Ksi (MPa).....	88 (610)	82 (570)
Elongation (%).....	35	36
Yield Strength, Ksi (Mpa).....	65 (450)	60 (415)

Part Number	Packaging	Wire Diameter	
		in.	mm
11703700	25# WB, VP	0.035	0.9
11869700	33# WB, VP	0.045	1.2
11869800	33# WB, VP	1/16	1.6

### 0.035" (0.9mm)

Amps	Volts	WFS	Low	Optimum	High
			120	150	180
			24	25/26	28
			375	460	550
			(9.5)	(11.7)	(14.0)

### 0.045" (1.2mm)

Amps	Volts	WFS	Low	Optimum	High
			135	200	250
			23	26	31
			200	350	450
			(5.0)	(8.9)	(11.4)

### 1/16" (1.6mm)

Amps	Volts	WFS	Low	Optimum	High
			200	250	300
			24/26	26/28	28/30
			175	250	325
			(4.5)	(6.4)	(8.3)

### Notes:

- 3/8" - 1/2" (10-12mm) electrical stickout
- When using Argon / Carbon Dioxide mixtures, voltage may be reduced by up to one volt to improve weldability and bead appearance.

### Nickel Flux Cored Wires

#### STOODY® 82-T1

Stoody 82-T1 is a gas shielded all position flux cored wire that meets the requirements of AWS A5.34, Class ENiCr3TX-Y.

**Applications:** Joining Nickel-Chromium-Iron alloys, clad side of joints in steels clad with Nickel-Chromium-Iron weld metal, surfacing steel with Nickel-Chromium-Iron weld metal, joining Inconel 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Iron, Niobium, Sulfur, Phosphorus, Nickel

**Typical Deposit Characteristics:**

Tensile Strength ..... 89 ksi (614 Mpa)  
 Yield Strength ..... 58 ksi (400 Mpa)  
 Elongation ..... 26 %

Part Number	Packaging	Wire Diameter		Shielding Gas	Wire Ext.	Welding Parameters	
		in.	mm			Amps	Volts
11872700	33# WB	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
11872600	33# WB	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27

#### STOODY 182-T1

Stoody 182-T1 is a gas shielded all position flux cored wire that meets the requirements of AWS 5.34 ENiCrFe3TX-Y.

**Applications:** Joining Nickel-Chromium-Iron alloys, clad side of joints in steels clad with Nickel-Chromium-Iron weld metal, surfacing steel with Nickel-Chromium-Iron weld metal, joining Alloys 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Iron, Niobium, Sulfur, Phosphorus, Nickel

**Typical Deposit Characteristics:**

Tensile Strength ..... 94 ksi (649 Mpa)  
 Yield Strength ..... 58 ksi (400 Mpa)  
 Elongation ..... 35 %

Part Number	Packaging	Wire Diameter		Shielding Gas	Wire Ext.	Welding Parameters	
		in.	mm			Amps	Volts
11916200	33# WB	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
11916100	33# WB	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27

#### STOODY A-T1

Stoody A-T1 is a gas shielded all position flux cored wire that meets the requirements of AWS 5.34 ENiCrFe2TX-Y.

**Applications:** Joining Nickel-Chromium-Iron alloys, joining Nickel steels, joining Inconel 600, 601 and Icoloy 800 to themselves or to stainless and carbon steels

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Iron, Molybdenum, Niobium, Sulfur, Phosphorus, Nickel

**Typical Deposit Characteristics:**

Tensile Strength ..... 89.5 ksi (595 Mpa)  
 Yield Strength ..... 51.0 ksi (340 Mpa)  
 Elongation ..... 45 %  
 Charpy Impact Toughness. .... 67 Ft.-lbs. (92 Joules)  
 at -320°F (-196°C)  
 Lateral Expansion ..... 46 mils (1.2mm) at  
 -320°F (-196°C)

Part Number	Packaging	Wire Diameter		Shielding Gas	Wire Ext.	Welding Parameters	
		in.	mm			Amps	Volts
11896500	33# WB, LLW	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
11896700	33# WB, LLW	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27



**STOODY® 625-T1**

Stoody 625-T1 is a gas shielded all position flux cored wire that meet the requirements of AWS 5.34 ENiCrMo3TX-Y.

**Applications:** Joining Nickel-Chromium-Molybdenum alloys, clad side of joints in steels clad with Nickel-Chromium-Molybdenum weld metal, surfacing steel with Nickel-Chromium-Molybdenum weld metal, joining steels to Nickel based alloys, joining 9% Nickel steel for cryogenic applications

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron\*, Niobium, Sulfur, Phosphorus, Nickel

\*For Iron <1%, please request Stoody 625LI-T1 (PDS SP-029)

**Typical Deposit Characteristics:**

Tensile Strength .....112 ksi (773 Mpa)  
Yield Strength .....72 ksi (497 Mpa)  
Elongation .....38 %

Part Number	Packaging	Wire Diameter		Shielding Gas	Welding Parameters		
		in.	mm		Wire Ext.	Amps	Volts
11872500	33# WB, LLW	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
11872400	33# WB, LLW	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27

**STOODY C276-T1**

Stoody C276-T1 is a gas shielded All Position Flux Cored Wire that meet the requirements of AWS 5.34 ENiCrMo4TX-Y.

**Applications:** Joining Nickel-Chromium-Molybdenum alloys, clad side of joints in steels clad with Nickel-Chromium-Molybdenum weld metal, surfacing steel with Nickel-Chromium-Molybdenum weld metal, joining higher Molybdenum - high Nitrogen containing stainless steels

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron, Tungsten, Sulfur, Phosphorus, Nickel

**Typical Deposit Characteristics:**

Tensile Strength .....106 ksi (705 Mpa)  
Yield Strength .....68 ksi (452 Mpa)  
Elongation .....42 %

Part Number	Packaging	Wire Diameter		Shielding Gas	Welding Parameters		
		in.	mm		Wire Ext.	Amps	Volts
11953700	33# WB, LLW	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
	33# WB, LLW	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27

**STOODY 622-T1**

Stoody 622-T1 is a gas shielded all position flux cored wire that meet the requirements of AWS 5.34 ENiCrMo10TX-Y.

**Applications:** Joining Nickel-Chromium-Molybdenum alloys, clad side of joints in steels clad with Nickel-Chromium-Molybdenum weld metal, surfacing steel with Nickel-Chromium-Molybdenum weld metal, joining higher Molybdenum - high Nitrogen containing stainless steels

**Typical Deposit Chemistry:**

Carbon, Manganese, Silicon, Chromium, Molybdenum, Iron, Tungsten, Sulfur, Phosphorus, Nickel

**Typical Deposit Characteristics:**

Tensile Strength .....103 ksi (685 Mpa)  
Yield Strength .....70 ksi (470 Mpa)  
Elongation .....27 %

Part Number	Packaging	Wire Diameter		Shielding Gas	Welding Parameters		
		in.	mm		Wire Ext.	Amps	Volts
11953800	33# WB, LLW	0.045	1.2	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	150-200	25-26
	33# WB, LLW	1/16	1.6	75% AR-25% CO <sub>2</sub> or 100%CO <sub>2</sub>	1/2	200-250	26-27



# STATEMENT OF WARRANTY

(as of March 15, 2009)

**LIMITED WARRANTY:** THERMADYNE warrants that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the THERMADYNE products as stated below, THERMADYNE shall, upon written notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with THERMADYNE's specifications, instructions, recommendations and recognized standard industry practice, and not been subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at THERMADYNE's sole option, of any components or parts of the product determined by THERMADYNE to be defective.

**THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.**

**LIMITATION OF LIABILITY:** THERMADYNE shall not under any circumstances be liable for special, indirect or consequential damages, such as, but not limited to, damage or loss of purchased or replacement goods, business interruption or loss of profit, or claims of customers of distributor (hereinafter the "Purchaser") for service interruption. The remedies of the Purchaser set forth herein are exclusive and the liability of THERMADYNE with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by THERMADYNE whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based.

**THIS WARRANTY BECOMES INVALID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY THERMADYNE PRODUCT.**

**THIS WARRANTY IS INVALID IF THE PRODUCT IS SOLD BY NON-AUTHORIZED PERSONS.**

This warranty is effective for the time stated in the Warranty Schedule beginning on the date that the authorized distributor delivers the products to the Purchaser.

Warranty repairs or replacement claims under this limited warranty must be submitted by an authorized THERMADYNE repair facility within thirty (30) days of the repair. No transportation costs of any kind will be paid under this warranty. Transportation charges to send products to an authorized warranty repair facility shall be the responsibility of the Purchaser. All returned goods shall be at the Purchaser's risk and expense. This warranty supersedes all previous THERMADYNE warranties.

## WARRANTY SCHEDULE

The warranty is effective below for the time stated in the Warranty Schedule beginning on the date that the authorized distributor delivers the products to the purchaser. THERMADYNE reserves the right to request documented evidence of date of purchase.

<b>GAS WELDING AND CUTTING EQUIPMENT</b>	<b>Parts / Labor</b>
Victor® Professional	5 years / NA
Victor CutSkill®	2 years / NA
Victor FirePower®	1 year / NA
Victor Medical	6 years / NA
Victor VSP	2 years / NA
HP&I Brass Regulators/Manifolds	2 years / NA
HP&I Stainless Regulators/Manifolds	1 year / NA
HP&I Corrosive Gas Regulators/Manifolds	90 days / NA
Aluminum Cylinders	10 years / NA
Steel Cylinders	1 year / NA
Oxygen Conservers	2 years / NA
Cutting Machine Motors	1 year / NA
TurboTorch®	3 years / NA
Transformers	5 years / NA
Parts Used in Rental Applications	1 year from date sold by seller to authorized distributor
<b>ARC ACCESSORIES, ARC GOUGING &amp; SLICE EQUIPMENT</b>	<b>Parts / Labor</b>
TC and TCV Water Coolers	1 year / NA
TSC-96 Smoke Collector	1 year / NA
ESG-1, EPG-CR1, EPG-CR2 Control Boxes for Eliminator Spool & Pull Guns	1 year / NA
QRC-2000 Nozzle Cleaning Stations	1 year / 1 year
QRC-3000 Series Ultrasonic Cleaner	2 years / 2 years
Arcair® N6000	1 year / NA
Eliminator® Spool and Pull Guns	90 days / NA
PullMaster™ MIG Guns & PullMaster™ Pull Guns	90 days / NA
Robotic Deflection Mounts	90 days / NA
QRM-100 Anti-Spatter Applicator	90 days / NA
All other products 30 days from date purchaser including but not limited to: • MIG Guns • Arc Gouging Equipment • Slice Equipment	30 days / NA
<b>PLASMA CUTTING SYSTEMS</b>	<b>Parts / Labor</b>
CUTMASTER® TRUE Series	4 years / 4 years
PakMaster® XL PLUS	3 years / 1 year
PakMaster® 150XL	2 years / 1 year
CUTMASTER 1Series™	3 years / 3 years
AirCut™ 15C	1 year / 1 year
Drag-Gun® Plus	2 years / 1 year
Drag-Gun	1 year / 1 year
PAK 200	2 years / 1 year
Automated Plasma	2 years / 1 year
Torches	1 year / 1 year
Consoles, Control Equipment, Heat Exchangers and Accessory Equipment	1 year / 1 year



ENGINE DRIVEN WELDERS	Parts / Labor
<b>Scout®, Raider®, Explorer™</b>	
Original Main Power Stators and Inductors	5 years / 3 years
Original Main Power Rectifiers, Control P.C. Boards	3 years / 3 years
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Power Switch Semi-Conductors	1 year / 1 year
Engines and Associated Components are NOT Warranted by Thermal Arc®, Although Most are Warranted by the Engine Manufacturer. SEE THE ENGINE MANUFACTURERS' WARRANTY FOR DETAILS.	See the Engine Manufacturers' Warranty for Details
GMAW/FCAW (MIG) WELDING EQUIPMENT	Parts / Labor
<b>Fabricator® 140, 180, 190, 210, 251, 281; Fabstar® 4030; PowerMaster® 350, 350P, 500, 500P 320SP, 400SP, 500SP; Excel-Arc® 6045; Wire Feeders: Ultrafeed®, Porta-feed®</b>	
Original Main Power Transformer and Inductor	5 years / 3 years
Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors	3 years / 3 years
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors	1 year / 1 year
GTAW (TIG) & MULTI-PROCESS INVERTER WELDING EQUIPMENT	Parts / Labor
<b>160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP</b>	
Original Main Power Magnetics	5 years / 3 years
Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors	3 years / 3 years
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors	1 year / 1 year
PLASMA WELDING EQUIPMENT	Parts / Labor
<b>Ultima® 150</b>	
Original Main Power Magnetics	5 years / 3 years
Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors	3 years / 3 years
Welding Console, Weld Controller, Weld Timer	3 years / 3 years
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors, Coolant Recirculators	1 year / 1 year
SMAW (Stick) WELDING EQUIPMENT	Parts / Labor
<b>Dragster™ 85; 95S</b>	
Original Main Power Magnetics	1 year / 1 year
Original Main Power Rectifiers, Control P.C. Boards	1 year / 1 year
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Power Switch Semi-Conductors	1 year / 1 year
<b>160S, 300S, 400S</b>	
Original Main Power Magnetics	5 years / 3 years
Original Main Power Rectifiers, Control P.C. Boards	3 years / 3 years
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Power Switch Semi-Conductors	1 year / 1 year
GENERAL ARC EQUIPMENT	Parts / Labor
FirePower® MIG Welders	5-2-1 years / NA
Water Recirculators	1 year / 1 year
Plasma Welding Torches	180 days / 180 days
Gas Regulators (Supplied with Power Sources)	180 days / NA
MIG and TIG Torches (Supplied with Power Sources)	90 days / NA
Replacement Repair Parts	90 days / NA
MIG, TIG and Plasma Welding Torch Consumable Items	NA / NA

**U.S. Customer Care:** ARCAIR® / STOODY® / THERMAL ARC® / THERMAL DYNAMICS® / TWECO® / VICTOR® ..... 800-426-1888 / FAX 800-535-0557  
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