

WeldTec®

Rocker™ TIG Torches

The new Rocker™ torches take the stress out of pipe and tube welding.

- No more cable binding or twisting
- Precise torch control
- Less hand and wrist fatigue
- Ideal for walking the cup
- Flex neck and gas valve models

Weldtec patented rocker cable connection allows the torch body to rock back and forth on the power cable without binding or twisting. This greatly reduces strain and tension on the weldors hand allowing longer weld cycles with reduced down time. Ideal for pipe and tube welding.

The Rocker™ rubber power cable provides more welding amps than the standard 9 and 17 model torches.



Made in America.

ORDERING INFORMATION

TORCH SERIES*	MODEL	AMPS*	TORCH PACKAGE	LENGTH	FLEX	VALVE
9FV	R-9FV	150	R-9FV-12R	12.5 Ft.	✓	✓
			R-9FV-25R	25 Ft.	✓	✓
9V	R-9V	150	R-9V-12R	12.5 Ft.		✓
			R-9V-25R	25 Ft.		✓
17FV	R-17FV	180	R-17FV-12R	12.5 Ft.	✓	✓
			R-17FV-25R	25 Ft.	✓	✓
17V	R-17V	180	R-17V-12R	12.5 Ft.		✓
			R-17V-25R	25 Ft.		✓

*Uses industry standard parts compatible with 9 and 17 style torches.

*AC, DCSP

Add a quick connector to make a TIGrig™ set-up for field welding. Works with air cooled torches and standard rubber power cables. Standard 5/8 RH inert gas hose connection and Tweco® style plug.

OPTIONAL - TIGrig™ SET-UP

DESCRIPTION	PART NO.	TORCHES	CABLES
Quick Connector, plug only	TTC-150	9, 17 Series Air Cooled	1 Pc. Rubber
Quick Connector, plug & gas hose 5/8 RH-FM	TTC-150G		
Quick Connector, plug & gas hose 1/4 NPT-M	TTC-150P		

Specifications subject to change without notice.



Torch body is free to rock back and forth without binding or twisting of cable.



Lenco Welding Accessories Limited
 Sales@LencoCanada.com • 1-800-265-5678

WeldTec®

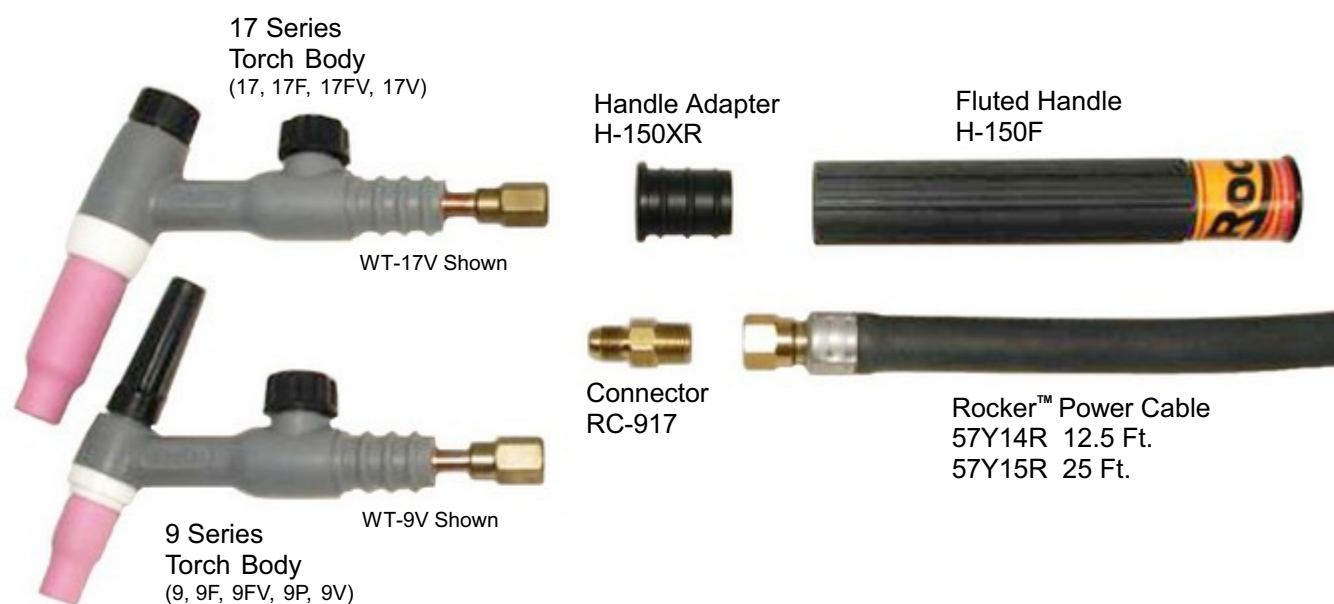
Rocker™ - Retro Kits

A pipe weldors dream . . . come true.

The special Rocker™ power cable can be retrofitted to existing torches in the field. A simple cable connector, handle, handle adapter and the Rocker™ power cable transforms your 9 or 17 series torch into a Rocker™ style torch.

ORDERING INFORMATION

RETRO KIT	LENGTH	INCLUDED IN KITS			
		ROCKER CABLE	CONNECTOR	ADAPTER	HANDLE
RK-12	12.5 Ft.	57Y14R	RC-917	H-150XR	H-150F
RK-25	25 Ft.	57Y15R	RC-917	H-150XR	H-150F



Specifications subject to change without notice.



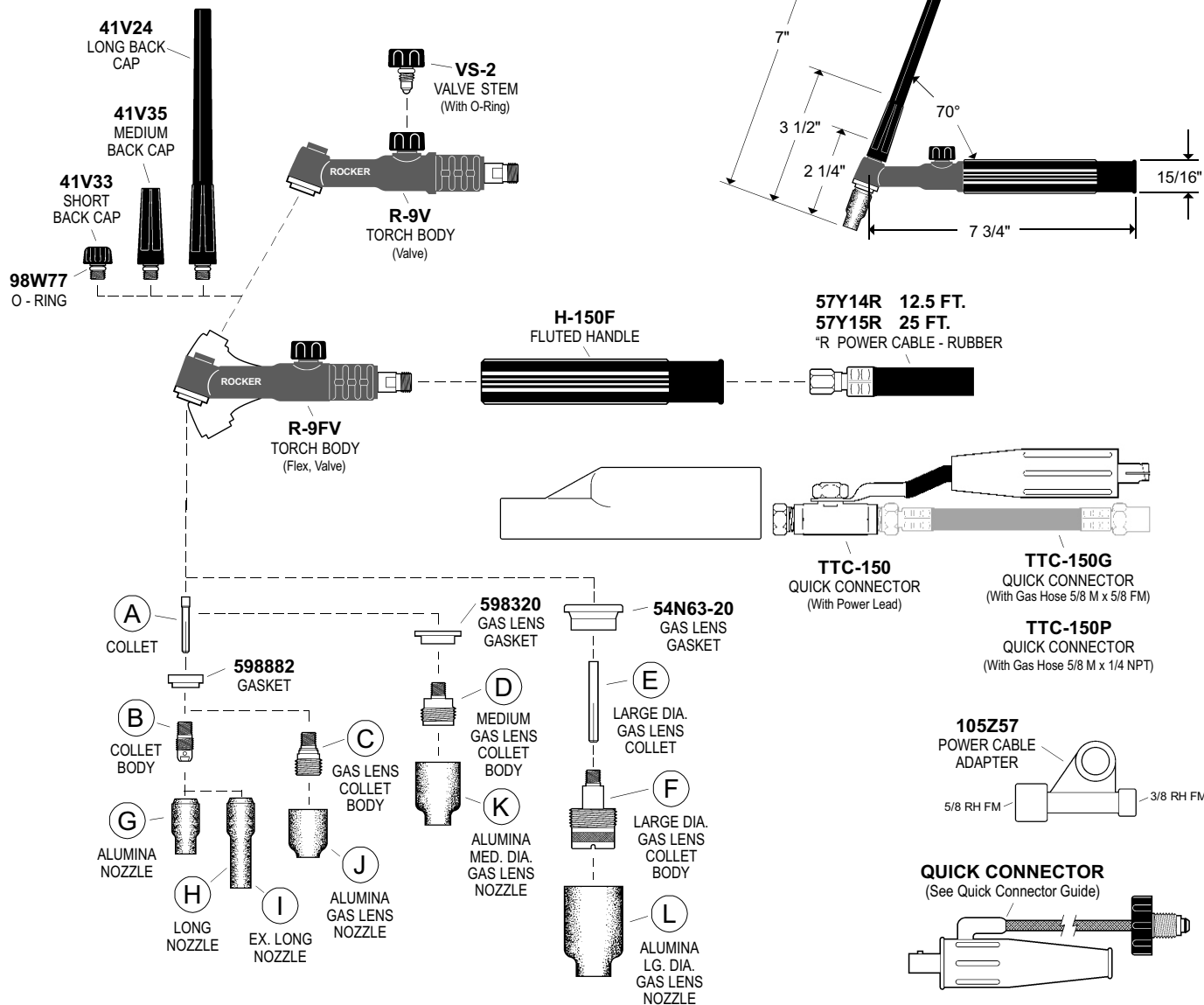
Lenco Welding Accessories Limited
Sales@LencoCanada.com • 1-800-265-5678



... by WeldTec®

REPLACEMENT PARTS

R-9FV • R-9V
FLEX - VALVE VALVE
150 AMPS • AIR COOLED
(PATENTED)



COPYRIGHT 2014 TEC WELDING PRODUCTS, INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	—	45V35SW	45V36SW	45V37SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA. GAS LENS	45V0204S	45V116S	45V64S	995795S	

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 1 7/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA



Lenco Welding Accessories Limited

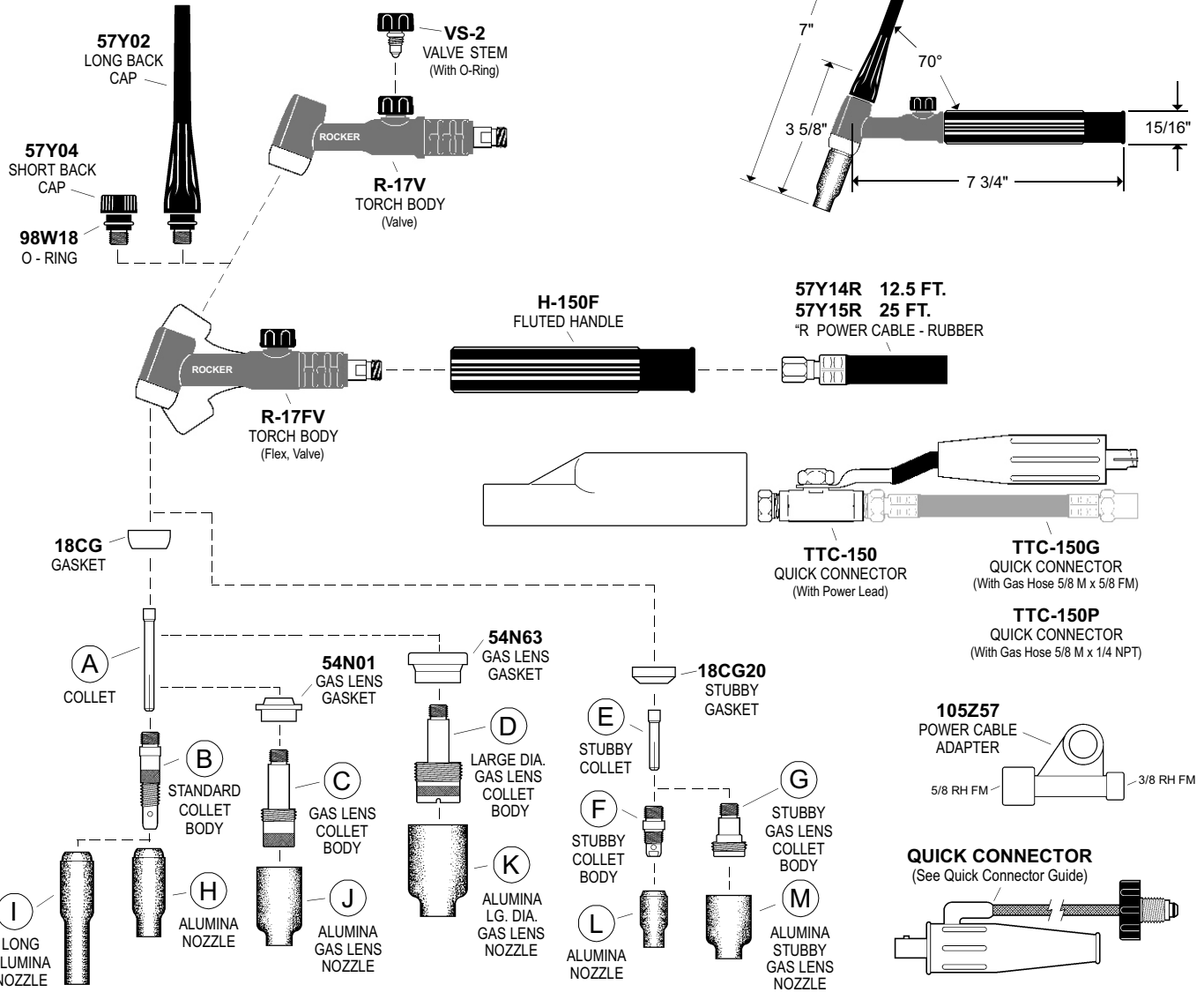
Sales@LencoCanada.com • 1-800-265-5678



... by WeldTec®

REPLACEMENT PARTS

R-17FV • R-17V
FLEX - VALVE VALVE
180 AMPS • AIR COOLED
(PATENTED)



COPYRIGHT 2014 TEC WELDING PRODUCTS, INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	STANDARD COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA. GAS LENS	—	—	45V116	45V64	995795
E	STUBBY COLLET	—	—	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY	17CB20				
G	STUBBY GAS LENS	—	—	45V25S	45V26S	45V27S

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA



Lenco Welding Accessories Limited

Sales@LencoCanada.com • 1-800-265-5678

WeldTec®

Quartz TIG Nozzles

Clear quartz glass nozzles for WeldTec® and most standard torches.

- Better weld puddle visibility
- Higher heat resistance
- No thermal shock breakage
- Better laminar gas coverage

TEC introduced the glass nozzles to TIG torches back in 1955. The original nozzles were made from Pyrex® grade glass.

These modern fused quartz nozzles offer superior temperature and thermal shock resistance, surpassing Pyrex®, lava and the pink ceramic nozzles for performance.

Now you can use these quartz nozzles on most TIG torches using a simple adapter ring. Available in several orifice sizes and several lengths to suit your job requirements.



Made in America.



WT-9, 20 with gas lens. WT-24 with gas lens.

ORDERING INFORMATION

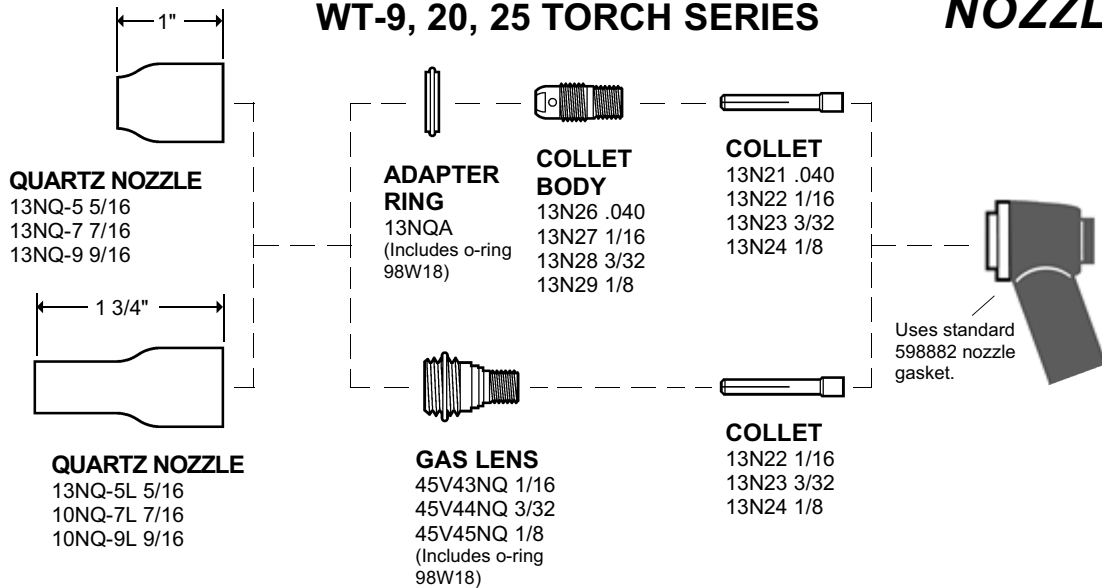
TORCH SERIES	DESCRIPTION	PART NO.	QUARTZ NOZZLE	SIZE	PART NO.
WT-17, 18, 26	ADAPTER RING  (GOLD COLOR)	10NQA	 #7L	7/16	10NQ-7L
	NOZZLE GASKET 	10NQG	 #9L	9/16	10NQ-9L
WT-9, 20, 24, 25 SW-320	ADAPTER RING  (SILVER COLOR) GAS LENS  NOZZLE GASKET  (USE WITH WT-24 SERIES)	13NQA 45V43NQ (1/16) 45V44NQ (3/32) 45V45NQ (1/8) 53N66	STANDARD #5  #7  #9  LONG #5L  #7L  #9L 	5/16 7/16 9/16 5/16 7/17 9/16	<u>STANDARD</u> 13NQ-5 13NQ-7 13NQ-9 <u>LONG</u> 13NQ-5L 10NQ-7L 10NQ-9L

Specifications subject to change without notice.

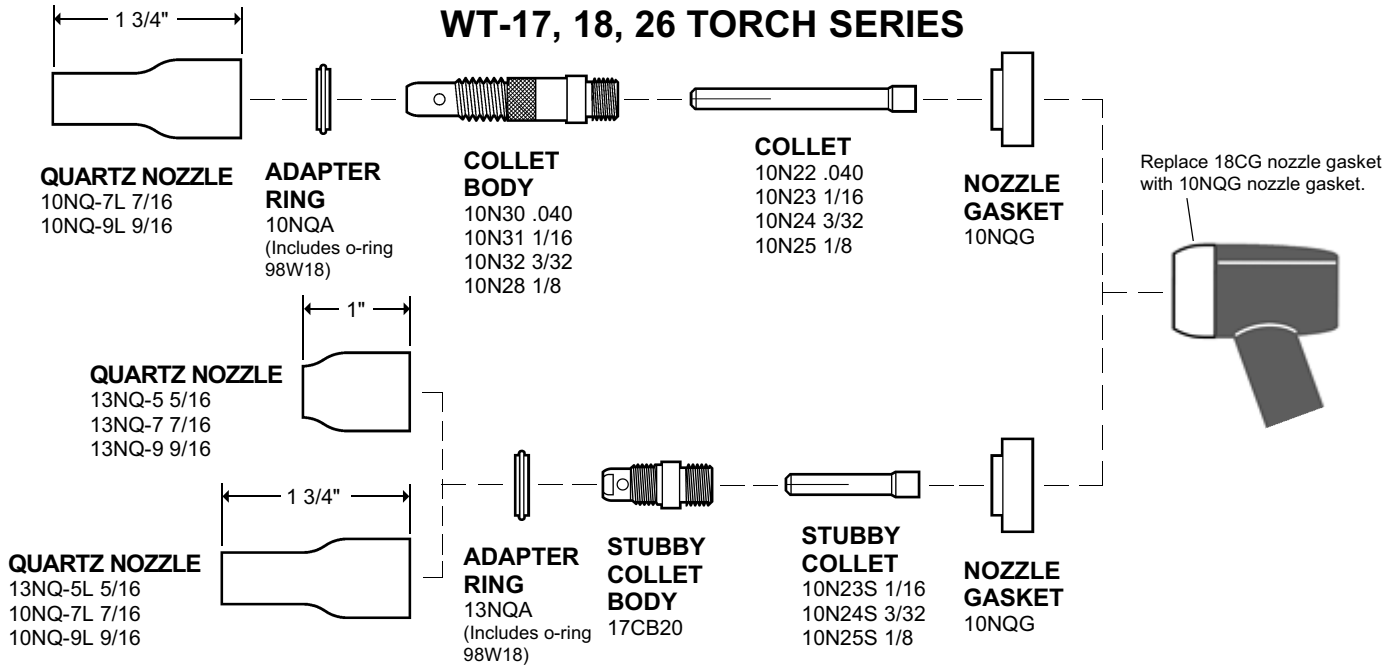


Lenco Welding Accessories Limited
Sales@LencoCanada.com • 1-800-265-5678

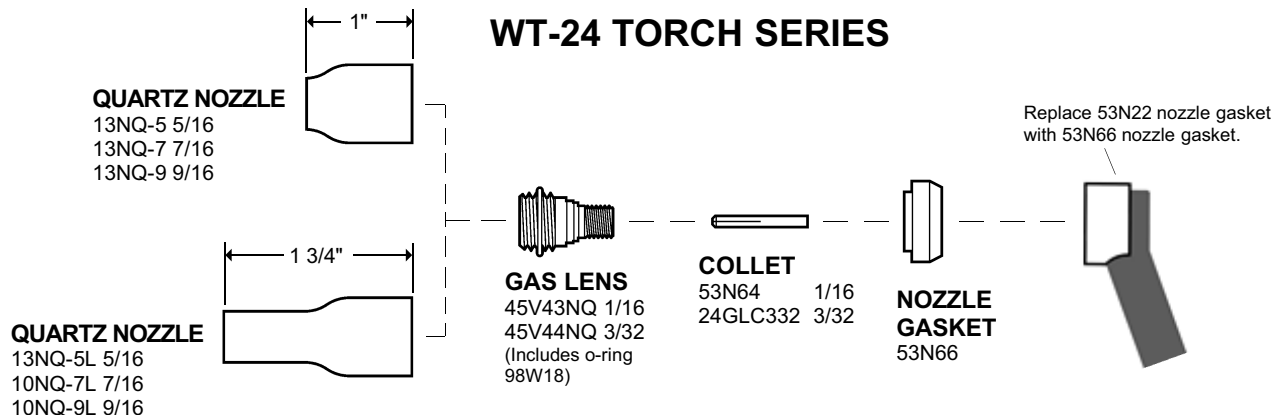
WT-9, 20, 25 TORCH SERIES



WT-17, 18, 26 TORCH SERIES



WT-24 TORCH SERIES



Specifications subject to change without notice.



Lenco Welding Accessories Limited
Sales@LencoCanada.com • 1-800-265-5678

i-HEAD[®]

INTERCHANGEABLE HEAD TIG TORCH SERIES



Flex-Neck

Ball-Joint

Roto-Head

Problem solvers

Allows access to difficult weld locations.

Ideal for pipe and tube welds.

WTF-17V

WTB-9

WTR-20



BALL-JOINT MODELS
Swivel ball joint head locks in place. Air cooled and water cooled models



FLEXIBLE-NECK MODELS
Air cooled and water cooled models provide solutions for hard to reach welds.



ROTO-HEAD MODELS
Head rotates 360°. Air cooled and water cooled models.



SPEED NUT[™] HOSE CONNECTIONS
No more troublesome wire clamps. Quick and easy repairs on water cooled models.

TEC Torch Company, Inc.

i-HEAD[®]

INTERCHANGEABLE HEAD TIG TORCH SERIES

These exciting i-Head torches give new meaning to versatility in TIG welding. Three distinct versions; **Flex**, **Ball** or **Roto** allow you to choose the model that best suits your needs.

The **Flex-Neck** models allow the torch body to flex, positioning the head at various angles.

The **Ball-Joint** models feature a swivel ball joint that locks the head in place with a twist of the torch body.

All the various head styles interchange between the Flex-Head and the Ball-Joint torch models. Both torch styles are available in air-cooled with or without a built-in gas valve along with two water-cooled models.

The **Roto-Head** models feature a torch head that rotates 360°. When in the desired position the head is locked firmly in place. The unique angled torch body allows access to tight weld locations.

All torch bodies and heads are made with resilient high temperature silicone rubber insulation that resist "HF" current leakage, chipping, cracking and withstands temperatures to 500° F.

The water-cooled models are available in deluxe packages featuring soft braided rubber hoses, power cable and a glove soft leather protective cable cover.

ORDERING INFORMATION

Ball-Joint "B" Models

125 amps - Air Cooled (920-70 Head)

WTB-9-12R	12 1/2 ft. Torch Package
WTB-9-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTB-9-25R	25 ft. Torch Package
WTB-9-25-2	25 ft. Torch Pkg - 2pc. Cable

WTB-9V-12R	12 1/2 ft. Torch Pkg w/Valve
WTB-9V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTB-9V-25R	25 ft. Torch Pkg w/Valve
WTB-9V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

150 amps - Air Cooled (1718-70 Head)

WTB-17-12R	12 1/2 ft. Torch Package
WTB-17-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTB-17-25R	25 ft. Torch Package
WTB-17-25-2	25 ft. Torch Pkg - 2pc. Cable

WTB-17V-12R	12 1/2 ft. Torch Pkg w/Valve
WTB-17V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTB-17V-25R	25 ft. Torch Pkg w/Valve
WTB-17V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

230 amps - Water Cooled (920-70 Head)

WTB-20-12DX	12 1/2 ft. Deluxe Torch Package
WTB-20-25DX	25 ft. Deluxe Torch Package

230 amps - Water Cooled (1718-70 Head)

WTB-18-12DX	12 1/2 ft. Deluxe Torch Package
WTB-18-25DX	25 ft. Deluxe Torch Package

Flex-Neck "F" Models

125 amps - Air Cooled (920-70 Head)

WTF-9-12R	12 1/2 ft. Torch Package
WTF-9-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTF-9-25R	25 ft. Torch Package
WTF-9-25-2	25 ft. Torch Pkg - 2pc. Cable

WTF-9V-12R	12 1/2 ft. Torch Pkg w/Valve
WTF-9V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTF-9V-25R	25 ft. Torch Pkg w/Valve
WTF-9V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

150 amps - Air Cooled (1718-70 Head)

WTF-17-12R	12 1/2 ft. Torch Package
WTF-17-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTF-17-25R	25 ft. Torch Package
WTF-17-25-2	25 ft. Torch Pkg - 2pc. Cable

WTF-17V-12R	12 1/2 ft. Torch Pkg w/Valve
WTF-17V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTF-17V-25R	25 ft. Torch Pkg w/Valve
WTF-17V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

230 amps - Water Cooled (920-70 Head)

WTF-20-12DX	12 1/2 ft. Deluxe Torch Package
WTF-20-25DX	25 ft. Deluxe Torch Package

230 amps - Water Cooled (1718-70 Head)

WTF-18-12DX	12 1/2 ft. Deluxe Torch Package
WTF-18-25DX	25 ft. Deluxe Torch Package

Roto-Head "R" Models

125 amps - Air Cooled (920R Head)

WTR-9-12R	12 1/2 ft. Torch Package
WTR-9-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTR-9-25R	25 ft. Torch Package
WTR-9-25-2	25 ft. Torch Pkg - 2pc. Cable

WTR-9V-12R	12 1/2 ft. Torch Pkg w/Valve
WTR-9V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTR-9V-25R	25 ft. Torch Pkg w/Valve
WTR-9V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

150 amps - Air Cooled (1718R Head)

WTR-17-12R	12 1/2 ft. Torch Package
WTR-17-12-2	12 1/2 ft. Torch Pkg - 2pc. Cable
WTR-17-25R	25 ft. Torch Package
WTR-17-25-2	25 ft. Torch Pkg - 2pc. Cable

WTR-17V-12R	12 1/2 ft. Torch Pkg w/Valve
WTR-17V-12-2	12 1/2 ft. Torch Pkg - 2pc., w/Valve
WTR-17V-25R	25 ft. Torch Pkg w/Valve
WTR-17V-25-2	25 ft. Torch Pkg - 2pc., w/Valve

230 amps - Water Cooled (920R Head)

WTR-20-12DX	12 1/2 ft. Deluxe Torch Package
WTR-20-25DX	25 ft. Deluxe Torch Package

230 amps - Water Cooled (1718R Head)

WTR-18-12DX	12 1/2 ft. Deluxe Torch Package
WTR-18-25DX	25 ft. Deluxe Torch Package

HEADS - FLEX-NECK & BALL JOINT



ROTO



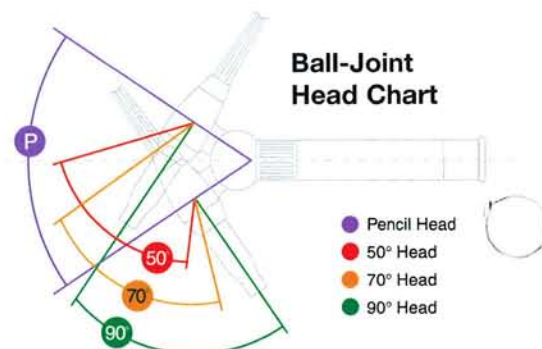
WATER COOLED DELUXE TORCH PACKAGES

The water cooled models are available in Deluxe packages that include: torch body, head(s), fluted handle, soft braided rubber hoses and power cable assembly, premium leather cable cover, 3/32" collet and collet body, tungsten electrode, #6 alumina nozzle, and back caps.

Note: Ball-Joint and Flex-Neck models include 70° and pencil heads.

SPECIFICATIONS

	Air Cooled	Water Cooled
Maximum Amperage Capacity (AC-DCSP)	125 or 150 AMPS	230 AMPS
Tungsten Size Capacity	.020" - 1/8" (0.5-3.2mm)	.020" - 5/32" (0.5-4.0mm)
Maximum Tungsten Length	7" (178mm)	7" (178mm)
Cooling Requirements	-	1 Qt./Min. (.946L/min)
Maximum Coolant Pressure	-	50 psi (345 Kpa)



BALL - JOINT WTB-9, 9V, 17, 17V, 18, 20 FLEX - NECK WTF-9, 9V, 17, 17V, 18, 20 DIMENSIONAL DATA SHEET

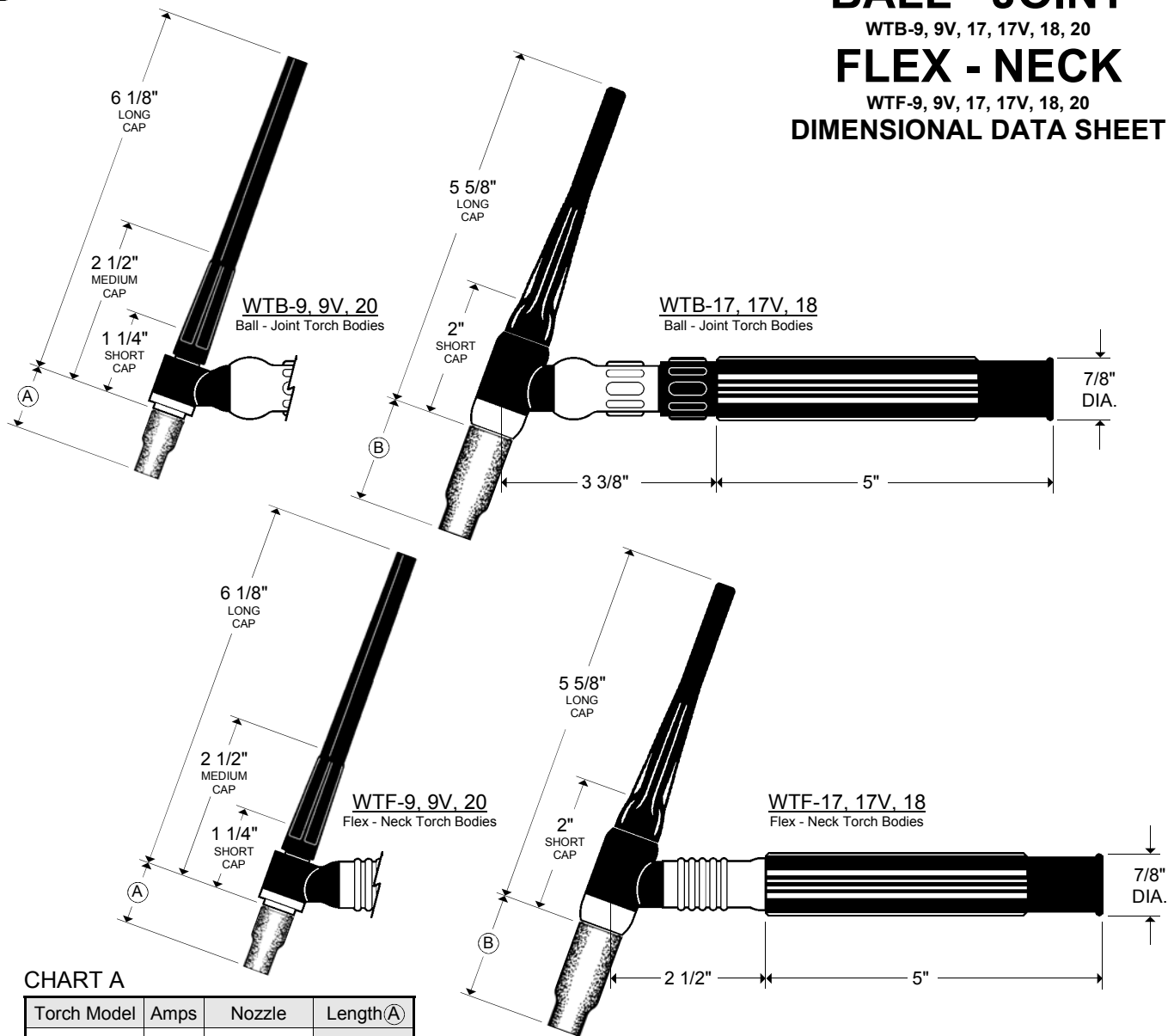


CHART A

Torch Model	Amps	Nozzle	Length(A)
WTR-9, 9V WTR-20	125 230	Standard Nozzle	1"
		Long Nozzle	1 7/8"
		Extra Long Nozzle	2 3/8"
		Gas Lens Nozzle	1"
		Medium Dia. Gas Lens Nozzle	1 5/16"
		Large Dia. Gas Lens Nozzle	1 7/8"

CHART B

Torch Model	Amps	Nozzle	Length(B)
WTR-17, 17V WTR-18	150 230	Standard Nozzle	1 11/16"
		Long Nozzle	2 7/8"
		Gas Lens Nozzle	1 3/4"
		Large Dia. Gas Lens Nozzle	1 7/8"

SPECIFICATIONS

Torch Model	Maximum Amps (dcsp)	Duty Cycle (dcsp)	Tungsten Capacity	Max. Length	Cooling Requirements
WTB-9, 9V WTF-9, 9V	125	60%	.020 - 3/32	7"	Air Cooled
WTB-17, 17V WTF-17, 17V	150	60%	.020 - 1/8	7"	Air Cooled
WTB-18 WTF-18	230	60%	.020 - 5/32	7"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)
WTB-20 WTF-20	230	60%	.020 - 1/8	7"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)

Note: Specifications and dimensions are subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

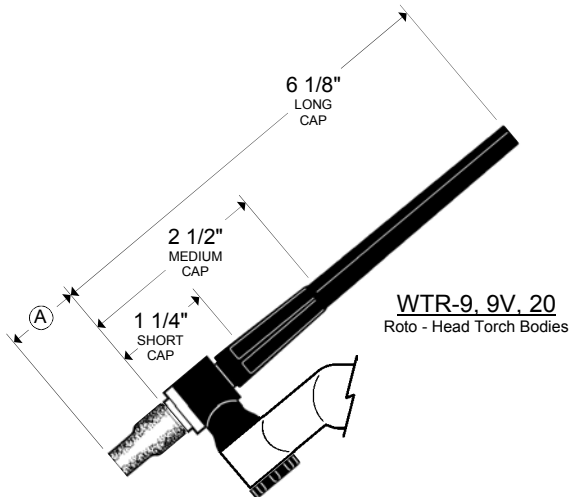
e-mail info@tectorch.com

www.weldtec.com

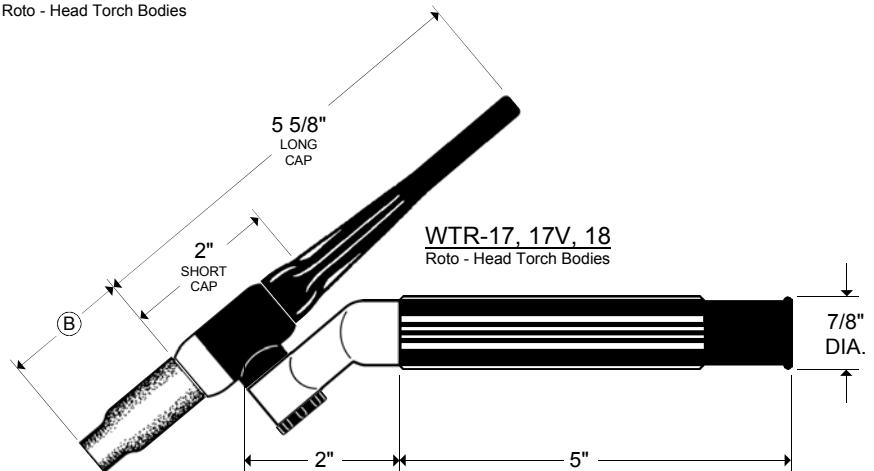
REVISION B

ROTO - HEAD

WTR-9, 9V, 17, 17V, 18, 20
DIMENSIONAL DATA SHEET



WTR-9, 9V, 20
Roto - Head Torch Bodies



WTR-17, 17V, 18
Roto - Head Torch Bodies

CHART A

Torch Model	Amps	Nozzle	Length(A)
WTR-9, 9V WTR-20	125 230	Standard Nozzle	1"
		Long Nozzle	1 7/8"
		Extra Long Nozzle	2 3/8"
		Gas Lens Nozzle	1"
		Medium Dia. Gas Lens Nozzle	1 5/16"
		Large Dia. Gas Lens Nozzle	1 7/8"

CHART B

Torch Model	Amps	Nozzle	Length(B)
WTR-17, 17V WTR-18	150 230	Standard Nozzle	1 11/16"
		Long Nozzle	2 7/8"
		Gas Lens Nozzle	1 3/4"
		Large Dia. Gas Lens Nozzle	1 7/8"

SPECIFICATIONS

Torch Model	Maximum Amps (dcsp)	Duty Cycle (dcsp)	Tungsten Capacity	Max. Length	Cooling Requirements
WTR-9, 9V	125	60%	.020 - 3/32	7"	Air Cooled
WTR-17, 17V	150	60%	.020 - 1/8	7"	Air Cooled
WTR-18	230	60%	.020 - 5/32	7"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)
WTR-20	230	60%	.020 - 1/8	7"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)

Note: Specifications and dimensions are subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION B



WP-225
(SF-225)
FLEXIBLE TORCH



WTF-20
FLEX - NECK

Both models share all heads.

17, 18 Style



1718-50
50 Degree Head



1718-70
70 Degree Head



1718-90
90 Degree Head



1718P
180 Degree Head

9, 20 Style



920-50
50 Degree Head



920-70
70 Degree Head



920-90
90 Degree Head



920P
180 Degree Head

24, 24W Style



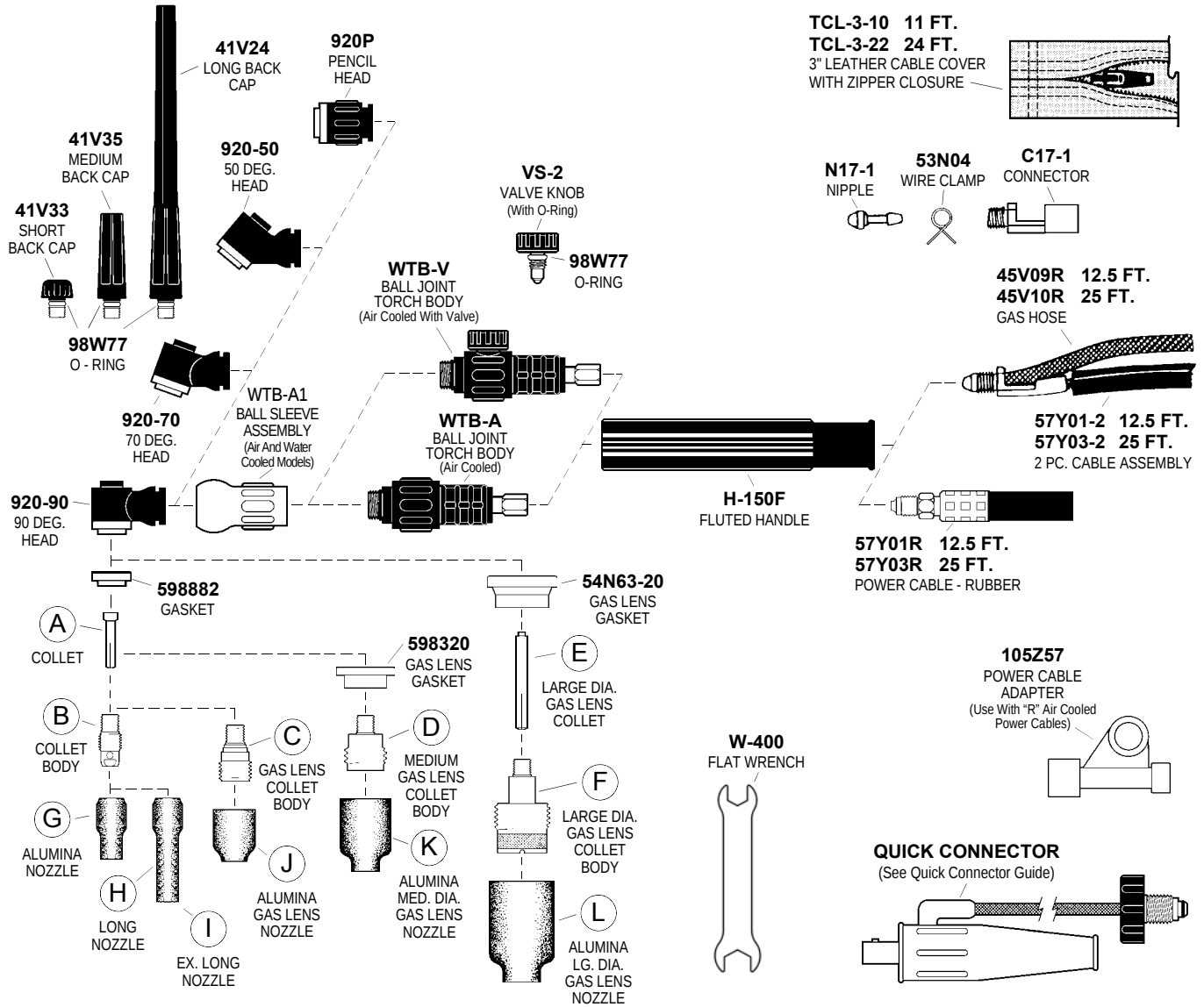
24-70
70 Degree Head



24-90
90 Degree Head

CAUTION

Head must be locked firmly before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA. GAS LENS	45V0204S	45V116S	45V64S	995795S	

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

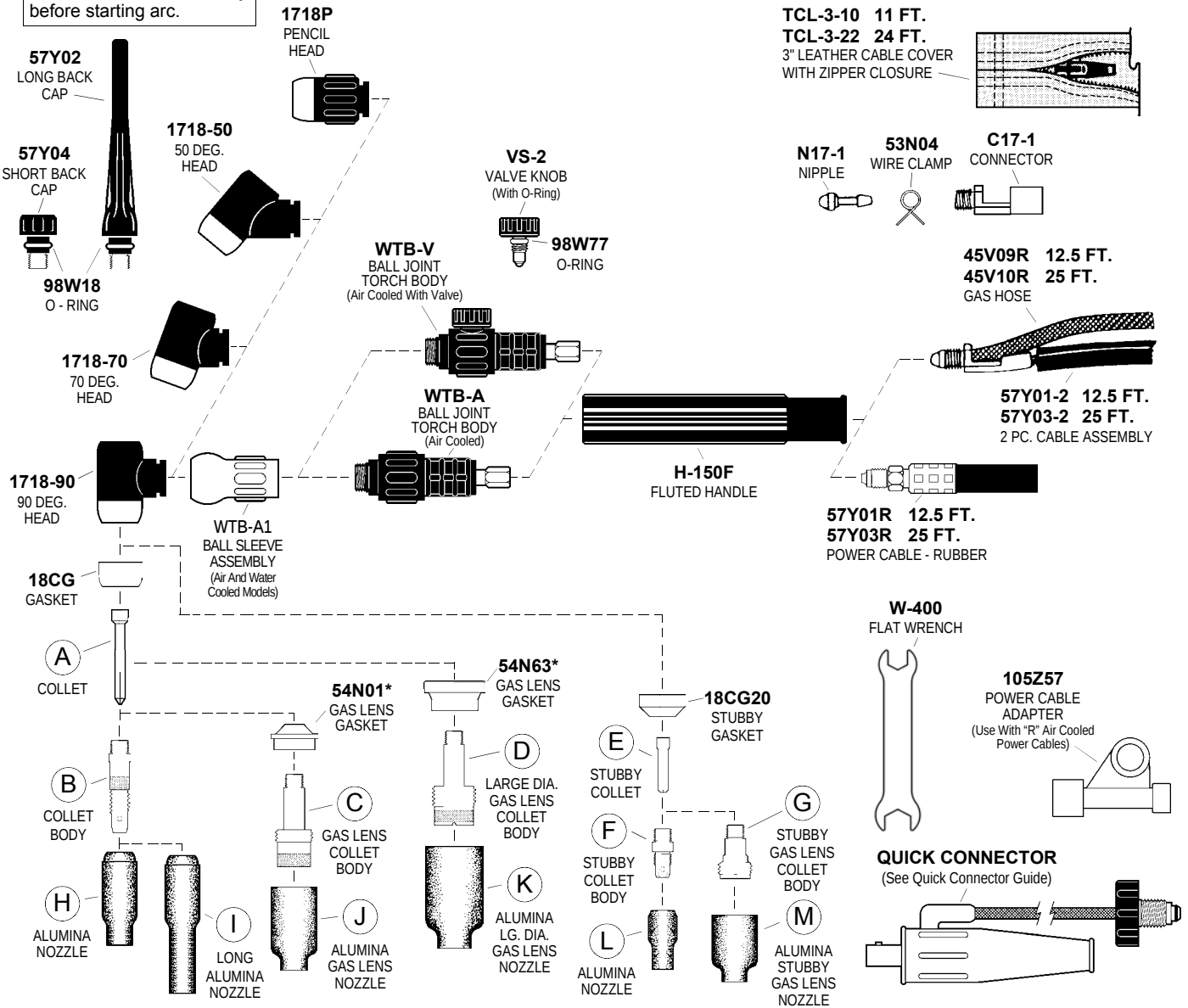
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

CAUTION
Head must be locked firmly
before starting arc.



COPYRIGHT 2001 - 2009 TEC TORCH CO. INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA. GAS LENS	45V0204		45V116	45V64	995795
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY	17CB20				
G	STUBBY GAS LENS	45V29S	45V24S	45V25S	45V26S	45V27S

Specifications and descriptions subject to change without notice.

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

* Must be used together with 18CG gasket.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

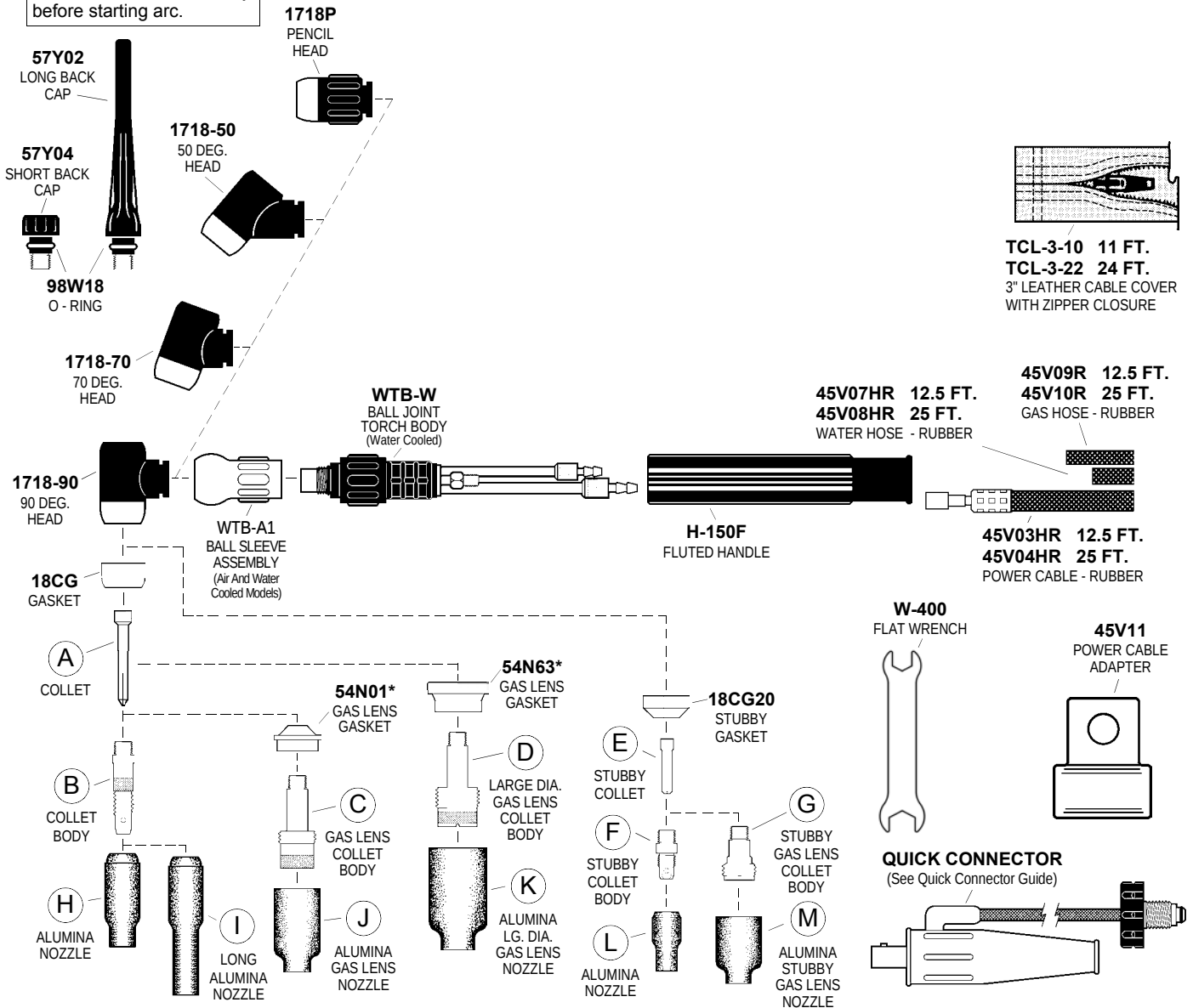
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

CAUTION
Head must be locked firmly
before starting arc.



COPYRIGHT 2001 - 2009 TEC TORCH CO. INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0
A	COLLET	10N21	10N22	10N23	10N24	10N25	54N20
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28	406488
C	GAS LENS	45V29	45V24	45V25	45V26	45V27	45V28
D	LG. DIA GAS LENS	45V0204		45V116	45V64	995795	45V63
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S	54N20S
F	STUBBY COLLET BODY	17CB20					—
G	STUBBY GAS LENS	45V29S	45V24S	45V25S	45V26S	45V27S	45V28S

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

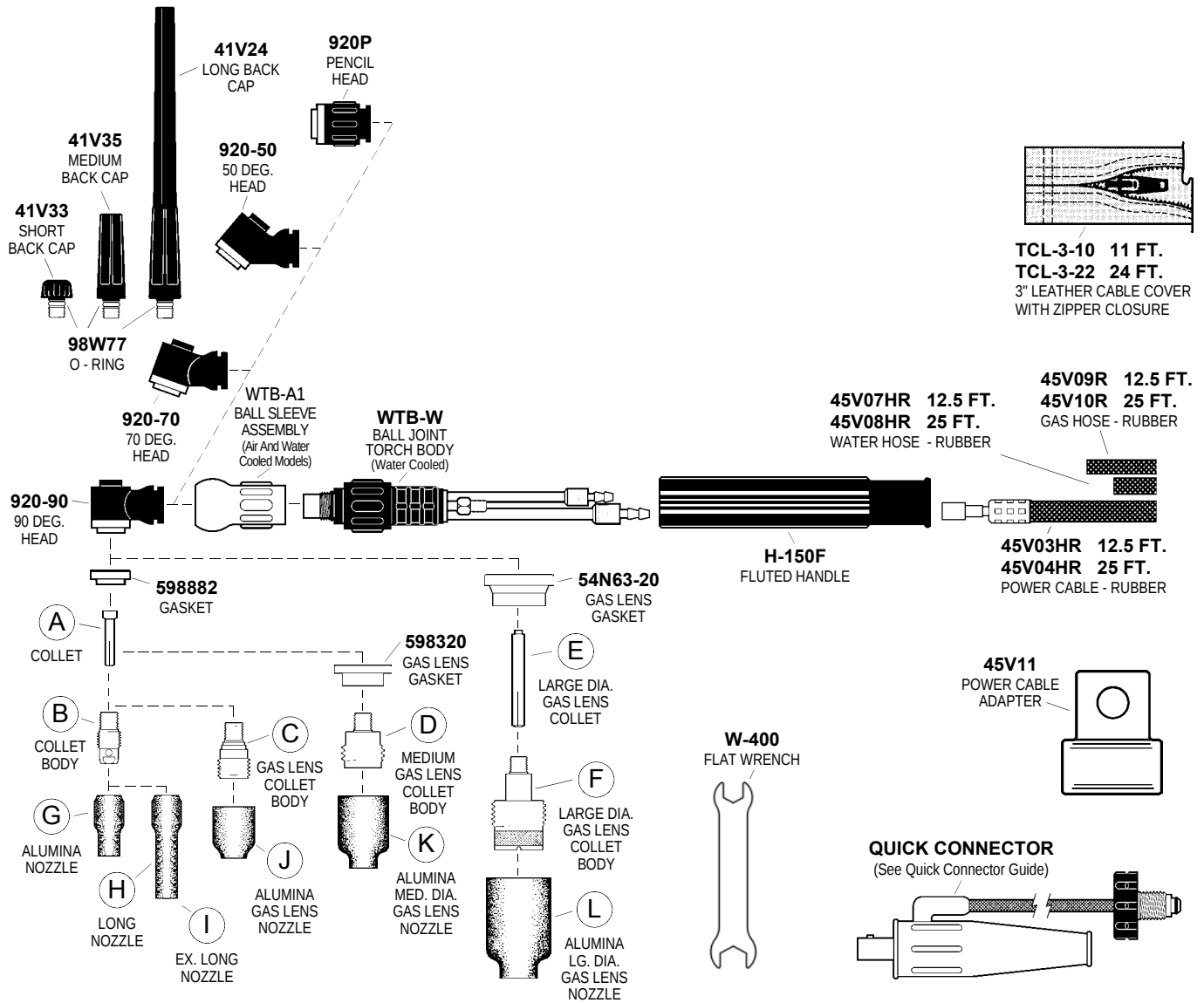
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION D

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA. GAS LENS	45V0204S	45V116S	45V64S	99S795S	

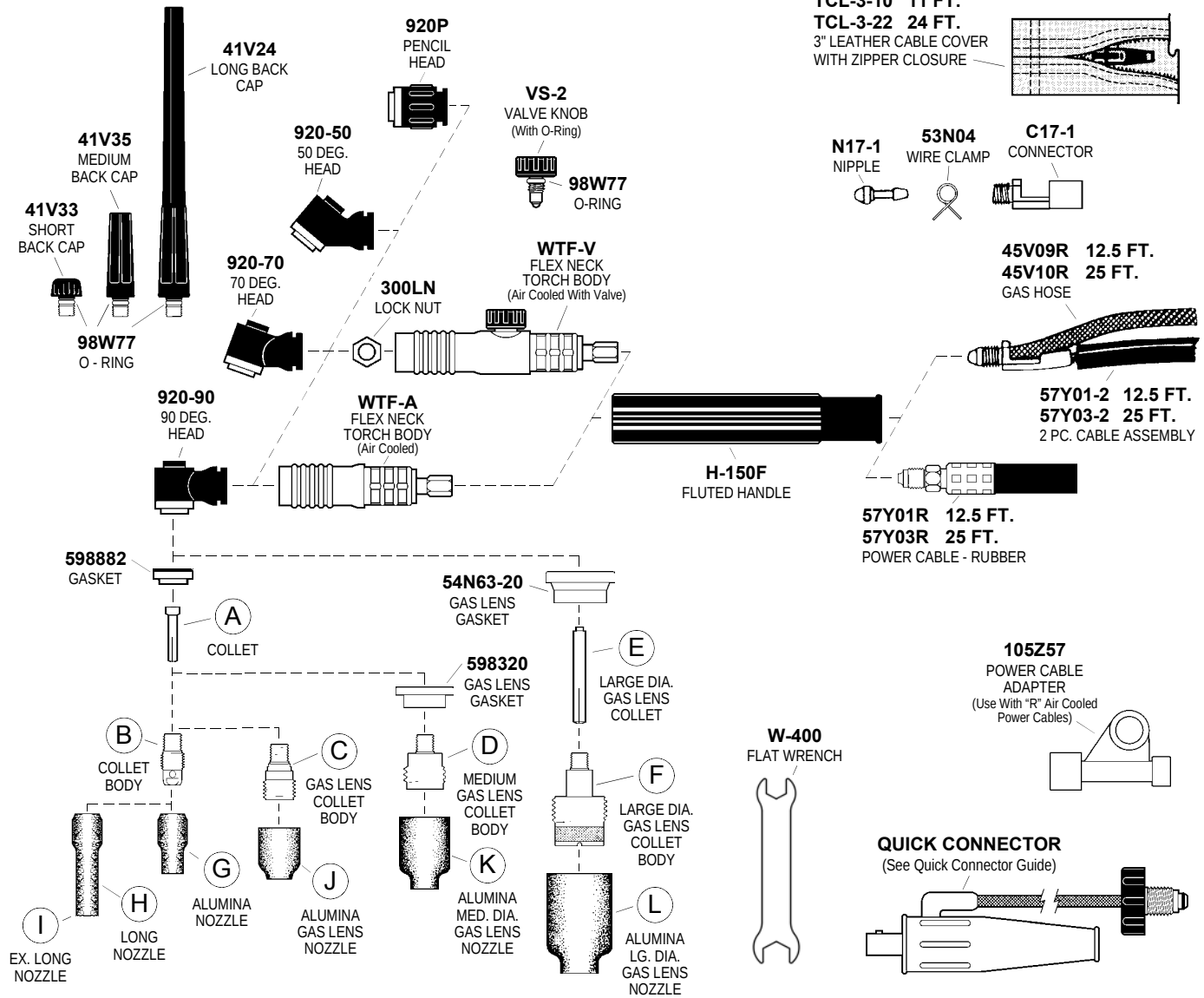
GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA GAS LENS	45V0204S	45V116S	45V64S	995795S	

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

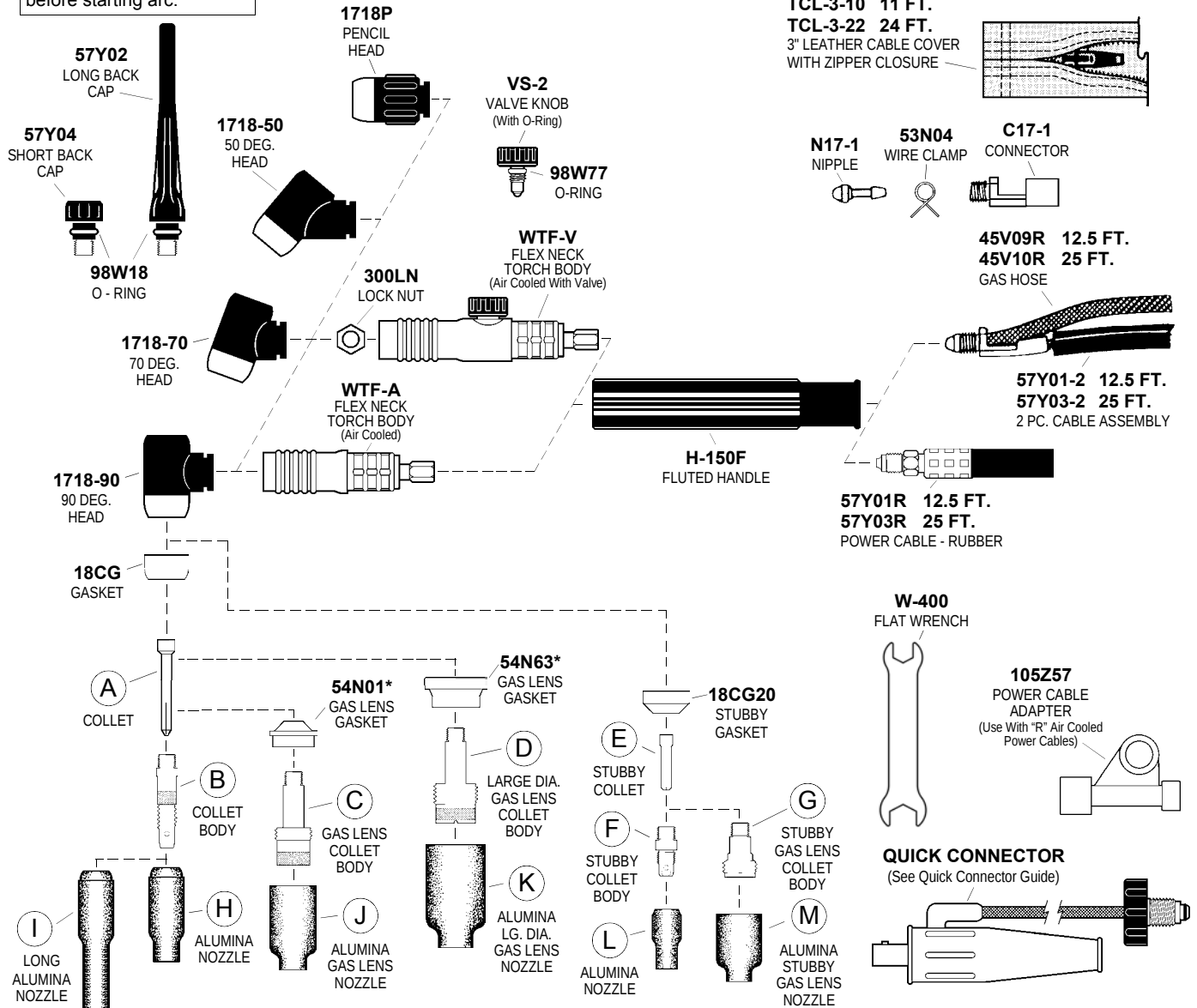
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA GAS LENS	45V0204		45V116	45V64	995795
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY	17CB20				
G	STUBBY GAS LENS	45V29S	45V24S	45V25S	45V26S	45V27S

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

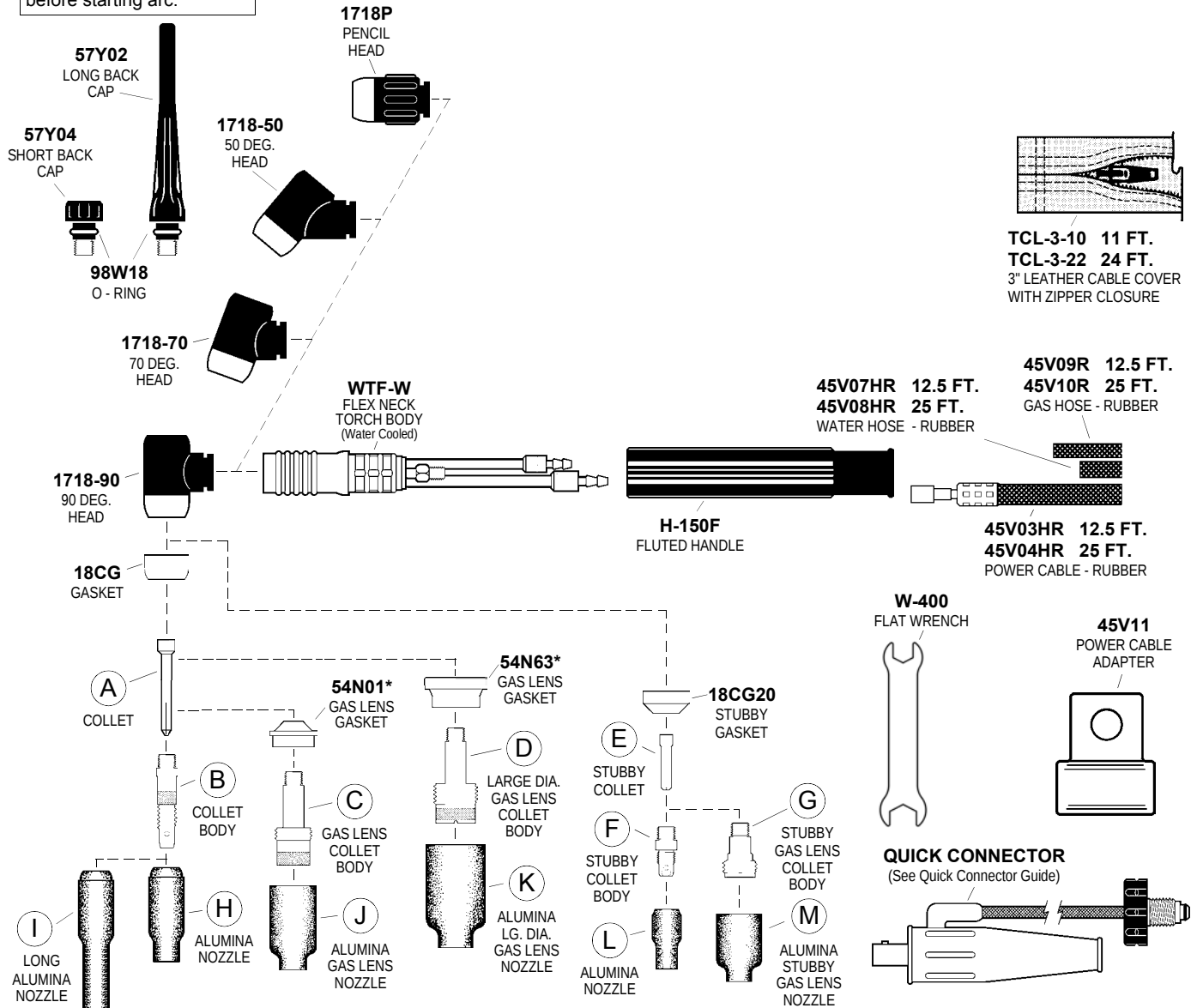
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0
A	COLLET	10N21	10N22	10N23	10N24	10N25	54N20
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28	406488
C	GAS LENS	45V29	45V24	45V25	45V26	45V27	45V28
D	LG. DIA. GAS LENS	45V0204		45V116	45V64	995795	45V63
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S	54N20S
F	STUBBY COLLET BODY	17CB20					—
G	STUBBY GAS LENS	45V29S	45V24S	45V25S	45V26S	45V27S	45V28S

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

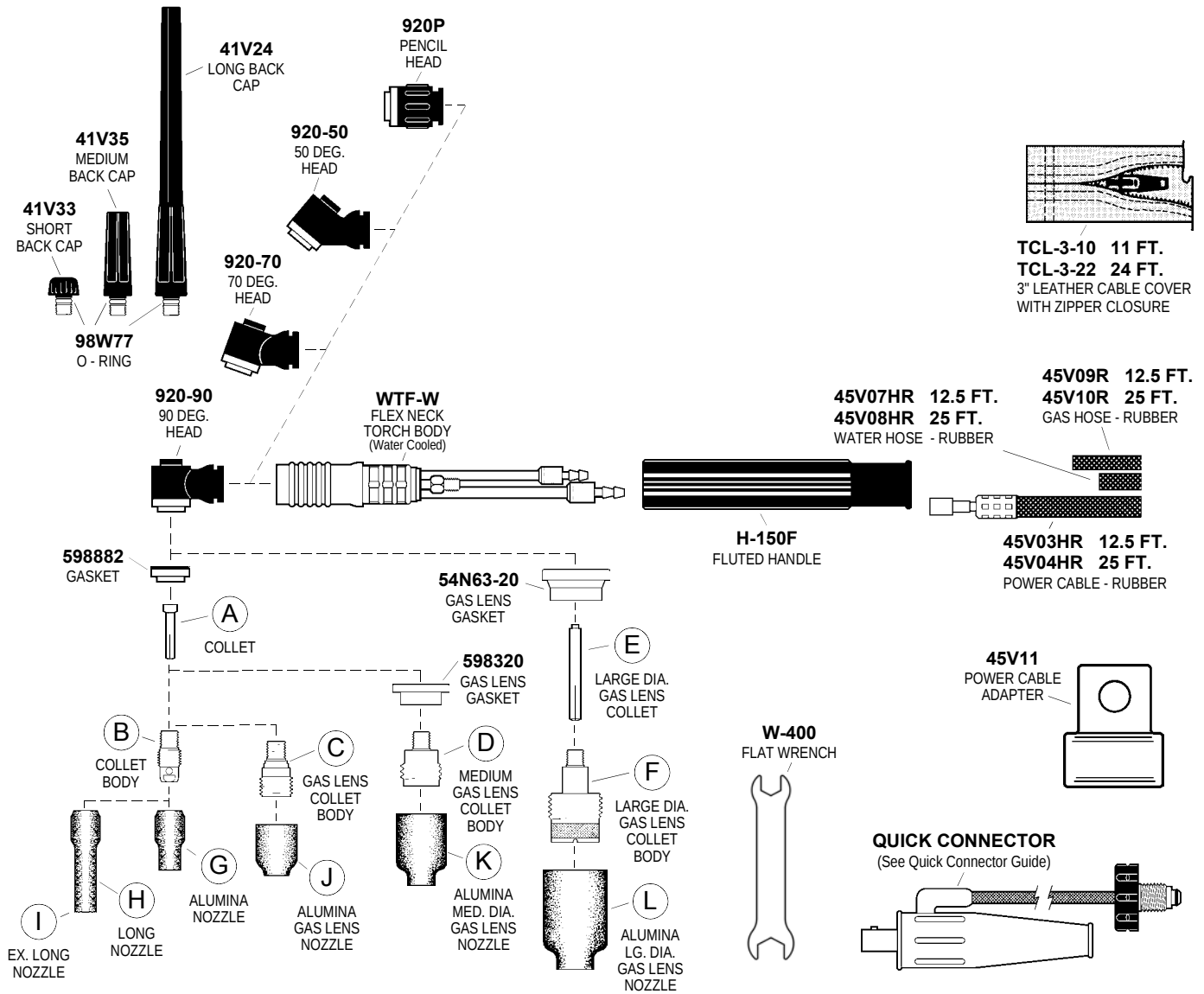
Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121
www.tectorch.com e-mail info@tectorch.com www.weldtec.com

REVISION C

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA GAS LENS	45V0204S	45V116S	45V64S	995795S	

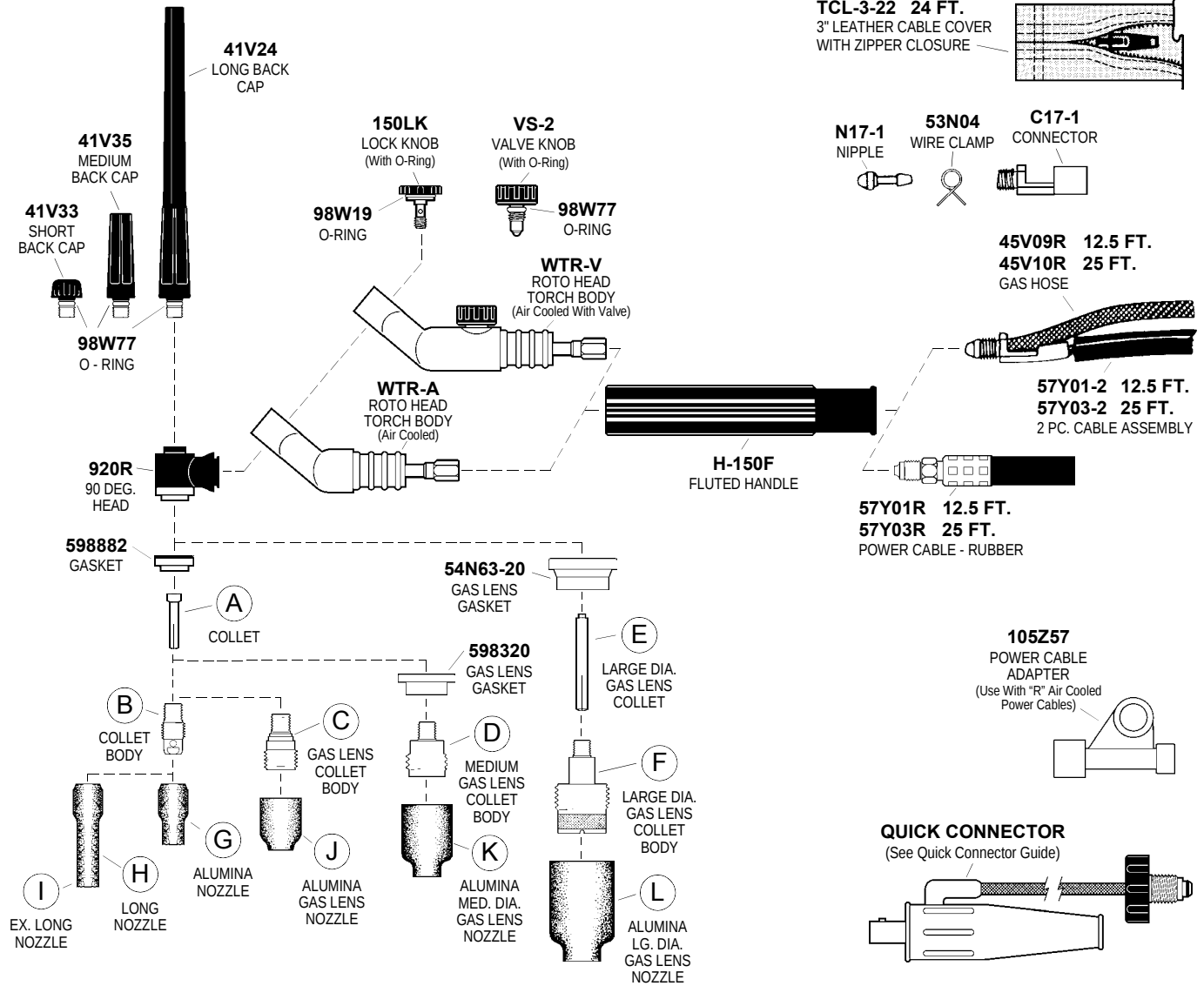
GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

CAUTION
Head must be locked firmly
before starting arc.



COPYRIGHT 2002 - 2007 TEC TORCH CO. INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA. GAS LENS	45V0204S		45V116S	45V64S	995795S

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

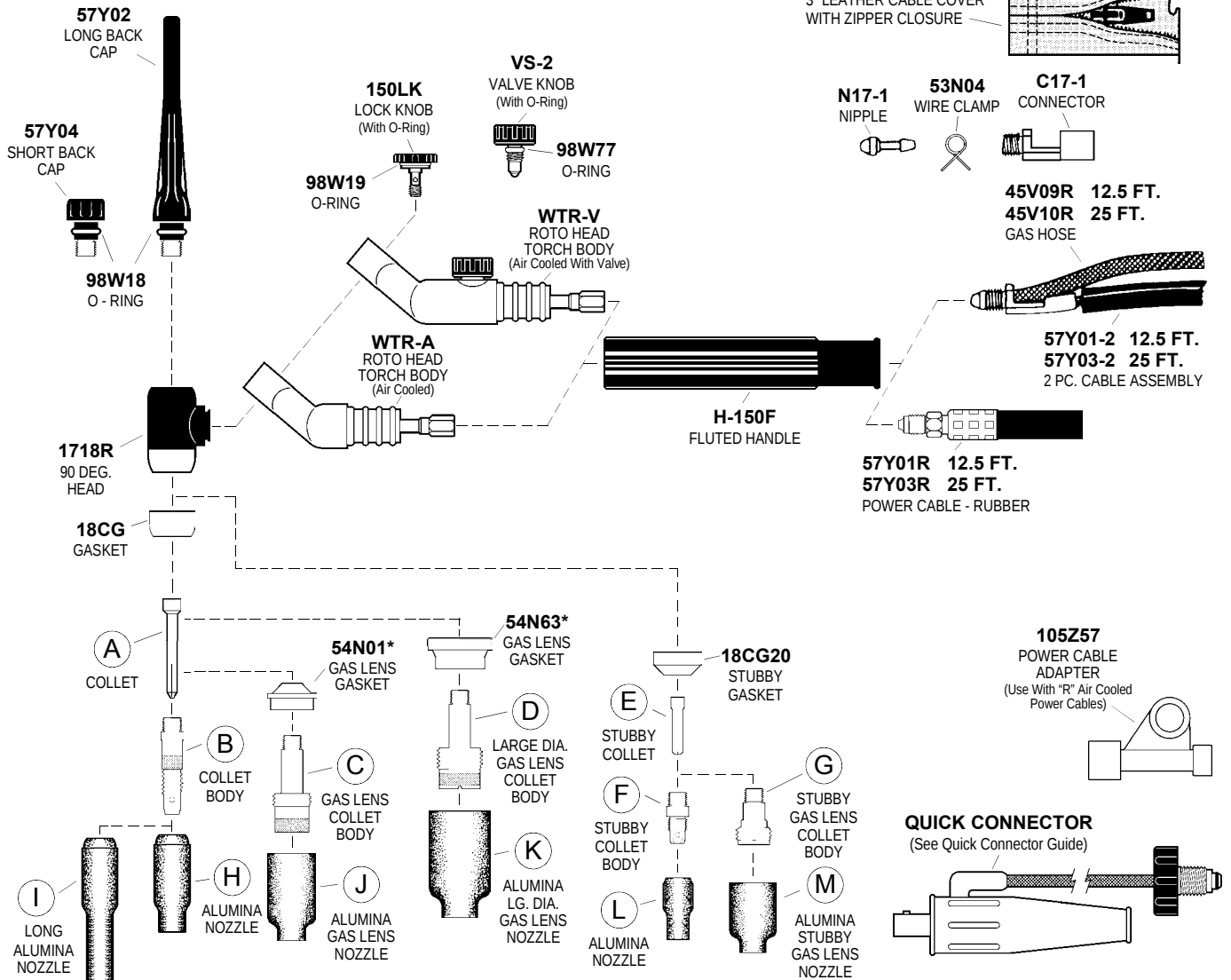
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION D

CAUTION
Head must be locked firmly
before starting arc.



COPYRIGHT 2002 - 2007 TEC TORCH CO. INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA. GAS LENS	45V0204		45V116	45V64	995795
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY	17CB20				
G	STUBBY GAS LENS	45V29S	45V24S	45V25S	45V26S	45V27S

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

* #15 53N89 15/16" ID X 1 7/8" Long

Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

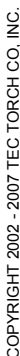
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION D

Head must be locked firmly before starting arc.



* Must be used together with 18CG gasket.

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
H	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
I	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
K	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
L	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—
M	ALUMINA STUBBY GAS LENS	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—

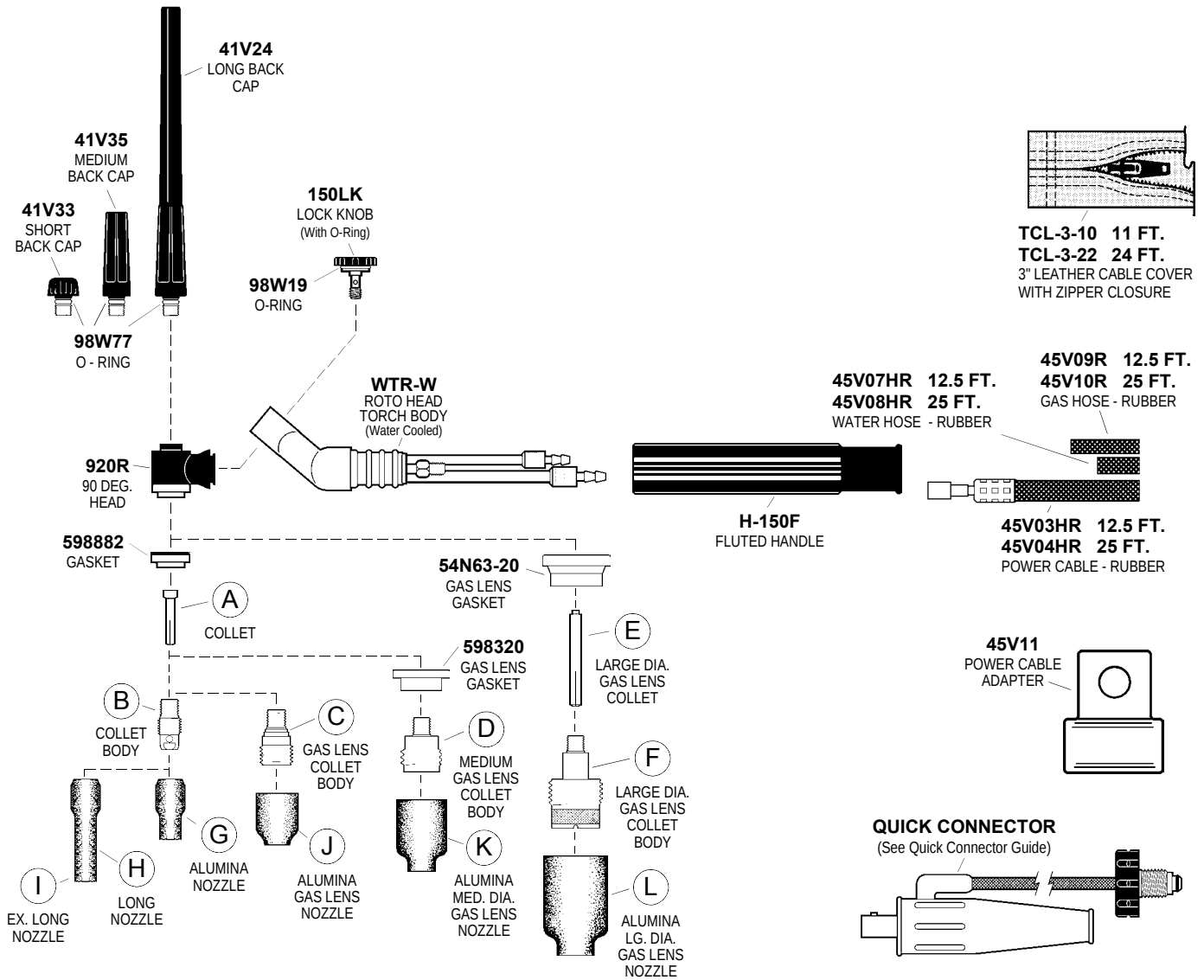
Specifications and descriptions subject to change without notice.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

REVISION B

CAUTION
Head must be locked firmly
before starting arc.



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA. GAS LENS	45V0204S	45V116S	45V64S	995795S	

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

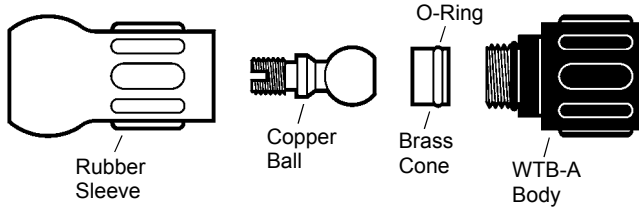
Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

WTB-A1 Ball Sleeve Assembly

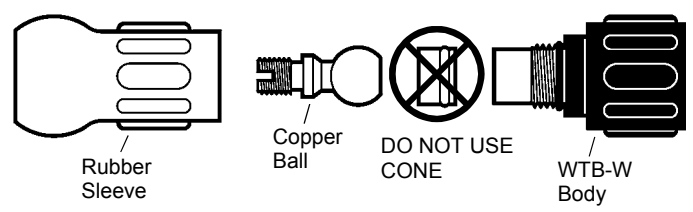
Air Cooled

Torches: WTB-9, 9V, 17, 17V



Water Cooled - NEW STYLE

Torches: WTB-18, 20 (Extended Nose Body)

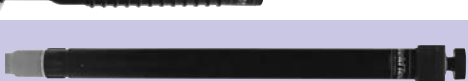


11/1/07

TEC TORCH COMPANY, INC. • P.O. BOX 1870 SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121
www.tectorch.com e-mail info@tectorch.com www.weldtec.com

WeldTec® TIG TORCHES

AIR COOLED

	Torch Model	Torch Package	Capacity Amps*	Features	Electrode Sizes	Access. Kit
	WT-9	WT-9-12R WT-9-12-2 WT-9-25R WT-9-25-2	125	Standard Model	.020" - 3/32"	AK-1
	WT-9F	WT-9F-12R WT-9F-12-2 WT-9F-25R WT-9F-25-2	125	Flex Head Model	.020" - 3/32"	AK-1
	WT-9FV	WT-9FV-12R WT-9FV-12-2 WT-9FV-25R WT-9FV-25-2	125	Flex Head with Valve	.020" - 3/32"	AK-1
	WT-9P	WT-9P-12R WT-9P-12-2 WT-9P-25R WT-9P-25-2	125	Pencil Model	.020" - 3/32"	AK-1A
	WT-9V	WT-9V-12R WT-9V-12-2 WT-9V-25R WT-9V-25-2	125	Built-in Gas Valve	.020" - 3/32"	AK-1
	WT-17	WT-17-12R WT-17-12-2 WT-17-25R WT-17-25-2	150	Standard Model	.020" - 1/8"	AK-2
	WT-17F	WT-17F-12R WT-17F-12-2 WT-17F-25R WT-17F-25-2	150	Flex Head Model	.020" - 1/8"	AK-2
	WT-17FV	WT-17FV-12R WT-17FV-12-2 WT-17FV-25R WT-17FV-25-2	150	Flex Head with Valve	.020" - 1/8"	AK-2
	WT-17V	WT-17V-12R WT-17V-12-2 WT-17V-25R WT-17V-25-2	150	Built-in Gas Valve	.020" - 1/8"	AK-2
	WT-23 A,B	Request Data Sheet A = 7" B = 14"	130	20 Style Machine Models	.020" - 1/8"	AK-23
	WT-24	WT-24-12R WT-24-12-2 WT-24-25R WT-24-25-2	80	Small Head Model	.020" - 1/16"	AK-5
	WT-24F	WT-24F-12R WT-24F-12-2 WT-24F-25R WT-24F-25-2	80	Flex Head Model	.020" - 1/16"	AK-5
	WT-24FV	WT-24FV-12R WT-24FV-12-2 WT-24FV-25R WT-24FV-25-2	80	Flex Head with Valve	.020" - 1/16"	AK-5
	WT-24V	WT-24V-12R WT-24V-12-2 WT-24V-25R WT-24V-25-2	80	Built-in Gas Valve	.020" - 1/16"	AK-5
	WT-26	WT-26-12R WT-26-12-2 WT-26-25R WT-26-25-2	200	Standard Model	.020" - 1/8"	AK-3
	WT-26F	WT-26F-12R WT-26F-12-2 WT-26F-25R WT-26F-25-2	200	Flex Head Model	.020" - 1/8"	AK-3
	WT-26FV	WT-26FV-12R WT-26FV-12-2 WT-26FV-25R WT-26FV-25-2	200	Flex Head with Valve	.020" - 1/8"	AK-3
	WT-26P	WT-26P-12R WT-26P-12-2 WT-26P-25R WT-26P-25-2	200	Pencil Model	.020" - 1/8"	AK-3A
	WT-26V	WT-26V-12R WT-26V-12-2 WT-26V-25R WT-26V-25-2	200	Built-in Gas Valve	.020" - 1/8"	AK-3
	WT-27 A,B,C	Request Data Sheet	200	A = 9" B = 20" C = Robotic	.040" - 1/4"	AK-27
	WT-29 A,B	Request Data Sheet A = 7" B = 14"	180	18 Style Machine Models	.020" - 5/32"	AK-29

"V" indicates built-in gas valve. "F" indicates flexible head.
"R" = flexible rubber cable & hose assembly.

"FV" indicates flex head and built-in gas valve.
-2 = 2 piece cable and hose assembly.

*AC or DCSP

TEC TORCH COMPANY, Inc. • P.O. BOX 1870 • San Marcos, CA 92079 • www.weldtec.com • (800) 258-9353

WeldTec® TIG TORCHES

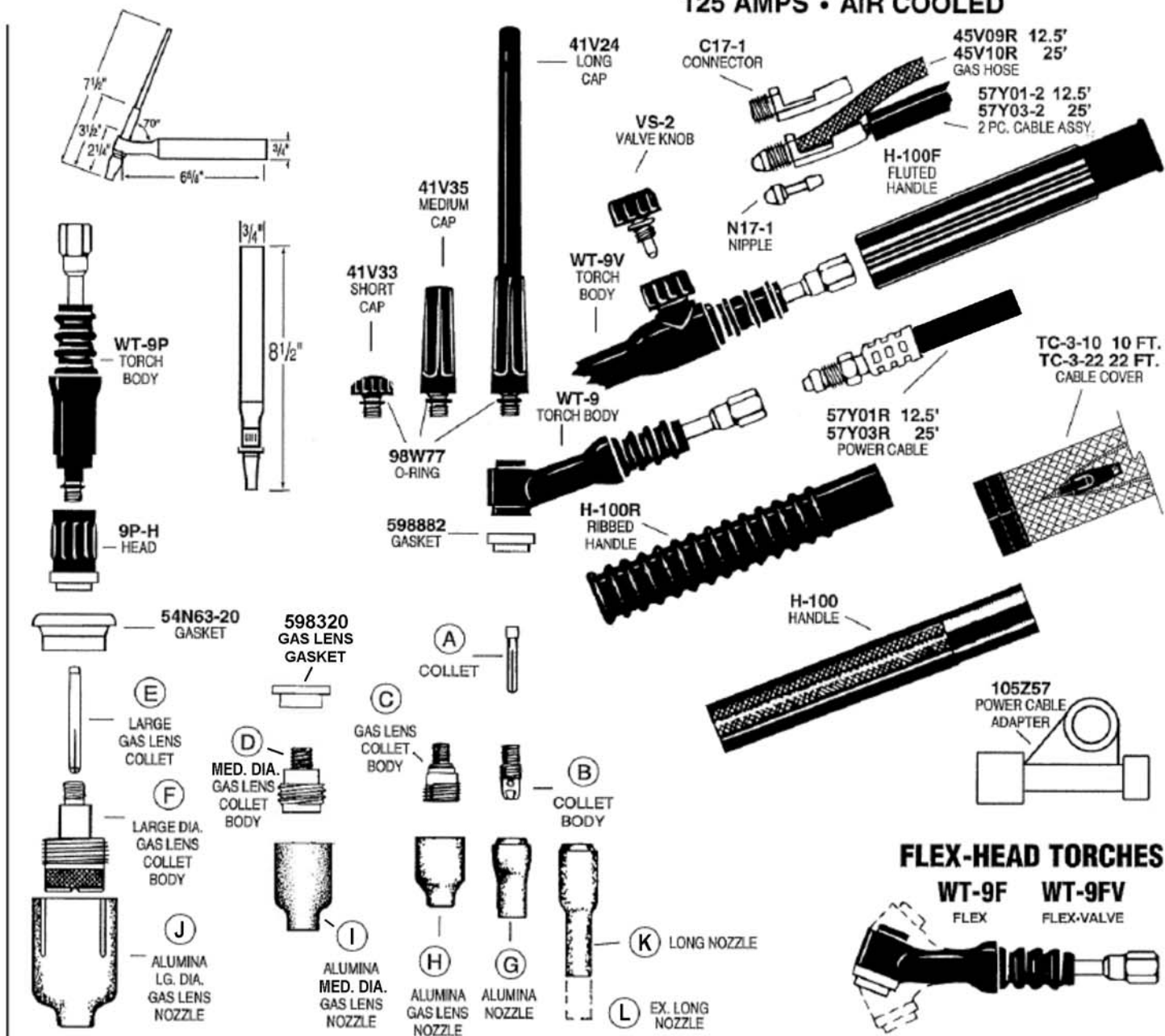
WATER COOLED

	Torch Model	Torch Package	Capacity Amps*	Features	Electrode Sizes	Access. Kit
	WT-18	WT-18-12 WT-18-12R WT-18-25 WT-18-25R	350	Standard Model	.020" - 5/32"	AK-3
	WT-18SP	WT-18SP-12 WT-18SP-12R WT-18SP-25 WT-18SP-25R	350	Pencil Model	.020" - 5/32"	AK-3A
	WT-18SPM	WT-18SPM-12 WT-18SPM-25	350	Machine Torch	.020" - 5/32"	AK-3A
	WT-18V	WT-18V-12 WT-18V-12R WT-18V-25 WT-18V-25R	350	Built-in Gas Valve	.020" - 5/32"	AK-3
	WT-20	WT-20-12 WT-20-12R WT-20-25 WT-20-25R	250	Standard Model	.020" - 1/8"	AK-4
	WT-20F	WT-20F-12 WT-20F-12R WT-20F-25 WT-20F-25R	225	Flex Head Model	.020" - 1/8"	AK-4
	WT-20H	WT-20H-12 WT-20H-12R WT-20H-25 WT-20H-25R	300	Heavy Duty Model	.020" - 5/32"	AK-4
	WT-20P	WT-20P-12 WT-20P-12R WT-20P-25 WT-20P-25R	225	Pencil Model	.020" - 1/8"	AK-4A
	WT-20V	WT-20V-12 WT-20V-12R WT-20V-25 WT-20V-25R	250	Built-in Gas Valve	.020" - 1/8"	AK-A
	WT-22 A,B	Request Data Sheet A = 7" B = 14"	260	20 Style Machine Models	.020" - 1/8"	AK-22
	WT-24W	WT-24W-12 WT-24W-12R WT-24W-25 WT-24W-25R	180	Small Head Model	.020" - 3/32"	AK-5W
	WT-24WF	WT-24WF-12 WT-24WF-12R WT-24WF-25 WT-24WF-25R	180	Flex Head Model	.020" - 3/32"	AK-5W
	WT-25	WT-25-12 WT-25-12R WT-25-25 WT-25-25R	225	Flex Neck Pencil	.020" - 1/8"	AK-4A
	WT-27AW	Request Data Sheet	500	9" Machine Model	.040" - 1/4"	AK-27
	WT-27BW	Request Data Sheet	500	20" Machine Model	.040" - 1/4"	AK-27
	WT-27CW	Request Data Sheet	500	9" Robotic Model	.040" - 1/4"	AK-27
	WT-28 A,B	Request Data Sheet A = 7" B = 14"	350	18 Style Machine Models	.020" - 5/32"	AK-28

"V" indicates built-in gas valve. "F" indicates flexible head.
"R" = flexible rubber cable & hose assembly.

*AC or DCSP

TEC TORCH COMPANY, Inc. • P.O. BOX 1870 • San Marcos, CA 92079 • www.weldtec.com • (800) 258-9353



FLEX-HEAD TORCHES

WT-9F FLEX WT-9FV FLEX-VALVE

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4
A	COLLET	13N20	13N21	13N22	13N23
B	COLLET BODY	13N25	13N26	13N27	13N28
C	GAS LENS	45V41	45V42	45V43	45V44
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L
F	LG. DIA. GAS LENS	45V0204S	45V116S	45V64S	—

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
I	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
J	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87
K	LONG 17/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
L	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—

ACCESSORY KIT AK-1 (WT-9, 9V, 9F, 9FV)

CONTAINS: LONG CAP, 2 - COLLETS, 2 - COLLET BODIES, 3 - NOZZLES, 2 - TUNGSTEN ELECTRODES.

ACCESSORY KIT AK-1A (WT-9P)

CONTAINS: AK-1 LESS LONG CAP.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC.

P.O. BOX 1870 • SAN MARCOS, CALIF. 92079

(760) 747-3700 • FAX (760) 747-2121

150AMPS • AIR COOLED



REVISION E

WeldTec®

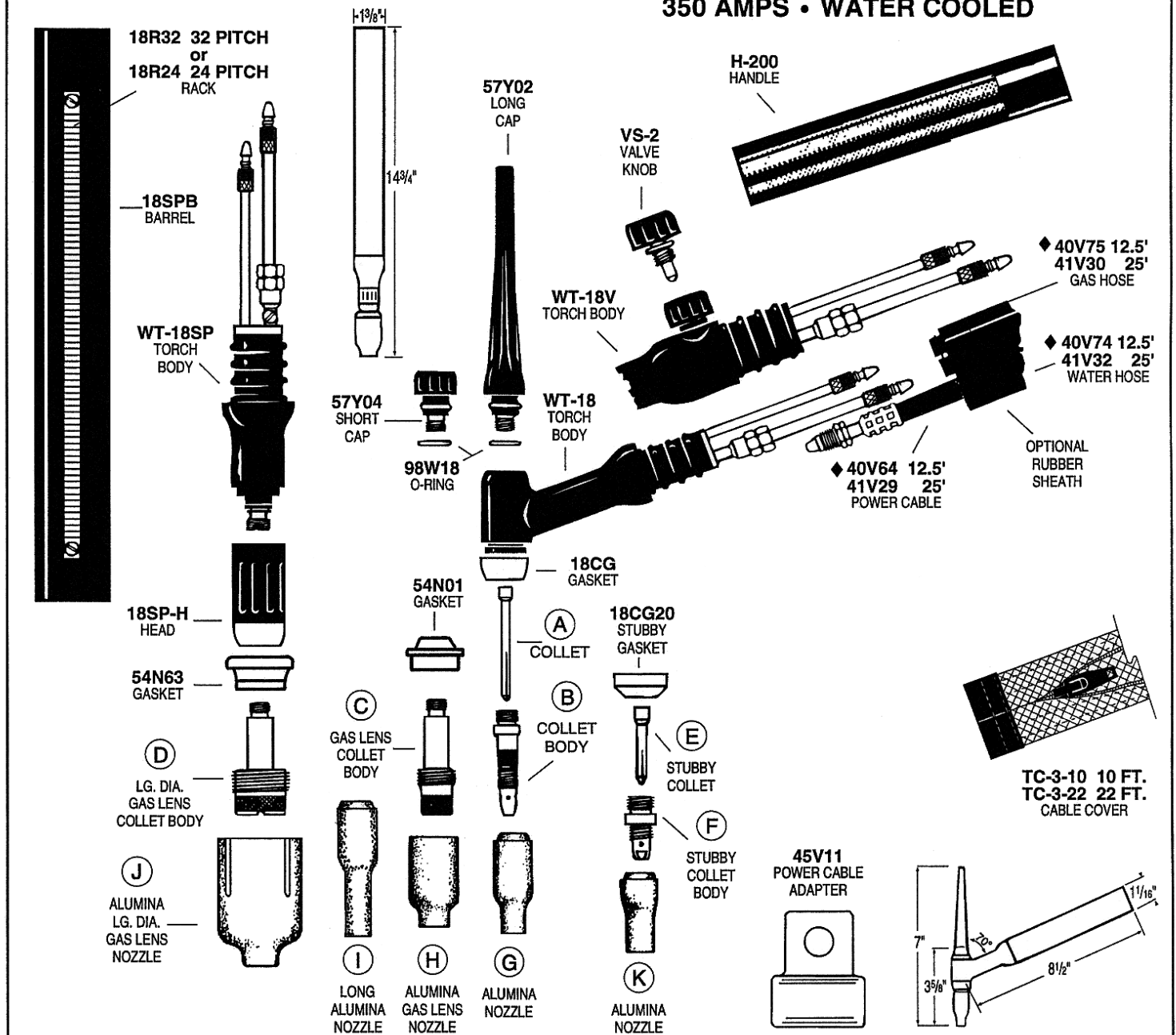
WT-18 • WT-18SP • WT-18V

STD.

PENCIL

VALVE

350 AMPS • WATER COOLED



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0
A	COLLET	10N21	10N22	10N23	10N24	10N25	54N20
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28	406488
C	GAS LENS	45V29	45V24	45V25	45V26	45V27	45V28
D	LG. DIA. GAS LENS	45V0204		45V116	45V64	995795	45V63
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S	—
F	STUBBY COLLET BODY	17CB20					

GAS NOZZLES

ITEM	SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	12 3/4"	SHORT
G	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
H	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	—	54N19
I	LONG ALUMINA	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	53N87	53N89
K	ALUMINA NOZZLE	13N08	13N09	13N10	13N11	13N12	13N13	—	—

ACCESSORY KIT AK-3 (WT-18, 18V)

CONTAINS: SHORT CAP, 3 - COLLETS, 3 - COLLET BODIES, 3 - NOZZLES, 3 - TUNGSTEN ELECTRODES.

ACCESSORY KIT AK-3A (WT-18SP)

SAME AS AK-3 LESS SHORT CAP.

♦ OPTIONAL SOFT FLEXIBLE RUBBER HOSES AND POWER CABLES ARE AVAILABLE BY ADDING "R" TO END OF PART NUMBER. CABLE COVER STRONGLY RECOMMENDED.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC.

P.O. BOX 1870 • SAN MARCOS, CALIF. 92079 • (760) 747-3700 • FAX (760) 747-2121

WeldTec®

WT-20 • WT-20F • WT-20H • WT-20P • WT-20V



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0
A	COLLET	13N20	13N21	13N22	13N23	13N24	13NC532
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29	13NCB532
C	GAS LENS	45V41	45V42	45V43	45V44	45V45	—
D	MED. DIA. GAS LENS	—	—	45V35SW	45V36SW	45V37SW	45V38SW
E	LG. DIA GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L	—
F	LG. DIA. GAS LENS	45V0204S		45V116S	45V64S	995795S	—

◆ OPTIONAL SOFT FLEXIBLE RUBBER HOSES AND POWER CABLES ARE AVAILABLE BY ADDING "R" TO END OF PART NUMBER. CABLE COVER STRONGLY RECOMMENDED.

GAS NOZZLES

ITEM	SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
I	ALUMINA MED. DIA. GAS LENS	—	—	—	54N16SW	54N15SW	54N14SW	54N12SW	54N19	—
J	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87
K	LONG 1 1/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
L	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—

CONTAINS: LONG CAP, 3 - COLLETS, 3 - COLLET BODIES, 3 - NOZZLES, 3 - TUNGSTEN ELECTRODES.

CONTAINS: AK-4 LESS LONG CAP.

TEC TORCH COMPANY, INC.

P.O. BOX 1870 ■ SAN MARCOS, CALIF. 92079

▪ (760) 747-3700 ▪ FAX (760) 747-2121

REVISION E

WeldTec®

WT-24 • WT-24F • WT-24FV • WT-24V

STD.

FLEX

FLEX-VALVE

VALVE

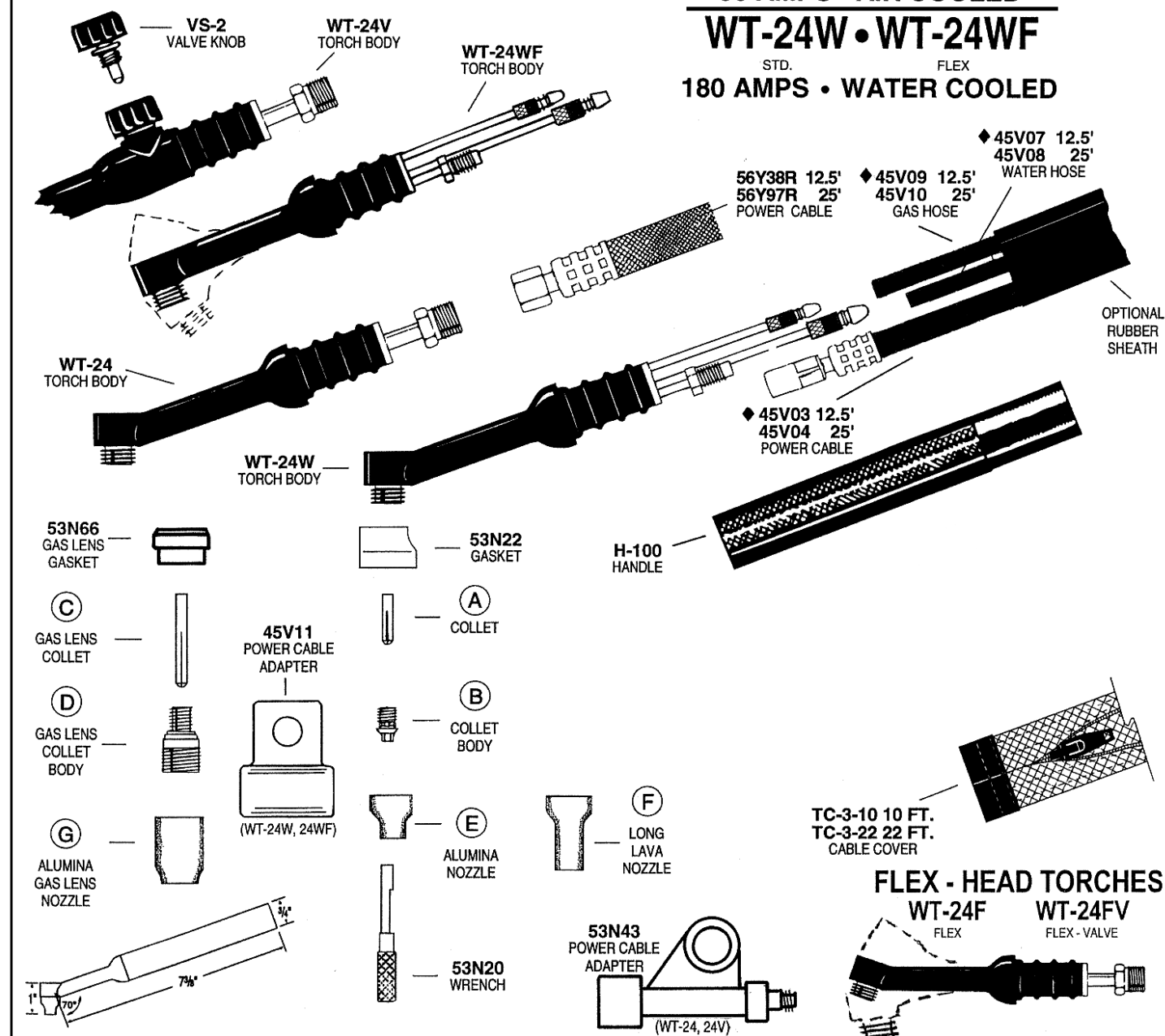
80 AMPS • AIR COOLED

WT-24W • WT-24WF

STD.

FLEX

180 AMPS • WATER COOLED



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4
A	COLLET	53N15	53N16	53N14	24C332
B	COLLET BODY	53N17	53N18	53N19	24CB332
C	GAS LENS COLLET	53N62	53N63	53N64	24GLC332
D	GAS LENS	45V41	45V42	45V43	45V44

♦ OPTIONAL SOFT FLEXIBLE RUBBER HOSES AND POWER CABLES ARE AVAILABLE BY ADDING "R" TO END OF PART NUMBER. CABLE COVER STRONGLY RECOMMENDED.

GAS NOZZLES

ITEM	SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"
E	ALUMINA	53N24A	53N25A	53N27A	—
F	LONG LAVA	53N28	—	53N26	—
G	ALUMINA GAS LENS	53N58	53N59	53N60	53N61

ACCESSORY KIT AK-5 (WT-24, 24F, 24FV, 24V)

CONTAINS: 2 - COLLETS, 2 - COLLET BODIES, 3 - NOZZLES, 1 - WRENCH, 2 - TUNGSTEN ELECTRODES.

ACCESSORY KIT AK-5W (WT-24W, 24WF)

CONTAINS: 3 - COLLETS, 3 - COLLET BODIES, 3 - NOZZLES, 1 - WRENCH, 3 - TUNGSTEN ELECTRODES.

MANUFACTURED IN USA

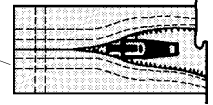
TEC TORCH COMPANY, INC.

P.O. BOX 1870 • SAN MARCOS, CALIF. 92079 • (760) 747-3700 • FAX (760) 747-2121

REVISION F

COPYRIGHT 1994 TEC TORCH CO. INC.

TC-3-10 11 FT.
TC-3-22 24 FT.
3" NYLON CABLE COVER
WITH ZIPPER CLOSURE



45V07R 12.5 FT.
45V08R 25 FT.
WATER HOSE - RUBBER

45V09R 12.5 FT.
45V10R 25 FT.
GAS HOSE - RUBBER

45V03R 12.5 FT.
45V04R 25 FT.
POWER CABLE - RUBBER

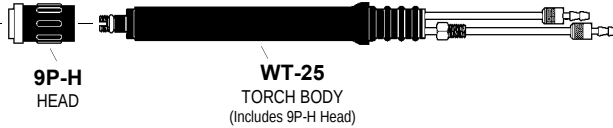
45V09 12.5 FT.
45V10 25 FT.
GAS HOSE - VINYL

45V07 12.5 FT.
45V08 25 FT.
WATER HOSE - VINYL

45V03 12.5 FT.
45V04 25 FT.
POWER CABLE - VINYL

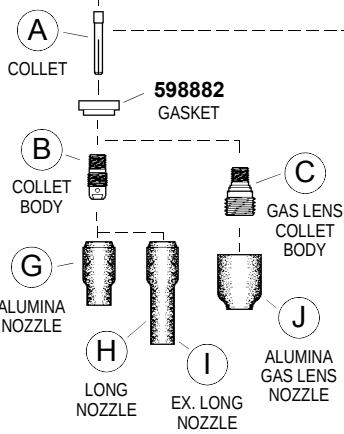


H-100
HANDLE



9P-H
HEAD

WT-25
TORCH BODY
(Includes 9P-H Head)



A
COLLET

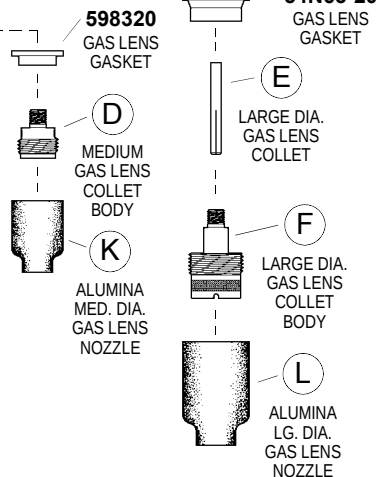
B
COLLET
BODY

G
ALUMINA
NOZZLE

H
LONG
NOZZLE

I
EX. LONG
NOZZLE

J
ALUMINA
GAS LENS
NOZZLE



C
GAS LENS
COLLET
BODY

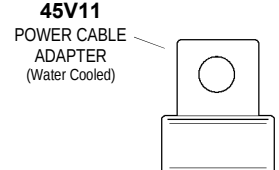
D
MEDIUM
GAS LENS
COLLET
BODY

K
ALUMINA
MED. DIA.
GAS LENS
NOZZLE

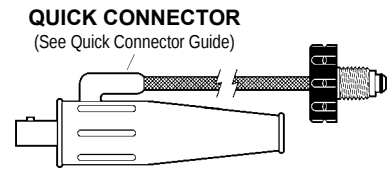
E
LARGE DIA.
GAS LENS
COLLET

F
LARGE DIA.
GAS LENS
COLLET
BODY

L
ALUMINA
LG. DIA.
GAS LENS
NOZZLE



45V11
POWER CABLE
ADAPTER
(Water Cooled)



QUICK CONNECTOR
(See Quick Connector Guide)

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA GAS LENS	45V0204S		45V116S	45V64S	995795S

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 1 7/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	—	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

Specifications and descriptions subject to change without notice.

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION B

WT-26 • WT-26F • WT-26FV • WT-26P • WT-26V

VALVE

WT-26P TORCH BODY

H-200 HANDLE

VS-1 VALVE KNOB

C26-1 CONNECTOR

N26-1 NIPPLE

WT-26V TORCH BODY

WT-26 TORCH BODY

46V28R 12.5' 46V30R 25' POWER CABLE

OPTIONAL RUBBER SHEATH

TC-3-10 10 FT. TC-3-22 22 FT. CABLE COVER

FLEX-HEAD TORCHES

WT-26F FLEX WT-26FV FLEX-VALVE

45V62 POWER CABLE ADAPTER

54N01 GASKET

18CG GASKET

(A) COLLET

(B) COLLET BODY

(G) ALUMINA NOZZLE

(H) ALUMINA GAS LENS NOZZLE

(I) LONG ALUMINA NOZZLE

(K) ALUMINA NOZZLE

(J) ALUMINA LG. DIA. GAS LENS NOZZLE

(C) GAS LENS COLLET BODY

(F) STUBBY COLLET BODY

(E) STUBBY COLLET

18CG20 STUBBY GASKET

54N63 GASKET

18SP-H HEAD

98W18 O-RING

57Y04 SHORT CAP

57Y02 LONG CAP

45V09R 12.5' 45V10R 25' GAS HOSE

46V28-2 12.5' 46V30-2 25' 2 PC. CABLE ASSY.

WT-26P TORCH BODY DIMENSIONS: 1 1/16" (top section), 11" (main body)

H-200 HANDLE DIMENSIONS: 7" (total length), 3 5/8" (lower section), 8 1/2" (upper section), 1 1/16" (tip diameter), 20° (tip angle)

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA. GAS LENS	45V0204		45V116	45V64	995795
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY			17CB20		

ITEM	SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	12 3/4"	SHORT
G	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	10N44	—
H	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	—	54N19
I	LONG ALUMINA	—	10N49L	10N48L	10N47L	—	—	—	—
J	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	53N87	53N89
K	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—

CONTAINS: SHORT CAP. 3 - COLLETS. 3 - COLLET BODIES. 3 - NOZZLES. 3 - TUNGSTEN ELECTRODES.

MANUFACTURED IN USA

TEC TORCH COMPANY, INC.

P.O. BOX 1870 • SAN MARCOS, CALIF. 92079 • (760) 747-3700 • FAX (760) 747-2121

REVISION D



Micro TIG Welding Torches

WeldTec® offers the most advanced micro welding TIG torches on the market . . . and now, flexible* neck models, both air cooled and water cooled.

When the WeldTec® design team introduced the micro torch to the market 25 years ago it first appeared as a 50 amp air cooled model. To meet the needs of today's welding challenges they reintroduce two new models, a 125 amp water cooled model and a 60 amp air cooled model. Both models share chucks and clear glass nozzles. They can be fitted with 180°, 45°/90° combo chucks (.040, 1/16, 3/32) and clear glass nozzles to handle the most difficult welding applications.

The standard torch neck length is 3-1/2 inches, the flexible neck model is 5 inches long. The standard non-flex models can be special made with a neck length as short as 2 inches to as long as 12 inches.

Access to difficult weld locations was never easier.

- Low profile design for access to tight locations.
- Flexible neck models.
- Interchangeable chucks and nozzles.
- Clear glass nozzles for better visibility.
- Low maintenance dual o-ring head design.
- Flexible - soft rubber hose and power cable options.
- Glove soft leather protective cable cover on DX models.

WT-60-12	12 1/2 ft. Torch Package - Vinyl	Standard Model	60 Amps Air Cooled
WT-60-25	25 ft. Torch Package - Vinyl		
WT-60-12SF	12 1/2 ft. Torch Package - Super Flex		
WT-60-25SF	25 ft. Torch Package - Super Flex		
WT-60F-12	12 1/2 ft. Torch Package - Vinyl	Flex Neck Model	
WT-60F-25	25 ft. Torch Package - Vinyl		
WT-60F-12SF	12 1/2 ft. Torch Package - Super Flex		
WT-60F-25SF	25 ft. Torch Package - Super Flex		
WT-125-12	12 1/2 ft. Torch Package - Vinyl	Standard Model	125 Amps Water Cooled
WT-125-25	25 ft. Torch Package - Vinyl		
WT-125-12R	12 1/2 ft. Torch Package - Super Flex		
WT-125-25R	25 ft. Torch Package - Super Flex		
WT-125-12DX	12 1/2 ft. Torch Package - Deluxe	Flex Neck Model	
WT-125-25DX	25 ft. Torch Package - Deluxe		
WT-125F-12	12 1/2 ft. Torch Package - Vinyl		
WT-125F-25	25 ft. Torch Package - Vinyl		
WT-125F-12R	12 1/2 ft. Torch Package - Super Flex		
WT-125F-25R	25 ft. Torch Package - Super Flex		
WT-125F-12DX	12 1/2 ft. Torch Package - Deluxe		
WT-125F-25DX	25 ft. Torch Package - Deluxe		

Standard: Vinyl - PVC plastic tubing.

Optional: Super Flex - soft over braided rubber tubing.

Deluxe: Soft over braided rubber tubing, leather cover, 1/16 combo chuck and 45 deg. nozzle.



WeldTec® - "where quality and innovation never ends"



Standard
3 1/2"

Flex Neck
5"

Specials
2" - 12"

Specifications subject to change without notice. *Flex neck models have a finite life and will work harden and fail after extensive or server flexing.

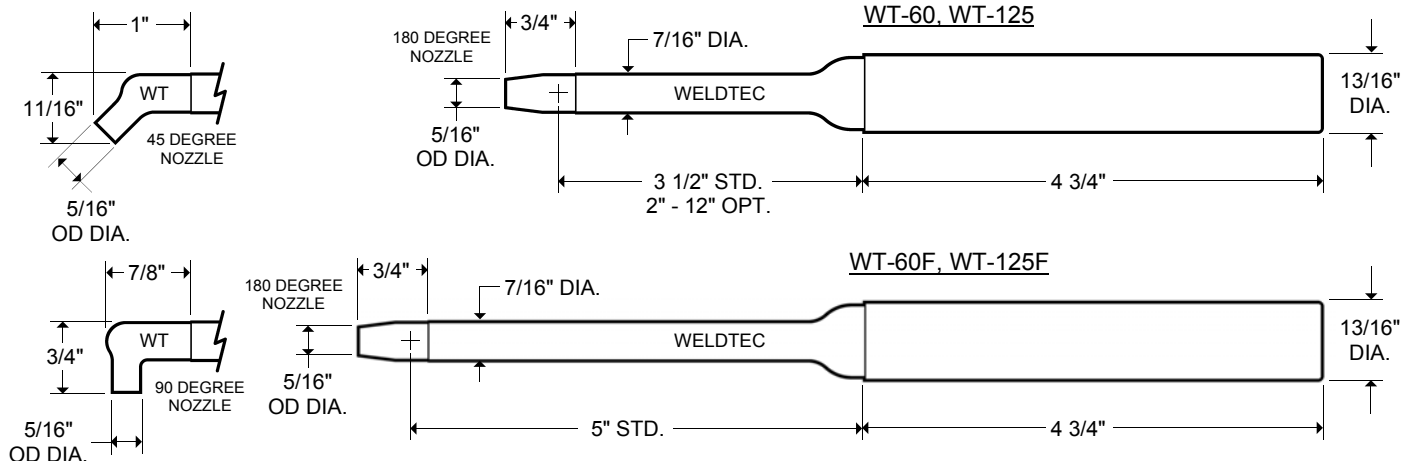
TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

COPYRIGHT 2010 TEC TORCH CO. INC.

www.tigtorch.com

e-mail info@tectorch.com

50 Years of TIG Innovation



SPECIFICATIONS

Maximum Amperage Capacity
Tungsten Size Capacity
Cooling Requirements
Maximum Coolant Pressure

WT-60, 60F

60 AMPS
.040 - 1/16 (1,0 - 1,6)
-
-

WT-125, 125F

125 AMPS
.040 - 3/32 (1,0 - 2,4)
1 Qt./Min. (.964L/Min.)
50 psi (345 Kpa)

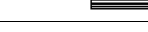
TUNGSTEN ELECTRODE LENGTHS

Angle	Std.		Min.		Max.	
	In.	mm	In.	mm	In.	mm
90°	.866	22	.787	20	.866	22
45°	.866	22	.866	22	.945	24
180°	.866	22	.748	19	1.182	30

GLASS NOZZLES

TORCH	LENGTH	ORIFICE IN mm	SIZE	PART NO.
WT-60, 60F, 125, 125F 	1"	1/4 6	4	125N45
WT-60, 60F, 125, 125F 	7/8"	1/4 6	4	125N90
WT-60, 60F, 125, 125F 	3/4"	1/4 6	4	125N180

REPLACEMENT PARTS

TORCH	DESCRIPTION	PART NO.
	Torch Body	WT-60
	Torch Body	WT-60F
	Handle	H-100
	Torch Body	WT-125
	Torch Body	WT-125F
	Handle	H-100B
WT-60, 60F, 125, 125F 	Chuck Wrench (Use with 180 deg. chuck)	53N20
WT-60, 60F, 125, 125F 	Torch Body O-Ring (2 Required) (Included on torch body)	98W77

CHUCKS

TORCH	ELECTRODE ANGLE	SIZE IN mm	PART NO.
WT-60, 60F, 125, 125F 	45 & 90 deg. Combo Chuck	.040 1,0 1/16 1,6 3/32 2,4	125C40C 125C116C 125C332C
WT-60, 60F, 125, 125F 	180 deg. Straight	.020 0,5 .040 1,0 1/16 1,6 3/32 2,4	125C20 125C40 125C116 125C332

POWER CABLE ADAPTERS

ADAPTERS	TORCH	PART NO.
 105Z57  45V11	WT-60, 60F WT-125, 125F	105Z57 45V11
 3538  3538GT	WT-60, 60F	3538 3538GT
 3578W  3578W-GT	WT-125, 125F	3578W 3578W-GT

ACCESSORY KITS

TORCH	DESCRIPTION	PART NO.
WT-60, 60F	Accessory Kit - .040 Parts	AK-60
WT-125, 125F	Accessory Kit - 1/16 Parts	AK-125

Note: Specifications and dimensions are subject to change without notice.

AK-60 Accessory Kit

For WT-60, 60F Air Cooled Torches

Includes: 1 Ea. 125C40C .040 Combo Chuck
1 Ea. 125C40 .040 Chuck
1 Ea. 125N45 45 Degree Glass Nozzle
1 Ea. 125N90 90 Degree Glass Nozzle
1 Ea. 125N180 180 Degree Glass Nozzle
1 Ea. 53N20 Chuck Wrench
1 Ea. .040 x 2 Tungsten Electrode
1 Ea. Parts Storage Box



53N20
Chuck Wrench
With Electrode Stop
(Use with 180 Degree Chuck)

.040 x 2
Tungsten Electrode



125N45
45 Degree
Glass Nozzle



125N90
90 Degree
Glass Nozzle



125N180
180 Degree
Glass Nozzle



125C40C
.040 Combo Chuck
(45 & 90 Degree)



125C40
.040 Chuck
(180 Degree)

AK-125 Accessory Kit

For WT-125, 125F Water Cooled Torches

Includes: 1 Ea. 125C116C 1/16 Combo Chuck
1 Ea. 125C116 1/16 Chuck
1 Ea. 125N45 45 Degree Glass Nozzle
1 Ea. 125N90 90 Degree Glass Nozzle
1 Ea. 125N180 180 Degree Glass Nozzle
1 Ea. 53N20 Chuck Wrench
1 Ea. 1/16 x 2 Tungsten Electrode
1 Ea. Parts Storage Box



53N20
Chuck Wrench
With Electrode Stop
(Use with 180 Degree Chuck)

1/16 x 2
Tungsten Electrode



125N45
45 Degree
Glass Nozzle



125N90
90 Degree
Glass Nozzle



125N180
180 Degree
Glass Nozzle



125C116C
1/16 Combo Chuck
(45 & 90 Degree)



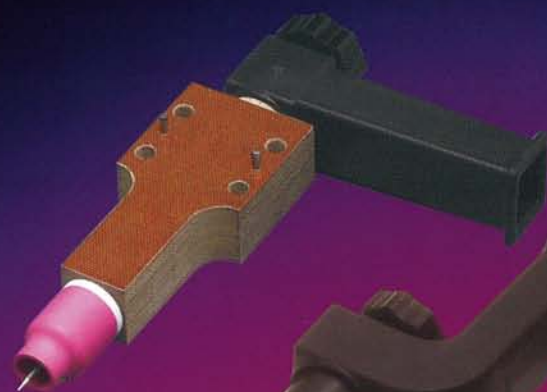
125C116
1/16 Chuck
(180 Degree)

Note: Specifications and dimensions are subject to change without notice.

WeldTec®

MACHINE TIG TORCHES

TEC Torch Company, Inc.



"MB"
MOUNTING
BLOCK
OPTION

MODEL
WT-27C
ROBOTIC



MODEL
WT-27A

MODEL
WT-27B

MODEL
WT-28B

MODEL
WT-22A

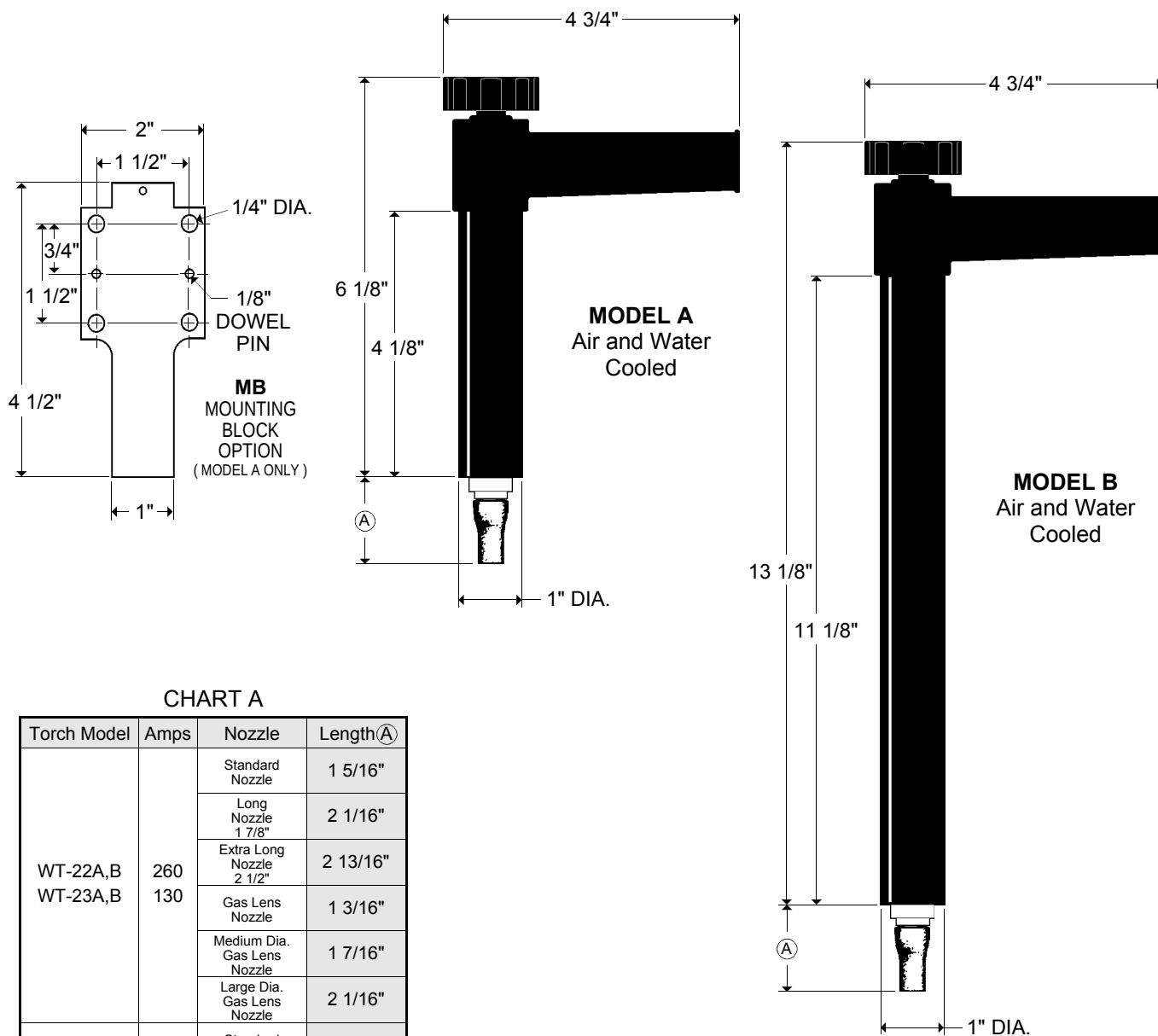


CHART A

Torch Model	Amps	Nozzle	Length (A)
WT-22A,B WT-23A,B	260	Standard Nozzle	1 5/16"
		Long Nozzle 1 7/8"	2 1/16"
	130	Extra Long Nozzle 2 1/2"	2 13/16"
		Gas Lens Nozzle	1 3/16"
		Medium Dia. Gas Lens Nozzle	1 7/16"
		Large Dia. Gas Lens Nozzle	2 1/16"
WT-28A,B WT-29A,B	350	Standard Nozzle	2 3/16"
		Long Nozzle 3"	3 5/16"
	180	Gas Lens Nozzle	2 1/4"
		Large Dia. Gas Lens Nozzle	2 3/8"

SPECIFICATIONS

Torch Model	Maximum Amps (ac-dcsp)	Duty Cycle (ac-dcsp)	Tungsten Capacity Max. Length		Cooling Requirements
WT-22A WT-22B	260	60%	.020 - 1/8	7" 14"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)
WT-23A WT-23B	130	60%	.020 - 3/32	7" 14"	Air Cooled
WT-28A WT-28B	350	60%	.020 - 5/32	7" 14"	Water Cooled 1 Qt./min. (50 psi MAX. OUTPUT)
WT-29A WT-29B	180	60%	.020 - 1/8	7" 14"	Air Cooled

Note: Specifications and dimensions are subject to change without notice.

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

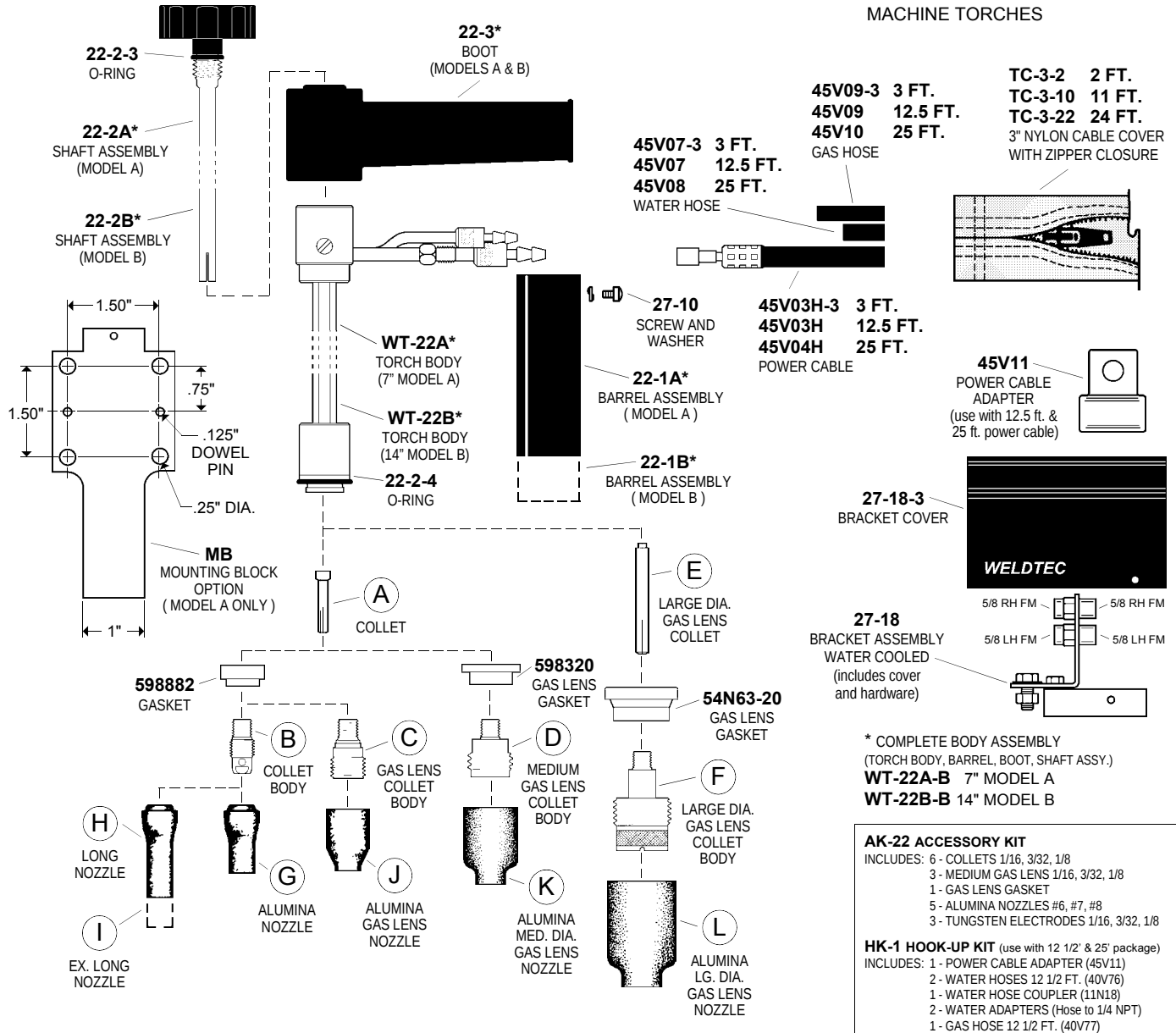
PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION A



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	13N20	13N21	13N22	13N23	13N24
B	COLLET BODY	13N25	13N26	13N27	13N28	13N29
C	GAS LENS	45V41	45V42	45V43	45V44	45V45
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW	45V37SW
E	LG. DIA GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L	13N24L
F	LG. DIA GAS LENS	45V0204S		45V116S	45V64S	995795S

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 1 7/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	54N16SW	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA.	—	—	—	57N75	—	57N74	53N88	—	53N87*

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

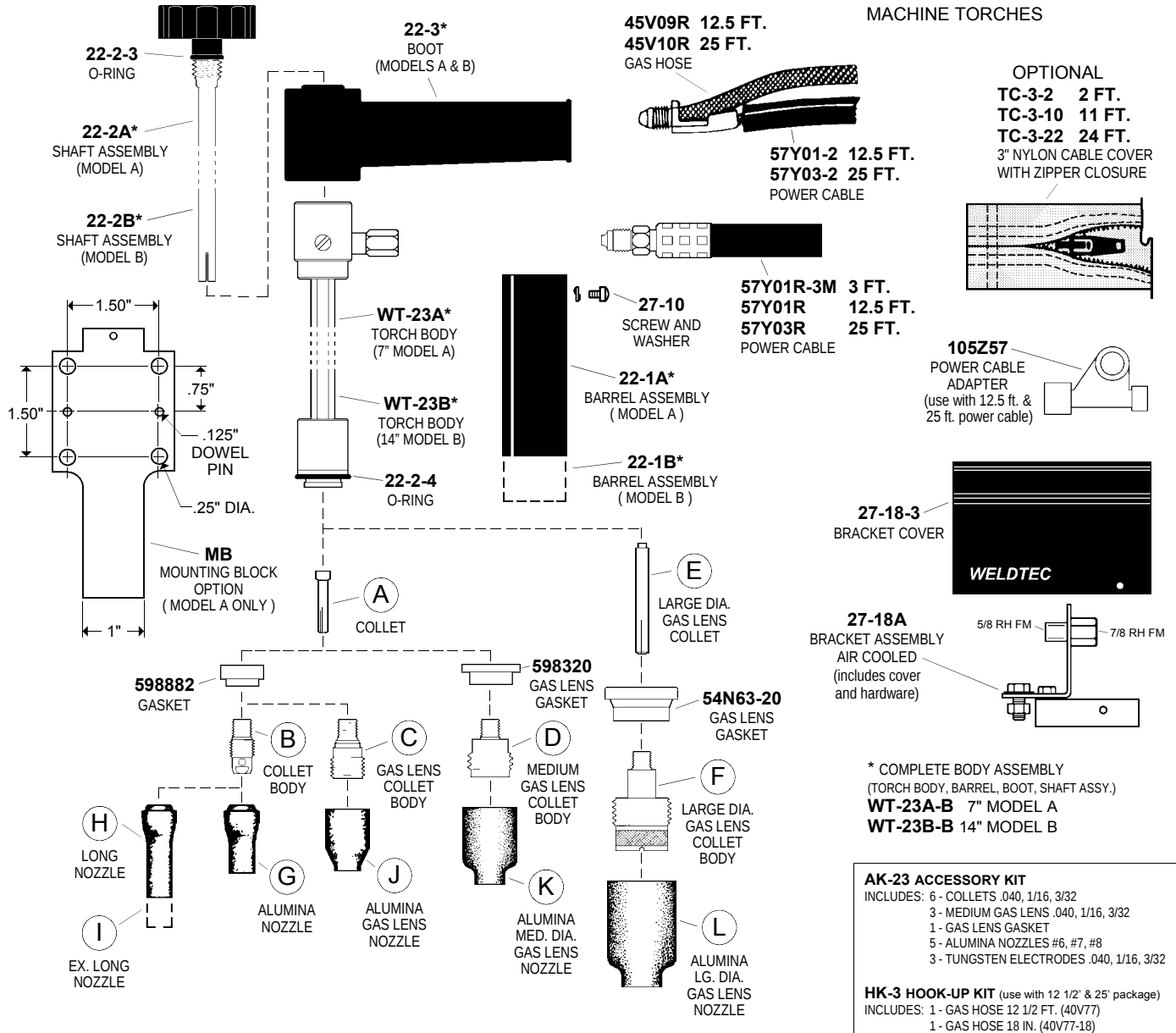
REVISION E

REPLACEMENT PARTS

WT-23

AIR COOLED • 130 AMPS

Model A = 7" Model B = 14"
MACHINE TORCHES



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4
A	COLLET	13N20	13N21	13N22	13N23
B	COLLET BODY	13N25	13N26	13N27	13N28
C	GAS LENS	45V41	45V42	45V43	45V44
D	MED. DIA. GAS LENS	—	45V34SW	45V35SW	45V36SW
E	LG. DIA. GAS LENS COLLET	13N20L	13N21L	13N22L	13N23L
F	LG. DIA. GAS LENS	45V0204S		45V116S	45V64S

GAS NOZZLES

ITEM	NO. SIZE	3 3/16"	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	—	13N08	13N09	13N10	13N11	13N12	13N13	—	—
H	LONG 1 7/8"	796F70	796F71	796F72	796F73	—	—	—	—	—
I	EX. LONG 2 1/2"	796F74	796F75	796F76	796F77	—	—	—	—	—
J	ALUMINA GAS LENS	—	53N58	53N59	53N60	53N61	53N61S	—	—	—
K	ALUMINA MED. DIA. GAS LENS	—	—	—	54N16SW	54N15SW	54N14SW	54N12SW	54N19	—
L	ALUMINA LG. DIA. GAS LENS	—	—	—	57N75	—	57N74	53N88	—	53N87*

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

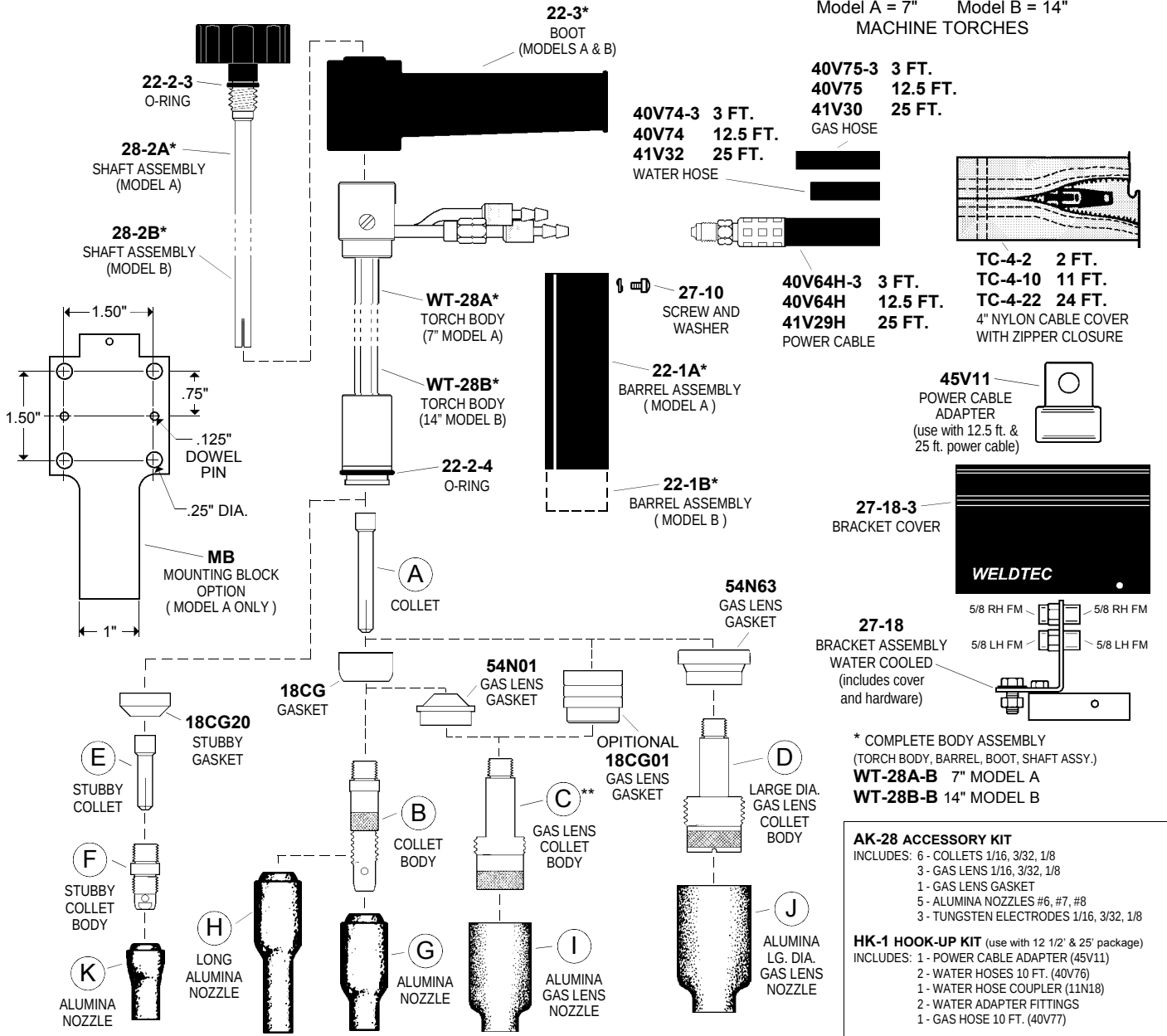
www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION E

Model A = 7" Model B = 14"
MACHINE TORCHES



COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0
A	COLLET	10N21	10N22	10N23	10N24	10N25	54N20
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28	406488
C	GAS LENS	45V29	45V24	45V25	45V26	45V27	45V28
D	LG. DIA GAS LENS	45V0204		45V116	45V64	995795	45V63
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S	—
F	STUBBY COLLET BODY	17CB20					—

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
H	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
I	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
J	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
K	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—

* #15 53N89 15/16" ID X 17/8" Long

** A shorter stubby gas lens collet body is available.

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

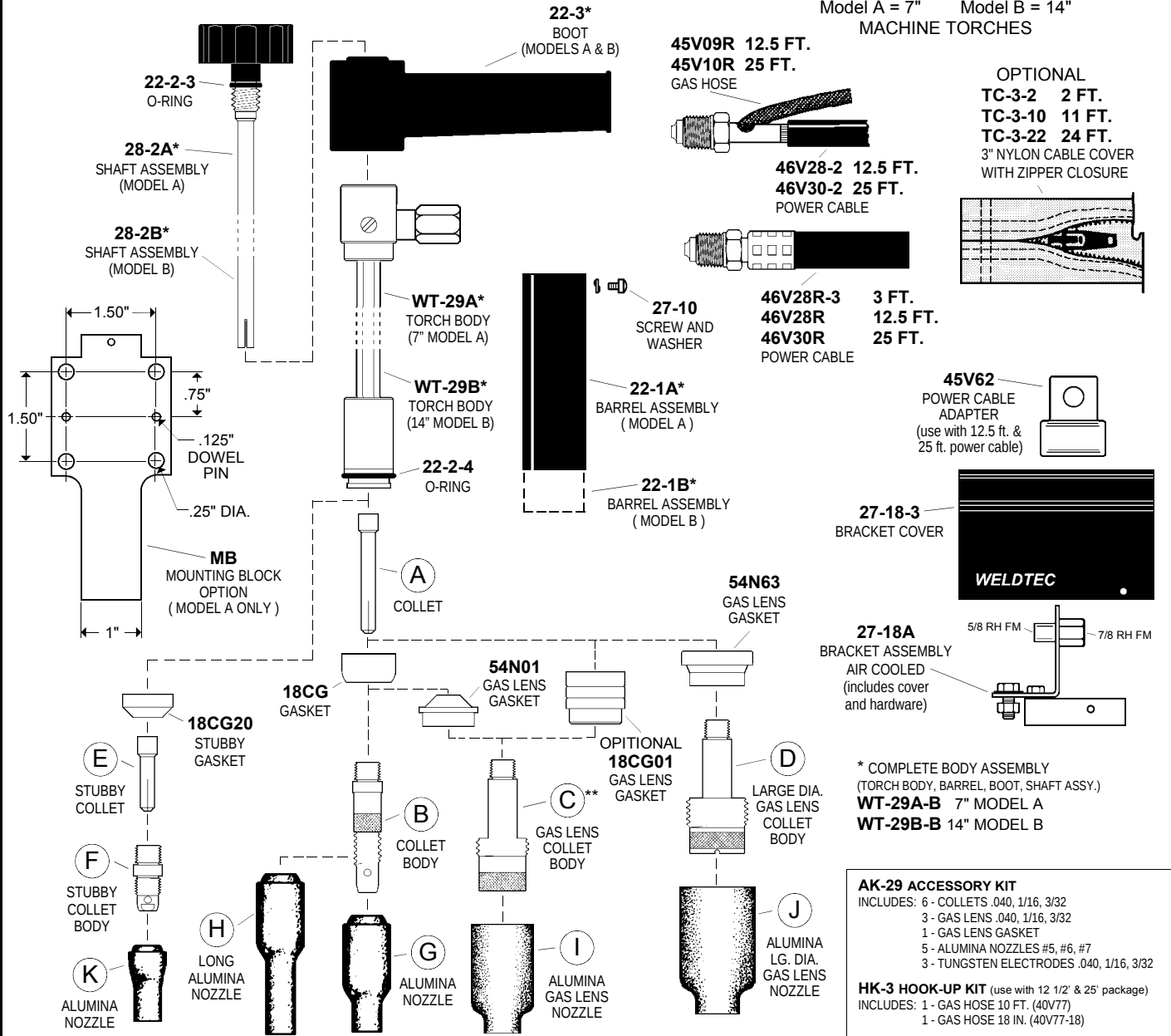
REVISION F

REPLACEMENT PARTS

WT-29

AIR COOLED • 180 AMPS

Model A = 7" Model B = 14"
MACHINE TORCHES



COPYRIGHT 2000 - 2009 TEC TORCH CO. INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	10N21	10N22	10N23	10N24	10N25
B	COLLET BODY	10N29	10N30	10N31	10N32	10N28
C	GAS LENS	45V29	45V24	45V25	45V26	45V27
D	LG. DIA GAS LENS	45V0204		45V116	45V64	995795
E	STUBBY COLLET	10N21S	10N22S	10N23S	10N24S	10N25S
F	STUBBY COLLET BODY	17CB20				

** A shorter stubby gas lens collet body is available.

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
G	ALUMINA	10N50	10N49	10N48	10N47	10N46	10N45	—	10N44
H	ALUMINA 3" LONG	—	10N49L	10N48L	10N47L	—	—	—	—
I	ALUMINA GAS LENS	54N18	54N17	54N16	54N15	54N14	—	54N19	—
J	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87*
K	ALUMINA	13N08	13N09	13N10	13N11	13N12	13N13	—	—

* #15 53N89 15/16" ID X 1 7/8" Long

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

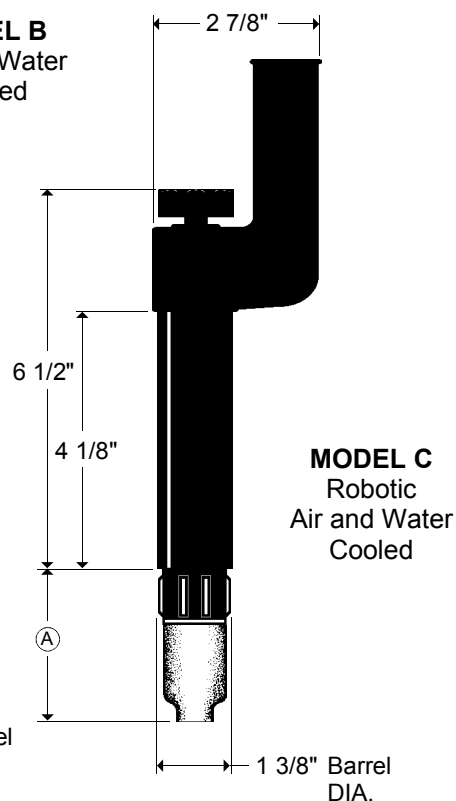
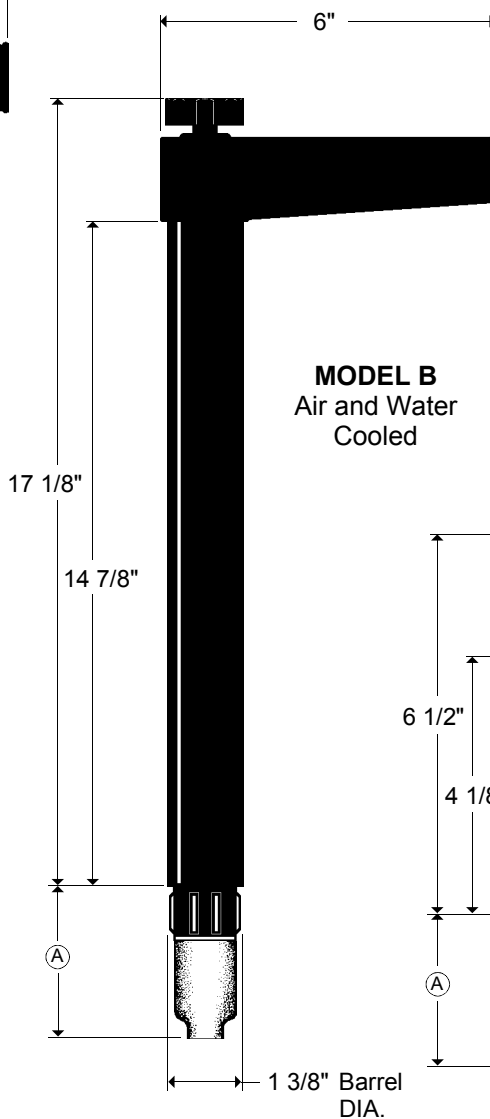
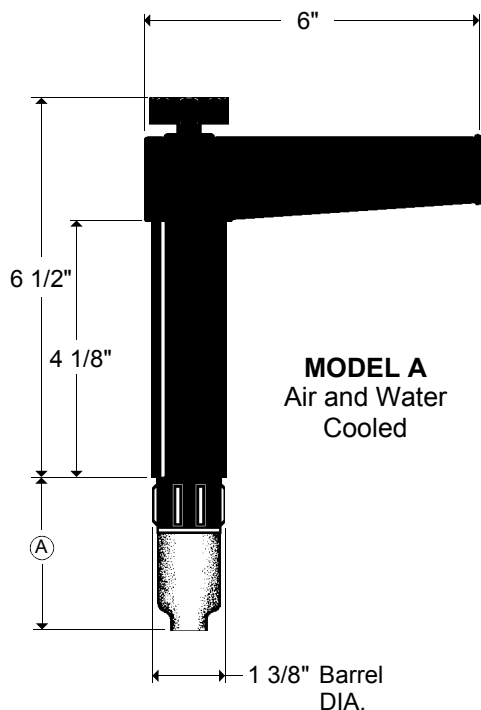


CHART A

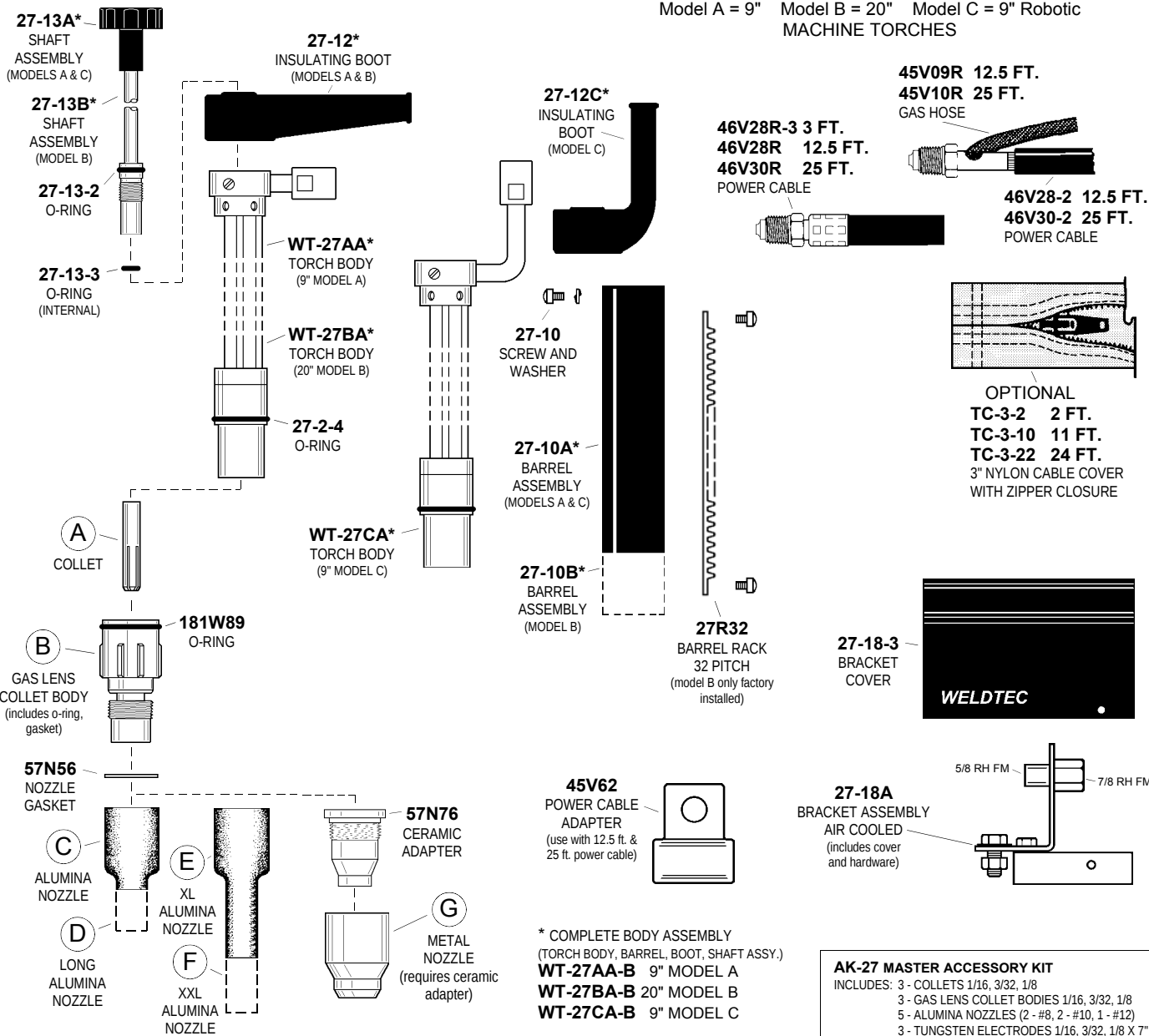
Torch Model	Amps	Nozzle	Length (A)
WT-27AA WT-27BA WT-27CA	200	Standard Nozzle	2 3/4"
		Long Nozzle 2 3/4"	3 5/8"
		Extra Long Nozzle 3 1/4"	4 1/8"
WT-27AW WT-27BW WT-27CW	500	Extra Extra Long Nozzle 4 3/4"	5 5/8"
		Metal Nozzle	3"

SPECIFICATIONS

Torch Model	Maximum Amps (ac-dcsp)	Duty Cycle (ac-dcsp)	*Tungsten Capacity	Max. Length	Cooling Requirements
WT-27AA WT-27BA WT-27CA	200	60%	.040 - 1/4	7" 18" 7"	Air Cooled
WT-27AW WT-27BW WT-27CW	500	60%	.040 - 1/4	7" 18" 7"	Water Cooled 2 Qt./min. (50 psi MAX. OUTPUT)

* Axial adjustment of tungsten electrode is possible by moving the ribbed sleeve and shaft knob in unison.

Note: Specifications and dimensions are subject to change without notice.



COPYRIGHT 2000 - 2009 TEC TORCH CO., INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0	3/16 4,8	1/4 6,4
A	COLLET	57N45	57N46	57N47	57N48	57N49	57N50	57N51
B	GAS LENS COLLET BODY	49V22	49V23	49V24	49V25	49V26	49V27	49V28

INDIVIDUAL ACCESSORY KITS

AK-27-16 INCLUDES: 1/16 COLLET AND GAS LENS COLLET BODY, 1 - #8 NOZZLE, 2 - #10 NOZZLES, 1/16 X 7" TUNGSTEN ELECTRODE.

AK-27-32 INCLUDES: 3/32 COLLET AND GAS LENS COLLET BODY, 2 - #10 NOZZLES, 1 - #12 NOZZLE, 3/32 X 7" TUNGSTEN ELECTRODE.

AK-27-18 INCLUDES: 1/8 COLLET AND GAS LENS COLLET BODY, 1 - #10 NOZZLE, 2 - #12 NOZZLES, 1/8 X 7" TUNGSTEN ELECTRODE.

GAS NOZZLES

ITEM	NO. SIZE	LENGTH	6 3/8"	7 7/16"	8 1/2"	10 5/8"	12 3/4"	15 15/16"
C	ALUMINA LG. DIA. GAS LENS	1 7/8"	57N75	—	57N74	53N88	53N87	53N89
D	LONG ALUMINA	2 3/4"	57N75L	—	57N74L	53N88L	53N87L	—
E	XL ALUMINA	3 1/4"	57N75XL	—	57N74XL	53N88XL	53N87XL	—
F	XXL ALUMINA	4 3/4"	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—
G	METAL	1 13/16"	—	—	—	57N78	57N77	—

* #15 53N89 15/16" ID X 17/8" Long

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

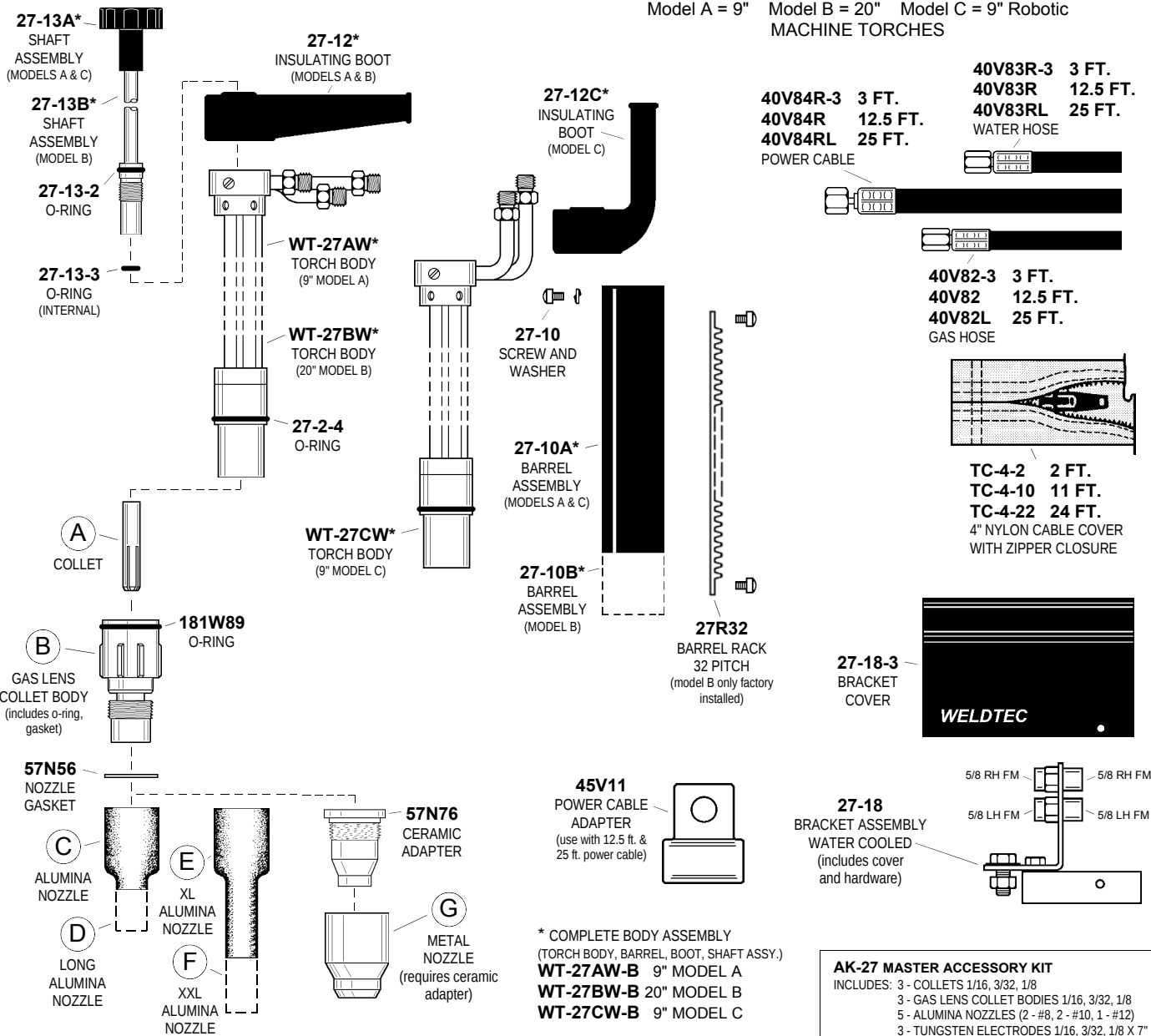
PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F



COPYRIGHT 2000 - 2009 TEC TORCH CO., INC.

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0	3/16 4,8	1/4 6,4
A	COLLET	57N45	57N46	57N47	57N48	57N49	57N50	57N51
B	GAS LENS COLLET BODY	49V22	49V23	49V24	49V25	49V26	49V27	49V28

INDIVIDUAL ACCESSORY KITS

AK-27-16 INCLUDES: 1/16 COLLET AND GAS LENS COLLET BODY, 1 - #8 NOZZLE, 2 - #10 NOZZLES, 1/16 X 7" TUNGSTEN ELECTRODE.

AK-27-32 INCLUDES: 3/32 COLLET AND GAS LENS COLLET BODY, 2 - #10 NOZZLES, 1 - #12 NOZZLE, 3/32 X 7" TUNGSTEN ELECTRODE.

AK-27-18 INCLUDES: 1/8 COLLET AND GAS LENS COLLET BODY, 1 - #10 NOZZLE, 2 - #12 NOZZLES, 1/8 X 7" TUNGSTEN ELECTRODE.

GAS NOZZLES

ITEM	NO. SIZE	LENGTH	6 3/8"	7 7/16"	8 1/2"	10 5/8"	12 3/4"	15 15/16"
C	ALUMINA LG. DIA. GAS LENS	1 7/8"	57N75	—	57N74	53N88	53N87	53N89
D	LONG ALUMINA	2 3/4"	57N75L	—	57N74L	53N88L	53N87L	—
E	XL ALUMINA	3 1/4"	57N75XL	—	57N74XL	53N88XL	53N87XL	—
F	XXL ALUMINA	4 3/4"	57N75XXL	—	57N74XXL	53N88XXL	53N87XXL	—
G	METAL	1 13/16"	—	—	—	57N78	57N77	—

* #15 53N89 15/16" ID X 17/8" Long

MANUFACTURED IN USA
 TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION G



HIGH PERFORMANCE TIG WELDING TORCHES



"Best TIG torch ever!"

J.C. Paso Robles, CA

"This torch is the best quality torch that I have ever used"

J.B. Lewisville, IN

"Great package"

B.M. Oxnard, CA

"Finally, a decent, rugged torch!"

D.T. Pleasant Prairie, WI

"Awesome Torch"

M.O. Vista, CA

"Excellent product design"

T.T. Xenia, OH

"The Best!!!"

Z.A. Louisville, KY

"Comfort of handle. Nicest torch I've seen."

K.S. Harleysville, PA

"P.S. your product is excellent - #1"

K.N. Moreno Valley, CA

"Good product, trouble free"

N.B. Centerville, OH

"Best torch I've used in 27 years of welding"

S.B. Kettering, OH

"Best I've ever used!"

D.L. Munford, AL

SW-320
320 amps

NEW
SW-450
450 amps

...we couldn't have said it better ourselves.

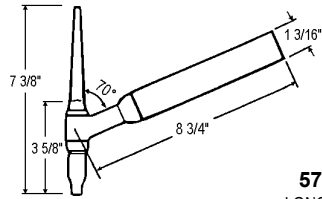
TEC Torch Company, Inc. • P.O. Box 1870, San Marcos, CA 92079 • (760) 747-3700

Speedway® and the overall shape, style and appearance of the handle are registered trademarks of the Tec Torch Co.

SPEEDWAY[®] SERIES

REPLACEMENT PARTS

SW-450
450 AMPS • WATER COOLED



57Y02
LONG BACK
CAP

57Y04
SHORT BACK
CAP

98W18
O - RING

SW-450
TORCH
BODY

H-200SW
SPEED BUMP
HANDLE

A
COLLET

18NG-GL
GAS LENS
GASKET

18NG
NOZZLE
GASKET

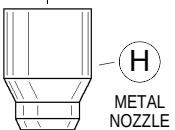
D
LARGE DIA.
GAS LENS
COLLET BODY

B
COLLET
BODY

C
GAS LENS
COLLET BODY



57N76
CERAMIC
ADAPTER



H
METAL
NOZZLE

G
ALUMINA
LG. DIA.
GAS LENS
NOZZLE

E
ALUMINA
NOZZLE

F
LONG
ALUMINA
NOZZLE

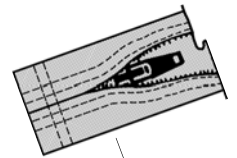
3578W
DIN CONNECTOR
(Water Cooled)

45V11
POWER CABLE
ADAPTER
(Water Cooled)

GAS HOSE - RUBBER
40V75R 12.5 FT.
41V30R 25 FT.

WATER HOSE - RUBBER
40V74R 12.5 FT.
41V32R 25 FT.

POWER CABLE - RUBBER
40V64HR 12.5 FT.
41V29HR 25 FT.



TCL-3-10Z 11 FT.
TCL-3-22Z 24 FT.
3" LEATHER CABLE COVER
WITH ZIPPER CLOSURE

AK-450 ACCESSORY KIT

INCLUDES: 3 - COLLETS-HD 3/32, 1/8, 5/32
1 - COLLET BODY
3 - GAS LENS 3/32, 1/8, 5/32
3 - ALUMINA NOZZLES #6, #7, #8
3 - TUNGSTEN ELECTRODES 3/32, 1/8, 5/32 X 7"

COLLETS • COLLET BODIES • GAS LENS

ITEM	ELECTRODE DIAMETER	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0	3/16 4,8
A	COLLET	10N22HD	10N23HD	10N24HD	10N25HD	54N20HD	18C36
B	COLLET BODY	NCB-36					
C	GAS LENS	18GL04	18GL16	18GL32	18GL18	18GL53	18GL36
D	LG. DIA GAS LENS	45V94	45V95	45V96	45V97	45V98	45V99

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"	12 3/4"
E	ALUMINA	54N18	54N17	54N16	54N15	54N14	—	54N19	—
HPS*		—	—	—	54N15HPS	54N14HPS	—	—	—
F	LONG ALUMINA 3"	—	54N17L	54N16L	54N15L	—	—	—	—
G	ALUMINA LG. DIA. GAS LENS	—	—	57N75	—	57N74	53N88	—	53N87**
H	METAL	—	—	—	—	—	57N78	—	57N77

* Nozzles Available In HPS High Performance Series (Gray Color).

** #15 53N89 15/16" ID X 1 7/8" Long.

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tigtorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION F

H-10, 10F, 10FV, 10V
H-16, 16F, 16FV, 16V
H-20, H-35

FEATURES

The Heliweld II™ torch models are engineered and manufactured using the most modern materials and techniques to meet the stringent requirements of industry.

- High conductivity copper construction
- High temperature silicone rubber insulation
- High capacity silver brazed construction
- Durable, flexible rubber hoses & cables
- Protective zippered cable covers
- Air cooled flex heads and built-in gas valves



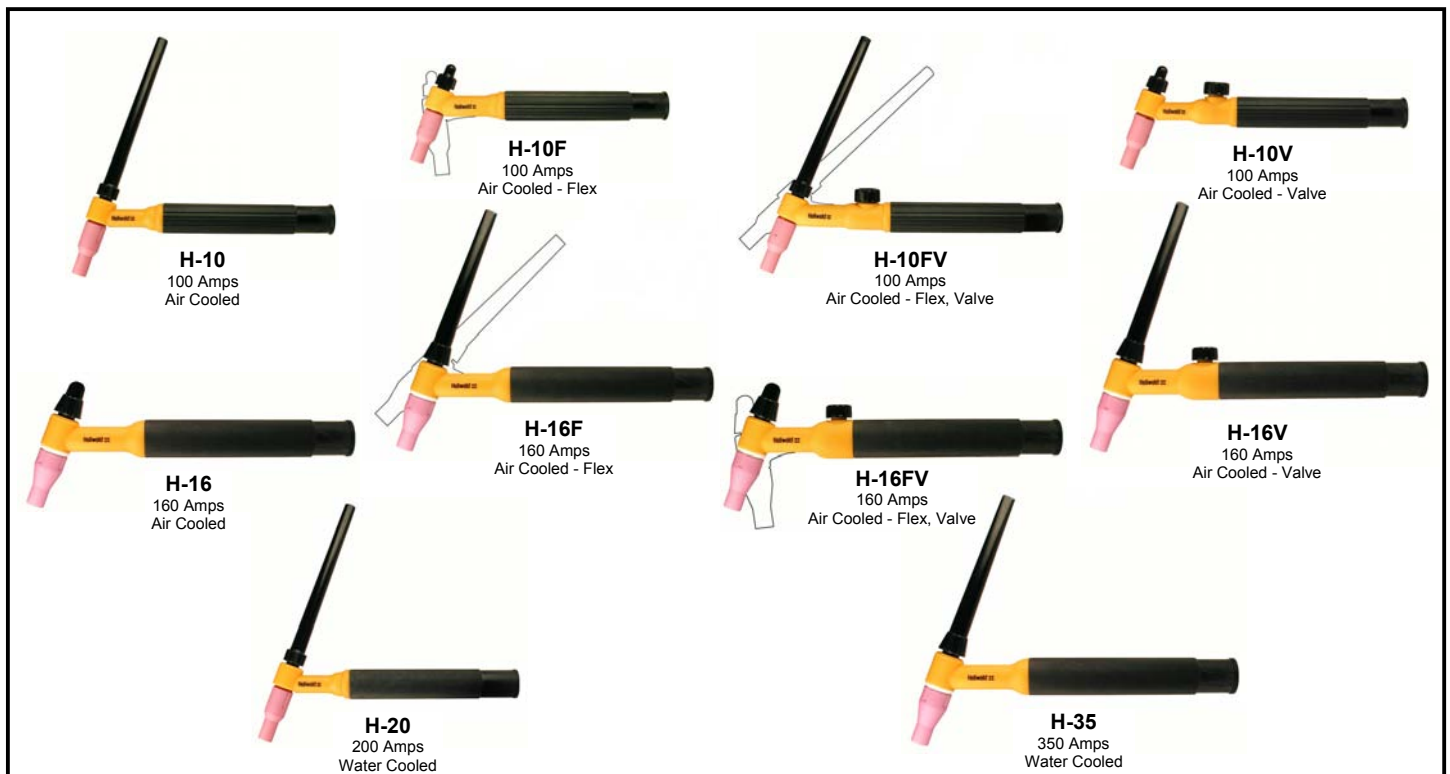
SPECIFICATIONS

MODEL	PART NO.	AIRCO® NO.	DESCRIPTION		AMPS*	FEATURES
H-10	H-10-12 H-10-25	2301-0010 2301-0030	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	100	Standard Model
H-10F	H-10F-12 H-10F-25	- -	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	100	Flex Head Model
H-10FV	H-10FV-12 H-10FV-25	- -	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	100	Flex Head With Valve
H-10V	H-10V-12 H-10V-25	2301-0070 2301-0071	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	100	Built-In Gas Valve
H-16	H-16-12 H-16-25	2301-0047 2301-0049	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	160	Standard Model
H-16F	H-16F-12 H-16F-25	- -	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	160	Flex Head Model
H-16FV	H-16FV-12 H-16FV-25	- -	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	160	Flex Head With Valve
H-16V	H-16V-12 H-16V-25	2301-0084 2301-0085	12 1/2 Ft. Torch Package 25 Ft. Torch Package	A	160	Built-In Gas Valve
H-20	H-20-12R H-20-25R	2301-0041 2301-0042	12 1/2 Ft. Torch Package 25 Ft. Torch Package	W	200	Standard Model
H-35	H-35-12R H-35-25R	2301-3751 2301-3776	12 1/2 Ft. Torch Package 25 Ft. Torch Package	W	350	Standard Model

NOTES: Power cable connector and accessory kit not supplied with torch package. Order as needed.
A=Air cooled, W=Water cooled.

* AC, DCSP

TORCH MODELS



Specifications and models subject to change without notice.

ALUMINA NOZZLES

TORCH	LENGTH	ORIFICE IN mm	SIZE	PART NO.
H-10, 10F, 10FV, 10V H-20 	1 9/16"	1/4 6 5/16 8 3/8 10 7/16 11	4 5 6 7	2304-0069 2304-0070 2304-0073 2304-0074
H-16, 16F, 16FV, 16V H-35 	1 5/8"	1/4 6 5/16 8 3/8 10 1/2 12.5 5/8 16	4 5 6 8 10	2304-0079 2304-0080 2304-0081 2304-0082 2304-0083

ALUMINA GAS FLOW STRAIGHTENER NOZZLES

TORCH	LENGTH	ORIFICE IN mm	SIZE	PART NO.
H-10, 10F, 10FV, 10V H-20 	1"	1/4 6 5/16 8 3/8 10 7/16 11 1/2 12.5	4 5 6 7 8	53N58 53N59 53N60 53N61 53N61S
H-16, 16F, 16FV, 16V H-35 	1 5/8"	1/4 6 5/16 8 3/8 10 7/16 11 1/2 12.5 11/16 17.5	4 5 6 7 8 11	54N18 54N17 54N16 54N15 54N14 54N19

BACK CAPS

TORCH	DESCRIPTION	PART NO.
H-10, 10F, 10FV, 10V H-20 	2" Short Cap 3" Medium Cap 7" Long Cap	2304-0008 2304-0009 2304-0010
H-16, 16F, 16FV, 16V H-35 	2" Short Cap 3" Medium Cap 7" Long Cap	2304-0143 2304-0144 2304-0145

POWER CABLE CONNECTORS

TORCH	PART NO.
H-10, 10F, 10FV, 10V H-16, 16F, 16FV, 16V H-20 H-35 	2310-1645 2310-1879 2310-1824 2310-0735
H-10, 10F, 10FV, 10V H-16, 16F, 16FV, 16V 	3576 3558G
H-20 H-35	3558W-20 3558W

For more information contact your local welding supply distributor.

NOSE TRANSFER BLOCKS

TORCH	SIZE IN mm	PART NO.
H-10, 10F, 10FV, 10V H-20 	.020 - 1/8 0,5 - 3,2	2310-1810
H-16, 16F, 16FV, 16V H-35 	.020 - 3/16 0,5 - 4,8	2310-1938

COLLETS

TORCH	SIZE IN mm	PART NO.
H-10, 10F, 10FV, 10V H-20 	.020 0,5 .040 1,0 1/16 1,6 3/32 2,4 1/8 3,2	2304-0138 2304-0137 2304-0136 2304-0135 2304-0068
H-16, 16F, 16FV, 16V H-35 	.020 0,5 .040 1,0 1/16 1,6 3/32 2,4 1/8 3,2 5/32 4,0 3/16 4,8	2304-0086 2304-0087 2304-0088 2304-0089 2304-0090 2304-0091 2304-0146

GAS FLOW STRAIGHTENERS*

TORCH	SIZE IN mm	PART NO.
H-10, 10F, 10FV, 10V H-20 	.020 - 1/16 0,5 - 1,6 3/32 2,4 1/8 3,2	2304-0187A 2304-0188A 2304-0189A
H-16, 16F, 16FV, 16V H-35 	.020 - 1/16 0,5 - 1,6 3/32 2,4 1/8 3,2 5/32 - 3/16 4,0 - 4,8	2304-0176A 2304-0177A 2304-0178A 2304-0179A

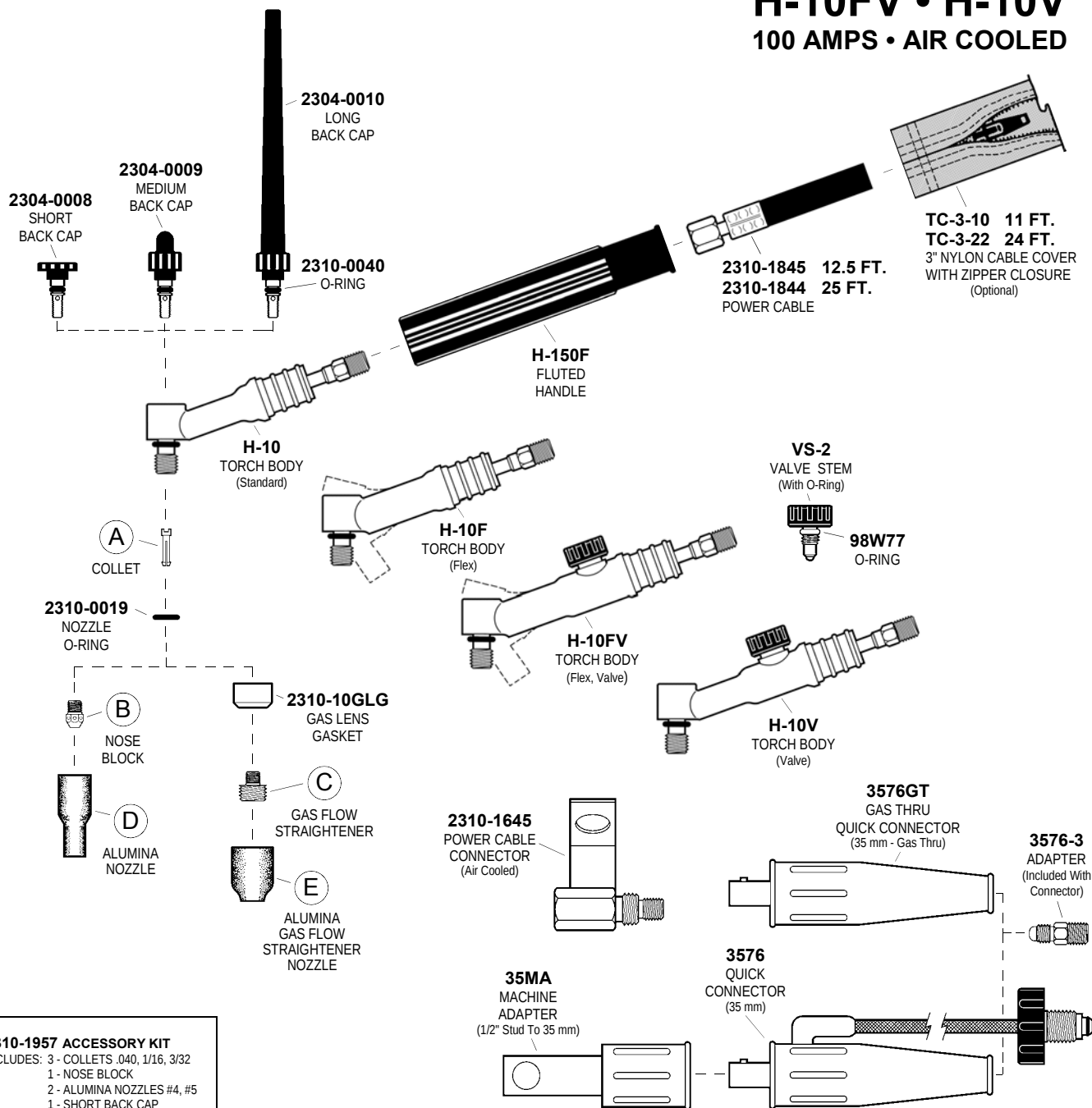
*NOTE: Gas flow straighteners do not use original Airco® nozzles.

GASKETS • INSULATORS

TORCH	DESCRIPTION	PART NO.
H-10, 10F, 10FV, 10V H-20  Nozzle O-Ring  Gas Lens Gasket	Nozzle O-Ring G/L Gasket	2310-0019 2310-10GLG
H-16, 16F, 16FV, 16V H-35  Nozzle Gasket  Gas Lens Gasket	Nozzle Gasket G/L Gasket	2310-2051 2310-16GLG

Heliweld II™

TEC Torch Company, Inc.
P.O. Box 1870, San Marcos, CA 92079 USA
(760) 747-3700 Fax (760) 747-2121
www.tectorch.com



COLLETS • NOSE BLOCK • GAS STRAIGHTENERS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	2304-0138	2304-0137	2304-0136	2304-0135	2304-0068
B	NOSE BLOCK	2310-1810				
C	GAS FLOW STRAIGHTENER	2304-0187A		2304-0188A	2304-0189A	

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"
D	ALUMINA	2304-0069	2304-0070	2304-0073	2304-0074	—
E	ALUMINA	53N58	53N59	53N60	53N61	53N61S

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

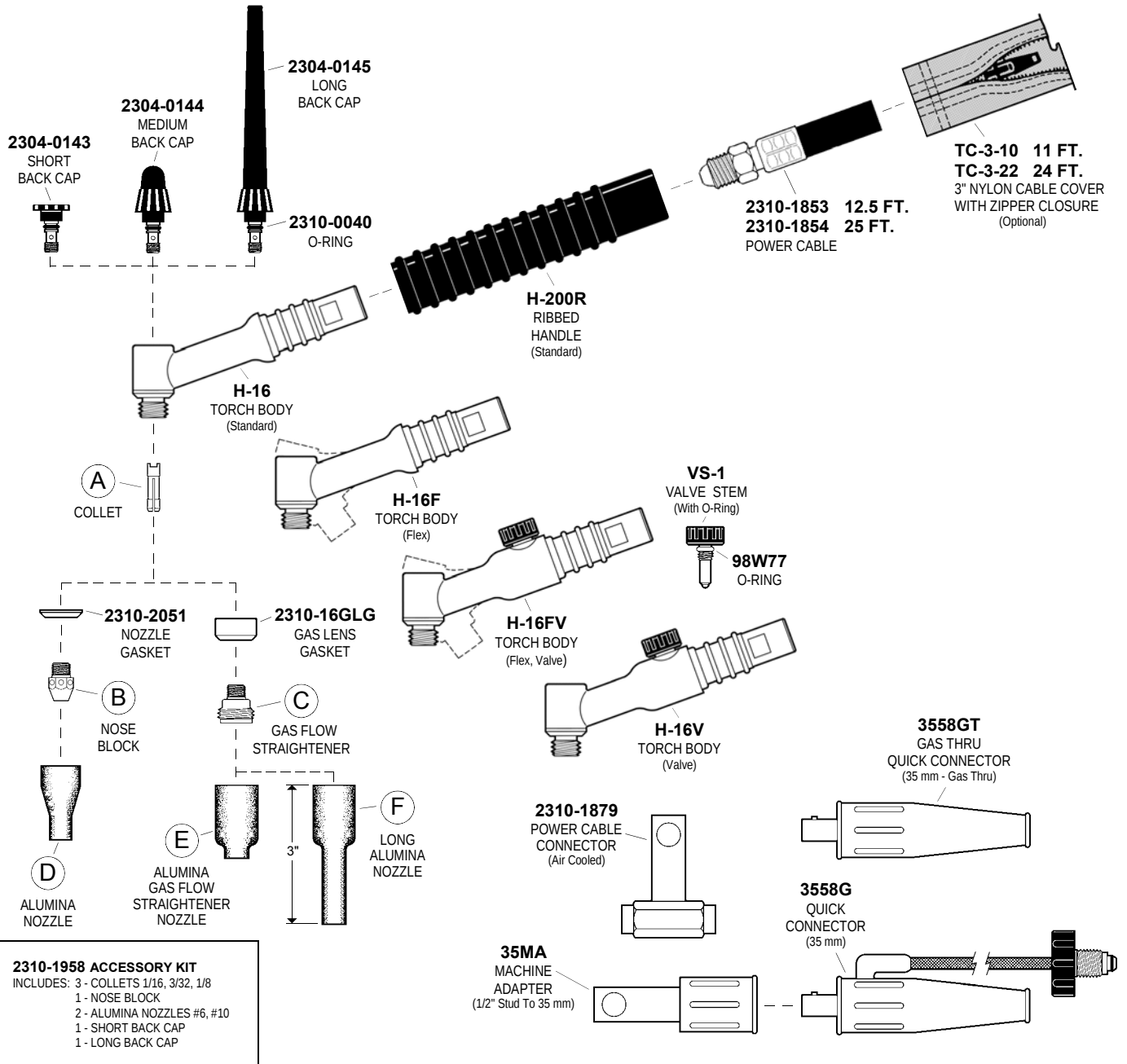
PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION C



COLLETS • NOSE BLOCK • GAS STRAIGHTENERS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0	3/16 4,8
A	COLLET	2304-0086	2304-0087	2304-0088	2304-0089	2304-0090	2304-0091	2304-0146
B	NOSE BLOCK	2310-1938						
C	GAS FLOW STRAIGHTENER	2304-0176A			2304-0177A	2304-0178A	2304-0179A	—

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"
D	ALUMINA	2304-0079	2304-0080	2304-0081	—	2304-0082	2304-0083	—
E	ALUMINA	54N18	54N17	54N16	54N15	54N14	—	54N19
F	LONG ALUMINA 3"	—	54N17L	54N16L	54N15L	54N14L	—	—

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

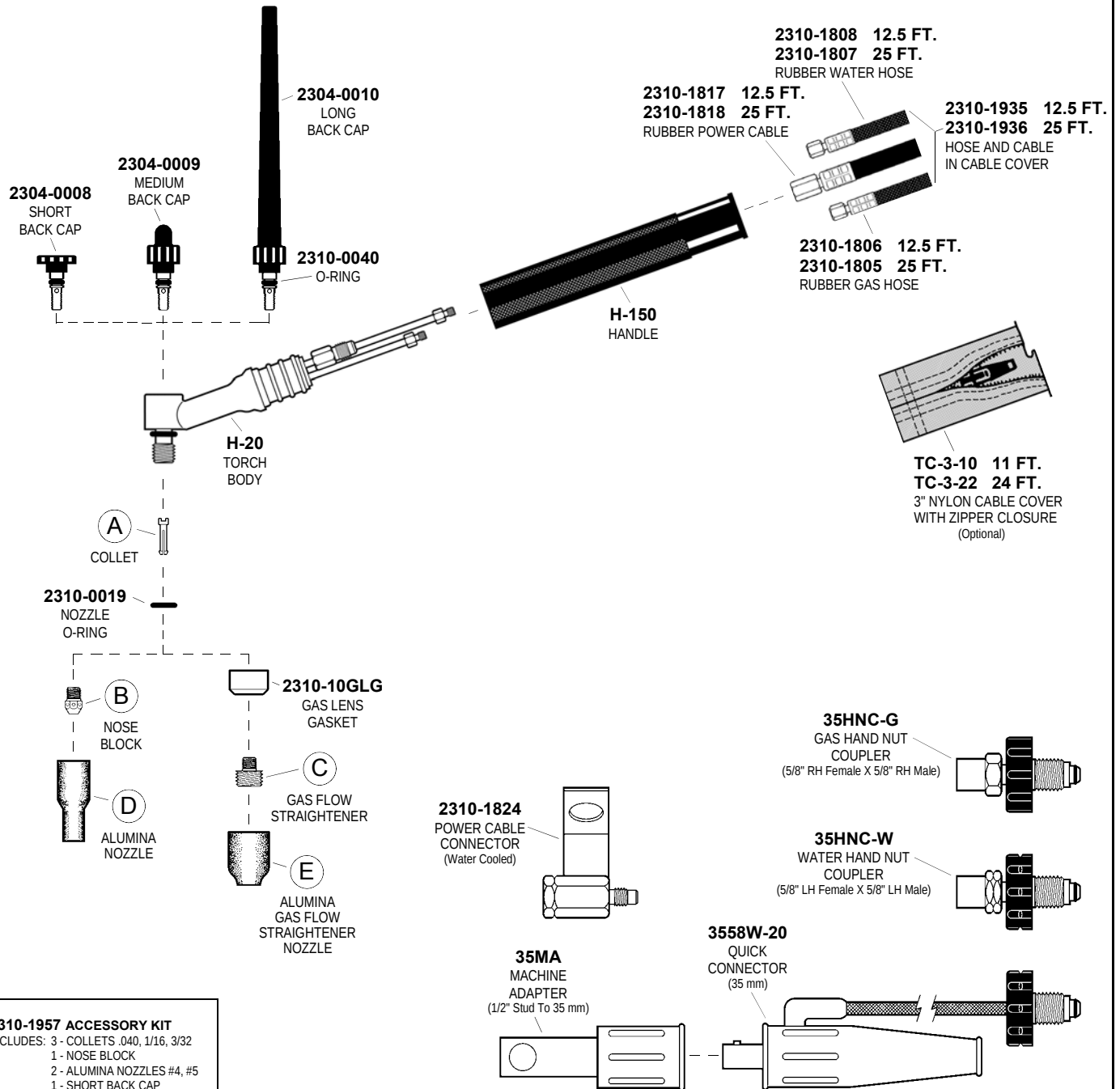
PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION E



COLLETS • NOSE BLOCK • GAS STRAIGHTENERS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2
A	COLLET	2304-0138	2304-0137	2304-0136	2304-0135	2304-0068
B	NOSE BLOCK	2310-1810				
C	GAS FLOW STRAIGHTENER	2304-0187A		2304-0188A	2304-0189A	

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"
D	ALUMINA	2304-0069	2304-0070	2304-0073	2304-0074	—
E	ALUMINA	53N58	53N59	53N60	53N61	53N61S

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

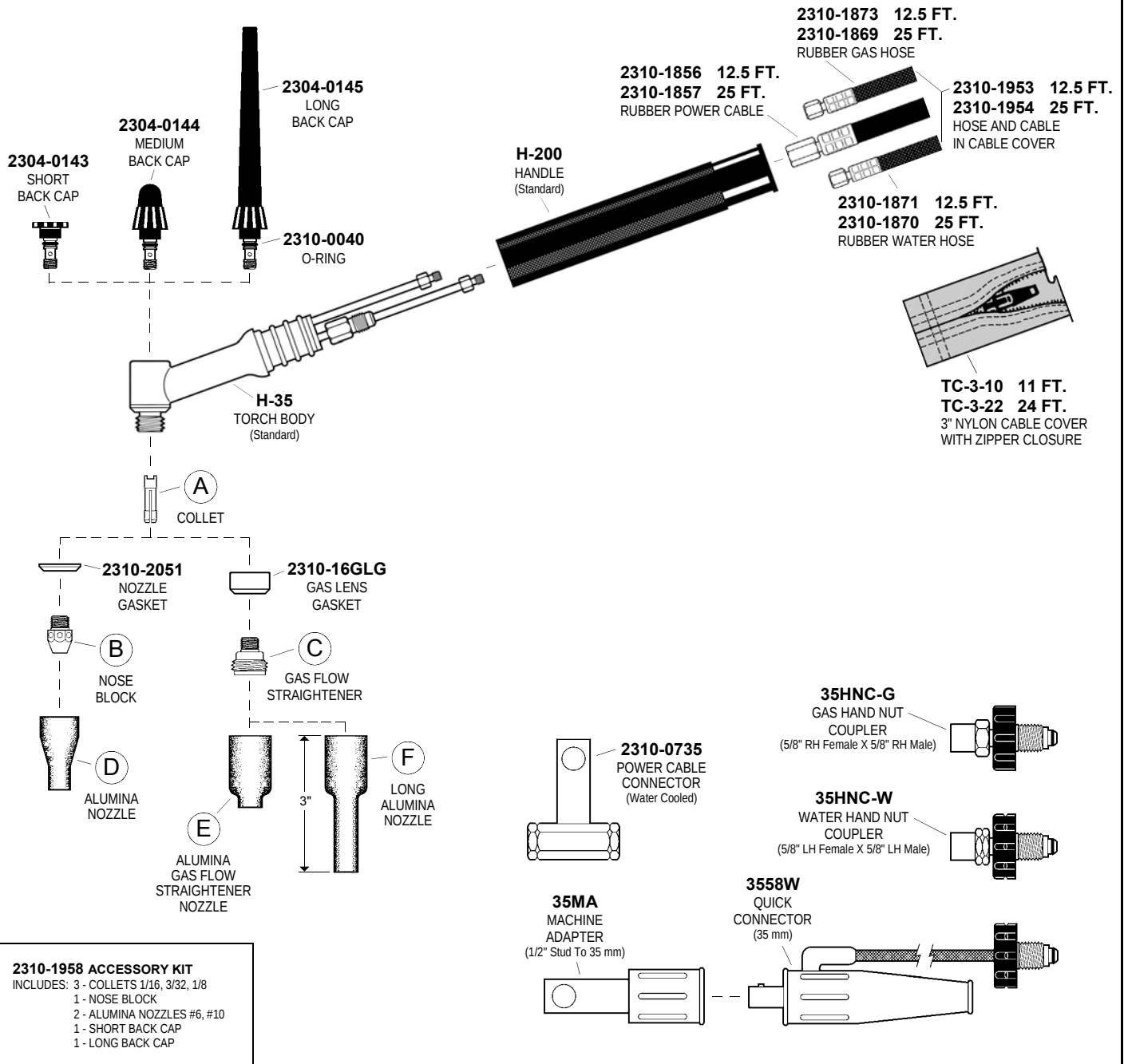
PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION C



COLLETS • NOSE BLOCK • GAS STRAIGHTENERS

ITEM	ELECTRODE DIAMETER	.020 0,5	.040 1,0	1/16 1,6	3/32 2,4	1/8 3,2	5/32 4,0	3/16 4,8
A	COLLET	2304-0086	2304-0087	2304-0088	2304-0089	2304-0090	2304-0091	2304-0146
B	NOSE BLOCK	2310-1938						
C	GAS FLOW STRAIGHTENER	2304-0176A		2304-0177A	2304-0178A	2304-0179A	—	

GAS NOZZLES

ITEM	NO. SIZE	4 1/4"	5 5/16"	6 3/8"	7 7/16"	8 1/2"	10 5/8"	11 11/16"
D	ALUMINA	2304-0079	2304-0080	2304-0081	—	2304-0082	2304-0083	—
E	ALUMINA	54N18	54N17	54N16	54N15	54N14	—	54N19
F	LONG ALUMINA 3"	—	54N17L	54N16L	54N15L	54N14L	—	—

MANUFACTURED IN USA
TEC TORCH COMPANY, INC.

PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tectorch.com

e-mail info@tectorch.com

www.weldtec.com

REVISION E

TIG Welding Nozzles



Background

The TIG welding process was invented by and the original torch designs were developed in the welding department of Northrop Aviation Co. in Hawthorne, CA just prior to WWII. The early torch designs used steel, brass or copper nozzles. It wasn't until after the war that torch designs were improved and ceramics became the material of choice for nozzles or cups as they were sometimes called. Two types of materials were used. Grade A lava (tan color) and alumina oxide (pink). Alumina oxide is still the primary nozzle material in use today for several important reasons; outstanding electrical insulation properties, high dielectric strength and high operating temperatures.

Where does alumina oxide come from.

Alumina oxide is processed from Bauxite ore, which is present in most of the earth's surface. The alumina is extracted from the raw ore by a series of chemical treatments that produces a alumina powder. This powder is then ground in large rotating ball mills into a very fine white powder into which additives are blended to enhance the properties or aid in processing of the mixture. Chromium oxide is added to obtain the pink color.

How nozzles are made.

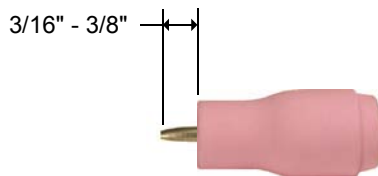
The fine powder mixture is now formed into a nozzle by one of several methods. Dry pressing, isostatic pressing and injection molding. The pressing or molding process forms the basic nozzle by compressing the powder around a steel mandrel that has been machined in the form of the internal shape of the nozzle including the screw threads. Next the nozzle outside form is machined or ground to shape. Some nozzles require additional machining to create recesses inside the bore. The nozzle is now fired in high temperature kilns at temperatures up to 3000° F. During the firing entrapped air is forced out causing the nozzle to shrink approximately 20% in size. Many nozzles are lost during the firing due to uneven shrinkage and distortion.

Why do some nozzles hold up better than others.

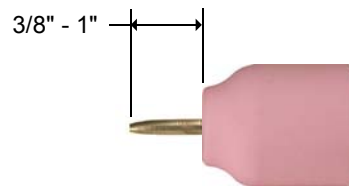
There are several key factors in making premium welding nozzles. First, the basic material mixture. Some nozzle manufacturers add fillers to reduce the cost of the mixture. This lowers the percent of alumina oxide and lowers the physical properties of the nozzle. Second, the processing method can have a big impact on the durability and life of the nozzle. The important factor is how dense the mixture is compressed during the forming process. The higher the forming pressure the denser, more compact, the nozzle with fewer voids and air pockets. Many imported nozzles are formed on simple bench top low pressure forming presses resulting in nozzles with voids and air pockets.

Why do some nozzles just crack and break.

With all the strong features that make alumina oxide an ideal material for welding nozzles it does have one big draw back. . . . thermal shock. Thermal (heat) shock is a condition that occurs when the nozzle is heated during the welding process. As the nozzle heats up the back end of the nozzle which is screwed onto the collet body or gas lens collet body remains cooler than the front end which is closer to the weld arc and molten puddle. The difference in temperature at both ends of the nozzle creates thermal stresses within the nozzle which causes the nozzle to break apart. Usually the front end of the nozzle breaks off. This condition is compounded when the tungsten electrode does not protrude outside the end of the nozzle. For longer life it's very important to extend the electrode beyond the end of the nozzle.



STANDARD



GAS LENS

Welding conditions such as; air drafts, torch angle, joint configuration can affect the tungsten stick-out length.

Stubby Gas Lens Collet Body

WeldTec's stubby collet bodies add new versatility to the popular 17, 18 and 26 series torches. They reduce the overall torch head length allowing access to confined areas. They provide better torch head balance when using the short back cap and many times can eliminate the cost and time of changing to a smaller torch.



Stubby Gas Lens



Standard Gas Lens

TORCH SERIES:
WT-17, 17F, 17FV, 17V
WT-18, 18SP, 18V
WT-26, 26F, 26FV, 26P, 26V
WTB-17, 17V, 18
WTF-17, 17V, 18
WTR-17, 17V, 18
SW-418

GAS LENS COLLET BODIES



<u>GAS LENS COLLET BODIES</u>	<u>PART NUMBER</u>
.040 Stubby Gas Lens Collet Body	45V24S
1/16 Stubby Gas Lens Collet Body	45V25S
3/32 Stubby Gas Lens Collet Body	45V26S
1/8 Stubby Gas Lens Collet Body	45V27S
5/32 Stubby Gas Lens Collet Body	45V28S
.020 Stubby Gas Lens Collet Body	45V29S

COLLETS



.020 Stubby Collet	10N21S
.040 Stubby Collet	10N22S
1/16 Stubby Collet	10N23S
3/32 Stubby Collet	10N24S
1/8 Stubby Collet	10N25S
5/32 Stubby Collet	54N20S

ALUMINA GAS LENS NOZZLES

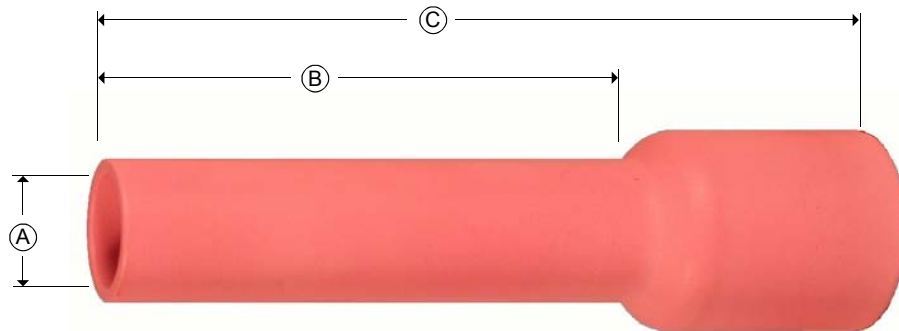


#6 (3/8") Stubby Gas Lens Nozzle	54N16SW
#7 (7/16") Stubby Gas Lens Nozzle	54N15SW
#8 (1/2") Stubby Gas Lens Nozzle	54N14SW
#10 (5/8") Stubby Gas Lens Nozzle	54N12SW

NOZZLE GASKET



Stubby Nozzle Gasket	18CG20
----------------------	---------------



Part Number	Size	Ⓐ Orifice	Ⓑ Orifice Length	Ⓒ Overall Length
57N75	6	3/8"	3/8"	1 7/8"
57N75L	6L	3/8"	1 1/8"	2 3/4"
57N75XL	6XL	3/8"	1 5/8"	3 1/4"
57N75XXL	6XXL	3/8"	3 1/8"	4 3/4"
57N74	8	1/2"	3/8"	1 7/8"
57N74L	8L	1/2"	1 1/8"	2 3/4"
57N74XL	8XL	1/2"	1 5/8"	3 1/4"
57N74XXL	8XXL	1/2"	3 1/8"	4 3/4"
53N88	10	5/8"	3/8"	1 7/8"
53N88L	10L	5/8"	1 1/8"	2 3/4"
53N88XL	10XL	5/8"	1 5/8"	3 1/4"
53N88XXL	10XXL	5/8"	3 1/8"	4 3/4"
53N87	12	3/4"	3/8"	1 7/8"
53N87L	12L	3/4"	1 1/8"	2 3/4"
53N87XL	12XL	3/4"	1 5/8"	3 1/4"
53N87XXL	12XXL	3/4"	3 1/8"	4 3/4"

Note: Prices and dimensions are subject to change without notice.

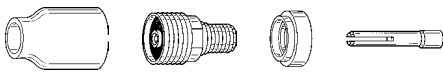
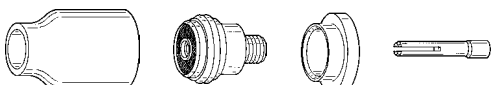
WeldTec®

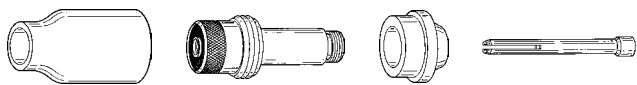
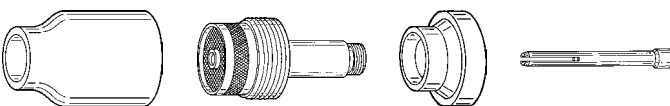
Gas Lens Kits

The **gas lens collet body system** is a big aid for most welding applications and is essential for welding reactive metals. The gas lens **virtually eliminates turbulence** in the gas stream as it emerges from the nozzle. This means fewer molecules of air are pulled into the gas stream before it reaches the weld zone. Welds are **cleaner and brighter**. The long stable stream of shielding gas allows the tungsten electrode to be extended farther from the end of the nozzle providing **improved weld zone visibility**.



Kit Includes: Gas Lens, Collet, Insulator, Alumina Nozzle

TORCH SERIES: WT-9, 9F, 9FV, 9P, 9V WT-20, 20F, 20H, 20P, 20V WT-25 SW-320	SIZE	PART NO.	KIT INCLUDES
	1/16	45V4K-116	13N22 1/16 Collet 45V43 1/16 Small Gas Lens 53N60 #6 Alumina Nozzle 598882 Gas Lens Insulator
	3/32	45V4K-332	13N23 3/32 Collet 45V44 3/32 Small Gas Lens 53N61 #7 Alumina Nozzle 598882 Gas Lens Insulator
	1/8	45V4K-18	13N24 1/8 Collet 45V45 1/8 Small Gas Lens 53N61 #7 Alumina Nozzle 598882 Gas Lens Insulator
 SMALL GAS LENS KIT REPLACES INSULATOR ON TORCH			
	1/16	45V3K-116	13N22 1/16 Collet 45V35SW 1/16 Med. Gas Lens 54N15SW #7 Alumina Nozzle 598320 Gas Lens Insulator
	3/32	45V3K-332	13N23 3/32 Collet 45V36SW 3/32 Med. Gas Lens 54N14SW #8 Alumina Nozzle 598320 Gas Lens Insulator
	1/8	45V3K-18	13N24 1/8 Collet 45V37SW 1/8 Med. Gas Lens 54N14SW #8 Alumina Nozzle 598320 Gas Lens Insulator
 MEDIUM GAS LENS KIT REPLACES INSULATOR ON TORCH			

TORCH SERIES: WT-17, 17F, 17FV, 17V WT-18, 18SP, 18V WT-26, 26F, 26FV, 26P, 26V SW-418	SIZE	PART NO.	KIT INCLUDES
	1/16	45V2K-116	10N23 1/16 Collet 45V25 1/16 Large Gas Lens 54N15 #7 Alumina Nozzle 54N01 Gas Lens Insulator *
	3/32	45V2K-332	10N24 3/32 Collet 45V26 3/32 Large Gas Lens 54N14 #8 Alumina Nozzle 54N01 Gas Lens Insulator *
	1/8	45V2K-18	10N25 1/8 Collet 45V27 1/8 Large Gas Lens 54N14 #8 Alumina Nozzle 54N01 Gas Lens Insulator *
 LARGE GAS LENS KIT USE WITH INSULATOR ON TORCH			
	1/16	45V6K-116	10N23 1/16 Collet 45V116 1/16 XL Gas Lens 57N74 #8 Alumina Nozzle 54N63 Gas Lens Insulator
	3/32	45V6K-332	10N24 3/32 Collet 45V64 3/32 XL Gas Lens 53N88 #10 Alumina Nozzle 54N63 Gas Lens Insulator
	1/8	45V6K-18	10N25 1/8 Collet 995795 1/8 XL Gas Lens 53N87 #12 Alumina Nozzle 54N63 Gas Lens Insulator
 EXTRA LARGE GAS LENS KIT USE WITH INSULATOR ON TORCH			

* An Optional One Piece Insulator Is Available. Part No. 18CG01

Specifications subject to change without notice.

Champagne Nozzle II

Super Size Nozzle Champagne Nozzle Kits

WeldTec® conceived and developed the super size champagne nozzle for all demanding weld zone flooding applications.

It can be used for exotic metals such as titanium, monel, inconel, hastelloy, waspaloy and other high temperature metals. Use it for stainless steels or any other metal requiring a complete protective umbrella of shielding gas for superior weld quality and reduced oxidation and discoloration.

An additional benefit is the ability for greater electrode stick-out for better visibility of the weld puddle.

The champagne nozzle is made from a high heat resistive non-conductive ceramic and fits standard hand held torch models WT-9, 20, 24, 25, Speedway® SW-320 and machine torch models WT-22, 23. It requires no special parts or conversion kits and mounts directly on the standard gas lens collet body used with these torch models.

The new Screen Pack filter assembly uses a stainless steel electrode guide to center the electrode, bundle and protect the fine filter screens from overheating providing longer life and ease of replacement.

These champagne nozzles can be ordered for 1/16, 3/32 or 1/8 inch diameter electrodes as individual nozzle assemblies or in convenient kits which includes the champagne nozzle assembly, gas lens collet body, collet and insulating gasket.

*Note: Many titanium welding applications may require additional trailing shield protection.

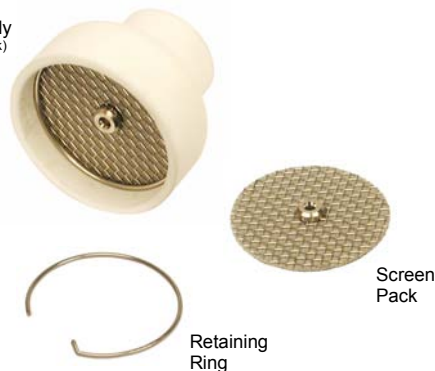
Champagne nozzle mounted on Speedway® SW-320 High Performance TIG torch.

**Biggest
Screen Area
Of It's Kind**



Champagne Nozzle

Champagne
Nozzle Assembly
(Includes Screen Pack)



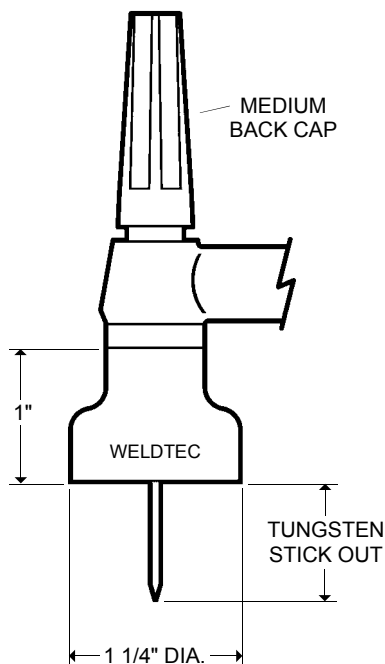
Champagne Nozzle Kits

Champagne
Nozzle Assembly
(Includes Screen Pack)



WeldTec® - "where quality and innovation never ends"

Specifications subject to change without notice.



CHAMPAGNE NOZZLE KITS

	TORCH SERIES	DESCRIPTION	PART NO.
	20	Nozzle Kit - 1/16	53CNK2-16
	22		
	23		
	25		
	SW-320	Nozzle Kit - 3/32	53CNK2-32
		Nozzle Kit - 1/8	53CNK2-18

REPLACEMENT PARTS

	DESCRIPTION	SIZE	PART NO.
	Champagne Nozzle	1/16	53N6CN2-16
		3/32	53N6CN2-32
		1/8	53N6CN2-18
	Screen Pack	1/16	53N6SP-16
	Screen Pack	3/32	53N6SP-32
	Screen Pack	1/8	53N6SP-18
	Gas Lens	1/16	45V43
	Gas Lens	3/32	45V44
	Gas Lens	1/8	45V45
	Collet	1/16	13N22
	Collet	3/32	13N23
	Collet	1/8	13N24
	Insulating Gasket		598882

Note: Specifications and dimensions are subject to change without notice.

WeldTec®

bullet proof. . .

. . . that's the only way to describe WeldTec's new Overcoat™ leather cable covers.



These unique patented two-piece protective covers are made using a “bullet proof” cowhide leather main cover and a glove soft leather extension cover. They are designed specifically to bundle and protect the expensive hoses and cables used on TIG torches, MIG guns and plasma torches.

The cowhide leather cover will take the abuse of being dragged on the shop floor, over the weld fixture and even over sharp edges on the work piece. It is not affected by sparks, spatter, flames, heat or cold and is closed with a “bullet proof” Velcro® closure that will not arc-out or melt and is double stitched with heat resistant Kevlar® thread for durability.

The 6 foot glove soft leather extension cover is fitted with a non-conductive zipper closure and extends from the cowhide cover up to the TIG torch handle giving the operator a light weight, highly flexible protective cover at the torch end. The softer extension cover resists burns, tears, cuts and does not pickup grinding burrs. The two covers can easily be replaced separately if needed.

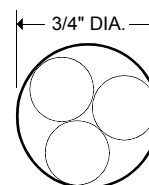
These protective covers will pay for themselves many times over in reduced cable/hose replacement costs and reduced down time.

Complete 2 Pc. Sets

Part Number	Description	Torch Length
TOC-12	12 ft. Overcoat® Leather Cable Cover Set	12 1/2 ft.
TOC-24	24 ft. Overcoat® Leather Cable Cover Set	25 ft.

Individual Cover Segments

Part Number	Description	Torch Length
TOC-6P	6 ft. Pigskin Leather Cable Cover	12 1/2 & 25 ft.
TOC-6CH	6 ft. Cowhide Leather Cable Cover	12 1/2 ft.
TOC-18CH	18 ft. Cowhide Leather Cable Cover	25 ft.



Cover bundles up to 3/4" diameter.



WeldTec® - “where quality and innovation never ends”

Specifications subject to change without notice.

TEC TORCH COMPANY, INC. • PO BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121
COPYRIGHT 2008 TEC TORCH CO. INC. www.tigtorch.com e-mail info@tectorch.com 50 Years of TIG Innovation

WeldTec® Cable Covers

Type	Description	Torch Length	Width	Length	Zipper	Velcro
 This soft & supple leather cover is burn, spatter, tear and abrasion resistant.	Premium Leather	12 1/2 Ft. 25 Ft.	3" 3"	11 Ft. 24 Ft.	TCL-3-10Z TCL-3-22Z	TCL-3-10V TCL-3-22V
 Traditional woven nylon cover. Soft, flexible and lightweight. Good abrasion and tear resistance.	Black Nylon	12 1/2 Ft. 25 Ft. 12 1/2 Ft. 25 Ft.	3" 3" 4" 4"	11 Ft. 24 Ft. 11 Ft. 24 Ft.	TC-3-10Z TC-3-22Z TC-4-10Z TC-4-22Z	TC-3-10V TC-3-22V TC-4-10V TC-4-22V
 Bright visible color. Soft lightweight with good tear and abrasion resistance.	Safety Orange Nylon	12 1/2 Ft. 25 Ft.	3" 3"	11 Ft. 24 Ft.	TCO-3-10Z TCO-3-22Z	TCO-3-10V TCO-3-22V
 Bright visible color. Soft lightweight with good tear and abrasion resistance.	Optic Yellow	12 1/2 Ft. 25 Ft.	3" 3"	11 Ft. 24 Ft.	TCY-3-10Z TCY-3-22Z	TCY-3-10V TCY-3-22V

Wide Choice of Materials

WeldTec cable covers are available in two types of materials: glove-soft leather and soft woven nylon. Each type of material offers bundling and protection for the expensive torch cable and hoses.

Double Stitched Construction

Careful workmanship insures long life with double stitching of the closure. Cover ends are fused to resist fraying and ty-straps are provided to secure the cover to the torch handle.

Non-conductive Zipper or Velcro Closure

The full length closure allows installation of the cover without removing the torch from the welding machine. The non-conductive zipper will not conduct "HF" current and is protected from hot metal contact by the overlap flap construction. Velcro closure is not affected by burn or melt spots.

Standard Sizes

3" wide up to 3/4" diameter bundle and 4" wide up to 1 1/4" diameter bundle. Special sizes and lengths are available on special order.

WeldTec®

**Fits...
Miller®, Lincoln®
Hobart®**

Control Switches

These new "SS" switches are the latest advancement in torch mounted controls. They mount quickly and easily to most torch handles with convenient tie straps. They come complete with switch, cord and machine plug.



WT-20 TIG torch shown with SS-5 On/Off switch.

- SWITCH SADDLE FITS MOST HANDLES
- THREE INTERCHANGEABLE SWITCHES
- SNAP ACTION CONTACTS
- NO SOLDER WIRE CONNECTIONS
- MODERN CIRCUIT BOARD DESIGN
- LOW PROFILE

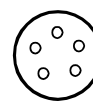
Complete Switch Assemblies

DESCRIPTION	PART NO.
Flat Top Momentary Switch, Cord and Machine Plug	SS-1F-28 X
Joy Stick Momentary Switch, Cord and Machine Plug	SS-1J-28 X
Push Button On/Off Switch, Cord and Machine Plug	SS-5-28 X

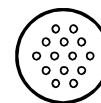
Switch Assembly

Includes: Switch saddle, switch, mounting straps, cord and machine plug.

X = Plug Selection
M5 = Miller 5 Pin
M14 = Miller 14 Pin
L6 = Lincoln 6 Pin
T = Thermal Arc



Miller 5



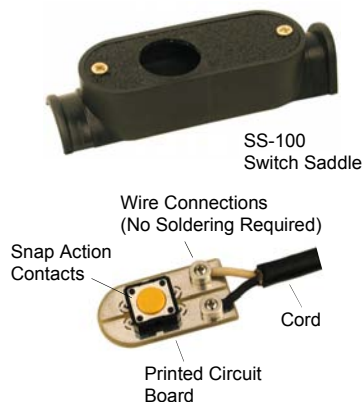
Miller 14



Lincoln 6

Switch extension cords are available.

"SS" Series Switch Saddle



PART NO.	DESCRIPTION
SS-100	Plastic Switch Saddle Housing With Cover
SS-1F	Momentary Switch - Flat Top
SS-1J	Momentary Switch - Joy Stick
SS-5	On/Off Switch - Raised Push Button



SS-1F
Flat Top



SS-1J
Joy Stick



SS-5
On/Off

SS-1F, SS-1J - Press and hold for contact.

SS-5 - Press once for on press again for off.

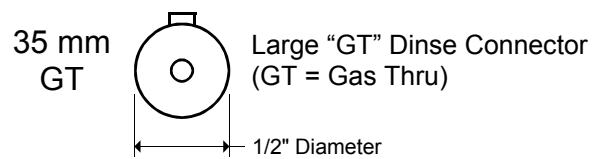
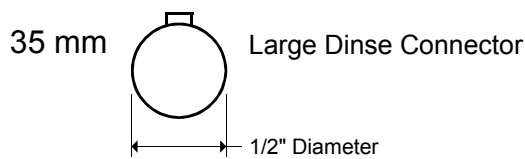
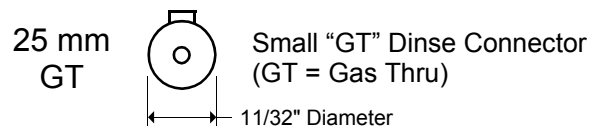
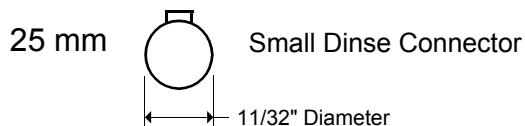
All switches fit into switch saddle housing.

QUICK CONNECTOR GUIDE

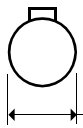
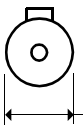
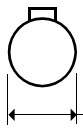
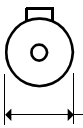


WeldTec®

DIMENSIONAL INFORMATION



Dinse style connectors are also referred to as: International Style Connectors, Twist-Mate™ Connectors, Twist Lock Connectors, DIN Connectors and Dinse Type Plugs. All connectors in each size group (25 or 35) should be interchangeable.

MACHINE MODEL	TORCH MODEL - DINSE ADAPTER						
	9, 17, 24 1 piece power cable		26 1 piece power cable		All Water Cooled Torches		
Miller®		KEY		KEY		KEY	
Econotig	3538GT	H	3578G-GT	I	3578W-GT	K	A  2538
Syncrowave 180 SD	3538GT	H	3578G-GT	I	3578W-GT	K	
Syncrowave 200	3538GT	H	3578G-GT	I	3578W-GT	K	B  2538-18
Syncrowave 250 DX (w/stud)	3538 + 35MA	C,L	3578G + 35MA	E,L	3578W + 35MA	J,L	
Syncrowave 250 DX	3538-18	D	3578G-18	F	3578W	J	C  3538
Syncrowave 350 SD, DX, LX (w/stud)	3538 + 35MA	C,L	3578G + 35MA	E,L	3578W + 35MA	J,L	
Syncrowave 350 LX	3538-18	D	3578G-18	F	3578W	J	D  3538-18
Dynasty 200 SD, DX	3538-18	D	3578G-18	F	3578W	J	
Dynasty 300, 350 SD, DX, LX	3538-18	D	3578G-18	F	3578W	J	E  3578G
Maxstar 140	2538	A	NA		NA		
Maxstar 150 STL	2538GT	G	NA		NA		F  3578G-18
Maxstar 200 SD, DX	3538-18	D	3578G-18	F	3578W	J	
Maxstar 300, 350 SD, DX, LX	3538-18	D	3578G-18	F	3578W	J	G  2538GT Gas Thru
Lincoln®							
Square Wave 175 PRO	3538GT	H	3578G-GT	I	3578W-GT	K	H  3538GT Gas Thru
Square Wave 275	3538GT	H	3578G-GT	I	3578W-GT	K	
Precision TIG 185	3538GT	H	3578G-GT	I	3578W-GT	K	I  3578G-GT Gas Thru
Precision TIG 225	3538GT	H	3578G-GT	I	3578W-GT	K	
Precision TIG 275 / 375	1 pc cable + PCA-2-4		3578G-18 + 35AS11	F,M	3578W + 35AS11	J,M	J  3578W
Invertec V155 S	2538	A	NA		NA		
Invertec V160 T	3538GT	H	3578G-GT	I	3578W-GT	K	K  3578W-GT Gas Thru
Invertec V205 T	3538GT	H	3578G-GT	I	3578W-GT	K	
Invertec V310 T	3538GT	H	3578G-GT	I	3578W-GT	K	L  35MA Stud Machine
Invertec V311 T	3538GT	H	3578G-GT	I	3578W-GT	K	
ESAB®							M  35AS11
Miniarc 90	2538	A	NA		NA		
Miniarc 140	2538	A	NA		NA		Dimensional Information
Miniarc 150	2538	A	NA		NA		
Heliarc 161	3538-18	D	3578G	E	3578W	J	25 mm  Small Dinse Connector 11/32" Diameter
Heliarc 252 / 352	1 pc cable + PCA-2-4		3578G-18 + 35AS11	F,M	3578W + 35AS11	J,M	
Thermal Arc®							35/50 mm  Large Dinse Connector 1/2" Diameter
ArcMaster 160 TS	3538-18	B	NA		NA		
ArcMaster 185	3538-18	D	3578G-18	F	3578W	J	25 mm GT  Small "GT" Dinse Connector (GT = Gas Thru) 11/32" Diameter
ArcMaster 200	3538-18	D	3578G-18	F	3578W	J	
ArcMaster 300 TS	3538-18	D	3578G-18	F	3578W	J	35/50 mm GT  Large "GT" Dinse Connector (GT = Gas Thru) 1/2" Diameter
ArcMaster 400 TS	3538-18	D	3578G-18	F	3578W	J	
P-Wee 160 TS	2538-18	B	NA		NA		Dimensional Information
Pro-Plus 400 GTS	3538-18	D	3578G-18	F	3578W	J	
Pro-Plus 400 MST	3538-18	D	3578G-18	F	3578W	J	25 mm  Small Dinse Connector 11/32" Diameter
Pro-Wave 185 GTSW	3538-18	D	3578G-18	F	3578W	J	
Pro-Wave 300 GTSW	3538-18	D	3578G-18	F	3578W	J	35/50 mm  Large Dinse Connector 1/2" Diameter
Pro-Wave 400 GTSW	3538-18	D	3578G-18	F	3578W	J	
Pro-Lite 250 TS	3538-18	D	3578G-18	F	3578W	J	25 mm GT  Small "GT" Dinse Connector (GT = Gas Thru) 11/32" Diameter
Pro-Lite LS-300	3538	C	3578G	E	3578W	J	
Dragster 80, 85	2538	A	NA		NA		35/50 mm GT  Large "GT" Dinse Connector (GT = Gas Thru) 1/2" Diameter
Hobart®							
TIGMATE	3538GT	H	3578G-GT	I	3578W-GT	K	Dimensional Information

Note: Threaded stud machine & engine drives use 1/2" threaded studs, use 35MA machine adapter plus dinse adapter.

DCG05-2010

AIR COOLED TORCHES

	TYPE	DESCRIPTION	TORCH SERIES	PART NUMBER
	25 mm	Connector With 6 ft. Gas Supply Hose For Air Cooled WT-9V, 17V With One Piece Power Cable. Gas Connection To Flowmeter.	9V, 9FV 17V, 17FV	2538
	25 mm	Connector With 18 in. Gas Supply Hose For Air Cooled WT-9, 17 With One Piece Power Cable. Gas Connection To Machine.	9, 17	2538-18
	25 mm	Connector With 6 ft. Gas Supply Hose For Air Cooled WT-26V With One Piece Power Cable. Gas Connection To Flowmeter.	26V, 26FV	2578G

	35 mm	Connector With 6 ft. Gas Supply Hose For Air Cooled WT-9V, 17V With One Piece Power Cable. Gas Connection To Flowmeter.	9V, 9FV 17V, 17FV	3538
	35 mm	Connector With 18 in. Gas Supply Hose For Air Cooled WT-9, 17 With One Piece Power Cable. Gas Connection To Machine.	9, 17	3538-18
	35 mm	Connector With 6 ft. Gas Supply Hose For Air Cooled WT-26V With One Piece Power Cable. Gas Connection To Flowmeter.	26V, 26FV	3578G
	35 mm	Connector With 18 IN. Gas Supply Hose For Air Cooled WT-26 With One Piece Power Cable. Gas Connection To Machine.	26	3578G-18

GT - GAS THRU STYLES

	25 mm GT	Gas Thru Connector For Air Cooled WT-9, 17 Torch Models With One Piece Power Cable.	9, 17	2538GT
	35 mm GT	Gas Thru Connector For Air Cooled WT-9, 17 Torch Models With One Piece Power Cable.	9, 17	3538GT
	35 mm GT	Gas Thru Connector For Air Cooled WT-26 Torch Models With One Piece Power Cable.	26	3578G-GT
	35 mm GT	Gas Thru Connector - 2 pc For Air Cooled WT-9, 17, 26 Torch Models With Two Piece Power Cable.	9, 17, 26	3558-GT2

CC - CABLE CONNECTOR STYLES

	25 mm	Connector - Welding Cable For Air Cooled WT-9, 17 With Two Piece Power Cable. Gas Connection To Machine.	9, 17	25CC
	35 mm	Connector - Welding Cable For Air Cooled WT-9, 17, 26 With Two Piece Power Cable. Gas Connection To Machine.	9, 17, 26	35CC

Specifications subject to change without notice.

WATER COOLED TORCHES

	TYPE	DESCRIPTION	TORCH SERIES	PART NUMBER
 25 mm Water Return Hose 2578W	25 mm	Connector With 6 ft. Water Return Hose For All Water Cooled Torches. Water Connection To Water Cooler.	18, 20 24W, 25	2578W
 35 mm Water Return Hose 3578W	35 mm	Connector With 6 ft. Water Return Hose For All Water Cooled Torches. Water Connection To Water Cooler.	18, 20 24W, 25	3578W
 35 mm GT Water Return Hose 3578W-GT 5/8" RH Gas Hose Connection 7/8" LH Power Cable Connection 5/8" LH Water Return Hose Connection	35 mm GT	Gas Thru Connector With 6 ft. Water Return Hose For All Water Cooled Torches. Water Connection To Water Cooler. REF. (LINCOLN® SW 175, SW 275; MILLER® Econotig®, SW 180)	18, 20 24W, 25	3578W-GT

ACCESSORIES

	DESCRIPTION	PART NUMBER
 35HNC-G	Gas Hand Nut Coupler Converts Standard Hose Fitting To Quick Connect Type. 5/8" RH Female X 5/8" RH Male	35HNC-G
 35HNC-W	Water Hand Nut Coupler Converts Standard Hose Fitting To Quick Connect Type. 5/8" LH Female X 5/8" LH Male	35HNC-W
 35QR-G	Gas Connector And Plug Converts Standard Hose Fitting To Quick Connect Type. 5/8" RH Female X 5/8" RH Male	35QR-G
 35QR-W	Water Connector And Plug Converts Standard Hose Fitting To Quick Connect Type. 5/8" LH Female X 5/8" LH Male	35QR-W
 35MA	Machine Adapter - Female Converts Machine With 1/2 Thread Stud Connection To 35 mm Quick Connect.	35MA
 35AS11	Adapter Sleeve - Direct Connect Converts 7/8" LH Direct Thread Connection To 35 mm Quick Connect. REF. (ESAB® 252, 352; LINCOLN® PT 275, PT 375)	35AS11
 35HN-G	Gas Hand Nut 5/8" RH Male Use With O-Ring Nipple	35HN-G
 35HN-W	Water Hand Nut 5/8" LH Male Use With O-Ring Nipple	35HN-W

Quick Connector Kits

Water Cooled Torches

Convert your Miller®, Lincoln®, ESAB® machines to quick connectors for water cooled TIG torches. True quick connect, no tools needed.



Converter Kit - 1/2" Stud Machines

Water Cooled Torches

Converts 1/2" stud machines to Quick Connect setup.

3578K

Includes: **35MA** Machine Adapter - Female
(1 ea.) **3578W** Connector with 6 ft. Water Return Hose
35HNC-W Water Hand Nut Coupler
35HNC-G Gas Hand Nut Coupler

Use on: All machines with 1/2" threaded stud connections.



Quick Connect Kit - Dinse Style

Side Hose Connection - Water Cooled Torches

Converts Plug-In DIN machines to Quick Connect setup.

3578K-SH

Includes: **3578W** Connector with 6 ft. Water Return Hose
(1 ea.) **35HNC-W** Water Hand Nut Coupler
35HNC-G Gas Hand Nut Coupler

Use on: All inverter style machines with 35 mm plug-in connections.



Quick Connect Kit - Dinse Style

"Gas Thru" Connection - Water Cooled Torches

Converts Plug-In Gas Thru machines to Quick Connect setup.

3578K-GT

Includes: **3578W-GT** Connector with 6 ft. Water Return Hose
(1 ea.) **35HNC-W** Water Hand Nut Coupler

Use on: Econotig®, Syncrowave® 180SD, Squarewave® 175, 175 PRO, Squarewave® 275, Precision TIG™ 185, or similar machines.



Optional - Water Extension Hose

6 Ft. extension hose for the water return line to the water cooler. Includes coupler.

40V76-6U

WeldTec® - "where quality and innovation never ends"



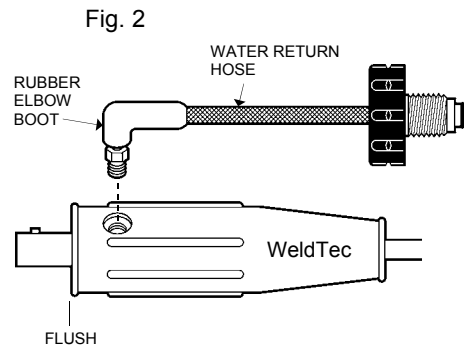
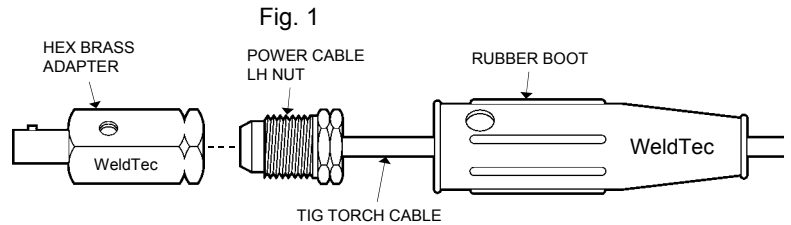
MACHINE / DINSE CONNECTOR CHART

MFG	Status	MACHINE MODEL	POWER CONN.	GAS	WATER	TORCH MODEL - DINSE ADAPTER		
						9, 17, 24	26	All Water
						1 piece power cable**	1 piece power cable**	Cooled Torches
Miller	New Old New Old New	Econotig ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Syncrowave 180 SD ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Syncrowave 200 ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Syncrowave 250 DX ac/dc	1/2" Stud	Under frt panel	None	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Syncrowave 250 DX ac/dc	35mm	Front panel	None	3538-18	3578G-18	3578W
		Syncrowave 350 SD,DX,LX ac/dc	1/2" Stud	Under frt panel	None	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Syncrowave 350 LX ac/dc	35mm	Front panel	None	3538-18	3578G-18	3578W
		Aerowave ac/dc	1/2" Stud	Front panel	None	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Dynasty 200 SD,DX ac/dc	35mm	Front panel	None	3538-18	3578G-18	3578W
		Dynasty 300 SD, DX, LX	35mm	Front panel	None	3538-18	3578G-18	3578W
	New	Maxstar 140 dc	25mm	None*	None	2538	2578G	-
		Maxstar 150 STL dc	25mm - Gas Thru	Gas Thru	None	2538GT	-	-
		Maxstar 200 SD, DX dc	35mm	Front panel	None	3538-18	3578G-18	3578W
		Maxstar 300 SD, DX, LX dc	35mm	Front panel	None	3538-18	3578G-18	3578W
Lincoln	New	Square Wave 175 PRO ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Square Wave 275 ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Precision TIG 185 ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Precision TIG 225 ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Precision TIG 275 ac/dc	Direct Connect	Side Pod	Side Pod	"R" Cable + PCA-2-4	3578G-18 + 35AS11	Call Factory
		Precision TIG 375 ac/dc	Direct Connect	Side Pod	Side Pod	"R" Cable + PCA-2-4	3578G-18 + 35AS11	Call Factory
		Invertec V160-T dc	35mm - Gas Thru	Gas Thru	None	3538GT	378G-GT	3578W-GT
		Invertec V205-T ac/dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Invertec V350-PRO dc	35mm	None* - Kit	None	3538	3578G	3578W
		V100-S dc	35mm	None*	None	3538	3578G	3578W
		V130-S dc	35mm	None*	None	3538	3578G	3578W
		Invertec V200-T dc	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Invertec V250-S dc	35mm	None*	None	3538	3578G	3578W
		Invertec V300-PRO dc	35mm	None*	None	3538	3578G	3578W
ESAB		Miniarc 90 dc	25mm	None*	None	2538	2578G	2578W
		Miniarc 140 dc	25mm	None*	None	2538	2578G	2578W
		Miniarc 150 dc	25mm	None*	None	2538	2578G	2578W
		Heliarc 161 ac/dc	35mm	Front panel	None	3538-18	3578G	3578W
		Heliarc 252 ac/dc	Direct Connect	Front panel	Front	"R" Cable + PCA-2-4	3578G-18 + 35AS11	3578W + 35AS11
		Heliarc 352 ac/dc	Direct Connect	Front panel	Front	"R" Cable + PCA-2-4	3578G-18 + 35AS11	3578W + 35AS11
Thermal Dynamics ThermalArc	New	P-Wee 130 GTS	25mm	None*	None	2538	2578G	-
		P-Wee 160 TS dc	25mm	Front panel	None	2538-18	2578G	2578W
		P-Wee 200 GTS	25mm	None*	None	2538	2578G	-
		P-Wee 250 GTS	25mm	None*	None	2538	2578G	-
	New	Pro-Plus 400 GTS	35mm	Front panel	None	3538-18	3578G-18	3578W
		Pro-Plus 400 MST dc	35mm	Front panel	None	3538-18	3578G-18	3578W
	New	Pro-Wave 185	35mm	Front panel	None	3538-18	3578G-18	3578W
		Pro-Wave 185 TSW ac/dc	35mm	Front panel	None	3538-18	3578G-18	3578W
	New	Pro-Wave 300 GTSW	35mm	Front panel	None	3538-19	3578G-19	3578W
		Pro-Wave 300 TSW ac/dc	35mm	Front panel	None	3538-18	3578G-18	3578W
	New	Pro-Wave 400 GTSW	35mm	Front panel	None	3538-18	3578G-18	3578W
		Pro-Lite 250 TS dc	35mm	Front panel	None	3538-18	3578G-18	3578W
		Pro-Lite LS-300	35mm	None*	None	3538	3578G	3578W
		Dragster 80	25mm	None*	None	2538	2578G	-
		Power Master 500 ac/dc	1/2" Stud	None	None	3538 + 35MA	3578G + 35MA	3578W + 35MA
Hobart These now ThermalArc		Econotig	35mm - Gas Thru	Gas Thru	None	3538GT	3578G-GT	3578W-GT
		Ultraweld 130	25mm	None*	None	2538	2578G	2578W
		Porta-Tig	1/2" Stud	Front panel	Ft panel	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Tigwave 250 AC/DC	1/2" Stud	Under frt panel	Opt. water	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Tigwave 350 AC/DC	1/2" Stud	Under frt panel	Opt. water	3538 + 35MA	3578G + 35MA	3578W + 35MA
		Arc-Master 351, 501	1/2" Stud	None	None	3538 + 35MA	3578G + 35MA	3578W + 35MA
		CD Arc Start	1/2" Stud	Side panel	None	3538 + 35MA	3578G + 35MA	3578W + 35MA

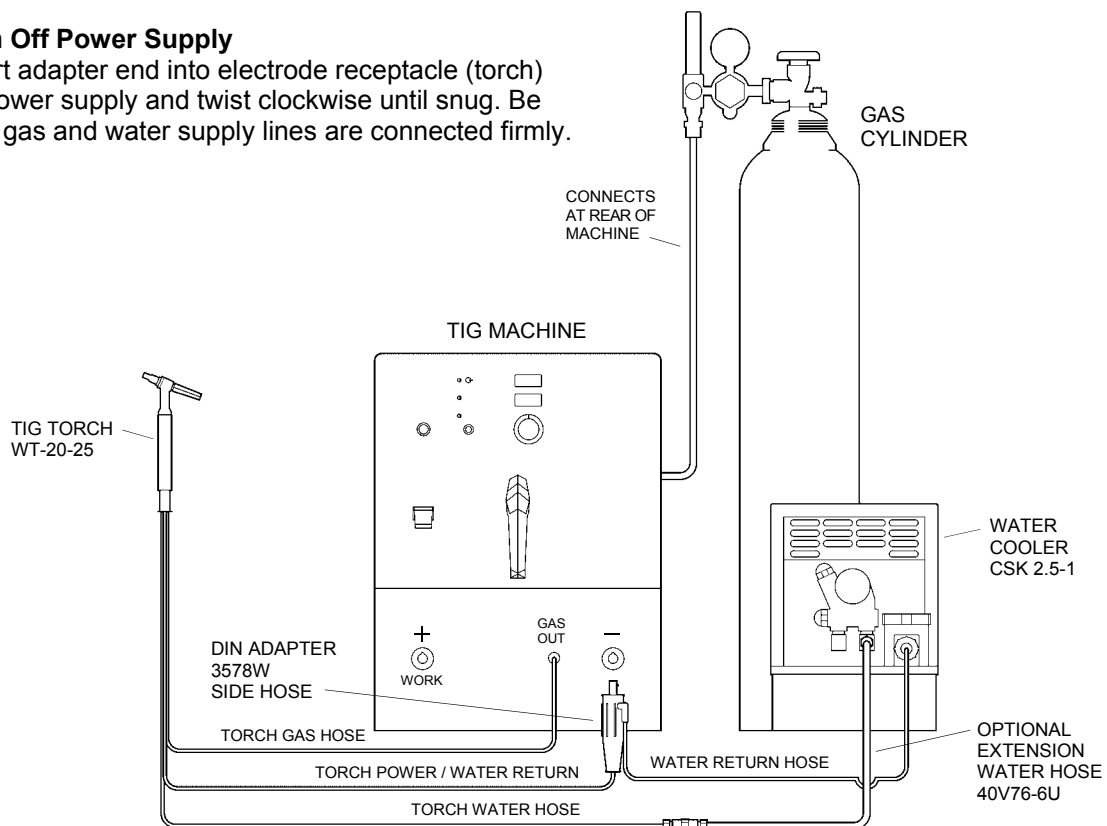
Bold are current models. * Use "V" or "FV" model torch with built in gas valve. ** Call factory for 2 piece power cable connections.

QUICK CONNECTOR INSTALLATION INSTRUCTIONS SH - SIDE HOSE

- Push the torch power cable nut thru the hole on the tapered end of the rubber boot as shown in Fig. 1.
(This will take a little effort to get started.)
- Screw the brass nut into the hex adapter. Note Left Hand - "LH" threads. Tighten only snug. Do not over tighten.
- Align the small side hole on the hex brass adapter with the side hole on the rubber boot before pushing the boot completely to the edge of the hex portion.
- Position the rubber boot side hole to expose the threaded side hole on the hex brass adapter and attach the hose connection as shown in Fig. 2.
Note Right Hand - "RH" threads. Tighten only snug. Do not over tighten. Slide rubber elbow boot over connection for insulation.
- Connect other end of water return hose assembly to water-in side of water cooler.
Note Left Hand - "LH" threads on brass nut.



- **Turn Off Power Supply**
Insert adapter end into electrode receptacle (torch) on power supply and twist clockwise until snug. Be sure gas and water supply lines are connected firmly.



QUICK CONNECTOR INSTALLATION INSTRUCTIONS GT - GAS THRU

- Screw the brass nut of the torch power cable into the hex adapter as shown in Fig. 1. Repeat for torch gas hose and water return hose. Note Left Hand - "LH" threads. Right Hand - "RH" threads. Tighten only snug. Do not over tighten.

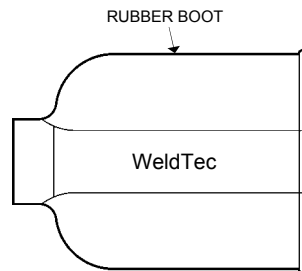
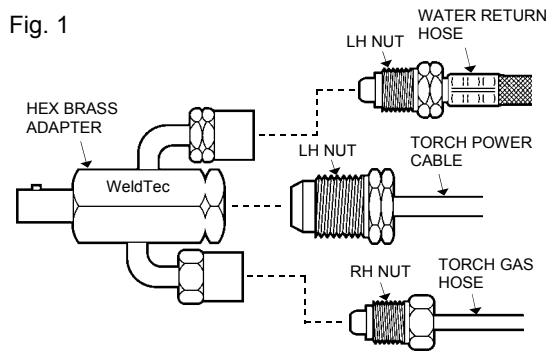
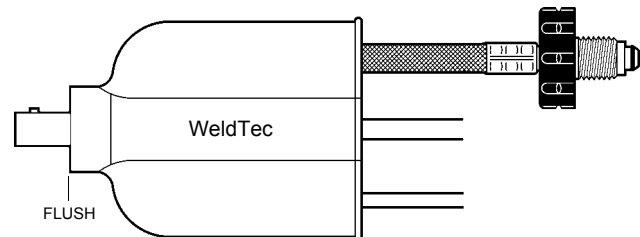


Fig. 1

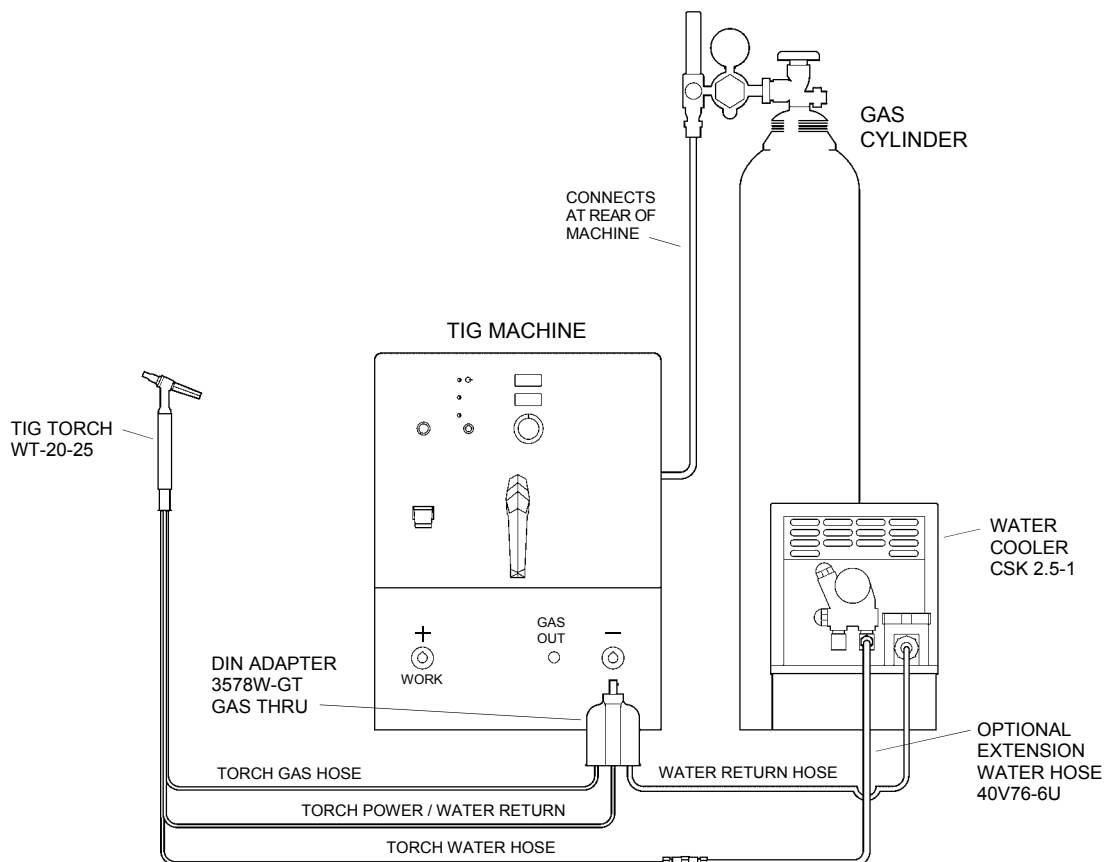


- Push the rubber boot onto hex adapter assembly. Align the boot to the edge of hex adapter as shown in Fig. 2.

Fig. 2



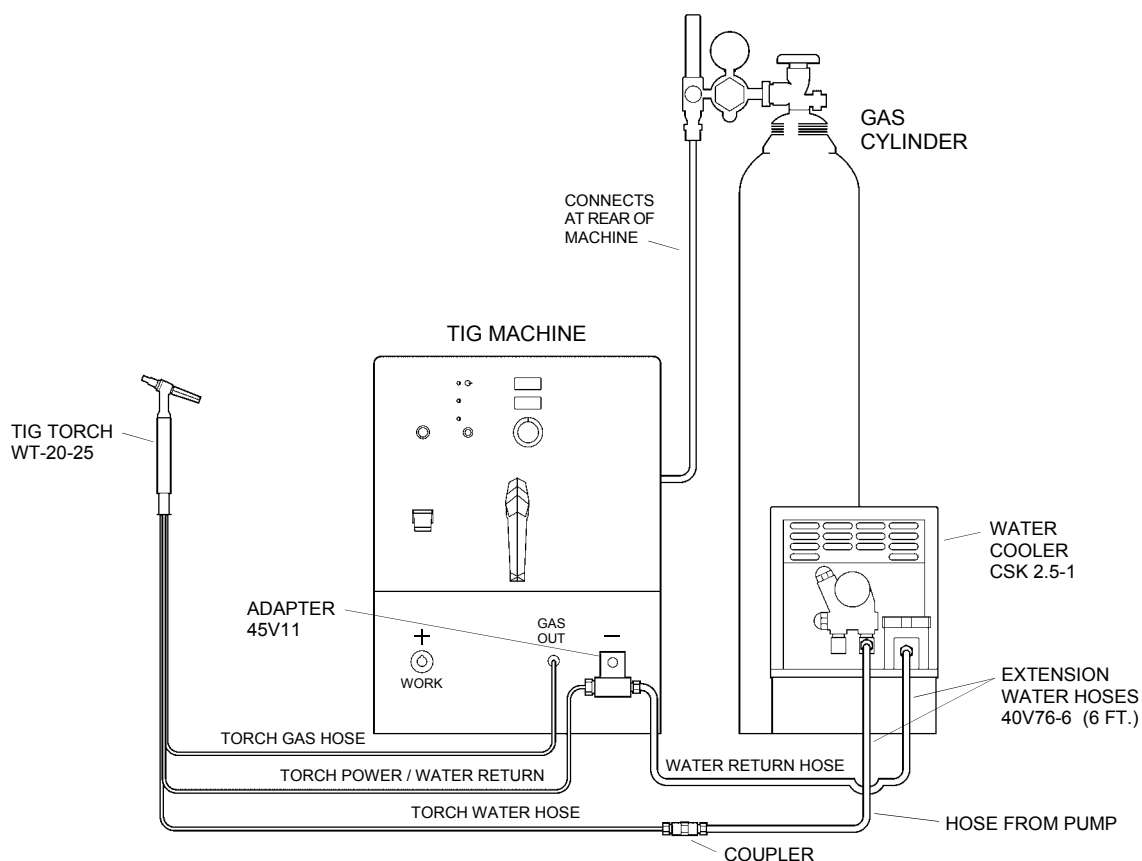
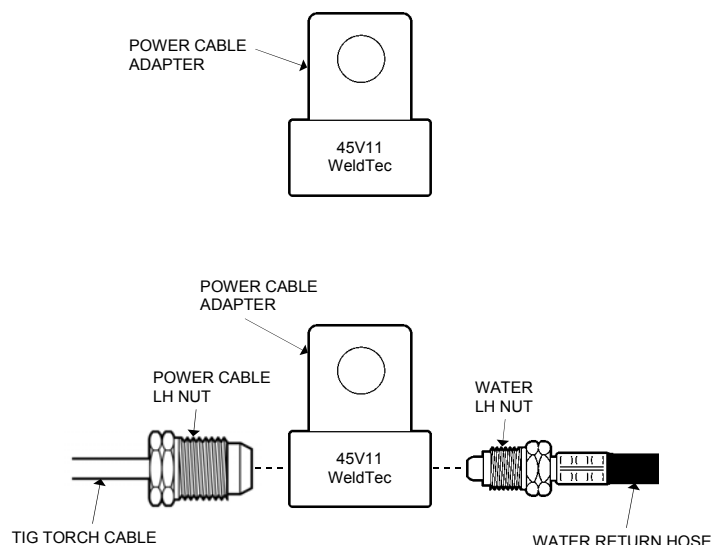
- Connect other end of water return hose assembly to water-in side of circulator. Note "LH" threads on brass nut.
- **Turn Off Power Supply**
Insert adapter end into torch receptacle (electrode) on power supply and twist clockwise until snug. Be sure gas and water supply lines are connected firmly.



INSTALLATION INSTRUCTIONS ALL WATER COOLED TORCHES

PCA - ADAPTER THREADED STUD CONNECTION

- Turn off power supply. Mount the power cable adapter to electrode (torch) stud on the power supply.
- Screw the brass nut (power cable) and brass nut (water return hose) into adapter. Connect other end of hose to water return (water in) side of water cooler. Note Left Hand - "LH" threads. Tighten only snug. Do not over tighten.



EXTENSION ADAPTERS AIR COOLED

	DESCRIPTION	TORCH SERIES	PART NUMBER
 3558F-GT 35 mm Gas Thru Connection Extension Cable Connection 5/8" RH Gas Hose Connection	Power Cable Adapter With Boot For Air Cooled WT-9, 17, 26 Torch Models. Female Connector Which Allows Torches Using 35 mm "GT" Gas Thru Connectors To Plug Into Extension Cable And Gas Hose.	9, 17, 26	3558F-GT
 PCA-2 3/8" RH Torch Cable Connection Extension Cable Connection 5/8" RH Gas Hose Connection	Power Cable Adapter With Boot For Air Cooled WT-9, 17 Torch Models. Connects Standard Torch Cable (1 Pc - R) To Extension Cable And Gas Hose.	9, 17	PCA-2
 PCA-3G 7/8" RH Torch Cable Connection Extension Cable Connection 5/8" RH Gas Hose Connection	Power Cable Adapter With Boot For Air Cooled WT-26 Torch Models. Connects Standard Torch Cable (1 Pc - R) To Extension Cable And Gas Hose.	26	PCA-3G

WATER COOLED

	DESCRIPTION	TORCH SERIES	PART NUMBER
 PCA-3W 7/8" LH Torch Cable Connection Extension Cable Connection 5/8" LH Water Hose Connection Gas Coupler Water Coupler	Power Cable Adapter With Boot For All Water Cooled Torch Models. Connects Standard Torch Cable To Extension Cable And Water-Return Hose. Couplers Provided For Water-In Hose And Gas Hose.	18, 20 24W, 25	PCA-3W

NOTE: Extension cable and hoses not included with adapters - contact distributor.

EXTENSION ADAPTER INSTALLATION INSTRUCTIONS

PCA - 2

- Push the torch power cable thru the hole on the small end of the rubber boot as shown in Fig. 1.

- Screw the brass nut into the power cable adapter. Note Right Hand - "RH" threads. Do not over tighten.

- Screw the brass nut on the gas hose extension into the power cable adapter. Note Right Hand - "RH" threads. Do not over tighten.

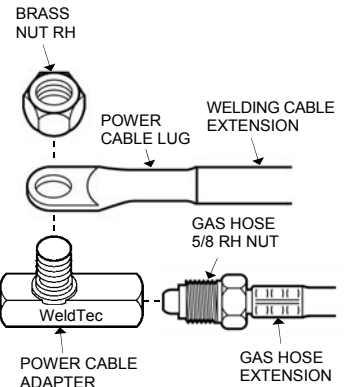
- Attach and align the power cable lug onto the brass stud and tighten with brass nut.

- Position the rubber boot over the power cable adapter as shown in Fig. 2.

- **Turn Off Power Supply**
Connect other end of welding cable extension to electrode receptacle (torch) on power supply.

- Connect other end of gas hose extension to flowmeter/regulator on gas cylinder. Note Right Hand - "RH" threads. Do not over tighten.

Fig. 1

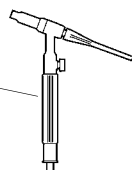


Note: PCA-2 includes power cable adapter, brass nut and rubber boot.

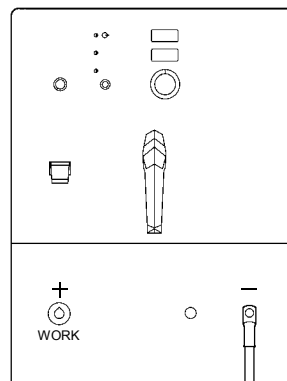
Fig. 2



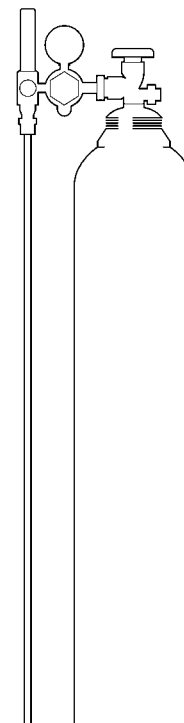
AIR COOLED
TIG TORCH
WITH BUILT IN
GAS VALVE
WT-9V, 9FV
WT-17V, 17FV



GAS DRIVE
OR
TIG MACHINE



ARGON GAS
CYLINDER



GAS EXT. HOSE
40V77 12 1/2 Ft.
40V77L 25 Ft.

TORCH POWER CABLE

EXTENSION
ADAPTER
PCA-2

WELDING CABLE EXTENSION

EXTENSION ADAPTER INSTALLATION INSTRUCTIONS

PCA - 3G

- Push the torch power cable thru the hole on the small end of the rubber boot as shown in Fig. 1.

- Screw the brass nut into the power cable adapter. Note Right Hand - "RH" threads. Do not over tighten.

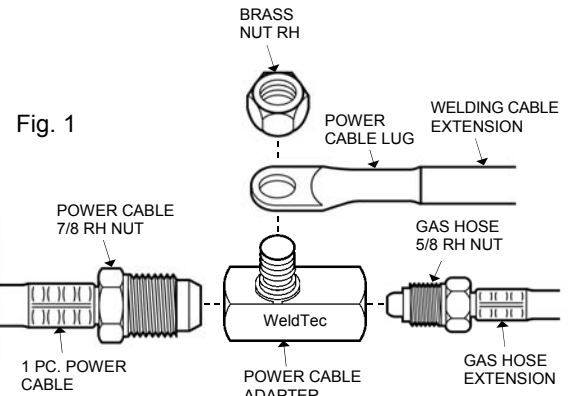
- Screw the brass nut on the gas hose extension into the power cable adapter. Note Right Hand - "RH" threads. Do not over tighten.

- Attach and align the power cable lug onto the brass stud and tighten with brass nut.

- Position the rubber boot over the power cable adapter as shown in Fig. 2.

- **Turn Off Power Supply**
Connect other end of power cable extension to electrode receptacle (torch) on power supply.

- Connect other end of gas hose extension to flowmeter/regulator on gas cylinder. Note Right Hand - "RH" threads. Do not over tighten.

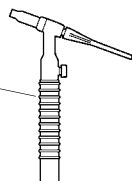


Note: PCA-3G includes power cable adapter, brass nut and rubber boot.

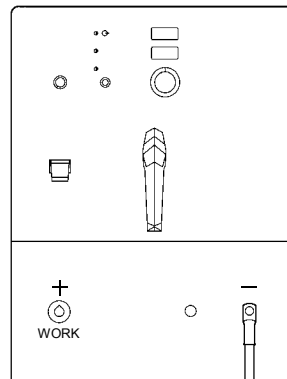
Fig. 2



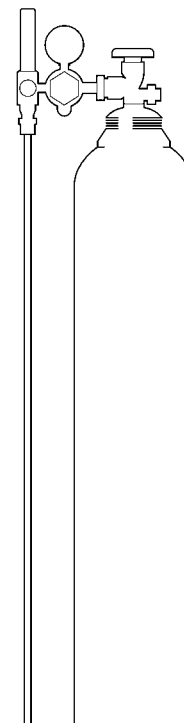
AIR COOLED
TIG TORCH
WITH BUILT IN
GAS VALVE
WT-26V, 26FV



GAS DRIVE
OR
TIG MACHINE



ARGON GAS
CYLINDER



GAS EXT. HOSE
40V77 12 1/2 Ft.
40V77L 25 Ft.

TORCH POWER CABLE

EXTENSION
ADAPTER
PCA-3G

WELDING CABLE EXTENSION

Whip - Extension Power Cables Air Cooled TIG Torches WT-9 WT-17



Whip Cable on Standard Rubber Power Cable



Whip Cable on 2-Pc Power Cable



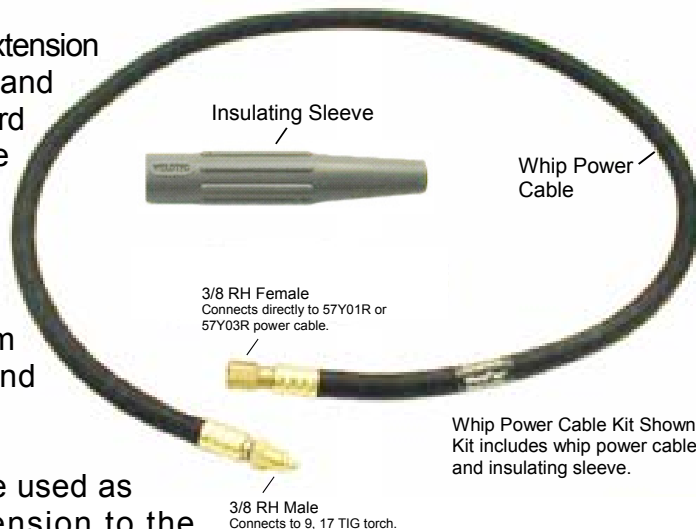
Whip Cable with PCA-2 Adapter

These "super flexible" whip - extension power cables add flexibility and maneuverability to the standard TIG torch giving the welder more control and ease of use.

Made from a soft non-conductive rubber tube with a durable over braided cover for maximum flexibility, kink resistance and light weight.

These power cables can be used as a whip lead or as an extension to the existing torch power cable. They simply connect to the torch end of the normal power cable and the connection is protected from damage and electrical shorting with the insulating sleeve supplied in the kits.

The whip - extension power cables are available in 3, 6, 12.5 and 25 foot lengths.



Whip Power Cable Kit Shown
Kit includes whip power cable and insulating sleeve.

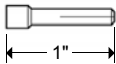
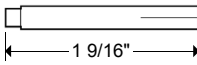
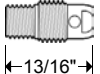
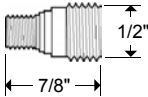
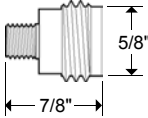
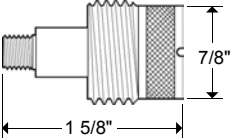
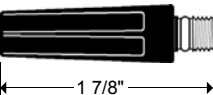
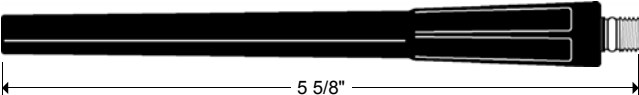
ORDER INFORMATION

POWER CABLE ONLY	Torch Series	Part Number	Length (ft.)	Description
	9, 17	57Y01SF - 3W	3	Whip Power Cable Assembly
		57Y01SF - 6W	6	Whip Power Cable Assembly
		57Y01SF - 12W	12	Extension Power Cable Assembly
		57Y01SF - 25W	25	Extension Power Cable Assembly
KIT 	9, 17	57Y01SF - 3WK	3	Whip Power Cable Kit with Sleeve
		57Y01SF - 6WK	6	Whip Power Cable Kit with Sleeve
		57Y01SF - 12WK	12	Extension Power Cable Kit with Sleeve
		57Y01SF - 25WK	25	Extension Power Cable Kit with Sleeve
INSULATING SLEEVE 	9, 17	PCA-4-1		Insulating Sleeve - Silicone Rubber (Used with Whip Cables)
Note: Sleeve can be used as a soft flexible handle for WT-9, 17, 20, 24 torch models.				

Specifications subject to change without notice.

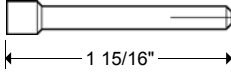
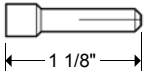
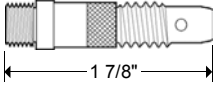
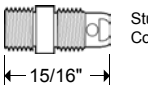
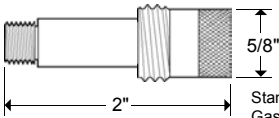
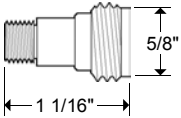
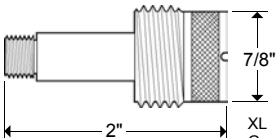
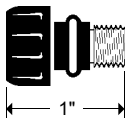
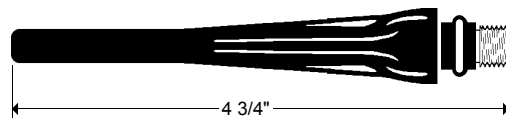
PARTS GUIDE

TORCH SERIES: 9, 20, 25, SW-320

		NOZZLE TYPE	.020"	.040"	1/16"	3/32"	1/8"	5/32"
	Collet		13N20	13N21	13N22	13N23	13N24	13NC532*
	Large Gas Lens Collet		13N20L	13N21L	13N22L	13N23L	13N24L	—
COLLET BODY								
	Collet Body	(A) (B) (C)	13N25	13N26	13N27	13N28	13N29	13NCB532*
GAS LENS								
	Standard Gas Lens	(D)	45V41	45V42	45V43	45V44	45V45	
MEDIUM GAS LENS								
	Medium Gas Lens	(E)			45V35SW	45V36SW	45V37SW	45V38SW*
XL GAS LENS								
	XL Gas Lens	(J)	45V0204S	45V116S	45V64S	995795S		
BACK CAPS								
	Short 41V33							
	Medium 41V35*							
	Long 41V24							

*NOTE: Use 41V35-532 medium back cap with 5/32 collet, collet body and medium gas lens.

TORCH SERIES: 17, 18, 26, SW-418

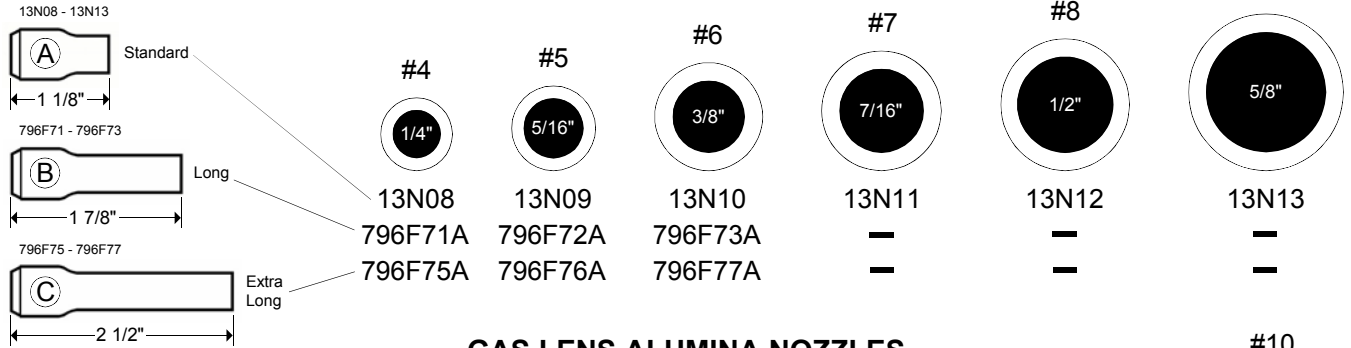
		NOZZLE TYPE	.020"	.040"	1/16"	3/32"	1/8"	5/32"
	Collet		10N21	10N22	10N23	10N24	10N25	54N20
	Stubby Collet		10N21S	10N22S	10N23S	10N24S	10N25S	54N20S
COLLET BODY								
	Collet Body	(F) (G)	10N29	10N30	10N31	10N32	10N28	406488
	Stubby Collet Body	(A) (B) (C)			17CB20	(.020" - 1/8")		
GAS LENS								
	Standard Gas Lens	(H) (I)	45V29	45V24	45V25	45V26	45V27	45V28
			45V29S	45V24S	45V25S	45V26S	45V27S	45V28S
XL GAS LENS								
	Stubby Gas Lens	(E)	45V0204	45V116	45V64	995795	45V63	
	XL Gas Lens	(J)						
BACK CAPS								
	Short 57Y04							
	Long 57Y02							

Specifications subject to change without notice.

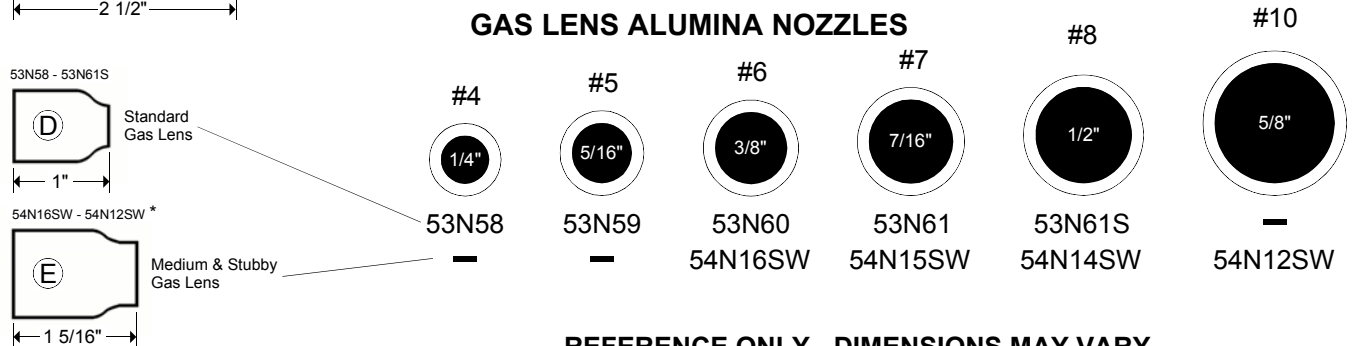
NOZZLE GUIDE

TORCH SERIES: 9, 20, 25, SW-320

STANDARD ALUMINA NOZZLES



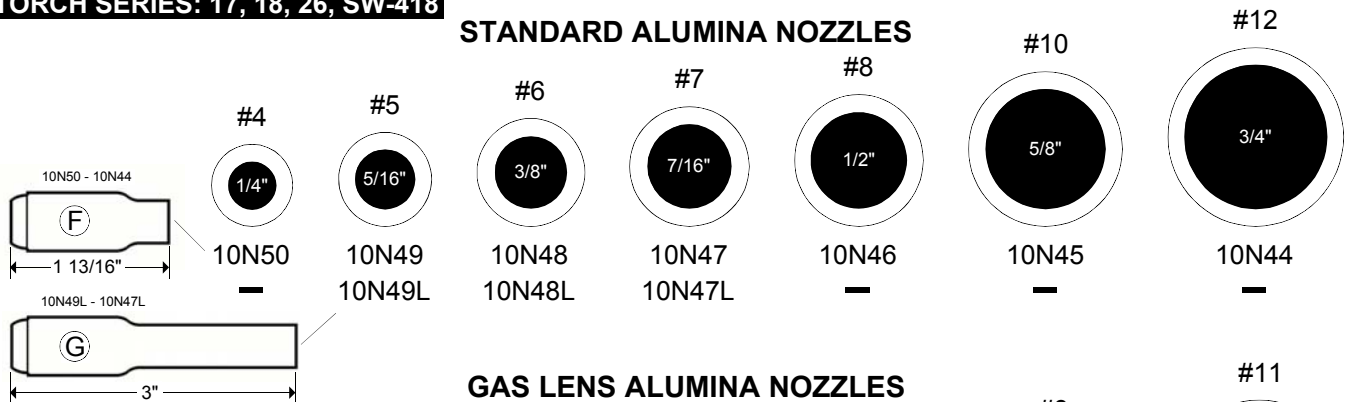
GAS LENS ALUMINA NOZZLES



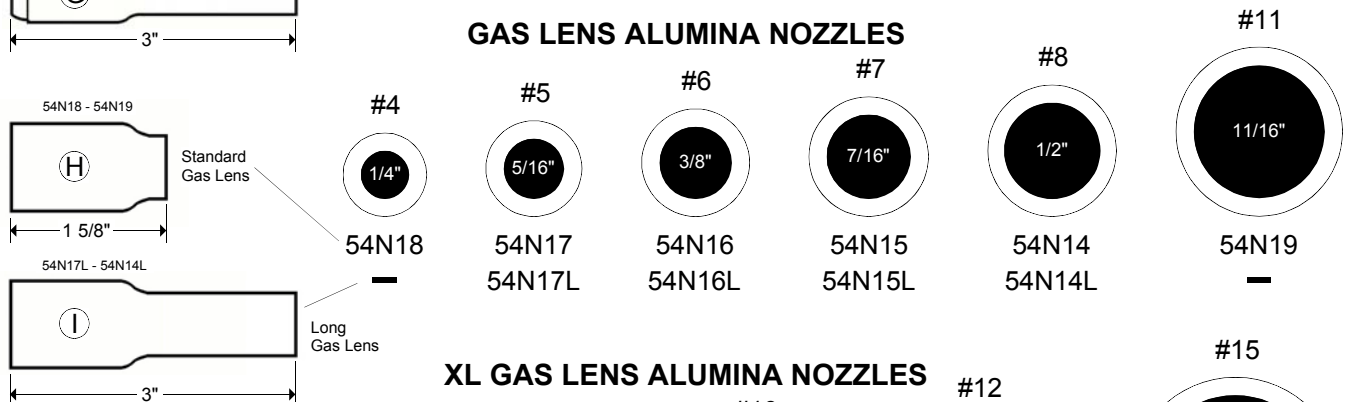
REFERENCE ONLY - DIMENSIONS MAY VARY

TORCH SERIES: 17, 18, 26, SW-418

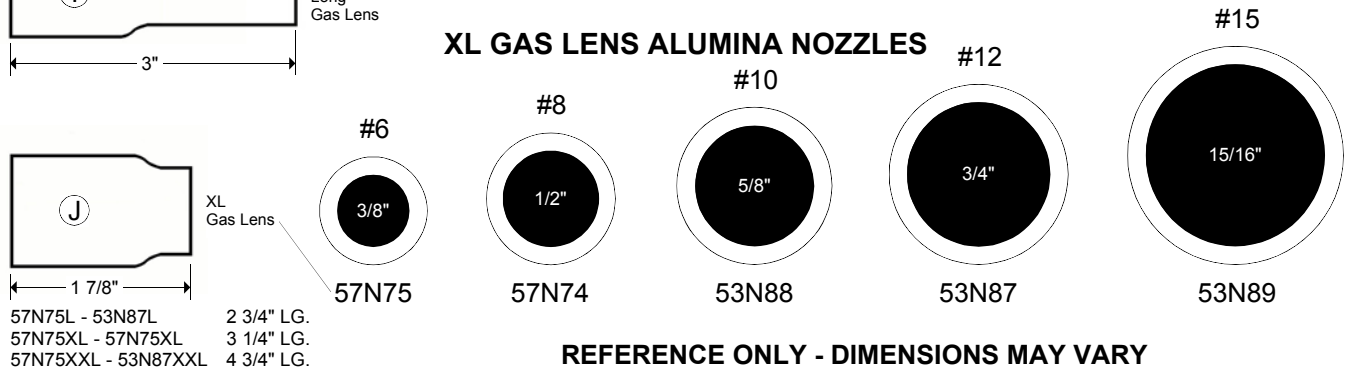
STANDARD ALUMINA NOZZLES



GAS LENS ALUMINA NOZZLES



XL GAS LENS ALUMINA NOZZLES



REFERENCE ONLY - DIMENSIONS MAY VARY

Specifications subject to change without notice.



TIG SPOT GUNS

MODEL 5000 430 AMP WATER COOLED
MODEL 5505 200 AMP AIR COOLED

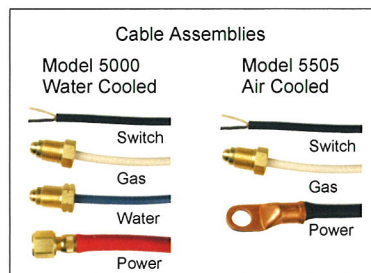
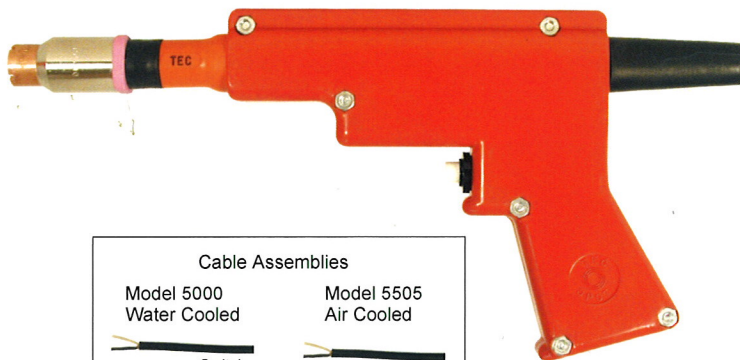
TEC TIG spot weld guns will spot weld such materials as mild steel, stainless steel, monel, inconel in thickness of 1/8" (3,2mm) or less from one side only. The TIG spot weld process is not suitable for aluminum, galvanized or coated materials.

The TIG spot weld process uses a conventional TIG welding machine equipped with a spot timer and high frequency arc starting. The spot gun is connected to the welding machine just like a manual TIG torch.

The spot guns are simple to use and are constructed of durable long lasting material. Replaceable locator tips are constructed of durable copper and are available for tacking inside or outside corners, butt and lap joints.

SPECIFICATIONS

Chuck Sizes .040" - 1/8"
 Electrode Length 7 in. Max.
 Weld Current DCSP



Note: Photo shows locator and insulator which are supplied individually or in accessory kit.

ORDERING INFORMATION

5000 SPOT GUN ASSEMBLY

Water cooled spot gun rated at 430 amps for heavy duty production applications.

Includes: Torch head, handle assembly, cable assembly and switch cord (25 ft.).

5505 SPOT GUN ASSEMBLY

Air cooled spot gun rated at 200 amps for thin gauge materials and light duty occasional spot weld applications.

Includes: Torch head, handle assembly, 2 pc. cable assembly and switch cord (25 ft.).

652-00 ACCESSORY KIT

Accessory kit can be used with water or air cooled spot gun assembly.

Includes: 2 Ea. 180-10 Ceramic Insulator
 1 Ea. 190-00 Locator Body
 2 Ea. 190-86 Flat Tip
 1 Ea. 222-00 3/32" Chuck
 1 Ea. 223-00 1/8" Chuck
 1 Ea. 200-NGR Gasket
 1 Ea. 101-06 Wrench
 1 Ea. Storage Box

Note: Connector plug required for TIG welding machine. Consult machine contactor wiring diagram for the proper connections.

ACCESSORIES

190-85
INSIDE
CORNER TIP



190-82
OUTSIDE
CORNER TIP



190-86
FLAT TIP



190-437L
#5L TIP



190-562
#7 TIP



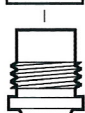
190-562L
#7L TIP



190-00
ADAPTER
BODY



180-10
CERAMIC
INSULATOR



ELECTRODE CHUCKS

220-00	.040	1,0
221-00	1/16	1,6
222-00	3/32	2,4
223-00	1/8	3,2
224-00	5/32	4,0



600-0W
POWER CABLE
ADAPTER
(Water Cooled
Model 5000)



635-0W
DIN CONNECTOR
(Water Cooled
Model 5000)



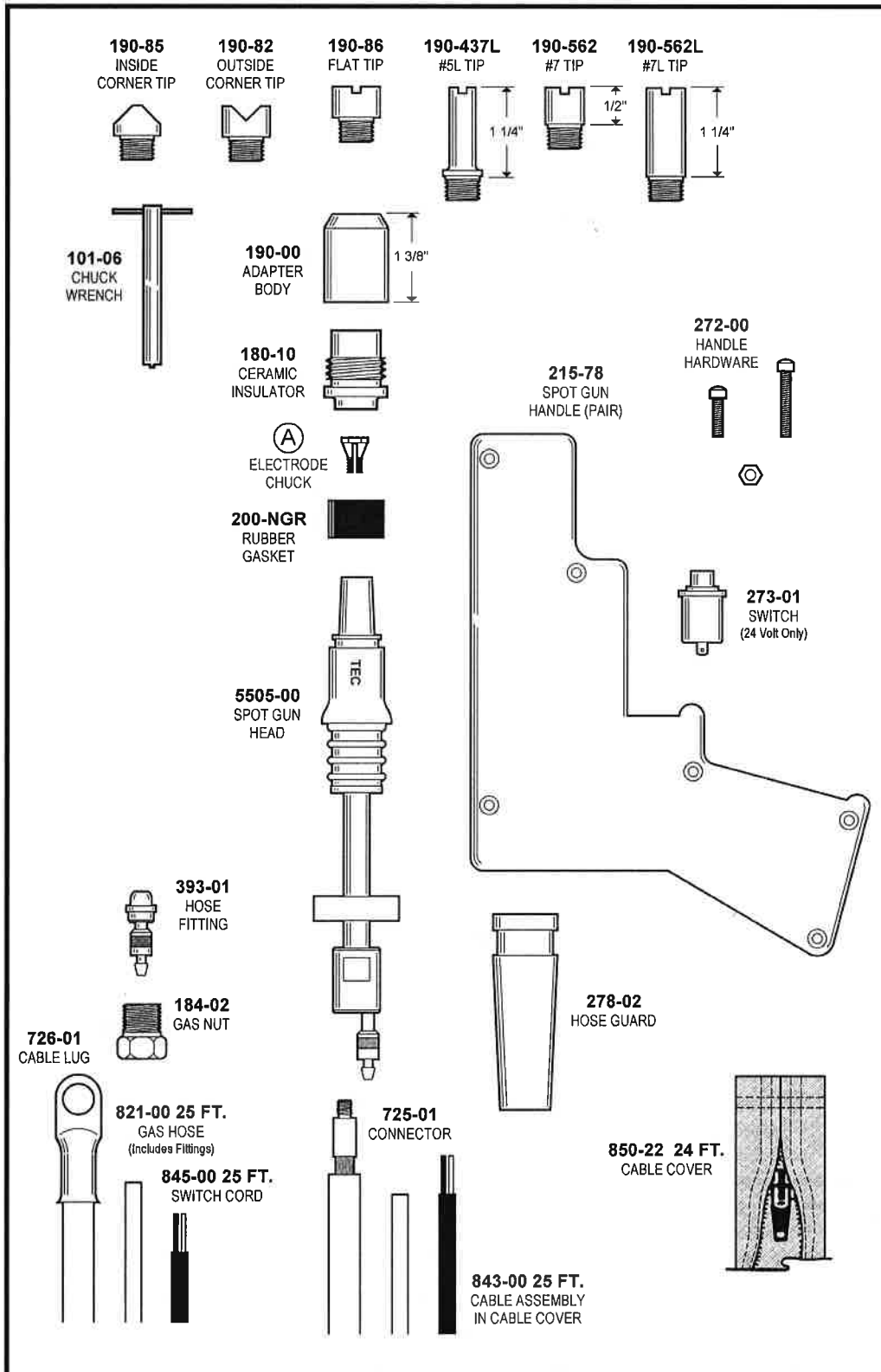
635-CC
DIN CONNECTOR
(Air Cooled
Model 5505)





REPLACEMENT PARTS
200 AMPS • AIR COOLED

MODEL 5505



(A) ELECTRODE CHUCKS

220-00	.040	1,0
221-00	1/16	1,6
222-00	3/32	2,4
223-00	1/8	3,2
224-00	5/32	4,0

ACCESSORY KIT 652-00

(includes)

2 ea.	180-10	Ceramic Insulator
1 ea.	190-00	Adapter Body
2 ea.	190-86	Flat Tip
1 ea.	222-00	3/32 Electrode Chuck
1 ea.	223-00	1/8 Electrode Chuck
1 ea.	200-NGR	Rubber Gasket
1 ea.	101-06	Wrench
1 ea.		Storage Box

MANUFACTURED IN USA

TEC TORCH COMPANY, INC.

P.O. BOX 1870 • SAN MARCOS, CA 92079 • (760) 747-3700 • FAX (760) 747-2121

www.tigtorch.com

e-mail info@tectorch.com

www.weldtec.com