Thermadyne® is a manufacturer and marketer of some of the most respected brands in the industry. Through our network of distributors, we are proud to serve a diverse group of skilled individuals including:

JUSTIN “RED” WEIRICH Willerdng Metal Fabrication [O’Fallon, MO]
Justin specializes in TIG aluminum, but is an expert in MIG. Thermal Dynamics®, Tweco® and Victor® help him do things that other people only wish they could do.

LIEUTENANT JAMES C. STANFIELD Palm Beach Fire Rescue [Palm Beach, FL]
Lt. Stanfield is a technical rescue officer for the Palm Beach Fire Rescue team. To help them prepare for any type of emergency, they recently added a Thermal Dynamics portable plasma cutting system to their Special Operations Truck.

TERESA MAXEY Maximum Welding [Sioux City, IA]
Teresa is a decorative artist and a businesswoman. She has incredible influence on young woman who take up welding. She encourages people not to fear being adventurous with their work.

JEFFREY STEWART Instructor/Consultant Technical Welding Services, Inc. [Dryden, Michigan]
Jeff excelled in welding and represented the state of Michigan in the SkillsUSA Championships in 1981. He won 3 state welding medals, 2 regional gold medals and 1 silver national medal, launching his welding career.

ROBERT RUSH Millcraft SMS Services [Washington, PA]
Robert Rush learned welding on the job, and has been doing it everyday for the past 30 years. He is part of a team that repairs equipment for steel mills keeping these companies operational and in business.

TOM HEEGER President, Acme Erectors [St. Louis, MO]
Welding has been good to Tom. After years of being a welder, he became an owner by purchasing Acme Erectors in 1995 and grew it from a three-person shop to a large diversified corporation.

BROTHER MELVIN MEYER, S.M. Artist-in-Residence Marianist Galleries [St. Louis, MO]
Brother Mel has been welding metal into art for nearly 50 years. He first started welding when someone just gave him a torch. He soon discovered that welding was in his blood. From there, he moved quickly into the big welders and cutters.

BILL MOORE Ironworkers Local 396 [O’Fallon, MO]
Bill’s dad was an ironworker. He taught Bill how to weld when he was 15. Today, Bill applies his craft at Weaver Steel and has contributed to building significant landmarks, sports venues and public arenas.

TIMOTHY MULLALY Ironworker Local 361 [New York City, NY]
He chose to pursue a career as an ironworker because he likes working on the big visible projects. He works for one of the world’s leading construction groups. They restore and build notable landmarks in New York.
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.
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This catalog is provided as a starting point and overview for Thermadyne distributors and end-users. We hope this catalog will be helpful but we understand that the information in any printed catalog will be somewhat static. Because greater numbers of people look to the internet for current information about our brands and products, we have made significant improvements to our website. Changes have been straightforward and always with our customers in mind.

Our website features:

- Quality graphic design with a friendly, inviting appearance.
- Integrated campaigns, news, promotions and marketing materials.
- Each individual brand within the website has similar feel in design and navigation, but each brand has colors schemes, banners and graphic elements that makes them unique and distinct.
- Intuitive navigation system that allows new sections and pages to be added and changed as updated information is required.
- Enhanced ability to locate and compare product offerings.
- Improved functionality and usefulness for distributors of MY THERMADYNE, the password protected and secure area of the site.

The web is an interactive resource and, for that reason, we will always be looking for ways to improve it. We encourage you to visit our website often for the latest product and brand information available.

Look for the keyword search tips in each section of this catalog and a keyword search index on the next page to help you find the products and information you seek on our website at www.thermadyne.com.

**THERMADYNE Website Search Tip** – If you do not know the exact name or part number of the product you are looking for, try to use a wildcard search using an asterisk. Example: cutmaster* or victor*
**Keyword Search Index**

To help in searching our new Thermadyne® website, here are some keywords sorted by brand:
(Note: * Denotes a Wildcard search and is needed to give most comprehensive search results)

### Outfits

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>CutSkill® (Product Name &amp; Number)</th>
<th>FirePower® (Product Name &amp; Number)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Journeyman</td>
<td>CutSkill 450</td>
<td>FirePower 350</td>
</tr>
<tr>
<td>SuperRange</td>
<td>CutSkill 350</td>
<td>FirePower 250</td>
</tr>
<tr>
<td>Cutter Select*</td>
<td>CutSkill 250</td>
<td></td>
</tr>
<tr>
<td>Portable Torch</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Regulators & Flowmeters

<table>
<thead>
<tr>
<th>Professional (Series, Type*)</th>
<th>CutSkill (Series, Type*)</th>
<th>FirePower (Series, Type)</th>
</tr>
</thead>
<tbody>
<tr>
<td>SR 700*</td>
<td>RC 450*</td>
<td>RF 350*</td>
</tr>
<tr>
<td>AF 250*</td>
<td>RC 350*</td>
<td>RF 250*</td>
</tr>
<tr>
<td>HRF 2400*</td>
<td>RC 250*</td>
<td></td>
</tr>
<tr>
<td>SR 4*</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Straight Torches

<table>
<thead>
<tr>
<th>Professional (Name or Model No.)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>ST 2600FC*</td>
<td></td>
<td></td>
</tr>
<tr>
<td>ST 1000FC*</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bulldog*</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Toolsco.

### MIG Guns

<table>
<thead>
<tr>
<th>Professional (Product Name/Part No.)</th>
<th>WeldSkill® (Product Name)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>415116</td>
<td>250 Amp WeldSkill SpliFire</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>350 Amp SprayMaster Smoke Master</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hobby</td>
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</table>

### MIG Consumable Parts

<table>
<thead>
<tr>
<th>Professional (Part No.)</th>
<th>WeldSkill (Part No.)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>1435</td>
<td>WS1435</td>
<td></td>
</tr>
<tr>
<td>52FN</td>
<td>WS52</td>
<td></td>
</tr>
<tr>
<td>24CT</td>
<td>WS24CT</td>
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</table>

### Arcair

### Manual Torches

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>CutSkill (Product Name)</th>
<th>FirePower</th>
</tr>
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<tbody>
<tr>
<td>K3000</td>
<td>CS4000</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>K4000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>K-5*</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tri-Arc*</td>
<td></td>
<td></td>
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### Slice®

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
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<th>FirePower</th>
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<tbody>
<tr>
<td>Utility Pack</td>
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<td>Not Applicable</td>
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<tr>
<td>Industrial Pack</td>
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<td>Battery Pack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Complete Pack</td>
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### Handles & Attachments

<table>
<thead>
<tr>
<th>Professional (Product Name/Part No.)</th>
<th>CutSkill (Product Name/Part No.)</th>
<th>FirePower (Product Name/Part No.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>315FC*</td>
<td>WH 370FC-V</td>
<td>WH 370FC-FS</td>
</tr>
<tr>
<td>8-MFA-1*</td>
<td>WH 270FC-V</td>
<td>WH 270FC-FS</td>
</tr>
<tr>
<td>CA 2460*</td>
<td>CA 370-V</td>
<td>CA 370-FS</td>
</tr>
<tr>
<td>Type 55*</td>
<td>CA 270-V</td>
<td>CA 270-FS</td>
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</table>

### Oxy-Fuel Cutting Tips

<table>
<thead>
<tr>
<th>Professional (Size, Series, Type)</th>
<th>CutSkill (Size, Series, Type -no dashes)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-1-101</td>
<td>CS11011</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>1-3-101</td>
<td>CS31011</td>
<td></td>
</tr>
<tr>
<td>1-GPP</td>
<td>CS6P101</td>
<td></td>
</tr>
<tr>
<td>1-HPN</td>
<td>CSHPN1</td>
<td></td>
</tr>
</tbody>
</table>

### Safety Accessories

<table>
<thead>
<tr>
<th>Professional (Size, Series, Type)</th>
<th>CutSkill (Series, Type)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>CTR*</td>
<td></td>
<td></td>
</tr>
<tr>
<td>CTO</td>
<td></td>
<td></td>
</tr>
<tr>
<td>CTF*</td>
<td></td>
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</table>

### MIG Consumable Parts

### Manual Products

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>WeldSkill</th>
<th>FirePower</th>
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</thead>
<tbody>
<tr>
<td>AS32</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>GC300</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Magnetic Ground Clamp</td>
<td>T120</td>
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</tbody>
</table>

### Conductor Tube

<table>
<thead>
<tr>
<th>Professional (Product Name/Part No.)</th>
<th>WeldSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>MS6360S</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>356060</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Flex*</td>
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### Metal Working Chemicals

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>Protex Original</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Protex Tip Dip</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Protex Clear</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Protex Alclean</td>
<td></td>
<td></td>
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### Under Water Cutting

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sea-Stinger*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Sea Torch*</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Arcwater II*</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### Manual Systems

<table>
<thead>
<tr>
<th>Professional</th>
<th>CutSkill®</th>
<th>FirePower®</th>
</tr>
</thead>
<tbody>
<tr>
<td>CUTMASTER 39</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>CUTMASTER 52</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>CUTMASTER 82</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>AirCut 15C</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>PAK 200</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
</tbody>
</table>

### Automation Systems

<table>
<thead>
<tr>
<th>Professional (Series, Type*)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto-Cut*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Ultra-Cut*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Auto-Cut 200</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Ultra-Cut 200</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
</tbody>
</table>

### Torches (Manual/Automated)

<table>
<thead>
<tr>
<th>Professional (Name or Model No.)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>PCH-10*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>PCH-25*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>1 Torch SL60</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>PCH-51*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>PCM-51*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
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### Consumable Parts (Manual/Automated)

<table>
<thead>
<tr>
<th>Professional (Part No.)</th>
<th>CutSkill</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>9-6501</td>
<td>CS96501</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>9-5751</td>
<td>CS95751</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>9-8215</td>
<td></td>
<td></td>
</tr>
<tr>
<td>20-1010</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Welding Supplies

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>WeldSkill® (Product Name)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>PowerMaster 500*</td>
<td>Fabricator 251</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>ArcMaster 185 ACDC</td>
<td>Dragstar 85</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>ArcMaster 400MST</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Fabstar 4030*</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Build Up & Joining

<table>
<thead>
<tr>
<th>Carbon Steel (Product Name)</th>
<th>Manganese Steel (Product Name)</th>
<th>Mang/Carbon Steels (Product Name)</th>
<th>Cast Iron (Product Name)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Built Up LH</td>
<td>Dynamang*</td>
<td>Stoody 2100</td>
<td>Castweld 55</td>
</tr>
<tr>
<td>Stoody Build Up</td>
<td>Nicromang*</td>
<td>Versalloy Plus</td>
<td>Castweld Ni55-0</td>
</tr>
<tr>
<td>Stoody 104 Thermaclad</td>
<td>Trackwear*</td>
<td>Stoody 110*</td>
<td></td>
</tr>
</tbody>
</table>

### Wire Feeders

<table>
<thead>
<tr>
<th>Professional (Product Name)</th>
<th>WeldSkill (Part No.)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>Portafeed VS 212*</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Hefty II</td>
<td>Not Applicable</td>
<td>Not Applicable</td>
</tr>
<tr>
<td>Ultrafeed VA 4000</td>
<td>Ultrafeed A 2000</td>
<td></td>
</tr>
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</table>

### Consumable Parts (Manual/Automated)

<table>
<thead>
<tr>
<th>Professional (Product Name/Part No.)</th>
<th>WeldSkill (Part No.)</th>
<th>FirePower</th>
</tr>
</thead>
<tbody>
<tr>
<td>Autocraft 70S-6</td>
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<td>Not Applicable</td>
</tr>
</tbody>
</table>

### Metal to Earth (Extreme Abrasion) Tungsten & Vanadium Carbide

<table>
<thead>
<tr>
<th>Electrodes/Rods (Product Name)</th>
<th>Open Arc/Gas Shield (Product Name)</th>
<th>Submerged Arc (Product Name)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stoodite*</td>
<td>Stoodite*</td>
<td>Stoodite*</td>
</tr>
<tr>
<td>Stoodite 6</td>
<td>Stoodite 6</td>
<td>Stoodite 6</td>
</tr>
<tr>
<td>Stoooy 60</td>
<td>Stoodite 6</td>
<td>Stoooy 21</td>
</tr>
<tr>
<td>Stoooy C</td>
<td>Stoooy C</td>
<td>Stoooy C</td>
</tr>
</tbody>
</table>

### Abrasion & Corrosion (Cobalt & Nickel Base)

<table>
<thead>
<tr>
<th>Electrodes/Rods (Product Name)</th>
<th>Open Arc/Gas Shield (Product Name)</th>
<th>Submerged Arc (Product Name)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Self Hardening</td>
<td>Stoooy 965-G</td>
<td>Stoooy 103CP</td>
</tr>
<tr>
<td>Stoooy 77</td>
<td>Stoooy 121</td>
<td>Stoooy 143-S</td>
</tr>
<tr>
<td>Stoooy 35</td>
<td>Stoooy 101HC</td>
<td>Stoooy 145-S</td>
</tr>
<tr>
<td>Stoooy 20</td>
<td>Super 20</td>
<td>Stoooy 103CP</td>
</tr>
</tbody>
</table>

### Metal to Earth

<table>
<thead>
<tr>
<th>Electrodes/Rods (Product Name)</th>
<th>Open Arc/Gas Shield (Product Name)</th>
<th>Submerged Arc (Product Name)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Self Hardening</td>
<td>Stoooy 965-G</td>
<td>Stoooy 103CP</td>
</tr>
<tr>
<td>Stoooy 77</td>
<td>Stoooy 121</td>
<td>Stoooy 143-S</td>
</tr>
<tr>
<td>Stoooy 35</td>
<td>Stoooy 101HC</td>
<td>Stoooy 145-S</td>
</tr>
</tbody>
</table>

### NOTES:
- Not all products contain marketing details. If you wish for us to add an item or items, please notify webadmin@thermadyne.com with the products in question.
- By clicking New Search, you will start your product search over from the beginning.
- To search for a phrase, use quotation marks, i.e. “300 ACDC”.
- Please follow keyword search as shown above. If no space in name, do not add a space. (315FC will give a different result than 315 FC)
Victor Professional Equipment

Victor is committed to providing superior quality, reliable equipment 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

- Stainless steel panel toolbox
- Optimum Safety
  - Built-in reverse flow check valves and flashback arrestors
  - Includes T grade hose for use with any fuel gas
  - Self-resetting relief valve protects regulator
  - Includes color coded gauges

Cutting Attachment

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

Journeyman®

Applications
Capable of welding from 1/32”/.79mm up to 3”/75mm with appropriate welding nozzle and cutting from 1/8”/3mm up to 8”/200mm with appropriate cutting tip.

Journeyman Components

- Heavy Duty CSR450 Series Regulators with Stainless Steel Diaphragms and Gauge Guards
- Heavy Duty H315FC Torch Handle
- CA2460 Cutting Attachment
- Welding Nozzles, Sizes: 1, 3, 5 (see chart for welding capacities)
- MFA Heating Nozzle, Size 8
- Cutting Tip: 1-1-101 (cuts up to 3/4”/19mm)
- 25’ x 1/4” T Grade Multi-fuel Hose, Soft Sided Shade 5 Goggles, Multi-wrench and Tip Cleaner

Contender®

Applications
Capable of welding from 1/32”/.79mm up to 3”/75mm with appropriate welding nozzle and cutting from 1/8”/3mm up to 8”/200mm with appropriate cutting tip.

Contender Components

- Heavy Duty CSR350 Series Regulators with Gauge Guards
- Heavy Duty 315FC Torch Handle
- CA2460 Cutting Attachment
- 6 MFA Heating Nozzle
- Cutting Tip: 1-1-101 (cuts up to 3/4”/19mm)
- 25’ x 1/4” T Grade Multi-fuel Hose and Striker

SuperRange® II

Applications
Capable of welding from 1/32”/.79mm up to 1 1/4”/31mm with appropriate welding nozzle and cutting from 1/8”/3mm up to 6”/150mm with appropriate cutting tip.

SuperRange II Components*

- Heavy Duty CSR350 Series Regulators with Gauge Guards
- Medium Duty 100FC Torch Handle
- CA1350 Cutting Attachment
- W-1 Welding Nozzles, Size: 2 (welds 1/16”/1.5mm to 1/8”/3mm)
- Cutting Tip: 0-3-101 (cuts up to 1/2”/12mm)
- 25’ x 1/4” T Grade Multi-fuel Hose, Soft Sided Shade 5 Goggles, Multi-wrench and Tip Cleaner

* SuperRange II with 6MFA Optional Outfit
Performers Applications
Capable of welding from \(\frac{1}{32”} / 0.79\text{mm}\) up to \(1\frac{1}{4”} / 31\text{mm}\) with appropriate welding nozzle and cutting from \(\frac{1}{4”} / 3\text{mm}\) up to \(6” / 150\text{mm}\) with appropriate cutting tip.

Performers Components
- Medium Duty CSR250 Series
  Regulators with Gauge Guards
- Medium Duty 100FC Torch Handle
- CA1350 Cutting Attachment
- W-1 Welding Nozzles, Size: 0 (welds \(\frac{1}{32”} / 0.8\text{mm}\) to \(\frac{3}{64”} / 2\text{mm}\))
- Cutting Tip: 0-3-101 (cuts up to \(\frac{1}{4”} / 12\text{mm}\))
- 12’ x \(\frac{3}{16”}\) T Grade Multi-fuel Hose, Soft Sided Shade 5 Goggles, Multi-wrench and Tip Cleaner

Journeyman Select Applications
Capable of welding from \(\frac{1}{32”} / 0.79\text{mm}\) up to \(3” / 75\text{mm}\) with appropriate welding nozzle and cutting from \(\frac{3}{64”} / 2\text{mm}\) up to \(8” / 200\text{mm}\) with appropriate cutting tip.

Journeyman Select Components
- Heavy Duty CSR450 Series Regulators
- Heavy Duty 315FC Torch Handle
- CA2460 Cutting Attachment
- Cutting Nozzle, Size 8 Type 55 (cuts up to \(3/4” / 19\text{mm}\))
- 25’ x \(\frac{3}{16”}\) T Grade Multi-fuel Hose, Goggles and Multi-wrench

Portable Torch Applications
Capable of welding from \(\frac{1}{32”} / 0.79\text{mm}\) up to \(1\frac{1}{4”} / 31\text{mm}\) with appropriate welding nozzle and cutting from \(\frac{1}{4”} / 3\text{mm}\) up to \(4” / 100\text{mm}\) with appropriate cutting tip.

Portable Torch Components
- 150 Series Regulators with Color-coded Gauges
- Medium Duty 100FC Torch Handle
- CA1350 Cutting Attachment
- W-1 Welding Nozzles, Sizes: 1 (welds \(\frac{3}{64”} / 2\text{mm}\) to \(\frac{1}{32”} / 0.8\text{mm}\))
- Cutting Tip: 0-3-101 (cuts up to \(\frac{1}{4”} / 12\text{mm}\))
- Includes 10’ x \(\frac{3}{16”}\) T Grade Hose, Goggles and Lighter
- Cylinders Optional
- Built-in Reverse Flow Check Valves and Flashback Arrestors
- Cutting Attachment Operates with Any Fuel Gas

* Requires sufficient acetylene & oxygen supply

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.

See our full line catalog or visit us on the web at www.victorequip.com for more information.

Victor Professional & Heavy Industry Gas Equipment Catalog
(Form No. 65-2007)
## Ordering Information

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Torch Handle</th>
<th>Welding Nozzle</th>
<th>Cutting Attachment</th>
<th>Cutting Tip</th>
<th>Heating Nozzle</th>
<th>Oxygen Regulators</th>
<th>Fuel Gas Regulator</th>
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### Journeyman AF (Alternate Fuel)

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<th>Welding Nozzle</th>
<th>Cutting Attachment</th>
<th>Cutting Tip</th>
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### Portable Torch™ Kit

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### Journeyman Select

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### Cutter Select™

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Gas Equipment

Victor Professional Regulators / Flowmeters

Professional Series REGULATOR Standard Features
- A wide variety of delivery ranges and gases.
- Meets third party listing that conforms to CGA E-4.

700 Series
Single & Two Stage Cylinder Type Regulators
- High Volume Heavy Duty
- Forged Brass Body
- 2½" Brass Gauges
- Delrin Bushing
- Stainless Steel Diaphragm
- ½" Outlet Connection

450 Series
Single & Two Stage Cylinder Type Regulators
- Heavy Duty
- Forged Brass Body and Housing Cap
- 2½" Brass Gauges
- Delrin Bushing
- Stainless Steel Diaphragm
- Optional Gauge Guards and Colored Gauges

350 Series
Single & Two Stage Cylinder Type Regulators
- Heavy / Medium Duty
- Forged Brass Body and Housing Cap
- 2½" Brass Gauges
- Delrin Bushing
- Stainless Steel Diaphragm
- Optional Gauge Guards and Colored Gauges

250 Series
Single & Two Stage Cylinder Type Regulators
- Medium Duty
- Forged Brass Body and Housing Cap
- 2" Brass Gauges
- Delrin Bushing
- Optional Gauge Guards and Colored Gauges

AF 250 / CF 253
Flowgauge Regulators
- Medium Duty
- Forged Brass Body and Housing Cap
- 2" Brass Gauges
- Delrin Bushing
- Sintered Inlet Filter
- 1½" Diaphragm

S 700 / S 350 / S 250
High Volume Station Regulators
- Heavy Duty (S 700), Medium/Heavy Duty (S 350) and Light Duty (S 250)
- Forged Brass Body and Housing Cap
- Maximum Inlet Pressure: 200 PSIG
- Delrin Bushing

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 22 for ordering information on available gauge guards.

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

DFM Dual Flow
Dual Flow Regulator Flowmeter
- Designed to Monitor Two (2) Separate Processes of Gas Flow
- Brass Body
- Teflon Seat
- Sintered Inlet Filter
- Lexan Cover Tubes
- Brass Piston
- Aluminum Ball (Flowmeter Version)

SR 4
Single Stage Piston Style Regulator
- High Pressure Delivery
50 to 4500 PSI
- Machined Body and Cap
- 2¼" Gauges
- Delrin Bushing

International Customer Care:  905-827-9777  /  FAX 905-827-9797
www.victorequip.com
Gas Equipment

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.

H315FC / 315FC
Heavy Duty Torch Handles
- The CA 2460 series cutting attachment is performance matched to both the H315FC and 315FC torch handle.
- H315FC is a high flow torch handle.

100FC
Medium Duty Torch Handle
- The 1350 series cutting attachment is performance matched to the 100FC torch handle.

HD310C
Victor Heavy Industry Torch Handle
- The HD310C is compatible with high capacity heating nozzles and is performance matched to the CA 2460 series cutting attachment.

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 2460 series cutting attachment is performance matched for use with H315FC and the 315FC torch handle.
Head Angles: 90°, 75°, 180°
Cutting Range: 8”/200mm

CA 1350 Series
Medium Duty Cutting Attachment
The 1350 series cutting attachment is performance matched for use with the 100FC torch handle.
Head Angles: 90°, 75°, 180°
Cutting Range: 6”/150mm

Victor Professional Nozzles

Professional Series HEATING / WELDING NOZZLE Standard Features
- Available in a wide variety of sizes.

Type MFA (Acetylene)
Heavy Duty Heating Nozzle
Multi-flame heating head for heat treating, straightening & priming.

Type MFA-1 (Acetylene)
Medium Duty Heating Nozzle
Multi-flame heating head for heat treating, straightening & priming.

Type MFN (Propane / Natural Gas)
Heavy Duty Heating Nozzle
Multi-flame heating head for heat trimming, straightening & priming. Use with HD310C torch handle and ¼” hose.

Type 55 (All Alternate Fuel Gases)
Heavy Duty Heating Nozzle
Multi-flame heating head for heat trimming, straightening & priming. Use with HD310C torch handle and ¼” hose.

Type W (Acetylene)
Heavy Duty Heating Nozzle
General purpose welding & pre-heating.

Type W-1 (Acetylene)
Medium Duty Heating Nozzle
General purpose welding & pre-heating.
Victor Professional Straight Cutting Torches

ST 2600FC
Straight Cutting Torch
- Uses Series 1 Cutting Tips

OPTIONS
Head Angles: 90°, 75°, 180°
Torch Lengths: 17”, 21”, 36”, 48”, 72”
Cutting Capacity: 8”/200mm

ST 1000FC
Straight Cutting Torch
- Uses Series 1 Cutting Tips

OPTIONS
Head Angles: 90°, 75°, 180°
Torch Lengths: 17”, 21”, 36”, 48”
Cutting Capacity: 5”/125mm

ST 900FC
Straight Cutting Torch
- Uses Series 1 Cutting Tips

OPTIONS
Head Angles: 90°, 75°, 180°
Torch Lengths: 17”, 21”, 36”, 48”
Cutting Capacity: 5”/125mm

Straight Cutting Torch Users Guide

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<th>Gas Type</th>
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<td>ST2600FC</td>
<td>Multi-Fuel</td>
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<td>HC1100C</td>
<td>Propane/Natural Gas</td>
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<td>HC1500C</td>
<td>Propane/Natural Gas</td>
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*with optional tips.

Victor Heavy Industry Straight Cutting Torches

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”/457mm
- Use of High Flow Flashback Arrestors is Recommended
- Best for High Flow Applications
- 2-tube Design

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”/762mm
- Use of High Flow Flashback Arrestors is Recommended
- Use Accessory Reverse Flow Check Valves
- 2-tube Heavy Duty Design
- Ideal for Mill and Foundry Applications
- Use Genuine Victor HDNL Series Cutting Tips
- Lock Down Lever; ¼”-14 RH Oxygen Inlet

HC 1100C
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: 14”/355mm
- Use of High Flow Flashback Arrestors Recommended
- Torch will operate at any fuel gas pressure of 4 ounces and above
- Use Genuine 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

The high capacity HEAVY INDUSTRY straight cutting torches in the right hand column of this page are designed for heavy cutting applications found in such industries as scrapping, demolition and foundries.

Although built to Victor’s quality and safety standards, due to the cutting capacity and/or design of each torch, flashback arrestors are not manufactured into these Victor Heavy Industry Torches.

To reduce the risk of personal injury, death and/or property damage, use sufficient capacity flashback arrestors with all Victor Heavy Industry Torch Products. Alternative fuel gas only refers to Propane, Natural Gas and Propylene Gases. Acetylene, Hydrogen and Gasoline are NOT included as an alternative gas.
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 high performance “straight through” design that minimizes turbulence and improves cut quality. Accessory reverse flow check valves are supplied for use at the torches inlet connection.

**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: 8½", 14"
- Cutting Capacity: 7⁄8"/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", 22½"
- Cutting Capacity: 12"/305mm

*Gear racks sold separately.

**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" from the Machine
- Speed Constant Over Wide Range of Temperatures
- Torch Holder Designed for 1¼"/35mm Barrel Diameter Torches

**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 1½"/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
- 11 Teeth per Inch
To Most, It’s A Word.
To Others, It’s A Statistic.
To Us, It’s Personal.

NOT JUST SAFE. VICTOR SAFE.
Victor CutSkill® Equipment
Victor manufactures CutSkill products for the frequent user.
Victor CutSkill, quality products at an affordable price.

CutSkill 450
Applications
Capable of welding from \(\frac{1}{32}\)/.79mm up to 3”/75mm with appropriate welding nozzle and cutting from \(\frac{1}{8}\)/3mm up to 8”/200mm with appropriate cutting tip.

Components
- RC 450 Series Regulators
- WH370FC-V Torch Handle
- CA 370-V Cutting Attachment
- 2-UM Welding Nozzle (welds up to \(\frac{1}{4}\)/3mm)
- Series 1 Cutting Tip (cuts up to \(\frac{1}{4}\)/19mm)
- 25’ x \(\frac{1}{4}\)” RM Grade Hose

CutSkill 350
Applications
Capable of welding from \(\frac{1}{32}\)/.79mm up to 3”/75mm with appropriate welding nozzle and cutting from \(\frac{1}{8}\)/3mm up to 8”/200mm with appropriate cutting tip.

Components
- RC 350 Series Regulators
- WH370FC-V Torch Handle
- CA 370-V Cutting Attachment
- 2-UM Welding Nozzle (welds up to \(\frac{1}{4}\)/3mm)
- Series 1 Cutting Tip (cuts up to \(\frac{1}{4}\)/19mm)
- 25’ x \(\frac{1}{4}\)” RM Grade Hose

CutSkill 250
Applications
Capable of welding from \(\frac{1}{32}\)/.79mm up to 1¼”/31mm with appropriate welding nozzle and cutting from \(\frac{1}{8}\)/3mm up to 6”/150mm with appropriate cutting tip.

Components
- RC 250 Series Regulators
- WH270FC-V Torch Handle
- CA 270-V Cutting Attachment
- 0-UM-1 Welding Nozzle (welds up to \(\frac{5}{64}\)/1.9mm)
- Series 3 Cutting Tip (cuts up to \(\frac{1}{2}\)/12mm)
- 20’ x \(\frac{3}{16}\)” RM Grade Hose

CutSkill Portable Tote
Applications
Capable of welding from \(\frac{1}{32}\)/.79mm up to 1¼”/31mm with appropriate welding nozzle and cutting from \(\frac{1}{8}\)/3mm up to 4”/100mm with appropriate cutting tip.

Components
- Rugged Patented Design Molded Plastic Carrying Case
- Built-in Flashback Arrestors and Check Valves
- SR150 CR Regulator
- SR160 AR Regulator
- WH270FC-V Welding Torch
- CA 270-V Cutting Attachment
- 2-UM-1 Welding Nozzle (welds up to \(\frac{5}{64}\)/1.9mm)
- 0-3-101 Cutting Tip (cuts up to \(\frac{1}{2}\)/12mm)
- 12’-\(\frac{3}{8}\)” x \(\frac{3}{16}\)” Twin RM Grade Hose

Optional
- 10 Cu. ft. CGA 200 Acetylene Cylinder
- 20 Cu. ft. CGA 540 Oxygen Cylinder

See our full line catalog or visit us on the web at www.victorequip.com for more information.

Victor CutSkill & FirePower
Gas Equipment Catalog (Form No. 70-2701)
CutSkill Series REGULATOR / FLOWMETER Standard Features
- A Wide Variety of Delivery Ranges and Gases
- Two Year Warranty
- Listed/Conforms to CGA E-4

RC 450 Series
Single Stage Cylinder Type Regulator
- Heavy Duty
- Forged Brass Body & Housing Cap
- Stem Type Seat Mechanism
- Stainless Steel Diaphragm
- Maximum Inlet Pressure: 3000 PSIG/34 BAR
- 9/16” x 18 Outlet Connection
- Internal Relief
- 2½” Gauges

RC 350 Series
Single Stage Cylinder Type Regulator
- Heavy/Medium Duty
- 2½” Gauges
- Delrin Bushing
- Neoprene Diaphragm

RC 250 Series
Single Stage Cylinder Type Regulator
- Medium Duty
- 2” Gauges
- Delrin Bushing
- Neoprene Diaphragm

1400 Series
HRF Flowmeter
- Single Stage Piston Design
- Argon, Argon/CO₂ Mix & CO₂ Models
- Maximum Inlet Pressure: 3000 PSIG/204 BAR
- 25 PSIG/1.7BAR or 80 PSIG/5.4BAR
  Pre-set Pressure
- Up to 50 CFH/24 LPM for Argon and up to 30 CFH/18 LPM for CO₂ Delivery
- Available in CGA 320 & 580
  Inlet Connections
- Option MIG Kit Available with 10’ Hose

Design/Construction
- Machined Brass Body
- Teflon Seat
- 5/8”-18 RH(F) Outlet Connection Except When Noted
- 1/2”/38cm PSIG/KPA Gauges Except When Noted

TPR Purging Regulator
Single Stage Purging Regulator
- Forged Brass Body & Housing Cap
- Stem Type Seat Mechanism
- Neoprene Diaphragm
- Maximum Inlet Pressure: 3000 PSIG/204 BAR

150 Series “T” Handle
Single Stage T Handle Regulator
- Forged Brass Body & Housing Cap
- Stem Type Seat Mechanism
- Neoprene Diaphragm
- Maximum Inlet Pressure: 3000 PSIG/204 BAR
- Available in CGA 540 & 510
  Inlet Connections
- 5/8”-18 Outlet Connection

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
- Heavy Duty
  WH 370FC-V
- Medium Duty
  WH 270FC-V

CutSkill Cutting Attachments
- Heavy Duty
  CA 370-V
- Medium Duty
  CA 270-V

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

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

Victor FirePower Outfits

FirePower 350

Applications
Capable of welding from ⅛"/0.79mm up to 1/4"/31mm with appropriate welding nozzle and cutting from ⅛"/3mm up to ⅝"/150mm with appropriate cutting tip.

Components
- RF 350 Heavy/Medium Duty Regulators
- WH350FC-FS Torch Handle with Built-in Flashback Arrestors and Check Valves
- CA350-FS Cutting Attachment
- 2-UM Welding Nozzle (up to ⅛"/3mm)
- Series 1 Cutting Tip (up to ⅝"/19mm)
- 25' x ⅛" R Grade Hose
- Includes Striker and Goggles

FirePower 250

Applications
Capable of welding from ⅛"/0.79mm up to 1/4"/31mm with appropriate welding nozzle and cutting from ⅛"/3mm up to ⅝"/150mm with appropriate cutting tip.

Components
- RF 250 Medium Duty Regulators
- WH270FC-FS Torch Handle with Built-in Flashback Arrestors and Check Valves
- CA250-FS Cutting Attachment
- 0-UM Welding Nozzle (up to ⅛"/3mm)
- Series 3 Cutting Tip (up to ⅝"/12mm)
- 20' x ⅛" R Grade Hose
- Includes 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

RF 250 Series

Single Stage Cylinder Type Regulator
- Medium Duty
- Forged Brass Body
- Stem Type Seat Mechanism
- Neoprene Diaphragm
- Internal Relief

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
- ⅜" x 18 Hose Connections
- Stainless Steel Ball Valves

FirePower Cutting Attachments

Features
- 90° Head
- Universal Mixer
- Triangular Tube Design
- Stainless Steel Cutting Oxygen Lever and Ball Valve

U.S. Customer Care: 800-426-1888 / FAX 800-535-0557
Canada Customer Care: 905-827-4515 / FAX 800-588-1714
BUCKET IS FOURTH GENERATION IN THE COMPANY HIS FAMILY STARTED IN 1898. He learned to weld from his father and uncle, and from just being around the business. His first job at Tremmel Construction was sweeping floors at age 10.

The company specializes in welding specialty metals such as brass, aluminum, copper, polished stainless steel and sheet metal. “Brass is very tricky,” Burt explains. “It doesn’t like to weld very well. But I know how to weld it, and I teach the other employees how to do it.”

BUCKET HAS A DEGREE IN DRAFTING AND DESIGN, and does all of the mechanical drawings for their welding projects, along with the day-to-day running of the business.

“WE LOST EVERYTHING IN KATRINA.”

Hurricane Katrina completely destroyed the shop. All equipment, paperwork, even photos dating back 100 years – gone.

But the one thing he and his co-workers didn’t lose – their skills. So with a keep on truckin’ attitude they are back in business with new equipment from THERMAL DYNAMICS, VICTOR, TWECO and ARCAIR.

BUCKET TREMMEL, JR.
President
Tremmel Construction Specialties, L.L.C.
Biloxi, MS

Burt carries the torch – will you?

THERMODYNE, 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, Stoody, CIGWELD and TurboTorch are among the Thermadyne family of brands that you can count on for safety, reliability and quality.

www.thermadyne.com
Gas Equipment Accessories

VICTOR Website Keyword Search Tip – In addition to the product name and part number, you can search using keywords such as tip size: 1-101. (See Index on pages 6-7 for more info.)

**Acetylene**

**One Piece**
- **Series 1 Type 101**
  - Hand & machine torch cutting.

**One Piece**
- **Series 3 Type 101**
  - Hand cutting.
  - (Series 3 for small cutting head)

**One Piece**
- **Series 3 Type 101**
  - Hand cutting & machine torch cutting. 30° angle with torch perpendicular.

**One Piece**
- **Series 1 Type 101L**
  - Extra length 18" tip.

**One Piece**
- **Series 1 Type 108**
  - Boiler tube removal. Short tip to insert inside tube or confined area.

**One Piece**
- **Series 1 Type 100**
  - Drag tip for clean metal. Plate cutting and trimming.

**One Piece**
- **Series 3 Type 100**
  - Drag tip for clean metal. Plate cutting and trimming. (Series 3 for small cutting head)

**One Piece Bent**
- **Series 1 Type 112**
  - Cutting close to bulkheads, hand cutting of internal treads. 45° angle with torch perpendicular.

**One Piece Bent**
- **Series 3 Type 118**
  - Desamening, gouging, weld preparation, removing defective welds, rivet washing.

**One Piece Bent**
- **Series 3 Type 118**
  - Desamening, gouging, weld preparation, removing defective welds, rivet washing. (Series 3 for small cutting head)

**Propylene**

**One Piece**
- **Series 1 Type 303MP**
  - Hand & machine torch cutting.

**Two Piece**
- **Series 1 Type GPP**
  - Hand & machine torch cutting.

**Two Piece**
- **Series 3 Type GPP**
  - Hand cutting. (Series 3 for small cutting head)

**Two Piece**
- **Series 1 Type HPP**
  - Heavy pre-heat for scrap, bevel and other heavy pre-heat requirements.

**One Piece Bent**
- **Series 1 Type 318MP**
  - Desamening, gouging, weld preparation, removing defective welds, rivet washing.

**Two Piece**
- **Series 1 Type BTMP**
  - High performance bevel tip for use with mild steel, HSLA, T-1, HY-80.

**Propane & Natural Gas**

**One Piece**
- **Series 1 Type 200**
  - Hand & machine torch cutting.

**One Piece**
- **Series 1 Type 200L**
  - Extra length 18” tip.

**Two Piece**
- **Series 1 Type GPN**
  - Hand & machine torch cutting.

**Two Piece**
- **Series 3 Type GPN**
  - Hand torch cutting. (Series 3 for small cutting head)

**One Piece**
- **Series 1 Type HDN**
  - Mill and foundry, scrap cutting under severe conditions.

**One Piece**
- **Series 1 Type HDNL**
  - Extra length. Mill and foundry, scrap cutting under severe conditions.

**One Piece**
- **Series 1 Type MCN**
  - Coarse spline for extra heavy pre-heat and wide kerf for demolition, ripping and rail car repair.

**Two Piece**
- **Series 1 Type CSN**
  - Coarse spline for scrap cutting.

**Two Piece**
- **Series 1 Type HPN**
  - Heavy pre-heat for scrap, bevel and other heavy pre-heat requirements.

**Two Piece**
- **Series 1 Type HWN**
  - Heavy wall shell for extra heavy pre-heat applications.

**One Piece**
- **Series 1 Type 207**
  - Tivet washing.

**One Piece**
- **Series 1 Type 218**
  - Desamening, gouging, weld preparation, removing defective welds, rivet washing.

**One Piece**
- **Series 1 Type 234**
  - Scarfing, gouging, weld preparation, removing defective rivets.

**One Piece Bent**
- **Series 1 Type 244**
  - Cutting close to bulkheads, rivet washing.

**Two Piece**
- **Series 2 Type 265N**
  - Heavy industry cutting.

**Two Piece Bent**
- **Series 1 Type GTB**
  - High performance gouging tip.

**Two Piece**
- **Series 1 Type BTN**
  - High performance bevel tip for use with mild steel, HSLA, T-1, HY-80.

**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.

U.S. Customer Care: 800-426-1888 / FAX 800-535-0557
Canada Customer Care: 905-827-4515 / FAX 800-588-1714
### Gas Equipment Accessories

#### Acetylene

**Tip Cutting Charts**

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### Propylene

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### Propane & Natural Gas

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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 Pak for Torch (Oxygen & Fuel) Flashback Arrestors
- FB-O (Oxygen) Torch Flashback Arrestor
- FB-F (Fuel) Torch Flashback Arrestor

**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

**Regulator Models**

- FB-OR Regulator Flashback Arrestor (Oxygen)
- FB-FR Regulator Flashback Arrestor (Fuel)

**Vanguard™ Replacement Cartridge**

**For Flashback Arrestors**

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

**Replacement Cartridge Models**

- 0657-0036 Pair Pak for use with 315FC, 100FC, and CST 800 FC Torch Handles
- 0656-0046 Pair Pak for use with ST2600FC, ST1000FC, ST900FC
- H315FC – 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 Pak Kwik-Connect (Oxygen and Fuel)

**Regulator Design & Construction Features**
- Single Stage Regulators:
  - Provide adjustable flow control
  - Suitable for light-duty applications

**FlameBuster Plus Flashback Arrester**
- 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-0 Torch Flashback Arrester w/ Kwik-Connect (Oxygen)
- FBP-F Torch Flashback Arrester w/ Kwik-Connect (Fuel)
- FBP-1 Pair Pak Torch Flashback Arrestors w/ Kwik-Connect (Oxygen and Fuel)

**Regulator Models**
- FBP-OR Not Shown Regulator Flashback Arrester w/ Kwik-Connect (Oxygen)
- FBP-FR Not Shown Regulator Flashback Arrester w/ Kwik-Connect (Fuel)
- FBPFR-1 Pair Pak – Not Shown Regulator Flashback Arrestors w/ Kwik-Connect (Oxygen and Fuel)

Don’t Leave Safety to Chance!
Insist on using torches with built-in Flashback Arrestors and Check Valves.

International Customer Care: 905-827-9777 / FAX 905-827-9797
www.victorequip.com
# Victor Equipment Reference Guide

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*HD310C – not included in any outfit. built-in flashback arrestors not included.
### Industrial Regulator Matrix

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* Denotes Delivery Availability
Victor Specialty Products
Proven service to specialty gas and manifold markets for over 92 years.

SG500 Series
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.

HP500 Series
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.

GP270 Series
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.

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.

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.

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 for more information.
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.

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.

**Configurator**

Victor Specialty Products has recently implemented a dramatic improvement in the way that HP&I are ordered with the introduction of a product configurator. The new approach eliminates the need for the 8-digit part numbers that we previously used. The part number is now derived from a configured string that completely describes the regulator. The configured string has always been part of the description and that will not change. The configured string, derived from our part number matrix will simply become the part number. This will dramatically improve delivery and simplify order processing.

When a customer needs a special regulator, the configurator provides a means create a bill of materials and instantly provide pricing and availability.
Medical Gas Equipment

Victor Medical

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

O2n Demand IV Conserver

The O2n 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 conserving device on the market, making it less irritating to the patient. With a conserving ratio of up to 6:1 the O2n 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.

O2n Demand V Conserver

The O2n Demand V is a demand style dual cannula conserving device 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 its 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 O2n Demand V is suitable for a broad range of patients. The lighter weight (13.6 OZ.) and smaller size (4 3/4" long) of the O2n Demand V will cause less fatigue and the 4:1 conserving ratio allows longer cylinder life than other comparable conserving devices.

Slmlite II® Series

The SLMLITE 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.

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.

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® 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™ to minimize breakage.

• Large numerals for adjustment ease

• Lexan™ inner and outer tubes avoid breakage

• Calibrated at 50 PSIG inlet pressure

VM Series Manifold

The VM2100 (High Pressure) and VM1100 (Liquid Cylinder) manifolds are truly the most versatile medical gas manifolds available. The high flow capacity and ease of operation make the VM manifolds the choice for Hospitals, Surgical Centers, Urgent Care Facilities and Veterinary Hospitals. These fully automatic systems come 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. The VM2100 & VM1100 Series manifolds meet all requirements of NFPA99.

See our full line catalog (Form No. 68-9902) or visit us on the web at www.victormed.com for more information.
WORLD WIDE WELDER

From Africa to the Eiffel Tower to the Mississippi River — Sow Ibrahima’s twenty years as a welder has been a global adventure.

Sow learned how to weld at his father’s company. That was over 20 years ago in Senegal, a small country on the African continent. Ever since, he has done welding around the globe.

He spent 15 years welding in the Italian countryside. His job even brought him to France’s Eiffel Tower where he applied his craft.

Today Sow works in the U.S. at Cash’s Scrap Metal where he cuts big river barges into scrap for recycling. Cash’s has been featured twice on the Discovery Channel’s Dirty Jobs.

Sow is a welding specialist with a fierce passion for the job. His boss said he loves welding so much, he must be told to leave at the end of his shift. “I want to be busy all the time. A hardworking environment is the best way to keep my skills growing,” he says with pride.

WELDING IS A DANGEROUS JOB. SOW USES VICTOR TORCHES AND EQUIPMENT TO SHARPEN HIS SKILLS, STAY SAFE, AND CONTINUE HIS DYNAMIC CAREER.

SOW IBRAHIMA
Scrap Metal and Iron Worker

Sow carries the torch – will you?

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, Stoody, Cigweld and TurboTorch are among the Thermadyne family of brands that you can count on for safety, reliability and quality.

www.thermadyne.com
**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

**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

---

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

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**KEY APPLICATIONS**

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<th>REFRIGERATION</th>
<th>MAINTENANCE AND REPAIR</th>
<th>PLUMBING</th>
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**MODEL**  | **TX-500**  | **TX-503**  | **TX-504**  | **STK-99**  | **PL-3A**  | **PL-5A**  | **PL-8A**  | **PL-12A**  | **T-504**  | **T-503** 

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

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**VIPER™**

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**U.S. Customer Care:** 800-238-0282 / FAX 800-535-0557

**Canada Customer Care:** 905-827-4515 / FAX 800-588-1714
See our full line catalog (Form No. 56-1252) or visit us on the web at www.turbotorch.com for more information.

**Swirl Air Acetylene Kits & Tips**

- **X-3B** (0386-0335) Flexible kit brazes light medium gauge steel.
- **X-5B** (0386-0338) Flexible lighter duty kit.
- **A-3** (0386-0101) PL-5ADLX-MC KIT (0386-0832)
- **PL-8ADLX-MC KIT** (0386-0834)
- **PL-12ADLX-B KIT** (0386-0836)

**Manual Lighting Torches & Tips**

- **STK-1** (0386-0408) Manual Lighting Hand Torch
- **STK-9** (0386-0403) Manual Lighting Hand Torch
- **STK-11** (0386-1283) Manual Lighting Hand Torch
- **ST-3 EXTREME** (0386-0171) Size 3 Hand Torch Tip
- **ST-3 EXTREME** (0386-0170) Size 1 Hand Torch Tip
- **ST-11 EXTREME** (0386-1282) Double Barrel Hand Torch Tip

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- **STK-1** Air Acetylene: 1½" - 3" 2" - 3½ ¾" - 1½ 1" - 2" 2" - 3½ 1½" - ¾ ¾" - 2½ ¼" - ¼ ½" - ½ 3½" - ¾ ½" - ¼ ¾" - ¾ ½" - ½ ¼" - ½ ¼" - ¼
TurboTorch by VICTOR

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<td>Cut</td>
<td>3/4”</td>
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<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
<td>1/8” - 7/8”</td>
<td>1/8” - 7/8”</td>
<td>3/16” - 3/4”</td>
<td>3/16” - 3/4”</td>
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<tr>
<td>Brass/Weld</td>
<td>5/64” - 2 5/16”</td>
<td>5/64” - 2 5/16”</td>
<td>5/64” - 2 5/16”</td>
<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
<td>1/4” - 1/2”</td>
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<td>1/8” - 7/8”</td>
<td>3/16” - 3/4”</td>
<td>3/16” - 3/4”</td>
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</tr>
</tbody>
</table>

- **Built-in Flashback Arrestors** (certain models) Patent #5407348
- **Patented Balance Design**
- **Ergonomic Carry Handle**
- **Built-in Storage Compartments**
- **Check Valves Included for Safety**
- **Small Footprint**
- **Ergonomic Carry Handle**
- **Removable Storage Compartment**
- **Tanks and Torch Storage**
- **Built-in Flashback Arrestors (certain models) Patent #5407348**
- **Patented Balance Design**
- **Ergonomic Carry Handle**
- **Built-in Storage Compartments**
- **Check Valves Included for Safety**
- **Small Footprint**
- **Ergonomic Carry Handle**
- **Removable Storage Compartment**
- **Tanks and Torch Storage**
- Cuts up to 3/4” (3” with optional tips) in kits equipped with cutting
- Welds up to 1/4” (1/4” with optional tips) in kits equipped with welding

**HVAC/R and Plumbing Air-Fuel Brazing & Soldering Equipment**

Air Fuel Equipment

HVAC/R and Plumbing Air-Fuel Brazing & Soldering Equipment

TurboTorch by VICTOR

Check Valves Included for Safety

Built-in Flashback Arrestors (certain models) Patent #5407348

Patented Balance Design

Ergonomic Carry Handle

Built-in Storage Compartments

Check Valves Included for Safety

Small Footprint

TurboTorch by VICTOR

Built-in Flashback Arrestors (certain models) Patent #5407348

Patented Balance Design

Ergonomic Carry Handle

Built-in Storage Compartments

Check Valves Included for Safety

Small Footprint

TurboTorch by VICTOR

Built-in Flashback Arrestors (certain models) Patent #5407348

Patented Balance Design

Ergonomic Carry Handle

Built-in Storage Compartments

Check Valves Included for Safety

Small Footprint
Tweco Arc Welding Accessories

Tweco, a brand of St. Louis-based Thermadyne Industries Inc., is the world’s largest supplier of welding and cutting products. 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.

Smoke Master® MIG Guns

250 & 450 AMP AIR-COOLED
60% Duty Cycle, CO₂ Gas

- Efficiently Removes up to 90% of Smoke from the Welding Zone
- Features Tweco Eliminator® Style Consumable Parts
- Tough Outer Jacket Made of Full Length Leather for Increased Flexibility and Enhanced Cable Life
- Cleaner, More Efficient Smoke Removal

Smoke Master FUME REMOVAL SYSTEM

- Compatible with Tweco Smoke Master MIG Guns
- Efficiently Removes Welding Fumes
- High Efficiency Filter
- Separately Air-cooled Motor
- Automatic Start-Stop Function Standard
- 120V / 60 Hz.

Check out pages 34-35 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 for more information.
## MIG Guns

### Arc Welding Equipment and Accessories

<table>
<thead>
<tr>
<th>Mini</th>
<th>#1</th>
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<td><strong>Options / Features</strong></td>
<td>• Knucklehead™</td>
<td>• quick change</td>
<td>• metal jacketed conductor tube</td>
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<td></td>
<td>• swivel conductor tube</td>
<td>• Knucklehead™</td>
</tr>
<tr>
<td></td>
<td></td>
<td>• Knucklehead™</td>
<td>• metal jacketed conductor tube</td>
</tr>
<tr>
<td></td>
<td></td>
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<td><strong>Tip Series</strong></td>
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<td><strong>Diffuser Series</strong></td>
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<td>51 series</td>
<td>52 series</td>
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<td>none (self insulated nozzle)</td>
<td>none (self insulated nozzle)</td>
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<tr>
<td><strong>Conductor Tube Series</strong></td>
<td>35-60, 45 &amp; 60°</td>
<td>61 series 45 &amp; 60°</td>
<td>62J series 45 &amp; 60°</td>
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<tr>
<td><strong>Liner Series</strong></td>
<td>40 series</td>
<td>42 series</td>
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## Tweco. WeldSkill.

<table>
<thead>
<tr>
<th>WS150</th>
<th>WS250</th>
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<th>SpitFire® 180</th>
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<td>WS 21-50</td>
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<td>WS24A62</td>
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<td><strong>Tip Series</strong></td>
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<td>WS14 series</td>
<td>WS14 series</td>
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<td><strong>Diffuser Series</strong></td>
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<td>WS54</td>
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<td><strong>Liner Series</strong></td>
<td>WS42 Series</td>
<td>WS44 Series</td>
<td>WS44 Series</td>
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Miller is a registered trademark of Illinois Tool Works, Inc. Lincoln is a registered trademark of Lincoln Electric Co. The afore mentioned trademarks are in no way affiliated with Tweco or Thermadyne Industries, Inc.
## Rear Plug Connections

**WM150J Series 45 & 60°**

- **WM250J Series 45 & 60°**
- **64J-60 or 64J-45**

**Conductor Tube Series**

- 35-60, 45 & 60°
- 61 series 45 & 60°
- 62J series 45 & 60°
- 63J series 45 & 60°

## Options / Features

- **• metal jacketed conductor tube**
- **• Knucklehead™**
- **• dual schedule**
- **• locking trigger**
- **• ergonomic**

## Nozzle Insulator

- **WS51**
- **WS52**
- **WS54**
- **WS34A**

## Diffuser Series

- 63J3 series
- 64J series 45 & 60°
- MS63 series, 45, 60°
- MS64H series, 45, 60, 180°

## Liner Series

- 44 series
- 42 series
- 44 series
- 44 series

## Duty Cycle Rating

- 10’, 12’, 15’, 20’

## Available Lengths


**Euro-Kwik**

- • front & rear steel spring conductor tube
- • metal jacketed & swivel conductor tube
- • ergonomic

**Knucklehead™**

- • metal jacketed & swivel conductor tube
- • dual schedule
- • ergonomic

**Standard & Eliminator**

- • metal jacketed & swivel conductor tube
- • dual schedule
- • ergonomic

**TWECO Website Keyword Search Tip**

Keywords such as arc welding accessories, MIG guns, a532, twecotong, electrode holders and contact tips. (See Index on pages 6-7 for more info.)
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-35
- EL16-35
- EL16-45
- EL16RS-45

Standard Contact Tips for Traditional and Spray Master® Guns
Standard, Tapered & Heavy Duty Styles
- 11-23
- 11T-35
- 16AS-364
- 14AH-364
- 11H-35
- 16S-35

Chrome Zirconium Copper "RZ" Contact Tips
- 14RZ-45
- 16RZT-45

Copper-Silver Tweco Robotics "RS" Contact Tips
- 16RST-35

Nozzles
Eliminator Style Nozzles
- EL22CT
- EL21-50

Standard Nozzles for Traditional and Spray Master® Guns
Standard, Tapered & Heavy Duty Styles
- 22T-37-SS
- 22-62
- 23-62-F
- 24CT-62-F

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

Competitive Style Diffusers
BERNARD® Style Diffusers
- W5S4BH-14
- W5S4BH-16

ESAB® Style Diffusers
- W5S4EH-14
- W5S4EH-16

TREGASKISS® Style Diffusers
- HD54-14
- HD54-16

MILLER® Style Diffuser
- HD52M-11

OXO® Style Diffusers
- W5S4BH-14
- W5S4BH-16

Bernard, Miller and OXO are registered trademarks of Illinois Tool Works, Inc. ESAB is a registered trademark of ESAB AB. Tregaskiss is a registered trademark of Tregaskiss, Ltd., Canada. The afore mentioned trademarks are in no way affiliated with Tweco or Thermadyne Industries, Inc.
**Wire Conduit**

Wire Conduits for All Guns
Eliminator®, Traditional & Spray Master®

**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**

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

**New & Improved Tweco Website**

Visit our new website, same address, newer look, more features. Website now allows the user to look up specific part numbers for detailed specifications, including images and literature available. Stop by and check it out.

**Visit our new website, same address, newer look, more features. Website now allows the user to look up specific part numbers for detailed specifications, including images and literature available. Stop by and check it out.**
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

<table>
<thead>
<tr>
<th>Model</th>
<th>Amps</th>
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<tr>
<td>A-532</td>
<td>200A</td>
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<td>A-316</td>
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<tr>
<td>A-732</td>
<td>300A</td>
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<td>A-14</td>
<td>350A</td>
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<td>A-14-HD</td>
<td>400A</td>
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<td>A-38-HD</td>
<td>500A</td>
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**Ground Clamps**

- Steel, Copper & Flat Ground Clamps

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<th>Model</th>
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<td>SGC-500</td>
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<td>GC-300</td>
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<td>FGC-500</td>
<td>500A</td>
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**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

<table>
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<th>Model</th>
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<td>RG-440</td>
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<td>GCRG-140</td>
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**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

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<thead>
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<td>GC-300</td>
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<td>GCRG-1200</td>
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<td>GCRG-600-75</td>
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U.S. Customer Care: 800-426-1888 / FAX 800-535-0557
Canada Customer Care: 905-827-4515 / FAX 800-588-1714
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.

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<th>Part Number</th>
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<td>SMGC300</td>
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<tr>
<td>SMGC600</td>
<td>600 Amp</td>
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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

TwecoLugs®

Crimp & Solder Type

- 150A, 225A, 250A & 325A Rating
- 50A, 70A & 90A Rating (Power Cable Lugs)
- Various Cable Sizes Available

Terminals and TwecoLugs

Screw-on Terminals

- Fit ½" (12.7mm) Terminal Size
- 3 Sizes Available

Female Terminals

- ⅛" (13.5mm) Stud Hole Size
- Various Configurations Available

Ball-Point Connection Type Lugs

- ⅛" (13.5mm) Stud Hole Size
- Various Configurations Available

Heavy Duty Type Lugs

- Mechanical Ball-Point
- Various Configurations Available
Quick Robotic MIG Guns & Accessories

Tweco Robotics 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 robotics 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 QRL 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 1½” (41.28mm) 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® Antispatter Compound Through the Conductor Tube and Nozzle
- Furnished with Tweco Robotics R45-116 Conduit
- Furnished with a Tweco®, Miller®, and 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.

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

Cleaning Station Accessories

QWT-3 Wire Trim Unit
For use with QRC-2000

QRM-100 Anti-Spatter Mist Applicator
For use with QRC-2000

Tweco Water Coolers

TC900 & TCV-900 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
- Vance Pumps are Equipped with a Bypass to Eliminate Excessive Pump Wear

See our full line catalog or visit us on the web at www.tweco.com for more information.

Tweco Robotics
Quick Robotic MIG Guns & Accessories Catalog
(Form No. 64-2203)
Tweco Robotics 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 ampere @ 60% duty cycle, both are offered with and without a cable assembly.

Mounting of this particular series is directly to the 1¼” (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 di-electric properties.

TAM series with cable assemblies are offered in lengths of 2 ft. (.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 ampere @ 60% duty cycle. Mounting surface is the outer diameter of the 1¾” (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 for more information.
**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 ampere @ 60% duty cycle. Mounting surface is the outer diameter of the 1½” (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.

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**Tweco Water Coolers**

**TC900 & TCV-900 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
- Vance Pumps are Equipped with a Bypass to Eliminate Excessive Pump Wear

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**TJ-2 Tri-Just**

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

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**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.

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**TJ2-KB Keyed Bracket**

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

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® 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
- Design Specifically for use with Slice Cutting Systems

See our full line Tweco & Arcair Professional catalog (Form No. 64-2103) or visit us on the web at www.thermadyne.com/arcair for more information.
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 ±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 forkift 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

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® Professional

SLICE® FIRE AND RESCUE
CUTTING SYSTEM

LET NOTHING STAND IN YOUR WAY.

YOUR ALL-PURPOSE TOOL FOR FAST ENTRY AND RESCUE. QUICKLY CUTS THROUGH STEEL DOORS, FRAME WALLS, IRON BARS & GRATINGS, REBAR, METAL ROOFING, BRICK, CONCRETE, ALUMINUM & STAINLESS STEEL.
NEW 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 a name a few.

A40
- ¼” (6mm) Production Capacity
- 20-40 Amps, 60 Amps Max, Adjustable
- Duty Cycle:  80% @ 40A
  100% @ 50A
- SL100 SV 1Torch with SureLok® Technology
- CNC Interface

A60
- ⅜” (10mm) Production Capacity
- 20-60 Amps, 80 Amps Max, Adjustable
- Duty Cycle:  80% @ 60A
  100% @ 55A
- SL100 SV 1Torch with SureLok® Technology
- CNC Interface

A80
- ½” (12mm) Production Capacity
- 30-80 Amps, 100 Amps Max, Adjustable
- Duty Cycle:  80% @ 80A
  100% @ 90A
- SL100 SV 1Torch with SureLok® Technology
- CNC Interface

A120
- ⅜” (15mm) Production Capacity
- 30-120 Amps, 120 Amps Max, Adjustable
- Duty Cycle:  80% @ 120A
  100% @ 110A
- 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
- ¼” (15mm) Production Cut
- ⅜” (20mm) Maximum Cut
- 1” (25mm) Edge Start
- Duty Cycle:  100% @ 100A @ 160V
- 10-100 Amps
- XT-301 Torch and Leads
- Water Mist Secondary
- CE, CSA, CCC

Auto-Cut 200
- 1” (25mm) Production Cut
- 1⅜” (30mm) Maximum Cut
- 2” (50mm) Edge Start
- Duty Cycle:  100% @ 200A @ 160V
- 10-200 Amps
- XT-301 Torch and Leads
- Water Mist Secondary
- CE, CSA, CCC

Auto-Cut 2002
- 1” (25mm) Production Cut
- 1⅜” (40mm) Maximum Cut
- 2” (50mm) Edge Start
- Duty Cycle:  100% @ 200A @ 180V
- 10-200 Amps
- XT-301 Torch and Leads
- Water Mist Secondary
- High Speed Oxygen Cutting
- CE, CSA, CCC

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

Conventional Automated Systems

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

Conventional Automated Systems

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

### Auto-Cut® 300
- 1/4" (30mm) Production Cut
- 1/2" (40mm) Maximum Cut
- 3/4" (70mm) Edge Start
- Duty Cycle: 100% @ 300A @ 180V
- 10-300 Amps
- XT-301 Torch and Leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC

### Auto-Cut 300²
- 1/2" (40mm) Production Cut
- 3/4" (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-1000 – Gas Control
Plasma and secondary gas pressures and WMS (Water Mist Secondary) flows are precisely controlled at the power supply with dedicated regulators.

### GCM-2000 – Gas Control
Digitally controlled plasma and secondary gases with dedicated regulators, pressure gauges and flowmeters.

### 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

---

**Water Mist Secondary (WMS)**
- Low Operating Costs
- Dross-Free Cutting
- Oxide Free Surface
- Easy to Use
**Ultra-Cut® Series High Precision Automation**

The Thermal Dynamics Ultra-Cut Series delivers premium precision and heavy-duty conventional plasma cutting on mild steel and non-ferrous alloys. With consumable parts for both precision and conventional plasma cutting from gage to 3" (75mm) it’s the only plasma system you will need. Select precision consumable parts for high precision cutting on mild steel. Or select conventional consumable parts for faster and more economical cutting with air plasma.

**Control Modules**

GSM-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

**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.

**Ultra-Cut 100**

- ½" (12mm) Production Cut
- ¾" (15mm) Maximum Cut
- ¾" (20mm) Edge Start
- Duty Cycle: 100% @ 100A @ 180V
- 10-100 Amps
- XT™-300 Torch and Leads
- Water Mist Secondary
- CE, CSA, CCC

**Ultra-Cut 200**

- 1" (25mm) Production Cut
- 1½" (40mm) Maximum Cut
- 2½" (62mm) Edge Start
- Duty Cycle: 100% @ 200A @ 180V
- 10-200 Amps
- XT-300 Torch and Leads
- Water Mist Secondary
- CE, CSA, CCC

**Ultra-Cut 300**

- 1½" (40mm) Production Cut
- 1¾" (45mm) Maximum Cut
- 3" (75mm) Edge Start
- Duty Cycle: 100% @ 300A @ 180V
- 10-300 Amps
- XT-300 Torch and Leads
- Water Mist Secondary
- CE, CSA, CCC

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**Contact Information**

U.S. Customer Care: 866-279-2628 / FAX 800-535-0557  
Canada Customer Care: 905-827-4515 / FAX 800-588-1714
**Water Mist Secondary**

Water Mist Secondary (WMS®) optimizes non-ferrous cutting; delivering excellent cut quality on non-ferrous materials with low cost of operation by using N2 as plasma and ordinary tap water as the secondary. A reducing atmosphere is produced in the cut by the release of hydrogen from the secondary water. This reducing atmosphere decreases oxidation on the cut surface. WMS is recommended for materials up to 1” (25mm) thick.

- Low Operating Costs
- Dross-Free Cutting
- Oxide Free Surface
- Easy to Use

**NEW & Improved Thermal Dynamics Website**

Visit our new website, same address, newer look, more features. Website now allows the user to look up specific part numbers for detailed specifications, including images and literature available. Stop by and check it out.

www.thermal-dynamics.com

**PAK® 45**

- 3” (75mm) Maximum Cut
- ¾” (20mm) Piercing
- Duty Cycle: 100% @ 400A @ 200V
- 10 – 400 Amps
- Liquid Cooled Torch
- N2, Ar-H2, Plasma
- CE, CSA, CCC

**TA-500/1000**

- 6” (150mm) Maximum Cut
- 2” (50mm) Piercing
- Duty 100% @ 500A/1000A @ 200V
- Paralleled to 1000 Amps
- Liquid Cooled Torch
- N2 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 – Powered by an internal microprocessor, the front panel LED’s provide status conditions during setup and trouble shooting.

#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 is there. The ½" (6mm) system can power through ¾" (15mm) material when needed – up to 150% more punch when necessary.

#3: True Protection – As if a 4 YEAR unlimited warranty on the power supply wasn’t enough, the CUTMASTER TRUE Series is the only line of plasma cutting machines offering True Guard – a rugged roll bar for added durability.

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

#5: True Flexibility – The new CUTMASTER TRUE Series offers MULTI-VOLTAGE and the patented 1Torch®. With the 1Torch, there’s only one set of consumable parts for the entire range of machines. Adding lead extensions allows you to cut up to 100’ from the power supply. It also allows you to move from a hand to a mechanized torch quickly.

#6: True Portability – The CUTMASTER TRUE Series offers lighter, more portable machines without compromising performance. The powerful 52 weighs in at a mere 43 lbs.
Superior Performance Features

- The Industry's only 60 Amp Drag Tip
- Lightweight design improves portability (Reduced nearly 50%)
- Trigger feature prevents hand fatigue during long cuts
- Auto Pilot Restart feature instantly reignites the pilot arc while cutting expanded metals
- Color Coded LEDs indicate pressure status and setup errors
- All user controls are conveniently located on the front panel
- TRUE GUARD™ roll bar provides easy transportation and protects the front and rear of the power supply for unmatched durability
- Universal selectable input power from 208 to 460 VAC ± 10%, single or three phase, 50 or 60 Hz
- Convenient storage compartment for spare and consumable parts

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

Ordering Information

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<th>Product Description</th>
<th>Catalog No.</th>
<th>Catalog No.</th>
</tr>
</thead>
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<td>CUTMASTER® 39 with SL60® 75° hand torch, 20 ft. (6.1m) lead</td>
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<tr>
<td>CUTMASTER 52 with SL60® 75° hand torch, 20 ft. (6.1m) lead</td>
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<td>1-5130-V</td>
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<tr>
<td>CUTMASTER 52 with SL100® 180° machine torch, 50 ft. (15.2m) lead*</td>
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<tr>
<td>CUTMASTER 102 with SL100 75° hand torch, 20 ft. (6.1m) lead</td>
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<tr>
<td>CUTMASTER 102 with SL100 75° hand torch, 50 ft. (15.2m) lead</td>
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<td>CUTMASTER 102 with SL100 180° machine torch, 25 ft. (7.6m) lead*</td>
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<tr>
<td>CUTMASTER 102 with SL100 180° machine torch, 50 ft. (15.2m) lead*</td>
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<td>1-1333-V</td>
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<td>CUTMASTER 82 with SL60® 75° hand torch, 20 ft. (6.1m) lead</td>
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<tr>
<td>CUTMASTER 82 with SL60® 75° hand torch, 50 ft. (15.2m) lead</td>
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<tr>
<td>CUTMASTER 82 with SL100® 180° machine torch, 25 ft. (7.6m) lead*</td>
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<tr>
<td>CUTMASTER 82 with SL100® 180° machine torch, 50 ft. (15.2m) lead*</td>
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<tr>
<td>CUTMASTER 152 with SL100 75° hand torch, 20 ft. (6.1m) lead</td>
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<td>1-1730-V</td>
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<tr>
<td>CUTMASTER 152 with SL100 75° hand torch, 50 ft. (15.2m) lead</td>
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<tr>
<td>CUTMASTER 152 with SL100 180° machine torch, 25 ft. (7.6m) lead*</td>
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<tr>
<td>CUTMASTER 152 with SL100 180° machine torch, 50 ft. (15.2m) lead*</td>
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<td>1-1733-V</td>
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</tbody>
</table>

* = Voltage (2 = 3ph 460V, 3 = 3ph 400V, 4 = 3ph 400V CE, 5 = 600V)

AirCut® 15C
- ⅛” (3mm) Recommended Cut Capacity
- ¼” (6mm) Maximum Cut
- Built-in Air Compressor
- 15 Amp, Fixed
- Duty Cycle: 35% @ 15A
- PCH-10 Torch

PAK® 200
- ⅛” (40mm) Recommended Cut Capacity
- 2¼” (70mm) Maximum Cut
- 35-200 Amp, Adjustable
- Duty Cycle: 100% @ 200A
- PCH-200 Torch
- Liquid-Cooled Torch
- Dual Gas Capacity
Manual Plasma Cutting Systems, Torches & Accessories

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® (Lincoln Pro-Cut 55 Compatible)

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

- Light / Medium Duty Torch
- 30-60Amp Capacity
- Available in 75° Torch Head Configuration
- Standard Connection or ATC Quick Disconnect Available (not for SL55)

1Torch SL100® (Lincoln Pro-Cut 80 Compatible)

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

- Medium / Heavy Duty Torch
- 40-120Amp Capacity
- Available in 75° 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.

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Power Supply Model</th>
<th>Cat No.</th>
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</thead>
<tbody>
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<td>AIRCO®/BOC®</td>
<td>PCS-43</td>
<td>7-3425</td>
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<td></td>
<td>PCS-53, PCS-80, PCS-90</td>
<td>7-3435</td>
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<tr>
<td>CEBORA®</td>
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<td>7-3438</td>
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<td>Pocket 25</td>
<td>7-3476</td>
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<tr>
<td>CENTURY®</td>
<td>82020*, 82050*, M2050*</td>
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<td>MRA1-70</td>
<td>7-3437</td>
</tr>
<tr>
<td>DAYTON®</td>
<td>3W722X*, 520318*</td>
<td>7-3478</td>
</tr>
<tr>
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1Torch SL60® (Lincoln Pro-Cut 55 Compatible)

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

- Light / Medium Duty Torch
- 30-60Amp Capacity
- Available in 75° torch head configuration
- Standard connection or ATC quick disconnect available (not for SL55)

1Torch SL100® (Lincoln Pro-Cut 80 Compatible)

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

- Medium / Heavy Duty Torch
- 40-120Amp Capacity
- Available in 75° or 180° (not for SL80) torch head configurations
- Standard connection or ATC quick disconnect available (not for SL80)

Notes:
- Each Adapter Kit includes connection fitting, electrical connectors and installation instruction sheets for the selected power supply.
-‡ The Miller Spectrum 1000 machines with Serial Numbers beginning LF are not compatible with 1Torch RPT Torches.
-† The Miller PlazCut 60 machines with Serial Numbers beginning JE are not compatible with 1Torch® RPT® Torches.
-* Non-HF Systems.
Electrode www.thermal-dynamics.com

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 3/16” (4.8mm) thickness. Produces the best cut quality, narrowest kerf width, fastest cutting speeds, with little to no distortion. 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 for cutting metal thicker than 3/16” (4.8mm) 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” to 1/4” from the workpiece), Use the Shield Cup Body together with the Deflector for extended parts life and improved resistance to reflected 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 thicknesses greater than 3/16” (4.8mm) simply drag the Shield Cap in contact with the workpiece. Use the Shield Cup Body with the appropriate Drag Tip or Drag Shield Cap matching the current level being used. This method is not recommended for cutting light-gauge sheetmetal.

Gouging
A simple method of metal removal by angling the torch to a lead angle of 35-45 degrees 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. Can use the Shield Cup Body with either the Gouging Shield Cap or the Shield Deflector. Can also use the single piece Shield Cup.

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.

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<thead>
<tr>
<th>Current Range</th>
<th>Mode Of Operation</th>
<th>Amps</th>
<th>Electrode</th>
<th>Start Cartridge</th>
<th>Tip</th>
<th>Shield Cup</th>
<th>Shield Cup Body</th>
<th>Drag Shield Cup</th>
<th>Deflector</th>
<th>Gouging Profiles</th>
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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.

**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 S2, S2, 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 SureLock® leads. Snaps make it easy to install. Snap two covers together for wider torches.

**Torch Protector**
Cat No. 9-8135 for 70° Torch,
Cat No. 9-8136 for 90° Torch
For use with the PCH-120 Torch. Rugged protector easily snaps onto torch providing excellent protection against damage caused by excessive heat or metal sparks. Great accessory for your gouging project.

**Trigger Guard Kits**
SureLock 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.*
### Miscellaneous Torch Accessories (cont.)

#### 1Torch® Leads Packages
(For CUTMASTER® TRUE™ Series and A-Series)

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<td>SL60®</td>
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### 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.

### Automation Accessories

#### Automation Interface Kit*
Cat. No. 9-8311 - For CUTMASTER TRUE Series and A-Series
*Note: Required for SC-11 torch height control

#### CNC Harness Cable
Cat. No. 9-9385 - For CUTMASTER TRUE Series (Manual & Mechanized)

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</tbody>
</table>

### 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

#### Dust Covers
Cat. No. 9-7072
(for CUTMASTER 39, 52, 82, 102, & 152 Systems)

#### Tool Boxes
Cat. No. 8-3141 - Small, Cat. No. 9-4173 - Large
Plastic boxes with handy compartments for storage of your torch consumables. Small (8.375” x 4.25” x 1.75” / 213mm x 108mm x 44mm), Large (17.5” x 7.75” x 3” / 445mm x 197mm x 76mm)

#### Welding Gloves
Cat. No. 9-1250

#### 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.
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 160S
- 115/230V or 460V, 1ph, 60 Hz.
- 5-85A (115V), 5-160A (230V/460V)
- STICK and Lift TIG Welding
- Lightweight, Compact & Portable
- Complete Packages Available

ArcMaster 160TS
- 115/230V, 1 Phase, 60 Hz.
- 5-85A (115V), 5-160A (230V)
- STICK and DC HF/Lift TIG
- Rapid Pulse Output
- Complete Packages Available

ArcMaster 185 ACDC
- 208-230/460V, 1 Phase, 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 300S
- 208-230/460V, 1/3ph, 50/60 Hz.
- 5-300 Amps Welding Output
- DC STICK, Lift TIG
- 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

Inverter Arc Welders (WeldSkill)

WeldSkill® Dragster® Series

Dragster 85
- 115 VAC, 1 Phase, 60 Hz.
- 5-85 Amps Welding Output
- Simple Amperage Control and Operator Interface
- Lightweight and Portable – 11 lbs.
- Complete Packages Available

* Limited warranty, refer to warranty schedule for details.
Professional ArcMaster® Series

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

- 120 VAC, 1 Phase, 60 Hz.
- 30-140 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Complete Packages Available

Fabricator 180

- 230 VAC, 1 Phase, 60 Hz.
- 30-180 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Complete Packages Available

Fabricator 190

- 230 VAC, 1 Phase, 60 Hz.
- 30-190 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Complete Packages Available

Fabricator 210

- 208/230V, 1 Phase, 60 Hz.
- 20-250 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Complete Packages Available

Fabricator 251

- 208/230V, 1 Phase, 60 Hz.
- 20-300 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Complete Packages Available

Fabricator 281

- 208/230, 1 Phase, 60 Hz.
- 20-300 Amps Welding Output
- DC Flux Cored, MIG
- 2 Roll Wire Feed System
- Includes Removable Wire Feeder
Professional PowerMaster® Series

**PowerMaster 500**
- 208/230/400/460V, 3ph, 50/60 Hz.
- 5-560 Amps Welding Output
- DC STICK, Lift TIG, Flux Cored, MIG, CAG
- Compact and Portable
- Complete Packages Available

**PowerMaster 500P**
- 208/230/400/460V, 3ph, 50/60 Hz.
- 5-560 Amps Welding Output
- DC STICK, Lift TIG, Flux Cored, Pulse MIG, MIG, CAG
- Pulse and AVC Pulse MIG
- Complete Packages Available

**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

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

Professional Fabstar® System

**Fabstar 4030**
- 208/230/460/600V, 3ph, 60 Hz.
- 40-400 Amps Welding Output
- DC MIG, Flux Cored
- CV, Output Voltage Regulation
- Solid State Contactor
- Single Range Voltage Control
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 Ultrafeed® Series**

**Ultrafeed A 2000**
- 115 VAC, 50/60 Hz., CV
- 1.5 Amps Max Input Current
- 30-650 IPM (0.76-16.6m/min.) Wire Speed
- 0.024"-1/6" (0.6-2.0mm) Wire Size
- 2 Gear Driven Feed Rolls
- 60 lb. (27.3kg) Max Spool Size

**Ultrafeed VA 2000**
- 115 VAC, 50/60 Hz., CV
- 4 Amps Max Input Current
- 70-660 IPM (1.8-16.8m/min.) Wire Speed
- 0.024"-1/8" (0.6-2.0mm) Wire Size
- 2 Gear Driven Feed Rolls
- 60 lb. (27.3kg) Max Spool Size

**Ultrafeed VA 4000**
- 115 VAC, 50/60 Hz., CV
- 4 Amps Max Input Current
- 50-875 IPM (1.25-22.1m/min.) Wire Speed
- 0.024"-3/32" (0.6-3.2mm) Wire Size
- 4 Gear Driven Feed Rolls
- 60 lb. (27.3kg) Max Spool Size

**Professional Portafeed® System**

**Portafeed VS 212**
- 15-100VDC, 50/60 Hz., VS
- 8 Amps Max Input Current
- 50-800 IPM (1.27-20.32m/min.) Wire Speed
- 0.024"-.125" (0.6-3.2mm) Wire Size
- 2 Gear Driven Feed Rolls
- 44 lb. (20kg) Max Spool Size

**Professional HMC-410 System**

**HMC-410**
- 120 VAC, 50/60 Hz., CS
- 4 Amps Max Input Current
- 60-888 IPM (1.5-22.6/min.) Wire Speed
- Wire Sizes:
  - 0.024"-.125" (0.6-3.2mm) Hard
  - 0.030"-.125" (0.8-3.2mm) Tubular
  - 0.035"-.125" (0.9-2.8mm) Soft
- 4 Gear Driven Feed Rolls
- 60 lb. (27.3kg) Max Spool Size

International Customer Care: 905-827-9777 / FAX 905-827-9797
www.thermalarc.com
Higher Manganese & Silicon.
Excellent choice for welding through mill scale, rust or dirt.

Copper Coated.
Improves arc starting and contact tip life.

Operates on wide range of shielding gases.
CO₂ and Argon based shielding gases.

Precision wound spools.
Layer level wound for improved feedability.

Multi application.
Suitable for all position Gas Metal Arc Welding (GMAW) of mild steel and low alloy steels, used in general fabrication and structural work.

Classifications

| AWS A5.18 | ER70S-6 |
| ASME-SFA-5.18 | ER70S-6 |

Typical Mechanical Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile strength, psi (MPa)</td>
<td>78,000 (538)</td>
</tr>
<tr>
<td>Yield strength, psi (MPa)</td>
<td>63,000 (434)</td>
</tr>
<tr>
<td>Elongation, %</td>
<td>30</td>
</tr>
<tr>
<td>CVN (Charpy V-notch) Impact</td>
<td>83 ft. lbs @ -20°F, 112.5 J @ -29°C</td>
</tr>
</tbody>
</table>

Typical Wire Analysis, %

<table>
<thead>
<tr>
<th>Element</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>C</td>
<td>0.06</td>
</tr>
<tr>
<td>Mn</td>
<td>1.45</td>
</tr>
<tr>
<td>Si</td>
<td>0.85</td>
</tr>
<tr>
<td>S</td>
<td>0.012</td>
</tr>
<tr>
<td>P</td>
<td>0.014</td>
</tr>
<tr>
<td>Cu</td>
<td>0.050</td>
</tr>
</tbody>
</table>

Recommended Shielding Gases

<table>
<thead>
<tr>
<th>Gas</th>
</tr>
</thead>
<tbody>
<tr>
<td>Argon + 10-25% CO₂</td>
</tr>
<tr>
<td>100% CO₂</td>
</tr>
<tr>
<td>Argon + 2-5% O₂</td>
</tr>
</tbody>
</table>

Suggested Welding Parameters: Ranges developed using DCEP polarity with CO₂ and mixed gases.

<table>
<thead>
<tr>
<th>Wire Diameter in. (mm)</th>
<th>Wire Feed Speed ipm (mpm)</th>
<th>Voltage</th>
<th>Amperage</th>
<th>Electrical Stickout in. (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.024 (0.6)</td>
<td>200-700 (5.1-17.8)</td>
<td>15-24</td>
<td>60-140</td>
<td>1/4-3/8 (6-10)</td>
</tr>
<tr>
<td>0.030 (0.8)</td>
<td>100-575 (2.5-14.6)</td>
<td>16-26</td>
<td>50-200</td>
<td>1/4-3/8 (6-10)</td>
</tr>
<tr>
<td>0.035 (0.9)</td>
<td>120-570 (3.0-14.5)</td>
<td>17-28</td>
<td>70-240</td>
<td>3/8-5/8 (10-16)</td>
</tr>
<tr>
<td>0.045 (1.2)</td>
<td>120-570 (3.0-14.5)</td>
<td>18-33</td>
<td>100-330</td>
<td>3/8-5/8 (10-16)</td>
</tr>
</tbody>
</table>

U.S. Customer Care: 800-426-1888 / FAX 800-535-0557
Canada Customer Care: 905-827-4515 / FAX 800-588-1714
WITH THE FABRICATOR® 281
YOU CAN REALLY GO PLACES.

INTRODUCING the FABRICATOR 281.

TAKE YOUR ARC WELDING TO NEW HEIGHTS...up to 41 feet without moving the power source!

Now you can easily work across the shop, on top of equipment, or around large projects without dragging the welding power source with you.

Fabricator 281 features a completely separate wire feeder that can be placed 26 feet from the power source. Plus, a Tweco® MIG gun is included to give you another 15 feet of distance. An optional spool gun for aluminum welding connects directly to the wire feeder extending the power source to work piece reach another 25 feet.

The 2-roll swivel base wire feeder mounts neatly attached to the power source. But when you need to “go the distance” the caster wheeled wire feeder easily lifts off the mount to move closer to your project. There’s nothing else like it!

When you want more mobility, performance, and safety, no other portable welder comes close. Fabricator 281 will go the distance.

For more info and to find a distributor, visit: www.thermalarc.com
# Signature Products Selection Guide

<table>
<thead>
<tr>
<th>Wear Mode</th>
<th>Product</th>
<th>Base Metal</th>
<th>General Use</th>
<th>PROCESS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Build-up &amp; Joining Alloys</strong></td>
<td><strong>Stoody Build-up</strong></td>
<td>Carbon steel</td>
<td>Build-up</td>
<td>GTAW</td>
</tr>
<tr>
<td></td>
<td><strong>Stoody Build-up LH</strong></td>
<td>Carbon steel</td>
<td>Build-up</td>
<td>SMAW</td>
</tr>
<tr>
<td></td>
<td><strong>Nicromang™</strong></td>
<td>Manganese steel</td>
<td>Build-up &amp; Joining</td>
<td>FCAW, GMAW</td>
</tr>
<tr>
<td></td>
<td><strong>Versalloy™ Plus</strong></td>
<td>Carbon &amp; Manganese steel</td>
<td>Build-up, repair &amp; joining</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Stoody 110</strong></td>
<td>Carbon &amp; Manganese steel</td>
<td>Build-up &amp; repair</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Stoody 2110</strong></td>
<td>Carbon &amp; Manganese steel</td>
<td>Build-up &amp; repair</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Castweld 55</strong></td>
<td>Cast iron</td>
<td>Joining, Build-up &amp; repair</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Castweld 99</strong></td>
<td>Cast iron</td>
<td>Joining, Build-up &amp; repair</td>
<td></td>
</tr>
<tr>
<td><strong>Metal to Metal Alloy</strong></td>
<td><strong>Stoody 1105</strong></td>
<td>Carbon &amp; Low alloy steel</td>
<td>Metal to Metal wear</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Super Build-up</strong></td>
<td>Carbon &amp; Low alloy steel</td>
<td>Metal to Metal wear</td>
<td></td>
</tr>
<tr>
<td><strong>Metal to Earth Alloy “ModerateAbrasion”</strong></td>
<td><strong>Stoody 19</strong></td>
<td>Carbon &amp; Low alloy, Manganese steel</td>
<td>Severe abrasion, low impact</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Stoody 965</strong></td>
<td>Carbon &amp; Low alloy, Manganese steel</td>
<td>Moderate abrasion, high impact</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Stoody 31</strong></td>
<td>Carbon &amp; Manganese steel</td>
<td>Moderate abrasion, moderate impact</td>
<td></td>
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<tr>
<td></td>
<td><strong>Stoody 101HC</strong></td>
<td>Carbon &amp; Low alloy, Manganese steel</td>
<td>Severe abrasion, low impact</td>
<td></td>
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<tr>
<td></td>
<td><strong>Stoody 121</strong></td>
<td>Carbon &amp; Low alloy, Manganese steel</td>
<td>Moderate to severe abrasion, moderate impact</td>
<td></td>
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<tr>
<td></td>
<td><strong>Stoody 130</strong></td>
<td>Carbon &amp; Low alloy steel</td>
<td>Extreme Abrasion &amp; low impact</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Vancar™</strong></td>
<td>Carbon &amp; Low alloy steel</td>
<td>Extreme Abrasion &amp; low impact</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Acetylene Tube Borium (ATB Bare)</strong></td>
<td>Carbon &amp; Low alloy steel</td>
<td>Extreme Abrasion &amp; low impact</td>
<td></td>
</tr>
<tr>
<td><strong>Temperature Abrasion Corrosion</strong></td>
<td><strong>Stoodite 6</strong></td>
<td>Carbon &amp; Low alloy and Stainless Steel</td>
<td>High temperature abrasion &amp; corrosion resistance</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Stoodite 21</strong></td>
<td>Carbon &amp; Low alloy and Stainless Steel</td>
<td>High temperature abrasion &amp; corrosion resistance</td>
<td></td>
</tr>
</tbody>
</table>

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.)
<table>
<thead>
<tr>
<th>AVAILABLE SIZES</th>
<th>APPLICATIONS (Partial Listing)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wire</td>
<td>Electrodes</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 3/32&quot;, 7/64&quot;</td>
<td>Hammers, Carbon Steel Shovel Pads, Shaft, Rolls, Pump Parts</td>
</tr>
<tr>
<td>1/8&quot;, 5/32&quot;, 3/16&quot;, 1/4&quot;</td>
<td>Tractor Rollers, Steel Shovel Pads, Tractor Idlers, Sprockets, Shafts</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 3/32&quot;</td>
<td>Dredge Pumps Parts, Crusher Jaws, Impact Breaker Bars, Hammers</td>
</tr>
<tr>
<td>3/32&quot;, 1/8&quot;, 5/32&quot;</td>
<td>General purpose Stainless, good for joining Stainless to dissimilar metals</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 3/32&quot;, 7/64&quot;</td>
<td>Shovel Teeth, Turbine Cone, Shovel Pads, Crusher Rolls, Drive Tumblers</td>
</tr>
<tr>
<td>1/8&quot;, 5/32&quot;, 3/16&quot;, 1/4&quot;</td>
<td>Steel Frogs, Switch Points, Hammers, Shovel Teeth, Roll Crushers</td>
</tr>
<tr>
<td>1/16&quot;, 3/32&quot;</td>
<td>Joining build-up, and repair of cast iron parts</td>
</tr>
<tr>
<td>3/32&quot;, 1/8&quot;, 5/32&quot;</td>
<td>Similar applications as Castweld 55 with focus on hairline cracks</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 7/64&quot;</td>
<td>Gear Teeth, Sprockets, Steel Shovel Pads, Carbon Steel Shafts</td>
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<tr>
<td>.045&quot;, 1/16&quot;</td>
<td>Tillage Tools, Dredge Parts, Shredder Knives, Extruder Screws</td>
</tr>
<tr>
<td>1/8&quot;, 5/32&quot;, 3/16&quot;, 1/4&quot;</td>
<td>Bucket Arms, Chain Links, Rolling Mill Guides, Pulley, Scrapper, Blades</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 5/64&quot;</td>
<td>Bucket Slides &amp; Lips, Blades, Clam Shell bucket, Augers, Scraper Sides</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 5/64&quot;</td>
<td>Scraper Slides, Scraper Cutters Vibrator Ditcher Shanks, Pot Hole Augers</td>
</tr>
<tr>
<td>1/16&quot;, 7/64&quot;</td>
<td>Muller Plows, Chisel Plow, Ammonia Injectors, Raymond Mill Plows</td>
</tr>
<tr>
<td>1/16&quot;, 3/32&quot;, 7/64&quot;</td>
<td>5/32&quot;, 3/16&quot;</td>
</tr>
<tr>
<td>1/8&quot;, 5/32&quot;, 3/16&quot;, 1/4&quot;</td>
<td>Farm Drill Points, Dry Cement Pump Screws, Drill Pipe Stabilizer, Paddles</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;, 3/32&quot;</td>
<td>(also in bare rod)</td>
</tr>
<tr>
<td>.045&quot;, 1/16&quot;</td>
<td>(also in bare rod)</td>
</tr>
</tbody>
</table>
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/CO2 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 410NiMoTi-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

**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) ...... 25 ft-lbs (34 Joules)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>11921000</td>
<td>33# WB, VP</td>
<td>.045 1.6</td>
<td>75% Ar, 25% CO2</td>
<td>190-250 26-27</td>
</tr>
</tbody>
</table>

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

**BRILLIANT 2209 T-1 AP**

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (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) ...... 33 ft-lbs (52 Joules)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Welding Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>11892000</td>
<td>33# WB, LLW</td>
<td>.045 1.2</td>
<td>190-250 26-27</td>
</tr>
<tr>
<td>11892100</td>
<td>33# WB, LLW</td>
<td>.045 1.2</td>
<td>190-250 26-27</td>
</tr>
<tr>
<td>.045&quot; (1.2mm)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.16&quot; (3.0mm)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.16&quot; (3.0mm)</td>
<td>170  210  250  300</td>
<td>28  28  28  28</td>
<td>115  195  245  320</td>
</tr>
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</table>
**308L T-1 AP**

Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO2 (X=1) or Argon/CO2 (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

**Typical Deposit Characteristics:**

<table>
<thead>
<tr>
<th>Deposit Characteristics</th>
<th>75 AR/25 CO2</th>
<th>100% CO2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength, Ksi (MPa)</td>
<td>88 (610)</td>
<td>86 (600)</td>
</tr>
<tr>
<td>Elongation (%)</td>
<td>39</td>
<td>41</td>
</tr>
<tr>
<td>Yield Strength, Ksi (MPa)</td>
<td>63 (435)</td>
<td>60 (415)</td>
</tr>
</tbody>
</table>

<table>
<thead>
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<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
</tr>
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<tbody>
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<tr>
<td>11819000</td>
<td>33# WB</td>
<td>.045</td>
</tr>
<tr>
<td>11819100</td>
<td>33# WB</td>
<td>1/16</td>
</tr>
</tbody>
</table>

**Typical Deposit Characteristics:**

<table>
<thead>
<tr>
<th>Deposit Characteristics</th>
<th>75 AR/25 CO2</th>
<th>100% CO2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Strength, Ksi (MPa)</td>
<td>87 (600)</td>
<td>84 (573)</td>
</tr>
<tr>
<td>Elongation (%)</td>
<td>37</td>
<td>38</td>
</tr>
<tr>
<td>Yield Strength, Ksi (MPa)</td>
<td>62 (430)</td>
<td>60 (415)</td>
</tr>
</tbody>
</table>

**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.

**308L T-1 FH**

Stoody FH stainless steel flux cored wires are designed for flat and horizontal welding applications, using either 100% CO2 (X=1) or Argon/CO2 (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

**Typical Deposit Characteristics:**

<table>
<thead>
<tr>
<th>Deposit Characteristics</th>
<th>75 AR/25 CO2</th>
<th>100% CO2</th>
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</thead>
<tbody>
<tr>
<td>Tensile Strength, Ksi (MPa)</td>
<td>87 (600)</td>
<td>84 (573)</td>
</tr>
<tr>
<td>Elongation (%)</td>
<td>37</td>
<td>38</td>
</tr>
<tr>
<td>Yield Strength, Ksi (MPa)</td>
<td>62 (430)</td>
<td>60 (415)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
</tr>
</thead>
<tbody>
<tr>
<td>11703100</td>
<td>35# WB, VP</td>
<td>.035</td>
</tr>
<tr>
<td>11869400</td>
<td>33# WB, VP</td>
<td>.045</td>
</tr>
<tr>
<td>11869300</td>
<td>33# WB, VP</td>
<td>1/16</td>
</tr>
</tbody>
</table>

**Notes:**

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

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
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<tbody>
<tr>
<td>11703100</td>
<td>35# WB, VP</td>
<td>.035</td>
</tr>
<tr>
<td>11869400</td>
<td>33# WB, VP</td>
<td>.045</td>
</tr>
<tr>
<td>11869300</td>
<td>33# WB, VP</td>
<td>1/16</td>
</tr>
</tbody>
</table>

**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.
Stoody AP stainless steel wires are designed for welding in all positions with either 100% CO₂ (X=1) or Argon/CO₂ (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 E309LTi-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics: 75 AR/25 CO₂ 100% CO₂
Tensile Strength, Ksi (MPa) ......................... 88 (610) 86 (600)
Elongation (%) ............................................. 34 38
Yield Strength, Ksi (Mpa) ............................. 69 (480) 64 (440)

<table>
<thead>
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<tbody>
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<td></td>
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<tr>
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<tr>
<td>11819300</td>
<td>33# WB</td>
<td>.045 1.2</td>
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<tr>
<td>11819400</td>
<td>33# WB</td>
<td>1/16 1.6</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Amps</th>
<th>Volts</th>
<th>WFS in/min (m/min)</th>
<th>Notes</th>
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<tbody>
<tr>
<td>100</td>
<td>120</td>
<td>275 (6.9)</td>
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</tr>
<tr>
<td>25</td>
<td>26</td>
<td>375 (6.9)</td>
<td></td>
</tr>
<tr>
<td>1/16&quot; (0.1mm)</td>
<td>170</td>
<td>105</td>
<td>500 (11.7)</td>
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<tr>
<td>27</td>
<td>26</td>
<td>375 (6.9)</td>
<td></td>
</tr>
<tr>
<td>27</td>
<td>26</td>
<td>375 (6.9)</td>
<td></td>
</tr>
</tbody>
</table>

Notes:
• 3/8" - 1/2" (10 - 12mm) electrical stick-out
• 1. Flat and vertical welding

Stoody FH stainless steel flux cored wires are designed for flat and horizontal welding applications, using either 100% CO₂ (X=1) or Argon/CO₂ (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 E309LT0-X.

Typical Deposit Chemistry:
Carbon, Manganese, Silicon, Chromium, Nickel

Typical Deposit Characteristics: 75 AR/25 CO₂ 100% CO₂
Tensile Strength, Ksi (MPa) ......................... 84 (585) 83 (580)
Elongation (%) ............................................. 34 33
Yield Strength, Ksi (Mpa) ............................. 61 (420) 61 (420)

<table>
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<tbody>
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<td></td>
<td></td>
<td>in. mm</td>
</tr>
<tr>
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<td>25# WB, VP</td>
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<tr>
<td>11869600</td>
<td>33# WB, VP</td>
<td>.045 1.2</td>
</tr>
<tr>
<td>11869500</td>
<td>33# WB, VP</td>
<td>1/16 1.6</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Amps</th>
<th>Volts</th>
<th>WFS in/min (m/min)</th>
<th>Notes</th>
</tr>
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<tbody>
<tr>
<td>120</td>
<td>150</td>
<td>375 (9.5)</td>
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<tr>
<td>24</td>
<td>26/28</td>
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</tr>
<tr>
<td>300</td>
<td>250</td>
<td>175 (4.5)</td>
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</tr>
<tr>
<td>24/26</td>
<td>26/28</td>
<td>200 (5.0)</td>
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</tr>
<tr>
<td>200</td>
<td>175</td>
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</tr>
<tr>
<td>300</td>
<td>300</td>
<td>175 (4.5)</td>
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</tr>
<tr>
<td>28/30</td>
<td>28/30</td>
<td>200 (5.0)</td>
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<tr>
<td>250</td>
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</tr>
<tr>
<td>250</td>
<td>325</td>
<td>175 (4.5)</td>
<td></td>
</tr>
</tbody>
</table>

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% CO₂ (X=1) or Argon/CO₂ (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 E308LTI-X.

**Typical Deposit Chemistry:**
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

**Typical Deposit Characteristics:**
- Tensile Strength, Ksi (MPa)..................88 (610) 86 (600)
- Elongation (%).................................36 39
- Yield Strength, Ksi (MPa)......................66 (460) 62 (430)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter in.</th>
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<tbody>
<tr>
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<td>25# WB</td>
<td>.035</td>
</tr>
<tr>
<td>1181900</td>
<td>33# WB</td>
<td>.045</td>
</tr>
<tr>
<td>11819700</td>
<td>33# WB</td>
<td>1/16</td>
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</table>

<table>
<thead>
<tr>
<th>.035&quot; (0.9mm)</th>
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</thead>
<tbody>
<tr>
<td>Amps</td>
</tr>
<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
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</tbody>
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<table>
<thead>
<tr>
<th>.045&quot; (1.2mm)</th>
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<tbody>
<tr>
<td>Amps</td>
</tr>
<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>.1/16&quot; (1.6mm)</th>
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</thead>
<tbody>
<tr>
<td>Amps</td>
</tr>
<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
</tr>
</tbody>
</table>

**316L T-1 FH**

Stoody FH stainless steel flux cored wires are designed for flat and horizontal welding applications, using either 100% CO₂ (X=1) or Argon/CO₂ (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 E316LTO-X.

**Typical Deposit Chemistry:**
Carbon, Manganese, Silicon, Chromium, Nickel, Molybdenum

**Typical Deposit Characteristics:**
- Tensile Strength, Ksi (MPa)..................88 (610) 82 (570)
- Elongation (%).................................35 36
- Yield Strength, Ksi (MPa)......................66 (450) 60 (415)

<table>
<thead>
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<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter in.</th>
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</thead>
<tbody>
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</tr>
<tr>
<td>11868700</td>
<td>33# WB, VP</td>
<td>.045</td>
</tr>
<tr>
<td>11869800</td>
<td>33# WB, VP</td>
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<table>
<thead>
<tr>
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<tbody>
<tr>
<td>Amps</td>
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<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>.045&quot; (1.2mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Amps</td>
</tr>
<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
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</table>

<table>
<thead>
<tr>
<th>.1/16&quot; (1.6mm)</th>
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<tbody>
<tr>
<td>Amps</td>
</tr>
<tr>
<td>Volts</td>
</tr>
<tr>
<td>WFS (in/min)</td>
</tr>
</tbody>
</table>

**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, cladding 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%

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
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<tbody>
<tr>
<td>11872700</td>
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<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
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<tr>
<td>11872600</td>
<td>33# WB</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>

**STOODY 182-T1**

Stoody 182-T1 is a gas shielded All Position Flux Cored Wire that meets the requirements of AWS A5.34 ENiCrFe3TX-Y.

**Applications:** Joining nickel-chromium-iron alloys, cladding 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%

<table>
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<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
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<td>33# WB</td>
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<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
</tr>
<tr>
<td>11916100</td>
<td>33# WB</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>

**STOODY A-T1**

Stoody A-T1 is a gas shielded All Position Flux Cored Wire that meets the requirements of AWS A5.34 ENiCrFe2TX-Y.

**Applications:** Joining nickel-chromium-iron alloys, joining nickel steels, joining Inconel 600, 601 and Incoloy 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)

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>11896500</td>
<td>33# WB, LLW</td>
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<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
</tr>
<tr>
<td>11896700</td>
<td>33# WB, LLW</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>
**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
- Sulfer
- 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 %

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
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<tbody>
<tr>
<td>11872500</td>
<td>33# WB, LLW</td>
<td>.045</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
</tr>
<tr>
<td>11872400</td>
<td>33# WB, LLW</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>

**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
- Sulfer
- Phosphorus
- Nickel

**Typical Deposit Characteristics:**
- **Tensile Strength:** 106 ksi (705 Mpa)
- **Yield Strength:** 68 ksi (452 Mpa)
- **Elongation:** 42 %

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>11953700</td>
<td>33# WB, LLW</td>
<td>.045</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
</tr>
<tr>
<td>11953800</td>
<td>33# WB, LLW</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>

**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
- Sulfer
- Phosphorus
- Nickel

**Typical Deposit Characteristics:**
- **Tensile Strength:** 103 ksi (685 Mpa)
- **Yield Strength:** 70 ksi (470 Mpa)
- **Elongation:** 27 %

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Packaging</th>
<th>Wire Diameter</th>
<th>Shielding Gas</th>
<th>Welding Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>11953800</td>
<td>33# WB, LLW</td>
<td>.045</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 150-200 25-26</td>
</tr>
<tr>
<td>11953800</td>
<td>33# WB, LLW</td>
<td>1/16</td>
<td>75% AR-25% CO2 or 100% CO2</td>
<td>1/2 200-250 26-27</td>
</tr>
</tbody>
</table>
STATEMENT OF WARRANTY
(as of November 1, 2008)

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 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 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 or consequential damages, such as, but not limited to, damage or loss of purchased or replacement goods, 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.

<table>
<thead>
<tr>
<th>GAS WELDING AND CUTTING EQUIPMENT</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Victor® Professional</td>
<td>5 years / NA</td>
</tr>
<tr>
<td>Victor CutSkill®</td>
<td>2 years / NA</td>
</tr>
<tr>
<td>Victor FirePower®</td>
<td>1 years / NA</td>
</tr>
<tr>
<td>Victor Medical</td>
<td>6 years / NA</td>
</tr>
<tr>
<td>Victor VSP</td>
<td>2 years / NA</td>
</tr>
<tr>
<td>HP&amp;I Brass Regulators/Manifolds</td>
<td>2 years / NA</td>
</tr>
<tr>
<td>HP&amp;I Stainless Regulators/Manifolds</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>HP&amp;I Corrosive Gas Regulators/Manifolds</td>
<td>90 days / NA</td>
</tr>
<tr>
<td>Aluminum Cylinders</td>
<td>10 years / NA</td>
</tr>
<tr>
<td>Steel Cylinders</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>Oxygen Conservers</td>
<td>2 years / NA</td>
</tr>
<tr>
<td>Cutting Machine Motors</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>TurboTorch®</td>
<td>3 years / NA</td>
</tr>
<tr>
<td>Transformers</td>
<td>5 years / NA</td>
</tr>
<tr>
<td>Parts Used in Rental Applications</td>
<td>1 year from date sold by seller to authorized distributor</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>ARC ACCESSORIES, ARC GOUGING &amp; SLICE EQUIPMENT</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>TC and TCV Water Coolers</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>TSC-96 Smoke Collector</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>ESG-1, EPG-CR1, EPG-CR2 Control Boxes for Eliminator Spool &amp; Pull Guns</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>QRC-2000 Nozzle Cleaning Stations</td>
<td>1 year / 1 year</td>
</tr>
<tr>
<td>Arcair® N6000</td>
<td>1 year / NA</td>
</tr>
<tr>
<td>Eliminator® Spool and Pull Guns</td>
<td>90 days / NA</td>
</tr>
<tr>
<td>Robotic Deflection Mounts</td>
<td>90 days / NA</td>
</tr>
<tr>
<td>QRM-100 Anti-Spatter Applicator</td>
<td>90 days / NA</td>
</tr>
<tr>
<td>All other products 30 days from date purchaser including but not limited to:</td>
<td>30 days / NA</td>
</tr>
<tr>
<td>• MIG Guns</td>
<td></td>
</tr>
<tr>
<td>• Arc Gouging Equipment</td>
<td></td>
</tr>
<tr>
<td>• Slice Equipment</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PLASMA CUTTING SYSTEMS</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>CUTMASTER® TRUE Series</td>
<td>4 years / 4 years</td>
</tr>
<tr>
<td>PakMaster® XL PLUS</td>
<td>3 years / 1 year</td>
</tr>
<tr>
<td>CUTMASTER 1Series™</td>
<td>3 years / 3 years</td>
</tr>
<tr>
<td>AirCut™ TSC</td>
<td>1 year / 1 year</td>
</tr>
<tr>
<td>Drag-Gun® Plus</td>
<td>2 years / 1 year</td>
</tr>
<tr>
<td>Drag-Gun</td>
<td>1 year / 1 year</td>
</tr>
<tr>
<td>PAK 200</td>
<td>2 years / 1 year</td>
</tr>
<tr>
<td>Automated Plasma</td>
<td></td>
</tr>
<tr>
<td>Torches</td>
<td>1 year / 1 year</td>
</tr>
<tr>
<td>Consoles, Control Equipment, Heat Exchangers and Accessory Equipment</td>
<td>1 year / 1 year</td>
</tr>
</tbody>
</table>

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### ENGINE DRIVEN WELDERS

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Scout®, Raider®, Explorer™</td>
<td>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.</td>
</tr>
</tbody>
</table>

### GMAW/FCAW (MIG) WELDING EQUIPMENT

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fabricator® 140, 180, 190, 210, 251, 281; Fabstar® 4030; PowerMaster® 350, 350P, 500, 500P; Excel-Arc® 6045; Wire Feeders: Ultrafeed®, Porta-feed®</td>
<td>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</td>
</tr>
</tbody>
</table>

### GTAW (TIG) & MULTIPROCESS INVERTER WELDING EQUIPMENT

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MSTP</td>
<td>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</td>
</tr>
</tbody>
</table>

### PLASMA WELDING EQUIPMENT

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ultima® 150</td>
<td>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</td>
</tr>
</tbody>
</table>

### SMAW (Stick) WELDING EQUIPMENT

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dragster™ 85</td>
<td>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, 160S, 300S, 400S</td>
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</tbody>
</table>

### GENERAL ARC EQUIPMENT

<table>
<thead>
<tr>
<th>Model</th>
<th>Parts / Labor</th>
</tr>
</thead>
<tbody>
<tr>
<td>FirePower® MIG Welders</td>
<td>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</td>
</tr>
</tbody>
</table>
Jim Shepard has always had an affinity for how things work. It began in childhood when he deconstructed bikes and built erector sets for fun.

He learned metalworking in high school and furthered his education with an Associate’s Degree in Machine Technology.

At the young age of twenty-four, he opened Shepard Machine Co., where he built and repaired all kinds of intricate devices. His company crafted over 100 machines mainly for the food industry, many taking 2-3 months of 18-hour days. With blueprints and thousands of tiny pieces, Jim and his team built the machines from the ground up, making tweaks to enhance their reliability.

After years of success, Jim was able to retire from the business, but metalworking is still in his blood. Now he considers himself a hobbyist – working on all sorts of metal projects in his 60 by 80 foot ‘hobby’ shop.

And his tool of choice? The new Thermal Dynamics® CUTMASTER® 52 TRUE™ Series plasma cutting system. “It cuts so smooth and the 1Torch is comfortable to use. Makes me want to keep working all day long.”

“I’M STILL BUILDING THINGS. AND THERMAL DYNAMICS KEEPS IT FUN.”

JIM SHEPARD
Welder/Fabricator

Jim carries the torch – will you?

THERMODYNE, 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, Stoody, CIGWELD and TurboTorch are among the Thermadyne family of brands that you can count on for safety, reliability and quality.

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