



Discover **your** new **schweisskraft®** catalogue

**It is thanks to you that
the Schweisskraft brand exists.**

We specialise in selling high-quality welding technology products. These are almost exclusively manufactured and supplied by renowned German, European and international manufacturers according to our specifications. Each of our products is characterised by quality, durability and stable value. Our experience enables us to continuously develop and improve our products, as well as complete the overall programme.

Are you looking for a welding system that offers comprehensive performance features at an economical price? The decision to go for a Schweisskraft welding machine is the right one. Our machines impress with their outstanding quality and precise workmanship, not to mention their excellent value for money.

Schweisskraft products are subject to the strictest production and final inspections. The focus is on using the best materials, excellent welding properties and the simplest operation. The production process is carried out in accordance with the relevant standards and is subject to thorough individual inspections. A 100% check of performance and function is carried out at the end of the production process.

STÜRMER: Expertise in advice and service

Leave nothing to chance with a welding machine from Schweißkraft! Our experienced specialists will work closely with you to develop customised welding solutions that are tailored to your specific requirements. Thanks to state-of-the-art large-scale production facilities, we can offer you our high-quality welding equipment at a very attractive price-performance ratio.

Kilian Stürmer
Managing Director



Robert Stürmer
Sales Manager



Sales and service in Hallstadt / Bamberg / Germany

Our welding experts will be happy to advise you at your premises, if required. Thanks to their extensive knowledge and experience, our expert consultants can determine the optimal solution for each application.

Even after the sale, we will remain available as your long-term partner for any service or spare parts enquiries you may have. If you have any questions, please feel free to contact our Service Centre. Thanks to our connected spare parts warehouse, we are well equipped to provide a service that guarantees you the highest availability and fastest supply of spare parts, as well as prompt maintenance and repair of your welding machine at all times.

Your SCHWEISSKRAFT team



Large-scale production on state-of-the-art production lines lead to the good price-performance ratio of Schweisskraft welding machines



DISCOVER OUR PRODUCT VIDEOS NOW!

On our YouTube channel all our product videos are available to you. Subscribe to our YouTube channel so you don't miss any of the new videos.



Equipment familiarisation & expert training

We recommend that our customers have their welding machine commissioned and receive on-site training from our specialists.

The device familiarisation includes:

- Connection of the device supply installed at the workstation, such as mains cable, gas or compressed air (depending on device type) and individual supply, connection of torch and earth cables.
- Assembly of modular systems (e.g. power source, water cooling unit and trolley)

- Inserting the filler metal (MIG/MAG)
- Adjustment of working voltage and welding wire feed speed (MIG/MAG)
- Setting the shielding gas quantity (MIG/MAG/TIG)
- Notes on maintenance and care
- Instruction in the functions and setting options
- Duration: approx. 60 min.

The expert training programme includes

- **MIG/MAG, TIG**, manual electric or plasma cutting
- Comprehensive training on all device functions incl. practice welding
- Customised application benefits and their implementation on a sample component that you provide directly from your production facility.
- **Duration:** By individual agreement

We will be happy to assist you with any queries you may have! Our product consultants will support you with technical information. Our customers can contact us via a telephone hotline or an information email address for expert advice and solutions.

Contact:

email: beratung@schweisskraft.de

Or simply give us a call on : **+49 (0) 951 96 555 - 501**



Type	Art. no.	€ plus VAT/ PU
Device familiarisation	EINWSCHWEIßT	69.00
Expert training	SCHULUNGSCHEIß	66.00

Ask us for advice and a personalised quote!

SERVICE MAKES THE DIFFERENCE



SLD - Stürmer Logistics Services These figures speak for themselves

- › 20000 pallet spaces
- › 2500 shelf spaces for small parts
- › 22000 m² storage space
- › approx. 2000 m² accessories storage area
- › 55 employees
- › approx. 10500 shipments per month
- › approx. 23 million euros in stock available at all times
- › approx. 50000 m² floor space

OVER 50000 ITEMS READY FOR DELIVERY:

- › approx. 21000 machines
 - › approx. 235000 accessory items
 - › approx. 250000 spare parts
- (as at 31.12.2022)

Key success factors

- › Fast availability thanks to high storage capacity
- › Fast loading and throughput times thanks to storage location management and route optimisation
- › Reliable quality thanks to scanning process
- › Massive increase in permeability in the outgoing goods process

Providing the right product, at the right time, in the right place, in the right quantity, in the right quality and at the right cost.

These have always been our declared goals in order to make business easier for you, our retail partners, and to offer you the greatest possible benefit. Not just since our logistics centre began operations in April 2014. Today, these processes are so well established that the value chain functions smoothly.

More than 360000 items are available in our logistics centre. This enables prompt despatch of almost all items throughout Germany and Europe. Qualified employees ensure the proper delivery of the goods. Every year, over 100000 shipments leave the company premises via freight forwarders or parcel services.



We are all working towards one goal: That you and your customers are satisfied!





Study and try out The STÜRMER demonstration and training centre

Learning by doing

Aristotle already knew this: “For the things we have to learn before we can do them, we learn by doing them.” That is exactly what you can do at our demonstration centre in Hallstadt near Bamberg. You can access our products and our specialist consultants, who have a wealth of expertise, in an area of approx. 2000 m². Like you, they all have a practical background, so they know exactly what matters.

You can expect

- ▶ approx. 2000 m² of training and exhibition space
- ▶ 150 machines permanently ready for you to demonstrate
- ▶ an excerpt of the most important machines from each division of our product portfolio

A good theory is the most practical thing of all.

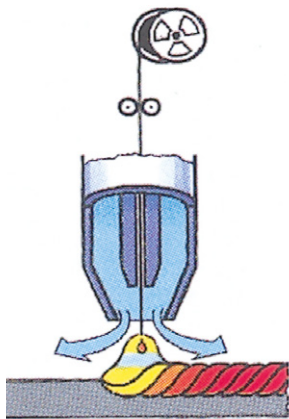
It doesn't work entirely without theory. That is why we also offer product training courses at our company site in Hallstadt. They are not held by pure theorists. They are held by practitioners who know their craft.

You will not only learn about STÜRMER products, but also about the differences between them and competing products.

Many machines are presented, demonstrated and explained in the exhibition. Practice-orientated theory is therefore guaranteed.

To round off the combination of theory and practice, we often go to the company's own bistro in a cosy atmosphere.





MIG/MAG welding - Metal inert* gas - metal active gas (*inert = low-reaction)

MIG/MAG welding is the most commonly used welding process in the world. This is due to its wide range of applications, including the elimination of slag cleaning and the ability to perform simple, single-sided welding with deep penetration. The fact that this process can be used easily in all welding positions makes it even more appealing, particularly from an economic perspective. The MIG/MAG process is a machine-based, gas-shielded welding process. An electric arc burns between the current-carrying wire electrode and the workpiece, which

is protected by a gas (active or inert, such as a mixture of gases). The electrode is the wire that is fed mechanically and melts in its own arc.

The MAG process

Suitable for steel, unalloyed, low-alloy and high-alloy base materials, making it ideal for production and repair welding. It is used for sheet thicknesses from 0.6 mm.

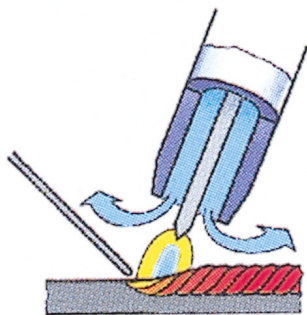
The MIG process

In contrast to the MAG process, the MIG and the new MIG soldering process are used for aluminium and copper materials with the addition of inert (= low-reactivity) gases such as argon. Wall thicknesses from

2.0 mm can be welded here (MIG soldering from 0.5 mm).

For thinner materials, a pulsed current source or the TIG method is recommended.

The MIG/MAG welding process is highly versatile, but it must be used in an area that is protected from draughts and moisture when working outdoors, in order to maintain the shielding gas effect.



TIG welding - Tungsten Inert* gas (*Inert = low-reaction)

TIG welding is a process that creates an electric arc between a non-consumable tungsten electrode and the workpiece. Pure argon, a noble gas that does not react with other elements, is used as a protective gas. This prevents the molten metal from reacting. The filler wire is fed without current, either by hand (manual welding) or by machine (automatic welding). However, there are also welding jobs that can be carried out without filler material. The material used determines whether direct or alternating current is used.

The **main advantage** of TIG welding lies in the wide range of materials that can be welded. Materials with a thickness of 0.3 mm (automated), such as alloyed steels, high-alloy steels, aluminium, magnesium, copper and their alloys, unalloyed steels, nickel, gold, silver and titanium, among others, can be welded. Can be used for welding all material thicknesses and root layers with thicker cross-sections. The TIG process achieves **the best results** compared to other welding processes due to non-porous weld seams with a very high tensile strength.

spherical tungsten coating forms on the electrode, and the arc alternates between the negative and positive poles at high frequency.

Direct current welding:

For welding alloyed steels and non-ferrous metals. The tungsten electrode is ground to a point. The arc burns stably.

**HF ignition = contactless ignition
Lift-Arc ignition = contact ignition**

Alternating current welding:

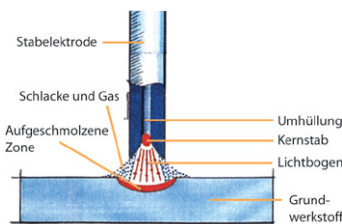
For welding light metals. A hemi-

Electrode welding

Electrode welding is an uncomplicated welding method that can be used to weld almost all metals. This method is also excellent for use outdoors and even under water. In electrode welding, the arc length is determined by hand - the distance between the electrodes determines the arc length. Welding is mainly carried out using direct current; for example, rutile electrodes are easy to weld using negative direct current, while basic electrodes are welded using positive direct current.

The electrode is the arc carrier and filler material. It consists of an alloyed or unalloyed core wire and a coating. The coating protects the molten pool from harmful atmospheric oxygen and stabilises the arc. In addition, a slag is formed which protects and shapes the weld seam. Depending on the thickness and composition of the coating, a distinction is made between rutile and basic electrodes. Rutile is easier to weld and has a nice, flat seam. The slag is also easier to remove.

It should be noted that many electrodes have to be re-dried after prolonged storage because moisture accumulates from the air over time. Otherwise, electrode welding is a very common and easy-to-use welding process.



Plasma cutting

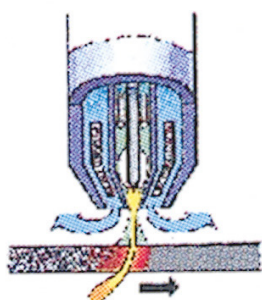
Plasma cutting was originally only used where flame cutting and its process variants could only deliver poor results or no results at all. This applies in particular to high-alloy steels, cast iron, light and non-ferrous metals. The technical development of plasma cutting in recent years and the increase in cutting speed have led to plasma cutting being used more and more frequently for cutting thin-walled workpieces (approx. 0.5 to 20 mm), including those made of unalloyed or low-alloy steel.

Due to the exclusively external heat supply, the energy content of the plasma jet is reduced when it penetrates the workpiece. This results in a cutting groove that tapers with the distance from the workpiece surface.

The plasma gas is pressurised and fed into the space between the electrode and the nozzle. To start up a plasma torch, a pilot arc is ignited with the aid of a high-frequency high-voltage discharge. This burns at a low power between the nozzle and the electrode, it puts the cutting gas into the plasma state as a result of thermal dissociation and ionisation.

The plasma-forming medium has a significant influence on quality and efficiency. This can be compressed air or a gas mixture. It should be noted that compressed air is absolutely pure compressed air.

Plasma cutting is particularly suitable for steel, CrNi or aluminium sheets.

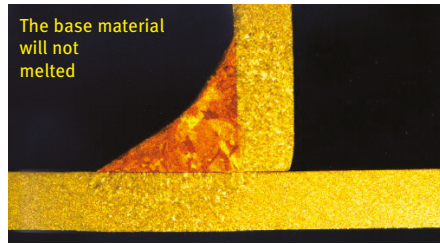


MIG brazing - for new areas of application, new materials and new regulations, especially in the automotive sector.

Galvanised sheet metal is all the rage. They are used, for example, in automotive engineering, the construction industry, ventilation and air conditioning technology, building services engineering and the furniture industry.

Why galvanised?

Zinc applied to steel (electrolytically or by hot-dip galvanising) creates a barrier layer that protects against corrosion. Zinc also has a cathodic protective effect. If the zinc layer is damaged, the material is still protected against corrosion within a radius of 1-2 mm of the damage. Zinc also provides a long-distance protective effect, safeguarding uncoated cut edges and microcracks.



The use of copper-based filler materials (bronze) makes it possible to work with low heat. Due to the low heat input, only a small amount of zinc vaporises and component distortion is reduced. The strength values are relatively high and the soldered seam is corrosion-resistant due to the alloy components, as the filler material is made of bronze.

The cross-section shows that the base material is not melted during MIG brazing.

Shielding gases

Argon, I1 or Ar mixtures with admixtures of CO₂ or O₂ are usually used for arc brazing. For solder materials with Si or Sn content, low active contents of CO₂ or O₂ are advantageous. They stabilise the arc, reduce the tendency to porosity, but increase the heat input into the base material.

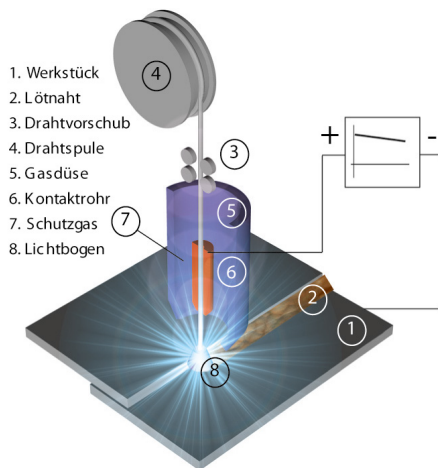
Ar-He mixtures without an active component are suitable for solder materials with aluminium content.

N₂ additives stabilise the arc and produce a wide seam, but they can lead to considerable pore formation.

H₂ as a shielding gas component is suitable for increasing the soldering feed rate, but can also lead to porosity. The experience of the shielding gas manufacturer should be utilised to specifically match the shielding gas to the soldering task.



The seam typical of MIG brazing due to the melting of the CuSi wire



MIG brazing - what is it?

The term MIG brazing refers to a brazing process for galvanised and coated thin sheets, as well as higher-strength steel sheets. In contrast to conventional gas-shielded welding (approx. 1600 °C), MIG brazing does not melt the base material, but instead creates a brazed joint between the workpieces using brazing wire (usually copper-based filler material) with a low melting point of approx. 1000 °C.

Zinc begins to vaporise at around 480 °C. This means that conventional welding would burn the zinc layer over a large area. The evaporating zinc and oxides then lead to the formation of pores, cracks and binding defects.

Surface coatings and pre-treatment

Sheet metal with zinc layer thicknesses of up to 15 µm can generally be joined without any problems using arc brazing processes. Solders containing aluminium are recommended for aluminised base materials. Additionally, if galvanised sheets have an organic coating, the processing parameters must be adjusted.

In order for metallurgical interaction between the base material and the liquid solder to occur, the interface with the solder should be metallically bare and free of contamination. Otherwise, porosity, bonding defects, etc. may occur.

Filler materials and auxiliary materials

The wire electrodes and welding rods ML CuSi3 and ML CuAl8 are mainly used for arc brazing. In Germany, ML CuSi3 has traditionally prevailed, while in other countries the alloy ML CuAl8 is often used for similar tasks. ML CuAl8 is used for the MIG brazing of stainless steel and for joints where the visual appearance of the seam surface is important. This can be of major importance in the furniture industry, for example.

Our recommendation:
PRO-MAG
SYN-MAG
SYN-MIG SC
SYN-MIG i

The advantages of the MIG brazing process at a glance:

- No corrosion of the soldered seam
- Minimal welding spatter
- Simple reworking of the soldered seam
- Lower operating temperature
- Low warping
- Reduced microstructural change in high-strength sheet steel
- Capillary effect of the solder, resulting in 1/3 higher strength for round and slotted hole soldering
- Low burn-off of the coating
- Cathodic protection of the base material in the immediate seam area (zinc)
- Corrosion protection without post-treatment
- Optimum control to maintain the sheet thickness

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SYNERGIC MIG/MAG WELDING MACHINES

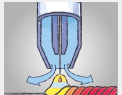


MIG/MAG gas-shielded welding systems

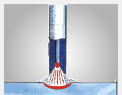
easymig 181 Multi

The portable multifunctional inverter for MIG/MAG, TIG and electrode welding – with 230V, ideal for any construction site

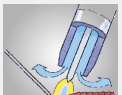
- ▶ Simple stepless adjustment of the operating point by selecting the voltage and wire speed using one button each
- ▶ Best welding results thanks to reliable ignition and stable arc
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- ▶ Cored wires can be easily welded by simply reversing the polarity
- ▶ User-friendly setting also for TIG and electrode



MIG/MAG



ELECTRODES



TIG Lift - Arc



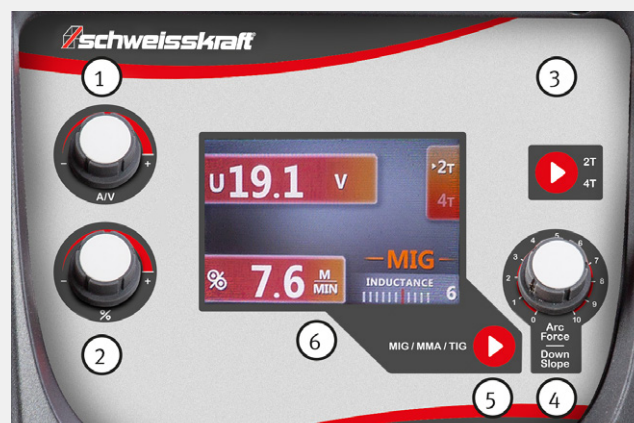
Interior polarity reversible for filler wires



Including SMB torch and pressure reducer

OPERATION

- ① Rotary knob for setting the welding voltage or current
- ② Rotary knob for wire feed speed
- ③ Pushbutton for setting 2- or 4-cycle operation



- ④ Rotary knob and throttle for ARC force and down-slope
- ⑤ Push-button for setting MIG/MAG, TIG or E-hand operation
- ⑥ Display of welding voltage, welding current and other settings made

TECHNICAL DATA:

Model	EASY-MIG 181 Multi	
Art. no.		1071181
Technical data		
Setting range for MIG/MAG	A	40 – 180
Setting range for electrode	A	10 – 160
Setting range for TIG DC	A	10 – 180
Duty cycle at I_{max} [40°C] MIG/MAG	%	20
Duty cycle at I_{max} [40°C] Electrode	%	20
Duty cycle at I_{max} [40°C] TIG DC	%	20
Current at 100% duty cycle [40°C] MIG/MAG	A	80
Current at 100% duty cycle [40°C] Electrode	A	80
Current at 100% duty cycle [40°C] TIG DC	A	70
Wire feed unit	Roll	2
MIG/MAG power consumption	kVA	8.41
Electrode power consumption	kVA	6.67
Power consumption TIG DC	kVA	8.4
Electrical connection ~50 Hz	V	230
Dimensions (L x W x H) approx.	mm	525 x 220 x 410
Weight approx.	kg	14.5
Standards ¹⁾ : DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A		

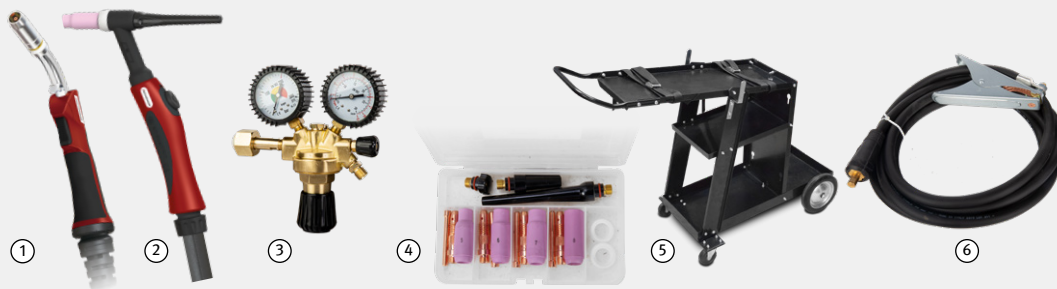
¹⁾ EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- 3 m welding cable 16 mm² with 300A electrode holder
- 3 m ground cable 16 mm² with 300A earth clamp
- Torch SMB 15 3 m
- Gas hose 4 m including quick connector
- Pressure reducer
- Feed roller V 0.8-1.0 mm



ACCESSORIES



ACCESSORIES

	Art. no.
① TIG torch SR26, ED, gas-cooled, 4 m	1105004
② MIG/MAG torch SMB 15, 3 m	1090153
③ Argon/CO2 pressure reducer, large	1700050
④ Wear parts set VTS SR17/SR18/SR26 Short torch cap / medium torch cap / long torch cap; gas nozzles: Size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm / clamping sleeves: 1.6 mm, 2.4 mm, 3.2 mm, 4.0 mm; clamping sleeve housing: 1.6 mm, 2.4 mm, 3.2 mm, 4.0 mm; Teflon seal for nozzle	1100152
⑤ Universal trolley	1090015
⑥ Ground cable complete with MK4/25 KS13 200A clamp	1250225
Welding cable complete with electrode holder SK4/25 KS13 EH260	1250361
Welding cable complete with electrode holder SK4/35 KS13 EH400	1250362
Feed roller 0.8/0.9 mm K-groove	1171001
Feed roller 0.6/0.8 mm V-groove	1171002
Feed roller 0.8/1.0 mm V-groove	1171003
Feed roller 0.8/1.0 mm U-groove	1171004

MIG/MAG gas-shielded welding systems

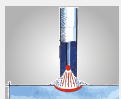
craftmig® 201 LCD P Synergic

Impulse gas-shielded welding machine Modern MIG welding machine for professional use

- ▶ Best welding results thanks to reliable ignition and stable arc
- ▶ Suitable for operation on a power generator
- ▶ Simplest setting thanks to synergy function - three steps to welding: gas, material, wire diameter
- ▶ 2/4 time, dots, interval
- ▶ Material thickness
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ The quiet-running fans dissipate the heat well from the appliances and ensure a long switch-on time
- ▶ Arc force control: The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- ▶ Device with PFC (power factor correction) equipped enables the best use even on cable reels



MIG/MAG



ELECTRODES



TIG Lift - Arc



Power Factor Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Generator Friendly



Including SMB torch and pressure reducer

OPERATION



Simple setting with plain text display.

Quickly achieve the perfect result after one setting in three steps:

Step 1: Set gas/material, wire Ø.

Step 2: 2/4 time, dots, interval

Step 3: Set the material thickness.

Thanks to the large display, all parameters are always in view and can be adjusted.

Welding has never been so easy!

TECHNICAL DATA:

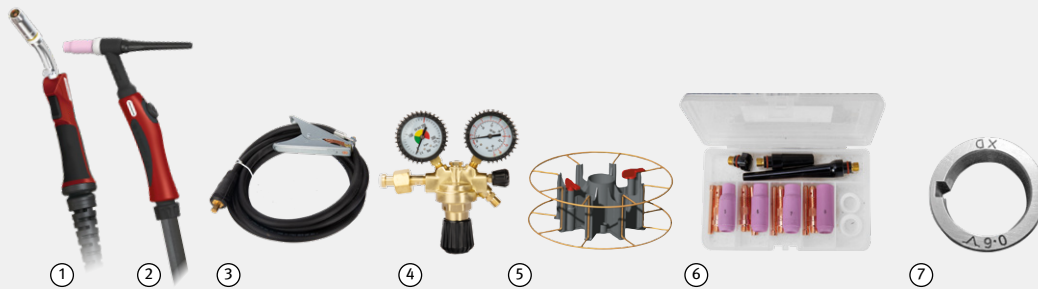
Model	CRAFT-MIG 201 LCD P Synergic	
Article no.	1071201	
Technical data		
Setting range for MIG/MAG	A	25 – 200
Setting range for TIG DC	A	10 – 200
Setting range for electrode	A	10 – 200
Duty cycle at max. current 40°C	%	40
Current at duty cycle 100% 40°C	A	130
MIG/MAG power consumption	kVA	6.44
Electrode power consumption	kVA	7.36
Power consumption TIG DC	kVA	5.06
Power factor	cos phi	0.99
Efficiency	%	80
Cooling type		AF
Torch cooling		gas-cooled
Wire feeder, weldable wires, steel	mm	0.6 – 1.0
Wire feeder, weldable wires, stainless steel	mm	0.6 – 0.9
Wire feed unit	Rollers	2
Wire feed speed	m/min	1.5 – 16.5
No-load voltage	V	Electrode: 65 TIG: 63 MIG/MAG: 65
Power consumption	kVA	Electrode: 32 TIG: 22 MIG/MAG: 28
Electrical connection ~50 Hz	V	110/230
Dimensions (L x W x H) approx.	mm	560 x 220 x 410
Weight approx.	kg	15.5
Standard		EN 60 974-1; -10

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Torch SMB25 3m
- Feed rollers Ø0.8- 1.0 mm steel
- Ground cable 25mm² 3m incl. 300A earth clamp
- 4 m gas hose
- Argon/CO2 pressure reducer, large
- 3 m mains cable

ACCESSORIES



ACCESSORIES

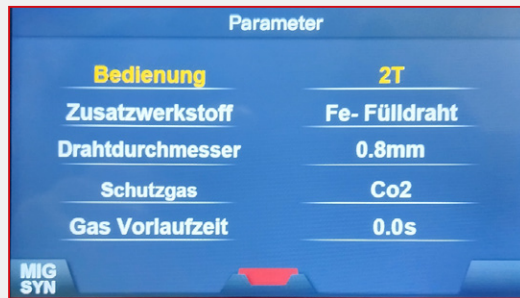
	Art. no.
① MIG/MAG welding torch, gas-cooled SMB25 4m	1090254
② SR26 TIG torch, 4 m ED, gas-cooled	1105004
③ Ground cable 4m 25mm², KS50/13mm, clamp 200A	1250225
③ Ground cable 4m 35mm², KS50/13mm, clamp 400A	1250235
④ Pressure reducer Argon/CO ²	1700050
⑤ Basket coil adapter KA 2, with quick-release fastener	1110005
⑥ Wear parts kit VTS SR 17/18/26 Torch cap short/medium/long, gas nozzle size 5/6/7/8/10, clamping sleeve 1.6/3.2/4.0/2.4mm, clamping sleeve housing 1.6/3.2/4.0/2.4mm, Teflon seal for nozzle	1100152
⑦ Single feed roller	
0.6/0.8 mm V-groove	1171005
0.8/1.0 mm V-groove	1171006
0.8/1.0 mm K-groove	1171007
0.8/1.0 mm U-groove	1171008

MIG/MAG gas-shielded welding systems

Series SYN-MIG Synergic - Universally applicable MIG/MAG inverter welding machines with synergy characteristics

- ▶ Infinitely regulatable
- ▶ Synergy characteristics - 3 steps lead to the perfect welding result
- ▶ Adjustable choke enables precise adjustment of the arc characteristics
- ▶ Robust trolley with large storage space for gas cylinders and accessories makes it easier to transport and organise tools directly on site
- ▶ Can hold both 10 litre cylinders and up to 50 litre gas cylinders
- ▶ State-of-the-art inverter technology ensures precise welding and a uniform arc with maximum efficiency
- ▶ Overheating protection and voltage monitoring ensure safe working conditions
- ▶ Suitable for use on the generator
- ▶ Sheet thickness: from 0.8 mm steel and stainless steel (MAG), from 1.0 mm for aluminium (MIG)
- ▶ Base materials: Unalloyed and low-alloy materials (S235JR), high-alloy materials (stainless steel), aluminium alloy, filler wire
- ▶ Typical applications: Locksmithery, mechanical engineering, assembly, car workshop, tinsmith, maintenance, repair

OPERATION



- User-friendly LCD display enables precise setting of welding parameters
- Simple setting with plain text display



- All welding parameters and settings at a glance

Scope of delivery	
SYN-MIG 201-2 P Synergic	
SYN-MIG 203-2 Synergic	
· 16 mm ² earth cable 3 m	
· Pressure reducer	
· Gas hose 4 m	
· MAG torch SMB 15 4 m	

Scope of delivery	
SYN-MIG 253-4 Synergic	
SYN-MIG 323-4 Synergic	
· 35 mm ² earth cable 3 m	
· Pressure reducer	
· Gas hose 4 m	
· MAG torch SMB 25 4 m	

Scope of delivery	
SYN-MIG 353-4 W Synergic	
SYN-MIG 403-4 W Synergic	
· 35 mm ² earth cable 3 m	
· Pressure reducer	
· Gas hose 4 m	
· MAG torch SMB 400 4 m	

TECHNICAL DATA:

MACHINES ARE DELIVERED WITHOUT COOLING WATER!

Model		SYN-MIG 201-2 P Synergic	SYN-MIG 203-2 Synergic	SYN-MIG 253-4 Synergic	SYN-MIG 323-4 Synergic	SYN-MIG 353-4 W Synergic	SYN-MIG 403-4 W Synergic
Article no.		1071202	1071203	1071254	1071323	1071353	1071403
Setting range for MIG/MAG	A	30 – 140 / 3 – 200	30 – 200	30 – 250	30 – 315	30 – 350	30 – 400
Setting range for electrode	A	10 – 100 / 20 – 200	10 – 200	10 – 250	10 – 250	10 – 350	10 – 400
Setting range for TIG DC	A	10 – 140 / 10–200	10 – 200	10 – 250	10 – 300	10 – 350	10 – 400
Duty cycle at max. current 40°C	%	40 / 30	40	60	40	60	60
Current at duty cycle 60% 40°C	A	100 / 145	165	250	260	350	400
Current at duty cycle 100% 40°C	A	80 / 110	130	195	200	275	310
MIG/MAG power consumption	kVA	3.7 / 5.7	8.5	11.2	15.4	13.5	16.8
Electrode power consumption	kVA	3.0 / 6.5	9.6	12.5	12.7	14.4	17.9
Power consumption TIG DC	kVA	2.8 / 4.4	6.8	8.9	11.4	10.8	13.6
Cooling type		AF	AF	AF	AF	AF	AF
Torch cooling			gas-cooled			water-cooled	
Weldable wires, steel	mm	0.6 – 1.0	0.6 – 1.0	0.6 – 1.2	0.8 – 1.2	0.8 – 1.2	0.8 – 1.2
Weldable wires, stainless steel	mm	0.8 – 1.0	0.8 – 1.0	0.8 – 1.2	0.8 – 1.2	0.8 – 1.2	0.8 – 1.2
Weldable wires, aluminium	mm	1.0 – 1.2	1.0 – 1.2	1.0 – 1.2	1.0 – 1.2	1.0 – 1.2	1.0 – 1.2
Weldable wires, CuSi	mm	1.0	1.0	1.0	1.0	1.0	1.0
Weldable wires, filler wire	mm	0.8 – 1.0	0.8 – 1.0	0.8 – 1.2	0.8 – 1.2	0.8 – 1.2	0.8 – 1.2
Wire feed unit	Rollers	2	2	4	4	4	4
Wire feed speed	m/min	16	18	24	24	24	24
Wire feed rolls, driven	Roll	1	1	2	2	2	2
Required generator output	kVA	>7	>7	>8	>10	>13	>15
Open circuit voltage MMA	V	66.5	74	75	74	76.5	75
Electrical connection ~50 Hz	V	110/230	400	400	400	400	400
Dimensions (L x W x H) approx.	mm	1100 x 530 x 850					
Weight approx.	kg	44.7	52.5	52.5	53.5	66.5	66.5
Standards 1):		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A					

Procedure

- ▶ MIG / MAG
- ▶ WIG (DC)
- ▶ Electrode

MIG MAG



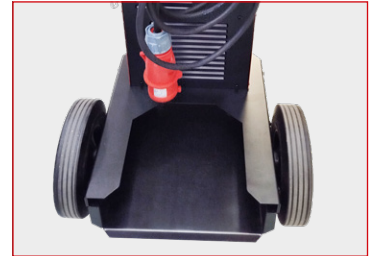
HANDLE

- Robust handle design for easy manoeuvring and for winding up the hose package



COLOUR DISPLAY

- Simple operation with large colour display.
- 3 steps to the result.
- The display is optimally protected by the cover.



BOTTLE TROLLEY

- low-lying



FLAP

- Large, wide-opening flap makes it easy to set up the machine
- The lighting also makes it easier to work in dark surroundings

VIEWING WINDOW

- in the cover of the wire feeder



Syn-Mig
403-4 W Synergic



MIG / MAG PULSE WELDING MACHINES



Power
Factor
Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Generator
Friendly

- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers



Multivoltage
Einsatz
weltweit

- ▶ Regulates the voltage from 110 V - 230 V



AC/DC
Technology

- ▶ Welding with direct current or alternating current



DC
PULSE

- ▶ TIG DC function = enables simple TIG welding

MIG/MAG gas-shielded welding systems

craftmig® 201P Pulse /253 Pulse

Impulse gas-shielded welding machines. Modern MIG welding machines for professional use

- ▶ Pulse function: Significantly less rework thanks to low-spatter welding
- ▶ Best welding results thanks to reliable ignition and stable arc
- ▶ Synergy function: Automatic calculation of the tension and wire feed by preselecting the wire Ø, material and gas
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ The quiet-running fans dissipate the heat well from the appliances and ensure a long switch-on time
- ▶ Arc force control: The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrodes can be processed without any problems
- ▶ Cored wires can be easily welded by simply reversing the polarity
- ▶ Suitable for operation on a power generator
- ▶ Wide range of functions: MIG/MAG (Pulse, Dual Pulse, Synergic, manual), TIG Lift Arc, E-Hand

CRAFT-MIG 201P Pulse

- ▶ Device with PFC (power factor correction) equipped enables the best use even on cable reels

CRAFT-MIG 253 Pulse:

- ▶ Optionally with water cooling



Generator Friendly



DC PULSE



Power Factor Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



CRAFT-MIG 201P Pulse

CRAFT-MIG 253 Pulse



Including SMB torch and pressure reducer

OPERATION

- 1 Digital display for welding voltage
- 2 Digital display for welding amperage
- 3 LED for mains connection and overload indicator
- 4 Selector buttons for gas, wire loading, job and store/load



- 5 Welding process selection
- 6 Torch assignment (2-stroke/4-stroke)
- 7 Special parameters
- 8 Rotary knob for voltage
- 9 Rotary knob for arc length correction, among other things

TECHNICAL DATA:

Model		CRAFT-MIG 201P Pulse	CRAFT-MIG 253 Pulse
Art. no.		1072201	1072253
Technical data			
Setting range MIG/MAG	A	20 – 200	20 – 250
Setting range TIG DC	A	10 – 200	10 – 250
Setting range Electrode	A	10 – 200	10 – 250
Duty cycle at max. current 40°C	%	40	60
Current at duty cycle 100% 40°C	A	130	195
Wire feed speed	m/min	1.5 – 24	1.5 – 24
Wire feed unit	Roll	4	4
No-load voltage	V	Electrode: 94.4 TIG: 92.2 MIG/MAG: 84.5	Electrode: 79 TIG: 75 MIG/MAG: 71
Idling voltage explanation		Specifications for electrical connection 230 V	
Power factor	cos phi	0.99	Electrode: 0.68 TIG: 0.66 MIG/MAG: 0.67
Efficiency	%	82.22	Electrode: 89.02 TIG: 84.71 MIG/MAG: 87.71
Electrical connection ~50 Hz	V	110/230	400
Dimensions (L x W x H) approx.	mm	580 x 230 x 400	750 x 240 x 450
Weight approx.	kg	25	28.5
Standards ¹⁾ :		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

¹⁾ EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

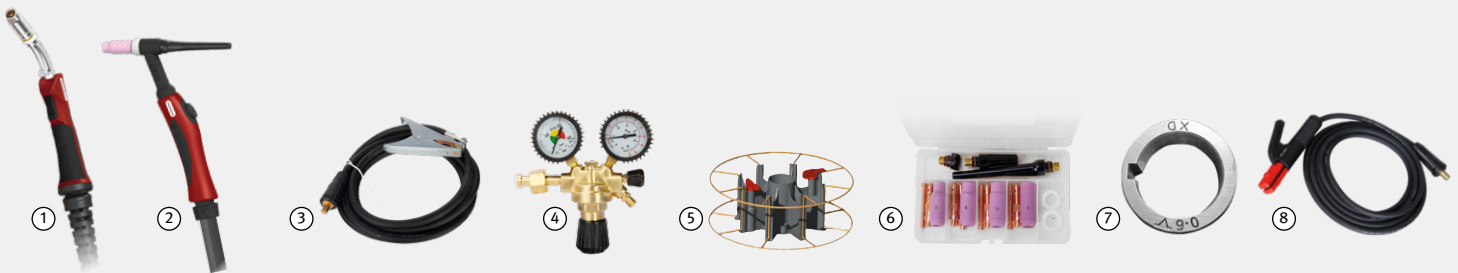
CRAFT-MIG 201P PULSE SCOPE OF DELIVERY:

- Welding torch SMB 25/ 3 m
- Ground cable 25mm² / 3m
- Gas hose 12 x 6 mm, 4 m
- Argon/CO₂ pressure reducer
- Feed rollers Ø0.8 - 1.0 mm steel

CRAFT-MIG 253 PULSE SCOPE OF DELIVERY:

- Welding torch SMB 25/ 4 m
- Ground cable 35mm² / 4m
- Gas hose 12 x 6 mm, 4 m
- Argon/CO₂ pressure reducer
- Feed rollers Ø0.8 - 1.0 mm steel

ACCESSORIES



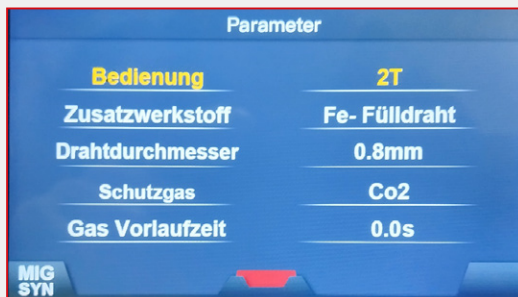
ACCESSORIES	Art. no.
① MIG/MAG welding torch, gas-cooled SMB25 4m	1090254
② SR26 TIG torch, 4 m ED, gas-cooled	1105004
③ Ground cable 4m 25mm ² , KS50/13mm, clamp 200A	1250225
③ Ground cable 4m 35mm ² , KS50/13mm, clamp 400A	1250235
④ Pressure reducer Argon/CO ₂	1700050
⑤ Basket coil adapter KA 2, with quick-release fastener	1110005
⑥ Wear parts kit VTS SR 17/18/26	1100152
⑦ ACCESSORIES for CRAFT-MIG 201P Pulse	
Sorting box, 3x torch cap, 5x gas nozzle, 4x adapter sleeve, 4x adapter sleeve housing, 1x Teflon seal	
Wire feed roller 0.6/0.8 mm V-groove	1171005
Wire feed roller 0.8/1.0 mm V-groove	1171006
Wire feed roller 0.8/1.0 mm K-groove	1171007
Wire feed roller 0.8/1.0 mm U-groove	1171008
⑧ SK4/25 KS13 EH260	1250361
ACCESSORIES for CRAFT-MIG 253 Pulse	
Wire feed roller 0.6/0.8 mm V-groove	1171030
Wire feed roller 0.8/1.0 mm V-groove	1171031
Wire feed roller 1.0/1.2 mm V-groove	1171032
Wire feed roller 0.8 / 1.0 mm for filler wire	1171033
Wire feed roller 1.0 / 1.2 mm for filler wire	1171034
Wire feed roller 0.8 / 1.0 mm for aluminium	1171035
Wire feed roller 1.0 / 1.2 mm for aluminium	1171036

MIG/MAG gas-shielded welding systems

Syn-Mig 353-4 W Pulse - Universally applicable MIG/MAG inverter welding machine with synergy characteristics and double pulse function

- ▶ Innovative impulse technology enables low-spatter weld seams - up to 80% less rework with a higher deposition rate at the same time
- ▶ Double-pulse function enables TIG-like weld seams at MAG speed
- ▶ High duty cycle of 60% at maximum power ensures longer welding times without overheating, ideal for large projects
- ▶ Synergy characteristics for steel, stainless steel and aluminium - 3 steps to the perfect result
- ▶ State-of-the-art inverter technology in modular design ensures maximum reliability combined with maximum efficiency
- ▶ Adjustable choke enables precise adjustment of the arc characteristics
- ▶ Suitable for use on the generator
- ▶ Integrated water cooling for optimum temperature control
- ▶ Sophisticated cooling system with encapsulated air duct for efficient heat dissipation ensures stable welding performance even in the toughest applications
- ▶ Can hold both 10 litre cylinders and up to 50 litre gas cylinders

OPERATION



- User-friendly LCD display enables precise setting of welding parameters
- Simple setting with plain text display



- All welding parameters and settings at a glance

TECHNICAL DATA:

Technical data		SYN-MIG 353-4 W Pulse
Article no.		1072353
Setting range for MIG/MAG	A	10 – 350
Setting range for TIG DC	A	10 – 350
Setting range for electrode	A	20 – 350
MIG soldering setting range	A	10 – 350
Duty cycle at max. current 40°C	%	60
Current at duty cycle 60% 40°C	A	350
Current at duty cycle 100% 40°C	A	270
MIG/MAG power consumption	kVA	12.4
Electrode power consumption	kVA	13.4
Power consumption TIG DC	kVA	9.8
Power factor	cos phi	0.726
Efficiency	%	89.02
Wire feeder, weldable wires, CuSi	mm	1.0
Wire feeder, weldable wires, filler wire	mm	0.9 – 1.6
Wire feeder, weldable wires, steel	mm	0.8 – 1.6
Wire feeder, weldable wires, stainless steel	mm	0.8 – 1.6
Wire feeder, weldable wires, aluminium	mm	1.0 – 1.6
Wire feed unit	Rollers	4
Wire feed speed	m/min	1.5 – 24
Required generator output	kVA	13
No-load voltage	V	MMA: 73 TIG: 73 MIG: 76
Power consumption	A	26.5
Connection voltage ~ 50 Hz	V	400
Dimensions (L x W x H) approx.	mm	1100 x 530 x 850
Weight approx.	kg	66.5

SCOPE OF DELIVERY:

- MIG torch MB 401- 4 m
- 3 m ground cable 35 mm² with earth clamp 300 A
- Pressure reducer
- 4 m gas hose

MACHINE IS DELIVERED WITHOUT COOLING WATER!

Equipment	
MIG/MAG process	Yes
MMA process	Yes
Operating display	LCD
Spot welding	Spot
Adjustable throttle	0 – 10 for syn, -10 – +10 for pulse
2-stroke/4-stroke change-over	2T/4T/4T+
Overload indicator	Yes

MIG MAG



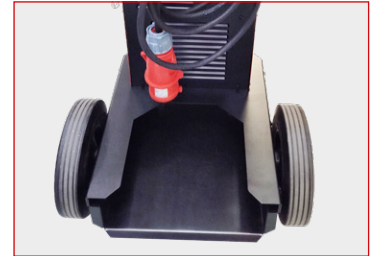
HANDLE

- Robust handle design for easy manoeuvring and for winding up the hose package



COLOUR DISPLAY

- Simple operation with large colour display.
- 3 steps to the result.
- The display is optimally protected by the cover.



BOTTLE TROLLEY

- low-lying



FLAP

- Large, wide-opening flap makes it easy to set up the machine
- The lighting also makes it easier to work in dark surroundings

VIEWING WINDOW

- in the cover of the wire feeder



Syn-Mig 353-4 W Pulse



MIG/MAG TORCH ACCESSORIES



Torch SMB 15 gas-cooled

Technical data:		
Current max.	180 A (DC)	150 A (AC)
DC/AC duty cycle	60%	
Cooling	gas-cooled	
Electrode diameter	0.6 – 1.0 mm	
Contact tip	M6	
Connection	Euro central connection	
Gas flow	10– 15 l/min	
Original equipment contact tip	Steel, 0.8 mm	
Torch neck	45°	

Art. no.	Designation
1090153	MIG/MAG torch SMB 15, 3 m
1090154	MIG/MAG torch SMB 15, 4 m
1090155	MIG/MAG torch SMB 15, 5 m



	Art. no.	Designation	PU ⁽¹⁾
	1091600	Wear parts set SMB 15 1 x gas nozzle carrier 2 x retaining spring 10 x contact tip 0.8 mm 10 x contact tip 1.0 mm 2 x gas nozzle, conical 1 x gas nozzle, cylindrical	1
	1091601	Torch neck	1
	1091602	Gas nozzle carrier	10
	1091603	Retaining spring	10
	1091604	Contact tip M6 / 25 mm / Ø 0.6 mm	10
	1091605	Contact tip M6 / 25 mm / Ø 0.8 mm	10
	1091606	Contact tip M6 / 25 mm / Ø 1.0 mm	10
	1091607	Contact tip aluminium M6 / 25 mm / Ø 1.0 mm	10
	1091608	Conical gas nozzle	10
	1091609	Cylindrical gas nozzle	10
	1091610	Point gas nozzle	10
	1091612	Handle shell	1
	1091613	Pushbutton	1
	1091616	Anti-kink spring	1
	1091617	Kink protection on the machine side	1
	1091650	Blue guide spiral Ø 0.6 - 0.9 mm / 3.0 m (for torch SMB 15, 3 m)	1
	1091651	Blue guide spiral Ø 0.6 - 0.9 mm / 4.0 m (for torch SMB 15, 4 m)	1
	1091652	Blue guide spiral Ø 0.6 - 0.9 mm / 5.0 m (for torch SMB 15, 5 m)	1

Guide spirals/Teflon cores see page 37




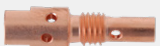
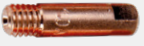


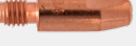







(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

Torch SMB 25 gas-cooled

Technical data:	
Current max.	230 A (DC) 200 A (AC)
DC/AC duty cycle	60%
Cooling	gas-cooled
Electrode diameter	0.8 – 1.2
Contact tip	M6
Connection	Euro central connection
Gas flow	10– 15 l/min
Original equipment contact tip	Steel, 1.0 mm
Torch neck	45°

Art. no.	Designation
1090253	MIG / MAG torch
1090254	MIG/MAG torch SMB 25, 4 m
1090255	MIG/MAG torch SMB 25, 5 m



	Art. no.	Designation	PU ⁽¹⁾
	1092700	Wear parts set SMB 25 2 x nozzle holder 3 x retaining spring 10 x contact tip 0.8 mm 10 x contact tip 1.0 mm 2 x gas nozzle, conical 1 x gas nozzle, cylindrical	1
	1092701	Torch neck	1
	1092702	Retaining spring SMB 25	10
	1092703	Nozzle holder	10
	1092704	Contact tip M6 / 28 mm / Ø 0.8 mm	10
	1092705	Contact tip M6 / 28 mm / Ø 1.0 mm	10
	1092706	Contact tip M6 / 28 mm / Ø 1.2 mm	10
	1092707	Contact tip aluminium M6 / 28 mm / Ø 1.0 mm	10
	1092708	Contact tip aluminium M6 / 28 mm / Ø 1.2 mm	10
	1092709	2 x gas nozzle, conical	10
	1092710	Cylindrical gas nozzle	10
	1092711	Point gas nozzle	10
	1091612	Handle shell	1
	1091613	Pushbutton	1
	1091650	Blue guide spiral Ø 0.6 - 0.9 mm / 3.0 m (for torch SMB 25, 3 m)	1
	1091651	Blue guide spiral Ø 0.6 - 0.9 mm / 4.0 m (for torch SMB 25, 4 m)	1
	1091652	Blue guide spiral Ø 0.6 - 0.9 mm / 5.0 m (for torch SMB 25, 5 m)	1

Guide spirals/Teflon cores see page 37

(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

MIG / MAG torch







Torch SMB 25 Flex **gas-cooled**

Model	SMB 25 Flex
Art. no.	1092524
Technical data:	
Shielding gas	CO2, mixed gas
Welding current CO2	230 A
Welding current Mixed gas	200 A
DC/AC duty cycle	60 %
Cooling	gas-cooled
Electrode diameter	0.8 – 1.2 mm
Contact tip	M6
Connection	Euro-ZA
Original equipment contact tip	Steel, 1.0 mm
Torch neck	flexible

Flexible torch neck



Art. no.	Wear parts
1092707	Contact tip aluminium 1.0 mm SMB 25 / 36
1092549	Contact tip Cu for Al M6 / 28 mm / Ø 1,2 mm

	Art. no.	Designation	PU ⁽¹⁾
	1092707	Contact tip aluminium 1.0 mm SMB 25 / 36	10
	1092549	Contact tip M6 Ø 1.2 mm /28 mm	10
	1092560	Nozzle holder M6	10
	1092552	Point gas nozzle	10
	1092550	Gas nozzle, conical, Ø 14.5 mm/57 mm	10
	1092552	Point gas nozzle	10















Guide spirals/Teflon cores see page 37

Torch SMB 36 gas-cooled

Technical data:		
Current max.	320 A (DC)	290 A (AC)
DC/AC duty cycle	60%	
Electrode diameter	0.8 – 1.2 mm	
Contact tip	M6 / M8	
Connection	Euro central connection	
Gas flow	10 – 20 l/min	
Original equipment contact tip	Steel, 1.2 mm	
Torch neck	50°	



Art. no.	Designation
1090363	SMB 36/3 m with pushbutton
1090364	SMB 36/4 m with pushbutton
1090365	SMB 36/5 m with pushbutton

	Art. no.	Designation	PU ⁽¹⁾
	1093670	Wear parts set SMB 36 2 x nozzle holder 2 x gas distributors 5 x contact tip 0.8 mm 5 x contact tip 1.0 mm 5 x contact tip 1.2 mm 4 x gas nozzle, conical 1 x gas nozzle, cylindrical	1
	1093671	Torch neck	1
	1093672	Nozzle holder	
	1093673	Gas distributor	
	1092704	Contact tip M6 / 28 mm / Ø 0.8 mm	10
	1092705	Contact tip M6 / 28 mm / Ø 1.0 mm	10
	1092706	Contact tip M6 / 28 mm / Ø 1.2 mm	10
	1092707	Contact tip aluminium M6 / 28 mm / Ø 1.0 mm	10
	1092708	Contact tip aluminium M6 / 28 mm / Ø 1.2 mm	10
	1092710	Cylindrical gas nozzle	10
	1091612	Handle shell	1
	1091613	Pushbutton	1
	1092750	Blue guide spiral Ø 1.0 - 1.2 mm / 3.0 m (for torch SMB 36, 3 m)	1
	1092751	Blue guide spiral Ø 1.0 - 1.2 mm / 4.0 m (for torch SMB 36, 4 m)	1
	1092752	Blue guide spiral Ø 1.0 - 1.2 mm / 5.0 m (for torch SMB 36, 5 m)	1
	1093695	Blue guide spiral Ø 1.6 mm / 3.0 m (for torch SMB 36, 3 m)	1
	1093696	Blue guide spiral Ø 1.6 mm / 4.0 m (for torch SMB 36, 4 m)	1
	1093697	Blue guide spiral Ø 1.6 mm / 5.0 m (for torch SMB 36, 5 m)	1

Guide spirals/Teflon cores see page 37







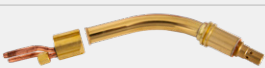



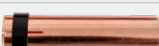


(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

Torch SMB 400 water-cooled

Technical data:		
Current max.	400 A (DC)	350 A (AC)
DC/AC duty cycle	100%	
Electrode diameter	0.8 – 1.2	
Contact tip	M6	
Connection	Euro central connection	
Gas flow	10 – 20 l/min	
Original equipment contact tip	Steel, 1.2 mm	
Torch neck	50°	



Art. no.	Designation
1090403	SMB 400/3 m with pushbutton
1090404	SMB 400/4 m with pushbutton
1090405	SMB 400/5 m with pushbutton

	Art. no.	Designation	PU ⁽¹⁾
	1094100	Wear parts set SMB 400 2 x nozzle holder 3 x gas distributors 5 x contact tip 1.0 mm 5 x contact tip 1.2 mm 4 x gas nozzle, conical 1 x gas nozzle, cylindrical	1
	1094105	Contact tip M8 / 30 mm / Ø 0.8 mm	10
	1094106	Contact tip 1.0 mm	10
	1094107	Contact tip 1.2 mm	10
	1094108	Aluminium contact tip 1.0 mm	10
	1094109	Aluminium contact tip 1.2 mm	10
	1094101	Torch neck SMB 36	10
	1094103	Nozzle holder	10
	1094104	Gas distributor	10
	1094110	Conical gas nozzle Ø 16.0 / 76 mm	1
	1094111	Cylindrical gas nozzle Ø 19.0 / 76 mm	1
	1094112	Point gas nozzle	1
	1094150	Blue guide spiral 3.0 m 0.6 – 0.9 mm (for torch SMB 400, 3 m)	1
	1094151	Blue guide spiral 4.0 m 0.6 – 0.9 mm (for torch SMB 400, 4 m)	1
	1094152	Blue guide spiral 5.0 m 0.6 – 0.9 mm (for torch SMB 400, 5 m)	1

Guide spirals/Teflon cores see page 37

MIG / MAG torch accessories

INTERIOR AND GUIDE SPIRALS

	Art. no.
Guide spirals with retaining nipple and O-ring recommended for steel and stainless steel	
Blue insulated 1.5/4.5; for Ø 0.6 - 0.8 mm	SMB 15-36
3.0 m	1051573
4.0 m	1051574
5.0 m	1051575
Red insulated 2.0/4.5; for Ø 1.0 - 1.2 mm	SMB 15-36
3.0 m	1052576
4.0 m	1052577
5.0 m	1052578
Blank 2.0/4.5; for Ø 1.0 - 1.2 mm	SMB 400
3.0 m	1054073
4.0 m	1054074
5.0 m	1054075
Blue insulated 0.6 - 0.9 mm	SMB 15
3.0 m	1091650
4.0 m	1091651
5.0 m	1091652
Blue 1.0 - 1.2 mm	SMB 25
3.0 m	1092750
4.0 m	1092751
5.0 m	1092752
Blue 1.6 mm	SMB 36
3.0 m	1093695
4.0 m	1093696
5.0 m	1093697
Blue 1.0 - 1.2 mm	SMB 400
3.0 m	1094150
4.0 m	1094151
5.0 m	1094152

TEFLON CORES

	Art. no.
with retaining nipple and O-ring recommended for non-ferrous metals such as aluminium, Cu and CuSi	
Blue 1.5/4.0; for Ø 0.8 - 1.0 mm	SMB 25-36
3.0 m	1051593
4.0 m	1051594
5.0 m	1051595
Red 2.0/4.0; for Ø 1.0 - 1.2 mm	SMB 25-36
3.0 m	1052590
4.0 m	1052591
5.0 m	1052592
Yellow 2.7/4.7; for Ø 1.6 mm	SMB 400
3.0 m	1053666
4.0 m	1053667
5.0 m	1053668
0.6 - 0.9 mm	SMB 25
3.0 m	1091655
4.0 m	1091656
5.0 m	1091657

POLYAMIDE CORES

	Art. no.
with retaining nipple and O-ring recommended for aluminium	
Grey 2.0/4.0; for Ø 1.0 - 1.2 mm	SMB 25/36
3.0 m	1052583
4.0 m	1052584
5.0 m	1052585
Grey 2.9/4.7; for Ø 1.6 mm	SMB 400
4.0 m	1052586
0.8 - 1.2 mm	SMB25/36
4.0 m	1091661
4.0 m	1091662
1.2 - 1.6 mm	SMB25/36/400
4.0 m	1092760
4.0 m	1092761
4.0 m	1092762

GUIDE TUBE

	Art. no.
for cores	
0.8 - 1.2 mm	1091665



CARBON -TEFLON CORES

	Art. no.
with retaining nipple, O-ring and brass spiral recommended for stainless steel and aluminium	
Black 2.7/4.7; for Ø 1.6 mm	SMB 400
4.0 m	1052599
Black 2.0/4.0; for Ø 1.0 - 1.2 mm	SMB 25/36
3.0 m	1052596
4.0 m	1052597
5.0 m	1052598

ACCESSORIES

	Art. no.	PU
O-ring 3.5 x 1.5	1051583	20
Holding nipple Ø 4 mm	1051596	20
Retaining nipple for guide spiral blank 1.5/4.0	1051598	20
Retaining nipple for guide spiral blank 2.0 - 2.5/4.0	1051599	20
Guide tube brass Ø 4 mm	1051597	1
Brass spiral, ready-made 200 mm	1051524	1

MIG BRAZING TORCH CONVERSION KIT

	Art. no.
SMB 15/4 m for wire 0.8 mm	1091521
consisting of	
10 x contact tip Ø 0.8 mm and Teflon core blue Ø 0.8 - 1.0 mm, 4 m	
SMB 15/4 m for wire 1.0 mm	1091522
consisting of	
10 x contact tip Ø 1.0 mm and Teflon core red Ø 1.0-1.2 mm, 4 m	

CUSI 3 WELDING WIRE

	Art. no.
For copper, low-alloyed copper and copper-zinc alloys. Well suited for galvanised sheet metal	
Small spool D200	
Ø 0.8 mm 5 kg	1131620
Ø 1.0 mm 5 kg	1131619
Basket coil K300	
Ø 0.8 mm 15 kg	1131625
Ø 1.0 mm 15 kg	1131624

CUAL 8 WELDING WIRE

	Art. no.
For manganese and nickel-copper-aluminium alloys. Well suited for highly stressed and high-strength steels	
Small spool D200	
Ø 0.8 mm 5 kg	1131630
Ø 1.0 mm 5 kg	1131629
Basket coil K300	
Ø 0.8 mm 15 kg	1131635
Ø 1.0 mm 15 kg	1131634

ARGON SHIELDING GAS

	Filling	Art. no.
Seamless steel bottles, complete with bottle valve, threaded according to DIN 477, cap DIN 4667 and filling		
New bottle	10 l	1741012
New bottle	20 l	1741021
Filling	10 l	1741013
Filling	20 l	1741023

ACCESSORIES

	Art. no.
MIG/MAG special tong	1092000
for cutting, time-saving cleaning and removing the shielding gas nozzle (Ø 15 - 18 mm) and loosening and tightening the contact tip	
Basket coil adapter KA 1	1110001
one-piece, plug-in	
Basket coil adapter KA 2	1110005
with quick-release fastener	
Centring adapter for D 200 coils	1110007
two-part	



MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

Torch

Torch ABIMIG W 440

water-cooled

Technical data:	
Load	500 A CO ₂
Shielding gas	450 A Mixed gas M21 (DIN EN ISO 14175)
Duty cycle	100%
Wire Ø	0.8 – 1.6 mm

Art. no.	Designation
1059943	W 440D torch 3 m ABIMIG
1059944	W 440D torch 4 m ABIMIG
1059945	W 440D torch 5 m ABIMIG
1059963	W 440D torch 3 m UD ABIMIG
1059964	W 440D torch 4 m UD ABIMIG
1059965	W 440D torch 5 m UD ABIMIG




Torch ABIMIG W 540









water-cooled

Technical data:	
Load	600 A CO ₂
Shielding gas	550 A Mixed gas M21 (DIN EN ISO 14175)
Duty cycle	100%
Wire Ø	1.0 – 1.6 mm





Art. no.	Designation
1059946	W 540D torch 3 m ABIMIG
1059947	W 540D torch 4 m ABIMIG
1059948	W 540D torch 5 m ABIMIG
1059966	W 540D torch 3 m UD ABIMIG
1059967	W 540D torch 4 m UD ABIMIG
1059968	W 540D torch 5 m UD ABIMIG

	Art. no.	Designation	Thread	Design	Ø / Nominal diameter	PU*
	1054042	Contact tip ECu	M8		0.8 mm	10
	1054044	Contact tip ECu	M8		1.0 mm	10
	1054046	Contact tip ECu	M8		1.2 mm	10
	1057045	Contact tip ECu	M8		1.4 mm	10
	1054045	Contact tip ECu	M8		1.6 mm	10
	1054047	Contact tip ECu aluminium wire	M8		1.0 mm	10
	1054049	Contact tip ECu aluminium wire	M8		1.2 mm	10
	1057046	Contact tip ECu aluminium wire	M8		1.4 mm	10
	1057047	Contact tip ECu aluminium wire	M8		1.6 mm	10

Torch ABIMIG W 440

	Art. no.	Designation	Thread	Design	Ø / Nominal diameter	PU*
	1057040	Splash guard for gas nozzle NW12				10
	1057041	Splash guard for gas nozzle NW14.5 & 18				10
	1057042	Nozzle holder 26 mm	M10/M8			5
	1057043	Nozzle holder 28 mm	M10/M8			5
	1057044	Nozzle holder 31 mm	M10/M8			5
	1057048	Gas nozzle	M20	conical	12 mm	10
	1057049	Gas nozzle	M20	conical	14.5 mm	10
	1057050	Gas nozzle	M20	cylindrical	18 mm	10

Torch ABIMIG W 540

	Art. no.	Designation	Thread	Design	Ø / Nominal diameter	PU*
	1057070	Splash guard for gas nozzle NW14, 16, 18				10
	1057071	Nozzle holder 25 mm	M11/M8			5
	1057072	Nozzle holder 27 mm	M11/M8			5
	1057073	Gas nozzle		conical	14 mm	10
	1057074	Gas nozzle		conical	16 mm	10
	1057075	Gas nozzle		cylindrical	20 mm	10

Guide spirals/Teflon cores see page 26

* PU = quantity in pieces per packaging unit. Purchase only possible in PUs

INVERTER TIG WELDING MACHINES



Power
Factor
Correction

► PFC is an electrical or electronic circuit that increases the so-called power factor



Generator
Friendly

► Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers



Multivoltage
Einsatz
weltweit

► Regulates the voltage from 110 V - 230 V



AC/DC
Technology

► Welding with direct current or alternating current



DC
PULSE

► TIG DC function = enables simple TIG welding



HF high-frequency ignition ignites during TIG welding without touching the workpiece

Inverter TIG welding machines DC / DC Pulse

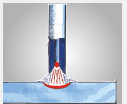
easytig® 181 DC / 201 DC PULSE

Inverter TIG welding machines. Portable TIG DC inverter for workshop and mobile use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ Precise setting of welding parameters via digital display
- ▶ Universally applicable for welding all common electrode types
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **HF high-frequency ignition** ignites during TIG welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle

EASY-TIG 201DC PULSE

- ▶ Adjustable welding curve
- ▶ Pulse up to 200 Hz



ELECTRODES



TIG



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EASY-TIG 181 DC

Torch included SR17
(Easy-Tig 181DC)



EASY-TIG 201 DC PULSE

Torch included SR26
(Easy-Tig 201DC PULSE)



OPERATION

- 1 Operation indicator light (green)
- 2 Temperature indicator light (yellow)
- 3 Digital display
- 4 TIG 4T/2T/ MMA selector switch
- 5 Rotary knob for welding current preselection
- 6 Rotary knob for down slope
- 7 Rotary knob for post flow



EASY-TIG 181DC



EASY-TIG 201 DC PULSE

- 8 Electrode welding setting
- 9 MMA/LIFT/HF TIG selection button
- 10 TIG 2T/4T mode selection button
- 11 Digital display - Hot start - Welding current - Arc strength
- 12 TIG parameter setting
- 13 Parameter selection and setting button

TECHNICAL DATA:

Model		EASY-TIG 181 DC	EASY-TIG 201 DC PULSE
Art. no.		1074018	1074020
Technical data			
Setting range for TIG DC	A	10 – 180	5 – 200
Setting range for electrode	A	10 – 180	5 – 200
Weldable electrode Ø	mm	1.6 – 4.0	1.6 – 4.0
Sheet thicknesses	mm	0.5 – 8.0	0.5 – 10.0
No-load voltage	V	MMA 75.5 TIG 92.6	MMA 90.5 TIG 60.3
Duty cycle at I _{max} [40°C] Electrode	%	40	30
Current at 100% duty cycle [40°C] TIG DC	A	100	120
Current at 100% duty cycle [40°C] Electrode	A	100	120
Power factor	cos phi	0.6	0.6
Ignition		HF	HF
Torch cooling		gas-cooled	gas-cooled
Protection class		IP21S	IP21S
Power consumption TIG	kVA	3.9	4.5
Electrode power consumption	kVA	5.9	6.9
Pulse rate	Hz	–	0.5–200
Electrical connection ~50/60Hz AC	V	230 ±10%	230 ±10%
Dimensions (L x W x H) approx.	mm	430 x 150 x 280	430 x 150 x 280
Weight approx.	kg	7.3	9.7
Standards ¹⁾		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

SCOPE OF DELIVERY:

- Welding torch SR 17/4 m (EASY-TIG 181DC)
- Welding torch SR 26/4 m (EASY-TIG 201DC PULSE)
- Ground cable 16mm²/3m
- Gas hose 4 m incl. quick connector
- Welding cable 16 mm² with electrode holder, 3 m

All devices protection class IP21S

¹⁾ EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

ACCESSORIES



ACCESSORY for Easy-Tig 181DC

① TIG torch SR17/4 m, ED, gas-cooled, 1105044

① TIG torch SR17/8 m, ED, gas-cooled 1105048

ACCESSORY for Easy-Tig 201 DC PULS

TIG torch SR26/4 m, U/D, gas-cooled 1105014

TIG torch SR26/8 m, U/D, gas-cooled 1105018

① TIG torch SR26/4 m, ED, gas-cooled 1105004

① TIG torch SR26/8 m, ED, gas-cooled 1105008

② Wireless hand remote control 1174004

③ Foot remote control 5m 1174009

④ Wireless foot remote control 1174007

Control cable plug 12-pin incl. contact pins 1104012

ACCESSORIES

Adapter 1/4" external thread x M12x1 internal thread / union nut 1104001

Argon/CO₂ Pressure reducer, large 1700050

3-pin control cable connector 1174010

⑤ Ground cable 25 mm² 4m 13 mm with 400 A clamp 1250225

⑥ Wear parts set 1100152

consisting of:

1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle

Wear parts set "Mini": 1100200

comprises:

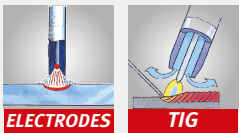
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm

Inverter TIG welding machines DC PULSE

CRAFTIG® 201 DC P PULSE / 253 DC PULSE

Portable TIG DC inverter for professional and mobile workshop use

- ▶ Built using modern inverter technology
- ▶ Universally applicable for welding all common electrode types
- ▶ Ideally suited for assembly work thanks to protection class IP 21S, generally also for outdoor work
- ▶ Power factor correction PFC for problem-free use even on cable reels
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ HF high-frequency ignition ignites during TIG welding without touching the workpiece
- ▶ Multi-voltage from 110 to 230 volts
- ▶ VRD for voltage reduction when idling
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting and display of welding parameters via LC display
- ▶ Suitable for generators
- ▶ Adjustable welding curve
- ▶ CRAFT-TIG 201 DC P PULSE equipped with PFC (power factor correction), also enables optimum use on cable drums
- ▶ With multivoltage
- ▶ CRAFT-TIG 253 DC PULSE optionally with water cooling
- ▶ VRD operation and TIG pulsing
- ▶ Water cooling connection



Power Factor Correction

▶ PFC is an electrical or electronic circuit that increases the so-called power factor

Generator Friendly

HF

Multivoltage Einsatz weltweit

DC PULSE

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CRAFT-TIG 201 DC P PULSE



CRAFT-TIG 253 DC PULSE

Torch included SR26 (Craft-Tig 201 DC P Pulse)



OPERATION

- 1 Electrode welding setting
- 2 MMA/LIFT/HF TIG selection button
- 3 TIG 2T/4T mode selection button
- 4 Digital display Multifunctional display
- 5 TIG parameter setting
- 6 Parameter selection and setting button



CRAFT-TIG 201 DC P PULSE



CRAFT-TIG 253 DC PULSE

- 1 Gas or water-cooled selector button
- 2 Digital display, Multifunction display
- 3 Display MMA
- 4 TIG parameter setting
- 5 MMA/LIFT/HF TIG selection button
- 6 TIG 2T/4T mode selection button
- 7 Parameter selection and setting button

TECHNICAL DATA:

Model		CRAFT-TIG 201 DC P PULSE	CRAFT-TIG 253 DC PULSE
Art. no.		1074201	1074253
Technical data			
Setting range TIG / electrode	A	5 – 200	5 – 250
Weldable electrodes	mm	1.6 – 4.0	1.6 – 5.0
Duty cycle at I _{max} [40°C] TIG / Electrode	%	50 / 30	60 / 60
Current at 100% duty cycle [40°C] TIG / Electrode	A	145 / 135	195 / 195
No-load voltage	V	TIG 66.5, MMA 66.7	Electrode 70.5 / TIG 60.5
Ignition		High frequency	High frequency
Torch cooling		gas-cooled	gas-cooled water-cooled
Power factor	cos phi	0.99	0.67
Current consumption TIG DC	A	19.7	13.5
Current consumption electrode DC	A	30.1	18.6
Pulse rate	Hz	0.5 – 200	0.5 – 200
Power consumption TIG / electrode	kVA	4.5 / 6.9	5 / 7.1
Required generator output	kVA	>6.9	>10.6
Overall performance	kVA	TIG 4.5/MMA 6.9	10.6/7.7
Electrical connection ~50/60Hz AC	V	230±10%	400±10%
Dimensions (L x W x H) approx.	mm	500 x 150 x 280	480 x 190 x 350
Weight approx.	kg	10	15
Standard		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.
All devices protection class IP21S

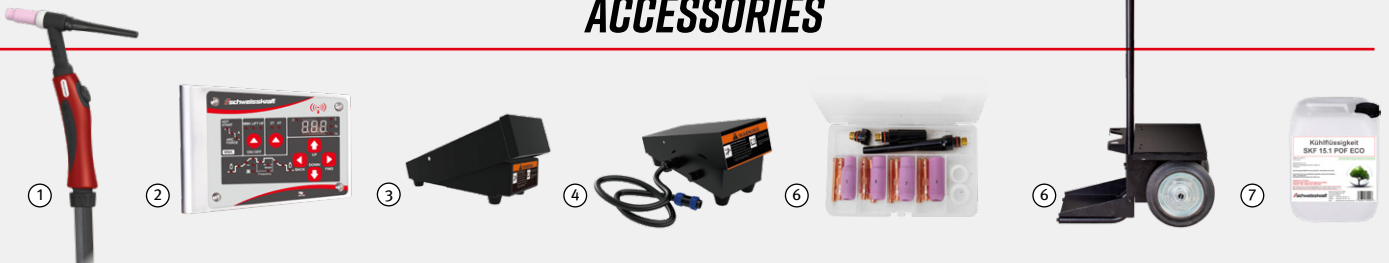
CRAFT-TIG 201 DC P PULSE SCOPE OF DELIVERY:

- Welding torch SR 26/ 4 m
- Pressure reducer
- Ground cable 16mm² / 3m
- Gas hose 4 m incl. quick connector
- Welding cable 16 mm² with electrode holder, 3 m

CRAFT-TIG 253 DC PULSE SCOPE OF DELIVERY:

- Ground cable 25mm² / 3m
- Gas hose 4 m incl. quick connector
- Hose clamp
- ! • Please remember to use the correct welding torch!

ACCESSORIES



ACCESSORY for CRAFT-TIG 253 DC PULSE

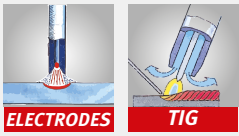
	Art. no.
TIG torch SR18, ED, water-cooled, 4 m	1105024
TIG torch SR18, ED, water-cooled, 8 m	1105028
TIG torch SR18, U/D, water-cooled, 4 m	1105034
TIG torch SR18, U/D, water-cooled, 8 m	1105038
⑥ Trolley	1174001
Cooling unit 400V / 4 l	1174006
⑦ Coolant SKF 15 10l - canister (ready-mixed)	1030110
ACCESSORIES	
③ TIG torch SR26, ED, gas-cooled, 4 m	1105004
③ TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
② Wireless hand remote control	1174004
⑤ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
Control cable plug 12-pin incl. contact pins	1104012
Control cable complete with plug	1104011
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
Argon/CO ₂ pressure reducer	1700050
Welding cable 4 m 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
⑥ Wear parts set	1100152
1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini": Teflon seal for nozzle, 2 x clamping sleeves 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve housings 1.0 mm, 2 x gas nozzles d = 9.8 mm, 1x torch cap each medium/long/short, Teflon seal, 1x gas lens each 1.6 mm, 2.4 mm, 3.2 mm, 2x collet 1.6 mm, 2.4 mm, 3.2 mm, 2x gas nozzle gas lens size 6, 2x tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	1100200

Inverter TIG welding machines AC / DC Pulse

easytig® 201 AC/DC PULSE –

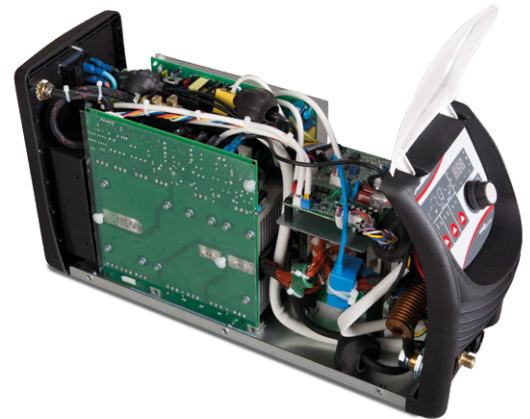
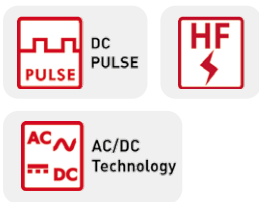
Portable TIG AC/DC inverter for workshop and mobile use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ TIG DC function = enables simple TIG welding
- ▶ Precise setting of welding parameters via digital display
- ▶ Universally applicable for welding all common electrode types
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ Adjustable welding curve
- ▶ **HF high-frequency ignition** ignites during TIG-welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle



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Torch included SR26

OPERATION

- ① MMA/LIFT/HF TIG selection button
- ② AC/DC selection button
- ③ TIG 2T/4T mode selection button



- ④ Parameter selection and setting button
- ⑤ TIG parameter setting
- ⑥ Display - Welding current

TECHNICAL DATA:

Model	EASY-TIG 201 AC/DC Pulse	
Art. no.	1074021	
Technical data		
Setting range for TIG DC	A	10 – 170
Setting range for electrode	A	10 – 170
Weldable electrode Ø	mm	1.6 – 4.0
Sheet thicknesses	mm	0.5 – 10
No-load voltage	V	AC TIG 73.4/DC TIG 69.8/AC MMA 69.3/DC MMA 69.3
Duty cycle at I_{max} [40°C] Electrode	%	30
Current at 100% duty cycle [40°C] TIG	A	110
Current at 100% duty cycle [40°C] Electrode	A	95
Power consumption TIG	kVA	4
Electrode power consumption	kVA	5.9
Ignition	HF	
Torch cooling	gas-cooled	
Protection class	IP21S	
Insulation class	H	
EMC - class	A	
Slow-blow fuse	A	16
Pulse rate	Hz	0.5~200
Required generator output	kVA	>9.5
Power factor	cos phi	0.6
Electrical connection ~50 Hz AC	V	230±10%
Dimensions (L x W x H) approx.	mm	460 x 150 x 280
Weight approx.	kg	9
Standards	DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system. All devices protection class IP21S

SCOPE OF DELIVERY:

- Welding torch SR 26/ 4 m
- Ground cable 25mm² / 3m
- Gas hose 4 m incl. quick connector

ACCESSORIES



ACCESSORIES

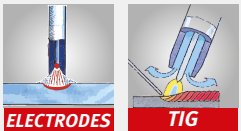
① TIG torch SR26, ED, gas-cooled, 4 m	1105004
① TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
② Pressure regulator with content and working pressure gauge, argon/CO ₂	1700050
③ Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
④ Foot remote control 5m	1174009
⑤ Welding cable 4 m 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
Ground cable 4m 25 mm ² 13 mm with 400 A clamp	1250225
⑥ Wear parts set	1100152
1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	

Inverter TIG welding machines AC / DC Pulse

craftig® 201 AC/DC P PULSE

Portable TIG DC inverter for professional and mobile workshop use

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and generally also for outdoor work thanks to protection class IP21S
- ▶ Universally applicable for welding all common electrode types
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ **HF high-frequency ignition** ignites during TIG-welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ Adjustable welding curve
- ▶ Device with **PFC** (power factor correction) equipped enables the best use even on cable reels
- ▶ Optionally with water cooling
- ▶ With multi-voltage and suitable for generators
- ▶ 9 programmes can be saved



▶ **PFC** is an electrical or electronic circuit that increases the so-called power factor



Scope of delivery Factory assembly
 Article no. 9002805
€89.00 plus VAT
 Assembly and filling with coolant for the TIG welding unit
CRAFT-TIG 201 AC/DC P Pulse SET 2 (Art. no. 1074202SET2)
 before delivery



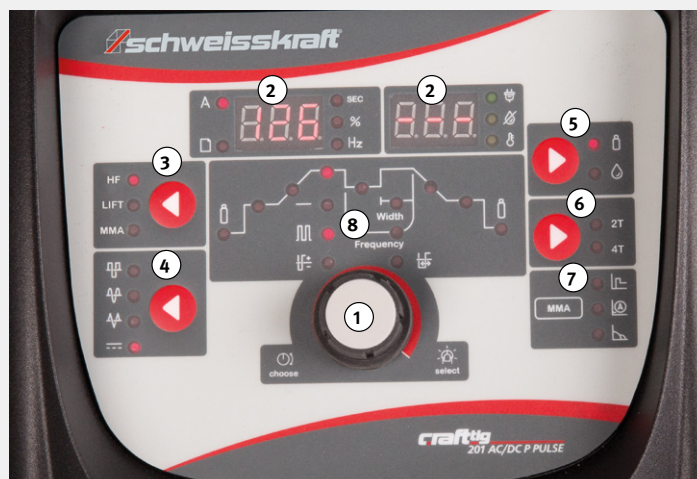
CRAFT-TIG 201 AC/DC P PULSE



CRAFT-TIG 201 AC/DC P PULSE SET 2

OPERATION

- ① Parameter selection and setting button
- ② Digital display, Multifunction display
- ③ WIGHF, Lift-Arc and MMA select button
- ④ AC/DC selector button



- ⑤ Gas or water-cooled selector button
- ⑥ TIG 2T/4T mode selection button
- ⑦ Display MMA
- ⑧ TIG parameter setting

TECHNICAL DATA:

Model	CRAFT-TIG	
	201 AC/DC P PULSE	201 AC/DC P Pulse Set2
Art. no.	1074202	1074202SET2
Technical data		
Setting range for TIG DC	A	5 – 200
Setting range for electrode	A	5 – 200
Weldable electrode Ø	mm	1.6 – 4.0
Sheet thicknesses	mm	0.5 – 10
No-load voltage	V	10.4 (MMA), 70 (TIG)
TIG setting range		3 – 200 (230 V) 3 – 160 (110 V)
Setting range for electrode		10 – 200 (230 V) 10 – 130 (110 V)
Duty cycle max. current [40°C] TIG	%	60
Duty cycle max. current [40°C] Electrode	%	35 (230 V) 60 (110 V)
Current at 100% duty cycle [40°C] TIG DC	A	155 (230 V) 125 (110 V)
Current at 100% duty cycle [40°C] Electrode	A	120 (230 V) 100 (110 V)
Ignition		HF
Torch cooling		gas-cooled Watercooled
Protection class		IP21S
Pulse rate	Hz	0.5 ~ 999
Power factor	cos phi	0.99
Current consumption TIG AC	A	(110 V / 230 V) 30.8 / 19.2
Current consumption TIG DC	A	(110 V / 230 V) 33.8 / 20.5
Current consumption electrode AC	A	(110 V/230 V) 35.8 / 27.5
Current consumption electrode DC	A	(110 V/230 V) 39.0 / 30.0
Required generator output	kVA	> 6.9
Power consumption TIG	kVA	4.7
Electrode power consumption	kVA	6.9
Electrical connection ~ 50 Hz	V	90 ~ 275
Dimensions (L x W x H) approx.	mm	580 x 190 x 350 580 x 630 x 1120
Weight approx.	kg	14.5 48.5
Standard*		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

SCOPE OF DELIVERY:

- Welding torch SR 26 / 4 m UP / Down gas-cooled
- Pressure reducer
- Ground cable 16mm² / 3m
- Gas hose 4 m incl. quick connector

SET 2 ADDITIONALLY INCLUDES:

- TIG torch SR18/ 4 m water-cooled
- VarioProtect XXL-W-2 TC welding helmet
- Basic L TIG welding glove
- Water cooling unit
- Trolley

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

ACCESSORIES



ACCESSORIES

TIG torch SR26, ED, gas-cooled, 4 m	1105004
TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
① TIG torch SR18, ED, water-cooled, 4 m	1105024
① TIG torch SR18, ED, water-cooled, 8 m	1105028
① TIG torch SR18, U/D, water-cooled, 4 m	1105034
① TIG torch SR18, U/D, water-cooled, 8 m	1105038
Pressure reducer Argon/CO ₂	1700050
② Wireless hand remote control	1174003
③ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
⑤ Wireless handheld remote control	1174100
Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
⑥ SKF 15 coolant 10 l – canister (ready-mixed)	1030110
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
⑦ 4 litre cooling unit, 230 V	1174002
⑧ Trolley	1174001
⑨ Wear parts set	1100152
1x short/medium/long torch cap each, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2x clamping sleeve housing 1.0 mm, 2x gas nozzle d=9.8 mm, 1x torch cap medium/long/short, Teflon seal, 1x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens gr. 6, 2x each tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	

Inverter TIG welding machines AC / DC Pulse

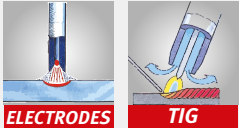
craftig® 323 AC/DC PULSE –

TIG DC pulse inverter for professional and mobile workshop use

- ▶ Built using modern inverter technology
- ▶ Ideally suited for assembly work thanks to protection class IP 21S, generally also for outdoor work
- ▶ Universally applicable for welding all common electrode types
- ▶ TIG pulsing enables welding with reduced heat input
- ▶ HF high-frequency ignition ignites during TIG

- ▶ welding without touching the workpiece
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Precise setting of welding parameters via digital display with job memory
- ▶ 9 programmes can be saved
- ▶ AC triangle wave welding output: Reduced heat input for the same current setting,

- ▶ particularly useful for welding thin metal
- ▶ Alternating current sine wave welding output: Traditional AC TIG welding waveform, quieter, "softer" arc characteristics
- ▶ AC square wave: Focussed arc for maximum penetration, fast travel speed with optimum directional control
- ▶ Exclusively available including factory assembly, article number 9002800



- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Including
Torch SR 18
Ground cable
Gas hose
Water cooling unit
Trolley

Scope of delivery Factory assembly
Article no. 9002800
115.00 € plus VAT
Assembly and filling with coolant for the TIG welding unit
CRAFT-TIG 323 AC/DC Pulse SET
(Art. no. 1074323SET)
before delivery

OPERATION



- ① Parameter selection and setting button
- ② Digital display, Multifunction display
- ③ WIGHF, Lift-Arc and MMA select button
- ④ AC/DC selector button

- ⑤ Gas or water-cooled selector button
- ⑥ TIG 2T/4T mode selection button
- ⑦ Display MMA
- ⑧ TIG parameter setting

TECHNICAL DATA:

Model	CRAFT-TIG 323 AC/DC PULSE	
Art. no.	1074323	
Setting range TIG / electrode	A	10 – 320
Weldable electrodes	mm	1.6 – 5.0
No-load voltage AC TIG / DC TIG	V	84.6 / 76.4
No-load voltage AC electrode / DC electrode	V	75.8 / 75.6
Duty cycle at max. current 40°C TIG DC	%	60
Duty cycle at max. current 40°C Electrode	%	60
Current at duty cycle 100% 40°C TIG DC	A	250
Current at duty cycle 100% 40°C Electrode	A	250
Power consumption TIG / electrode	kVA	4.8 / 6.5
Ignition	High frequency	
Torch cooling	gas-cooled Watercooled	
Pulse rate	Hz	0.5 – 250
Power factor	cos phi	0.65
Current consumption TIG AC / TIG DC	A	18.8 / 19.5
Current consumption electrode AC / electrode DC	A	24.3 / 25.8
Required generator output	kVA	>10.3
Electrical connection ~50/60 Hz	V	400 ±10%
Dimensions (L x W x H) approx.	mm	630 x 240 x 445
Weight approx.	kg	26
Standards*	DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	



1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

All devices protection class IP21S

SCOPE OF DELIVERY:

- Welding torch SR 18 4 m, water-cooled
- Ground cable 35mm²/3m
- Gas hose 4 m incl. quick connector
- Water cooling unit
- Trolley

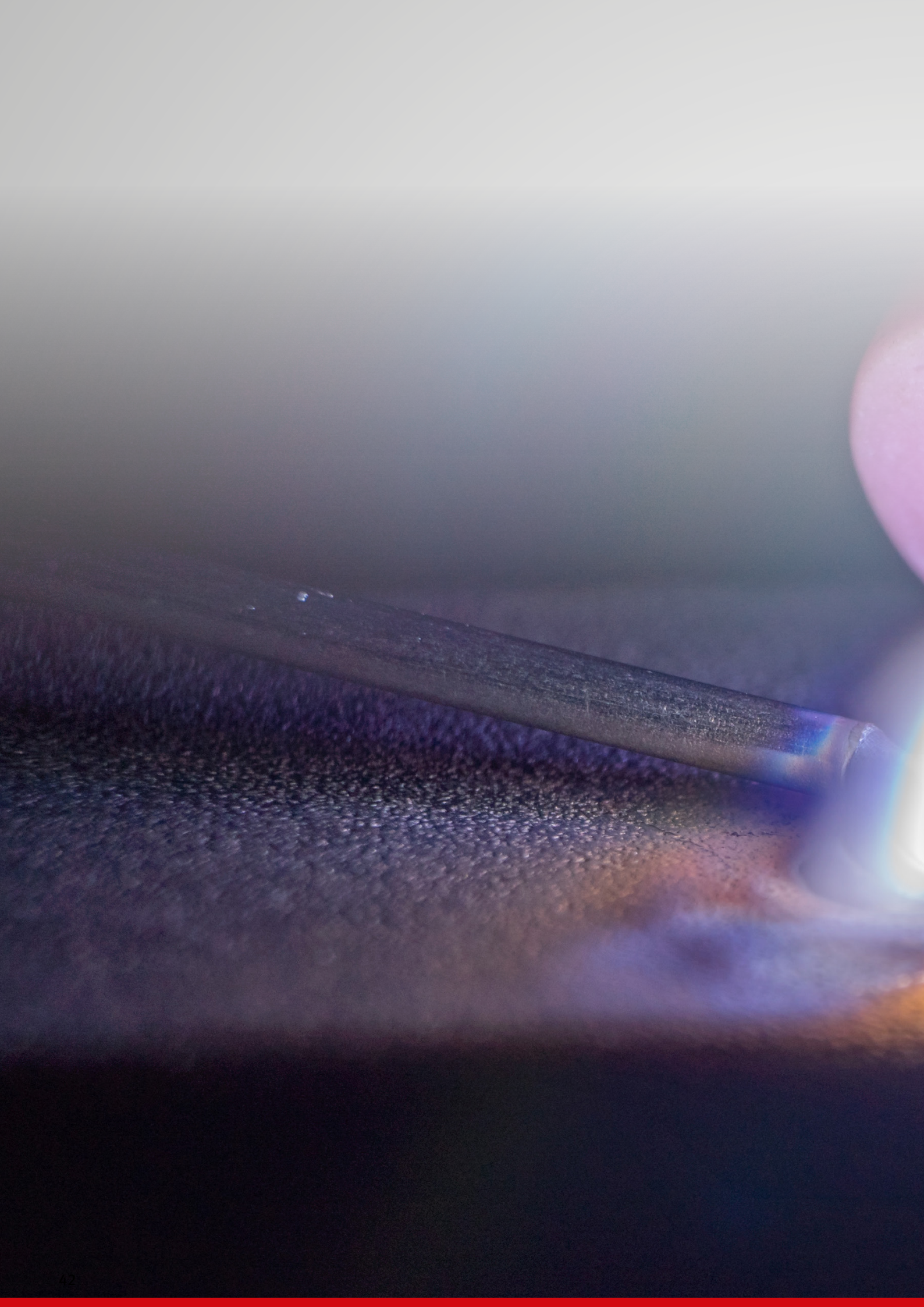
- ! Without coolant
- ! Without pressure reducer

ACCESSORIES

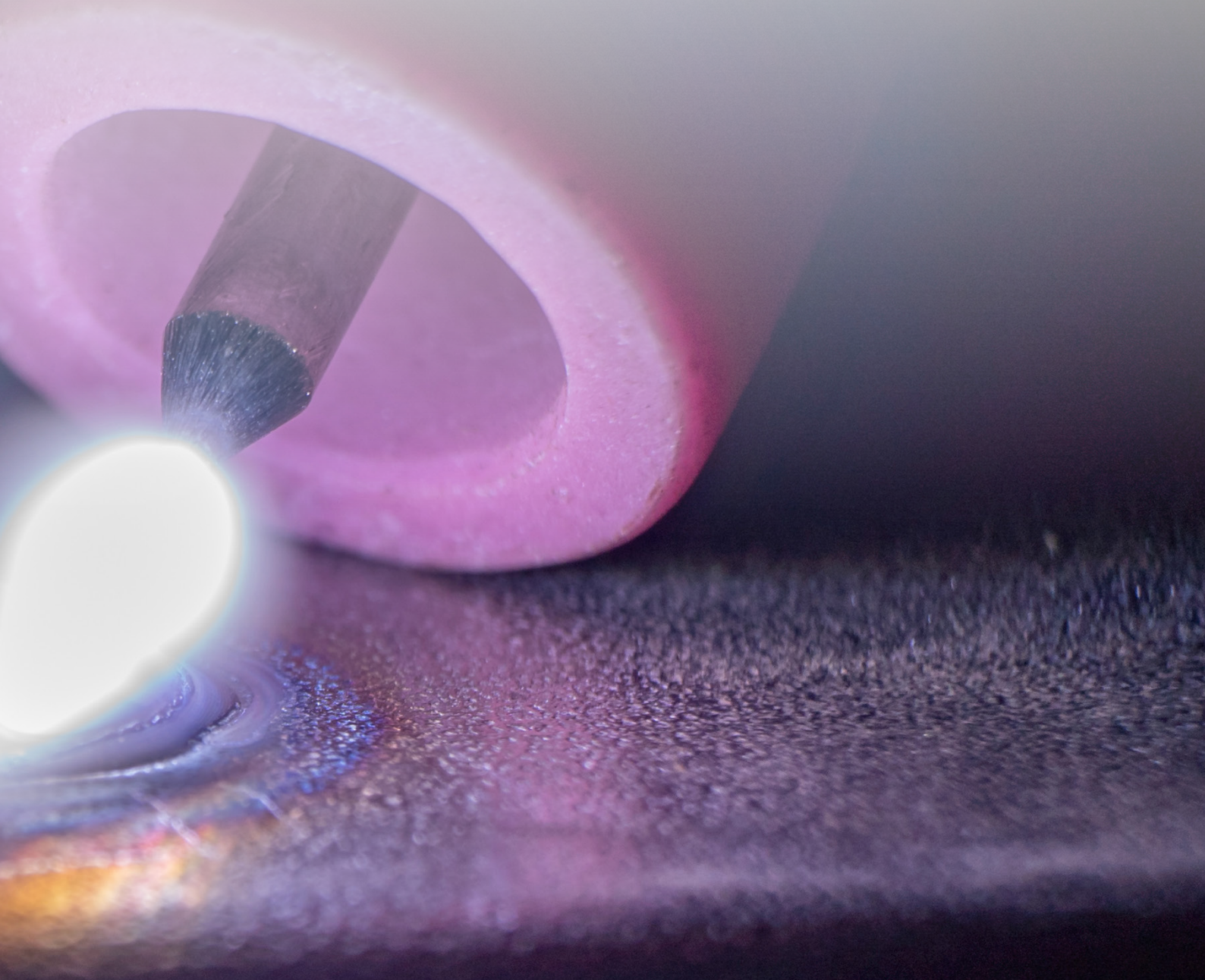


ACCESSORIES





TIG torch SR26, ED, gas-cooled, 4 m	1105004
TIG torch SR26, ED, gas-cooled, 8 m	1105008
TIG torch SR26, U/D, gas-cooled, 4 m	1105014
TIG torch SR26, U/D, gas-cooled, 8 m	1105018
① TIG torch SR18, ED, water-cooled, 4 m	1105024
① TIG torch SR18, ED, water-cooled, 8 m	1105028
① TIG torch SR18, U/D, water-cooled, 4 m	1105034
① TIG torch SR18, U/D, water-cooled, 8 m	1105038
Pressure reducer Argon/CO ₂	1700050
② Wireless hand remote control	1174003
③ Wireless foot remote control	1174007
④ Foot remote control 5m	1174009
⑤ Wireless handheld remote control	1174100
Control cable complete with plug	1104011
Control cable plug 12-pin incl. contact pins	1104012
⑥ Coolant SKF 15 10l - canister (ready-mixed)	1030110
Adapter 1/4" external thread x M12x1 internal thread / union nut	1104001
⑦ 4 litre cooling unit, 230 V	1174002
⑧ Trolley	1174001
⑨ Wear parts set	1100152
1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	
Wear parts set "Mini":	1100200
Teflon seal for nozzle, 2 x clamping sleeves 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve housings 1.0 mm, 2 x gas nozzles d = 9.8 mm, 1 x torch cap medium/long/short, Teflon seal, 1 x gas lens 1.6 mm, 2.4 mm, 3.2 mm, 2 x clamping sleeve 1.6 mm, 2.4 mm, 3.2 mm, 2 x gas nozzle gas lens size 6, 2 x tungsten electrode gold 1.6 mm, gold 2.4 mm, gold 3.2 mm	



TIG TORCH ACCESSORIES



Torch accessories for torches SR17, SR 18, SR 26, SSR 17 DD and SSR 7-26 DD

	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾
	1	Gas nozzle 47 mm	6.4 mm	1100304	10
		Gas nozzle 47 mm	8.0 mm	1100305	10
		Gas nozzle 47 mm	9.8 mm	1100306	10
		Gas nozzle 47 mm	11.2 mm	1100307	10
		Gas nozzle 47 mm	12.7 mm	1100308	10
		Gas nozzle 47 mm	15.7 mm	1100310	10
		Gas nozzle 47 mm	19.0 mm	1100312	10
	4	Teflon seal for nozzle		1100105	10
	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾
	2	Clamping sleeve housing	1.0 mm	1100210	10
		Clamping sleeve housing	1.6 mm	1100216	10
		Clamping sleeve housing	2.4 mm	1100224	10
		Clamping sleeve housing	3.2 mm	1100232	10
		Clamping sleeve housing	4.0 mm	1100240	10
	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾
	3	Clamping sleeve	1.0 mm	1100110	10
		Clamping sleeve	1.6 mm	1100116	10
		Clamping sleeve	2.4 mm	1100124	10
		Clamping sleeve	3.2 mm	1100132	10
		Clamping sleeve	4.0 mm	1100140	10
	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾
		Gas nozzle for gas lens size 4	6.4 mm	1100314	10
		Gas nozzle for gas lens size 5	8.0 mm	1100315	10
		Gas nozzle for gas lens size 6	9.8 mm	1100316	10
		Gas nozzle for gas lens size 7	11.2 mm	1100317	10
		Gas nozzle for gas lens size 8	12.7 mm	1100318	10
	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾
	8	Gas lens	1.0 mm	1103010	5
		Gas lens	1.6 mm	1103016	5
		Gas lens	2.4 mm	1103024	5
		Gas lens	3.2 mm	1103032	5
		Gas lens	4.0 mm	1103040	5
		Teflon seal for gas lens		1100107	10



Wear parts set for SR 17/18 and 26

1x short torch cap
1x medium torch cap
1x long torch cap

1x gas nozzle size 5 / 8 mm
1x gas nozzle size 6 / 9.8 mm
1x gas nozzle size 7 / 11.2 mm
1x gas nozzle size 8 / 12.7 mm
1x gas nozzle size 10 / 15.7 mm

1x clamping sleeve 1.0 mm
1x clamping sleeve 1.6 mm
1x clamping sleeve 2.4 mm
1x clamping sleeve 3.2 mm
1x clamping sleeve 4.0 mm

1x clamping sleeve housing 1.6 mm
1x clamping sleeve housing 2.0 mm
1x clamping sleeve housing 2.4 mm
1x clamping sleeve housing 3.2 mm
1x clamping sleeve housing 4.0 mm

Wear parts set Mini

1x Teflon seal for nozzle
2x clamping sleeve 1.6 mm
2x clamping sleeve 2.4 mm
2x clamping sleeve 3.2 mm
2x clamping sleeve housing 1.0 mm













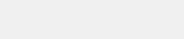


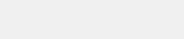

2x gas nozzle d=9.8mm
1x medium torch cap
1x long torch cap
1x short torch cap
1x Teflon seal

1x gas lens 1.6 mm
1x gas lens 2.4 mm
1x gas lens 3.2 mm
2x clamping sleeve 1.6 mm
2x clamping sleeve 2.4 mm

2x clamping sleeve 3.2 mm
2x gas nozzle, gas lens size 6
2x tungsten electrode gold 1.6 mm
2x tungsten electrode gold 2.4 mm
2x tungsten electrode gold 3.2 mm

(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

Torch accessories for torches SR17, SR 18, SR 26, SSR 17 DD and SSR 7-26 DD

	No.	Designation	Ø / Nominal diameter	Art. no.	PU ⁽¹⁾	
		Gas nozzle Mini size 4	6.4 mm	1100401	10	MIG/MAG
		Gas nozzle Mini size 5	8.4 mm	1100402	10	
		Gas nozzle Mini size 6	9.8 mm	1100403	10	
		Gas nozzle Mini size 7	11.2 mm	1100404	10	
		Gas nozzle Mini size 8	12.7 mm	1100405	10	
		Gas nozzle Mini size 10	15.7 mm	1100406	10	
	No.	Gas lens Mini	Ø / Nominal diameter	Art. no.	PU*	TIG inverter
		Gas lens Mini size 4		1100511	10	
		Gas lens Mini size 5		1100512	10	
		Gas lens Mini size 6		1100513	10	
		Gas lens Mini size 7		1100514	10	
		Gas lens Mini size 8		1100515	10	
		Teflon seal for gas lens Mini		1472102	10	Electrode inverter
	No.	Clamping sleeve Mini	Ø / Nominal diameter	Art. no.	PU*	
		Clamping sleeve Mini	1.0 mm	1473110	10	
		Clamping sleeve Mini	1.6 mm	1473116	10	
		Clamping sleeve Mini	2.4 mm	1473124	10	
		Clamping sleeve Mini	3.2 mm	1473132	10	
	No.	Clamping sleeve housing Mini	Ø / Nominal diameter	Art. no.	PU*	Laser welding
		Clamping sleeve housing Mini	1.6 mm	1473516	10	
		Clamping sleeve housing Mini	2.4 mm	1473524	10	
		Clamping sleeve housing Mini	3.2 mm	1473532	10	

	No.	Designation	Ø / Nominal diameter	Art. no.	PU*	
	5	Torch body (for SR17)		1100750	1	Plasma cutters
	1	Torch body (for SR26)		1100650	1	
	6	Torch cap long 117 mm		1100100	2	
		Torch cap short 22.5 mm		1100101	2	
	7	Grip shells set		1100150	1	Electrochemical processing
	8	Pushbutton (for SSR 17 DD, SSR 7-26 DD)		1100102	1	
		Potentiometer 10k		1100112	1	
	11	Handle shell halves for potentiometer (for SSR 17 DD, SSR 7-26 DD)		1100113	1	
		Wear parts set		1100152	1	
		Wear parts set "Mini"		1100200	1	

Torch

ABITIG 260W water-cooled (for HIGH-TIG systems)

Designation	Art. no.
ABITIG 260W 19 4m	1490054
ABITIG 260W 19 8m	1490058

Technical data:		
Duty cycle (at 60%)	240 A (DC)	170 A (DC)
Electrode diameter	1.0 – 3.2 mm	
Specification	D GRIP-LITTLE HighFlex leather	
Cooling	water-cooled	



ABITIG 260 W

R-TIG 150 gas-cooled (for HIGH-TIG systems)

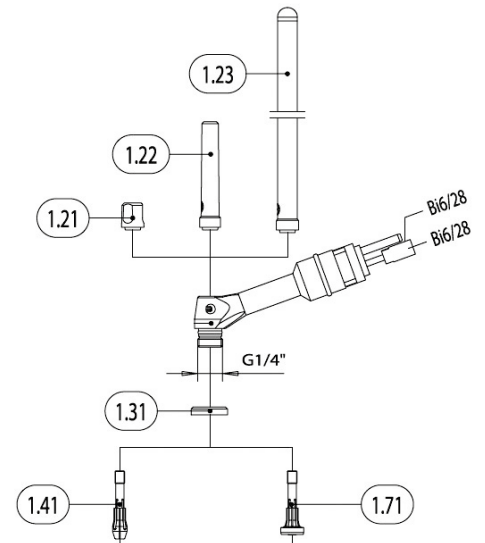
Designation	Art. no.
R-TIG 150 19 4m	1490014
R-TIG 150 19 8m	1490018

Technical data:		
Duty cycle (at 60%)	140 A (DC)	100 A (DC)
Electrode diameter	1.0 – 2.4 mm	
Specification	UD GRIP-LITTLE HighFlex leather	
Cooling	gas-cooled	



R-TIG 150 19

	No.	Designation	Art. no.	PU ⁽¹⁾
		Electrode holder, 1.6 mm	1466037	5
	01:41	Electrode holder, 2.4 mm	1466039	5
		Electrode holder, 3.2 mm	1466040	5
	1.71	Gas diffuser 1.0 mm	1466049	5
		Gas diffuser 1.6 mm	1466050	5
		Gas diffuser 2.4 mm	1466052	5
		Gas diffuser 3.2 mm	1466053	5
	01:31	Insulator	1466035	10
		Ceramic gas nozzle 6.5 mm	1466041	10
	01:51	Ceramic gas nozzle 8 mm	1466042	10
		Ceramic gas nozzle 10 mm	1466043	10
		Ceramic gas nozzle 11.5 mm	1466044	10
	01:21	Short torch cap	1466032	1
	01:22	Medium torch cap	1466033	1
	01:23	Long torch cap	1466034	1
		Wear parts set R-TIG 12-260 W	1466260	1








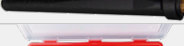

(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

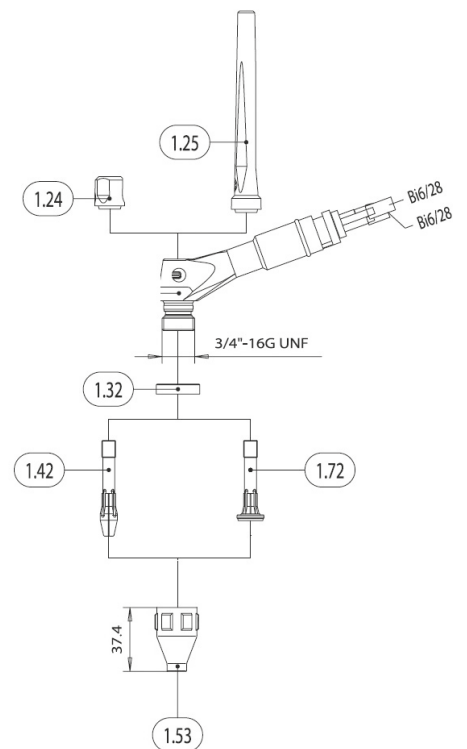
R-TIG 200 gas-cooled (for HIGH-TIG systems)

Designation	Art. no.
R-TIG 200 19 4m UD	1490034
R-TIG 200 19 8m UD	1490038

Technical data:		
Duty cycle (at 60%)	200 A (DC)	140 A (DC)
Electrode diameter	1.6 – 3.2 mm	
Specification	UD GRIP HighFlex leather	
Cooling	gas-cooled	



	No.	Designation	Art. no.	PU*
	01:42	Electrode holder 1.6 mm	1466009	5
		Electrode holder 2.4 mm	1466011	5
		Electrode holder 3.2 mm	1466012	5
		Electrode holder 4.0 mm	1466013	5
		Electrode holder 4.8 mm	1466014	5
	1.72	Gas diffuser 1,6 mm	1466025	5
		Gas diffuser 2,4 mm	1466027	5
		Gas diffuser 3,2 mm	1466028	5
		Gas diffuser 4,0 mm	1466029	5
		Gas diffuser 4,8 mm	1466030	5
	01:32	Insulator	1466008	10
	01:53	Ceramic gas nozzle 7.5 mm	1466015	10
		Ceramic gas nozzle 10 mm	1466016	10
		Ceramic gas nozzle 13 mm	1466017	10
		Ceramic gas nozzle 13 mm	1466018	10
		Ceramic gas nozzle 15 mm	1466019	10
		Ceramic gas nozzle 15 mm	1466020	10
	01:24	Short torch cap	1466006	1
	01:25	Long torch cap	1466007	1
		Wear parts set VTS R TIG 200	1490102	1





schweisskraft
EG 1

Why grind electrodes?

To prevent ignition issues and erratic arc behaviour during direct current TIG welding (DC), the electrodes should be ground to a point facing the direction of the current flow. When AC TIG welding with electrodes measuring 1.6 mm or more in diameter, one phase must be grounded in the direction of current flow to achieve a narrow arc!

The EG 1 can regrind electrodes up to 200 times, with lengths ranging from 15 mm to Ø 4.0 mm.

ELECTRODE GRINDING DEVICES



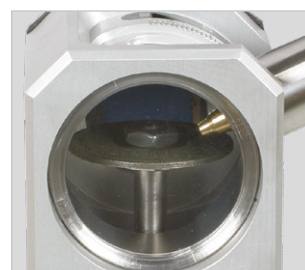
EG 1

Electrode grinder ensures the best welding results thanks to optimally ground electrodes

- ▶ Optimised for use in the workshop and during assembly
- ▶ Minimal material abrasion on the electrode of only 0.3 mm via built-in setting gauge
- ▶ The electrode can therefore be reground up to 200 times instead of just 50-100 times
- ▶ Does not anneal during the sanding process
- ▶ Integrated extraction system with P3 dust filter, providing optimum protection for the user
- ▶ Precise guidance of the electrode in a clamp holder
- ▶ Integrated suction with disposable filter element
- ▶ Infinitely variable speed regulation via adjusting wheel
- ▶ A simple adjustment allows 3 grinding levels of the diamond disc can be used, therefore three times the service life of the disc
- ▶ Electrodes with metal drops can also be ground directly, which saves time and the cancellation of the electrode
- ▶ Powerful motor with 850 watts
- ▶ Also for grinding short electrodes (up to 15 mm), e.g. for orbital welding systems



Stepless angle adjustment from 15°-180



Integrated viewing window



SCOPE OF DELIVERY:

- Drive motor
- Grinding head with filter housing and filter
- Electrode holder
- Diamond disc Ø 40mm
- Collets for electrodes 1.6/2.4/3.2 mm
- Operating tool,
- 2 x Allen keys 2/4 mm,
- 2 x open-end wrench 13-17/13-14
- Disposal bag for disposable filters
- Plastic case



Scope of delivery with case

Model	EG 1	
Art. no.	1690100	

Technical data		
Electrode Ø	mm	1.0 - 4.0
Grinding angle stepless	°	15° - 180°
Electrode length min.	mm	22
Infinitely variable speed	min ⁻¹	8000 - 22000
Diamond disc	mm	Ø 40
Motor power	W	850
Electrical connection ~50 Hz	V	230
Weight approx.	kg	3.8

ACCESSORIES

Accessories	Art. no.
Diamond disc 40 mm	1690102
Electrode holder	1690103
Collet 1.0 mm	1690105
Collet 1.6 mm	1690106
Collet 2.0 mm	1690107
Collet 2.4 mm	1690108
Collet 3.2 mm	1690109
Collet 4.0 mm	1690110
Filter cassette	1690117
Disposal bag	1690121
Switches	1690131

EG 4

Electrode grinding device for the perfect grinding of tungsten electrodes with a diameter of 1.0 to 4.0 mm

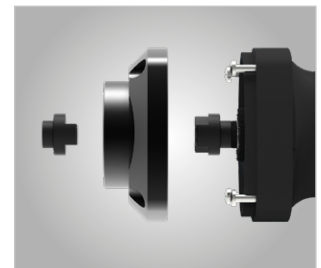
- ▶ Easy handling thanks to pre-set grinding angles and diameters
- ▶ Grinding angle 15°, 18°, 22.5° and 30° selectable
- ▶ Handy device, ideal for use in the workshop or during assembly
- ▶ Integrated 5-stage speed control via rotary wheel
- ▶ Easy to change grinding disc



Grinding and cutting options for different electrode diameters



5-stage speed control



Easy to change grinding disc

SCOPE OF DELIVERY:

- Grinding disc
- Transport case

Model		EG 4
Art. no.		1692004
Electrode diameter	mm	1.0 – 4.0
Electrode length min.	mm	30
Grinding angle	°	15 – 30
Speed	min ⁻¹	0 – 11000
Speed control		5-level
Diamond disc Ø	mm	33.5
Motor power	W	750
Electrical connection ~50 Hz	V	230
Dimensions (L x W x H) approx.	mm	340 x 76 x 76
Weight approx.	kg	1.6

ACCESSORIES



Accessories	Art. no.
① Cover cap	1692080
② Angle display	1692081
③ Grinding disc	1692082
④ Pair of carbon brushes	1692083
⑤ Switches	1692084
⑥ Transport case	1692085
⑦ Grinding wheel	1692086
⑧ Cross coupling EG4	1692087
⑨ Rotor EG	1692088

Electrode grinding device

EG 5

Electrode grinding device. Best welding results thanks to optimally ground tungsten electrodes

- ▶ For perfect grinding of tungsten electrodes with a diameter of 1.6 to 5 mm
- ▶ Grinding angle infinitely adjustable from 0 to 60 degrees

- ▶ Stop for setting the correct sanding length integrated in the device
- ▶ Precise grinding in longitudinal direction, resulting in better ignition properties, stable arc and longer service life

- ▶ Problem-free grinding even with a length of only 50 mm, spherical caps or metal drops
- ▶ Clamping also possible with work gloves thanks to smooth-running knurled screw
- ▶ Grinding dust can be easily removed via a drawer



Stop for setting the correct sanding length integrated in the device



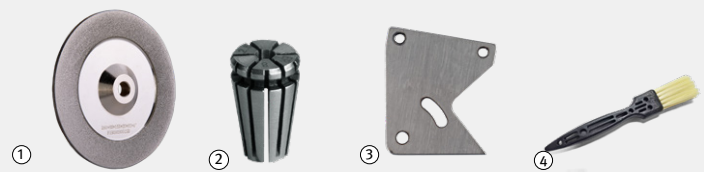
SCOPE OF DELIVERY:

- Diamond disc Ø 90mm
- One collet each 1.6 / 2.0 / 2.4 / 3.2 / 4.0 mm

Model	EG 5	
Art. no.	1692005	

Technical data		
Electrode diameter	mm	1.6 – 5.0
Electrode length min.	mm	35
Grinding angle	°	15 – 60
Speed	min ⁻¹	6500
Diamond disc Ø	mm	90
Motor power	kW	0.07
Electrical connection ~50 Hz	V	230
Dimensions (L x W x H) approx.	mm	225 x 150 x 195
Weight approx.	kg	4
Grain size		180

ACCESSORIES



Accessories	Art. no.
①Diamond disc K180	1692050
① Diamond disc K320	1692065
Electrode holder	1692051
Collet 1.6 mm	1692052
Collet 2.0 mm	1692053
②Collet 2.4 mm	1692054
Collet 3.2 mm	1692055
Collet 4.0 mm	1692056
Collet 5.0 mm	1692057
Protective glass	1692058
Main switch	1692059
Rubber foot set	1692060
Gasket	1692061
Fastening screw	1692062
Spacer disc	1692063
Adjusting nut	1692064
③Indicator	1692066
④ Cleaning brush	1692067

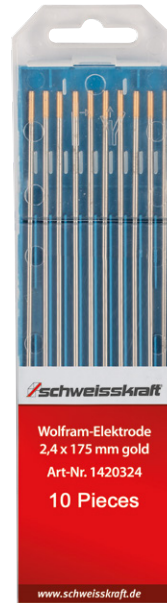
Tungsten electrodes

Tungsten electrodes - to be used for tungsten inert gas welding (TIG), plasma fusion cutting and related processes

Tungsten electrodes "WC 20" grey (thorium-free)

- ▶ Environmental compatibility: the optimum radiation-free alternative to thoriated electrodes
- ▶ Preferred use: TIG welding, plasma welding, plasma cutting, plasma spraying
- ▶ Current type: Direct current/alternating current
- ▶ recommended base materials: Rust-, acid- and heat-resistant steels, nickel and nickel alloys, refractory metals such as molybdenum, tantalum, niobium and their copper, bronze, titanium and titanium alloys, silicon-bronze alloys, silicon-bronze alloys and titanium alloys.

Size	Art. no.	PU ⁽¹⁾
1.0 x 175 mm	1420110	10
1.6 x 175 mm	1420116	10
2.4 x 175 mm	1420124	10
3.2 x 175 mm	1420132	10
4.0 x 175 mm	1420140	10



Tungsten electrodes "W" green (pure)

- ▶ Preferred use: TIG welding
- ▶ Current type: Alternating current
- ▶ recommended base materials: Aluminium and aluminium alloys, aluminium-bronze, magnesium and magnesium alloys, nickel and nickel alloys

Size	Art. no.	PU ⁽¹⁾
1.0 x 175 mm	1420210	10
1.6 x 175 mm	1420216	10
2.4 x 175 mm	1420224	10
3.2 x 175 mm	1420232	10
4.0 x 175 mm	1420240	10



Tungsten electrodes "WR 2" turquoise (mixed oxides, thorium-free)

- ▶ Special feature: Radiation-free universal electrode with excellent ignition behaviour and best load capacity values
- ▶ Current type: Direct current/alternating current
- ▶ Recommended base materials: Suitable for all base materials

Size	Art. no.	PU ⁽¹⁾
1.0 x 175 mm	1420410	10
1.6 x 175 mm	1420416	10
2.4 x 175 mm	1420424	10
3.2 x 175 mm	1420432	10
4.0 x 175 mm	1420440	10

Tungsten electrodes "WL 15" gold (1.5% lanthanum LaO₂)

- ▶ Special feature: Very good ignition properties and maximum service life
- ▶ Current type: Direct current/alternating current
- ▶ Recommended base materials: suitable for all base materials

Size	Art. no.	PU ⁽¹⁾
1.0 x 175 mm	1420310	10
1.6 x 175 mm	1420316	10
2.4 x 175 mm	1420324	10
3.2 x 175 mm	1420332	10
4.0 x 175 mm	1420340	10

(1) PU = quantity in pieces per packaging unit. Purchase only possible in PUs

Equipment familiarisation & expert training

We recommend that our customers have their welding machine commissioned and receive on-site training from our specialists.

The device familiarisation includes:

- Connection of the device supply installed at the workstation, such as mains cable, gas or compressed air (depending on device type) and individual supply, connection of torch and earth cables.
- Assembly of modular systems (e.g. power source, water cooling unit and trolley)
- Inserting the filler metal (MIG/MAG)

- Adjustment of working voltage and welding wire feed speed (MIG/MAG)
- Setting the shielding gas quantity (MIG/MAG/TIG)
- Notes on maintenance and care
- Instruction in the functions and setting options
- Duration: approx. 60 min.

The expert training programme includes

- **MIG/MAG, TIG**, manual electric or plasma cutting
- Comprehensive training on all device functions incl. practice welding
- Customised application benefits and their implementation on a sample component that you provide directly from your production facility.
- **Duration:** By individual agreement

We will be happy to assist you with any queries you may have! Our product consultants will support you with technical information. Our customers can contact us via a telephone hotline or an information email address for expert advice and solutions.

Contact:

email: beratung@schweisskraft.de
Or simply give us a call on : +49 (0) 951 96 555 - 501

Type	Art. no.
Device familiarisation	EINWSCHWEIBT
Expert training	SCHULUNGSCHEIBT

Ask us for advice and a personalised quote!





PREMIUM LASER WELDING MACHINES



Craft-Laser 800 / 1500 S / 2000 WS – Laser welding machines

Hand-held laser welding machines are the **newest revolution** in welding technology and have unbeatable advantages in the thin sheet metal sector compared to the previous conventional welding process.

ADVANTAGES LASER WELDING

compared to conventional welding processes

- + Hardly any warping, incredibly fast, incredibly good quality (even with very thin materials <1 mm)
- + Consumes approx. 70 % less energy
- + Quick and easy to learn
- + High process reliability
- + Extreme time savings with greatly reduced reworking at the same time
- + One of the lightest burners on the market at 680 g
- + 2-channel safety loop for maximum safety

CRAFT LASER ADVANTAGES:

- + Laser cleaning with up to 100 mm scan width with autofocus
- + 3 in 1 device: Welding / cutting / cleaning
- + Complete synergy - no more parameter lists
- + Service-friendly - no more tedious sending in

CRAFT-LASER 800 / 1500 S:

- ▶ Fully integrated wire feed case – no parallel entry of feed data and laser power
- ▶ Extremely simple machine operation thanks to complete synergy characteristics
- ▶ Fully automatic control of power, wire feed, oscillation width, oscillation frequency, laser frequency, PWM, hot start, etc. depending on the material, material thickness and filler material diameter.
- ▶ High-resolution, easy-to-read displays ensure maximum ease of use even from a distance
- ▶ Maximum penetration depth of up to 6 mm thanks to 20 nm single-mode laser and specially developed wobble technology
- ▶ **2 in 1 machine: Welding, cleaning**
- ▶ Perfect cleaning with up to 100 mm scan width and autofocus:
 - ▶ Ideal for derusting, paint stripping and cleaning workpieces
 - ▶ Optimal for scale removal
 - ▶ Autofocus means there is no need to maintain a fixed distance

CRAFT-LASER 2000 WS:

Water-cooled, handheld laser welding device is built for heavy-duty applications and the highest demands. Maximum focus stability at 100% duty cycle guarantees maximum process reliability.

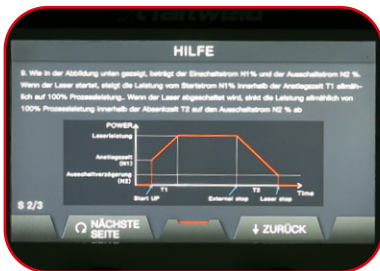
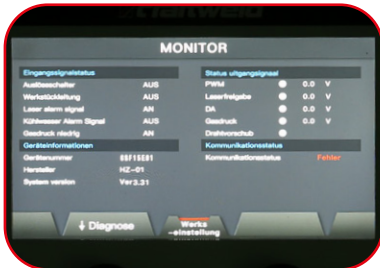
- ▶ Water-cooled 2000W - 20nm single-mode laser source with 100% duty cycle
- ▶ The specially developed water-cooled laser gun and improved optical systems guarantee maximum focus stability.
- ▶ **Programme selection via laser gun possible**
- ▶ High-performance water cooling from the laser cutting area guarantees maximum process reliability.
- ▶ **2-in-1 machine: Welding and cleaning**
 - ▶ Laser cleaning is ideal for paint removal, rust removal and other types of removal.
 - ▶ Optional Ethernet-IP interface for robot applications
 - ▶ **Optional: Double wire feed**

SECURITY:

- ▶ 2-channel emergency stop system
- ▶ 2-channel safety interface for access monitoring (door contact switch)
- ▶ Key switch to prevent unauthorised use
- ▶ 2-channel fibre breakage detection and monitored QBH connection
- ▶ Safety instructions and manual activation of the laser release at each start
- ▶ Double push-button prevents unintentional activation of the laser emission

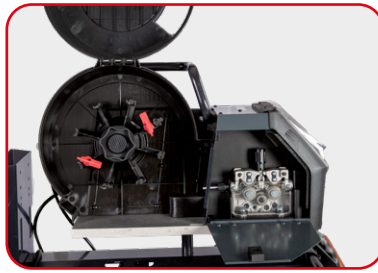
SIMPLE SERVICE:

- ▶ Replaceable burner and hosepack
- ▶ Laser cell can be replaced using swap procedure
- ▶ Interchangeable circuit boards and displays
- ▶ Laser centre offset can be corrected in the control system without calibration
- ▶ System can be upgraded and updated



DISPLAY

› In German and English



WIRE FEED CASE

› Precise wire feed with 4 rollers



HOSE PACKAGE

- › Double-sheathed hosepack and covered with additional leather protection - maximum robustness against cable breakage, wear and damage to the fibre conductor
- › Temperature stable, no problems even with aluminium despite back radiation
- › Stable wire feed, guided independently of the focus tube, ensures maximum feeding and process reliability



OPTIONAL TROLLEY

› suitable for Craft Laser 1500 S

! DISCOVER THE NEW CRAFT-LASER 2000 WS ON THE NEXT PAGE!

Craft-Laser 800 / 1500 S / 2000 WS – Laser welding machines

Hand-held laser welding machines are the **newest revolution** in welding technology and have unbeatable advantages in the thin sheet metal sector compared to the previous conventional welding process.



Craft-Laser 2000 WS

! THE CRAFT-LASER 2000 WS OFFERS ALL THE ADVANTAGES OF CRAFT-LASER 1500 S AND MUCH MORE!



HANDY WELDING GUN

- › Very light and handy
- › Ergonomic handle shell
- › Rubberised handle ensures comfortable handling and insulation against workpiece conduction, long service life and scratch resistance
- › Easy replacement of the lenses if required. These are located under the flap in the gun and can be replaced without tools.
- › Protected from dirt by cover flap - protective glass and focus lenses can be replaced

SCOPE OF DELIVERY

	800	1500 S	2000 S
Welding gun	x	x	x
Gas hose 4 m	x	x	x
5 protective glasses for laser welding gun	x	x	x
2 conveyor rollers 0.8 / 1.0 V-groove	x	x	x
2 conveyor rollers 1.0 / 1.2 V-groove	x	x	x
2 conveyor rollers 1.2 / 1.6 V-groove		x	x
2 conveyor rollers 0.8 / 1.0 U-groove	x	x	x
2 conveyor rollers 1.0 / 1.2 U-groove	x	x	x
2 conveyor rollers 1.2 / 1.6 U-groove		x	x
3 nozzles AS-12 for laser welding gun		x	x
3 nozzles ES-12 for laser welding gun		x	x
3 nozzles DS-16 for laser welding gun	x		x
3 nozzles BS-16 for laser welding gun		x	x
3 cutting nozzles	x	x	x
Laser cleaning accessories	x	x	x
Filter pressure regulator 1/4" 16 bar	x	x	x
Plug nipple 1/4" external thread	x	x	x
Double nipple G 1/4" x G 1/4"	x	x	x
Faceshield FS 1 (golden visor)	x		
VarioProtect LASER-M laser welding helmet		x	x



WEAR PARTS SET

- › included with Craft Laser 800, 1500 S, and 2000 WS



Craft-Laser 800

MODEL DESIGNATION

	CRAFT-LASER 800	CRAFT-LASER 1500 S	CRAFT-LASER 2000WS
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Article no.	1390008	1390015.2	1390020
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WELDABLE MATERIAL THICKNESS

Weldable material thickness Steel	0.8 – 3.0 mm	0.8 – 6.0 mm	0.8 – 8.0 mm
Weldable material thickness Stainless steel	0.8 – 3.0 mm	0.8 – 6.0 mm	0.8 – 8.0 mm
Weldable material thickness Aluminium	0.8 – 2.0 mm	0.8 – 4.0 mm	0.8 – 7.0 mm

WIRE FEED

Weldable wires, steel	0.8 – 1.2 mm	0.6 – 1.6 mm	0.6 – 1.6 mm
Weldable wires, stainless steel	0.6 – 1.2 mm	0.6 – 1.6 mm	0.6 – 1.6 mm
Weldable wires, aluminium	1.0 – 1.2 mm	1.0 – 1.6 mm	1.0 – 1.6 mm
Wire feed unit	4 rolls	4 rolls	4 rolls
Wire feed speed	0.25 – 6 m/min	0.25 – 6 m/min	0.25 – 6 m/min

LASER

Wobble	0 – 5.0 mm	0 – 5.0 mm	0 – 5.0 mm
Wavelength of the radiation	1070 nm	1075 nm	1080 nm
Spectral width	3 – 4 nm	3 – 4 nm	3 – 4 nm
Power of the red guide laser	200 µW	200 µW	200 µW
Type	Single mode	Single mode	Single mode

ELECTRICAL CONNECTION

Connection cable length	5.0 m	5.0 m	10.0 m
Input power	3.0 kW	5.9 kW	7.5 kW
Laser power	800 W	1500 W	2000 W

COOLING

Cooling type	Air-cooled	Air-cooled	water-cooled
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STANDARDS AND APPROVALS

Protection class	IP21S	IP21S	IP21S
WPS	✓		✓

ELECTRICAL DATA

Connection voltage	230V	230 V – 32 A CEE	230 V – 32 A CEE
Mains frequency	50 Hz	50 Hz	50 Hz

DIMENSIONS AND WEIGHTS

Dimensions (L x W x H) approx.	680 x 360 x 680	750 x 600 x 1000 mm	960 x 600 x 1000 mm
Weight of wire feed case	–	11.5 kg	11.5 kg
Weight approx.	38 kg	53 kg	150 kg

Laser protection cabin 3850 x 3900 x 2500 mm / 4000 x 4050 x 3000 mm / 6125 x 4050 x 3000 mm

- ▶ Made from powder-coated sheet steel (RAL 7035)
- ▶ Self-supporting, stable construction for long-lasting use
- ▶ Manufactured in modular design - simple and quick assembly
- ▶ Compatible with hand-held and stationary laser welding machines
- ▶ Effective heat dissipation from the laser welding cabin prevents overheating
- ▶ Large, smooth-running sliding door requires no swivelling range

- ▶ Increased productivity thanks to the ability to store raw and finished parts in the cabin

Model 4000 x 4050 x 3000 mm & Model 6125 x 4050 x 3000 mm

- ▶ Better material flow, as the cabins can be accessed with pallet trucks, trolleys and even smaller forklifts



Made in Germany



3850 x 3900 x 2500 mm



4000 x 4050 x 3000 mm



6125 x 4050 x 3000 mm

Incl. safety package incl. complete CE for Craft-Laser 800 / 1500S

Security package contains the following components:

- ▶ Switch cabinet with discrete PILZ safety relay for monitoring the protective circuits
- ▶ Contactless door contact switches from PILZ
- ▶ External emergency stop
- ▶ Internal emergency stop
- ▶ Laser warning light

Would you like advice?

Your local specialist dealer will be happy to advise you on all matters. We would be happy to advise you on this topic and refer you to a specialist dealer in your area.



Tim Bülles
Contact: +49(0)951 96555 425

YOUR PERSONALISED PRICE AND special sizes on request!

Accessories	Art. no.
Extraction package for laser safety cabin 1 - 3	1392050

Model		3850 x 3900 x 2500 mm	4000 x 4050 x 3000 mm	6125 x 4050 x 3000 mm
Article no.		1392000	1392005	1392010
Dimensions (L x W x H) approx.	mm	3850 x 3900 x 2500	4000 x 4050 x 3000	6125 x 4050 x 3000
Transport surcharge ²⁾		TVZSLASER	TVZSLASER	TVZSLASER

VarioProtect LASER-M / LASER-M AIR TH3 – Laser welding helmet specially developed for laser welding and cutting applications – also suitable for conventional welding processes

- ▶ Laser lens with variable tinting offers complete protection from direct laser exposure as well as from reflection, scattering, diffraction and divergence of the laser beam
- ▶ Developed for EN207 OD10 @ 1064nm
- ▶ Provides comprehensive protection to prevent

- eye burns, retinal damage and other tissue damage
- ▶ Ultra-clear vision - exceptional clarity and detail with Light State 2.0 laser lens with variable tinting
- ▶ Intelligent adjustment - number of colours,

- delay and sensitivity can be easily adjusted via user-friendly control panel with LED indicators
- ▶ Respiratory protection with a total filtration efficiency of >99.997%



VarioProtect LASER-M



MIG/MAG

TIG inverter

Electrode inverter



Laser welding



Plasma cutters



VarioProtect LASER-M AIR TH3

Electrochemical processing

Model		VarioProtect LASER-M VarioProtect LASER-M AIR TH3
Article number		1657060 / 1657065
Working temperature	°C	-10 – +55
Storage temperature	°C	-20 – +70
Response timelight/dark	ms	1 / 25000s
UV/IR protection		DIN 16
Light level		2.0
Dark protection level		DIN 4-8/8-12
Solar cells		Yes
Viewing window (W x H)	mm	96 x 46.5
Cassette (L x B x H)	mm	110 x 90 x 9
Sensors		2
Laser protection		1000-1100 D LB7 + IR LB8
Optical density		1000-1100 OD8
Special modes		GRIND / CUT / MIX / DARK
Dimensions (L x W x H) approx.	mm	270 x 230 x 215
Weight approx.	kg	0.87

Intelligent setting

- The number of colours, delay and sensitivity can be easily adjusted via a user-friendly control panel with LED displays

Scope of delivery

- ▶ TH3 fresh air supply incl. hose

Accessories	Art. no.	€ plus VAT
Outer attachment disc (PU 10 pcs.)	1663050	19.90
Inner attachment disc (PU 10 pcs.)	1663051	15.00
Headband	1663052	26.50
Forehead sweatband	1663053	2.50
Welding helmet housing	1663054	145.00
Filter cassette	1663055	459.00
Lithium battery 3V CR2450	1662034	459.00

Welding accessories

Face Shield FS 1 –

The safe and comfortable complete solution for eyes and face during hand-held laser welding



- ▶ The Face Shield (FS1) offers certified laser protection in accordance with EN 207
- ▶ New standards in wearing comfort
- ▶ only 386 g total weight
- ▶ Perfectly balanced thanks to an ingenious folding mechanism with spring-loaded coupling rods
- ▶ Height and width-adjustable headrest with Uvex Spiderneck neck support for perfect ergonomic relief

uvex | laservision

Model		FS 1 (golden visor)	FS 1 (blue-grey visor)
Art. no.		1872015	1872020
Standards		EN 166, EN 207 full protection	EN 166, EN 169, EN 207 full protection, EN 208 adjustment protection
Coating		Scratch-resistant outside / anti-fog inside	Scratch-resistant outside / anti-fog inside
Filters			
Colour view		Good	Outstanding
Version		FS1	FS1
Filters		P1P18	P1P22
Filter thickness approx.	mm	2	2
Filter colour		Gold	Blue-grey
Filter material		Plastic	Plastic
Filter technology		Absorption filter	Absorption filter
Visual brightness		very good	Sufficient
Protected area		Infrared, near infrared, ultra-violet	Infrared, near Infrared, visible, ultraviolet
VLT approx.	%	47	12
Protection level		M	M
Weight approx.	g	386	386



Laser safety goggles LSB 1 - Large field of vision without compromising protection

- ▶ Ergonomic design and adjustable temples for every head shape
- ▶ Flat temples for wearing under safety helmets
- ▶ Lightweight construction for a comfortable fit
- ▶ Thanks to the special anti-fog coating, visibility remains clear even in high humidity and changing temperature conditions



Technical data		LSB 1
Art. no.		1872050
Protection of the wavelength	nm	200-450 / 630-660 / 800-1100
Material		TR90 frame, PC filter
Permeability	%	18
Optical density		200 - 450nm OD 4+ 630 - 660nm OD 4+ 800 - 1.100nm OD 6+
LB protection level		316 - 440nm D LB5 + IR LB6 440 - 450nm DIR LB4 630 - 660nm DIR LB4 800 - 1080nm DIR LB6 LP S CE
Dimensions (L x W x H) approx.	mm	161 x 156 x 49
Weight approx.	g	40.2

Scope of delivery



PROFESSIONAL INVERTERS ELECTRODE WELDING MACHINES



Power
Factor
Correction

- ▶ PFC is an electrical or electronic circuit that increases the so-called power factor



Generator
Friendly

- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers



Multivoltage
Einsatz
weltweit

- ▶ Regulates the voltage from 110 V - 230 V



Voltage
Reduction
Device

- ▶ Voltage reduction in no-load operation

Electrode inverter

easystick® 141 / 161

230 volt electrode inverter in standard design

- ▶ All appliances are built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- ▶ **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems



Info & Video



OPERATION

- ① Operation indicator light
- ② Temperature control lamp
- ③ Rotary knob for welding current preselection



TECHNICAL DATA:

Model		EASY-STICK 141	EASY-STICK 161
Art. no.		1073014	1073016
Technical data:			
Circuit board		unsealed	unsealed
Weldable electrode Ø	mm	1.6 – 3.2	1.6 – 4.0
Setting range	A	10 – 140	10 – 160
Sheet thicknesses	mm	1.0 – 4.0	1.0 – 6.0
Power consumption	A	36.6	36.5
Slow-blow fuse	A	16	16
No-load voltage	V	77.4	69.9
Electrode duty cycle at I _{max}	%	15	25
Electrode Welding current at ED = 100%	A	55	80
Protection class		IP21S	IP21S
Insulation class		H	H
Working temperature	°C	-10~40	-10~40
Electrode power consumption	kVA	4.5	5
Required generator output	kVA	>8.4	>8.4k
Overall performance	kVA	8.4	8.4
Mains plug	A	16	16
Electrical connection ~50 Hz AC	V	230	230
Dimensions (L x W x H) approx.	mm	320 x 135 x 255	320 x 135 x 255
Weight approx.	kg	4.3	4.4
Standard		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m with electrode holder
- Ground cable 16mm²/3m



See our capabilities for yourself and request a personal consultation!



Contact: +49 (0) 951 96 555-501
beratung@schweisskraft.de

ACCESSORIES



①



②



③



④



⑤

ACCESSORIES

	Art. no.
① Transport case	1174050
② Ground cable 4m complete with earth clamp 16 mm ² , KS 25/9 mm, clamp 200 A	1250215
② Ground cable 4m complete with earth clamp 25 mm ² , KS 25/9 mm, clamp 200 A	1250224
③ Welding cable 5 m assembled 25 mm ² /10-25mm ² /9 mm spigot/M8	1250227
④ Welding cable 4 m with electrode holder 16 mm ² KS25/9 mm, electrode holder 260 A	1250353
⑤ Welding site equipment 25 mm ² ; KS 50/Pratica 1/earth clamp 200 A comprises: Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	1240445

Electrode inverter

craftstick® 161

230 volt electrode inverter in standard design with sealed circuit board

- ▶ Built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- ▶ Suitable for use on generators, e.g. in workshops, harbours, chemical plants, schools, metal construction, on building sites, ships or for farmers
- ▶ **Sealed circuit board protects against moisture, salt spray and corrosion, making it also suitable for offshore use**
- ▶ **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- ▶ **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- ▶ Longer duty cycle than the EASY-STICKseries



Generator Friendly



OPERATION

- 1 Operation indicator light
- 2 Temperature control lamp
- 3 Rotary knob for welding current preselection



TECHNICAL DATA:

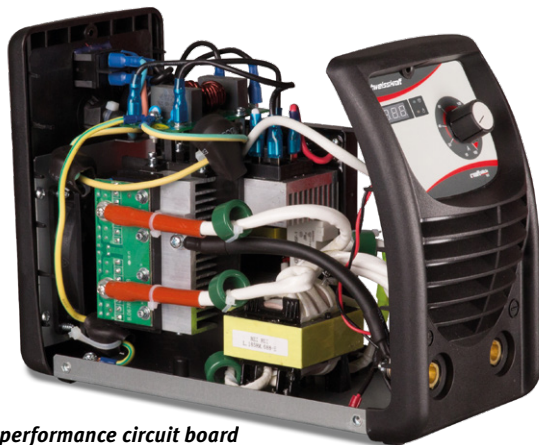
Model		CRAFT-STICK 161
Art. no.		1073161
Technical data:		
Circuit board		sealed
Weldable electrode Ø	mm	1.6 – 4.0
Setting range	A	10 – 160
Sheet thicknesses	mm	1.0 – 6.0
Power consumption	A	36.5
Slow-blow fuse	A	16
No-load voltage	V	75.3
Duty cycle at I _{max.} [40°C] Electrode	%	40
Welding current at 100% duty cycle [40°C]	A	90
Electrode		
Protection class	IP	21S
Insulation class		H
Working temperature	°C	-10~40
Electrode power consumption	kVA	5.2
Required generator output	kVA	>8.7
Overall performance	kVA	8.7
Mains plug	A	16
Electrical connection ~50 Hz	V	230
Dimensions (L x W x H) approx.	mm	320 x 135 x 255
Weight approx.	kg	4.9
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

Welding force systems bear the **S mark** and comply with standard EN 60 974-1; -10.

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m with electrode holder
- Ground cable 16mm²/3m



Sealed high-performance circuit board

See our capabilities for yourself and request a personal consultation!

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beratung@schweisskraft.de



ACCESSORIES



①



②



③



④



⑤

ACCESSORIES

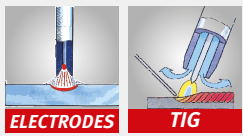
	Art. no.
① Transport case	1174050
② Ground cable 4m complete with earth clamp 16 mm ² , KS 25/9 mm, clamp 200 A	1250215
② Ground cable 4m complete with earth clamp 25 mm ² , KS 25/9 mm, clamp 200 A	1250224
③ Welding cable 5 m assembled 25 mm ² /10-25mm ² /9 mm spigot/M8	1250227
④ Welding cable 4 m with electrode holder 16 mm ² KS25/9 mm, electrode holder 260 A	1250353
⑤ Welding site equipment 25 mm ² ; KS 50/Pratica 1/earth clamp 200 A comprises: Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	1240445

Electrode inverter

craftstick® 161 P / 201 P

Robust 230 V electrode inverter with sealed circuit board for professional use

- ▶ Built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 23 also generally suitable for outdoor work
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **Sealed circuit board protects against moisture, salt spray and corrosion, making it also suitable for offshore use**
- ▶ **Working with PFC:** this enables use on generators
- ▶ **VRD** (voltage reduction in no-load operation) equipped
- ▶ TIG welding with Lift-Arc ignition
- ▶ TIG DC function = enables simple TIG welding with contact ignition
- ▶ Precise setting of welding parameters via digital display
- ▶ Universally applicable for welding all common electrode types
- ▶ The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- ▶ Consistent deposition rate is achieved through constant welding current
- ▶ At least 30% duty cycle for all devices
- ▶ **All CRAFT-STICKs have the following functions as standard:**
- ▶ **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- ▶ **Anti-stick** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely.
- ▶ This stabilises the arc and the electrode can be processed without any problems



Power Factor Correction

▶ PFC is an electrical or electronic circuit that increases the so-called power factor

Generator Friendly

PROTEC 440V 440V Tested in production 220V

VRD safe



Always the right wave for your task:

AC triangle wave welding output:

- ▶ Reduced heat input for the same current setting. Particularly useful for welding thin metal

Alternating current sine wave welding output:

- ▶ Traditional AC TIG welding waveform. Quieter, "soft" arc characteristics

AC square wave:

- ▶ Focussed arc for maximum penetration, fast welding speed with optimum directional control

OPERATION

- 1 Digital display
- 2 Operation indicator light (green)
- 3 Temperature indicator light (yellow)
- 4 E-hand



- 5 VRD = voltage reduction in no-load operation
- 6 TIG DC - function
- 7 Select button
- 8 Rotary knob for welding current preselection

TECHNICAL DATA:

Model		CRAFT-STICK 161 P	CRAFT-STICK 201 P
Art. no.		1073162	1073201
Technical data:			
Circuit board		sealed	sealed
Weldable electrode Ø	mm	1.6 – 4.0	1.6 – 4.0
Setting range for electrode	A	10 – 160	10 – 200
Setting range for TIG DC	A	10 – 160	10 – 200
Sheet thicknesses	mm	1.0 – 8.0	1.0 – 10.0
Power consumption	A	MMA 22.1 / TIG 14.7	MMA 28.8 / TIG 19.5
Slow-blow fuse	A	16	16
No-load voltage	V	MMA 70.6 / TIG 65.6	MMA 68.7 / TIG 65.3
Duty cycle at I _{max.} [40°C] TIG DC	%	30	40
Duty cycle at I _{max.} [40°C] Electrode	%	30	40
Welding current at 100% duty cycle [40°C] TIG DC	A	90	130
Welding current at 100% duty cycle [40°C] Electrode	A	90	130
Protection class		IP21S	IP21S
Insulation class		H	H
Working temperature	°C	-10~40	-10~40
Power consumption TIG DC	kVA	3.4	4.5
Electrode power consumption	kVA	5.1	6.6
Required generator output	kVA	>5.1	>6.6
Overall performance	kVA	5.1 / 3.4	6.6 / 4.5
Mains plug	A	16	16
Electrical connection ~50 Hz	V	230	230
Dimensions (L x W x H) approx.	mm	365 x 150 x 280	365 x 150 x 280
Weight approx.	kg	6.7	6.7
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

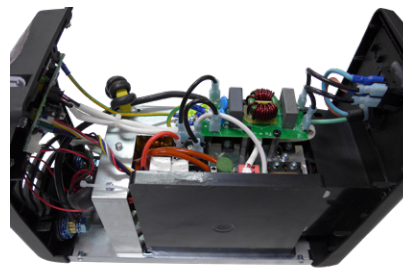
Info & Video



1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m
- Ground cable 16mm²/3m



Sealed high-performance circuit board

ACCESSORIES



ACCESSORY CRAFT-STICK 161 P	Art. no.
TIG torch	
① WP17V ED 4m with gas regulator	1461745
ACCESSORY CRAFT-STICK 201 P	
TIG torch	
WP 26 V/4 m with gas regulator	1462614
ACCESSORIES	
② Transport case	1174050
③ Pressure reducer Argon/CO.	1700050
Ground cable 4m 25mm ² , KS50/13mm, clamp 200A	1250225
Ground cable 4m 35mm ² , KS50/13mm, clamp 400A	1250235
Welding cable 4 m 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
Welding cable 4 m 35 mm ² , KS50/13 mm, electrode holder 400 A	1250362
④ Welding site equipment 25 mm ²	1240445
comprises:	
Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	
⑤ Wear parts set	1100152
comprises:	
1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	

Electrode inverter

craftstick® 253

400 volt electrode inverter in standard version with sealed circuit board

- ▶ Built using modern inverter technology
- ▶ Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **The sealed circuit board provides protection against moisture, salt spray and corrosion, making it ideal for use offshore.**
- ▶ TIG welding with Lift-Arc ignition
- ▶ **Hot Start:** Increasing the welding current briefly causes the arc to ignite reliably and become stable immediately
- ▶ Adjustable hot start and arc force
- ▶ **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- ▶ With TIG DC Liftarc ignition
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- ▶ **VRD (Volt Reduction Device):** Voltage reduction in no-load operation



OPERATION

1 Digital display

2 Operation indicator light

3 Temperature control lamp

4 MMA selection button, MMA VRD, Lift-Arc

5 Rotary knob for welding current preselection

6 Rotary control for "Hot Start" setting

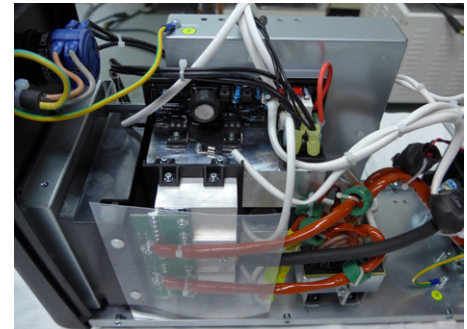
7 Rotary control for "Arc Force" setting



TECHNICAL DATA:

Model		CRAFT-STICK 253
Art. no.		1073253
Technical data:		
Circuit board		sealed
Weldable electrode Ø	mm	1.6 – 5.0
Setting range for electrode	A	20 – 250
Setting range for TIG DC	A	20 – 250
Sheet thicknesses	mm	1.0 – 10.0
Power consumption	A	MMA 17.7 / TIG 13.1
Slow-blow fuse	A	16
No-load voltage	V	MMA 70.1 / TIG 69.4
Duty cycle at I _{max.} [40°C] TIG DC	%	60
Duty cycle at I _{max.} [40°C] Electrode	%	60
Welding current at 100% duty cycle [40°C] TIG DC	A	200
Welding current at 100% duty cycle [40°C] Electrode	A	200
Protection class		IP21S
Insulation class		H
Working temperature	°C	-10~40
Power consumption TIG DC	kVA	6.3
Electrode power consumption	kVA	8.5
Required generator output	kVA	>10
Overall performance	kVA	10 / 7.4
Mains frequency	Hz	50/60
Electrical connection ~50 Hz	V	400 ±10%
Dimensions (L x W x H) approx.	mm	495 x 190 x 350
Weight approx.	kg	12
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.



Sealed high-performance circuit board

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m
- Ground cable 16mm²/3m



ACCESSORIES



ACCESSORIES

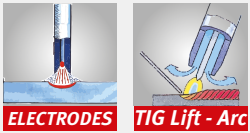
① TIG welding torch, gas-cooled WP 26 V / 4 m	1462614
② Pressure reducer Argon/CO ₂	1700050
③ Welding cable 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
③ Welding cable 35 mm ² , KS50/13 mm, electrode holder 400 A	1250362
④ Ground cable 4m complete with earth clamp 25 mm ² , KS50/13 mm, clamp 200 A	1250225
④ Ground cable 4m complete with earth clamp 35 mm ² , KS50/13 mm, clamp 400 A	1250235
⑤ Welding site equipment SPA 35 mm ²	1240450
comprises:	
5 metres PVC welding cable with electrode holder and welding cable plug, 3 metres PVC ground cable with earth clamp and welding cable plug, slag hammer, wire brush, polypropylene hand shield (CE), welding glass DIN 9, attachment glass 90 x 110 mm, 5-finger gloves	
⑥ Wear parts set	1100152
comprises:	
1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	

Electrode inverter

craftstick® 403 CEL

400 volt electrode inverter for industrial use, suitable for cellulose electrodes

- ▶ State-of-the-art inverter technology
- ▶ TIG welding with Lift-Arc ignition
- ▶ Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- ▶ **Hot Start:** Increasing the welding current briefly causes the arc to ignite reliably and become stable immediately
- ▶ **Anti Stick:** If the electrode accidentally sticks, the welding current is automatically reduced to prevent the electrode from annealing
- ▶ Suitable for cellulose electrodes
- ▶ **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- ▶ **VRD (Volt Reduction Device):** Voltage reduction in no-load operation



Control cable plug for manual remote control

OPERATION

- ① Display for welding current and other parameters
- ② Rotary knob for setting the welding current
- ③ Rotary knob for hot start control
- ④ Rotary knob for Arc Force control

- ⑤ Selection button for electrode, TIG or VRD with display
- ⑥ Warning light for overvoltage, overcurrent or overheating
- ⑦ Operating status display

TECHNICAL DATA:

Model	CRAFT-STICK 403 CEL	
Art. no.	1073403	
Weldable electrode Ø	mm	1.6 – 8.0
Setting range for electrode	A	20 – 400
TIG setting range	A	20 – 400
Duty cycle at I _{max.} [40°C] Electrode	%	60
Duty cycle at I _{max.} [40°C] TIG	%	60
Welding current at 100% duty cycle [40°C] Electrode	A	310
Welding current at 100% duty cycle [40°C] TIG	A	310
Protection class	IP21S	
Electrode power consumption	kVA	16.4
Power consumption TIG	kVA	12.4
Total power consumption	A	32.3 / 25.1
Required generator output	kVA	>22.4
Electrical connection ~50 Hz	V	400
Dimensions (L x W x H) approx.	mm	560 x 240 x 440
Weight approx.	kg	21.7
Standard	DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 50 mm² /3m with electrode holder 500 A
- Ground cable 50 mm²/3m with earth clamp 500 A



ACCESSORIES



ACCESSORIES

① TIG welding torch, gas-cooled WP 26 V/4m	1462614
② Pressure reducer Argon/CO ₂	1700050
③ Welding cable 25 mm ² , KS50/13 mm, electrode holder 260 A	1250361
③ Welding cable 35 mm ² , KS50/13 mm, electrode holder 400 A	1250362
④ Ground cable 4m complete with earth clamp 25 mm ² , KS50/13 mm, clamp 200 A	1250225
④ Ground cable 4m complete with earth clamp 35 mm ² , KS50/13 mm, clamp 400 A	1250235
⑤ Handheld remote control with 10m connection cable	1174011
⑥ Welding site equipment SPA 35 mm ²	1240450
comprises:	
5 metres PVC welding cable with electrode holder and welding cable plug, 3 metres PVC ground cable with earth clamp and welding cable plug, slag hammer, wire brush, polypropylene hand shield (CE), welding glass DIN 9, attachment glass 90 x 110 mm, 5-finger gloves	
⑦ Wear parts set	1100152
comprises:	
1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	

SCHWEISSER-PRÜFUNGSBESCHEINIGUNG NACH DIN EN ISO 9606-1:2017-12

Beispiel einer Bezeichnung nach Norm

ISO 9606-1 **141** **T** **BW** **FM4** **S** **s3.6 D60** **PH** **ss nb**

Norm

Produktform

Schweißzusatzart

Schweißnahteinheiten

Schweißprozess

Nahtart

Schweiß-
zusatzgruppe

Abmessung
des Prüfstücks

Prüfposition

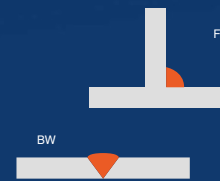
Schweißprozesse

Ordnungsnummern nach DIN EN ISO 4063

- 111 Lichtbogenhandschweißen
- 114 Metall-Lichtbogenschweißen mit Fülldrahtelektrode ohne Schutzgas
- 121 Unterpulverschweißen mit Massivdrahtelektrode
- 125 Unterpulverschweißen mit Fülldrahtelektrode
- 131 Metall-Inertgasschweißen mit Massivdrahtelektrode
- 135 Metall-Aktivgasschweißen mit Massivdrahtelektrode
- 136 Metall-Aktivgasschweißen mit schweißpulvergefüllter Drahtelektrode
- 138 Metall-Aktivgasschweißen mit metallpulvergefüllter Drahtelektrode
- 141 Wolfram-Inertgasschweißen mit Massivdraht- oder Massivabzusatz
- 142 Wolfram-Inertgasschweißen ohne Schweißzusatz
- 143 Wolfram-Inertgasschweißen mit Fülldraht- oder Füllstabzusatz
- 145 Wolfram-Inertgasschweißen mit reduzierenden Gasanteilen im ansonsten inerten Schutzgas und Massivdraht- oder Massivstabzusatz
- 15 Plasmaschweißen
- 311 Gasschweißen mit Sauerstoff-Acetylen-Flamme

Nahtarten

- BW Stumpfnah (butt weld)
- FW Kehlnah (fillet weld)



Prüfposition

Gemäß DIN EN ISO 6947

- PA Wannenposition
- PB Horizontalposition
- PC Querposition
- PD Horizontal-Überkopposition
- PE Überkopposition
- PF Steigposition
- PG Fallposition
- H-L045 Steigposition
- J-L045 Fallposition
- PH Steigenschweißen
- PJ Fallendenschweißen

Schweißnahteinheiten

- Stumpfnähte**
- ss einseitiges Schweißen
 - mb Schweißen mit Schweißbadsicherung
 - nb Schweißen ohne Schweißbadsicherung
 - gb Gaswurzelerschutz
 - fsa Schweißpulverstützung
 - bs beidseitiges Schweißen
 - ci Schweißzusatz Einlagerung
- Kehlnähte**
- al einseitig
 - ml mehrlagig
- Gasschweißen mit Sauerstoff-Acetylen-Flamme**
- lw nach links Schweißen
 - rw nach rechts Schweißen

Produktformen

- T Rohr (tube)
- P Blech (plate)



Schweißzusatzart

Umhüllte Elektroden

- Route A, Europa
- A sauer umhüllt
 - B basisch umhüllt oder basische Fülldrahtelektrode
 - C zelluloseumhüllt
 - R rutlumhüllt oder rutile Fülldrahtelektrode – langsam erstarrende Schlacke
 - RA rutilsauer umhüllt
 - RB rutilbasisch umhüllt
 - RC rutilizelluloseumhüllt
 - RR diok rutlumhüllt
- Route B, Pazifikraum
- 03 rutilbasisch umhüllt
 - 10 zelluloseumhüllt
 - 11 zelluloseumhüllt
 - 12 rutlumhüllt
 - 13 rutlumhüllt
 - 14 rutl- und eisenpulverumhüllt
 - 15 basisch umhüllt
 - 16 basisch umhüllt
 - 18 basisch und eisenpulverumhüllt
 - 19 limenitumhüllt
 - 20 eisenoxidumhüllt
 - 24 rutl- und eisenpulverumhüllt
 - 27 eisenoxid- und eisenpulverumhüllt
 - 28 basisch und eisenpulverumhüllt
 - 45 basisch umhüllt
 - 48 basisch umhüllt

Fülldrähte

- M Metallpulver-Fülldrahtelektrode
- P rutile Fülldrahtelektrode – schnell erstarrende Schlacke
- V Fülldrahtelektrode – rutil oder basisch/fluorid
- W Fülldrahtelektrode – basisch/fluorid, langsam erstarrende Schlacke
- Y Fülldrahtelektrode – basisch/fluorid, schnell erstarrende Schlacke
- Z Fülldrahtelektrode – andere Arten

Alle weiteren

- S Massivdrahtelektrode/-stab
- nm kein Zusatzwerkstoff

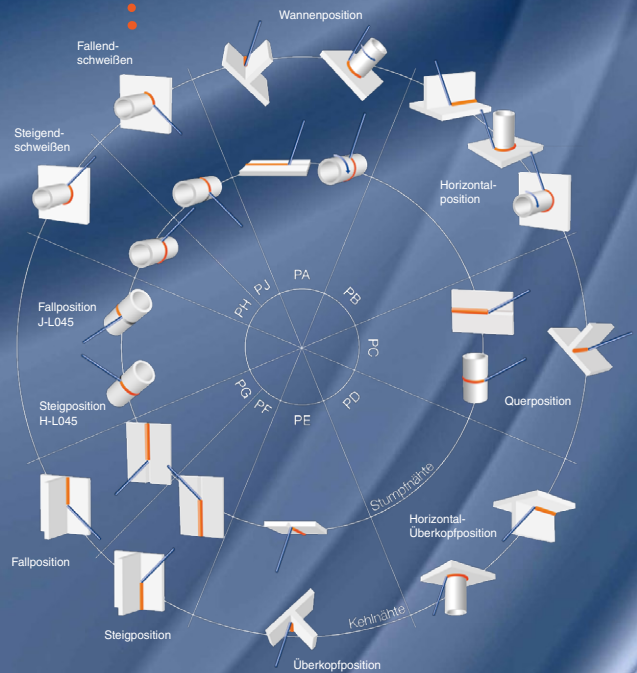
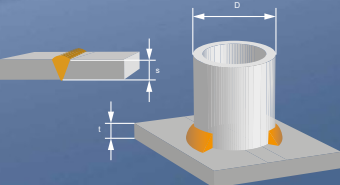
Schweißzusatzgruppeneinteilung

Gruppe	Schweißzusatz zum Schweißen von	Beispiele anwendbarer Normen*
FM1	unlegierte Stähle und Feinkornstähle	ISO 2580, ISO 14341, ISO 636, ISO 14171, ISO 17632, ISO 20378
FM2	hochfeste Stähle	ISO 18275, ISO 16834, ISO 26304, ISO 18276
FM3	warmfeste Stähle Cr < 3,75 %	ISO 3580, ISO 21952, ISO 24598, ISO 17634, ISO 20378
FM4	warmfeste Stähle 3,75 < Cr ≤ 12 %	ISO 3580, ISO 21952, ISO 24598, ISO 17634
FM5	nichtrostende und hitzebeständige Stähle	ISO 3581, ISO 14343, ISO 17633
FM6	Nickel und Nickellegierungen	ISO 14172, ISO 18274

* In Deutschland sind die entsprechenden nationalen Normen zu verwenden, hierzu wird auf das Nationale Vorwort der Norm verwiesen.

Abmessungen des Prüfstücks

- s Beschreibt die Schweißgutdicke
- t Beschreibt die Werkstoffdicke
- D Beschreibt den äußeren Durchmesser



www.dvs-perszert.de

Benannte Prüfstellen für Schweißerprüfungen sind Stellen, die nach europäischen Richtlinien oder Rechtsvorschriften zur Personalzertifizierung zugelassen sind oder über eine Akkreditierung nach DIN EN ISO/IEC 17024 für die Durchführung von Schweißerprüfungen verfügen.



PLASMA CUTTERS



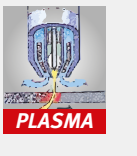
Plasma cutters

Series **craftcut**[®]

Compact, economical and powerful plasma cutting devices for professional continuous use

- ▶ For stainless steel, aluminium, steel, non-ferrous metals, also with painted surfaces
- ▶ From thin sheets to heavy plates
- ▶ Suitable for use on generators, e.g. in workshops, harbours, chemical plants, schools, metal construction, on building sites, ships or for farmers

- ▶ Pilot ARC controller: The set welding current is only released after the arc has been ignited
- ▶ Filter pressure regulator with plug nipple



Equipment	Craft-CUT 41	Craft-CUT 41P	Craft-CUT 63	Craft-CUT 123 CNC
LCD display			✓	✓
Pilot ARC controller	✓	✓	✓	✓
PFC operation		✓		
CNC interface				✓
Trafimector connection			✓	✓



CRAFT-CUT 41P

- ▶ Power factor correction PFC also enables use on cable reels

CRAFT-CUT 63

- ▶ With pressure reducer

CRAFT-CUT 123 CNC

- ▶ CNC interface for machine connection

Includes plasma torch S65
(Craft-CUT 41/ Craft-CUT 41P)



Including Pluscut plasma torch
(from Craft-CUT 63)



OPERATION

- 1 Digital display Amperage
- 2 Digital pressure display
- 3 Operation indicator light (green)
- 4 Temperature indicator light (yellow)



- 5 Lack of air display
- 6 Working lamp for plasma cutter connection
- 7 Cutting current controller
- 8 RUN/SET switch: RUN for start of cut; SET for gas test

TECHNICAL DATA:

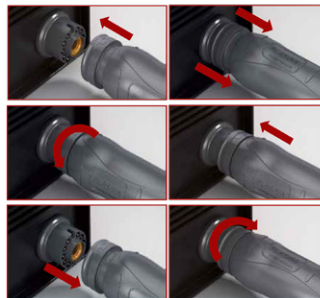
Model		CRAFT-CUT 41P	CRAFT-CUT 63	CRAFT-CUT 123 CNC
Art. no.		1075042	1075064	1075124
Technical data				
Quality cut steel (ST37)	mm	15	25	45
Stainless steel quality cut	mm	15	25	45
Aluminium quality cut	mm	14	20	30
Steel separating cut (ST37)	mm	20	30	50
Stainless steel separating cut	mm	20	30	50
Aluminium separating cut	mm	16	22	35
Power consumption	A	110V: 36.5 / 230V: 21.8	16.1	33.2
Plasma duty cycle	%	60	90	60
Plasma setting range	A	40	20 – 65	20 – 120
Welding current at 100% duty cycle [40°C] Plasma	A	30	61	100
Power consumption plasma	kVA	4.8	6.1	13.8
Voltage at ON time 100% duty cycle [40°C] Plasma	V	92	104	120
Air requirement	l/min	120	140	200
Operating pressure	bar	5	5	5
No-load voltage	V	320	450	420
Insulation class		H	H	H
Overall performance	kVA	110V: 4.0 / 230V:5.0	9.1	18.8
Electrical connection ~50 Hz	V	230	400	400
Dimensions (L x W x H) approx.	mm	460 x 145 x 280	660 x 240 x 445	700 x 240 x 445
Weight approx. Standard ¹⁾	kg	8.5	23	33

CRAFT-CUT 41/ CRAFT-CUT 41P SCOPE OF DELIVERY:

- Plasma torch S65 / 6m
- 3 m ground cable 6 mm² with earth clamp 300 A
- Standard central adapter

CRAFT-CUT 63/123CNC SCOPE OF DELIVERY:

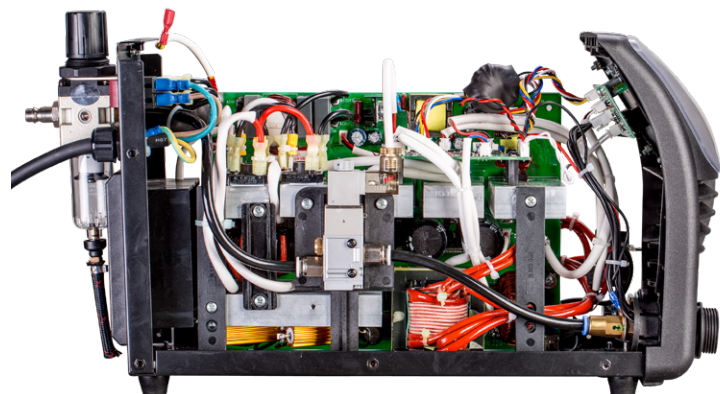
- Plasma torch Pluscut 65 / 6m (Craft-CUT 63)
- Plasma torch Pluscut 105 / 6m (Craft-CUT 123CNC)
- 3 m ground cable 8 mm² with earth clamp 300 A
- Central adapter Trafimector



CraftCut 63 and 123CNC

The TRAFIMECTOR® is one of the most compact connectors on the market and allows the torch to be changed without tools.

Cutting performance



(1) in steel

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

2) Explanation of transport surcharge – see overleaf, details of TP2RS plus VAT

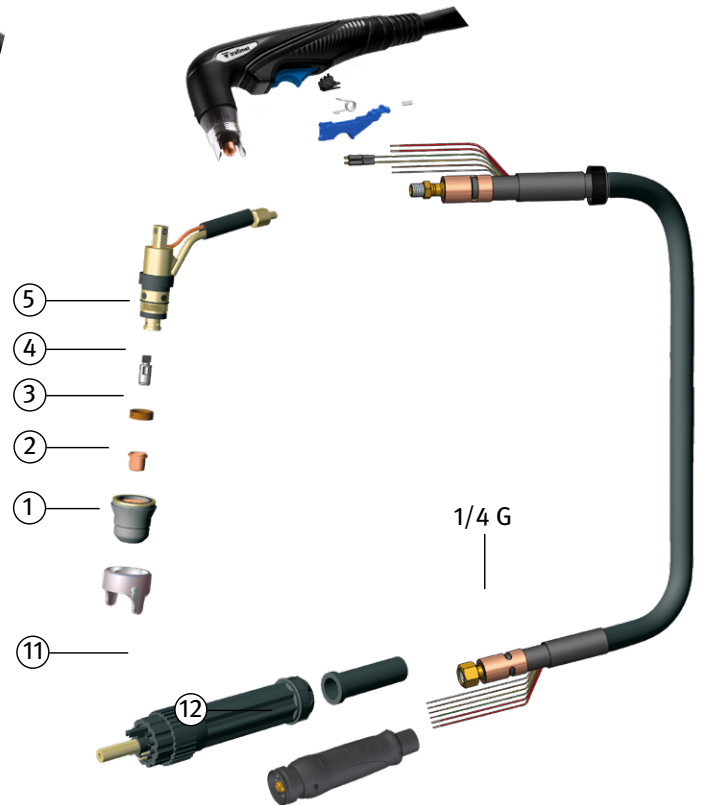
Plasma cutters

Plasma torch Express cut S 65 6m incl. central connection for CRAFT-CUT 41 / 41P



Designation	Art. no.
S65 6m incl. central connection, air-cooled	1332066

Technical data:	S65 6m
Welding current DC max.	60A
Duty cycle	60%
Air pressure	4 bar
Compressed air consumption	100 l/min



Circular cutting device

No.	Designation	Art. no.	PU ⁽¹⁾
5	Plasma electrode short	1332100	10
3	Cutting nozzle 0.8	1332101	10
3	Cutting nozzle 1.0	1332102	10
3	Cutting nozzle 1.6 for gouging	1332106	5
2	External protective nozzle 29 mm	1332103	2
1	Spacer	1332104	2
	Contact protection	1332105	2
4	Diffuser 4.6 mm	1333112	1
	Guide carriage	1333141	1
	Wear parts set		
	5 x Electrode		
	2 x diffuser		
	3 cutting nozzles		
	3 cutting nozzles	1332110	1
	2 x external protection nozzle		
	3 x distance piece		
	1 x sorting box		
	Circular cutting device	1333121	1

**Plasma torch Pluscut 65 / 6 m and 12 m
Incl. Trafimector**

**Plasma torch Pluscut 85 / 6 m and 12 m
Incl. Trafimector**

**Plasma torch Pluscut 105 / 6 m and 12 m
Incl. Trafimector**



Designation	Art. no.
Pluscut 65 / 6 m	1335065
Pluscut 65 / 12 m	1335067
Pluscut 85 / 6 m	1335085
Pluscut 85 / 12 m	1335087
Pluscut 105 / 6 m	1335085
Pluscut 105 / 12 m	1335122

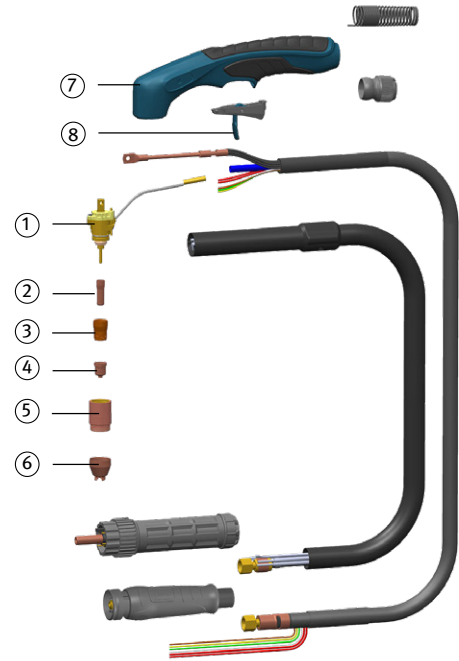
Technical data:	Pluscut 65	Pluscut 85	Pluscut 105
Cooling	air-cooled		
Connection	Trafimector connection		
Welding current DC max.	65 A	85 A	105
Air pressure	4.5 – 5 bar	4.5 – 5 bar	4.5 – 5 bar
Compressed air consumption	225 l/min	225 l/min	250 l/min



- 1 x protective cap 45-85A
- 1 x external protection nozzle 45-85A
- 1 x cutting nozzle 85A
- 1 x Swirl ring 45-85A
- 1 x Electrode 45-105A



Circular cutting device



No.	Designation Pluscut 65/85/105	Art. no.	PU ⁽¹⁾
5	Cooling tube Pluscut 45-105A	1331701	2
	Electrode Pluscut 45-105A	1331702	5
4	Pluscut 45A cutting nozzle	1331704	5
1	Torch body Pluscut 45-105A	1331706	
	Long protective cap Pluscut 45-105A	1331708	2
2	Electrode long Pluscut 65-105A	1331711	5
	Circular cutting device Pluscut 45-105A	1331740	
8	Microswitch kit Pluscut 45-105A Pluscut 45-105A	1331741	
8	Micro switch Pluscut 45-105A	1331742	

No.	Designation Pluscut 65	Art. no.	PU ⁽¹⁾
	Pluscut 45A starter set	1331700	
3	Swirl ring Pluscut 45-85A	1331703	
5	External protection nozzle Pluscut 45-85A	1331705	1
6	Protective cap Pluscut 45-85A	1331707	
	Pluscut 65A cutting nozzle	1331712	5
	Cutting nozzle long Pluscut 65A	1331713	5
	Protective cap for gouging tools Pluscut 65-85A	1331714	2
	Cutting nozzle for gouging Pluscut 65A	1331715	5

No.	Designation Pluscut 85	Art. no.	PU ⁽¹⁾
	Pluscut 65A starter set	1331710	
3	Swirl ring Pluscut 45-85A	1331703	
5	External protection nozzle Pluscut 45-85A	1331705	2
6	Protective cap Pluscut 45-85A	1331707	2
	Protective cap for gouging tools	1331714	2
	Pluscut 85A starter set	1331720	
	Pluscut 85A cutting nozzle	1331721	5
	Cutting nozzle long Pluscut 85A	1331722	5
	Cutting nozzle for gouging	1331723	5

No.	Designation Pluscut 105	Art. no.	PU ⁽¹⁾
	Pluscut 105A starter set	1331730	
3	Swirl ring Pluscut 105A	1331731	
	Pluscut 105A cutting nozzle	1331732	5
	Cutting nozzle long Pluscut 105A	1331733	5
5	Pluscut 105A external protection nozzle	1331734	1
6	Protective cap Pluscut 105A	1331735	2
	Protective cap for gouging tools Pluscut 105A	1331736	2
	Cutting nozzle for gouging	1331737	5

⁽¹⁾ PU = quantity in pieces per packaging unit. Purchase only possible in PUs

ELECTROCHEMICAL METAL- WORKING



CLEANO 3 – the entry-level model for cleaning TIG seams

Tools and accessories

- ▶ Tools are made entirely of stainless steel - therefore no corrosion
- ▶ Tools have bayonet lock - therefore very quick change possible
- ▶ All electrolytes are environmentally friendly and can be used in the food industry

The **CLEANO 3** is versatile and includes 1 programme:

- ▶ Clean with the high-performance brush
- With high-performance carbon fibre brush**
- ▶ even hard-to-reach areas and long seams can be cleaned
- ▶ And all absolutely thoroughly.
- ▶ Efficiently cleans TIG/TIG weld seams in seconds

The proven transformer technology allows:

- ▶ Compact device design
- ▶ fail-safe operation
- ▶ robust handling
- ▶ Simple and safe operation
- ▶ Use in the workshop and during assembly

Equipment features:

- ▶ 10 volts AC
- ▶ Sturdy carrying handle



Qualität Made in Germany



Info & Video



Technical data		CLEANO 3
Art. no.		1231120SK
Technical data		
Output voltage alternating current	V	10
Output current max.	A	80
Power	W	800
Electrical connection ~ 50 Hz	V	230
Dimensions (L x W x H) approx.	mm	298* x 145 x 225
Weight approx.	kg	7.9

*without cable connection

ACCESSORIES

ACCESSORIES	Art. no.
Initial equipment set for CLEANO 3	1231120ES
comprises:	
1231124KK	Plastic case
1236026ST	Brushline high-performance brush Ø 10 mm
1235024KS	Black ground cable, 3 m with bayonet lock
1235024KR	Ground cable, red, 3 m with bayonet lock
1232500WB	Wide-neck container, 500 ml
1232040DC	Electrolyte C Plus, 1 litre



Detailed accessories and descriptions can be found in the current **BYMAT price list** or at www.schweisskraft.de!

CLEANO 4

The professional entry-level model for easy and safe cleaning and polishing of TIG seams. And also marking bright and dark

Tools and accessories:

- ▶ Tools are made entirely of stainless steel - therefore no corrosion
- ▶ Tools have bayonet lock - therefore very quick change possible
- ▶ All electrolytes are environmentally friendly and can be used in the food industry

The CLEANO 4 is versatile and includes 4 different programmes:

- ▶ Clean with the high-performance brush
- ▶ Polishing with the high-performance brush
- ▶ Sign dark
- ▶ Sign bright

With high-performance carbon fibre brush

- ▶ even hard-to-reach areas and long seams can be cleaned
- ▶ And all absolutely thoroughly.
- ▶ Efficiently cleans TIG weld seams in seconds

The proven transformer technology allows:

- ▶ Compact device design
- ▶ fail-safe operation
- ▶ robust handling
- ▶ Simple and safe operation
- ▶ Use in the workshop and during assembly

Equipment features:

- ▶ 3-position switch
- ▶ Programmes (cleaning / polishing / marking)
- ▶ Sturdy carrying handle

- ① **WELD SEAM CLEANING**
- ② **POLISHING**
- ③ **MARKING**



Technical data	CLEANO 4
Art. no.	1231130SK
Technical data	
Output current	80 A
Power	800 W
Dimensions (L x W x H) approx.	345* x 180 x 285 mm
Primary voltage	230 V, 50 - 60Hz
Secondary voltage	10 / 12 V AC, 12V DC
Weight approx.	12 kg

*without cable connection

ACCESSORIES

ACCESSORIES	Art. no.
Initial equipment set for CLEANO 4	1231130ES
comprises:	
1231124KK	Plastic case
1236026ST	Brushline high-performance brush Ø 10 mm
1235024KS	Black ground cable, 3 m with bayonet lock
1235024KR	Ground cable, red, 3 m with bayonet lock
1232500WB	Wide-neck container, 500 ml
1232040DC	Electrolyte C Plus, 1 litre



Detailed accessories and descriptions can be found in the current **BYMAT price list** or at www.schweisskraft.de!

PREMIUM LINE / BRUSHLINE Accessories

BYMAT accessories	Product description	Art. no.
	5024 KR Premium line Ground cable, red, 3 m with bayonet lock and earth clamp	1235024KR
	5024 KS Premium line Ground cable, black, 3 m with bayonet lock	1235024KS
	5024 KL Earth clamp for welding cable	1235024KL
	502430 Adapter for Brush line and Premium line	123502430
	5024 AK Adapter with carbon anode 90°	1235024AK
	6024 VL Replacement filter fleece for 6024 RS (bag with 5 pieces)	1236024VL
	5024 HG Handle made of PTFE (Teflon) extremely acid-resistant and heat-resistant	1235024HG
	5024 ST Polishing punch made from PTFE (Teflon) extremely acid-resistant and heat-resistant with 60° carbon anode	1235024ST
	5025 ST Polishing punch made of PTFE (Teflon) extremely acid-resistant and heat-resistant with 90° carbon anode	1235025ST
	6025 ST High-performance brush with PTFE (Teflon) handle, extremely acid-resistant, heat-resistant, with brush A small 8 mm and adjusting sleeve	1236025ST
	6026 ST High-performance brush with PTFE (Teflon) handle, extremely acid-resistant, heat-resistant, with brush B medium 10 mm and adjusting sleeve	1236026ST
	6027 ST High-performance brush with PTFE (Teflon) handle, extremely acid-resistant, heat-resistant, with brush C large 14 mm and adjusting sleeve	1236027ST
	6025 PI Brush A small 8 mm (blue) and adjusting sleeve made of PTFE	1236025PI
	6026 PI Brush B medium 10 mm (black) and adjusting sleeve made of PTFE	1236026PI
	6027 PI Brush C large 14 mm (red) and adjusting sleeve made of PTFE	1236027PI
	6025 PO Replacement brush A small 8 mm (blue)	1236025PO
	6026 PO Replacement brush B medium 10 mm (black)	1236026PO
	6027 PO Replacement brush C large 14 mm (red)	1236027PO

Info & Video
Working correctly with the high-performance brush

BYMAT accessories	Product description	Art. no.
	6025 VH Adjusting sleeve made of PTFE (Teflon) A small for replacement brush 6025 PO, Ø 8 mm	1236025VH
	6026 VH Adjusting sleeve made of PTFE (Teflon) B medium for replacement brush 6026 PO, Ø 10 mm	1236026VH
	6027 VH Adjusting sleeve made of PTFE (Teflon) C large for replacement brush 6027 PO, Ø 14 mm	1236027VH
	Cleaning and marking felts (made of Nomex) 1206 SF Cleaning and marking felts 38 x 60 x 2.6 mm, 20 pieces 1207 SF Cleaning and marking felts 38 x 60 x 2.6 mm, 100 pieces	1231206SF 1231207SF
	Cleaning and marking felt rolls (made of Nomex) 1208 SFC Cleaning and marking felt roll, 1 m x 60 mm x 2.6 mm, 10 pieces. 1209 SF Cleaning and marking felt roll, 5 m x 60 mm x 2.6 mm	1231208SF 1231209SF
	Polishing felts made from Kevlar - Aramid 1216 PF Polishing felts, 40 x 60 x 2.5 mm, 20 pieces 1217 PF Polishing felts, 40 x 60 x 2.5 mm, 100 pieces	1231216PF 1231217PF
	Polishing felt rolls made of Kevlar - Aramid 1214 PF Polishing felt roll, 1 m x 60 mm x 2.5 mm, 10 rolls 1215 PF Polishing felt roll, 5 m x 60 mm x 2.5 mm	1231214PF 1231215PF
	Polishing felts made from Kevlar 1219 PP Professional polishing felts 38 x 60 x 2.0 mm, 20 piece 1220 PP Professional polishing felts 38 x 60 x 2.0 mm, 100 piece	1231219PP 1231220PP
	1205 OR Replacement O-rings 26 x 2 mm, bag with 10 pcs. 1127 OR Replacement O-rings 26 x 2 mm, bag with 100 pcs. (Also for CLASSICLINE)	1231205OR 1231127OR
	2500 WB Wide-neck container, 500 ml (also for CLASSICLINE)	1232500WB
	2100 SF Spray bottle for water, 1 litre for filling with water or Neutralyt (Also for CLASSICLINE)	1232100SF
	2150 DS Pressure spray bottle for water, 1.5 litres, for filling with water or Neutralyt (Also for CLASSICLINE)	1232150DS

Electrolytes for cleaning / polishing

Electrolytes for cleaning of TIG welding seams	Art. no.
Brush gel NON-DRIP A 500 ml	1232020PG
<i>Basis: Phosphoric acid</i>	
Electrolyte A, for cleaning bright steels	
1000 ml	1232030DH
5000 ml	1232035DH
Electrolyte LF, for cleaning bright steels	
1000 ml	1232030LF
5000 ml	1232035LF
Electrolyte B, for cleaning matt steels	
1000 ml	1232011DB
5000 ml	1232015DB
For polishing TIG weld seams	
Electrolyte C, for electrochemical polishing	
500 ml	1232020DC
1000 ml	1232021DC
5000 ml	1232025DC
For cleaning & polishing Tig and MIG/Mag weld seams	
Electrolyte C Plus for electrochemical polishing	
2040 DC – 1000 ml	1232040DC
2045 DC – 5000 ml	1232045DC

Electrolytes for marking

For marking	
100 ml	1232101ET
500 ml	1232105ET
1000 ml	1232111ET
5000 ml	1232115ET
For negative marking	
100 ml	1232170EN
For bright marking (similar to engraving)	
500 ml	1232175EN
1000 ml	1232171EN
5000 ml	1232185EN
For dark marking	
100 ml	1232101EC-S
500 ml	1232105EC-S
1000 ml	1232111EC-S
5000 ml	1232115EC-S

For dark marking of Chrome vanadium	Art. no.
100 ml	1232120EC
500 ml	1232125EC
1000 ml	1232126EC
5000 ml	1232127EC

For marking brass, copper, tin	
100 ml	1232130EM
500 ml	1232135EM

For marking aluminium	
100 ml	1232140EA
500 ml	1232145EA

Special electrolyte for marking chrome	
500 ml	1232615SC

For marking dark stainless steel with a high chrome content	
100 ml	1232601ER
500 ml	1232600ER

For marking dark stainless steel with a high nickel content	
100 ml	1232601CA
500 ml	1232600CA
1000 ml	1232610CA

Electrolytes for neutralisation

Neutralyt to neutralise electrolyte	
500 ml	1232215NT
1000 ml	1232211NT
5000 ml	1232250NT

Electrolytes for electroplating

Zinc	
100 ml	1232410GZ
500 ml	1232450GZ

Gold	
100 ml	1232510GG
500 ml	1232550GG

Silver	
100 ml	1232710GS
500 ml	1232750GS

Comparison of electrolytes

Cleaning with a carbon fibre brush:

- ▶ Electrolyte C
- ▶ Electrolyte C Plus
- ▶ Electrolyte LF
- ▶ Electrolyte A



Label printers and labelling tapes

Label printer Brother P-Touch D610B



- ▶ Equipped with a PC interface and Bluetooth for designing and printing labels via the P-touch Editor software on your computer or via the iPrint&Label app on your smartphone and tablet
- ▶ Labels up to 24 mm wide can be printed at high speed
- ▶ Features an automatic cutting unit and a high-resolution colour display with backlighting
- ▶ Up to 99 templates can be saved for printing frequently used labels

Model		Brother Brother P-Touch D610B
Article no.		123D610B
Type of labelling tapes		TZe labelling tapes
Labelling tape width	mm	3.5; 6; 9; 12; 18; 24
Memory		99 memory locations
USB interface		Yes, USB 2.0 Full Speed
Bluetooth		Yes (5.0)
Network-compatible		PC interface
Product type		Thermal transfer
Display		LC display with backlight
Type of cutting unit		automatic, scissors
Screen size		20 characters x 2 lines
Setting the unit		Yes
Number of buttons		65

Special labelling tapes	Art. no.
Brother, 18 mm x 3 m	1231410ST
Brother, 24 mm x 3 m	1231510ST

Designation Art. no.

SHORT-TERM TEMPLATES

- Customised production according to your wishes
- Production according to the graphics, trademarks, type plates, device numbers, labelling numbers, scales, fonts and logos you provide
- Very long service life: up to 5000 markings possible with one template

One-off set costs for long-term template

with imageable original	1231000SD
according to template (e.g.business card, letterhead, fax)	1231000SK

Outer dimensions 35 x 40 mm - Usable surface 25 x 15 mm

framed in a plastic frame	1231001SB
unframed	1231001SU

Outer dimensions 1/2 DIN A8 (74 x 36 mm) - Usable surface 54 x 16 mm

framed in a plastic frame	1231012SB
unframed	1231012SU

Outer dimensions DIN A8 (74 x 52 mm) - Usable surface 54 x 32 mm

framed in a plastic frame	1231002SB
unframed	1231002SU

Outer dimensions 1/2 DIN A7 (105 x 47 mm) - Usable surface 85 x 27 mm

framed in a plastic frame	1231013SB
unframed	1231013SU

Outer dimensions DIN A7 (105 x 74 mm) - Usable surface 85 x 54 mm

framed in a plastic frame	1231003SB
unframed	1231003SU

Outer dimensions 1/2 DIN A6 (148 x 62.5 mm)-Usable surface 128 x 42.5 mm

framed in a plastic frame	1231014SB
unframed	1231014SU

Outer dimensions DIN A6 (148 x 105 mm) - Usable surface 128 x 85 mm

framed in a plastic frame	1231004SB
unframed	1231004SU

Outer dimensions 1/2 DIN A5 (210 x 94 mm) - Usable surface 170 x 54 mm

framed in a plastic frame	1231015SB
unframed	1231015SU

Outer dimensions DIN A5 (210 x 148 mm) - Usable surface 170 x 108 mm

framed in a plastic frame	1231005SB
unframed	1231005SU

Outer dimensions 1/2 DIN A4 (297 x 125 mm) - Usable surface 257 x 85 mm

framed in a plastic frame	1231016SB
unframed	1231016SU

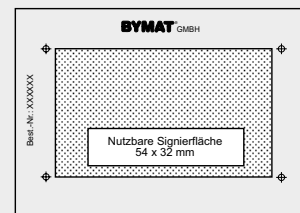
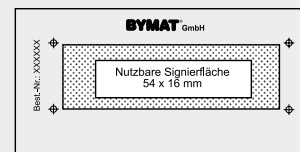
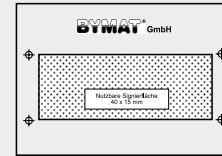
Outer dimensions DIN A4 (297 x 210 mm) - Usable surface 257 x 170 mm

framed in aluminium frame	1231006SA
framed in a plastic frame	1231006SB
unframed	1231006SU

Long-term template special size	1231007SG
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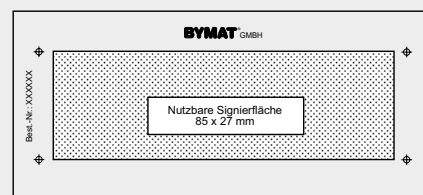
Outer dimensions 25 x 40 mm

1231001SB Long-term template framed in plastic frame (Usable area 40 x 15 mm)	1231001SU Long-term template unframed (Usable area 40 x 15 mm)
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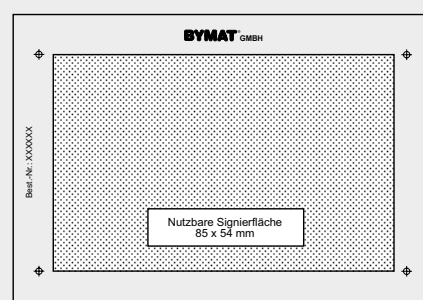
External dimension 1/2 A 7 (105 x 47 mm)

1231013SB Long-term template framed in plastic frame (85 x 27 mm usable area)	1231013SU Long-term template unframed (85 x 27 mm usable area)
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Outer dimensions DIN A 7 (105 x 74 mm)

1231003SB Long-term template framed in plastic frame (85 x 54 mm usable area)	1231003SU Long-term template unframed (85 x 54 mm usable area)
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MIG/MAG

TIG inverter

Electrode inverter

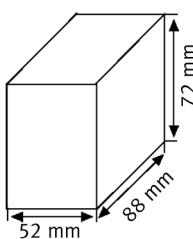
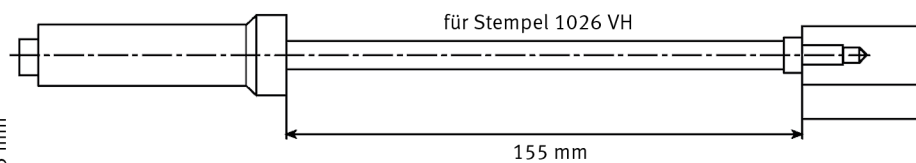
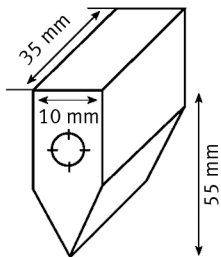
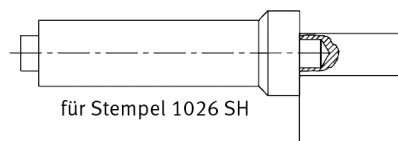
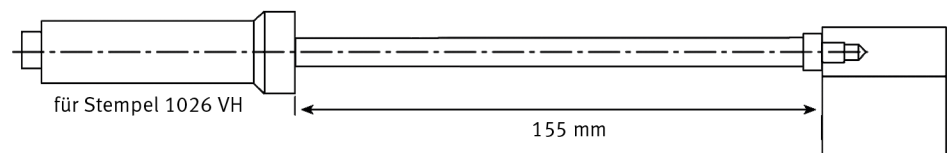
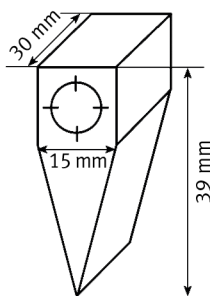
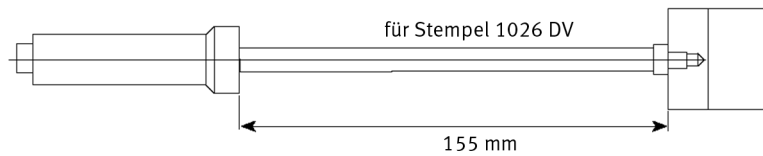
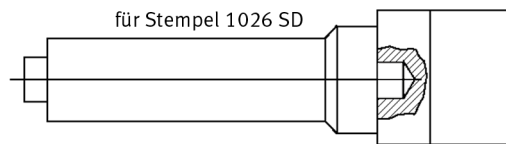
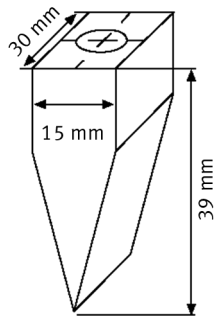
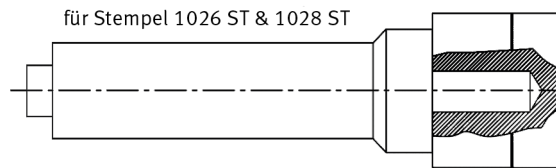
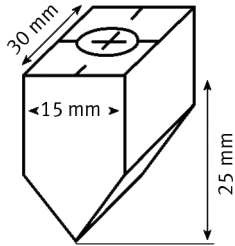
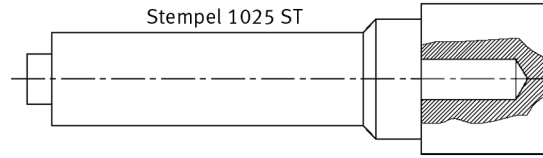
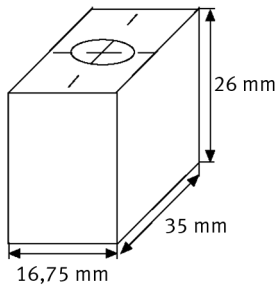
Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

Replacement carbons for cleaning, polishing, marking and electroplating stamps



WELDING FUME EXTRACTION SYSTEMS



Welding fume extraction systems

Procedure	Emission rate (mg/s)	Substances harmful to the respiratory tract and lungs	Toxic or toxic-irritant substances	Carcinogenic substances
Submerged arc welding	<1	low	low	low
Gas welding (oxyfuel process)	<1	low	low	–
TIG	<1	low	medium	medium
Laser beam welding without filler material	1 to 2	medium	high	high
MIG/MAG low-energy gas-shielded welding), brazing	1 to 4	low	medium	medium to high
LBH, MIG (general) MAG (solid wire) Flux-cored wire welding with shielding gas Laser beam welding with filler material	2 to 25	high	high	high
MAG (flux-cored wire) Flux-cored wire welding without shielding gas Oxyfuel flame cutting Arc spraying	>25	very high	very high	very high

Comparison test

Mobile filter devices with disposable filter

312 A
30.3V
1.2 mm
11 m/min

Continuous measurement: Welding time and welding wire consumption until filter change

Device type	Frequency of use	Filter area	Welding time (arc on)	Consumption Welding wire	Filter service life (factor)
SRF Master	occasional use	13 m ²	6 ¾ h	40.7 kg	100%
SRF Professional	regular use	17 m ²	13 h	86 kg	210%
SRF Maxi	intensive use	42 m ²	33 ¼ h	218 kg	540%

Selection criteria

Emission rate	Material	USE			
Application example	↓	sporadically	occasionally to frequently	regularly	permanent
Class I & II < 1-2 mg/s Submerged arc welding TIG welding Laser welding	unalloyed to lightly alloyed	1800020 SRF Master 1800005 SRF WallMaster	1800020 SRF Master 1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800025 SRF Profi 1800031 SRF SmartFil 1800030 SRF Maxi 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi
	Aluminium	1800020 SRF Master 1800005 SRF WallMaster	1800020 SRF Master 1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800025 SRF Profi 1800031 SRF SmartFil 1800030 SRF Maxi 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi
	Highly alloyed Non-ferrous material	1800020 SRF Master 1800005 SRF WallMaster	1800020 SRF Master 1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800025 SRF Profi 1800031 SRF SmartFil 1800030 SRF Maxi 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi
Class III 2-25 mg/s Manual arc welding MIG/MAG welding	unalloyed lightly alloyed aluminium	1800020 SRF Master 1800005 SRF WallMaster	1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi 1800040 SRF Master XL	1800040 SRF Master XL
	Highly alloyed Non-ferrous material	1800020 SRF Master 1800005 SRF WallMaster	1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi 1800040 SRF Master XL	1800040 SRF Master XL
Class IV > 25 mg/s Flux-cored wire welding	unalloyed lightly alloyed aluminium	1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi 1800040 SRF Master XL	1800040 SRF Master XL	1800040 SRF Master XL
	Highly alloyed Non-ferrous material	1800025 SRF Profi 1800031 SRF SmartFil 1800005 SRF WallMaster	1800031 SRF SmartFil 1800030 SRF Maxi 1800040 SRF Master XL	1800040 SRF Master XL	1800030 SRF Maxi 1800040 SRF Master XL

Recommendations based on European standards and expected filter change/cleaning intervals.

SRF Master / SRF Profi / SRF Maxi

Compact and robust filter units with suction arms for low to medium quantities of smoke and dust. For occasional to regular use

SRF Master

Area of application

- ▶ Low levels of smoke/dust
- ▶ Occasional use

Benefits

- ▶ Little adjustment of the extraction hood required
- ▶ More flexible due to additional hose connection at the rear

Properties

- ▶ Safe operation thanks to filter monitoring
- ▶ Extraction hood can be rotated and swivelled 360 degrees
- ▶ Push handle and cable holder



SRF Professional

Area of application

- ▶ Low to medium amounts of smoke/dust
- ▶ Occasional to frequent use

Benefits

- ▶ Little adjustment of the extraction hood required
- ▶ Convenient filter change through maintenance door
- ▶ Safe operation thanks to rotating field detection

Properties

- ▶ Safe operation thanks to filter monitoring
- ▶ Extraction hood can be rotated and swivelled 360 degrees
- ▶ Automatic start/stop (optional)



SRF Maxi

Area of application

- ▶ Medium amounts of smoke/dust
- ▶ Regular use

Benefits

- ▶ Little adjustment of the extraction hood required
- ▶ Contamination-free filter change
- ▶ Safe operation thanks to rotating field detection
- ▶ High efficiency due to long filter service life

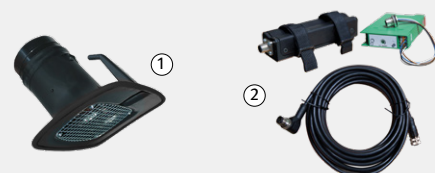
Properties

- ▶ Safe operation thanks to filter monitoring
- ▶ Extraction hood can be rotated and swivelled 360 degrees
- ▶ Automatic start/stop (optional)



Model	SRF Master	SRF Professional	SRF Maxi
Art. no.	1800020	1800025	1800030
Technical data			
Filters			
Procedure	3-stage	2-stage	2-stage
Filter type	Disposable filter	Disposable filter	Disposable filter
Filter area	approx. 13 m ²	approx. 17 m ²	approx. 42 m ²
Degree of separation	> 99 %	> 99 %	> 99 %
Filter material	Glass fibre fleece	Glass fibre fleece	Polyester fleece
Welding fume separation class	W3	W3	W3
Additional filters	Two pre-filters	Pre-filter	Pre-filter (aluminium mesh)
Basic data			
Suction capacity	max. 950 m ³ /h	max. 1100 m ³ /h	max. 1100 m ³ /h
Suction arm	Ø 150 mm	Ø 150 mm	Ø 150 mm
Suction arm length	2 m	3 m	3 m
Extraction connection	Ø 150 mm	Ø 150 mm	Ø 150 mm
Motor power	1.1 kW	1.1 kW	1.1 kW
Electrical connection ~ 50 Hz	230V	400V	400V
Sound pressure level	72 dB(A)	70 dB(A)	70 dB(A)
Dimensions (L x W x H) approx.	705 x 655 x 900 mm	785 x 730 x 950 mm	790 x 815 x 1080 mm
Weight approx.	71 kg	106 kg	120 kg

ACCESSORIES



ACCESSORY SRF Master	Art. no.
Main filter	1810020
Pre-filter cassette	1810021
10 x pre-filter mats	1810022
ACCESSORY SRF Profi	Art. no.
Main filter	1810025
10 x pre-filter mats	1810026
Automatic start/stop	1810100
ACCESSORY SRF Maxi	Art. no.
② Extraction hood with lighting	1810222
Replacement filter	1810030
② Automatic start/stop	1810100
Additional equipment on request	

SRF Master XL / SRF Maxi C

Self-cleaning filter units with suction arms for large quantities of smoke and dust.
For occasional to regular use

SRF Master XL

Area of application

- ▶ Large amounts of smoke/dust
- ▶ Regular use

Benefits

- ▶ Little adjustment of the extraction hood required
- ▶ Convenient filter change through maintenance door
- ▶ Dust discharge into collection container
- ▶ High efficiency thanks to automatic filter cleaning

Properties

- ▶ Safe operation thanks to filter monitoring
- ▶ Extraction hood can be rotated and swivelled 360 degrees



3m suction arm
Automatic filter
cleaning

SRF Master XL

Model	SRF Master XL
Art. no.	1800040
Technical data	
Filters	
Procedure	2-stage
Filter type	Cleaning filter
Filter area	approx. 10 m ²
Degree of separation	> 99 %
Filter material	ePTFE membrane
Welding fume separation class	W3
Additional filters	–
Basic data	
Suction capacity	max. 1000 m ³ /h
Suction arm	Ø 150 mm
Suction arm length	3 m
Compressed air connection	5-6 bar
Motor power	1.5 kW
Electrical connection ~ 50 Hz	400V
Sound pressure level	69 dB(A)
Dimensions (L x W x H) approx.	655 x 655 x 1,355 mm
Weight approx.	135 kg

ACCESSORIES



ACCESSORY SRF Master XL	Art. no.
Replacement filter	1810040
② Extraction hood with lighting	1810222
Set of 4 dust cartridges	1810036
② Automatic start/stop	1810100
Additional equipment on request	

SRF SmartFil

The mobile welding fume extraction system for regular use

Application

- ▶ Medium amounts of smoke/dust
- ▶ Regular use
- ▶ Changing workplaces

- ▶ 360 degree rotating extraction bonnet with throttle valve
- ▶ Filter area for replacement filters: 42 m²
- ▶ Large filter surface
- ▶ Compact and stable design

Benefits

- ▶ Safe operation due to rotating field detection
- ▶ Less tracking of the suction arm thanks to the flow-optimised design of the extraction hood
- ▶ Increased safety through filter monitoring
- ▶ Increased safety thanks to contamination-free filter changes
- ▶ High efficiency thanks to large capacity and long filter service life

Characteristics



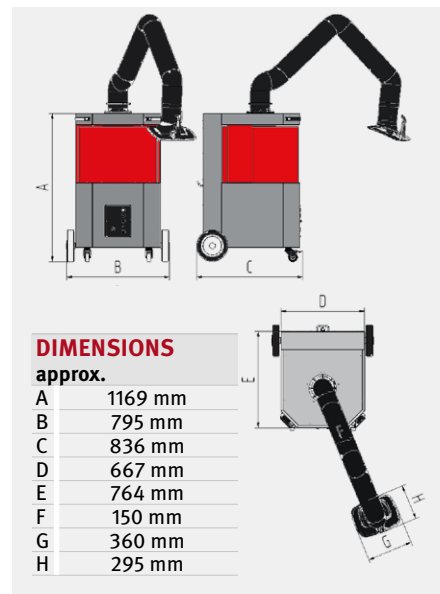
Ideal for changing workstations and confined work areas



Centrifugal fan

Suction arm, hose version

3m suction arm



DIMENSIONS approx.

A	1169 mm
B	795 mm
C	836 mm
D	667 mm
E	764 mm
F	150 mm
G	360 mm
H	295 mm

Model	SRF SmartFil
Art. no.	1800031

Technical data

Filters	
Filter stages	2
Filter area	25 m ²
Filter type	Disposable filter
Filter material	Polyester fleece
Degree of separation	≥ 99.5 %
Filter class	E12
Additional filters	Pre-filter
Basic data	
Suction capacity	1100 m ³ /h
Rated current	3.1 A
Control voltage	24 V, DC
Sound pressure level	70 dB(A)
Motor power	1.5 kW
Electrical connection ~ 50 Hz	400V
Dimensions (L x W x H) approx.	795 x 836 x 1169 mm
Weight approx.	131 kg

ACCESSORIES



ACCESSORIES		Art. no.
①	Replacement filter 25 m ²	1810220
②	Replacement filter 42 m ²	1810221
③	Extraction hood with lighting	1810222

SRF MAXI C 2.0 filter unit – Compact and robust filter unit with suction arms

Neu

- ▶ Automatic cleaning of the filter using compressed air
- ▶ Durable disposable filter with high absorption capacity (42 m² filter surface)
- ▶ High separation efficiency of >99.9%
- ▶ Contamination-free filter change
- ▶ Flexible suction arm with 3 m length
- ▶ High efficiency due to large filter capacity
- ▶ KemTex ePTFE filter cartridge for optimum health protection
- ▶ Safe operation due to rotating field detection

- ▶ Mobile with robust rollers - easy to move, even in confined spaces
- ▶ Also suitable for chrome-nickel steel
- ▶ Automatic start/stop and extraction bonnet with lighting optionally available



Made in Germany



3 m SUCTION ARM

Model		SRF MAXI C 2.0
Art. no.		1800036

Technical data		SRF MAXI C 2.0
Filter type		Cleaning filter
Filter area approx.	m ²	15
Degree of separation	%	>99.97
Filter material		ePTFE membrane
Filter class		M
Dust class		M
Additional filters		Spark pre-separator made of aluminium mesh
Extraction capacity max.	m ³ /h	1450
Suction arm diameter	mm	150
Suction arm length	m	3
Compressed air connection	bar	5 – 6
Sound pressure level	dB(A)	73
Drive motor power ~50 Hz	kW/V	1.5 / 400
Dimensions (L x W x H) approx.	mm	973 x 834 x 1350
Weight approx.	kg	197



ACCESSORIES	Art. no.
Replacement filter	1810035
Automatic start/stop	1810100
Extraction hood with lighting	1810222
Suction bonnet	1810300
Pre-filter insert Aluminium mesh	1810301
Dust collection bag, set of 5	1810302

SRF WallMaster

Cost-effective welding fume filter solution for modular design with high filter capacity and safe filter replacement

Application

- ▶ Medium amounts of smoke/dust
- ▶ Modular expansion in combination with registration elements
- ▶ One to two workstations

Benefits

- ▶ Increased safety thanks to contamination-free filter changes
- ▶ High efficiency thanks to large capacity and long filter service life
- ▶ Cost-effective welding fume filter by means

of simple retrofitting to existing detection elements

- ▶ Robust filter monitoring with the help of pressure gauge

Properties

- ▶ Retrofittable
- ▶ Integrated lifting device for filter change
- ▶ Quick and easy installation
- ▶ Compact and stable design
- ▶ Mechanical operation of the filter medium



Filter monitoring via pressure gauge



Integrated lifting device for filter change



Fig. shows scope of delivery



Fig. shows SRF WallMaster with 2x SRF exhaust air set (Article no. 1800006)

Exhaust air set – Welding fume exhaust air set with suction arm and fan

Application

- ▶ Large quantities of smoke/dust
- ▶ Permanent use
- ▶ Where air filtration is not absolutely necessary
- ▶ Welding fumes, gases, vapours, light dusts

Benefits

- ▶ Particularly quiet as the housing is made of cast silumin
- ▶ 40% less tracking of the suction arm thanks to the flow-optimised design of the hood
- ▶ User-friendly thanks to particularly smooth operation of the bonnet with one hand
- ▶ Holds set position unsupported thanks to internal support rods

Properties

- ▶ Retrofittable
- ▶ Integrated lifting device for filter change
- ▶ Quick and easy installation
- ▶ Compact and stable design
- ▶ Mechanical operation of the filter medium

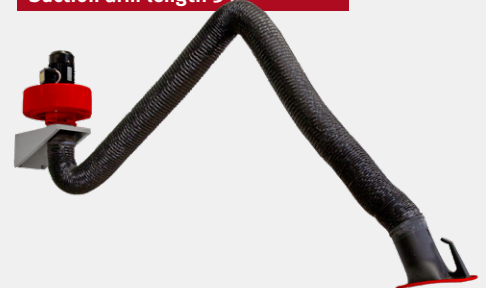
Scope of delivery:

- ▶ Fan, suction arm with hood, wall bracket, motor protection switch, set of connecting materials, exhaust air duct extendable from 1.25 to 5.00 m and matching exhaust nozzle.

1 suction arm

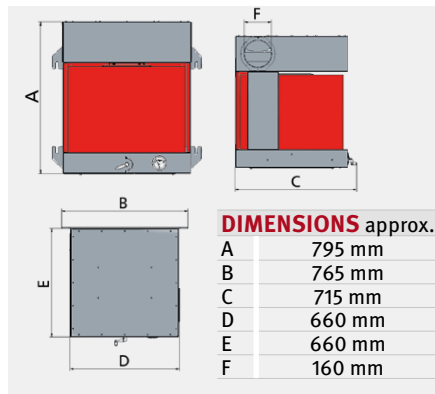
Suction arm diameter 150 mm

Suction arm length 3 m



Model	SRF exhaust air set
Art. no.	1800006
Technical data	
Extraction capacity	1000 m³/h
Max. Fan power	2000 m³/h
Rated current	1.5 A
Sound pressure level	73 dB(A)
Motor power	0.75 kW
Electrical connection ~50 Hz	400V
Weight approx.	43.5 kg

Model	SRF WallMaster
Art. no.	1800005
Technical data	
Filters	
Filter stages	2
Filter area	42 m²
Filter type	Disposable filter
Filter material	Polyester fleece
Degree of separation	≥ 99.5 %
Filter class	E12
Basic data	
Dimensions (L x W x H) approx.	765 x 715 x 795 mm
Weight approx.	65 kg
Suitable for volume flows	up to 1600 m³/h



ACCESSORIES



ACCESSORIES Art. no.
① Replacement filter 1810055

SRF CleanAirTower 2.0

Welding fume extraction unit. Energy-saving room ventilation system with layered ventilation for welding fumes in production halls

Application

- ▶ Workshops where spot extraction is not possible
- ▶ Supplementary to point suction systems
- ▶ Environments with changing sources of dust/smoke
- ▶ Workplaces, production halls, logistics and warehouses

Benefits

- ▶ Minimising heating costs through air recirculation and air distribution
- ▶ High level of safety due to contamination-free dust disposal
- ▶ No distribution of dirty air into uncontaminated hall areas, as there is hardly any air turbulence
- ▶ Cost-effective, even retrofitting, as no pipework is required
- ▶ Safe transport and easy installation thanks to crane eyes
- ▶ Uninterrupted operation thanks to automatic dust removal into dust collection bin

Properties

- ▶ Automatic filter cleaning
- ▶ Crane eyes
- ▶ 360-degree intake grille
- ▶ Cloud connection via mobile radio (12 months cloud use free of charge)
- ▶ Contamination-free dust disposal in disposable containers
- ▶ Slow, low-pulse air circulation
- ▶ Layer ventilation principle, recommended by the employers' liability insurance association
- ▶ System generates hardly any air turbulence

Additional equipment

- ▶ Air monitoring AirWatch

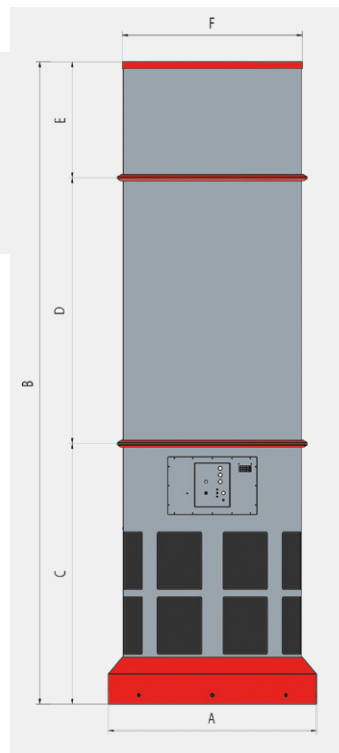
Functionality

- ▶ Intake of ambient air via a built-in fan
- ▶ The purified, clean air exits at the bottom of the system with low momentum
- ▶ The warm fresh air transports the welding fumes back towards the intake grille and a slow air circulation is created at the workstations (layer ventilation)



DIMENSIONS approx.

A	1172 mm
B	3622 mm
C	1463 mm
D	1502 mm
E	600 mm
F	1004 mm



Model	SRF CleanAirTower 2.0
Art. no.	1802000
Technical data	
Filters	
Filter stages	1
Filter process	Cleaning filter
Cleaning process	Rotary nozzle
Filter area	20 m ²
Number of filter elements	3
Total filter area	60 m ²
Filter material	PTFE membrane
Degree of separation	≥ 99.9 %
Dust class	M
Additional information	
IFA approval	W3-tested
Fan type	Centrifugal fan, direct drive
Compressed air supply	5 – 6 bar
Dust collection container volume	10 l
Basic data	
Suction capacity	6000 m ³ /h
Rated current	11 A
Control voltage	24 V, DC
Sound pressure level	72 dB(A)
Motor power	5.5 kW
Electrical connection ~ 50 Hz	400V
Dimensions (H x Ø) approx.	3622 x 1172 mm
Weight approx.	666 kg

ACCESSORIES



ACCESSORIES		Art. no.
①	ePTFE replacement filter set	1810250
②	Dust collector	1810251

Training welding table series

Sturdy tables with support made of fireclay bricks and angle iron

Application

- ▶ Teaching and training centres
- ▶ Training departments in companies

Benefits

- ▶ By dividing the work surface, two welding processes can be learnt at one workstation
- ▶ Long service life thanks to stable sectional steel construction

Properties

- ▶ Sturdy sectional steel construction
- ▶ Work area divided into two parts: rod iron grate and sheet steel support with fireclay plates
- ▶ Can be integrated into extraction cabins



Picture shows training welding table with optionally available forced position welding device



Can be integrated into extraction cabins

SCOPE OF DELIVERY:

- Bar grate
- Sheet steel support with fireclay plates

Model	600 x 600 x 800 mm	900 x 600 x 800 mm	1200 x 600 x 800 mm
Art. no.	1801000	1801005	1801010

Basic data		600 x 600 x 800	900 x 600 x 800	1200 x 600 x 800
Dimensions (L x W x H) approx.	mm	600 x 600 x 800	900 x 600 x 800	1200 x 600 x 800
Weight approx.	kg	39	47	54.5



ACCESSORIES

Accessories	Art. no.
Forced position welding device	1810260

Downdraft table series for extraction – Robust downdraft tables with return flow frame and fold-down side panels

Application

- ▶ Industrial grinding of machined workpieces

Benefits

- ▶ Safe working thanks to robust material support
- ▶ Also suitable for larger workpieces, as side panels can be folded down
- ▶ Reduced noise emission due to soundproofed side panels
- ▶ Higher grinding dust collection rate due to the return flow frame

- ▶ Easy cleaning thanks to integrated slag drawer
- ▶ Pleasant working thanks to the ergonomically adapted sheet steel construction

Properties

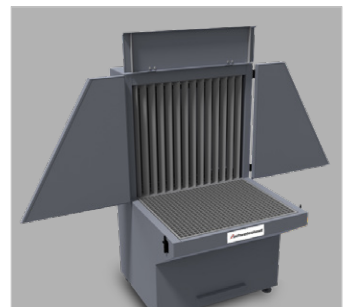
- ▶ Robust grating support
- ▶ Side panels can be folded down
- ▶ Side walls with sound insulation material
- ▶ Return flow frame
- ▶ Integrated slag drawer
- ▶ Connection to new or integration into an existing extraction system



Higher grinding dust collection rate due to the return flow frame



1510 x 1060 x 1700 mm



Also suitable for larger workpieces, as side panels can be folded down

Model		Downdraft table for extraction			
		1010 x 1060 x 1700 mm	1360 x 1060 x 1700 mm	1510 x 1060 x 1700 mm	2000 x 1060 x 1700 mm
Art. no.		1801105	1801110	1801115	1801120
Basic data					
Suction nozzle Ø	mm	250	250	250	250
Suction capacity recommended	m ³ /h	1500 – 1800	1500 – 1800	2000 – 3000	2000 – 3000
Table height	mm	800	800	800	800
Table top length	mm	1010	1360	1510	2000
Table top width	mm	760	760	760	760
Dimensions (L x W x H) approx.	mm	1010 x 1060 x 1700	1360 x 1060 x 1700	1510 x 1060 x 1700	2000 x 1060 x 1700
Weight approx.	kg	159	191.5	210	271

VarioProtect[®] solar power

schweisskraft[®]
Schweißtechnik

WELDING HELMETS WELDING PROTECTION WELDING ACCESSORIES



Welding helmets

Automatic welding filter **VARIOPROTECT** – vull vision with effective protection for your eyes

- ▶ Effective eye protection thanks to automatic dimming after a very short reaction time as soon as the arc is ignited
- ▶ Electronically controlled liquid crystal elements act as diaphragms that recognise the welding arc and react immediately by displaying a dark or bright image
- ▶ UV/IR filter keeps out harmful radiation
- ▶ On some models, the protection level can be

- continuously adjusted on the outside of the helmet without having to remove the helmet
- ▶ Stepless sensitivity adjustment
- ▶ Adjustable switching reaction time from dark to light

- ▶ Automatic darkening of the welding filter can be deactivated, can also be used for grinding in grinding mode
- ▶ Thanks to the automatic on/off function no button needs to be pressed
- ▶ Solar cell operation

VarioProtect® solar power

TRUE COLOUR DISPLAY

The next display generation: TrueColour

- ▶ True colour cassette for increased control: Welding in true colour and with more contrast improves the detection of surfaces and coloured elements of the working environment



Display head for grinding & welding helmets

- Head diameter: 60 cm
- Weight approx: 0.8 kg
- Material: Plastic

Art. no.	height
8150240	400 mm





TRUE COLOUR DISPLAY

PANORAMA FIELD OF VIEW SIDE WINDOW



GREEN DISPLAY

The next display generation with a wide field of view: TrueColor and Panorama

- ▶ True Colour cassette in the main viewing window for increased control: Welding in true colour and with more contrast improves the detection of surfaces and coloured elements of the working environment
- ▶ Side windows with "Green Displays"
- ▶ Pleasant welding with 180° field of vision thanks to the side windows on the right and left



TRUE COLOUR DISPLAY

PANORAMA FIELD OF VIEW

The next display generation with a wide field of view: TrueColor and Panorama

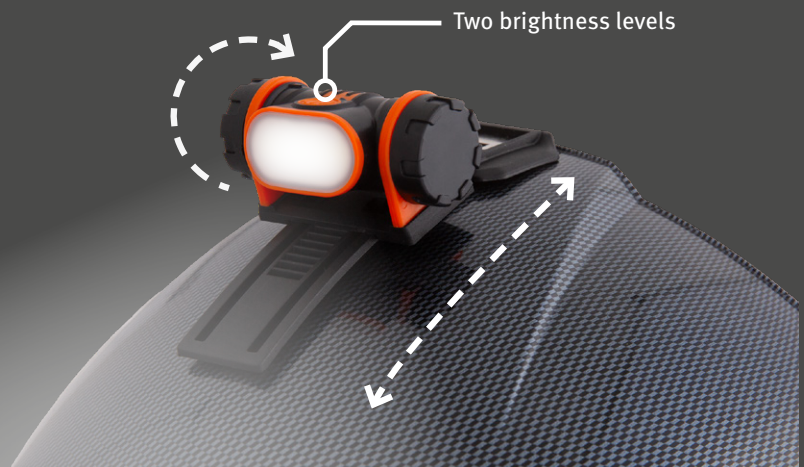
- ▶ True Colour cassette in the main viewing window for increased control: Welding in true colour and with more contrast improves the detection of surfaces and coloured elements of the working environment
- ▶ Pleasant welding with 180° field of vision thanks to the side windows on the right and left



LED LIGHT

The LED light can be effortlessly attached to all **labelled** welding helmets:

- > VarioProtect M-W
- > VarioProtect XL-W TC
- > VarioProtect 3XL-W SW TC
- > VarioProtect 3XL-W DIGITAL TC
- > VarioProtect XXL-W-2 TC (all)
- > VarioProtect XXL-W TC AIR TH3
- > VarioProtect XXL-W F-TC
- > VarioProtect XXL-W F-TC AIR

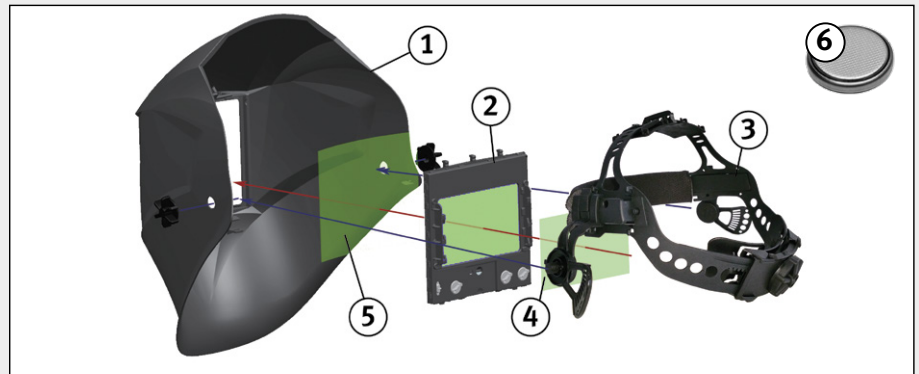


Model	LED light for welding helmet
Art. no.	1662260
Technical data	
Luminous intensity	40 – 80 Lumen
Battery type	AA battery
Dimensions (L x W x H) approx.	122x56x44 mm
Weight approx.	0.07 kg

Welding helmets

VARIOPROTECT XL-W TC

- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Stepless DIN 9-13
- ▶ Response time 0.1 ms
- ▶ Two sensors
- ▶ Switching between grinding and welding mode and infinitely variable adjustment of the dark protection level on the outside of the helmet



VarioProtect[®] solar power
**TRUE COLOUR
 DISPLAY**



1/1/1/1 in the classification

VarioProtect Panorama		VarioProtect XL-W TC	
Art. no.		1651000	
Filter cassette			
Viewing window (W x H)	mm	100 x 49	
Light-dark response time	ms	0.1	
Dark-light brightening time	ms	150 – 800	
Dark protection level		DIN 9-13	
UV/IR protection		Protection level 16 (permanent)	
Light level		Protection level 4	
Solar cells		Yes	
Battery type		2 x Li-Mn battery (CR2032)	
Number of sensors		2	
Standards and approvals			
Class		1/1/1/2	
Welding mask			
Material		Nylon	
Dimensions and weights			
Dimensions approx. (L x W x H)	mm	238 x 175 x 334	
Weight approx.	g	490	

ACCESSORY VarioProtect Panorama S-TC

No.	Designation	PU	Art. no.
1	Welding helmet housing	1	1662157
2	Filter cassette	1	1662158
3	Complete headband	1	1662102
4	Forehead sweatband	1	1662112
5	Inner windscreen	10	1662156
	Outer attachment disc	10	1662155
6	Lithium battery 3V CR24032	1	1662107



VARIOPROTECT XXL-W-2 TC

- ▶ Top marks in the evaluation of optical class, scattering and homogeneity class and angular properties class
- ▶ Easy operation, even with welding gloves
- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Large field of vision
- ▶ Welding mask with rear centre of gravity, very light, head and neck-friendly

Best marks
1/1/1/1 in the
classification

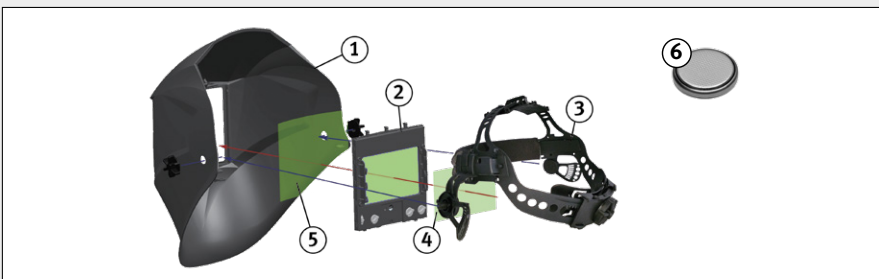


VarioProtect®
solar power
TRUE COLOUR
DISPLAY



Model	VarioProtect XXL-W-2 TC			
Colour	carbon	red	orange	blue
Art. no.	1654025	1654025-2	1654025-3	1654025-4

Filter cassette	
Viewing window (W x H)	mm 100 x 73
Light-dark response time	ms 0.3
Dark-light brightening time	ms 300 – 900
Dark protection level	DIN 4-13
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 4
Solar cells	Yes
Battery type	Lithium battery (CR2450)
Replaceable battery	Yes
Number of sensors	4
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Polyamide
Dimensions and weights	
Dimensions approx. (L x W x H)	mm 244 x 295 x 323
Weight approx.	g 430



ACCESSORY VarioProtect XXL-W-2 TC			
No.	Designation	PU	Art. no.
5	Outer attachment disc	10	1662075
4	Inner windscreen	10	1662076
3	Complete headband	1	1662032
	Forehead sweatband	1	1662023
2	Filter cassette	1	1662077
	Magnifying lens 2.0	1	1662036
	Centre sweatband (head / top)	1	1662050
	Rear sweatband (neck)	1	1662051
6	Lithium battery 3V CR2450	1	1662034



Welding helmets

VARIOPROTECT PANORAMA W S-TC

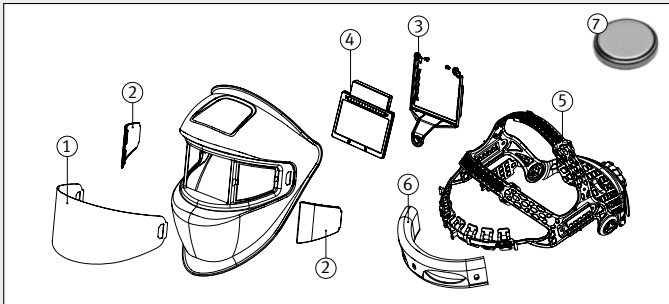
- Suitable for electrode, MIG/MAG and TIG welding and grinding
- Welding in true colour thanks to True Color Cassette in the main viewing window
- Comfortable welding with 180° field of view
- Side windows are automatically darkened as well

VarioProtect^{solar power}
TRUE COLOUR
DISPLAY



Best marks
1/1/1/1 in the
classification

Model	VarioProtect Panorama W TC silver
Art. no.	1654060
Filter cassette	
Viewing window (W x H)	100 x 67 mm
Light-dark response time	0.04 ms
Dark-light brightening time	150 – 800 ms
Dark protection level	DIN 5-9/9-13
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 3
Light level side windows	Protection level 5
Solar cells	Yes
Battery type	3V Lithium battery (CR2032)
Replaceable battery	Yes
Number of sensors	4
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Nylon
Dimensions and weights	
Dimensions (L x W x H) approx.	249 x 298 x 334 mm
Weight approx.	540 g



ACCESSORY VarioProtect Panorama W TC			
No.	Designation	PU	Art. no.
1	Outer attachment disc	10	1662140
	Inner windscreen	10	1662141
2	Inner side window set	2	1662142
3	Holding frame for filter cassette	1	1662143
4	Filter cassette	1	1662144
5	Forehead sweatband	1	1662122
6	Complete headband	1	1662123
7	Battery for VarioProtect CR2032	1	1662107

VARIOPROTECT XXL-W F-TC

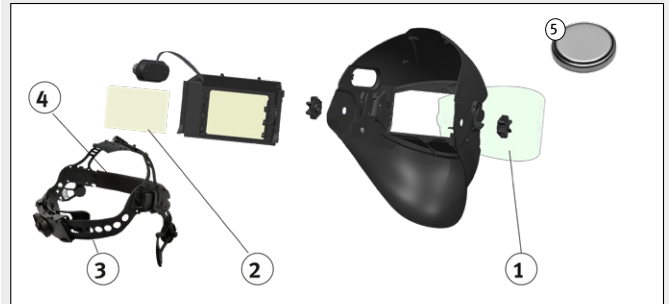
- Suitable for electrode, MIG/MAG and TIG welding and grinding
- Large field of vision
- Flip-up system: Cassette is folded up in the helmet, e.g. to be able to look directly through the clear protective disc when grinding
- Top marks in the assessment of optical class, scatter class, homogeneity class, and angle properties class

VarioProtect^{solar power}
TRUE COLOUR
DISPLAY



Best marks
1/1/1/1 in the
classification

Model	VarioProtect XXL-W F-TC
Art. no.	1654100
Filter cassette	
Viewing window (W x H)	100 x 65 mm
Light-dark response time	0.3 ms
Dark-light brightening time	
Dark protection level	DIN 4-13
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 4
Solar cells	Yes
Battery type	Lithium battery 3V CR2450
Replaceable battery	Yes
Number of sensors	4
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Polyamide
Dimensions and weights	
Dimensions (L x W x H) approx.	144 x 234 x 334 mm
Weight approx.	558 g



ACCESSORY VarioProtect XXL-W F-TC			
No.	Designation	PU	Art. no.
1	Outer attachment disc	10	1662060
2	Inner windscreen	10	1662061
3	Complete headband	1	1662032
4	Forehead sweatband	1	1662023
5	Lithium battery 3V CR2450	1	1662034
	Sweatband top of head	1	1662050
	Neck sweatband	1	1662051
	Magnifying lens 2.0	1	1662036

VARIOPROTECT 3XL-W DIGITAL TC

- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Extra large viewing window
- ▶ Digital filter cassette for simple and intuitive operation
- ▶ Toggling between grinding and welding modes without removing the helmet
- ▶ Large side windows

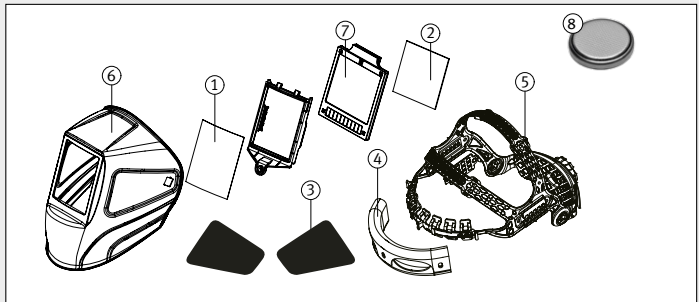
VarioProtect^{solar power}
**TRUE COLOUR
DISPLAY**



Best marks
1/1/1/1 in the
classification



Model	VarioProtect 3XL-W Digital TC
Art. no.	1654030
Filter cassette	
Viewing window (W x H)	100 x 93 mm
Light-dark response time	0.04 ms
Dark-light brightening time	60 – 1200 ms
Dark protection level	DIN 4-8/8-13
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 4
Solar cells	Yes
Battery type	2x 3V Lithium battery (CR2032)
Replaceable battery	Yes
Number of sensors	5
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Nylon
Dimensions and weights	
Dimensions (L x W x H) approx.	252 x 289 x 336 mm
Weight approx.	550 g



ACCESSORY VarioProtect 3XL-W Digital TC			
No.	Designation	PU	Art. no.
1	Outer attachment disc	10	1662100
2	Inner windscreen	10	1662136
3	Side window set	1	1662130
4	Forehead sweatband	1	1662122
5	Complete headband	1	1662123
6	Welding helmet housing	1	1662134
7	Filter cassette	1	1662135
	Magnifying lens 2.0	1	1662106
8	Lithium battery 3V CR2032	1	1662107

*Best marks in the evaluation of the optical class / scattering class / homogeneity class / class of angular properties

VARIOPROTECT PANORAMA-W DIGITAL TC

- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Welding in true colour thanks to True Color Cassette in the main viewing window
- ▶ Large 180° panoramic field of view
- ▶ Side windows are automatically darkened as well
- ▶ Digital filter cassette for simple and intuitive operation

VarioProtect[®]
TRUE COLOUR
DISPLAY



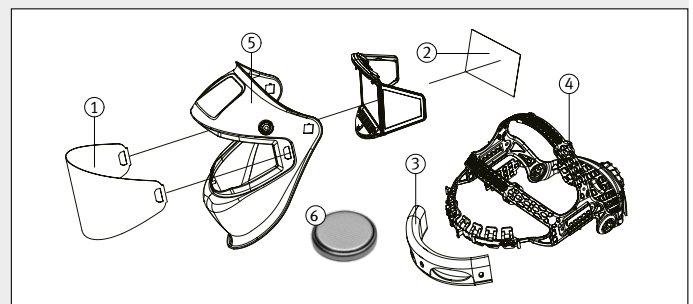
Internal digital adjustment



Best marks
1/1/1/1 in the
classification



Model	VarioProtect PANORAMA-W DIGITAL TC
Art. no.	1654040
Filter cassette	
Viewing window (W x H)	115 x 85 mm
Light-dark response time	0.04 ms
Dark-light brightening time	60 – 1200 ms
Dark protection level	DIN 4-8/8-14
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 4
Solar cells	Yes
Battery type	2x 3V Lithium battery (CR2032)
Replaceable battery	Yes
Number of sensors	5
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Nylon
Dimensions and weights	
Dimensions (L x W x H) approx.	249 x 296 x 334 mm
Weight approx.	570 g



ACCESSORY VarioProtect PANORAMA-W DIGITAL TC			
No.	Designation	PU	Art. no.
1	Outer attachment disc	10	1662120
2	Inner windscreen	10	1662121
3	Forehead sweatband	1	1662122
4	Complete headband	1	1662123
5	Welding helmet housing	1	1662124
6	Lithium battery 3V CR2032	1	1662107

VARIOPROTECT PANORAMA-W-2 TC AIR TH3

- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Welding in true colour thanks to True Color Cassette in the main viewing window
- ▶ Comfortable welding with 180° field of view
- ▶ Easy operation, even with welding gloves
- ▶ Highly efficient air filtration and air supply system provides the welder with clean and filtered air, preventing the inhalation of dangerous and harmful particles and welding vapours
- ▶ Even air distribution in the helmet

Best marks
1/1/1 in the
classification



VarioProtect
Panorama-W-2 TC



VarioProtect
Panorama-W-2 TC AIR



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VarioProtect^{solar power}

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Model	VarioProtect Panorama-W-2 TC AIR TH3
Art. no.	1654115
Technical data	
Viewing window	108x 73 mm
Power supply	Solar cells + replaceable batteries
UV/IR protection	Protection level 16 (permanent)
Dark protection level	DIN 4-13
Light level	Protection level 4
Number of sensors	4
Light-dark response time	0.3
Brightening time	continuously variable
Standards and approvals	
Class	1/1/1*
Welding mask	
Material	Polyamide
Blower respiratory protection	
Air flow	Level 1: 180 l/min / stage 2: 220 l/min
Filter type	TH3P R SL
Filter battery life	Level 1: 10 h / Level 2: 9 h
Dimensions and weights	
Dimensions (L x W x H) approx.	180 x 240 x 320 mm



ACCESSORIES Blower breath guard for VarioProtect Panorama-W-2 TC AIR TH3

No.	Designation	PU	Art. no.
1	Filters	1	1662065
2	Pre-filter	1	1662066
3	Spark arrester	1	1662067
4	Li-ion battery	1	1662068
5	Belt	1	1662069
	Air hose	1	1662070
	Charger	1	1662071
6	Filter cover	1	1662072
7	Fabric face shield	1	1662079

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

Welding helmets

VARIOPROTECT XXL-W F-TC AIR TH3 - Automatic welding helmet. Welding in true colours and with clean breathing air

VarioProtect[®] solar power

- ▶ Suitable for electrode, MIG/MAG and TIG welding and grinding
- ▶ Welding in true colours thanks to True Colour cassette
- ▶ Flip-up system: Cassette is folded up in the helmet, e.g. to be able to look directly through the clear protective disc when grinding
- ▶ Highly efficient air filtration and air supply system provides the welder with clean and filtered air, preventing the inhalation of dangerous and harmful particles and welding vapours
- ▶ Two fan speeds selectable
- ▶ Even air distribution in the helmet
- ▶ Li-ION battery for up to 10 hours running time
- ▶ Easy operation, even with welding gloves
- ▶ Large field of vision
- ▶ Top marks in the assessment of optical class, scatter class, homogeneity class, and angle properties class
- ▶ Welding mask with rear centre of gravity, very light, gentle on the head and neck



Best marks
1/1/1/1 in the
classification

TRUE COLOUR DISPLAY



▶ Flip-up system



Scope of delivery:

- Welding helmet
- Air filter system
- Rechargeable Li-ion battery 14.8V / 2.6 Ah
- Battery charger
- Breathing tube with cover 1 m
- Hip belt
- Black carrier bag

Model	VarioProtect XXL-W F-TC AIR TH3
Art. no.	1654105
Filter cassette	
Viewing window (W x H)	100 x 65 mm
Light-dark response time	0.3 ms
Dark protection level	DIN 4-13
UV/IR protection	Protection level 16 (permanent)
Light level	Protection level 4
Solar cells	Yes
Battery type	Lithium battery 3V CR2450
Replaceable battery	Yes
Number of sensors	4
Standards and approvals	
Class	1/1/1/1*
Welding mask	
Material	Polyamide
Blower respiratory protection	
Air flow	Level 1: 180 l/min Level 2: 220 l/min
Filter efficiency	
Filter type	TH3P R SL
Filter battery life	Level 1: 10 h Level 2: 9 h
Battery type	Li-ON 14.8V 2.2Ah
Noise level	<60 dB
Dimensions and weights	
Dimensions (L x W x H) approx.	194 x 254 x 334 mm
Weight approx.	2600 g
Explanation of weight	Welding mask and blower respiratory protection

VARIOPROTECT XXL-W TC AIR TH3 - Welding in true colours and with clean breathing air

VarioProtect®
solar power

- ▶ Top marks in the assessment of optical class, scatter class, homogeneity class, and angle properties class
- ▶ Welding in true colours thanks to cassette
- ▶ 3 fan speeds selectable
- ▶ Air filter system supplies the welder with filtered, clean air and thus prevents the inhalation of dangerous and harmful particles and welding vapours
- ▶ High filter effect: 99.99% = 0.3µm
- ▶ Even air distribution in the fresh air helmet
- ▶ Easy operation, even with welding gloves

- ▶ Integrated Li-ION battery for up to 8 hours running time

Best marks
1/1/1/1 in the classification



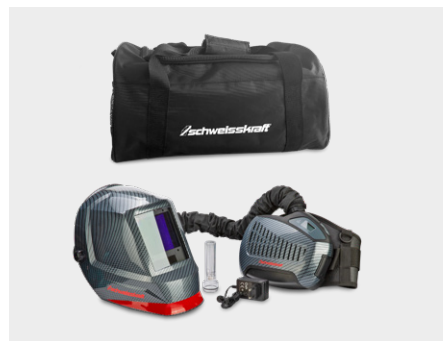
▶ Without fresh air filter system

Model	VarioProtect XXL-W F-TC AIR
Art. no.	1654056

Technical data	VarioProtect XXL-W TC AIR TH3
Art. no.	1654055
Welding mask	
Class	1/1/1/1
Viewing window	83.4 x 100 mm
Material	Nylon
Filter cassette	
Light-dark response time	0.08 ms
Dark-light brightening time	100 – 900 ms
Brightening time, dark-bright regulation	stepless
Dark protection level	5-9/9-13
UV/IR protection	Permanent DIN 15
Light level	Protection level 4
Number of sensors	4
On/Off	Fully automatic
Solar cells	Yes
Battery type	Lithium button battery CR2450 3V
Power supply	Solar cells + replaceable battery
Dimensions (L x W x H) approx.	114 x 133 x 9.5 mm
Blower respiratory protection	
Air flow	Level 1: 170 l/min Level 2: 200 l/min Level 3: 230 l/min
Filter efficiency	99.99% = 0.3µm
Filter type	TH3 P R SL
Filter battery life	Level 1: 8 h Level 2: 6 h Level 3: 4 h
Battery type	Rechargeable Li-ion battery (4400 mAh)
Noise level	< 73 dB
Dimensions and weights	
Total weight approx.	2463
Explanation of weight	Welding mask, filter, belt, battery

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beratung@schweisskraft.de



Scope of delivery:

- Welding helmet with air filter system
- Battery charger
- Breathing tube with cover
- Air flow tester
- Padded hip belt with double shoulder strap
- Black carrier bag

Welding helmets

Welding fumes are hazardous to health! Ways to avoid welding fumes:

Welding fume reduction with a welding system that produces less welding fumes due to its arc

► Approximately 5.2 g of welding fumes are produced by one 1 kg roll of SG wire, which are very hazardous to health.

VarioProtect XXL-W TC AIR

The most effective solution: The welding operator receives filtered air directly into the helmet.

► To prevent illness, the VarioProtect XXL-W TC AIR TH3 is a safe alternative for worry-free welding work.



Welding fumes produced when welding 1kg of SG wire

Filter devices or welding fume extraction systems

For extracting welding fumes directly at the welding station

► The toxic welding fumes pose an increased risk of lung cancer for the welder and those in the immediate vicinity. Inhalation should be avoided at all costs.



► Welding in true colours thanks to True Colour cassette

ACCESSORY VarioProtect XXL-W TC AIR

No.	Designation	PU	Art. no.
1	Outer attachment disc	1	1662200
2	Inner windscreen	1	1662201
3	Headband complete with air tube	1	1662255
4	Forehead sweatband	1	1662203
5	Replacement filter cassette	1	1662204
6	Welding helmet housing	1	1662256
7	Filter cover	1	1662250
8	TH3 filter	1	1662251
9	Pre-filter	1	1662208
10	Spark arrester	1	1662209
11	Air filter system	1	1662252
12	Li- ION battery	1	1662211

ACCESSORIES

No.	Designation	PU	Art. no.
13	Air hose	1	1662253
14	Belt harness	1	1662213
15	Charger	1	1662214
16	Air flow tester	1	1662215
17	Filter cassette holder frame	1	1662216
18	Lithium battery 3V CR2450	1	1662007
19	Clamping nut	1	1662219
20	Clamping screw set	1	1662220
23	Mounting frame of the filter cassette	1	1662221
Accessories			
21	Magnifying lens 2.0	1	1662217
22	Fabric protection	1	1662254
24	Spacer disc	1	1662257
25	Angle adjustment	1	1662258

Welding fumes are hazardous to health! Ways to avoid welding fumes:

Welding fume reduction with a welding system that produces less welding fumes due to its arc

- ▶ Approximately 5.2 g of welding fumes are produced by one 1 kg roll of SG wire, which are very hazardous to health.

VarioProtect XXL-W F-TC AIR

The most effective solution: The welding operator receives filtered air directly into the helmet.

- ▶ To prevent illness, the VarioProtect XXL-W TC AIR is a safe alternative for worry-free welding work.



Welding fumes produced when welding 1kg of SG wire

Filter devices or welding fume extraction systems

For extracting welding fumes directly at the welding station

- ▶ The toxic welding fumes pose an increased risk of lung cancer for the welder and those in the immediate vicinity. Inhalation should be avoided at all costs.



- ▶ Maximum wearing comfort thanks to easily adjustable headband
- ▶ Interchangeable headband and sweatband



- ▶ Large viewing window 100 x 65 mm
- ▶ Welding in true colours thanks to True Colour cassette
- ▶ Stepless adjustment of the dark protection level and sensitivity
- ▶ Setting the brightening time
- ▶ Toggling between grinding and welding mode



- ▶ The dark protection level and sensitivity can be adjusted continuously and easily from outside the helmet, even when wearing welding gloves.
- ▶ Toggling between grinding and welding modes without removing the helmet



- ▶ Fabric protection protects against welding fumes and keeps fresh air in the helmet at the same time



ACCESSORY VarioProtect XXL-W F-TC AIR

No.	Designation	PU	Art. no.
1	Outer attachment disc	1	1662060
2	Inner windscreen	1	1662061
3	Complete headband	1	1662032
4	Forehead sweatband	1	1662023
5	Hepa filter TH3P R SL	1	1662065
6	Pre-filter	1	1662066
7	Spark arrester	1	1662067
8	Li-ion battery	1	1662068

ACCESSORY VarioProtect XXL-W F-TC AIR

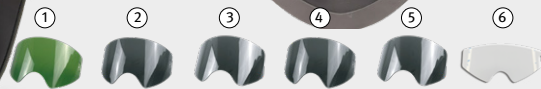
No.	Designation	PU	Art. no.
9	Belt	1	1662069
10	Air hose	1	1662070
11	Charger	1	1662071
12	Magnifying lens 2.0	1	1662036
13	Lithium battery 3V CR2450	1	1662034
14	Filter cover	1	1662072
	Filter cassette	1	1662073
	Sweatband top of head	1	1662050
	Neck sweatband	1	1662051

Welding helmets

VARIOPROTECT GRIND - Grinding helmet

- ▶ Ideal for grinding applications, metalworking and woodworking
- ▶ Unrestricted and clear view
- ▶ Maximum wearing comfort thanks to optimum fit and easily adjustable headband
- ▶ Light weight

Model		VarioProtect GRIND
Art. no.		1654200
Mask		
Lens power		1.0
Material		Nylon
Working temperature	°C	-5 – +55
Storage temperature	°C	-10 – +55
Standards		CE, ANSI, CSA, AS/NZS
Dimensions (L x W x H) approx.	mm	350 x 250 x 190
Weight approx.	g	385



No.	ACCESSORY	Art. no.
1	Visor DIN2	1662242
2	Visor DIN3	1662243
3	Visor DIN4	1662244
4	Folding visor DIN5	1662245
5	Folding visor DIN8	1662246
	Folding device	1662241
6	Protective film for viewing window	1662247

VARIOPROTECT GRIND-AIR TH3 - Face and respiratory protection against chips and dust generated during cutting and grinding

- ▶ Ideal for grinding applications, metalworking and woodworking
- ▶ Unrestricted and clear view
- ▶ Maximum wearing comfort thanks to optimum fit and easily adjustable headband
- ▶ Air filter system TH 3 for continuous supply of filtered, clean air without inhaling dangerous and harmful particles
- ▶ High filter effect: 99.996% = 0.3µm
- ▶ Three fan speeds selectable
- ▶ Even air distribution in the fresh air helmet
- ▶ Li-ION battery for up to 8 hours running time
- ▶ Light weight

VarioProtect®

Grinding dust is hazardous to health!

VarioProtect GRIND AIR

The most effective solution: The user receives filtered air directly into the helmet.

The VarioProtect GRIND AIR is a safe alternative that will help you to prevent illness and enjoy carefree welding work.



Fabric face shield

Art. no.	€ plus VAT
1662079	19.90



Technical data	VarioProtect GRIND AIR TH3
Art. no.	1654205
Mask	
Material	Nylon
Lens power	1 mm
Working temperature	-55 – +55 °C
Blower respiratory protection	
Air flow	Level 1: 170 l/min Level 2: 200 l/min Level 3: 230 l/min
Filter efficiency	99,996% (0.3µm)
Filter type	TH3 P R SL
Filter battery life	Level 1: 8 h Level 2: 6 h Level 3: 4 h
Battery type	Rechargeable Li-ion battery (4400 mAh)
Battery weight	350 g
Sound pressure level	< 73 dB(A)
Standards	CE, ANSI, CSA, AS/NZS
Dimensions (L x W x H) approx.	460 x 250 x 250 mm
Weight approx.	735 g
Explanation of weight	Welding mask, filter, belt, battery

SCOPE OF DELIVERY:

- Welding helmet with air filter system
- TH3 air filter system
- Rechargeable Li-ion battery (4400 mAh)
- Battery charger
- Breathing tube and cover (1 m)
- Flow meter
- Padded hip belt and double shoulder strap
- Black carrier bag



No.	ACCESSORY	Art. no.
1	Visor DIN2	1662242
2	Visor DIN3	1662243
3	Visor DIN4	1662244
4	Folding visor DIN5	1662245
5	Folding visor DIN8	1662246
	Folding device	1662241
6	Protective film for viewing window	1662247

VARIOPROTECT GRIND AIR

with connection for fresh air filter system

- ▶ Headband with connection for Schweisskraft fresh air filter systems of the articles 1654205, 1654050 and 1654055

Model	VarioProtect GRIND AIR
Art. no.	1654206
Mask	
Lens power	1.0
Material	Nylon
Standards and approvals	
Standards	CE, ANSI, CSA, AS/NZS
Dimensions and weights	
Dimensions (L x W x H) approx.	460 x 250 x 250 mm
Weight approx.	550 g



Headband with connection for Schweisskraft fresh air filter systems



▶ For Art. no.1654050



▶ For Art. no.1654055



▶ For Art. no.1654205



- ▶ Maximum wearing comfort thanks to easily adjustable headband
- ▶ Interchangeable headband and sweatband



- ▶ Large viewing window with unrestricted and clear view



- ▶ LCD for filter, battery status and air flow



- ▶ Fabric protection protects against welding fumes and keeps fresh air in the helmet at the same time



No.	ACCESSORY	Art. no.
1	Fabric face shield	1662230
2	Air filter system	1662231
3	Transparent pane (requires 1662239)	1662232
4	Pane mounting	1662239
5	Seal for transparent pane	1662233
6	Complete headband	1662237
7	Forehead sweatband	1662238
8	Filter cover	1662206
9	TH3 filter	1662251
10	Pre-filter	1662208
11	Spark arrester	1662209
12	Li-ion battery	1662211

No.	ACCESSORY	Art. no.
13	Air hose	1662212
14	Belt harness	1662213
15	Charger	1662214
16	Air flow tester	1662215
	Attachment to safety helmet	1662240
17	Visor DIN2	1662242
18	Visor DIN3	1662243
19	Visor DIN4	1662244
20	Folding visor DIN5	1662245
21	Folding visor DIN8	1662246
	Folding device	1662241
22	Protective film for viewing window	1662247

Welding accessories



HAND PROTECTION SHIELD D

Art. no.

Hand protection shield D

1600610

- ▶ made of diamond fibre, straight version
- ▶ for glass size 90 x 110 without safety glass



HAND PROTECTION SHIELD G

1600620

- ▶ made of fibreglass, cranked design
- ▶ for glass size 90 x 110 without safety glass



CLEAR-VIEW HAND SHIELD G

1600600

- ▶ made of fibreglass, cranked design
- ▶ with insulated mechanism for glass size 90 x 110 without protective glasses



HEAD PROTECTION SHIELD G

1600710

- ▶ Fibreglass with headband
- ▶ for glass size 90 x 110 without safety glass



HEADBAND

Art. no.

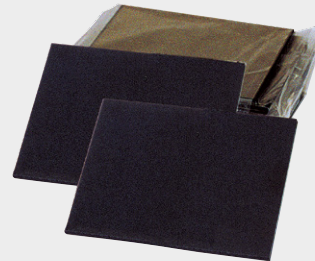
with ratchet adjustment

1600711

- ▶ for head protection shield G
- ▶ steplessly adjustable
- ▶ with forehead sweatband

for head protection shield P

1600721



WELDER'S PROTECTIVE GLASSES

Art. no.

90 x 110 according to DIN

9 A DIN

1601009

10 A DIN

1601010

11 A DIN

1601011

12 A DIN

1601012

13 A DIN

1601013

mirrored 90 x 110 according to DIN

9 A DIN mirrored

1601109

10 A DIN mirrored

1601110

11 A DIN mirrored

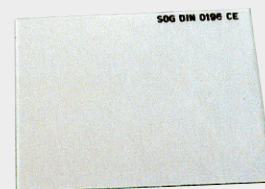
1601111

12 A DIN mirrored

1601112

13 A DIN mirrored

1601113



COVER GLASS (CLEAR)

Art. no.

90 x 110

1601300

40 x 110

1601301

1000 Hourglass 90 x 110

Plastic CR 39

1601310

MIG/MAG WELDER'S GLOVE BASIC

Particularly suitable for MIG/MAG

- ▶ Very soft and supple premium cow split leather
- ▶ Fleece lining for high comfort
- ▶ Long cuff to protect against sweat beads



- ▶ Thanks to the seamless index finger, gripping is easier and dexterity is improved.

Model	Size L	Size XL
Art. no.	1616110L	1616110XL
Delivery quantity	1 pack = 10 pair	

Standards and approvals		
EN 407:2004, Thermal risks	413X4X	
EN 388:2016, Mechanical risks	3144X	
DIN EN 12477:2001	Version A	

Dimensions		
Hand circumference, approx.	240 mm	270 mm
Length approx.	355 mm	360 mm

TIG WELDER'S GLOVE BASIC

Ideal for TIG welding with high dexterity

- ▶ Goatskin leather palm with split leather cuff
- ▶ Back of the hand made from cow split leather
- ▶ Long cuff to protect against sweat beads



Model	Size M	Size L	Size XL
Art. no.	1616120M	1616120L	1616120XL
Delivery quantity	1 pack = 10 pair		

Standards and approvals			
EN 407:2004, Thermal risks	413X4X		
EN 388:2016, Mechanical risks	2111X		
DIN EN 12477:2001	Version B		

Dimensions			
Hand circumference, approx.	220 mm	240 mm	270 mm
Length approx.	328 mm	330 mm	340 mm

MIG/MAG WELDER'S GLOVE PRO

Particularly suitable for MIG/MAG with double-layer palm

- ▶ Very soft and supple premium cow split leather
- ▶ Fleece lining for high comfort
- ▶ Long cuff to protect against sweat beads



- ▶ Thanks to the seamless index finger, gripping is easier and dexterity is improved.



- ▶ Palm made from double-layer cowhide leather

Model	Size L	Size XL
Art. no.	1616111L	1616111XL
Delivery quantity	1 pack = 10 pair	

Standards and approvals		
EN 407:2004, Thermal risks	413X4X	
EN 388:2016, Mechanical risks	3144X	
DIN EN 12477:2001	Version A	

Dimensions		
Hand circumference, approx.	240 mm	270 mm
Length approx.	355 mm	360 mm

TIG WELDER'S GLOVE PRO

Ideal for TIG welding with high dexterity, palm with foam lining

- ▶ Goatskin palm and back with goat split leather cuff
- ▶ Long cuff to protect against sweat beading
- ▶ Palm with foam lining for increased comfort



- ▶ Thanks to the seamless index finger, gripping is easier and dexterity is improved.

Model	Size M	Size L	Size XL
Art. no.	1616121M	1616121L	1616121XL
Delivery quantity	1 pack = 10 pair		

Standards and approvals			
EN 407:2004, Thermal risks	413X4X		
EN 388:2016, Mechanical risks	2111X		
DIN EN 12477:2001	Version B		

Dimensions			
Hand circumference, approx.	220 mm	240 mm	270 mm
Length approx.	325 mm	330 mm	338 mm

Welding accessories

WELDING JACKET with fabric back -

Pleasant wearing comfort and high level of safety when welding

- ▶ Front and sleeves made of heat- and fire-resistant split cow leather
- ▶ Leather splash guard on the front strip
- ▶ The back is made of flame-retardant fabric for a cooler feel.



Model	Size L	Size XL
Art. no.	1616200L	1616200XL
Delivery quantity	1 pcs.	

LEATHER WRIST GUARDS 48 cm -

Very durable, made of heat and fire-resistant leather

- ▶ Velcro fastener on the upper arm and wrist



Model	Leather wrist guard 48 cm
Art. no.	1616400
Delivery quantity	1 pairs

Technical data	
Length	400 mm

WELDING APRON 100 x 60 cm –

Individually adjustable welding apron made of split leather

- ▶ Front and sleeves made of heat- and fire-resistant split cow leather
- ▶ Leather splash guard on the front strip
- ▶ The back is made of flame-retardant fabric for a cooler feel.



Model	Welding apron 100 x 60 cm
Art. no.	1616300
Delivery quantity	1 pcs.

Dimensions	
Length approx.	1070 mm
Width approx.	630 mm

GAITERS 300 -

Leg and foot protection made of heat and fire-resistant leather

- ▶ Stress points riveted or reinforced with two layers of leather



Model	Gaiters 300
Art. no.	1616500
Delivery quantity	1 pairs

Technical data	
Shaft height	300 mm



FULL-VISION GOGGLES	Art. no.	PU
colourless	1600100	10
<ul style="list-style-type: none"> ▶ Made of flexible, crystal-clear plastic ▶ Ventilation opening covered with sieve ▶ Suitable for acid, vapours, dust and sanding ▶ according to EN 166 B 0196 CE 		



NYLON SAFETY GOGGLES	Art. no.	PU
adjustable, colourless, splinter-free	1600500	10
adjustable, 5 A DIN	1600505	10
<ul style="list-style-type: none"> ▶ Bracket adjustable in length and inclination ▶ Lightweight and comfortable design ▶ Mould pane 66 x 56 mm curved 		



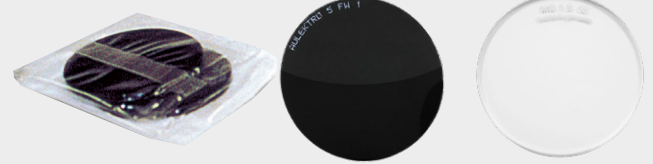
WELDER'S GOGGLES	Art. no.	PU
colourless, splinter-free	1600200	10
5 A DIN	1600205	10
<ul style="list-style-type: none"> ▶ for DIN jars 50 mm diameter 		



NYLON SAFETY GOGGLES	Art. no.	PU
colourless, splinter-free	1600400	10
5 A DIN	1600465	10
<ul style="list-style-type: none"> ▶ Simple pane change with knurled screw ▶ Soft frame ▶ for DIN jars 50 mm diameter 		



WELDER'S GOGGLES	Art. no.	PU
Can be folded up	1600305	10
<ul style="list-style-type: none"> ▶ soft and stable PVC body ▶ Also suitable for spectacle wearers ▶ DIN glasses can be folded up, colourless glasses underneath ▶ for DIN jars 50 mm diameter, colourless, shatterproof and 5 A DIN ▶ according to EN 166 3 4 F 0196 CE 		

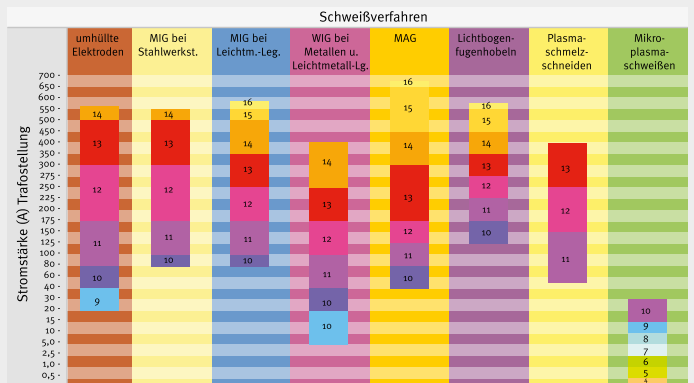


DIN GLASSES	Art. no.	PU
5 A DIN	1600805	10
round, 50 mm diameter		
colourless, splinter-free	1600800	10
round, 50 mm diameter		

Protective welding glass and its use in gas welding 3-8 FW 1 DIN

How to read the table correctly!

Determine the current in amperes (A) at the transformer for your selected welding process. The current intensity can be read off the vertical number line in the diagram. Now move horizontally from the read amperes to the column for the welding process used. Now you can easily read off the protection level to be used (number in the respective rectangle).



Protection level Flame cutting (L.-oxygen/hour)

3 FW 1 DIN	Light flame cutting work
4 FW 1 DIN	< 900 l
5 FW 1 DIN	900 - 2000 l
6 FW 1 DIN	2000 - 4000 l
7 FW 1 DIN	4000 - 8000 l
8 FW 1 DIN	> 8000 l

Protection level Flame cutting (L.-oxygen/hour)

3 FW 1 DIN	Light flame cutting work
4 FW 1 DIN	< 900 l
5 FW 1 DIN	900 - 2000 l
6 FW 1 DIN	2000 - 4000 l
7 FW 1 DIN	4000 - 8000 l
8 FW 1 DIN	> 8000 l



LED LIGHT	Art. no.
for welding helmet	1662260
<ul style="list-style-type: none"> ▶ Fits: Art. no. 1651000, 1654025, 1654025-2, 1654025-3, 1654025-4, 1651005, 1654030 	

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

TransEco protective barrier

Protective wall via 2 stands adjustable and mobile

- ▶ Can be combined and extended as required with many advantages:
- ▶ Protection against radiation during arc welding
- ▶ Protection against dirt, moisture, draughts and disruptive sunlight
- ▶ Visual protection during welding and grinding
- ▶ Simple assembly, tubular steel frame, powder-coated
- ▶ Covering made of TransTec films in proven quality
- ▶ Stable as individual walls, cubicles or complete workplace partitions
- ▶ Space-saving packaging (dispatch with parcel service possible)
- ▶ Certified according to DIN EN 1598, hazard factor < 1

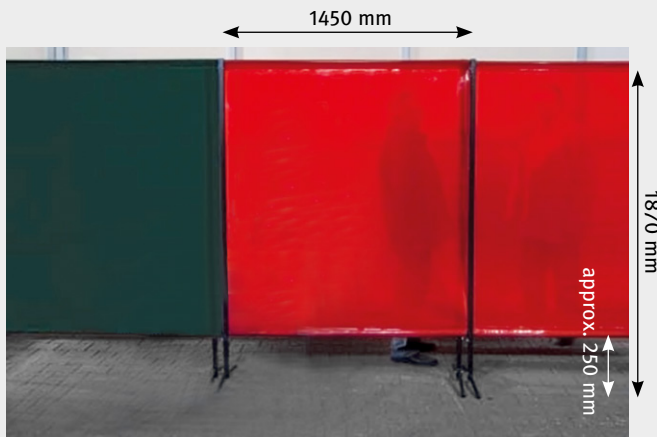


Illustration shows several crash barriers lined up next to each other

TRANSECO PROTECTIVE BARRIER	Weight approx.	Art. no.
1450 V red-orange 1450 x 1870 mm	9.3 kg	1611450
1450 V dark green dull 1450 x 1870 mm	9.3 kg	1611451
2050 V red-orange 2050 x 1870 mm	10.5 kg	1612000
2050 V dark green dull 2050 x 1870 mm	10.5 kg	1612001

Supplied as a kit with assembly instructions for self-assembly (applies to TransEco and TransFlex)

TransFlex protective barrier

Safety barrier mobile and portable

- ▶ Flexibly adaptable to changing welding situations
- ▶ Inexpensive protection as a single wall
- ▶ Also ideal as a combination of several walls
- ▶ Easy to install
- ▶ Ground clearance 300 mm
- ▶ Certified in accordance with DIN EN 1598, hazard factor < 1
- ▶ The TransFlex is based on a robust welded frame made of square and 1-inch round tubes, which are fully powder-coated.
- ▶ TransFlex base units are mobile and 2100 mm wide
- ▶ 2 arms as cantilevers 800 mm wide
- ▶ 3 curtains in 2 versions: red-orange or dark green dull, each 1300 mm wide x 1600 mm high, without hem
- ▶ 4 roller Ø 100 mm, 2 with brakes



Illustration shows scope of delivery in assembled condition

TRANSFLEX PROTECTIVE BARRIER WITH CURTAIN	Weight approx.	Art. no.
unhemmed, red-orange 3700 x 1950 mm	35 kg	1613000
unhemmed, dark green dull, 3700 x 1950 mm	35 kg	1613001

Application example:



Two TransFlex safety barriers combined to form a closed cabin. Outer walls and cantilevers can be swivelled



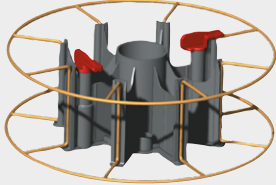
BASKET COIL ADAPTER

KA 1

▶ pluggable

Art. no.

1110001



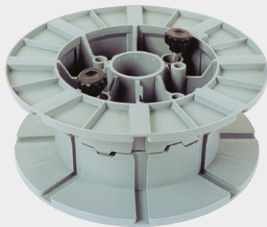
BASKET COIL ADAPTER

KA 2

▶ with quick-release fastener

Art. no.

1110005



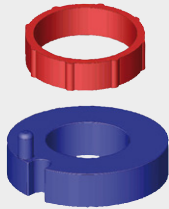
BASKET COIL ADAPTER

KA 3

▶ two-part

Art. no.

1110006



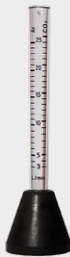
CENTRING ADAPTER

for D 200 coils

▶ two-part

Art. no.

1110007



GAS FLOW METER

for CO² + argon

Art. no.

1251100



MIG/MAG SPECIAL TONG

Size 1, for 12-15 mm nozzles

Size 2, for 15-18 mm nozzles

▶ Fast and accurate cutting of the welding rod
▶ Time-saving cleaning of the shielding gas nozzle, removal of the shielding gas nozzle, loosening and tightening of the contact tip

Art. no.

1091000

1092000

ACCESSORIES FOR ARGON/CO₂ PRESSURE REDUCER

(Art. no. 1700054)

with content and flow manometer

Max. pressure: 200 bar

Max. flow rate: 15 l/min

Connection: W 21.8 x 1/14"-1/4"

For gases: Argon, mixture Ar/CO², CO²

According to standard: EN 2503, EN 13918



1700451

1700452

1700054

Designation

Small welding force, Ø 50 mm

Contents pressure gauge Ø 50 mm 0-315 bar

Flow manometer Ø 50 mm 0-15 l/min

Art. no.

1700054

1700451

1700452

ACCESSORIES FOR ARGON/CO₂ PRESSURE REDUCER

(Art. no. 1700050)

with content and flow manometer

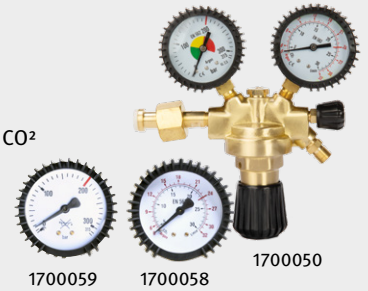
Max. pressure: 200 bar

Max. flow rate: 30 l/min

Connection: W 21.8 x 1/14"-1/4"

For gases: Argon, mixture Ar/CO², CO²

According to standard: EN 2503, EN 13918



1700059

1700058

1700050

Designation

Large welding force, Ø 63 mm

Contents pressure gauge Ø 63 mm 0-315 bar

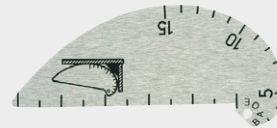
Flow manometer Ø 63 mm 0-30 l/min

Art. no.

1700050

1700059

1700058



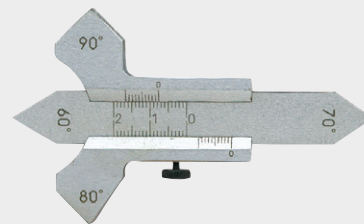
WELDING SEAM GAUGE

SL 1

▶ made of aluminium

Art. no.

1252201



WELDING SEAM GAUGE

SL 2

▶ Precision version for measuring flat weld seams and weld seams in corners 60°/80°/90°

Art. no.

1252202



NOZZLE SPRAY

400 ml (VE 12)

▶ anhydrous
▶ Silicone-free, odourless and CFC-free
▶ Plant-based release agent

Art. no.

1096401

Welding accessories



PRATICA

	Art. no.
Pratica 1 (200 A- 35% duty cycle/electrodes max. 3.2 mm)	1240123
Pratica 2 (350 A- 35% duty cycle/electrodes max. 5 mm)	1240143
Pratica 3 (520 A- 35% duty cycle/electrodes max. 8 mm)	1240163

► Insulated in accordance with EN 60974-11 with break-proof insulating shells made of hard glass fibre for Allen cable lug connection

INSULATING SHELLS FOR ELECTRODE HOLDERS

	Art. no.	€ plus VAT
for Pratica 1	1240124	1.05
for Pratica 2	1240144	1.39
for Pratica 3	1240164	2.50



ELECTRODE HOLDER

	Art. no.
Electrode holder Superior 4	1240040

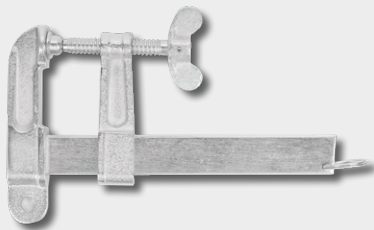
► 250 A - 35% duty cycle/200 A - 60% duty cycle/electrodes 2.4-4 mm/
Cable 25-35 mm²/480 gr. Handle and head fire and heat resistant

► Brass body with insulated compression spring

► Clamping the electrode by turning the electrode holder head

► with cable lug connection

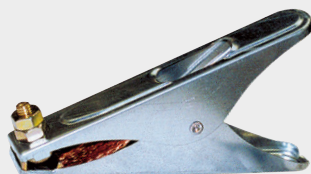
► in accordance with EN 60974-11 and IEC 974-11, B200 TÜV CE



POLE WELDING CLAMP

	Art. no.
made of steel 400 A	1250140
made of steel 600 A	1250160

► Malleable cast iron, span 150 mm, throat depth 80 mm, with cable relief



EARTH CLAMPS

	Art. no.
200 A, with copper braiding, 180 mm, M6	1240220
400 A, w. stranded copper wire, pole connect. Brass strap, 200 mm, M10	1240240
Earth clamp 500A	1240260



NEVADA EARTH CLAMPS ACCORDING TO BS 638-5 CE

	Art. no.
Nevada 3 (300 A - 60%/400 A - 35%)	1240235
Nevada 5 (400 A - 60%/500 A - 35%)	1240265



COMPRESSION CABLE LUGS

	Art. no.	PU
16 mm ²	1250416	10
25 mm ²	1250425	10
35 mm ²	1250435	10
50 mm ²	1250450	10
70 mm ²	1250470	10



SCREW CABLE LUGS

	Art. no.	PU
CU 25 mm ²	1250525	10
CU 35 mm ²	1250535	10
CU 50 mm ²	1250550	10
CU 70 mm ²	1250570	10



MAGNETIC POLE CLAMP

	Art. no.
MPK 400A	1240340
MPK 600A	1240360

► Very good magnetic adhesion to pipes



SLAG HAMMER

	Art. no.
Slag hammer	1250300

► approx. 440 g

► Oval tube Ø 28 mm

► All steel



WELDING SITE EQUIPMENT	Art. no.
SPA 16 mm ² /KS 10-25 mm ² / Pratica 1/ Earth clamp 200 A	1240400
SPA 25 mm ² /KS 35-50 mm ² / Pratica 1/ Earth clamp 200 A	1240445
SPA 35 mm ² /KS 35-50 mm ² / Pratica 2/ Earth clamp 600 A	1240450

- ▶ Welding cable PVC 5 m with electrode holder and welding cable plug
- ▶ PVC ground cable 3 m with earth clamp and welding cable plug
- ▶ Slag hammer
- ▶ Wire brush, 2-row
- ▶ Polypropylene hand protection shield (CE)
- ▶ Welding glass DIN 9
- ▶ Cover glass 90 x 110 millimetres
- ▶ Gloves 5-finger



WELDING CABLE 5 m prefabricated	Art. no.
25 mm ² /10-25mm ² /9 mm spigot/M8	1250227
35 mm ² /16-35mm ² /13 mm spigot /M10	1250236
50 mm ² /35-50mm ² /13 mm spigot /M10	1250252

- ▶ according to H01 N2 D VDE 0250
- ▶ 5 m complete with welding cable plug and compression cable lug
- ▶ for attaching an earth clamp or electrode holder



WELDING CABLE	Art. no.
16 mm ² per metre	1250316
25 mm ² per metre	1250325
35 mm ² per metre	1250335
50 mm ² per metre	1250350
70 mm ² per metre	1250370

- ▶ according to H01 N2 D VDE 0250, part 6
- ▶ High flexibility
- ▶ Resistance to cold and heat, flame retardant



GROUND CABLE 4m complete with earth clamp	Art. no.
16 mm ² , KS 25/9 mm, clamp 200A	1250215
25 mm ² , KS 25/9 mm, clamp 200A	1250224
16mm ² , KS50/13mm, clamp 200A	1250216
25mm ² , KS50/13mm, clamp 200A	1250225
35mm ² , KS50/13mm, clamp 400A	1250235
50mm ² , KS50/13mm, clamp 600A	1250250
70mm ² , KS70/13mm, clamp 600A	1250270



WELDING CABLE 4 m complete with electrode holder	Art. no.
16mm ² , KS25/9mm, electrode holder 260A	1250353
25mm ² , KS25/9mm, electrode holder 260A	1250354
16mm ² , KS50/13mm, electrode holder 260A	1250360
25mm ² , KS50/13mm, electrode holder 260A	1250361
35mm ² , KS50/13mm, electrode holder 400A	1250362
50mm ² , KS50/13mm, electrode holder 600A	1250363
70mm ² , KS50/13mm, electrode holder 600A	1250364



WELDING CABLE COUPLING PLUG	Art. no.	PU
KS 25, 10-25 mm ²	1250635	10
KS 50, 35-50 mm ²	1250650	10



WELDING CABLE COUPLING SOCKET	Art. no.	PU
KB 25, 10-25 mm ²	1250735	10
KB 50, 35-50 mm ²	1250750	10



WELDING CABLE INSTALLATION SOCKET	Art. no.	PU
EB 25, 10-25 mm ²	1250836	10
EB 50, 35-50 mm ²	1250851	10



WELDING RODS & WELDING CONSUMABLES



Welding wires

Low alloyed welding rods - Chemical composition

(standard values % of the weld metal)

Material no.	Designation	C	Si	Mn	Cr	Ni	Cu
1615	G II	0.15	0.2	0.9	-	-	-

Medium-alloy welding rods – Chemical composition

(standard values % of the weld metal)

Material no.	Designation	C	Si	Mn	Cr	Ni	Cu
1615	G III	0.09	0.1	1.1	0.4	-	-

High-alloy welding rods – Chemical composition

(standard values % of the weld metal)

Material no.	AWS/AISI	DIN	C max.	Si	Mn	Ni	Cr	Mo	Nb min.	S max.	P max.
1.4316	308L-Si	X 2 CrNi 19 9	0.025	0.8	1.7	10	20	-	-	0.015	0.02
1.4551	347-Si	X 5 CrNiNb 19 9	0.07	0.7	1.7	10	19.5	-	12 x C	0.015	0.02
1.4430	316L-Si	X 2 CrNiMo 19 12	0.025	0.8	1.7	12	18	2.7	-	0.015	0.02
1.4576	318	X 5 CrNiMoNb 19 12	0.05	0.7	1.4	11.5	18.5	2.6	12 x C	0.015	0.02
1.4370	307-Si	X 10 CrNiMn 1 8 8 6	0.10	0.7	6.5	9	19	-	-	0.015	0.02
1.4842	310	X 12 CrNi 25 20	0.12	0.5	1.7	20.5	25	-	-	0.015	0.02

High-alloy welding rods - Mechanical properties

not heat-treated, at 20 °C, MIG welding with argon +2% oxygen, TIG and plasma welding with argon as shielding gas (standard values)

Material no.	Yield strength	Tensile strength	Elongation	Notched impact strength	Hardness
1.4316	450 N/mm ²	550 N/mm ²	40%	70 J	200 HB
1.4551	320 N/mm ²	580 N/mm ²	30%	65 J	220 HB
1.4430	330 N/mm ²	540 N/mm ²	35%	80 J	210 HB
1.4576	350 N/mm ²	590 N/mm ²	30%	50 J	220 HB
1.4842	300 N/mm ²	550 N/mm ²	30%	65 J	

Hard coatings - Chemical composition

(standard values % of the weld metal)

Material no.	DIN	C max.	Si	Mn	Cr	Ni	Mo	Nb min.	S max.	P max.
1.4718	MSG 6-60	0.5	3.0	0.4	9.2	-	-	-	-	-

Aluminium welding rods – Chemical composition

(standard values % of the weld metal)

Material no.	DIN	Mn	Mg	Cr max.	Ti max.	Si	Al	Miscellaneous
3.3536	AlMg 3	0.4	3.0	0.3	0.25	-	hereinafter	in accordance with DIN 1732
3.3556	AlMg 5	0.3	5.0	0.3	0.25	-	hereinafter	in accordance with DIN 1732
3.3548	AlMg 4,5 Mn	0.8	5.0	0.25	0.25	-	hereinafter	in accordance with DIN 1732
3.2245	AlSi 5	-	-	-	-	5.0	hereinafter	in accordance with DIN 1732

Aluminium welding rods – Mechanical properties

Material no.	Yield strength	Tensile strength	Elongation
3.3536	175-205 N/mm ²	80-100 N/mm ²	15-20 %
3.3556	100-135 N/mm ²	220-260 N/mm ²	15-25 %
3.3548	110-150 N/mm ²	275-335 N/mm ²	15-20 %
3.2245	min. 50 N/mm ²	120-150 N/mm ²	10-18 %

Aluminium welding rods - Use

Material no.	Ampere/rod Ø				
	0.8 mm	1.0 mm	1.2 mm	1.6 mm	2.4 mm
3.2245	75 - 150	95 - 210	110 - 240	150 - 350	220 - 500
3.3536	80 - 150	100 - 210	120 - 240	175 - 360	220 - 500
3.3556	80 - 150	100 - 210	120 - 240	175 - 360	220 - 500
3.3548	80 - 150	100 - 210	120 - 240	175 - 360	220 - 500

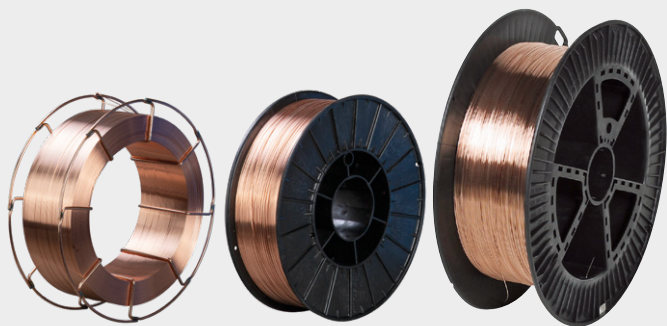
Tungsten electrode

Composition				
Abbreviation	Oxide additive		Impurities	Tungsten
	% m/m	Type	% m/m	% m/m
W	-	-	<_ 0,20	99.8
WT 20	0.35 to 0.55	ThO ₂	<_ 0,20	hereinafter
WC 20	1.80 to 2.20	CeO ₂	<_ 0,20	hereinafter

Labelling		
Abbreviation	Colour code according to RAL	
	Colour tone	Colour no.
W	green	6018
WT 20	red	3000
WC 20	grey	7011

Wire Ø	Ampere
1.6 mm	24-65 A
2.4 mm	60-120 A
3.2 mm	120-180 A
4.0 mm	150-225 A

MAG low-alloy steel welding wires



SG 2 MATERIAL NO. 1.5125 DIN 8559 / DIN EN 440

- ▶ for the following base materials:
Tubular steels St 35, St 45, St 52, St 55;
Thin sheets St 12, St 13, St 14
Shipbuilding steels A, B, C, D, E;
Boiler plates H 1, H 2, H 3; cast steel GS-38, GS-45, GS-52
Structural steels St 34, St 37, St 42, St 46, St 52, St 55, St 60
Fine-grained structural steels St E 26, St E 29, St E 32, St E 36, St E 39, St E 4
- ▶ Low-alloy wire electrode for joint and build-up welding
- ▶ Shielding gas: CO₂ and mixed gases

Basket coil K 300 spooled layers 15.0 kg	Art. no.
0.8 mm	1116008
1.0 mm	1116010
1.2 mm	1116012

Mandrel spool D 200 normal spool 5.0 kg	Art. no.
0.8 mm	1115008
1.0 mm	1115010

*Larger quantities on request.

SG 3 MATERIAL NO. 1.5130 DIN 8559 / DIN EN 440

- ▶ for the following base materials:
Tubular steels St 35, St 45, St 52, St 55;
Thin sheets St 12, St 13, St 14
Shipbuilding steels A, B, C, D, E;
Boiler plates H 1, H 2, H 3; cast steel GS-38, GS-45, GS-52
Structural steels St 34, St 37, St 42, St 46, St 52, St 55, St 60
Fine-grained structural steels St E 26, St E 29, St E 32, St E 36, St E 39, St E 4
- ▶ Low-alloy wire electrode for joint and build-up welding
- ▶ Shielding gas: CO₂ and mixed gases



Basket coil K 300 spooled layers 15.0 kg	Art. no.
0.8 mm	1117008
1.0 mm	1117010
1.2 mm	1117012

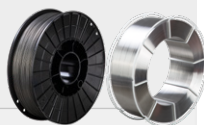
Filler wire – low alloy/rutile, for welding without gas DIN EN 758

Low alloy/rutile for the following base materials:
With MT-FD: St 33, St37-2 to St52-3, St37.4-St52.4, St35.8, St45.8, St37 to St52, HI, HII, 17 Mn 4

Mandrel coil D 200 normal spool 4.5 kg	Art. no.
MT-FD 0.9 mm	1132000

Basket coil K 300 spooled layers 15.0 kg	Art. no.
MT-CS 1.2 mm	1132001

With MT-CS: s185, S235JR, S355Jo, P295GH, P235GH, P265GH, S355GT



MIG Aluminium welding wires



Al Mg 3 Material no 3.3536 DIN 1732

- ▶ for the following base materials: Al Mg 3, Al Mn 1, Al Mg 1.8
- ▶ Welding of rolled and cast aluminium alloys
- ▶ Shielding gas: Pure argon or argon/helium mixture

Mandrel coil K 300 7.0 kg	Art. no.
1.0 mm	1123008
1.2 mm	1123010

AL MG 5 MATERIAL NO. 3.3556 DIN 1732

- ▶ for the following base materials: Al Mg 5, Al Mg 3, Al Mg Si 1, Al Mg 1
- ▶ Welding of rolled and cast aluminium alloys
- ▶ Shielding gas: Pure argon or argon/helium mixture

Mandrel coil D 300 7.0 kg	Art. no.
1.0 mm	1125010
1.2 mm	1125012

Al Si 5 Material no. 3.2245 DIN 1732

- ▶ for the following base materials: Al Mg Si 1, Al Zn 4.5 MG 1, Al Cu MG 1
- ▶ Shielding gas: Pure argon or argon/helium mixture

Mandrel coil D 300 7.0 kg	Art. no.
1.0 mm	1126010
1.2 mm	1126012

AL MG 4.5 MN MATERIAL NO. 3.3548 DIN 1732

- ▶ for the following base materials: Al Mg 4.5 Mn, Al Mg 3, Al Mg 5
- ▶ Welding of rolled and cast aluminium alloys
- ▶ Shielding gas: Pure argon or argon/helium mixture

Mandrel coil D 300 7.0 kg	Art. no.
1.0 mm	1124010
1.2 mm	1124012

Mandrel coil D 200 2.0 kg	Art. no.
1.0 mm	1124210

MIG welding wires for MSG brazing

CUSI 3 WELDING WIRE

For copper, low-alloyed copper and copper-zinc alloys welding on unalloyed or low-alloy steels and cast iron.

Small coil D200, 5 kg	Art. no.
Ø 0.8 mm	1131620
Ø 1.0 mm	1131619

Basket coil K300, 15 kg	Art. no.
Ø 0.8 mm	1131625
Ø 1.0 mm	1131624

CuAl 8 welding wire

For manganese and nickel-copper-aluminium alloys. For highly stressed corrosion-resistant build-up welding on unalloyed or low-alloy steels and cast iron.

Small spool D200, 5 kg	Art. no.
Ø 0.8 mm	1131630
Ø 1.0 mm	1131629

Basket coil K300, 15 kg	Art. no.
Ø 0.8 mm	1131635
Ø 1.0 mm	1131634

! Other dimensions, alloys, coil types and larger quantities on request.

Due to possible fluctuations in commodity prices, prices subject to change.

MAG Stainless steel welding wires



1.4316 DIN 8556: SG X 2 CR NI 19 9

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4311, 1.4303, 1.4310, 1.4319, 1.4541, 1.4550, 1.4552
- ▶ Connection and build-up welding on stainless and acid-resistant Cr and Cr-Ni steels.
- ▶ Not for use in high-sulphur media.
- ▶ For operating temperatures from -196°C to 350°C.
- ▶ Shielding gas: Argon S 1 - S 3, mixed gases

Mandrel coil D 300 15.0 kg	Art. no.
0.8 mm	1130208
1.0 mm	1130210
1.2 mm	1130212

Mandrel coil D 200 5.0 kg	Art. no.
0.8 mm	1130238
1.0 mm	1130231

1.4551 DIN 8556: SG X 5 CR NI NB 19 9

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4310, 1.4312, 1.4319, 1.4541, 1.4550
- ▶ TIG or MIG/MAG welding of stainless austenitic steels
- ▶ Not for use in high-sulphur media.
- ▶ For operating temperatures of up to 400°C, scale-resistant up to +800°C
- ▶ Shielding gas: Argon, mixed gases e.g. M11, M23

Mandrel coil D 300 15.0 kg	Art. no.
1.0 mm	1131610
1.2 mm	1131612

Hardfacing Shielding gas Welding wires



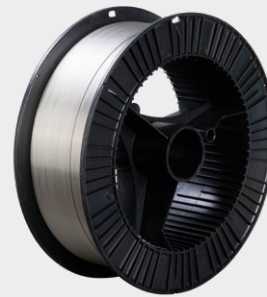
MSG MATERIAL 6-60 NO. 1.4718 DIN 8555

- ▶ Materials and application: Build-up welding on machine parts made of structural steel or cast steel that are subject to wear. The weld metal is particularly tough and abrasion-resistant. For excavator parts, screw conveyors, roll crushers, impact hammers, rollers and running surfaces.
- ▶ Vickers hardness: 650 - 775 HV
- ▶ Rockwell hardness: 56 - 62 HR
- ▶ Shielding gas: Argon S 1 - S 3, mixed gases

Mandrel coil D 300 15.0 kg	Art. no.
1.0 mm	1130110
1.2 mm	1130112
1.6 mm	1130116

! Additional filler wires for build-up welding, dimensions, alloys, coil types and larger quantities available on request.

MAG Stainless steel welding wires



1.4430 DIN 8556: SG X 2 CR NI MO 19 12

- ▶ for the following base materials: 1.4401, 1.4404, 1.4408, 1.4429, 1.4435, 1.4436, 1.4541, 1.4550, 1.4552, 1.4571, 1.4573, 1.4580, 1.4581, 1.4583, 1.6901, 1.6902, 1.6903, 1.6905
- ▶ Welding of stainless, cold-resistant and austenitic steels. For operating temperatures up to 400°C
- ▶ Shielding gas: Argon S 1 - S 3, mixed gases

Mandrel coil D 300 15.0 kg	Art. no.
0.8 mm	1130508
1.0 mm	1130510
1.2 mm	1130512

1.4576 DIN 8556: SG X 5 CR NI MO NB 19 12

- ▶ for the following base materials: 1.3401, 1.4408, 1.4435, 1.4436, 1.4573, 1.4580, 1.4581, 1.4583
- ▶ Various types of steel (black-white compounds); high-carbon and difficult-to-weld steels, e.g. manganese hard steel, buffer layers for hard surfacing, cold-tough nickel steels
- ▶ For operating temperatures from -120°C (cold-tough) to 300°C

Mandrel coil D 300 15.0 kg	Art. no.
0.8 mm	1130308
1.0 mm	1130310
1.2 mm	1130312

1.4370 DIN 8556: SG X 10 Cr Ni Mn 18 8

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4312, 1.4401, 1.4404, 1.4408, 1.4410, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4580, 1.4583 with H 1 to H 2
- ▶ Welding of stainless and acid-resistant Cr and Cr-Ni-Mn steels. For high demands on crack resistance and toughness. Work hardening. Joint welding on different types of steel (black and white joints). Temperatures up to 850°C.
- ▶ Shielding gas: Argon S 1 - S 3, mixed gases

Mandrel coil D 300 15.0 kg	Art. no.
0.8 mm	1130408
1.0 mm	1130410
1.2 mm	1130412

1.4842 DIN 8556: SG X 12 CR NI 25 20

- ▶ for the following base materials: 1.4832, 1.4837, 1.4841, 1.4845, 1.4840
- ▶ Welding of heat-resistant austenitic steels. The steel can be used in air up to 1100°C. Scale resistant up to 1100 °C
- ▶ Shielding gas: Argon S 1 - S 3, mixed gases

Mandrel coil D 300 15 kg	Art. no.
0.8 mm	1130708
1.0 mm	1130710
1.2 mm	1130712

Due to possible fluctuations in commodity prices, prices subject to change.



TIG welding rods, low-alloy 1000 mm

WSG 2 MATERIAL NO. 1.5125 DIN 8559

- ▶ for the following base materials: St 35 - St 55, St 35.4 - St 55.4, St 33 - St 52.3, St 38.8 - St 45.8, grade A - E, A 32 - A 36, boiler plate H 1 - H 3, StE 255 - StE 380, 17 Mn 4, 19 Mn 6, GS 38 - GS 52
- ▶ Welding of unalloyed and low-alloy steels. Melts evenly and smoothly and is well suited for constrained position welding.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450016
2.0 mm	5 kg	1450020
2.4 mm	5 kg	1450024
3.0 mm	5 kg	1450032

TIG medium alloy welding rods 1000 mm

SG Mo Material no. 1.5424 DIN 8575

- ▶ for the following base materials: St 37-3, St 44-3, St 52-3, H 1 - H 4.17 Mn 4.19 Mn 5.19 Mn 6, StE 36 - StE 47, St 45.8, Ast 35 - Ast 45
- ▶ Mo-alloyed welding rods for gas-shielded arc welding on high-temperature steels and high-strength fine-grain structural steels. Suitable for operating temperatures up to 550°C. The smooth and clear melting of the welding rod enables good constrained position welding.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
2.0 mm	5 kg	1457020
2.4 mm	5 kg	1457024
3.0 mm	5 kg	1457032

TIG high-alloy welding rods

1.4316 DIN 8556: SG X 2 CR NI 19 9

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4311, 1.4312, 1.4450, 1.4541, 1.4543, 1.4550, 1.4552, 1.4878, 1.4961, 1.6901, 1.6902, 1.6903, 1.6905
- ▶ Connection and build-up welding on stainless and acid-resistant Cr and Cr-Ni steels. Not for use in high-sulphur media. Operating temperatures from -196°C to 350°C.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.0 mm	5 kg	1451010
1.6 mm	5 kg	1451016
2.0 mm	5 kg	1451020
2.4 mm	5 kg	1451024
3.2 mm	5 kg	1451032

1.4551 DIN 8556: SG X 5 CR NI 19 9

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4310, 1.4312, 1.4319, 1.4541, 1.4550, 1.4840
- ▶ TIG or MIG/MAG welding of stainless austenitic steels
- ▶ Not for use in high-sulphur media.
- ▶ For operating temperatures of up to 400°C, scale-resistant up to +800°C
- ▶ Shielding gas: Argon, mixed gases e.g. M11, M23

Designation	PU	Art. no.
1.0 mm	5 kg	1455010
1.6 mm	5 kg	1455016
2.0 mm	5 kg	1455020
2.4 mm	5 kg	1455024
3.2 mm	5 kg	1455032

! Other dimensions, alloys, coil types and larger quantities on request.

Supplied in carton quantities (1 or 3 packs)



AL MG 3 MATERIAL NO. 3.3536 DIN 1732

- ▶ for the following base materials: Al Mg 3, Al Mg 1, Al Mg 2, Al Mg Mn, AlMg Si 0.5, G-Al Mg 3
- ▶ Welding of rolled and cast aluminium magnesium alloys
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450316
2.0 mm	5 kg	1450320
2.4 mm	5 kg	1450324
3.2 mm	5 kg	1450332
4.0 mm	5 kg	1450340

AL MG 5 MATERIAL NO. 3.3556 DIN 1732

- ▶ for the following base materials: Al Mg 5, Al Mg 3, Al Mg Mn, Al Mg 3 Si, G-Al Mg 3, G-Al Mg 5
- ▶ Welding of rolled and cast aluminium-magnesium alloys
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450416
2.0 mm	5 kg	1450420
2.4 mm	5 kg	1450424
3.2 mm	5 kg	1450432
4.0 mm	5 kg	1450440

AL MG 4.5 MN MATERIAL NO. 3.3548 DIN 1732

- ▶ for the following base materials: Al Mg 4.5 Mn, Al Mg 3, Al Mg 5, AlMgSi 0.5, Al Mg Si 1, Al Zn Mg 1
- ▶ Welding of rolled and cast aluminium-magnesium alloys
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450516
2.0 mm	5 kg	1450520
2.4 mm	5 kg	1450524
3.2 mm	5 kg	1450532
4.0 mm	5 kg	1450540

AL SI 5 MATERIAL NO. 3.2245 DIN 1732

- ▶ for the following base materials: Al Si 5, Al Mg Si 1, Al Cu Mg alloys, Al Zn Mg alloys
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450616
2.0 mm	5 kg	1450620
2.4 mm	5 kg	1450624
3.2 mm	5 kg	1450632
4.0 mm	5 kg	1450640

AL 99.5 MATERIAL NO. 3.0259 DIN 1732

- ▶ for the following base materials: l 99.5, Al 99, E-Al 99.5
- ▶ Welding of pure aluminium and aluminium
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1450716
2.0 mm	5 kg	1450720
2.4 mm	5 kg	1450724
3.2 mm	5 kg	1450732
4.0 mm	5 kg	1450740

Due to possible fluctuations in commodity prices, prices subject to change.

TIG welding rods for hardfacing

W 600 MATERIAL NO. 1.4718 DIN 8555

- ▶ Materials and application: Build-up welding on machine parts made of structural steel or cast steel that are subject to wear. The weld metal is particularly tough and abrasion-resistant. For excavator parts, screw conveyors, roll crushers, impact hammers, rollers and running surfaces. **Vickers hardness:** 650 - 775 HV. **Rockwell hardness:** 56 - 62 HRC
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.6 mm	5 kg	1456016
2.0 mm	5 kg	1456020
2.4 mm	5 kg	1456024



Low-alloy autogenous welding rods

G II MATERIAL NO. 1.0349 DIN 8554

- ▶ for the following base materials: St 34 - St 360-2, St 42, H 1, H 2, St 35, St 45, St 35.4
- ▶ Joint welding in apparatus, boiler, pipe, vehicle and mechanical engineering.
- ▶ Welding gases: Acetylene-oxygen

Designation	PU	Art. no.
2.0 mm	5 kg	1450120
2.5 mm	5 kg	1450125
3.0 mm	5 kg	1450130

Medium-alloy autogenous welding rods

G III MATERIAL NO. 1.6215 DIN 8554

- ▶ for the following base materials: St 34 - St 360-2, St 52-3, H 1, H 2, H 3, 17 Mn 4, St 35.4 St 45.4, St 35.8, St 45.8, GS 40 - GS 45
- ▶ Joint welding in apparatus, boiler, pipe, vehicle and mechanical
- ▶ Welding gases: Acetylene-oxygen

Designation	PU	Art. no.
2.0 mm	5 kg	1450220
2.5 mm	5 kg	1450225
3.0 mm	5 kg	1450230



ALUMINIUM ADHESIVE TAPE, 50 M

- ▶ Heat-resistant with PE film cover, DIN4102 Part 1 A2. Building material class non-combustible when bonded to a metallic substrate. DIN4102 Part 1 Class B Flame-retardant building material class, if bonded to mineral fibre products laminated with at least flame-retardant aluminium.

Designation	PU	Art. no.
Width 25mm	5 kg	1251025
Width 38mm	5 kg	1251038
Width 50mm	5 kg	1251050

1.4370 DIN 8556: SG X 15 CR NI MN 18 8

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4312, 1.4401, 1.4404, 1.4408, 1.4410, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4580, 1.4583, mit H 1 bis H 2
- ▶ Welding of stainless and acid-resistant Cr and Cr-Ni-Mn steels. For high demands on crack resistance and tough properties. Work hardening. Temperatures up to 850°C
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.0 mm	5 kg	1453010
1.6 mm	5 kg	1453016
2.0 mm	5 kg	1453020
2.4 mm	5 kg	1453024
3.2 mm	5 kg	1453032

1.4430 DIN 8556: SG X 2 Cr Ni Mo 19 12

- ▶ for the following base materials: 1.4301, 1.4306, 1.4308, 1.4312, 1.4401, 1.4404, 1.4408, 1.4410, 1.4417, 1.4429, 1.4435, 1.4436, 1.4541, 1.4550, 1.4571, 1.4573, 1.4580, 1.4581, 1.4583, 1.6901, 1.6902, 1.6903, 1.6905
- ▶ Welding of stainless, cold-resistant and austenitic steels. For operating temperatures up to 400°C.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.0 mm	5 kg	1452010
1.6 mm	5 kg	1452016
2.0 mm	5 kg	1452020
2.4 mm	5 kg	1452024
3.2 mm	5 kg	1452032

1.4576 DIN 8556: SG X 2 CR NI MO 19 12

- ▶ for the following base materials: 1.4301, 1.4306, 1.4401, 1.4408, 1.4410, 1.4429, 1.4435, 1.4436, 1.4437, 1.4523, 1.4541, 1.4543, 1.4550, 1.4552, 1.4571, 1.4573, 1.4580, 1.4581, 1.4583
- ▶ Due to the addition of niobium, this steel has high strength and high resistance to intergranular corrosion.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.0 mm	5 kg	1454010
1.6 mm	5 kg	1454016
2.0 mm	5 kg	1454020
2.4 mm	5 kg	1454024
3.2 mm	5 kg	1454032

1.4842 DIN 8556: SG X 12 Cr Ni 25 20

- ▶ for the following base materials: 1.4762, 1.4832, 1.4837, 1.4841, 1.4845, 1.4848, 1.4849, 1.4543, 1.4550, 1.4552, 1.4878, 1.4961, 1.6901, 1.6902, 1.6903, 1.6905
- ▶ Welding of heat-resistant austenitic steels. The steel can be used in air up to 1100°C. Scale resistant up to 1100 °C.
- ▶ Shielding gas: Pure argon

Designation	PU	Art. no.
1.0 mm	5 kg	1454510
1.6 mm	5 kg	1454516
2.0 mm	5 kg	1454520
2.4 mm	5 kg	1454524
3.2 mm	5 kg	1454532

Rod electrodes for welding rust- and corrosion-resistant steels, cast iron and for build-up welding

Our electrodes are "Made in Germany". They are characterised by due to high quality, excellent welding properties and good slag solubility.

1. Approvals

ABS American Bureau of Shipping
BV Bureau Veritas
GL Germanischer Lloyd
LR Lloyd's Register of Shipping
NV Det Norske Veritas
RRS Russian Register of Shipping
PRS Polski Rejestr Statkow
DB Deutsche Bahn AG
Ü Certificate of conformity
TÜV Technical monitoring association
UDT Urzad Dozoru Technicznego

2. Welding positions

PA (w) horizontal (butt seams, fillet weld in trough position)
PB (h) horizontal (fillet welds)
PC (q) transverse (horizontal welding on vertical wall)
PE (ü) overhead
PF (s) rising (from bottom to top)
PG (f) falling (from top to bottom)

3. Current type

=+ Direct current, electrode at positive pole
=- Direct current, electrode at negative pole
~ Alternating current

Schweisskraft R(C)3

Factory designation E 51 32 R(C)3, E38 0 RC 11, E 6013 according to DIN 1913/8529 /EN 499/AWS A5,1
Current type/welding position =- ~/PA, PB, PC, PE, PF, PG



Application, properties, approval

Very easy-to-handle universal electrode, medium-thick, rutile cellulose-coated, with versatile use in machine, steel, ship and pipeline construction. Excellent weldability in all positions including drop stitch. Well-formed seam surface and self-dissolving slag, low spray losses, good re-ignition capability.

Dimensions Ø x L approx.	PU/box pack x pc.	Weight approx.	Art. no.
2.0 x 250 mm	1 x 170	1.6 kg	1161021
2.5 x 350 mm	1 x 250 ⁽¹⁾	4.8 kg	1161025
3.2 x 350 mm	1 x 166 ⁽¹⁾	5.0 kg	1161032
2.0 x 250 mm	20 pcs.	0.19 kg	1161021SB
2.5 x 350 mm	17 pcs.	0.33 kg	1161025SB
3.2 x 350 mm	7 pcs.	0.22 kg	1161032SB

Schweisskraft RRC6

Factory designation E 42 0 RC 11, E 51 32 RR(C) 6, E 6013 according to DIN EN ISO 2560-A, DIN 1913, AWS A 5.1
Current type/welding position =- ~/PA, PB, PC, PE, PF



Application, properties, approval

For joint and repair welding of unalloyed structural steels. Excellent gap bridging, easy ignition and re-ignition, low spray losses. Creates smooth, fine-scaled seam surfaces. Also on rusted and primed base materials.

Dimensions Ø x L approx.	PU/box pack x pc.	Weight approx.	Art. no.
2.0 x 250 mm	1 x 175	1.6 kg	1165021
2.5 x 350 mm	1 x 252 ⁽¹⁾	4.8 kg	1165025
3.2 x 350 mm	1 x 147 ⁽¹⁾	4.8 kg	1165032
4.0 x 350 mm	3 x 103 ⁽¹⁾	4.8 kg	1165040

SCHWEISSKRAFT RR6

Factory designation E 51 32 RR6, E38 0 RR12, E 6013 according to DIN 1913/8529/EN 499/AWS A5,1
Current type/welding position =+ ~/PA, PB, PC, PE, PF



Application, properties, approval

Electrode (thick, rutile-coated) for versatile use in industry and trade. For joint welding in vehicle, tank, boiler, pipeline, shipbuilding, steel and mechanical engineering, boiler, pipeline, shipbuilding, steel and mechanical engineering on unalloyed and low-alloy steels. Excellent ignition properties, soft arc, little spatter, fine-scaled and smooth seam appearance, flat fillet welds, mostly self-dissolving slag.

Dimensions Ø x L approx.	PU/box pack x pc.	Weight approx.	Art. no.
2.0 x 250 mm	1 x 172	1.7 kg	1162021
2.5 x 350 mm	1 x 206	4.6 kg	1162025
3.2 x 350 mm	1 x 128	4.6 kg	1162032
4.0 x 350 mm	1 x 85	4.6 kg	1162040

SCHWEISSKRAFT RR(B)7

Factory designation E 43 33 RR(B)7, E38 2 RB 12, 5E 6013 according to DIN 1913/DIN EN 499/AWS A5,1
Current type/welding position =+ ~/PA, PB, PC, PE, PF



Application, properties, approval

Universal electrode, thick, rutile-based coated, particularly suitable for root and constrained position welding in pipework, tank, boiler and shipbuilding. Finely scaled, well-developed, radiopaque seams with notch-free transition to the base material. Very easy slag removal, even in root layers.

Dimensions Ø x L approx.	PU/box pack x pc.	Weight approx.	Art. no.
2.5 x 350 mm	3 x 242 ⁽¹⁾	4.8 kg	1163025
3.2 x 350 mm	3 x 144 ⁽¹⁾	5.0 kg	1163032

SCHWEISSKRAFT B(R)10

Factory designation E 51 54 B(R)10, E42 3 B 12 H 10, E 7016 according to DIN 1913/8529/EN 499/AWS A5,1
Current type/welding position =+ ~/PA, PB, PC, PE, PF



Application, properties, approval

Universal electrode (thick, basic coated with non-basic components) with high mechanical quality values for industry and trade for welding unalloyed and low-alloy steels. The good weldability in constrained positions and on alternating current should be emphasised.

Dimensions Ø x L approx.	PU/box pack x pc.	Weight approx.	Art. no.
2.5 x 350 mm	3 x 205 ⁽¹⁾	4.3 kg	1164025
3.2 x 350 mm	3 x 126 ⁽¹⁾	4.3 kg	1164032

(1) When ordering, you will receive 3 packs in a carton

Rod electrodes for welding rust- and corrosion-resistant steels

SCHWEISSKRAFT 4316 AC

Factory designation	E 19 9 LR 23, E 308 L-16 to DIN 8556/AWS A5.4
Current type/welding position	=+ ~/PA, PB, PC, PE, PF



Application, properties, approval

Rutile-coated electrode for joint welding on low-carbon, non-stabilised and stabilised, austenitic, chemically resistant CrNi steels at operating temperatures of up to 350°C, for corrosion-resistant Cr and heat-resistant Cr and CrNi steels, for austenitic steels that are close to cold and for alloy-like claddings.

Material no. 1.4300, 1.4301, 1.4306, 1.4308, 1.4311, 1.4312, 1.4541, 1.4543, 1.4550, 1.4552, 1.4878, 1.6905.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
2.5 x 300 mm	1 x 234	4.2 kg	1166025
3.2 x 350 mm	1 x 124	4.5 kg	1166032
2.5 x 300 mm	1 x 67	1.2 kg	1166026
3.2 x 350 mm	1 x 36	1.3 kg	1166033

SCHWEISSKRAFT 4430 AC

Factory designation	E 19 12 3 LR 23, E 316 L-16 according to DIN 8556/AWS A5.4
Current type/welding position	=+ ~/PA, PB, PC, PE, PF



Application, properties, approval

Rutile-coated electrode for joint welding on low-carbon, non-stabilised and stabilised, austenitic, chemically resistant CrNiMo steels at operating temperatures up to 400°C, for corrosion-resistant Cr and CrMo steels, for alloy-like claddings and for austenite-ferrite joints.

Material no. 1.4401, 1.4404, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
2.5 x 300 mm	1 x 233	4.2 kg	1166125
3.2 x 350 mm	1 x 136	4.9 kg	1166132
2.5 x 300 mm	1 x 68	1.2 kg	1166126
3.2 x 350 mm	1 x 39	1.4 kg	1166133

Rod electrodes for welding steels

Schweißkraft 4370 AC

Factory designation	E 18 8 Mn R26, approx. E 307-16 according to DIN 8556/AWS A5.4
Current type/welding position	=+ ~/PA, PB, PC, PE, PF
Ø in mm	2.5 - 5.0



Application, properties, approval

Rutile-coated electrode for joint welding between unalloyed and low-alloy steels with high-alloy steels and cast steel grades, for austenite-ferrite joints at operating temperatures up to 300°C, for welding high-C and difficult-to-weld steels as well as austenitic hard manganese steels, for welding buffer layers and for wear-resistant surfacing under work-hardening impact, pressure and rolling stress. The weld metal is fully austenitic, corrosion-resistant, scale-resistant up to 850°C and work-hardenable up to a hardness of approx. 350 HB.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
3.2 x 350 mm	1 x 132	4.8 kg	1167032
4.0 x 350 mm	1 x 92	5.0 kg	1167040
3.2 x 350 mm	1 x 39	1.4 kg	1167033
4.0 x 350 mm	1 x 24	1.3 kg	1167041

Schweißkraft 4337 AC

Factory designation	E 29 9 R23, E 312-16 according to DIN 8556/AWS A5.4
Current type/welding position	=+ ~/PA, PB, PC, PE, PF
Ø in mm	2.0 - 5.0



Application, properties, approval

Rutile-coated electrode for joint and build-up welding on identical and similar steels and cast steels, for joint welding on high-strength unalloyed and low-alloyed structural steels, heat-treatable steels and tool steels, on hard manganese steel and for joint welding between dissimilar

steels and with high-alloy stainless steels. The electrode is also suitable for crack-resistant and tough-hard intermediate layers for hard coatings as well as for wear-resistant, work-hardening and heat-hardening coatings. The austenitic-ferritic weld metal is stainless, corrosion-resistant and suitable for operating temperatures of up to 300°C. The increased delta ferrite content in the weld metal results in a high level of safety against hot cracks in black-white joints.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
2.5 x 300 mm	1 x 224	4.0 kg	1167125
3.2 x 350 mm	1 x 136	4.8 kg	1167132
2.5 x 300 mm	1 x 62	1.1 kg	1167126
3.2 x 350 mm	1 x 37	1.3 kg	1167133

Rod electrodes for welding cast iron

Schweisskraft NI

Factory designation	E NI BG 11, E NI-C1 according to DIN 8573/AWS A5,15
Current type/welding position	== += ~/PA, PB, PC, PS



Application, properties, approval

Basic graphite-coated nickel electrode for cold welding of grey, malleable and cast steel as well as for welding on fatigued castings. For eliminating blowholes and processing errors. The NI has excellent welding properties even at low amperage settings. It has a smooth, intensive flow and low spray losses, as well as easy slag removal. The weld seam is soft as a file and can be machined, including the transition zones to the base material.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
2.5 x 350 mm	1 x 74	1.5 kg	1168025
3.2 x 350 mm	1 x 43	1.5 kg	1168032

SCHWEISSKRAFT NIFE

Factory designation	E NiFe-1 BG 11, E NiFe-C1 according DIN 8573/AWS A5,15
Current type/welding position	== += ~/PA, PB, PC, PS



Application, properties, approval

Basic graphite-coated nickel-iron electrode for cold welding of grey cast iron with lamellar and globular graphite structure. Also suitable for joining cast iron (GGL and GGG grades) with unalloyed steel materials. The alloy of the weld metal essentially consists of core wire, 60%Ni and 40%Fe. The weld metal can be machined and is characterised by high crack resistance. It is very similar in colour to the base material and also corrodes like this later on. The soft welding electrode has good wetting properties.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
2.5 x 300 mm	1 x 82	1.3 kg	1168125
3.2 x 350 mm	1 x 47	1.5 kg	1168132

Rod electrodes for build-up welding

Schweisskraft 60 Factory designation

Factory designation	E 6-UM-60 F/ approx. E 307-16 according to DIN 8555
Current type/welding position	==+ / w, h, q, s
Ø in mm	2.5 - 5.0



Application, properties, approval

Basic-coated electrode for tough, impact-resistant and abrasion-resistant coatings on unalloyed and low-alloyed materials of high strength. Particularly suitable for coatings on machine parts, excavator teeth, blow bars, scrapers, screw conveyors, mill beaters, mixer blades, crusher jaws, crusher cones, etc.

The weld metal can only be machined by grinding, it can be soft annealed and hardened.

Dimensions Ø x L approx.	PU/plastic/carton Pack x pc.	Weight approx.	Art. no.
3.2 x 450 mm	1 x 133	6.3 kg	1169032
4.0 x 450 mm	1 x 88	6.3 kg	1169040

Various packaging units ...



Your advantages:

- All rod electrodes are packed in a practical plastic pack or outer carton and therefore do not become damp.
- Many types are available in the favourable small packaging

1. Approvals

ABS American Bureau of Shipping
BV Bureau Veritas
GL Germanischer Lloyd
LR Lloyd's Register of Shipping
NV Det Norske Veritas
RRS Russian Register of Shipping
PRS Polski Rejestr Statkow
DB Deutsche Bahn AG
Ü Certificate of conformity
TÜV Technical monitoring association
UDT Urząd Dozoru Technicznego

2. Welding positions

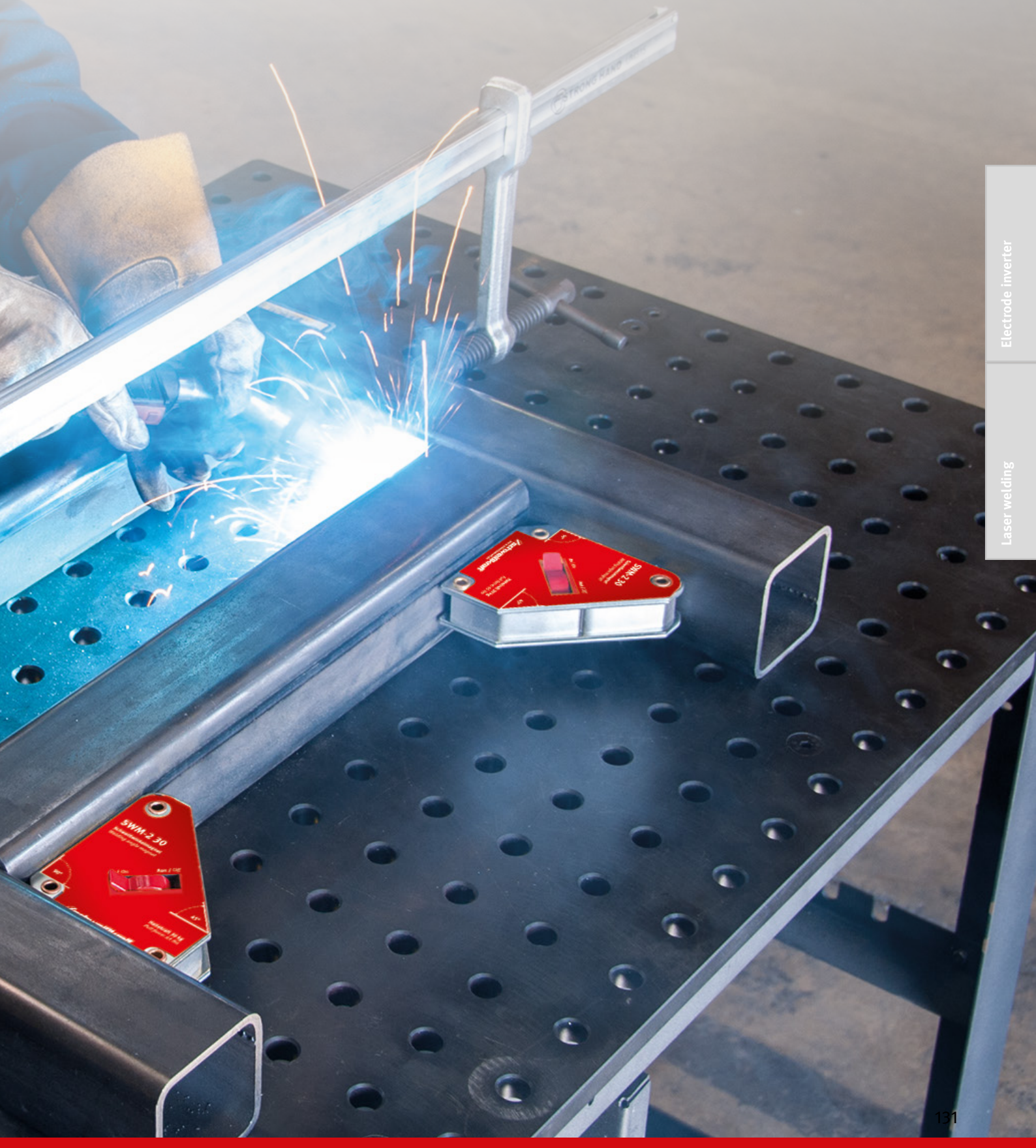
PA (w) horizontal (butt seams, fillet weld in trough position)
PB (h) horizontal (fillet welds)
PC (q) transverse (horizontal welding on vertical wall)
PE (ü) overhead
PF (s) rising (from bottom to top)
PG (f) falling (from top to bottom)

3. Current type

==+ Direct current, electrode at positive pole
== Direct current, electrode at negative pole
~ Alternating current



SCREW CLAMPS / WELDING MAGNETS



Electrode inverter

Laser welding

Screw clamps

USZ series - 4 - in - 1 all-steel screw clamp with toggle handle

- ▶ Tempered sliding and fixed clamp made from one piece for resilient and elastic clamping
- ▶ Fixed bracket and pressure plate made from one piece, tempered and torsion-resistant
- ▶ For clamping, tube tensioning, spreading and overlapping
- ▶ V-clamping attachment for pipes and an additional block for traversing included in the scope of delivery
- ▶ Surface-coated spindle with trapezoidal thread is smooth-running and does not jam.
- ▶ Best power transmission when tightening thanks to the rounded ends on the toggle handle
- ▶ Quick changeover of the sliding arm for spreading applications by reversing the clamping rail and the additional block
- ▶ Can be used on wood and steel



Standard incl. interchangeable V-clamping attachment and additional block for traversing and spreading

Accessories

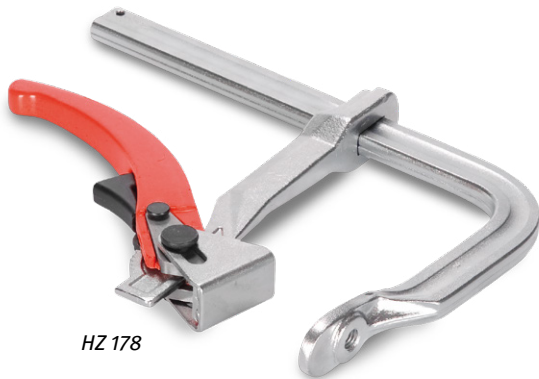


Magnetic V-clamping attachment

Article no. 1790006

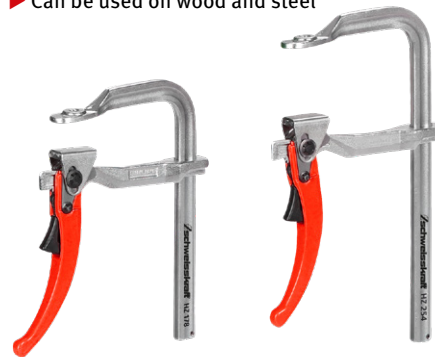
HZ series - Lever clamp with ratchet mechanism for efficient and vibration-resistant clamping

- ▶ Fixed bracket and pressure plate made from one piece, tempered and torsion-resistant
- ▶ With 38 mm wide movable pressure plate
- ▶ Functional ratchet mechanism for vibration-proof clamping
- ▶ Particularly useful in cramped working conditions
- ▶ Quick conversion of the sliding bracket for spreading applications by



HZ 178

- reversing the clamping rail and the additional block in two steps.
- ▶ Up to five times faster than conventional clamps thanks to the one-finger quick clamping and release lever
- ▶ Can be used on wood and steel



HZ 178

HZ 254

Accessories



V-clamping attachment
Article no. 1790005



Magnetic V-clamping attachment
Article no. 1790006



Additional block for traversing and spreading
Art. no. 1790007

Clamping



▶ Standard application efficient and easy to execute

Tubes clamping



▶ with the self-adjusting V-clamping attachment no problem

Spreading



▶ Quick changeover with just a few simple steps

Traversing



▶ Traversing by means of screw-on additional block

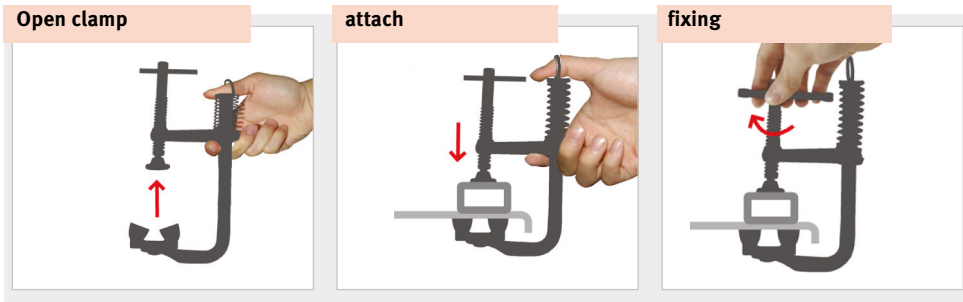
Model	max. clamping force	Span	Throat depth	Cross-section of fixed bracket	Thread	Weight approx.	Art. no.
USZ 216	550 kg	216 mm	121 mm	24 x 12 mm	M 10	1.9 kg	1790001
USZ 318	1100 kg	318 mm	140 mm	30 x 14 mm	M 10	3.5 kg	1790002
USZ 419	1100 kg	419 mm	140 mm	30 x 14 mm	M 10	4.0 kg	1790003
HZ 178	460 kg	178 mm	121 mm	22 x 11 mm	M 10	1.2 kg	1790010
HZ 254	460 kg	254 mm	121 mm	22 x 11 mm	M 10	1.3 kg	1790011

MSZ series - Magnetic screw clamp with quick-release spring and magnetic V-clamping attachment

- ▶ For steel workpieces
- ▶ Spring-loaded sliding arm for one-handed operation
- ▶ After positioning, the clamp holds magnetically to the workpiece
- ▶ Made of heat-treated and nickel-chromium-plated steel for long durability
- ▶ V-clamping attachment included in the scope of delivery
- ▶ With threaded hole, can be extended with optional V-clamping attachment or bolt



Simple one-handed operation in three steps:



Accessories

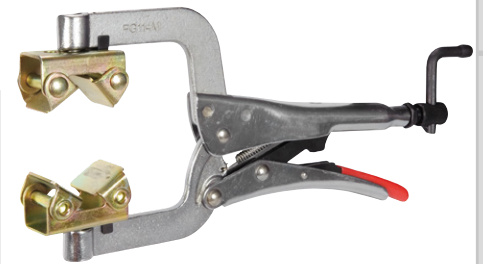
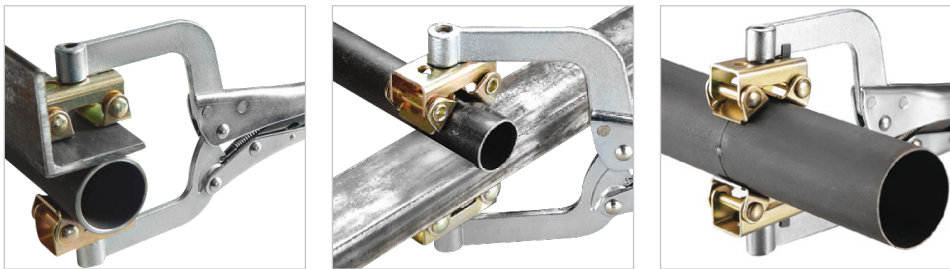


Additional block for traversing
suitable for MSZ 140
Art. no. 1790022

suitable for RGZ 280
Art. no. 1790007

RGZ 280 – Pipe grip pliers specially designed for holding round objects

- ▶ with two self-adjusting V-clamps, therefore also suitable for securing flat material to pipes
- ▶ operable with one hand



RGZ 280 - illustration shows scope of delivery, optionally available additional block for traversing see accessories above

WGZ 76 – Angle gripping tong - the helping hand for working with right-angled workpieces

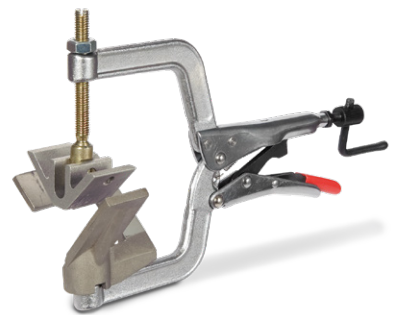
- ▶ For holding, aligning and fixing workpieces of different thicknesses at a 90° angle
- ▶ operable with one hand
- ▶ Applicable for wood and steel and synthetic materials



▶ For fixing right-angled connections

▶ Also for working with wood and synthetic materials

▶ for workpieces up to 1 1/4 inch (32 mm) thickness (D)

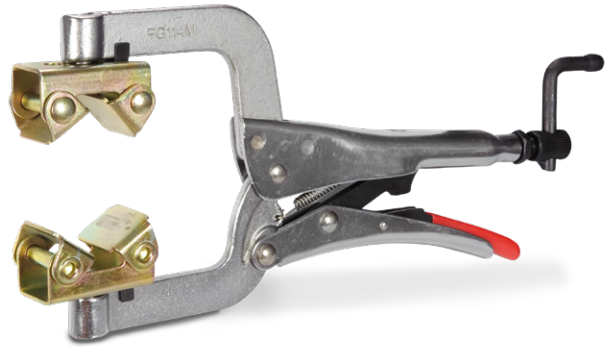


WGZ 76 - Fig. shows scope of delivery

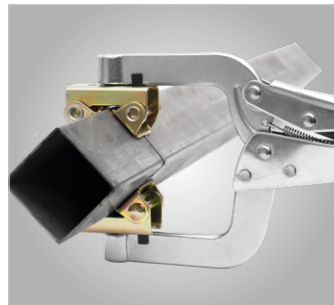
Model	max. clamping force	Span	Throat depth	Cross section	Thread	Weight approx.	Art. no.
MSZ 90	140 kg	90 mm	64 mm	13 x 6 mm	M 6	0.4 kg	1790020
MSZ 140	230 kg	140 mm	89 mm	16 x 8 mm	M 8	0.5 kg	1790021
Model	Span min./max.		Length	Thread	Weight approx.	Art. no.	
RGZ 280	40 - 64 mm		280 mm	M 10	1.3 kg	1790090	
Model	max. clamping force	Span	Throat depth	Length	Weight approx.	Art. no.	
WGZ 76	75 kg	32 mm	76 mm	216 mm	-	0.6 kg	1790080

Pipe grip pliers RGZ 150 - Convenient way to attach round or square pipes for butt welding

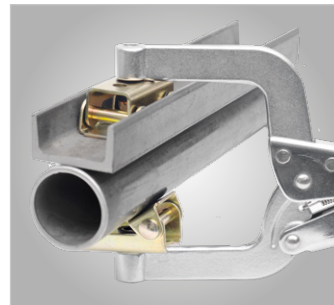
- ▶ The large opening allows the pipe wrench to be used up to a diameter of 63.5 mm
- ▶ The two V-pads offer a better clamping surface
- ▶ Adjustable upper spindle for holding pipes of different sizes
- ▶ Ergonomic one-hand release lever that does not pinch
- ▶ Quick-clamping crank for adjusting the clamping pressure without loosening the workpiece



• The V-pads of the pipe wrench adapt to many different shapes



• For holding two square tubes together



• The V-pads can be rotated 360°



• For holding two round-edged tubes together

Model		RGZ 150
Article no.		1790093
Span min.	mm	25
Span max.	mm	50

Throat depth	mm	50
Thread		M8
Dimensions and weights		
Length (product) approx.	mm	180
Weight (net) approx.	kg	0.4

Ground screw clamp MSZ 80 - With quick-release spring and insulated U-adapter

- ▶ Solid, insulated copper U-adapter can be rotated for easy access
- ▶ For fastening to round/irregularly shaped parts
- ▶ Clamping and earthing at the same time
- ▶ Designed for up to 300A
- ▶ With spring-loaded sliding bracket
- ▶ Made of heat-treated and nickel-chromium-plated steel for long durability



• For fastening to round/irregularly shaped parts
• Clamping and earthing at the same time

Model		MSZ 80
Article no.		1790079
Span	mm	75
Throat depth	mm	64
Clamping force max.	kg	100

Thread		M6
Amperage	A	300
Dimensions and weights		
Length (product) approx.	mm	180
Weight (net) approx.	kg	0.4

UGZ series - Universal gripping tongs

- ▶ Crank handle for quick opening, closing and adjustment
- ▶ With quick-release lever
- ▶ Serrated tong jaws for additional grip

- ▶ With hammer head and longitudinal groove in the upper jaw
- ▶ Brazed components with high durability

UGZ 75

- ▶ Large tong projection (64 mm)
- ▶ V-shaped notch in the upper jaw for clamping small parts

UGZ 40



UGZ 40



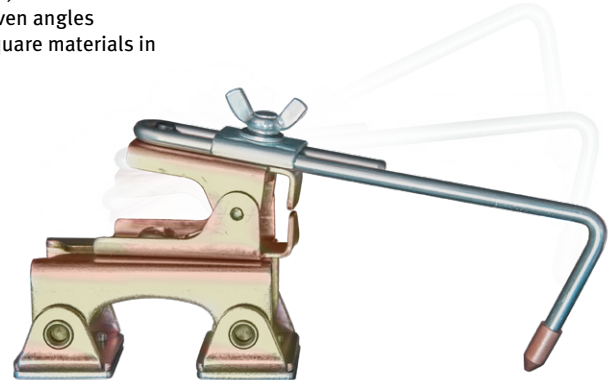
UGZ 75

Model	Throat depth	Opening area	Tool length	Weight approx.	Art. no.
UGZ 40	–	40 mm	300 mm	0.6 kg	1790091
UGZ 75	64 mm	6 ~ 75 mm	250 mm	0.7 kg	1790092

MHS 203 - Material retaining stop

- ▶ For holding, positioning and processing of steel workpieces
- ▶ Retaining finger with brass tip 360° and adjustable in length

- ▶ Particularly suitable for bolts, nuts or thin sheets for tack welds at uneven angles
- ▶ For use on round, flat and square materials in the light load range



Model	Holding force ⁽¹⁾	Dimensions approx.	Weight approx.	Art. no.
MHS 203	15 kg	178 x 102 x 102 mm	0.55 kg	1790077

(1) Holding force based on application with 10 mm steel plate

BHW 100 – TIG torch holder

- ▶ The welding torch can be placed wherever it is needed
- ▶ Adjustable cable holder

- ▶ The fully enclosed magnetic base plate makes it easier to clean metal residues

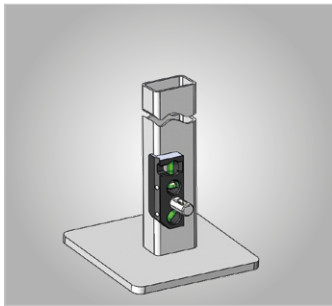


Model	Dimensions approx.	Weight approx.	Art. no.
BHW 100	Ø89 x 160 mm	0.85 kg	1790078

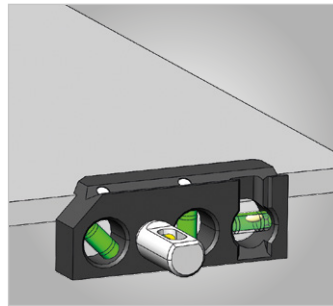
Spirit level

Three-axis spirit level SWL 3

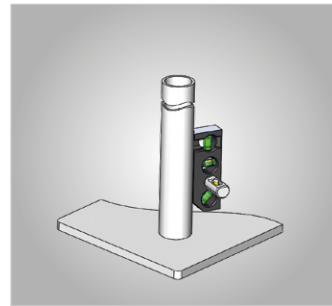
- ▶ Precise, CNC-machined spirit level
- ▶ Three built-in jumbo spirit levels and one clip-on spirit level
- ▶ The large clip-on spirit level can be rotated to facilitate viewing from different angles
- ▶ Large, machined guide edge for easy alignment of large parts
- ▶ The clip-on spirit level allows you to check the level in two axes simultaneously
- ▶ Housing made of anodised aluminium
- ▶ Relief for easy reading
- ▶ Eleven large and strong rare earth magnets on four sides, including the V-side



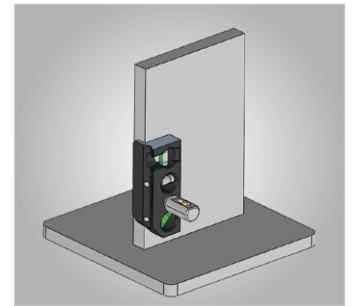
• Square tube



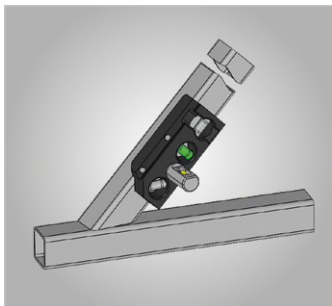
• Edge of a panel in a structure



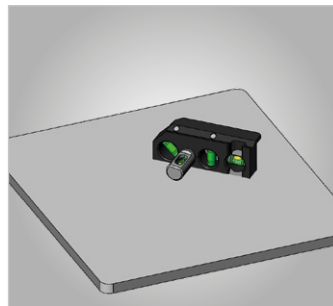
• Round tube



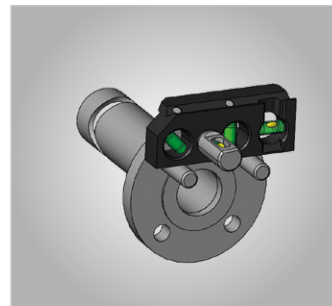
• Vertical structural edge



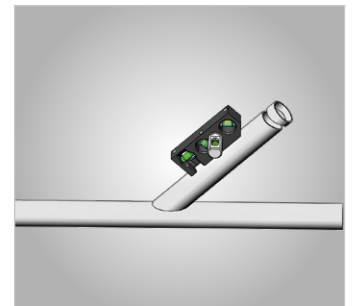
• 45° square structure



• Table top



• Flange



• 45° structure

Model		SWL 3
Article no.		1790097

Dimensions and weights		
Length (product) approx.	mm	152
Width/depth (product) approx.	mm	45
Height (product) approx.	mm	55
Weight (net) approx.	kg	0.5

Scope of delivery

- ▶ Attachable spirit level

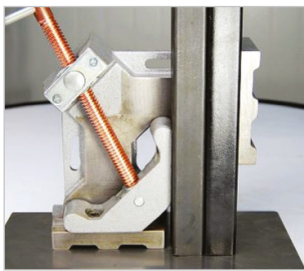
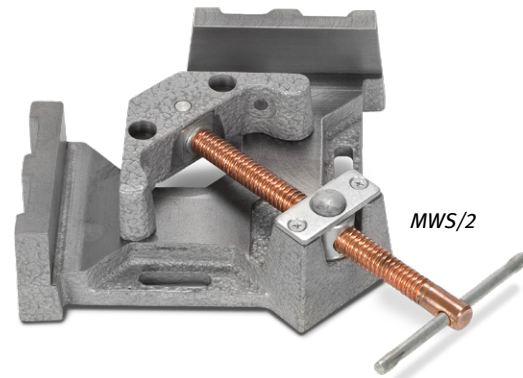


MWS series - Metal angle clamp in 2-axis or 3-axis design

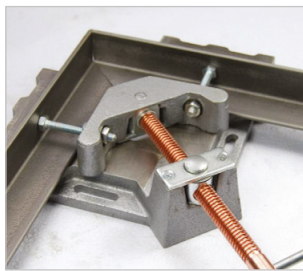
- ▶ For use in steel construction, welding and metalworking
- ▶ Sturdy jaws and base body made of grey cast iron
- ▶ For holding, aligning and fixing workpieces of varying thicknesses at a precise 90° angle
- ▶ Automatic adjustment of the pressure jaw to workpieces of different thicknesses thanks to the articulated spindle nut
- ▶ with push button for quick clamping of the workpiece (except for MWS-2 56)
- ▶ Welding spatter cannot adhere to the copper-plated trapezoidal spindle with T-handle
- ▶ Easy to attach to welding or machine tables thanks to elongated holes on the sides

MWS-2 series

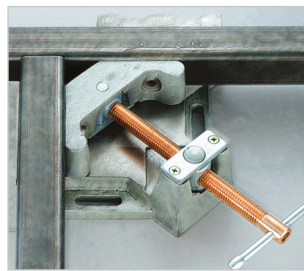
- ▶ For workpieces with two axes
- ▶ Due to the open design, fixing of T-joints and free access to the workpiece during welding and assembly work is possible



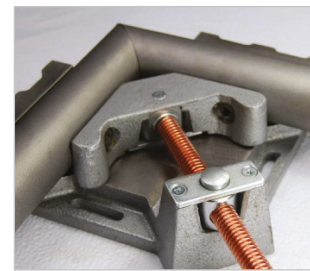
▶ Milled sides for setting up the metal angle clamps



▶ With device for better clamping of profiles



▶ Fixing of T-connections possible due to open construction method



▶ Also suitable for fixing round material

Series MWS-3

- ▶ For workpieces with three axes
- ▶ Quick removal of the workpiece by simply turning the second clamping arm away



▶ With quick clamping for fast, convenient set-up



▶ The second clamping arm can simply be swivelled away



Model	Span	Jaws length/height	T-distance	Fastening groove		Weight approx.	Art. no.
				Length	Width		
MWS-2 56	56 mm	90 x 33 mm	47 mm	35.5 mm	11 mm	4.0 kg	1790099
MWS-2 95	95 mm	122 x 35 mm	62 mm	40 mm	11 mm	5.0 kg	1790100
MWS-2 121	121 mm	135 x 64 mm	100 mm	51 mm	11 mm	10.6 kg	1790101
MWS-3 95	95 mm	122 x 35 mm	62 mm	-	-	11.1 kg	1790102
MWS-3 121	121 mm	100 x 64 mm	100 mm	-	-	19.6 kg	1790103

Welding angle magnets

SWM-2 30 – Switchable welding angle magnet for fixing sheet metal, round and square workpieces or pipes

- ▶ With high magnetic holding force for versatile applications
- ▶ Magnet can be switched on and off via toggle switch
- ▶ Easy to wipe off when switched off



For holding metal workpieces at a 45° or 90° angle



Model	Holding force ⁽¹⁾	Angle	Dimensions approx.	Weight approx.	Art. no.
SWM-2 30	30 kg	45° / 90°	110 x 95 x 25 mm	0.5 kg	1790029

(1) Holding force based on application with 9.5 mm steel plate

VSWM 15 – Adjustable welding angle magnet for stepless adjustment of the angle from 30° to 270°

- ▶ With high magnetic holding force for versatile applications
- ▶ Ideal for round and square pipes, angles and flat material
- ▶ Desired angle between 30° and 270° easily adjustable via hexagonal hole
- ▶ Fastening holes to connect two magnets together



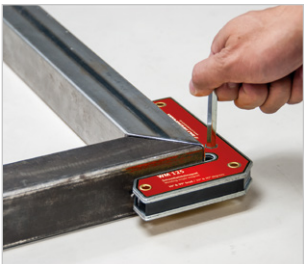
Add an Allen key to the scope of delivery

Model	Holding force ⁽¹⁾	Angle	Dimensions approx.	Weight approx.	Art. no.
VSWM 15	15 kg	30° – 270° stepless	156 x 156 x 20 mm	0.9 kg	1790051

(1) Holding force based on application with 10 mm steel plate

WM 125 – Two internal and external angle magnets for 90° and 270° angles

- ▶ With high magnetic holding force for versatile applications
- ▶ Ideal for round and square pipes, angles and flat material
- ▶ Fastening holes to connect two magnets together



Hexagonal hole for detaching the magnetic bracket.
Hexagon socket key not included in delivery

Scope of delivery WM 125:

- 1 angle magnet up to 9 kg holding force
- 1 angle magnet up to 15 kg holding force

Model	Holding force ⁽¹⁾	Angle	Dimensions approx.	Weight approx.	Art. no.
WM 125	9 kg 15 kg	90° / 270°	75.5 x 52 x 14 mm 125 x 85 x 18 mm	0.5 kg	1790042

(1) Holding force based on application with 10 mm steel plate



SWM-2 and SWM series – Switchable welding angle magnets for fixing sheet metal, round and square workpieces or pipes

- ▶ With high magnetic holding force for professional applications
- ▶ Magnet can be switched on and off via toggle switch
- ▶ Easy to wipe off when switched off
- ▶ Ideal for round and square pipes, angles and flat material

Series SWM-2



For holding metal workpieces at a 45° or 90° angle



SWM-2 35

SWM-2 65

SWM series

- ▶ For holding metal workpieces at a 90° angle
- ▶ Pole shoes with prism, therefore suitable for flat and round material



Professional design for the highest quality standards

Two independently functioning on/off switches



SWM 35

SWM 70

VSWM 41 – Adjustable welding angle magnet for stepless adjustment of the angle from 30° to 275°

- ▶ With high magnetic holding force for professional applications
- ▶ Pole shoes with prism, therefore suitable for flat and round material
- ▶ Conveniently adjustable to the desired angle and easy to fix with the practical lever



• Angle can be easily read off the scale

WM 90 – Angle magnet

- ▶ For creating 90° angles on the outside to enable obstacle-free welding on the inside
- ▶ Outer magnetic edges can be used for 60° material inclinations



Scope of delivery WM 90:
• 2 angle magnets each

Model	Holding force ⁽¹⁾	Angle	Dimensions approx.	Weight approx.	Art. no.
SWM-2 35	40 kg	45° / 90°	111 x 95 x 29 mm	0.7 kg	1790030
SWM-2 65	75 kg	45° / 90°	152 x 130 x 35 mm	1.4 kg	1790031
SWM 35	55 kg	90°	152 x 152 x 38 mm	1.2 kg	1790040
SWM 70	120 kg	90°	197 x 197 x 48 mm	2.7 kg	1790041
VSWM 41	50 kg	30°- 275° stepless	197 x 197 x 95 mm	2.4 kg	1790050
WM 90	14 kg	60°/90°	83 x 95 x 16 mm	0.2 kg	1790071

(1) Holding force based on application with 10 mm steel plate

Welding angle magnets

Switchable welding angle magnet SWM-4 65 – for fixing sheet metal, round and square workpieces or pipes

- ▶ With high magnetic holding force for professional applications
- ▶ Strong rare earth magnets
- ▶ Double plate for full magnetic force
- ▶ Magnet can be switched on and off via toggle switch
- ▶ Centre position of the on/off switch ideal for alignment and easy placement of parts
- ▶ Easy to wipe off when switched off
- ▶ Ideal for round and square pipes, angles and flat material
- ▶ For holding metal workpieces at different angles



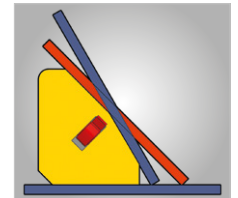
Model		SWM-4 65
Article no.		1790032
Holding force	kg	65
Angle	°	30 / 45 / 60 / 90
Dimensions and weights		
Length (product) approx.	mm	150
Width/depth (product) approx.	mm	130
Height (product) approx.	mm	35
Weight (net) approx.	kg	1.4



• For holding metal workpieces at a 90° angle



• For holding metal workpieces at a 45° angle

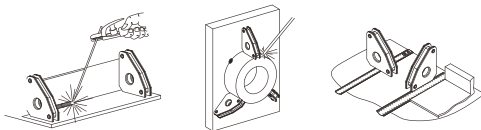


• For holding metal workpieces at a 30° or 60° angle

Series MSWM / SSWM - Permanent welding angle magnet

For 30°, 45°, 60° and 90° mounting bracket

- ▶ For holding round and flat iron workpieces at an exact angle
- ▶ Practical helpers for welding and assembly



MSWM 10
 ▶ Particularly suitable for small workpieces
 ▶ Two welding magnets included in the scope of delivery



SSWM 20
 ▶ Despite small design 40 kg holding force
 ▶ For the most common applications
 ▶ One welding magnet included in delivery

Model	Holding force ⁽¹⁾	Angle	Dimensions approx.	Weight approx.	Art. no.
MSWM 10	10 kg	30°/60°/45° /90°	59 x 51 x 16 mm	0.3 kg	1790060
SSWM 20	40 kg	30°/60°/45° /90°	140 x 111 x 19 mm	0.5 kg	1790070

(1) Holding force based on application with 10 mm steel plate

Series MM - Mass magnets compact, with up to 50 kg holding force

- ▶ V-shaped support for a secure hold on round and flat material surfaces
- ▶ Easy operation of the on/off switch, even when wearing gloves
- ▶ Metal chips fall off immediately after the solenoid is switched off
- ▶ Cable rotation up to 360° possible



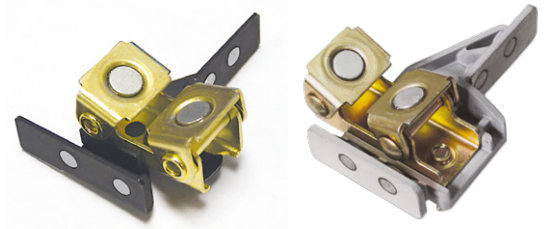
Model	Amperage	Duty cycle	Holding force	Dimensions approx.	Weight approx.	Art. no.
MM 300	300 A	60%	20 kg	50 x 50 x 64 mm	0.4 kg	1790072
MM 500	500 A	60%	50 kg	50 x 70 x 64 mm	1.1 kg	1790073

MHA series - Magnetic holding stops

For positioning small workpieces during tack welding

- ▶ For use on metal profiles such as round materials, flat steel or square tubes
- ▶ MHA 111 made of die-cast aluminium for more precise work
- ▶ Adjustable stops

position and secure the workpiece vertically or horizontally.



MHA 100 -

Fig. shows scope of delivery

MHA 111 -

Fig. shows scope of delivery

Model	Holding force ⁽¹⁾	Dimensions approx.	Weight approx.	Art. no.
MHA 100	8.0 kg	100 x 76 x 32 mm	0.2 kg	1790074
MHA 111	8.0 kg	111 x 73 x 38 mm	0.25 kg	1790075

MVS SET- Magnetic V-clamping attachments

For holding, positioning and processing of steel workpieces

- ▶ For use on round, flat and square materials in the light load range
- ▶ Four magnets per clamping attachment

Scope of delivery:

- ▶ Two clamping attachments, L x W: 55 x 39 mm, holding force 8 kg
- ▶ Two clamping attachments, L x W: 50 x 26 mm, holding force 6 kg

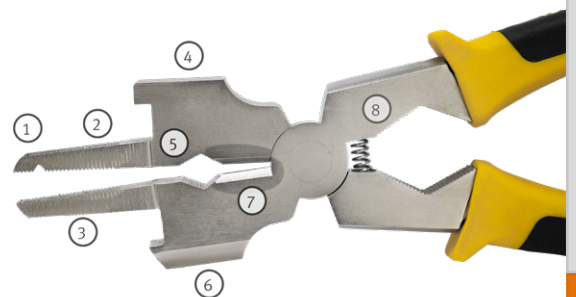


Model	Art. no.
MVS Set	1790076

(1) Holding force based on application with 10 mm steel plate

Multi welding tong MS 215 - Multifunctional, unique tong

- ▶ Side with slag hammer for removing slag and welding residues
- ▶ Flat hammer with scraper for quick removal of splashes
- ▶ With induction-hardened blades, chisel blades and scraping knives



Model		MS 215
Article no.		1790095
Dimensions and weights		
Length (product) approx.	mm	215
Weight (net) approx.	kg	0.5

1. V-groove for wire or nuts
2. Coarse file
3. Fine file
4. Flat hammer
5. Grip
6. Chisel blades
7. Side cutter
8. Grip



AUTOGENOUS AND PROPANE TECHNOLOGY GAS CYLINDERS





FSSG 20 litres (Fig. similar)



Universal bottle trolley 10-20 litres (Fig. similar)

UNIVERSAL BOTTLE TROLLEY

for 2 x 10-20 litre bottles

Art. no.	PU
1700005	1

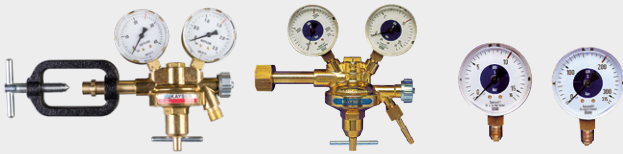
Mobile welding and cutting device

- ▶ Bottle trolley for 2 x 10 or 2 x 20 litre steel bottles
- ▶ Steel cylinder oxygen and acetylene (10 or 20 litres)
- ▶ Pressure regulator oxygen - single-stage and acetylene - single-stage
- ▶ Protective hose guard for acetylene and oxygen
- ▶ Combined welding and cutting device in sheet steel box (KE/17) (for welding from 0.5 - 9 mm, for cutting from 3 - 100 mm)
- ▶ Oxygen and acetyl

	Art. no.	PU	€ plus VAT/PU
FSSG 10 mobile oxyfuel welding and cutting unit	1700010	1	
FSSG 20 mobile oxyfuel welding and cutting unit	1700020	1	

PRESSURE REDUCER

	Art. no.	PU
Oxygen	1700030	1
Acetylene	1700040	1



REPLACEMENT PRESSURE GAUGE Ø 63 mm, connection G1/4

Acetylene 40 bar	1700041	1
Acetylene 2.5 bar	1700042	1
Oxygen 315 bar	1700031	1
Oxygen 16 bar	1700032	1
Argon 315 bar	1700051	1
Argon 30 litre	1700052	1



FLAME ARRESTORS

	Art. no.	PU
Acetylene	1700045	1
Oxygen	1700035	1

Teflon seal

for CO²/ARGON connection
18 x 11.5 x 2 mm

Art. no.	PU
1700033	10

TEFLON SEAL

for oxygen connection (20 x 11 x 2 mm)

Art. no.	PU
1700034	10

FIBRE GASKETS

for oxygen + argon connection

Art. no.	PU
1700036	10

ALUMINIUM SEALS (Acetylen)

Art. no.	PU
1700046	10



PRESSURE GAUGE PROTECTIVE CAPS

	Art. no.	PU
blue - oxygen	1700037	1
red - acetylene and other fuel gases	1700047	1
white/grey - other technical gases	1700057	1

▶ for pressure gauge 63 mm diameter
▶ Slotted design with safety opening



PRESSURE GAUGE PROTECTION BRACKET

	Art. no.	PU
Yellow version for fuel gas	1700048	1
Blue version for oxygen	1700038	1

▶ to protect the pressure gauges against damage



KEK / 17 SET

1700117	1
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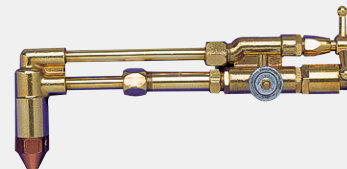
- ▶ Combined welding and cutting device
- ▶ Shaft diameter 17 mm
- ▶ for welding from 0.5 - 9 mm
- ▶ for cutting from 3 - 100 mm
- ▶ in sheet steel box



HANDLE Type KEK/17

1700127	1
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- ▶ Shank diameter 17 mm



CUTTING INSERT Type KEK/17

1700137	1
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- ▶ Shaft diameter 17 mm; without nozzles



GUIDE CARRIAGE

1700150	1
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- ▶ for KEK 17/25.5 mm



CIRCULAR GUIDE ROD (Circle)

1700151	1
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- ▶ for guide carriage KEK 17



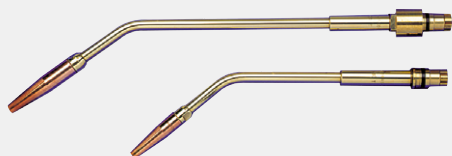
CUTTING NOZZLES

	Art. no.
S0 3-12 mm	1700202
S1 12-25 mm	1700203
S2 25-50 mm	1700204
S3 50-100 mm	1700205



HEATING NOZZLES FOR ACETYLENE FUEL GAS

Size H1 3-100 mm	1700231
Size H2 100-300 mm	1700232



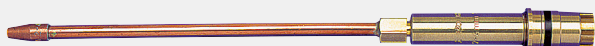
WELDING INSERTS TYPE KEK/17

Size 1 0.5- 1.0 mm	1700210
Size 2 1.0- 2.0 mm	1700211
Size 3 2.0- 4.0 mm	1700212
Size 4 4.0- 6.0 mm	1700213
Size 5 6.0- 9.0 mm	1700214
Size 6 9.0-14.0 mm	1700215
Shaft diameter 17 mm	



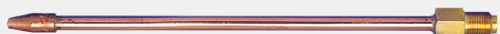
COPPER TIPS

0.5-1.0 mm	1700220
1.0-2.0 mm	1700221
2.0-4.0 mm	1700222
4.0-6.0 mm	1700223
6.0-9.0 mm	1700224
9.0-14.0 mm	1700225



PIPE WELDING INSERT TYPE KEK/17

Size 2 1-2 mm	1700118
Size 3 2-4 mm	1700119
Size 4 4-6 mm	1700120
Size 5 6-9 mm	1700121
▶ Copper tube 6 mm diameter, flexible, with soldered-on mouthpiece	



PIPE WELDING INSERT FRONT PARTS TYPE KEK/17

Size 2 1-2 mm	1700122
Size 3 2-4 mm	1700123
Size 4 4-6 mm	1700124
Size 5 6-9 mm	1700125
▶ Copper tube 6 mm diameter, flexible, with soldered-on mouthpiece	



HOSE

Acetylene 9 x 3.5 red, 40 m	1701701
Oxygen 6 x 5 blue, 40 m	1701702
Twin hose 6 x 9, 40 m	1701703



TWIN OXYFUEL HOSES CRIMPED

5 m	1701205
10 m	1701210
15 m	1701215
20 m	1701220

- ▶ Blue hose: Inner Ø 6 mm; outer Ø 16 mm; wall thickness 5 mm
- ▶ Red hose: Inner Ø 9 mm; outer Ø 16 mm; wall thickness 3.5 mm



DOUBLE HOSE CLAMP

Galvanised steel	1701023
▶ 16/16 mm	



MAGNETIC WELDING MIRROR

1701050

- ▶ With magnetic base and movable guide



DOUBLE BRANCH VALVE

1/4" right, oxygen/argon with 6 mm nozzles	1701037
3/8" left, acetylene/propane with 9 mm spouts	1701040
▶ Nuts and grommets	



PISTOL-SHAPED GAS LIGHTER

1701200	
▶ with flint 2.6 x 5.0 mm	
▶ nickel-plated	
100 replacement flints, 2.6 x 5.0 mm	1701201



GAS LIGHTER ROLLER FILE

1701100	
▶ with flint 3.0 x 20 mm	
▶ 10 replacement flints, 3.0 x 20 mm	
1701101	

Soft soldering/heating and brazing

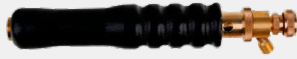
Soft soldering



COMPLETE SOLDERING IRON

Handle: G 3/8" L Art. no. 1711501

► comprises: Handle, hammer soldering iron 350 g piston torch, piston holder, draft shield



HANDLE

Hose connection: M 10 x 1 LH 1711502

STRAIGHT HAMMER SOLDERING IRON

250 g 1711503



CRANKED HAMMER SOLDERING IRON

350 g 1711504
500 g 1711505



TAPERED SOLDERING IRON

250 g 1711506
350 g 1711507



Windshield



Piston torch



Piston holder

WINDSHIELD/PISTON TORCH/PISTON HOLDER

Windshield 1711508
Piston torch 1711509
Piston holder 1711510



COMPLETE SOLDERING DEVICE FOR PROPANE

G 3/8" LH 1711500

► Scope of delivery: Standard handle G 3/8 "LH, piston burner, piston holder, draft shield, hammer soldering iron 350 g, small propane canister, HP hose 1.5 m bds. G3/8" LH, installation spanner, small pressure regulator

Preheating and brazing



PROPANE HANDLE

Art. no. 1711403

with main shut-off valve, momentary lever and adjustable wax damper setting

► Operating pressure: 1.5 - 4 bar
Hose connection: G 3/8" LH, connection for insert: M 14 x 1



PROPANE SOFT SOLDERING INSERTS

Size 3 Hole 3 mm 1711404
Size 5 Hole 5 mm 1711405
Size 7 Hole 7 mm 1711406

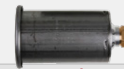
► Operating pressure: 1.5 - 2.5 bar



PROPANE BRAZING INSERTS

Size 12 for copper pipes \varnothing 12 mm 1711407
Size 14 for copper pipes \varnothing 18 mm 1711408
Size 17 for copper pipes \varnothing 22 mm 1711409
Size 20 for copper pipes \varnothing 28 mm 1711410

► Operating pressure 1.5 - 2.5 bar



TORCH HEAD - STAINLESS STEEL/ALUMINIUM

\varnothing 30 mm, approx. 600 g/h ⁽¹⁾; 1711411
15.5 kW/h at 1.5 bar

\varnothing 40 mm, approx. 2000 g/h ⁽¹⁾; 1711412
27 kW/h at 1.5 bar

\varnothing 50 mm, approx. 3000 g/h ⁽¹⁾; 1711413
47.6 kW/h at 1.5 bar

\varnothing 60 mm, approx. 5000 g/h ⁽¹⁾; 1711414
70.8 kW/h at 1.5 bar

\varnothing 80 mm, approx. 6200 g/h ⁽¹⁾; 1711415
93.6 kW/h at 1.5 bar

Operating pressure 1.5 - 2.5 bar

(1) Gas consumption at 1.5 bar



STEEL CONNECTING TUBE

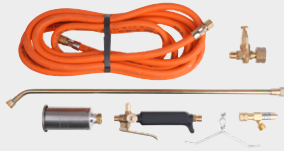
Connecting pipe 75 mm long 1711416
Connecting pipe 150 mm long 1711417
Connecting pipe 220 mm long 1711418
Connecting pipe 350 mm long 1711419
Connecting pipe 600 mm long 1711420
Connecting pipe 700 mm long 1711421
Connecting pipe 1,000 mm long 1711422

Union nut M 14 X 1 on one side, union nut male thread M 20 x 1 on the other side



BRAZING SET FOR PROPANE

1711400
► comprises: Propane handle, "MINI" small pressure regulator with combination connection and pressure gauge, brazing inserts: Sizes 12, 14, 17, 20, 1.5 m HP hose, G 3/8" LH union nut, burner spanner, gas lighter, in sheet steel box



PROFESSIONAL HEATING SET FOR PROPANE Art. no.
 ▶ consisting of: Propane handle, connecting pipe 600 mm, burner head ø 50 mm, storage device, 5 m HP hose, G 3/8" LH union nut, "MINI" small pressure regulator with combination connection without pressure gauge, 12 kg/h hose rupture safety device

Accessories



SMALL BOTTLE Art. no.
for propane 425 g 1711520
 ▶ TÜV tested. Seamless drawn steel bottle with valve and hook
 ▶ Connection: G 3/8" LH
 ▶ With stand



TRANSFER NOZZLE 1711521
 ▶ For filling the 425 g mini bottle from 5 kg and 11 kg bottles (household connection)



LIQUID GAS SMALL PRESSURE REGULATOR "MINI" 1711522
 ▶ Without pressure gauge
 ▶ Back pressure adjustable: 0 - 6 bar
 ▶ Performance: 6 kg/h
 ▶ Hose connection: G 3/8" LH
 ▶ LH for small bottle



LIQUID GAS SMALL PRESSURE REGULATOR 1711523
 ▶ with pressure gauge and combi connection
 ▶ Back pressure adjustable: 0 - 6 bar
 ▶ Performance: 18 kg/h
 ▶ Hose connection: G 3/8" LH



HOSE RUPTURE SAFETY DEVICES - PROPANE 1711524
 ▶ The hose rupture safety device prevents gas from escaping if the hose line is damaged or comes loose and shuts off the gas flow as soon as the prescribed operating volume is exceeded by 10 %. For manual reopening. Not mandatory for very small bottles!
 ▶ 0.5 - 4.0 bar- 4.8 - 10 kg/h
 ▶ Nominal pressure: 0.5 - 4 bar
 ▶ Nominal flow rate: 4.8 - 10 kg/h
 ▶ Input: G 3/8" LH female thread
 ▶ Outlet G 3/8" LH male thread



HIGH-PRESSURE HOSE LINE PB 30 Art. no.
 6.3 x 5 mm
 G 3/8 "LH x G 3/8" LH x 5000 mm 1711525
 6.3 x 5 mm
 G 3/8 "LH x G 3/8" LH x 10000 mm 1711526
 4 x 4 mm
 G 3/8 "LH x G 3/8" LH x 2000 mm 1711527
 4 x 4 mm
 G 3/8 "LH x G 3/8" LH x 5000 mm 1711528

Piezo soldering system

PROPANE TORCH SYSTEM Art. no.



MULTI HANDLE with plug-in/latch connection 1711601

- ▶ for tool-free torch insert
- ▶ Combination of automatic ignition and lockable momentary lever
- ▶ for hard and soft soldering, as well as fine soldering and shrinking, for propane operation according to the Bunsen principle
- ▶ Ergonomic plastic handle
- ▶ Automatic ignition for one-hand operation at the push of a lever
- ▶ Gas regulation with separate regulating and shut-off valve
- ▶ Rotatable hose connection G 3/8 LH
- ▶ Multi-handle suitable for size 17/19 hard soldering torches and size 5/7 soft soldering torches
- ▶ Gas pressure: max. 4 bar
- ▶ Throughput capacity: max. 6 kg/h



BRAZING TORCH
 Gas outlet 17 mm/ø 1711602
 Gas consumption kg/h at 2.0 bar: 0.320
 Gas outlet 19 mm/ø 1711603
 Gas consumption kg/h at 2.0 bar: 0.41
 Brazing torch Gas outlet 7 mm/ø 1711605
 Gas consumption kg/h at 2.0 bar: 0.222

SOFT SOLDERING TORCH
 Soft soldering torch Gas outlet 5 mm/ø 1711604
 Gas consumption kg/h at 2.0 bar: 0.12



Fig. similar

HARD AND SOFT SOLDERING SET with bottle 1711600
 ▶ Handle with piezo igniter, turbo burner 17 mm, HP hose 2.0 m, G 3/8 LH, small regulator fixed at 2.0 bar, small cylinder 425 g capacity, suspension hook

TURNTABLES AND ROLLER BLOCK TURNING DEVICES



SPV 30 – Welding positioning device, table model with manual operation
SPV 300 / SPV 300 HM – Manually operated welding positioning device

- ▶ For fast and convenient welding processing from all sides
- ▶ Easy to use
- ▶ Manual adjustment of the working height
- ▶ Turntable can be positioned vertically and horizontally



Model		SPV 30	SPV 300	SPV 300 HM
Art. no.		1540030	1540300	1540305
Technical data				
Table tilt angle	°	360	360	22.5 / 45 / 90
Horizontal load capacity	kg	360	300	300
Vertical load capacity	kg	260	150	150
Turntable diameter	mm	260	300 x 300	300 x 300
Dimensions (L x W x H) approx.	mm	630 x 350 x 280	1427 x 1200 x 1018	600 x 600 x 710
Weight approx.	kg	28	135	86

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

Welding turntables

Series SDT WE - Welding turntables with electric angle adjustment

- ▶ Simple operation
 - ▶ Simple angle adjustment via rotary knob
 - ▶ Infinitely adjustable disc speed
 - ▶ Clockwise/anticlockwise rotation
 - ▶ Control electronics protected by robust and closed housing
- ▶ Foot switch for start/stop
- From SDT 500WE:**
- ▶ Electric angle adjustment via rotary knob
- SDT 500 HC WE:**
- ▶ With hollow shaft Ø 170 mm



SDT 350 WM



SDT 2500 WE



SDT 500 HC WE

ACCESSORIES



ACCESSORIES

	Art. no.
SDT 350 WM / SDT 500 WE	
Three-jaw chuck Load capacity 120 kg	1541352
SDT 500 WE	Art. no.
Three-jaw chuck Load capacity 240 kg	1541353
SDT 350 WM	Art. no.
Three-jaw chuck Load capacity 30 kg	1541351

ACCESSORIES

for three-jaw chuck	Art. no.
Replacement clamping jaws for three-jaw chuck SDT 350 WM + SD 500 WE	1541360
Replacement clamping jaws for three-jaw chuck SDT 500 WE	1541361
Replacement clamping jaws for three-jaw chuck SDT350 WM	1541362

See our capabilities for yourself and request a personal consultation!



Contact: +49 (0) 951 96 555-501
beratung@schweisskraft.de

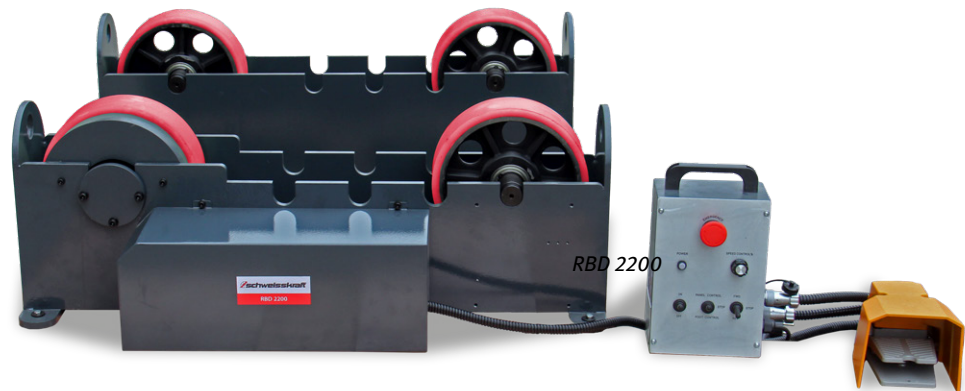
Technical data		SDT 220 WM	SDT 350 WM	SDT 500 WE	SDT 500 HC WE	SDT 1500 WE	SDT 2500 WE	SDT 4000 WE
Article number		1541220	1541350	1541500	1541505	1541915	1541925	1541940
Table tilt angle	°	0 – 135	0 – 135	-45 – 90	0 – 135	0 – 135	0 – 135	0 – 135
Infinitely variable speed	min ⁻¹	0 – 5	0 – 5	0 – 5	0 – 5	0.1 – 1.2	0.1 – 1.2	0.1 – 1.2
Horizontal/vertical load capacity	kg	220 / 100	350 / 120	500 / 250	500 / 250	1500 / 1000	2500 / 2000	4000 / 2700
Turntable diameter	mm	330	330	550	560	1000	1100	1200
Permissible welding current	A	80	300	300	120	800	800	800
Input power ~ 50 Hz	kW / V	0.15 / 230	0.125 / 230	0.400 / 230	0.8 / 230	0.75 / 400	1.5 / 400	1.5 / 400
Dimensions (L x W x H) approx.	mm	470 x 400 x 450	410 x 470 x 475	770 x 650 x 660	790 x 690 x 660	1576 x 1190 x 990	1735 x 1276 x 1050	1805 x 1310 x 1150
Weight approx.	kg	34	38	220	230	1170	1550	1790
Transport surcharge ¹⁾		-	TPZRS3 = €35.00			TPZDF1 = €345.00		

Roller block turning device RBD For professional welding processing

- ▶ Precise and high-quality weld seams possible thanks to infinitely adjustable workpiece
- ▶ speed
- ▶ For machining cylindrical workpieces
- ▶ With foot switch for start/stop
- ▶ Adjustable direction of rotation



RBD 1200

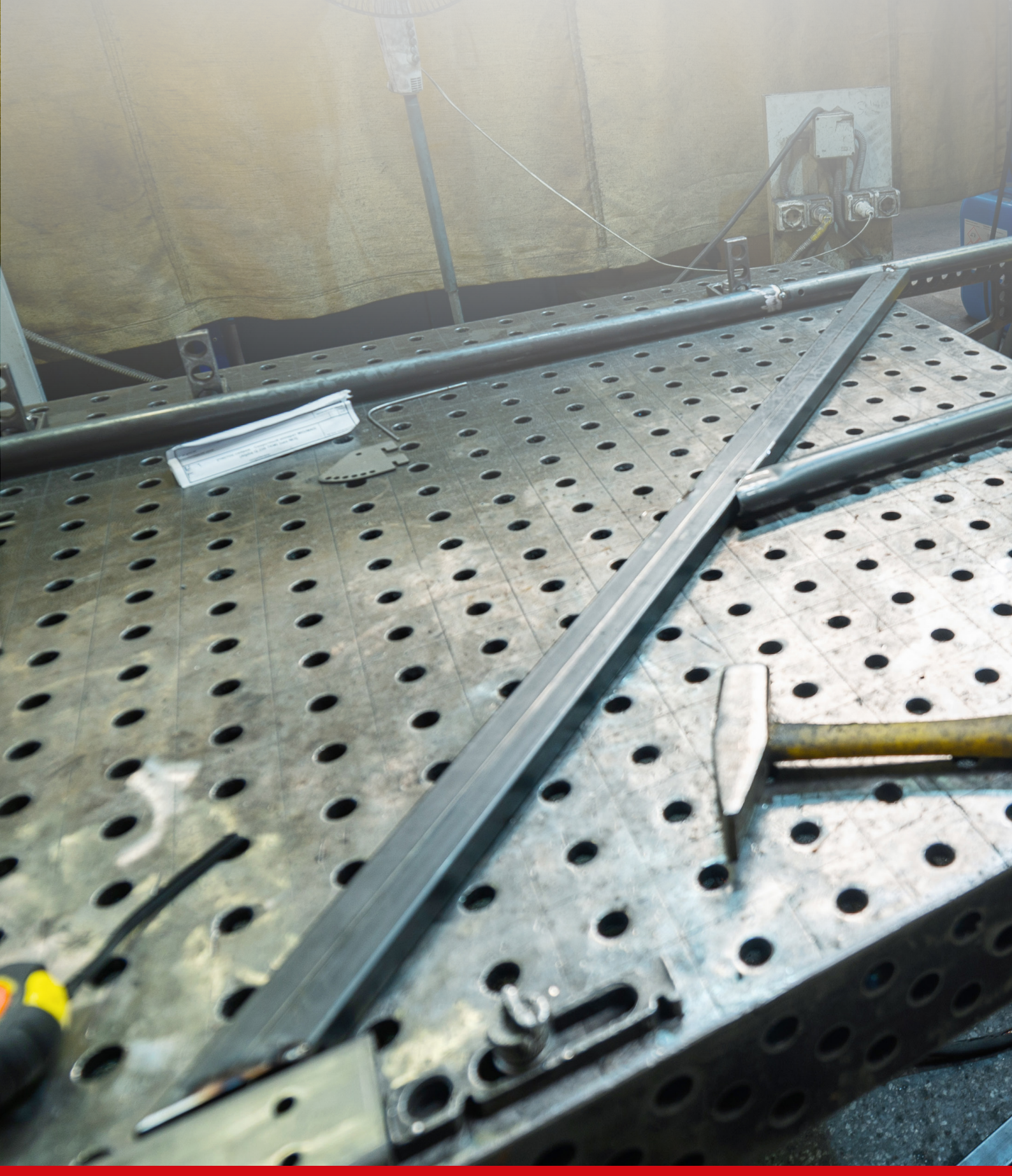


RBD 2200

Model		RBD 1200	RBD 2200	RBD 5000
Article no.		1542120	1542220	1542500
Load capacity	kg	1200	2200	5000
Workpiece diameter	mm	20 – 800	101 – 1524	304 – 2438
Speed	min ⁻¹	1413	3641	1475
Connection voltage ~50 Hz	V	230	230	230
Dimensions of drive unit (L x W x H) approx.	mm	552 x 324 x 336	940 x 407 x 336	1624 x 525 x 458
Dimensions of guide unit (L x W x H) ca.	mm	450 x 229 x 336	940 x 294 x 336	1418 x 410 x 457
Dimensions of switch box(L x W x H) ca.	mm	170 x 120 x 250	170 x 120 x 250	170 x 120 x 250
Weight approx.	kg	86	220	325

1) Inbound transport surcharge, see reverse side for explanation

ASSEMBLY AND WELDING TABLE TURNTABLE AND LIFT TABLE



MAT 300 S - Assembly and welding table with slotted plate and 300 kg load capacity

- ▶ Perfect for preparing welding work: Workpieces can be easily clamped and fixed with spot welds
- ▶ Fixing, clamping, welding, assembly: Can be used universally thanks to the extensive range of accessories
- ▶ Grooves in the table 10 mm wide
- ▶ Table with stable stand
- ▶ Feet adjustable in height by 6 cm
- ▶ Table top is also available separately and can also be used on existing base elements
- ▶ Work surface made of 4 mm steel with phosphated surface



Illustration shows accessories (tensioner, lever, clamps)

Model		MAT 300 S
Art. no.		1520000

Technical data		
Load capacity	kg	300
Table height min. / max.	mm	850 – 910
Dimensions (L x W x H) approx.	mm	1200 x 800 x 850
Weight approx.	kg	76
Transport packaging flat rate ⁽¹⁾		TVP 0 = €19.00

MAT 500 S - Assembly and welding table with Ø 28 mm perforated plate and 500 kg load capacity

- ▶ Perfect for preparing welding work: Workpieces can be easily clamped and fixed with spot welds
- ▶ Fixing, clamping, welding, assembly: Can be used universally for ergonomic and flexible working thanks to the extensive range of accessories
- ▶ Table with stable stand
- ▶ Feet adjustable in height by 6 cm
- ▶ Work surface made of 4 mm steel with phosphated surface



Model		MAT 500 S
Art. no.		1520003

Technical data		
Load capacity	kg	500
Table height min. / max.	mm	875 – 940
Dimensions (L x W x H) approx.	mm	1200 x 800 x 875
Weight approx.	kg	77
Transport packaging flat rate ⁽¹⁾		TVP 0 = €19.00

MAT 300 SH - Height-adjustable assembly and welding table with Ø 28 mm perforated plate and 300 kg load capacity

- ▶ Perfect for preparing welding work. Workpieces can be easily clamped and fixed with spot welds
- ▶ Fixing, clamping, welding, assembly: Thanks to extensive accessories and lifting function, it can be used universally for ergonomic and flexible working.
- ▶ Sturdy pallet truck frame "Made in Germany"
- ▶ Work surface made of 4 mm steel with phosphated surface



Illustration shows Accessories

- ▶ Application example with 1528188 clamping bolt Ø28mm Allen key and 1528187 clamping bolt Ø28mm clamping lever



- ▶ Clamping range of the Vario clamping bolt 0 - 75 mm

Model		MAT 300 SH
Art. no.		1520002

Technical data		
Load capacity	kg	300
Table height min. / max.	mm	460 – 1060
Dimensions (L x W x H) approx.	mm	1200 x 800 x 460
Weight approx.	kg	106
Transport packaging flat rate ⁽¹⁾		TVP 0 = €19.00

(1) Explanation of transport surcharges see overleaf, price TVP plus VAT.

Accessories

Accessories for slotted plates

Stop and clamping element 1528150
 ▶ with quick-tensioner for tool-free positioning in grooves with a width of 8 - 10 mm



Eccentric clamp Ø 30 mm 1528152
 ▶ Made of steel with burnished surface
 ▶ Dimensions approx. 100 x 44 mm



› Can be used in conjunction with clamping element (1528150) as an eccentric clamp

Swivel bearing with grub screw for eccentric clamp Ø 30 mm 1528154
 ▶ With M6 grub screw



› Can be used in conjunction with plate 180 x 40 mm (1528157), eccentric clamp (1528152) and clamping element (1528150) for workpiece fixing

Stop screw 1528155
 ▶ Stop diameter 30 mm, length 48 mm, thread M8
 ▶ 2 nuts and 2 washers Ø 30 mm included in the scope of delivery

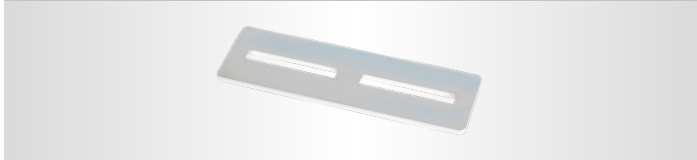


▶ Can be used in conjunction with bracket (1528158 or 1528159) and clamping element (1528150) as a flexible stop

Plate 180 x 40 mm with thread 1528157
 ▶ M6 threaded hole
 ▶ Slot width 10.5 mm



Plate 200 x 60 mm 1528156
 ▶ Slot width 10.5 mm



Angle 80 x 40 x 60 mm 1528158
 ▶ Slot width 12.5 mm



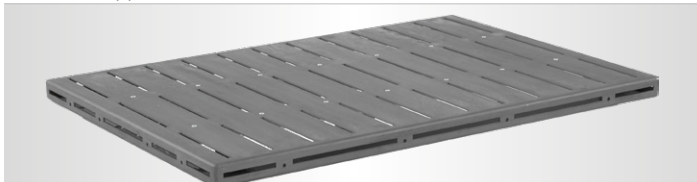
Angle 80 x 80 x 60 mm 1528159
 ▶ Slot width 12.5 mm



Adapter block 50 x 50 x 12 mm 1528160
 ▶ made of aluminium



Metal table top 1520001
 ▶ Slot width 10 mm
 ▶ Dimensions (L x W x H) approx.: 1200 x 800 x 50 mm
 ▶ Weight approx. 47 kg

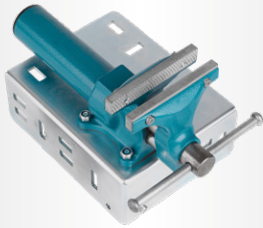


Support rail and stop rail 1190 mm
 ▶ Suitable as a long stop or extension of the worktop
 ▶ Zinc-phosphatised surface to protect against corrosion and weld spatter
 ▶ Steel square tube 40 x 40 mm with 8 mm grooves
 ▶ Two stop and clamping elements for tool-free positioning on slotted plates

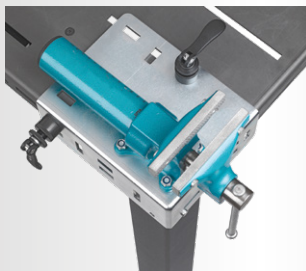


Vice 1528170

- ▶ Can be mounted horizontally and vertically
- ▶ Quick adjustment for large span differences without operating the swivel joint, pre-setting of the opening width using a scale
- ▶ Clamping force is 10 kN



Technical data		Vice
Span	mm	130
Clamping depth	mm	65
Jaw width	mm	120



▶ Image shows horizontal fixation with two stop and clamping elements (1528150) - not included in the scope of delivery

Starter set clamping system for assembly and work table with 8 - 10 mm slots 1528100

- ▶ Clamping system for assembly and work tables for all standard aluminium profiles and groove widths
- ▶ Push-turn-fix, it couldn't be easier or quicker
- ▶ The quick-release clamps can be used almost universally and are supplied to fit the profiles of all well-known manufacturers with groove widths of 8 and 10 mm

Scope of delivery:

- ▶ Organiser panel with mounting pins
- ▶ 6 quick releases Ø 30 mm
- ▶ 6 eccentric clamps Ø 30 mm made of PU
- ▶ 4 rotary bearings with threaded pin for eccentric clamp Ø 30 mm
- ▶ 1 round adapter plate with tensioner
- ▶ horizontal length 250 mm
- ▶ 1 round adapter plate with vertical clamp, length 250 mm
- ▶ 2 Adapter block
- ▶ 4 adapter brackets 80 x 40 x 60 mm
- ▶ 4 stop screws
- ▶ 6 adapter plates 180 x 40 mm



Accessories for perforated panels

Vario tensioning bolt

- ▶ Compatible with standard welding tables, standard stop elements and existing accessories
- ▶ Extremely flexible use thanks to variable and infinitely variable clamping range
- ▶ Very easy to adjust and operate thanks to new and patented clamping system
- ▶ Robust and insensitive

16 S	1528186
16 K	1528187
28 S	1528188
28 K	1528189



Model	16 S	16 K
Art. no.	1528186	1528187
Clamping	Hexagon socket	Clamping lever
Tightening torque	very high	high
Clamping range	mm	0 – 36
Diameter	mm	16

Model	28 S	28 K
Art. no.	1528188	1528189
Clamping	Hexagon socket	Clamping lever
Tightening torque	very high	high
Clamping range	mm	0 – 75
Diameter	mm	28



▶ Clamping a Vario clamping bolt 28 S with Allen key



▶ Tool-free clamping of a Vario clamping bolt 28 K
▶ Stepless clamping of up to three stop elements

Vario clamping bolt set

- ▶ 4 Vario clamping bolts each with hexagon socket and clamping lever fastening

Ø 16 mm	1528192
Ø 28 mm	1528193

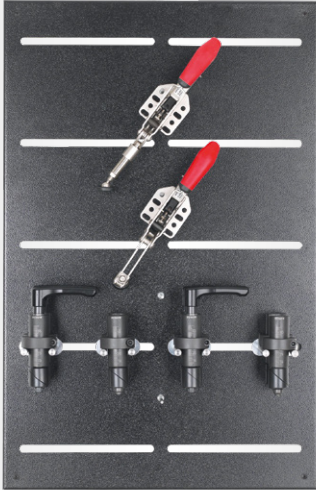


Accessories

Vario clamping bolt starter set

- ▶ Organiser panel with mounting pins
- ▶ 1 Horizontal clamp with clamping bolt
- ▶ 1 Vertical clamp with clamping bolt
- ▶ 4 Vario clamping bolts each with Allen and clamping lever fixation

Ø 16 mm	1528190
Ø 28 mm	1528191



Support rail and stop rail 1190 mm

- ▶ Suitable as a long stop or extension of the worktop
- ▶ Zinc-phosphatised surface to protect against corrosion and weld spatter
- ▶ Steel square tube 40 x 40 mm with 8 mm grooves
- ▶ Two clamping bolts with clamping levers for tool-free positioning on hole plates

with clamping bolt Ø 16 mm	1528182
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High-quality quick-tensioners with variable tension height

- ▶ Infinitely variable equalisation function for workpieces with different clamping heights or widths without readjustment on the spindle
- ▶ Galvanised and passivated
- ▶ Ergonomic, oil-resistant handle with large palm rest and soft component
- ▶ Loss protection for the pressure screw at the end of the clamping arm



› Stepless equalisation function without adjusting the spindle

Suitable for slotted plates

Right angle clamp with round adapter plate, closed

- ▶ Suitable for fixing to slotted hole plates with two stop and clamping elements, 1528150 (not included in the scope of delivery)

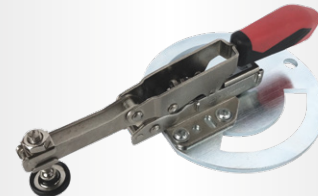
Length 179 mm, clamping range 0 - 25 mm	1528161
Length 253 mm, clamping range 0 - 35 mm	1528162



Vertical clamp with round adapter plate, closed

- ▶ Suitable for fixing to slotted hole plates with two stop and clamping elements, 1528150 (not included in the scope of delivery)

Length 173 mm, clamping range 0 - 35 mm	1528163
Length 244 mm, clamping range 0 - 40 mm	1528164



Horizontal clamp on tripod

- ▶ Height of the tripod 300 mm
- ▶ with clamping for grooves 8 - 10 mm

Length 179 mm, clamping range 0 - 25 mm	1528165
Length 253 mm, clamping range 0 - 35 mm	1528166



Vertical clamp on tripod

- ▶ Height of the tripod 300 mm
- ▶ with clamping for grooves 8 - 10 mm

Length 173 mm, clamping range 0 - 35 mm	1528167
Length 244 mm, clamping range 0 - 40 mm	1528168

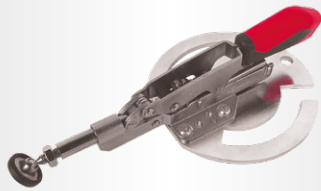


Suitable for perforated plates Ø 16 or 28 mm

Horizontal clamp with round adapter plate, open

- ▶ Suitable for fixing to perforated plates
- ▶ Fixing with two clamping bolts with disc (not included in the scope of delivery)

Length 253 mm, clamping range 0 - 35 mm	1528172
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Vertical clamp with round adapter plate, open

- ▶ Suitable for fixing to perforated plates
- ▶ Fixing with two clamping bolts with disc (not included in the scope of delivery)

Length 244 mm, clamping range 0 - 40 mm	1528173
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Clamping bolt with disc

- ▶ For fixing the round adapter plate, open

Ø 16 mm	1528184
Ø 28 mm	1528185



Horizontal clamp with clamping bolt

- ▶ Length of the tensioner 253 mm
- ▶ Clamping range 0– 35 mm
- ▶ With clamp for perforated panels

Ø 16 mm	1528176
Ø 28 mm	1528174



Vertical clamp with clamping bolt

- ▶ Length of the tensioner 244 mm
- ▶ Clamping range 0– 40 mm
- ▶ With clamp for perforated panels

Ø 16 mm	1528177
Ø 28 mm	1528175



Vertical clamp on stand with clamping bolt for perforated plates

- ▶ Tripod height 300 mm
- ▶ Clamping range 0– 40 mm
- ▶ With clamp for perforated panels

Ø 16 mm	1528180
Ø 28 mm	1528181



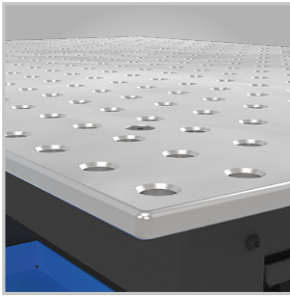
Horizontal tensioner on tripod with clamping bolt

- ▶ Tripod height 300 mm
- ▶ Clamping range 0– 35 mm
- ▶ With clamp for perforated panels

Ø 16 mm	1528178
Ø 28 mm	1528179



Siegmund Workstation



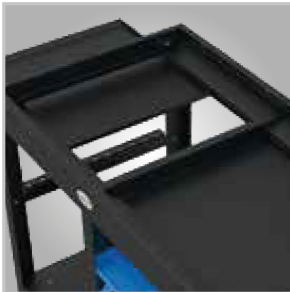
Perforated plate (1200 x 800 mm)

- ▶ Made from through-hardened X8.7 tool steel
- ▶ Resistant to scratches, excellent impact resistance, high point load and long service life



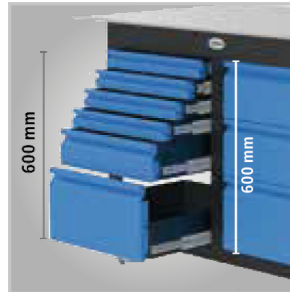
Feet with finely adjustable discs

- ▶ The foot plates are finely adjustable and enable a precise work surface
- ▶ The combination of feet and the optionally available rollers makes the Siegmund workstation mobile



Dirt protection under the table top

- ▶ There are two plates underneath the tabletop to protect your tools from welding beads and dirt
- ▶ You can pull out the two trays like drawers for cleaning.



Space saver

- ▶ There is defined storage space for many items in the workstation. There is space for various accessories on the shelves. So you have everything in hand. You can optionally add drawers in different heights to your workstation. Here you will find space for every type of tool.

WORKSTATION 0806



inclusive
1 x 120 mm drawer



Closed
inclusive
2 x 180 mm drawer
1 x 240 mm drawer
1 set of walls

WORKSTATION 1208



Including
shelves

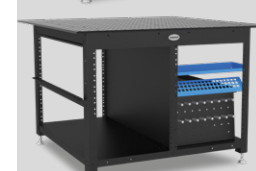


inclusive
2 x 180 mm drawer
1 x 240 mm drawer
1 set of walls

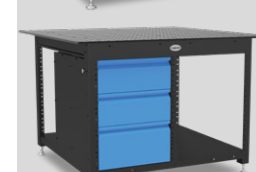


Closed
inclusive
2 x 180 mm drawer
1 x 240 mm drawer
1 set of walls

WORKSTATION 1212



Including
shelves



inclusive
1 x 120 mm drawer



Closed
inclusive
4 x drawer 180 mm
2 x 240 mm drawer
2 set of walls

Siegmund Workstation



The intelligent concept of the workstation means you always have your tools to hand at your workstation. This creates clarity and organisation and offers you sufficient space for your accessories.



Technical data	Siegmund Workstation
Load capacity (0806)	356 kg
Load capacity (1208)	912 kg
Load capacity (0806)	869 kg
Bore diameter	16 mm
Bore spacing	50 mm
Table top material thickness	11.5 – 13
Dimensions (L x W) (0806)	800 x 650 mm
Dimensions (L x W) (1208)	1200 x 800 mm
Dimensions (L x W) (1212)	1200 x 1200 mm
Height dimensions	850 mm

Model	Art. no.
Workstation 0806	191164900
Workstation 0806 incl. drawer	191164903
Workstation 0806 closed incl. 3 drawer	191164907
Workstation 1208	191164400
Workstation 1208 incl. shelves	191164401
Workstation 1208 incl. 3 drawer	191164407
Workstation 1208 closed incl. 6 drawer	191164409
Workstation 1212	191164600
Workstation 1212 incl. shelves	191164601
Workstation 1212 closed incl. 3 drawer	191164607
Workstation 1212 closed incl. 6 drawer	191164609

Accessories for workstation basic package and workbench



Accessories	Art. no.
① Workstation base frame	194004002
② Shelf	194004020
③ Tool wall incl. shelf	194004025
④ Equipped with 4 rollers	194004100
⑤ Drawer 60 mm	194004200
⑥ Drawer 120 mm	194004205
⑦ Drawer 180 mm	194004210
⑧ Drawer 240 mm	194004215
⑨ Clamp holder	194164030
⑩ Bolt and prism bracket	194164035
⑪ Tool set A	
▶ 2 screw clamps	
▶ 6 quick-release bolts	194167320
▶ 4 stops	
▶ 1 Allen key	
⑫ Tool set B	
▶ 4 screw clamps	
▶ 8 quick-release bolts	
▶ 6 stops	194167340
▶ 2 Stop and clamping angle	
▶ 1 Allen key	
▶ 1 x 100 mm vice	
⑬ Eccentric stop Ø 75 mm - nitrided	194160403 N
⑭ Flex stop 12 x 83 mm - aluminium	194160412
⑮ Universal stop 80 L - nitrided	193160410 N
⑯ Universal stop 115 L - nitrided	193160420 N
⑰ Angle setting template - nitrided	194160455 N
⑱ Stop and clamping bracket 50 L - nitrided	194160105 N
⑲ Stop and clamping angle 90 X - nitrided	193160108 N
⑳ Stop and clamping bracket 90 L - nitrided	193160110 N
㉑ Stop and clamping bracket 300 G - nitrided	193160162 N
㉒ Stop and clamping bracket 500 G - nitrided	194160164 N
㉓ Stop and clamping bracket 500 GK left - nitrided	193160134 N
㉔ Stop and clamping bracket 500 GK right - nitrided	193160136 N

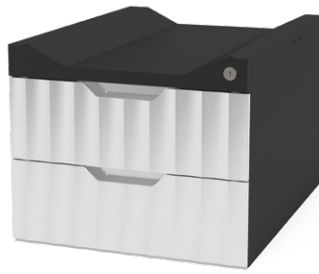
Accessories	Art. no.
㉕ Quick-release pin short - burnished	193160510
㉖ Ball stud flat short - burnished	194160522
㉗ Ball stud flat long - burnished	194160523
㉘ Countersunk bolt short - burnished	194160528
㉙ Staking bolt - burnished	194160540
㉚ Connecting bolt short - nitrided	194160560 N
㉛ Magnetic clamping bolt 34 mm - aluminium	194160740
㉜ Professional screw clamp - burnished / nitrided	193160610
㉝ Professional screw clamp 45°/90° - burnished	193160630
㉞ Universal pipe screw clamp - burnished	194160604
㉟ Basic screw clamp - burnished	194160620
㊱ Prism for screw clamps - burnished / nitrided	194160656
㊲ Duo prism Ø 25 mm - burnished / nitrided	194160650
㊳ Vario prism Ø 50 mm 90°/120° with screwed-in collar - nitrided	1931606451 N
㊴ Reducing bush 28 mm -> 16 mm - burnished	194000546
㊵ Allen key 4 mm	193160852
㊶ Torch holder - burnished	193160920
㊷ Brush Ø 17 mm with protective cap	193160820
㊸ Combination whetstone 150 x 50 x 25 mm	193000942
㊹ CleanBasic 1 litre in spray bottle	194000914
㊺ CleanBasic 5 litres	194000915
㊻ Non-stick with corrosion protection 1 litre in spray bottle	194000924
㊼ Non-stick with corrosion protection 1 litre in pump bottle	194000929
㊽ Non-stick with corrosion protection 5 litres	194000926
㊾ Premium vice 100 mm	194004300
㊿ Quick-release bolt without groove, triple-burnished	194160513
⓫ Table press	

Options (ex works only)	Art. no.
Surcharge for plasma nitriding	194164004XX

Accessories for workbenches

Drawer box incl. 2 drawers

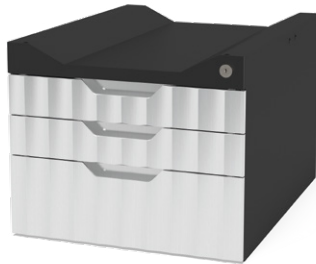
- ▶ 2x Drawer 160mm
- ▶ Lockable
- ▶ Two keys included
- ▶ Drawer pull-out 500 mm



Model	Drawer box incl. 2 drawers
Article number	19316BX000990
Dimensions (L x W x H)	623 x 472 x 387 mm
Weight	27 kg
Load capacity	100 kg

Drawer box incl. 3 drawers

- ▶ 2x Drawer 80mm
- ▶ 1x Drawer 160mm
- ▶ Lockable
- ▶ Two keys included
- ▶ Drawer pull-out 500 mm



Model	Drawer box incl. 3 drawers
Article number	19316BX0009901
Dimensions (L x W x H)	623 x 472 x 387 mm
Weight	30 kg
Load capacity	100 kg

Stop and clamping angle 95L

- ▶ Combination of borehole and slotted hole
- ▶ Increased stability due to struts



Model	Stop and clamping angle 95L
Article number	193160117A

Sliding block SET swivelling + clamping bush

- ▶ 1x Set sliding block HX8 M6 swivelling (pack of 4)
- ▶ 1x set of clamping bushes with collar (pack of 4)



Model	Sliding block SET swivelling + clamping bush
Article number	193160548

Basic screw clamp for workbench nitrided

- ▶ Vertical brace is hardened
- ▶ Horizontal brace painted / powder-coated
- ▶ Ball diameter spindle 8mm
- ▶ Trapezoidal thread spindle 12x4 mm
- ▶ Especially for table surfaces made of aluminium profiles



Model	Base screw clamp
Article number	193160621

Height-adjustable turntable – quick and easy to achieve the right working height

Ergonomic working in a small space

▶ The height-adjustable turntable from Siegmund offers you a space-saving and ergonomic work surface. You can adjust the

working height steplessly by turning the plate. Use the locking unit on the side to fix the position of the worktop

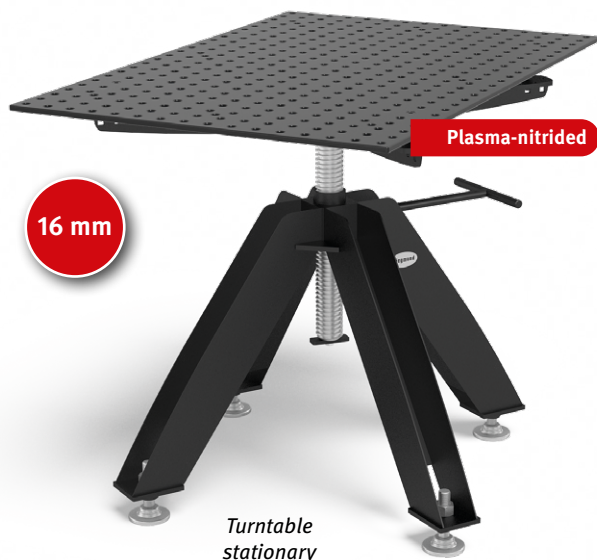
360° processing

▶ With the height-adjustable turntable, you can easily reach and process your workpiece from all sides

VERSIONS:

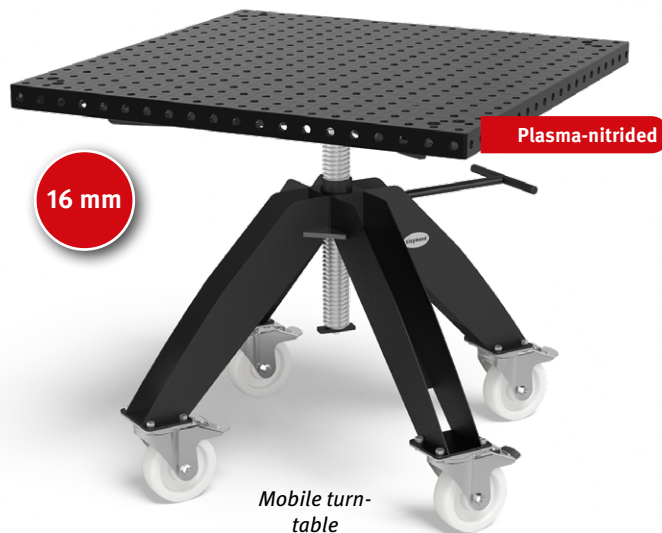
Stationary base frame

▶ With sturdy base plates for a secure stand



Mobile base frame

▶ With sturdy swivel castors and parking brakes with the same load capacity as the stationary version



Model	System 16 station-ary 1200 x 800 x 12	System 28 station-ary 1200 x 800 x 15	System 16 mobile 1200 x 800 x 12	System 28 mobile 1200 x 800 x 15	System 16 station-ary 1000 x 1000 x 50	System 16 mobile 1000 x 1000 x 50
Art. no.	192DS164004X7	192DS804004X7	192DM164004X7	192DM804004X7	192DS161010P	192DM161010P
Equipment	incl. perforated plate				incl. Basic table top	
Material	Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated				High-quality steel S355J2+N, plasma-nitrided and BAR-coated	
Bore Ø	16 mm	28 mm	16 mm	28 mm	16 mm	16 mm
Bore spacing	50 mm	100 mm	50 mm	100 mm	50 mm	50 mm
Material thickness	12 mm	15 mm	12 mm	15 mm	12 mm	12 mm
Load capacity	912 kg	888 kg	912 kg	888 kg	843 kg	843 kg
Length	1200 mm	1200 mm	1200 mm	1200 mm	1000 mm	1000 mm
Width	800 mm	800 mm	800 mm	800 mm	1000 mm	1000 mm
Table height	780 – 1100 mm	780 – 1100 mm	780 – 1100 mm	780 – 1100 mm	780 – 1100 mm	780 – 1100 mm
Weight approx.	158 kg	182 kg	158 kg	182 kg	227 kg	227 kg

Accessories

Accessories	Compatible with	Art. no.	€ plus VAT	Accessories	Compatible with	Art. no.	€ plus VAT
① System 16 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 4 stops ▶ 1 Allen key	192DS164004X7 192DM164004X7 192DS161010P 192DM161010P 192HT164004X7	193167320	394.00	③ System 28 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 6 spacer rings ▶ 6 stops ▶ 1 Allen key	192DS804004X7 192DM804404X7 192HT804004X7	193287320	623.00
② System 16 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1x 125 mm vice	192DS164004X7 192DM164004X7 192DS161010P 192DM161010P 192HT164004X7	193167340	978.00	④ System 28 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 8 spacer rings ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1x 125 mm vice	192DS804004X7 192DM804404X7 192HT804004X7	193287340	1368.00

Mobile lifting table including perforated plate for loads up to approx. 500 kg

- ▶ Quick and easy to achieve the ideal working height
- ▶ Set new standards in ergonomics and

- flexibility and benefit from the wide range of possible applications
- ▶ The sturdy steel construction offers stability

even when adjusting the working height



Model	System 16 mobile 1200x800x12	System 28 mobile 1200x800x12
Art. no.	192HT164004X7	192HT804004X7
Equipment	incl. perforated plate	
Material	Through-hardened tool steel X8.7 plasma-nitrided and BAR-coated	
Bore Ø	16 mm	28 mm
Bore spacing	50 mm	100 mm
Material thickness	12 mm	15 mm
Load capacity	500 kg (without plate)	
Length	1200 mm	
Width	800 mm	
Table height	700 – 1000 mm	
Weight approx.	153 kg	177 kg

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Accessories

Accessories	Compatible with	Art. no.	Accessories	Compatible with	Art. no.
① System 16 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 4 stops ▶ 1 Allen key	192DS164004X7 192DM164004X7	193167320	③ System 28 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 6 spacer rings ▶ 6 stops ▶ 1 Allen key	192DS804004X7 192DM804404X7	193287320
② System 16 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1 x 125 mm vice	192DS161010P 192DM161010P 192HT164004X7		④ System 28 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 8 spacer rings ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1 x 125 mm vice	192DS804004X7 192DM804404X7 192HT804004X7	

Lifting tables

Mobile lifting table including perforated plate for loads up to approx. 1000 kg

- ▶ Bores Surface in diagonal grid
- ▶ Quick and easy to achieve the ideal working height
- ▶ Set new standards in ergonomics and flexibility and benefit from the wide range of possible applications
- ▶ The sturdy steel construction offers stability even when adjusting the working height



System 16
Mobile lift table incl. perforated plate



System 28
Mobile lift table incl. perforated plate

Model	System 16 mobile 1500x1000x12	System 28 mobile 1500x1000x15
Art. no.	192HS164014X7	192HS804014XD7

Technical data		
Equipment	incl. perforated plate	
Material	Through-hardened tool steel X8.7 plasma-nitrided and BAR-coated	
Bore Ø	16 mm	28 mm
Bore spacing	50 mm	100 mm
Material thickness	11.5 – 13 mm	15 mm
Load capacity	1000 kg (without plate)	
Length approx.	1500 mm	
Width approx.	1000 mm	
Table height approx.	700 – 1,000 mm	
Weight approx.	335 kg	362 kg

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Accessories

①		②		③		④	
Accessories		Compatible with		Accessories		Compatible with	
<ul style="list-style-type: none"> ① System 16 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 4 stops ▶ 1 Allen key 		<ul style="list-style-type: none"> 192DS164004X7 192DM164004X7 192DS161010P 192DM161010P 192HT164004X7 		<ul style="list-style-type: none"> ③ System 28 tool set A ▶ 2 screw clamps ▶ 6 quick-release bolts ▶ 6 spacer rings ▶ 6 stops ▶ 1 Allen key 		<ul style="list-style-type: none"> 192DS804004X7 192DM804404X7 192HT804004X7 	
<ul style="list-style-type: none"> ② System 16 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1 x 125 mm vice 		<ul style="list-style-type: none"> 192DS164004X7 192DM164004X7 192DS161010P 192DM161010P 192HT164004X7 		<ul style="list-style-type: none"> ④ System 28 tool set B ▶ 4 screw clamps ▶ 8 quick-release bolts ▶ 8 spacer rings ▶ 6 stops ▶ 2 Stop and clamping angle ▶ 1 Allen key ▶ 1 x 125 mm vice 		<ul style="list-style-type: none"> 192DS804004X7 192DM804404X7 192HT804004X7 	
		Art. no.				Art. no.	
		193167320				193287320	
		193167340				193287340	

Materials in comparison for system 16/22/28

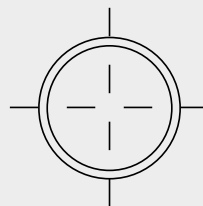
Model	PROFESSIONAL 750 with plasma nitriding	PROFESSIONAL EXTREME 8.7 with plasma nitriding	PROFESSIONAL EXTREME 8.7 PLUS with plasma nitriding
Vickers hardness	Basic hardness: approx. 165 - 220 Vickers Surface hardness: approx. 450 - 750 Vickers	Basic hardness: approx. 280 - 340 Vickers Surface hardness: approx. 450 - 850 Vickers	Basic hardness: approx. 280 - 340 Vickers Surface hardness: approx. 450 - 850 Vickers
Material	Specific base material S355J2+N, plasma-nitrided	Through-hardened tool steel made from special alloy Siegmund X8.7	Through-hardened tool steel made from special alloy Siegmund X8.7
Side panel	100 mm	100 mm	150 mm
Basic hardness	★★	★★★★★	★★★★★
Surface hardness	★★★★★	★★★★★	★★★★★
Impact resistance	★★★	★★★★★	★★★★★
Scratch resistance	★★★★	★★★★★	★★★★★
Protection against welding spatter	★★★★★	★★★★★	★★★★★
Corrosion resistance	★★★★★	★★★★★	★★★★★
Point load	★★★★	★★★★★	★★★★★
Flatness in new condition	★★★★★	★★★★★	★★★★★
Maintaining evenness after heavy use	★★★	★★★★	★★★★
Service life	★★★★	★★★★★	★★★★★

System 16 - For filigree applications

► For simple superstructures with a low weight of up to approx. 1000 kg per foot of basic equipment, we recommend System 16. Thanks to the standard bore spacing of 50 mm, you can also clamp small parts without any problems.

► Thanks to the sophisticated Siegmund modular system, all systems can be connected to each other using connecting elements.

- 1. Bore surface 50 x 50 mm grid
- 2. Bores with 2 mm radius
- 3. Corners and edges with radius 3 / 6 mm
- 4. Side panel height 100 mm Bore spacing side panel 25 mm
- 5. Including scaling on the surface
- 6. Construction reinforced by ribs



BORE Ø 16mm

MATERIAL

► Material thickness approx. 11.5 - 13 mm

PROFESSIONAL 750

► Plasma-nitrided and BAR-coated

PROFESSIONAL EXTREME 8.7

► Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated

PROFESSIONAL EXTREME 8.7 PLUS

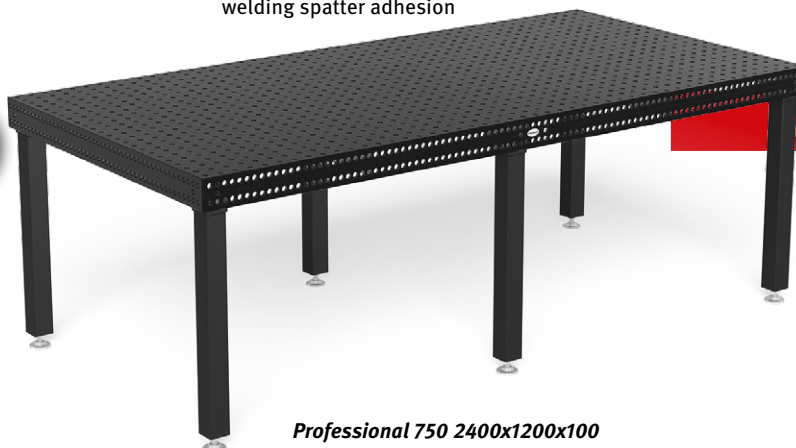
► Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated; **height side panel 150 mm**

Professional 750 series plasma nitrided – welding tables, surface hardness up to 750 Vickers!

- The bores have a diameter of 16 mm
- The table is made from high-quality S355J2+N steel, plasma-nitrided and BAR-coated

- The welding tables are fitted with a scale as standard
- Protection against rust, scratches and welding spatter adhesion

- Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient



Professional 750 2400x1200x100

Professional 750 welding table made from **high-quality steel S355J2+N plasma-nitrided**

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Professional 750 1200 x 1200 x 100	2000 kg	1200 mm	1200 mm	850 mm	261 kg	190160015P
Professional 750 2000 x 1000 x 100		2000 mm	1000 mm		354 kg	190160020P
Professional 750 2400 x 1200 x 100		2400 mm	1200 mm		503 kg	190160030P
Professional 750 3000 x 1500 x 100	4000 kg	3000 mm	1500 mm		758 kg	190160040P

System 16

Professional Extreme 8.7 series – Plasma-nitrided welding tables with surface hardness up to 850 Vickers!

- ▶ The bores have a diameter of 16 mm
- ▶ The table top is made from through-hardened X8.7 tool steel, plasma-nitrided and BAR-coated
- ▶ The welding tables are fitted with a scale as standard
- ▶ Protection against rust, scratches and welding spatter adhesion
- ▶ Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient
- ▶ Side panel with diagonal grid



Professional Extreme 8.7-4000x2000x100

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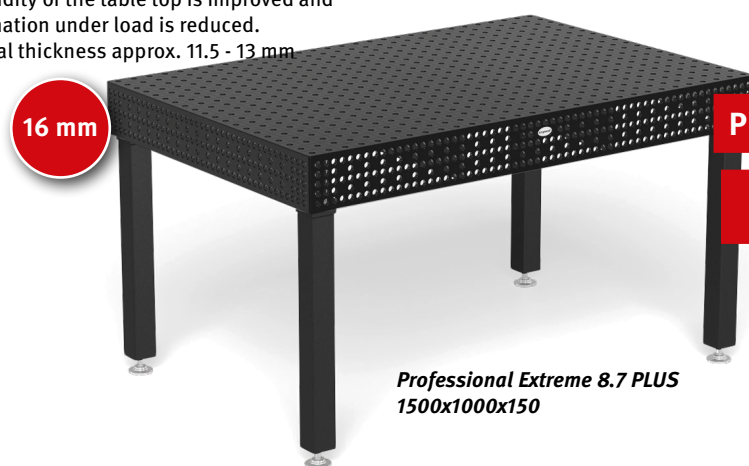


Professional Extreme 8.7 made from through-hardened tool steel X8.7 plasma-nitrided

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.	
Professional Extreme 8.7 - 1000x500x100	2000 kg	1000 mm	500 mm	850 mm	126 kg	190160005X7D	
Professional Extreme 8.7 - 1000x1000x100			1000 mm		192 kg	190160010X7D	
Professional Extreme 8.7 - 1200x800x100			800 mm		193 kg	190160025X7D	
Professional Extreme 8.7 - 1200x1200x100		1200 mm	1200 mm		259 kg	190160015X7D	
Professional Extreme 8.7 - 1500x1000x100			1000 mm		279 kg	190160035X7D	
Professional Extreme 8.7 - 1500x1500x100			1500 mm		394 kg	190160050X7D	
Professional Extreme 8.7 - 2000x1000x100		2000 mm	1000 mm		351 kg	190160020X7D	
Professional Extreme 8.7 - 2000x1200x100			1200 mm		412 kg	190160060X7D	
Professional Extreme 8.7 - 2400x1200x100			1200 mm		499 kg	190160030X7D	
Professional Extreme 8.7 - 3000x1500x100		4000 kg	3000 mm		1500 mm	753 kg	190160040X7D
Professional Extreme 8.7 - 4000x2000x100			4000 mm		2000 mm	1255 kg	190160055X7D

Professional Extreme 8.7 PLUS series – plasma-nitrided welding tables with surface hardness up to 850 Vickers!

- ▶ Professional Extreme PLUS with extra high side panel for particularly demanding applications. More possibilities than ever before.
- ▶ Thanks to the higher side panel and ribbing, the rigidity of the table top is improved and deformation under load is reduced.
- ▶ Material thickness approx. 11.5 - 13 mm
- ▶ Side panel made of high-quality steel S355J2+N + plasma nitriding
- ▶ Bore surface 50x50 mm grid
- ▶ Rounded corners, edges and drill holes
- ▶ Side panel, 3 rows of bores with 25 mm spacing, 2 rows with 50 mm spacing
- ▶ Including scaling on the surface
- ▶ Construction reinforced by ribs
- ▶ Grid lines enable precise superstructures



Professional Extreme 8.7 PLUS 1500x1000x150

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Professional Extreme 8.7 PLUS made from through-hardened tool steel X8.7 plasma-nitrided

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Professional Extreme 8.7 PLUS 1200x1200x150	2000 kg	1200 mm	1200 mm	850 mm	264 kg	190160015X7PL
Professional Extreme 8.7 PLUS 1500x1000x150		1500 mm	1000 mm		290 kg	190160035X7PL
Professional Extreme 8.7 PLUS 2000x1000x150		2000 mm	1000 mm		374 kg	190160020X7PL
Professional Extreme 8.7 PLUS 2400x1200x150	3000 kg	2400 mm	1200 mm		518 kg	190160030X7PL
Professional Extreme 8.7 PLUS 3000x1500x150	4000 kg	3000 mm	1500 mm		815 kg	190160040X7PL
Professional Extreme 8.7 PLUS 4000x2000x150	4000 kg	4000 mm	2000 mm		1411 kg	190160055X7PL

Accessories for welding tables system 16 mm

16 mm



Accessories	Set 1 System 16*	Set 2 System 16*	Set 3 System 16*	Set 4 System 16*	Set 5 System 16*
Art. no.	193163100	193163200	193163300	193163400	193163500
21 ferrule burnished/nitrided	4 x	6 x	8 x	10 x	12 x
22 Clamp 45°/90° burnished		2 x	4 x	4 x	6 x
23 Prism nitrided 90°/120°		4 x	4 x	8 x	8 x
20 Clamping bolt burnished 53 mm	12 x	18 x	24 x	30 x	36 x
9 Nitrided stop 80 mm		4 x	4 x	8 x	8 x
10 Nitrided stop 115 mm	4 x	6 x	8 x	10 x	12 x
11 Nitrided angle 25 mm	4 x	6 x	8 x	10 x	12 x
12 Nitrided angle 90 mm	4 x	6 x	8 x	10 x	12 x
13 Nitrided angle 300 mm		2 x	2 x	4 x	4 x
16 + 17 Nitrided rotation angle 250 mm left+right				1 x + 1 X	1 x + 1 X
14 + 15 Nitrided angle 500 mm left+right			1 x + 1 X	1 x + 1 X	1 x + 1 X
18 + 19 Nitrided angle 750 mm left+right					1 x + 1 X
24 Tool trolley				1 x	1 x

*Incl. eccentric, Allen key, brush, whetstone, Probe CleanBasic, Non-stick sample, torch holder

Options (ex works only)	Art. no.
1 Foot Basic equipment 850	193160857X
Surcharge per foot:	
2 - 550-950	193160877XX
3 - Floor anchoring 750	193160875XX
4 - with swivel castor and parking brake 750	193160876XX
5 - height-adjustable with swivel castor and parking brake 600-900	193160879XX
6 - Sub Table Box lockable	1931609901

Accessories	Art. no.
7 Non-stick with corrosion protection 1 litre in spray bottle	194000924
8 Eccentric stop Ø 75 mm with M10 thread - nitrided	193160402 N
9 Universal stop 80 L - nitrided	193160410 N
10 Universal stop 115 L - nitrided	193160420 N
Stop and clamping angle	
11 -90 X - nitrided	193160108 N
12 -90 L - nitrided	193160110 N
13 -300 G - nitrided	193160162 N
14 -500 GK right - nitrided	193160136 N
15 -500 GK left - nitrided	193160134 N
16 -250 G with rotation angle left - cast / nitrided	193160161 N
17 -250 G with rotation angle right - cast/ nitrided	193160163 N
18 -750 GK right - nitrided	193160148 N
19 -w750 GK left - nitrided	193160146 N

Accessories	Art. no.
20 Quick-release pin short - burnished	193160510
21 Professional screw clamp - burnished / nitrided	193160610
22 Professional screw clamp 45°/90° - burnished	193160630
23 Vario prism Ø 50 mm 90°/120° with screwed-in collar - nitrided	1931606451 N
24 Tool trolley	193160910
25 Brush Ø 17 mm with protective cap	193160820
26 Torch holder - burnished	193160920
27 Allen key 4	193160852
28 Combination whetstone 150 x 50 x 25 mm	193000942
29 Premium 100 vice	194004300
30 Table press	193160780
Surface clamping countersunk bolt	
31 - double-burnished	193220595
32 - triple-burnished	1931605953
33 - quadruple-burnished	1931605954
Surface clamping bolt	
34 - double-burnished	193160590
35 - quadruple-burnished	1931605904
36 - triple-burnished	1931605903
37 Quick-release bolt without groove, triple-burnished	194160513

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

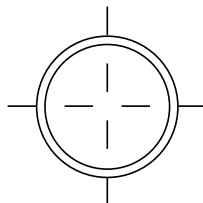
Electrochemical processing

Welding accessories

System 22 - For heavy-duty applications

► The Professional 750 welding tables are made from high-quality S355J2+N steel and are also plasma-nitrided and coated. Due to the increased load capacity of the welding table, it is particularly suitable for processing heavy components.

- 1. Bore Surface in diagonal grid or 100 x 100 mm grid
- 2. Bores with 2.5 mm radius
- 3. Corners and edges with radius 3 / 6 mm
- 4. Side panel height 150 mm Bore spacing side panel 50 mm
- 5. Including scaling on the surface
- 6. Construction reinforced by ribs



BORE Ø 22mm

MATERIAL

► Material thickness approx. 17 - 19 mm

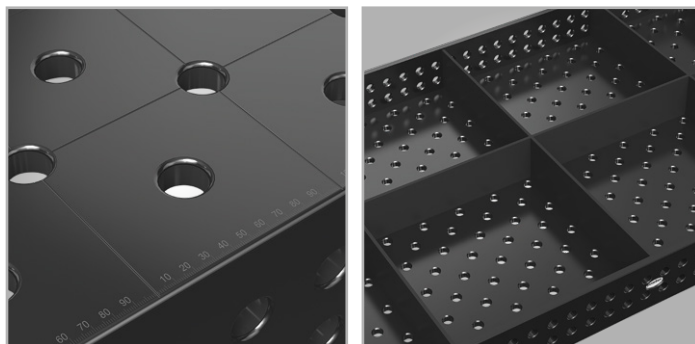
PROFESSIONAL 750

► plasma-nitrided and BAR-coated

PROFESSIONAL EXTREME 8.7 PLUS

► Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated; **height side panel 250 mm**

Model	PROFESSIONAL 750
Material	high-quality steel S355J2+N, plasma-nitrided and BAR-coated
Plasma nitriding	✓
Basic hardness	approx. 165 - 220 Vickers
Surface hardness	approx. 450 - 750 Vickers
Material thickness	approx. 17 - 19 mm
Side panel	150 mm
Diagonal grid	✓
Scale	✓



Professional 750 series – plasma-nitrided welding tables Surface hardness up to 750 Vickers!

- Hole arrangement in a 100 mm grid on the table top and a parallel hole arrangement in a 50 mm grid on the sides. The bores have a diameter of 22 mm
- The table is made from high-quality S355J2+N steel, plasma-nitrided and BAR-coated
- The welding tables are fitted with a scale as standard
- Protection against rust, scratches and welding spatter adhesion
- Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient



Professional 750 1000x1000x150

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Professional 750 welding table made from high-quality steel S355J2+N plasma-nitrided

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Professional 750 1000x1000x150	2000 kg	1000 mm	1000 mm	850 mm	296 kg	190220010P
Professional 750 1200x1200x150		1200 mm	1200 mm		387 kg	190220015P
Professional 750 1500x1000x150		1500 mm	1000 mm		412 kg	190220035P
Professional 750 1500x1500x150		1500 mm	1500 mm		573 kg	190220050P
Professional 750 2000x1000x150		2000 mm	1000 mm		519 kg	190220020P
Professional 750 2400x1200x150		2400 mm	1200 mm		740 kg	190220030P
Professional 750 3000x1500x150		3000 mm	1500 mm		1097 kg	190220040P

Professional Extreme 8.7 series plasma nitrided – welding tables with diagonal grid

- ▶ diagonal hole arrangement on the table top and a parallel hole arrangement in a 50 mm grid on the sides. The bores have a diameter of 22 mm
- ▶ The table is made from high-quality S355J2+N steel, plasma-nitrided and BAR-coated
- ▶ The welding tables are fitted with a scale as standard
- ▶ Protection against rust, scratches and welding spatter adhesion
- ▶ Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient



Professional Extreme 8.7 welding table made of through-hardened X8.7 tool steel, plasma nitrided **with diagonal grid**

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Professional Extreme 8.7 - 1000x1000x150	2000 kg	1000 mm	1000 mm	850 mm	295 kg	190220010XD7
Professional Extreme 8.7 - 1200x800x150		1200 mm	800 mm		291 kg	190220025XD7
Professional Extreme 8.7 - 1200x1200x150		1200 mm	1200 mm		387 kg	190220015XD7
Professional Extreme 8.7 - 1500x1000x150		1500 mm	1000 mm		412 kg	190220035XD7
Professional Extreme 8.7 - 1500x1500x150		1500 mm	1500 mm		573 kg	190220050XD7
Professional Extreme 8.7 - 2000x1000x150		2000 mm	1000 mm		519 kg	190220020XD7
Professional Extreme 8.7 - 2000x2000x150		2000 mm	2000 mm		929 kg	190220045XD7
Professional Extreme 8.7 - 2400x1200x150		2400 mm	1200 mm		725 kg	190220030XD7
Professional Extreme 8.7 - 3000x1500x150		3000 mm	1500 mm		1073 kg	190220040XD7
Professional Extreme 8.7 - 4000x2000x150 ⁽¹⁾		4000 mm	2000 mm		1807 kg	190220055XD7

Professional Extreme 8.7 PLUS series – plasma-nitrided welding tables with surface hardness up to 850 Vickers!

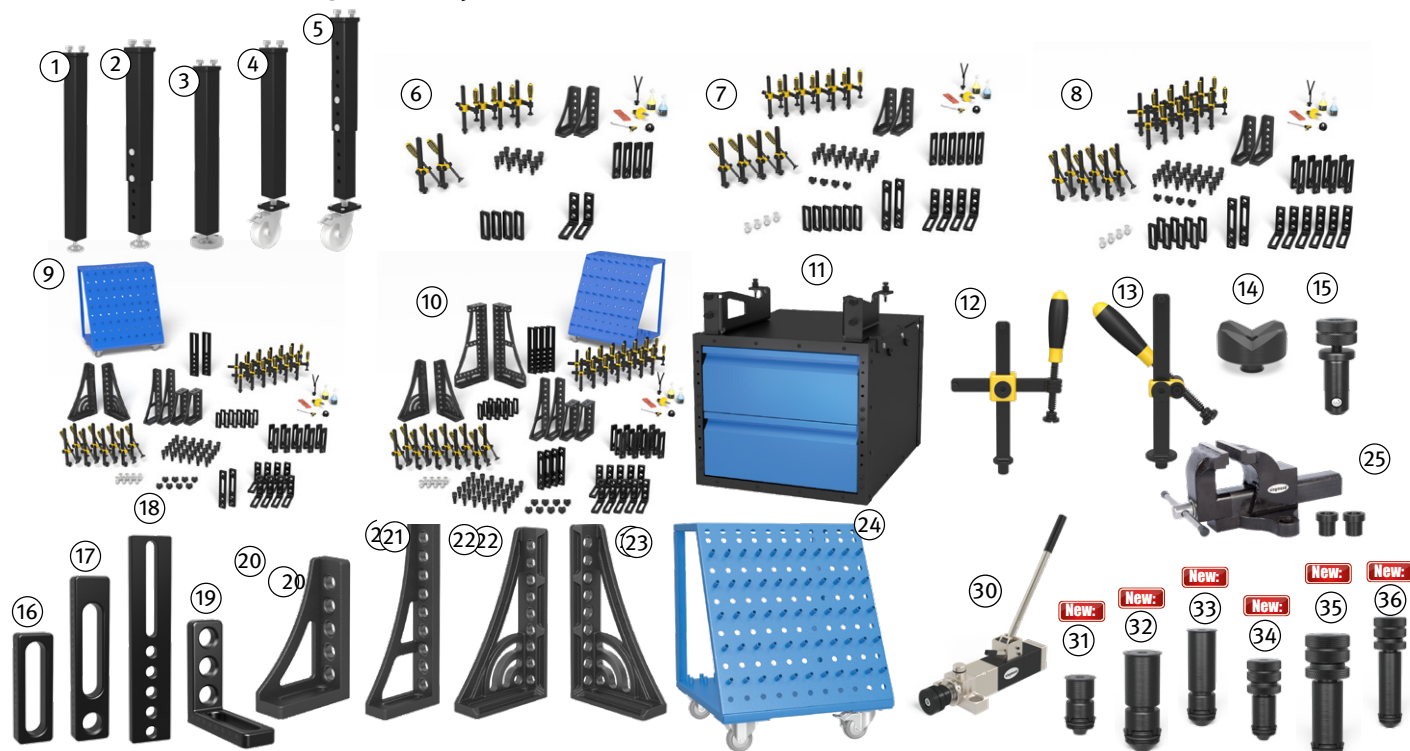
- ▶ Professional Extreme PLUS with extra high side panel for particularly demanding applications. More possibilities than ever before.
- ▶ Thanks to the higher side panel and ribbing, the rigidity of the table top is improved and deformation under load is reduced.
- ▶ Material thickness approx. 17 - 19 mm
- ▶ Side panel made of high-quality steel S355J2+N + plasma nitriding
- ▶ Bores Surface in diagonal grid
- ▶ Rounded corners, edges and drill holes
- ▶ Bores Side panel 4 rows with 50 mm spacing
- ▶ Including scaling on the surface
- ▶ Construction reinforced by ribs
- ▶ Grid lines enable precise superstructures



Professional Extreme 8.7 PLUS made from through-hardened tool steel X8.7 plasma-nitrided

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Professional Extreme 8.7 PLUS 1200x1200x250	2000 kg	1200 mm	1200 mm	850 mm	432 kg	190220015XD7PL
Professional Extreme 8.7 PLUS 1500x1000x250	2000 kg	1500 mm	1000 mm		466 kg	190220035XD7PL
Professional Extreme 8.7 PLUS 2000x1000x250	2000 kg	2000 mm	1000 mm		595 kg	190220020XD7PL
Professional Extreme 8.7 PLUS 2400x1200x250	3000 kg	2400 mm	1200 mm		808 kg	190220030XD7PL
Professional Extreme 8.7 PLUS 3000x1500x250	3000 kg	3000 mm	1500 mm		1226 kg	190220040XD7PL
Professional Extreme 8.7 PLUS 4000x2000x250	8000 kg	4000 mm	2000 mm		2061 kg	190220055XD7PL

Accessories for welding tables system 22 mm



Accessories	⑥ Set 1 System 22 ⁽¹⁾	⑦ Set 2 System 22 ⁽¹⁾	⑧ Set 3 System 22 ⁽¹⁾	⑨ Set 4 System 22 ⁽¹⁾	⑩ Set 5 System 22 ⁽¹⁾
Art. no.	193223100	193223200	193223300	193223400	193223500
⑫ Screw clamp - burnished	4 x	6 x	10 x	12 x	14 x
⑬ Screw clamp 45°/90° - burnished	2 x	4 x	6 x	8 x	10 x
⑭ Vario prism Ø 50 90° / 120°		4 x	4 x	8 x	8 x
⑮ Quick-release bolt - burnished	12 x	18 x	24 x	30 x	30 x
Magnetic clamping bolt 60		4 x	4 x	8 x	8 x
⑯ Universal stop 150 L - nitrided	4 x	6 x	8 x	10 x	12 x
⑰ Universal stop 225 L - nitrided	4 x	6 x	8 x	10 x	12 x
Universal stop 300 - nitrided		2 x	2 x	2 x	4 x
⑱ Universal stop 500 S - nitrided				2 x	4 x
⑲ Stop and clamping bracket 175 L	2 x	4 x	6 x	8 x	10 x
⑳ Stop and clamping bracket 300 G	2 x	2 x	2 x		
Stop and clamping bracket 300 x 195				2 x	2 x
㉑ Stop and clamping bracket 500 G				2 x	2 x
㉒ Stop and clamping angle 500 G with left-hand rotation angle - nitrided				1 x	1 x
㉓ Stop and clamping angle 500 G with right-hand rotation angle - nitrided				1 x	1 x
Stop and clamping bracket 800 GK, left - nitrided					1 x
Stop and clamping bracket 800 GK, right - nitrided					1 x
㉔ Tool trolley				1 x	1 x

(1) Incl. eccentric, Allen key, 1 brush Ø 17 with protective cap, whetstone, 1 sample bottle of CleanBasic cleaning agent, 1 sample bottle of non-stick agent with corrosion protection

Options (ex works only)

	Art. no.
① Foot Basic equipment 800	193220857X
② Surcharge for height-adjustable foot 500-800	193220878XX
② Surcharge for height-adjustable foot 550-900	193220877XX
③ Surcharge for base with floor anchoring 700	193220874XX
④ Surcharge for base with swivel castor and parking brake 700	193220866XX
⑤ Surcharge for height-adjustable base with swivel castor and parking brake 600-850	193220879XX

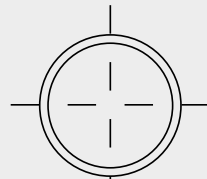
Accessories	Art. no.
⑪ Sub Table Box for System 22	1932209901
⑫ Professional screw clamp - burnished	1932206101
⑬ Professional screw clamp 45°/90° - burnished	1932206301
⑭ Vario prism Ø 50 90° / 120° with screwed-in collar - burnished	1932206451
⑮ Quick-release bolt without groove, double-burnished	19322511
Magnetic clamping bolt 60	193220740
⑯ Universal stop 150 L - nitrided	193220410 N
⑰ Universal stop 225 L - nitrided	193220420 N
Universal stop 300 - nitrided	193220426 N
⑱ Universal stop 500 S - nitrided	193220430 N

Accessories

	Art. no.
Stop and clamping angle	
⑲ 175 L - nitrided	193220110 N
⑳ 300 G - nitrided	193220152 N
300 x 195 - nitrided	193220116 N
㉑ 500 G - nitrided	193220162 N
㉒ 500 G with left-hand rotation angle - nitrided	193220164 N
㉓ 500 G with right-hand rotation angle - nitrided	193220165 N
800 GK, left - nitrided	193220144 N
800 GK, right - nitrided	193220146 N
㉔ Tool trolley	193220910
㉕ Vice 125 set for System 22	193224320
㉖ Table press	193220780
⑳ Surface tensioning countersunk bolt, double-burnished	193220595
㉑ Surface tensioning countersunk bolt, triple-burnished	1932205903
㉒ Surface tensioning countersunk bolt, quadruple-burnished	1932205954
㉓ Surface clamping bolt, double-burnished	193220590
㉔ Surface clamping bolt, quadruple-burnished	1932205904
㉕ Surface clamping bolt, triple-burnished	1932205903

System 28 - For heavy-duty applications

- ▶ The Professional 750 welding tables are made from high-quality S355J2+N steel and are also plasma-nitrided and coated. Due to the increased load capacity of the welding table, it is particularly suitable for processing heavy components.
- ▶ Equipped with a diagonal grid, the clamping options on this welding table are almost doubled.



BORE Ø 28mm

MATERIAL

- ▶ Material thickness approx. 24.5 - 27 mm

PROFESSIONAL 750

- ▶ Plasma-nitrided and BAR-coated

PROFESSIONAL EXTREME 8.7

- ▶ Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated

PROFESSIONAL EXTREME 8.8 PLUS

- ▶ Through-hardened tool steel X8.7, plasma-nitrided and BAR-coated; height side panel 300 mm

Professional 750 series – Plasma-nitrided welding tables with surface hardness up to 750 Vickers!

- ▶ The bores have a diameter of 28 mm
- ▶ The table is made from high-quality S355J2+N steel, plasma-nitrided and BAR-coated
- ▶ The welding tables are fitted with a scale as standard
- ▶ Protection against rust, scratches and welding spatter adhesion
- ▶ Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient



Professional 750 4000x2000x200



Professional 750 1000x1000x200



Professional 750 2000x1000x200

Professional 750 welding table made from high-quality steel S355J2+N plasma-nitrided

Model	Load capacity	Length approx.	Width approx.	Table height incl. feet	Weight approx.	Art. no.	Packaging surcharge	Transport surcharge
Professional 750	4000 kg	1000 mm	1000 mm	850 mm	416 kg	190280010P	TVPS2	TPZS10
1000 x 1000 x 200		1200 mm	1200 mm		544 kg	190280015P	TVPS2	TPZS11
1200 x 1200 x 200		800 mm	800 mm		408 kg	190280025P	TVPS2	TPZS10
1500 x 1000 x 200		1000 mm	1000 mm		577 kg	190280035P	TVPS2	TPZS11
1500 x 1500 x 200		1500 mm	1500 mm		801 kg	190280050P	TVPS2	TPZS13
2000 x 1000 x 200		1000 mm	1000 mm		730 kg	190280020P	TVPS2	TPZS12
2000 x 1200 x 200		1200 mm	1200 mm		843 kg	190280060P	TVPS2	TPZS13
2000 x 2000 x 200		2000 mm	2000 mm		1299 kg	190280045P	TVPS3	TPZS14
2400 x 1200 x 200		2400 mm	1200 mm		986 kg	190280030P	TVPS3	TPZS15
3000 x 1500 x 200		6000 kg	3000 mm		1500 mm	1517 kg	190280040P	TVPS3
4000 x 2000 x 200	8000 kg	4000 mm	2000 mm	2501 kg	190280055P	TVPS3	TPZS17	

1) For information on transport surcharges, see overleaf, details of transport and packaging costs TVZS within Germany plus VAT

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

System 28

Professional Extreme 8.7 series - plasma-nitrided welding tables with diagonal grid – surface hardness up to 850 Vickers

- ▶ The bores have a diameter of 28 mm
- ▶ The table top is made from through-hardened X8.7 tool steel
- ▶ The welding tables are fitted with a scale as standard
- ▶ Protection against rust, scratches and welding spatter adhesion
- ▶ Plasma-nitrided using a thermochemical process, making the welding table more corrosion-resistant and more resilient

- ▶ 1. Bore Surface in diagonal grid or 100 x 100 mm grid
- ▶ 2. Bores with 3 mm radius
- ▶ 3. Corners and edges with radius 3 / 6 mm
- ▶ 4. Side panel height 200 mm Bore spacing side panel 50 mm
- ▶ 5. Including scaling on the surface
- ▶ 6. Construction reinforced by ribs



Professional Extreme 8.7-1200x1200x200

Professional Extreme 8.7 made of through-hardened tool steel X8.7 plasma-nitrided and with diagonal grid

Model	Load capacity	Length approx.	Width approx.	Table height incl. feet	Weight approx.	Art. no.
Professional Extreme 8.7						
1000 x 1000 x 200	4000 kg	1000 mm	1000 mm	850 mm	400 kg	190280010XD7D
1200 x 1200 x 200		1200 mm	1200 mm		521 kg	190280015XD7D
1200 x 800 x 200		1200 mm	800 mm		392 kg	190280025XD7D
1500 x 1000 x 200		1500 mm	1000 mm		554 kg	190280035XD7D
1500 x 1500 x 200		1500 mm	1500 mm		767 kg	190280050XD7D
2000 x 1000 x 200		2000 mm	1000 mm		699 kg	190280020XD7D
2000 x 1200 x 200		2000 mm	1200 mm		806 kg	190280060XD7D
2000 x 2000 x 200		2000 mm	2000 mm		1240 kg	190280045XD7D
2400 x 1200 x 200		2400 mm	1200 mm		947 kg	190280030XD7D
3000 x 1500 x 200		6000 kg	3000 mm		1500 mm	1425 kg
4000 x 2000 x 200	8000 kg	4000 mm	2000 mm	2384 kg	190280055XD7D	

Professional Extreme 8.8 PLUS series, plasma nitrided – welding tables with surface hardness up to 850 Vickers!

- ▶ Professional Extreme PLUS with extra high side panel for particularly demanding applications. More options than ever before
- ▶ Construction reinforced by ribs
- ▶ Grid lines enable precise superstructures
- ▶ Thanks to the higher side panel and ribbing, the rigidity of the table top is improved and deformation under load is reduced
- ▶ Material thickness approx. 24.5 - 27 mm
- ▶ Bores Surface in diagonal grid
- ▶ Rounded corners, edges and drill holes

- ▶ Side panel, 3 rows of bores with 50 mm spacing, 2 rows with 100 mm spacing
- ▶ Including scaling on the surface



Professional Extreme 8.8 PLUS 1500x1000x300

Professional Extreme 8.8 PLUS made from through-hardened tool steel X8.8 plasma-nitrided

Model	Load capacity	Length approx.	Width approx.	Table height incl. feet	Weight approx.	Art. no.
Professional Extreme 8.8 PLUS						
1200 x 1200 x 300	2000 kg	1200 mm	1200 mm	850 mm	582 kg	190280015XD8PL
1500 x 1000 x 300		1500 mm	1000 mm		625 kg	190280035XD8PL
1500 x 1500 x 300		1500 mm	1500 mm		871 kg	190280050XD8PL
2000 x 1000 x 300		2000 mm	1000 mm		796 kg	190280020XD8PL
2400 x 1200 x 300		2400 mm	1200 mm		1072 kg	190280030XD8PL
3000 x 1500 x 300		3000 kg	3000 mm		1500 mm	1611 kg
4000 x 2000 x 300	4000 kg	4000 mm	2000 mm	2686 kg	190280055XD8PL	

1) For information on transport surcharges, see overleaf, details of transport and packaging costs TVZS within Germany plus VAT

Hexagon 8.7 groove table series - plasma-nitrided tool steel with cross groove in hexagon shape

The advantages of a welding table and grooved table combined

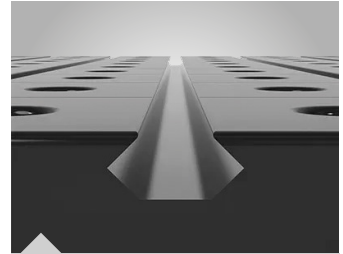
- ▶ Combines the advantages of a welding table with those of a grooving table in one product
- ▶ When fixing components, the Hexagon grooved table offers a wide range of clamping options and maximum flexibility

Flexible clamping with many options

- ▶ In addition to fastening in the system holes, the grooves offer infinitely variable fixing of the clamping devices

Compatible

- ▶ All Siegmund System 28 accessories are compatible with the Hexagon grooved table. The popular Siegmund ST Box can also be easily attached (see p. 186)



Properties

- ▶ Bore Ø 28 mm
- ▶ with cross groove in hexagon shape
- ▶ Hexagon groove spacing 100 mm
- ▶ Surface holes 100 x 100 mm grid
- ▶ Side panel drill holes in diagonal grid pattern

28 mm



Plasma-nitrided

with cross grooves



Material

- ▶ Tool steel X8.7 plasma nitrided
- ▶ Material thickness approx. 24.5 - 27 mm
- ▶ Side plate made of high-quality S355J2+N steel



Advantages Hexagon Nut

- ▶ more favourable price and light weight
- ▶ Same load capacity as standard welding tables
- ▶ Working with threads up to M12 possible

See our capabilities for yourself and request a personal consultation!



Contact: +49 (0) 951 96 555-501
beratung@schweisskraft.de

Hexagon groove table made from through-hardened tool steel X8.7 plasma-nitrided with cross grooves

Model	Load capacity	Length	Width	Table height incl. feet	Weight approx.	Art. no.
Hexagon grooved table 1200x1200x200	4000 kg	1200 mm	1200 mm	850 mm	500 kg	190280015HNK
Hexagon grooved table 1500x1000x200		1500 mm	1000 mm		531 kg	190280035HNK
Hexagon grooved table 1500x1500x200		1500 mm	1500 mm		734 kg	190280050HNK
Hexagon grooved table 2000x1000x200		2000 mm	1000 mm		668 kg	190280020HNK
Hexagon grooved table 2400x1200x200		2400 mm	1200 mm		920 kg	190280030HNK
Hexagon grooved table 3000x1500x200		3000 mm	1500 mm		1356 kg	190280040HNK
Hexagon grooved table 4000x2000x200		4000 mm	2000 mm		2262 kg	190280055HNK

System 28

Accessories for welding tables system 28 mm



Accessories Art. no.	Set 1 System 28 ⁽¹⁾ 193283100	Set 2 System 28 ⁽¹⁾ 193283200	Set 3 System 28 ⁽¹⁾ 193283300	Set 4 System 28 ⁽¹⁾ 193283400	Set 5 System 28 ⁽¹⁾ 193283500
22 Ferrule nitrided	4 x	6 x	10 x	14 x	14 x
23 Clamp nitrided 45°/90°	2 x	4 x	6 x	10 x	10 x
24 Prism nitrided 135°	2 x	4 x	4 x	6 x	8 x
20 Bolt burnished 95 mm	12 x	18 x	24 x	30 x	36 x
21 Magnetic clamping bolt		4 x	4 x	8 x	8 x
8 Nitrided stop 150 mm	4 x	6 x	8 x	10 x	12 x
9 Nitrided stop 225 mm	4 x	6 x	8 x	10 x	12 x
10 Nitrided stop 500 mm				4 x	4 x
11 Nitrided angle 175 mm	2 x	4 x	6 x	8 x	12 x
13 Nitrided angle 300 mm	2 x	2 x	2 x	2 x	2 x
12 Nitrided angle 500 mm		2 x	2 x	2 x	2 x
16 + 17 Turning angle nitrided 500 mm				1 x + 1X	1 x + 1X
14 + 15 Nitrided angle 750 mm			1 x + 1X	1 x + 1X	1 x + 1X
18 + 19 Nitrided angle 800 mm					1 x + 1X
25 Tool trolley				1 x	1 x

* Incl. eccentric, Allen key, brush, whetstone, Probe CleanBasic, Non-stick sample, torch holder

Options (ex works only)	Art. no.
Base basic equipment 750 instead of base basic equipment 650	193280857X
① Surcharge per height-adjustable foot 450-700	193280878XX
② Surcharge per height-adjustable foot 550-900	193280877XX
③ Surcharge per foot with swivel castor and parking brake	193280876XX
④ Surcharge per height-adjustable foot with swivel castor and parking brake 550-750	193280879XX
⑤ Surcharge per foot with floor anchoring	193280874XX
Accessories	
⑥ Sub Table Box for System 28	1932809901
⑦ Eccentric stop Ø 60 mm with M10 thread - nitrided	193280402 N
⑧ Universal stop 150 L - nitrided	193280410 N
⑨ Universal stop 225 L - nitrided	193280420 N
⑩ Universal stop 500 S - nitrided	193280430 N
Stop and clamping angle	
⑪ 175 L - nitrided	193280110 N
⑫ 500 G - nitrided	193280162 N
⑬ 300 G - nitrided	193280152 N
⑭ 750 G left - nitrided	193280166 N
⑮ 750 G right - nitrided	193280167 N
⑯ 500 G with rotation angle left - cast / nitrided	193280164 N
⑰ 500 G with rotation angle right - cast / nitrided	193280165 N
⑱ 800 GK, left - nitrided	193280144 N
⑲ 800 GK, right - nitrided	193280146 N
⑳ Quick-release pin, short - burnished	193280510
㉑ Quick-release pin, short - burnished without groove	193280511
㉒ Magnetic clamping bolt 68 mm	193280740
㉓ Professional screw clamp - nitrided	193280610 N
㉔ Professional screw clamp 45°/90° - nitrided	193280630 N
㉕ Prism Ø 50 mm 135° with screwed-in collar - nitrided	1932806481 N
㉖ Tool trolley	193280910
㉗ Brush Ø 30 mm with protective cap	193280820
㉘ Torch holder - burnished	193280920
㉙ Allen key 6 mm	1932808521
㉚ Combination whetstone 200 x 50 x 25 mm	193000940
Stop and clamping angle	
⑳ 175 SL - nitrided	193280109 N
㉑ 300 GK, left - nitrided	193280124 N
㉒ 300 GK, right - nitrided	193280126 N
㉓ 500 GK, left - nitrided	193280130 N
㉔ 500 GK, right - nitrided	193280132 N
㉕ Table press	193280780
㉖ Non-stick with corrosion protection 1 litre in spray bottle	194000924
㉗ Surface tensioning countersunk bolt, double-burnished	193280595
㉘ Surface tensioning countersunk bolt, triple-burnished	1932805953
㉙ Surface tensioning countersunk bolt, quadruple-burnished	1932805954
㉚ Surface clamping bolt, double-burnished	193280590
㉛ Surface clamping bolt, quadruple-burnished	1932805904
㉜ Surface clamping bolt, triple-burnished	1932805903
㉝ Quick-release bolt without groove, triple-burnished	193280513
㉞ Vice 125 incl. fastening material incl. protective jaw set	193284320
Vice 125	193004320
Vice 150 incl. fastening material incl. protective jaw set	193284330
㉟ Protective jaw set 100	194004315
Protective jaw set 125	194004325
Protective jaw set 150	194004335
㊱ Hexagon standard slot nut - nitrided	193HN280547
㊲ Hexagon slot nut, rotatable - nitrided	193HN2805471
㊳ Hexagon slot nut, long - nitrided	193HN2805472
㊴ Adapter for screw clamps - nitrided	193HN280602
㊵ Clamping bush for M12 thread	1932805464
㊶ Hexagon grooved table accessory set	193HN28399

Workbench – stable work surface for various tasks such as metal and woodworking, repairs or assembly work

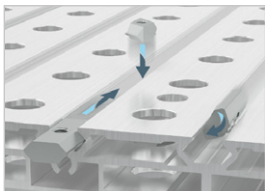
- ▶ Perforated plate made of high-quality steel S355J2+N with plasma nitriding
- ▶ Robust frame made of aluminium profiles
- ▶ Height adjustable
- ▶ Simple attachment of stops, clamping devices or vices
- ▶ Flexibility due to bore pattern
- ▶ Numerous accessories available



**Workbench
1200 x 800 mm**



**Workbench 1200 x 1000
Aluminium table profile**



Aluminium table profile
Hexagon Nut System
for additional
clamping options

Technical data

Model		Workbench 1200 x 800 mm	Workbench 1500 x 1000 mm	Workbench 1,200 x 700 mm	Workbench 1200 x 700 mm height-adjustable	Workbench 1200x1000 mm height-adjustable
Article no.		190161208	190161510	190161207L	190161207	190161210
Table height	mm	800 – 975		800	800 – 975	
Table legs		4	4	4	4	4
Load capacity approx.	kg	250	250	250	250	250
Table top (L x W)	mm	1200 x 800	1500 x 1,000	1200 x 700	1200 x 700	1200 x 1,000
Material		Steel S355J2+N, plasma-nitrided		Surface made of aluminium table profiles		
Bore diameter	mm	16	16		16	16
Bore spacing	mm	50	50	50	50	50
Material thickness	mm	12	12	24	24	24
Dimensions (L x W x H) approx.	mm	1200 x 800 x 800	1500 x 1000 x 800	1200 x 700 x 800	1200 x 700 x 800	1200 x 1000 x 800
Weight approx.	kg	108	158	39	39	50

Accessory for workbench



Accessories	Art. no.
① Tool set A	
▶ 2 screw clamps	
▶ 6 quick-release bolts	194167320
▶ 4 stops	
▶ 1 Allen key	
② Tool set B	
▶ 4 screw clamps	
▶ 8 quick-release bolts	
▶ 6 stops	
▶ 2 Stop and clamping angle	194167340
▶ 1 Allen key	
▶ 1 x 100 mm vice	
③ Eccentric stop Ø 75 mm - nitrided	194160403 N
④ Flex stop 12 x 83 mm - aluminium	194160412
⑤ Universal stop 80 L - nitrided	193160410 N
⑥ Universal stop 115 L - nitrided	193160420 N
⑦ Angle setting template - nitrided	194160455 N
⑧ Stop and clamping bracket 50 L - nitrided	194160105 N
⑨ Stop and clamping angle 90 X - nitrided	193160108 N
⑩ Stop and clamping bracket 90 L - nitrided	193160110 N
⑪ Stop and clamping bracket 300 G - nitrided	193160162 N
⑫ Stop and clamping bracket 500 G - nitrided	194160164 N
⑬ Stop and clamping bracket 500 GK left - nitrided	193160134 N
⑭ Stop and clamping bracket 500 GK right - nitrided	193160136 N
⑮ Quick-release pin short - burnished	193160510
⑯ Ball stud flat short - burnished	194160522
⑰ Ball stud flat long - burnished	194160523
⑱ Countersunk bolt short - burnished	194160528
⑲ Staking bolt - burnished	194160540
⑳ Connecting bolt short - nitrided	194160560 N

Accessories	Art. no.
⑲ Magnetic clamping bolt 34 mm - aluminium	194160740
⑳ Professional screw clamp - burnished / nitrided	193160610
㉑ Professional screw clamp 45°/90° - burnished	193160630
㉒ Universal pipe screw clamp - burnished	194160604
㉓ Basic screw clamp - burnished	194160620
㉔ Prism for screw clamps - burnished / nitrided	194160656
㉕ Duo prism Ø 25 mm - burnished / nitrided	194160650
㉖ Vario prism Ø 50 mm 90°/120° with screwed-in collar - nitrided	1931606451 N
㉗ Reducing bush 28 mm -> 16 mm - burnished	194000546
㉘ Allen key 4 mm	193160852
㉙ Torch holder - burnished	193160920
㉚ Brush Ø 17 mm with protective cap	193160820
㉛ Combination whetstone 150 x 50 x 25 mm	193000942
㉜ CleanBasic 1 litre in spray bottle	194000914
㉝ CleanBasic 5 litres	194000915
㉞ Non-stick with corrosion protection 1 litre in spray bottle	194000924
㉟ Non-stick with corrosion protection 1 litre in pump bottle	194000929
㊱ Non-stick with corrosion protection 5 litres	194000926
㊲ Premium vice 100 mm	194004300
㊳ Quick-release bolt without groove, triple-burnished	194160513
㊴ Swivel rollers for workbench	1930041002
㊵ Aluminium table end profile 800	193160800
㊶ Vice 100 with 16 mm system holes	193004310
㊷ MDF protective panel 1200 x 700	19316004616
㊸ MDF protective panel 1200 x 800	19316004416
㊹ Hand-tightening bolt without groove, triple burnished	19316004365
㊺ Surface clamping bolt, triple burnished	19316003261

WELDING ROBOTS



EASY-ARC

The mobile welding cell for the workshop: Simple, affordable, safe

Compact, mobile and quickly ready for use

- ▶ Favourable purchase price
- ▶ Fully assembled and documented
- ▶ Space-saving and flexible use

Time-saving operation

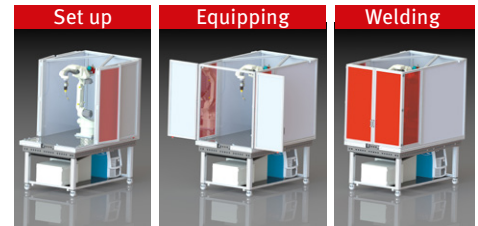
- ▶ Simple creation of the welding programme via the OTC Easy Teach control unit
- ▶ No extensive training necessary

Stable and precise welding robot

- ▶ Physical relief for employees
- ▶ Optimised, consistent welding quality

Safe operation

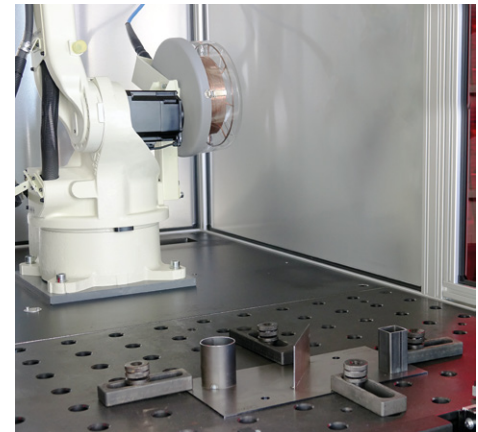
- ▶ Protection against access and glare through electrically monitored lightweight protective housing



**SHORTAGE OF SKILLED LABOUR?
OPTIMISED PRODUCTION!
PRODUCTION COSTS UNDER PRESSURE?
THE EASY-ARC WELDING ROBOT IS THE ANSWER!**

Lightweight protective housing incl. set-up and loading doors

Welding robot (optional FD-B6 or FD-V8)



Welding machine Welbee P400

Welding table with integrated perforated plate

Electrical safety interrogation of the loading doors

Welding robot controller FC 11

Table legs with swivel castors and parking brakes

MIG/MAG

TIG inverter

Electrode inverter

Laser welding

Plasma cutters

Electrochemical processing

Welding accessories

MIG/MAG-Package – Compact, turnkey welding robot station with welding technology

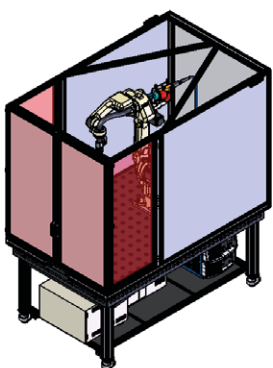
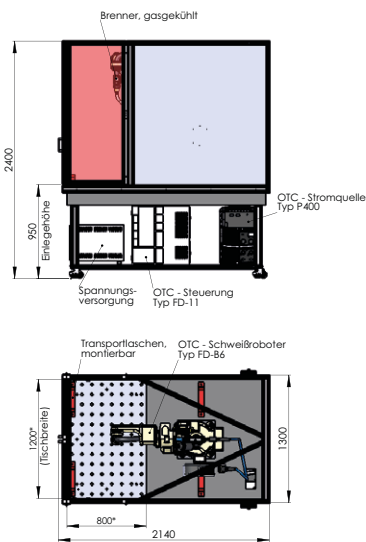
Model	Easy Arc 01.01 FD-B6	Easy Arc 01.02 FD-B6	Easy Arc 01.03 FD-B6	Easy Arc 01.04 FD-B6
Equipment	Basic equipment	Option 01	Option 02	Option 03
Art. no.	1850000	1850005	1850010	1850015

Equipment	MIG/MAG	MIG/MAG	MIG/MAG	MIG/MAG
Welding process	air-cooled	water-cooled	air-cooled	water-cooled
Cooling	air-cooled	water-cooled	air-cooled	water-cooled
Welding machine	Welbee P400	Welbee P500L	Welbee P400	Welbee P500L
Torch	RT3500H	RTW5000H	RT3500H	RTW5000H
Welding robots	FD-B6	FD-B6	FD-B6	FD-B6
Welding table	2000 x 1200 mm	2000 x 1200 mm	2000 x 1200 mm	2000 x 1200 mm
Positioner	-	-	A2-1PB250	A2-1PB250

1) For information on transport surcharges see overleaf, details of TPZRS plus VAT

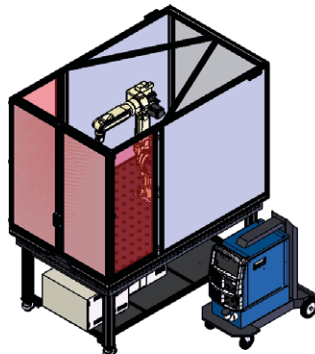
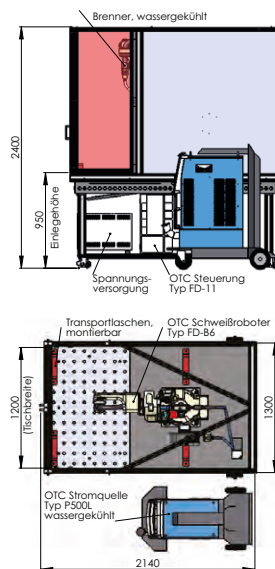
Basic equipment for MIG/MAG-welding with welding machine Welbee P400

- ▶ 3D welding table with intelligent system grids for clamping and positioning workpieces
- ▶ Fully assembled and documented in accordance with CE standards
- ▶ Welbee P400 welding machine (gas-cooled inverter pulse power source)
- ▶ Safety technology with monitoring unit (RMU) and enclosure
- ▶ Six-axis robot FD-B6 with integrated cable routing for optimum accessibility
- ▶ Robot welding torch with forced switch-off



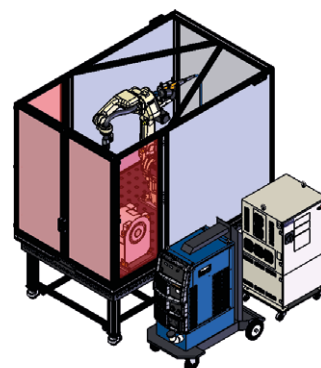
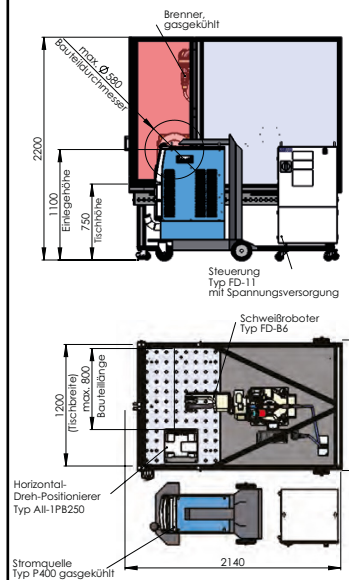
Option 01 for MIG/MAG-welding with welding machine Welbee P500L

- ▶ Welbee P500L welding machine (water-cooled inverter pulse power source)



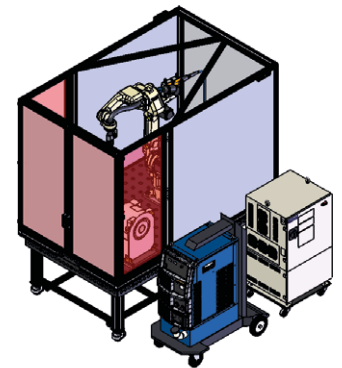
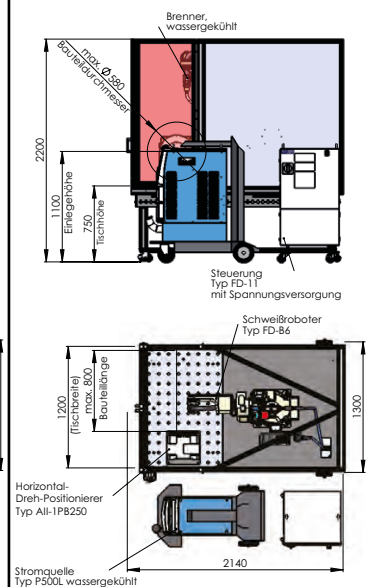
Option 02 for MIG/MAG-welding with horizontal rotary positioner

- ▶ Welbee P400 welding machine
- ▶ Horizontal rotary positioner A2-1PB250 incl. Synchronmotion software and integration into the Easy Teach control system



Option 03 for MIG/MAG-welding with horizontal rotary positioner

- ▶ Welbee P500L welding machine (water-cooled inverter pulse power source)
- ▶ Horizontal rotary positioner A2-1PB250 incl. Synchronmotion software and integration into the Easy Teach control system



TIG-Package - Compact, turnkey welding robot station with welding technology

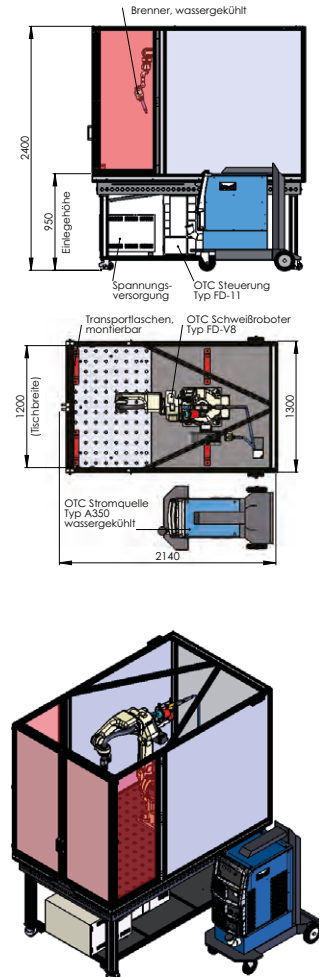
Model	Easy Arc 02.01 FD-V8	Easy Arc 02.02 FD-V8	Easy Arc 02.03 FD-V8	Easy Arc 02.04 FD-V8
Equipment	Basic equipment	Option 01	Option 02	Option 03
Art. no.	1850100	1850105	1850110	1850115

Equipment	TIG	TIG	TIG	TIG
Welding process	TIG	TIG	TIG	TIG
Cooling	water-cooled	water-cooled	water-cooled	water-cooled
Welding machine	Welbee A350P	Welbee A350P	Welbee A350P	Welbee A350P
Torch	Binzel	Binzel push-pull	Binzel	Binzel push-pull
Welding robots	FD-V8	FD-V8	FD-V8	FD-V8
Welding table	2000 x 1200 mm	2000 x 1200 mm	2000 x 1200 mm	2000 x 1200 mm
Positioner	-	-	A2-1PB250	A2-1PB250

1) For information on transport surcharges see overleaf, details of TPZRS plus VAT

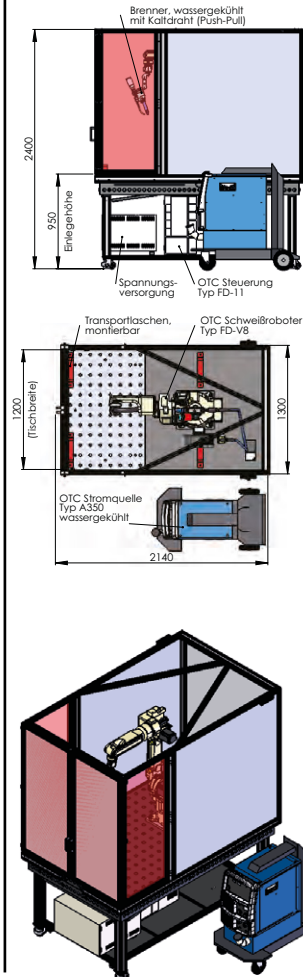
Basic equipment for TIG welding with welding machine Welbee A350P

- ▶ 3D welding table with intelligent system grids for clamping and positioning workpieces
- ▶ Fully assembled and documented in accordance with CE standards
- ▶ Welbee A350P welding machine (water-cooled inverter pulse power source)
- ▶ Safety technology with monitoring unit (RMU) and enclosure
- ▶ Six-axis robot FD-V8 for maximum flexibility
- ▶ Robotic welding torch with 3D forced shutdown



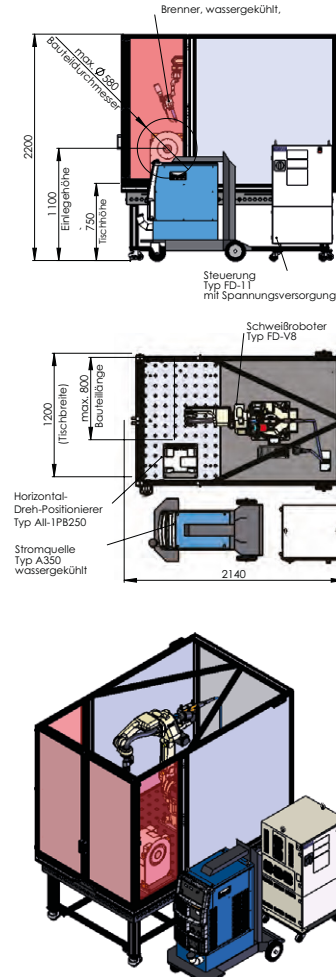
Option 01 for TIG welding with cold wire (push-pull system)

- ▶ Push-pull system for feeding welding rod into the weld pool



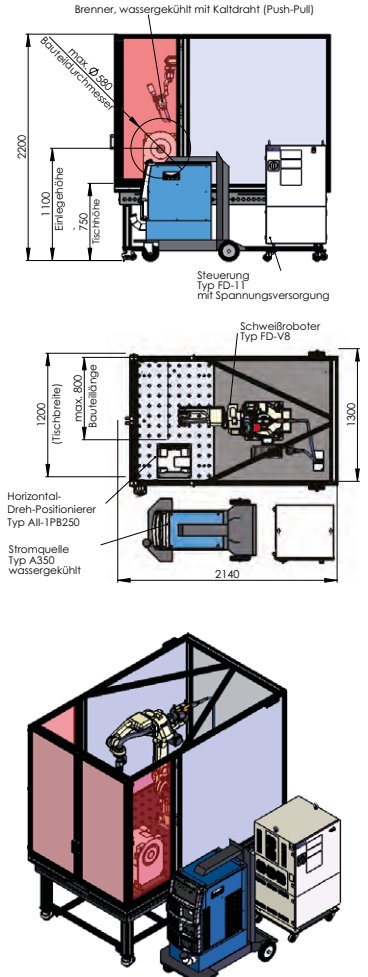
Option 02 for TIG welding with horizontal rotary positioner

- ▶ Horizontal rotary positioner A2-1PB250 incl. Synchronmotion software and integration into the Easy Teach control system



Option 03 for TIG welding with horizontal rotary positioner

- ▶ Push-pull system for feeding welding rod into the weld pool
- ▶ Horizontal rotary positioner A2-1PB250 incl. Synchronmotion software and integration into the Easy Teach control system

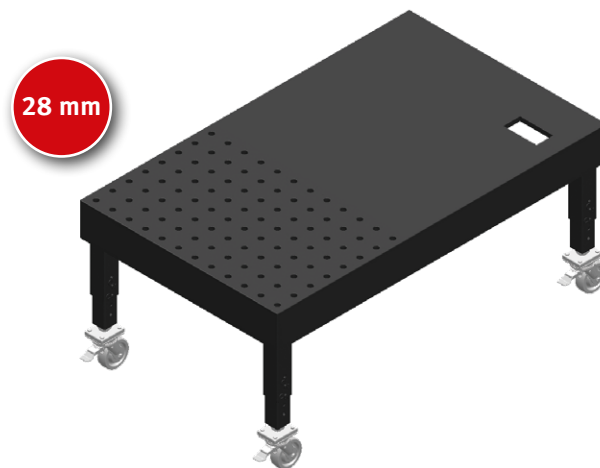


Prices for robots only. Additional costs are incurred for maintenance, commissioning and training.

Welding robot components

Welding table 750 – surface hardness up to 750 Vickers

- ▶ Manufactured from high-quality S355J2+N steel, plasma nitrided and coated
- ▶ Dimensions approx. (D x W) 2,000 x 1,200 mm
- ▶ Table height depends on the selected variant
- ▶ Table legs with swivel castors and parking brakes
- ▶ 28 mm holes in a 100 x 100 mm grid
- ▶ Load capacity 1000 kg
- ▶ Weight approx. 600 kg



Welding machine



Model	P400 (MIG/MAG)	P500L (MIG/MAG)	A350P (TIG)
Version	gas-cooled	water-cooled	water-cooled
Sheet thicknesses	1 – 10 mm	1 – 15 mm	0.5 – 15 mm
Mains voltage (± 15 %)	3 x 400 V / 50 Hz	3 x 400 V / 50 Hz	3 x 400 V / 50 Hz
Power consumption	19.2 kVA	25 kVA	12.2 kVA
Current at 100% duty cycle, 40°C TIG	370 A	410 A	270 A (AC) / 300 A (AC)
Duty cycle at max. current 40°C	50%	50%	30%
Setting range	20 – 400 A	20 – 500 A	5 – 350 A
Power consumption	22.9 A	22.9 A	18,5 A (AC) / 19 A (DC)
No-load voltage	74V	74V	74V
Type of protection/cooling	IP 23 / F	IP 23 / F	IP 23 / F
Switching stages	Stepless	Stepless	Stepless

Welding robots

Model	Welding robots FD-B6	Welding robots FD-V8
Kinematics	vertically articulated robot	
Number of axes	6	
Working area (P-point)	R 1445 mm	R 1437 mm
Maximum load capacity	6 kg	8 kg
Repeat accuracy	± 0.08 mm	
Drive system	AC servo motor	
Ambient temperature / humidity	0 ~ 45°C, 20 ~ 80%	
Weight approx.	145 kg	140 kg
Max. load capacity upper arm	10 kg	



FD-B6



FD-V8



Horizontal rotary positioner

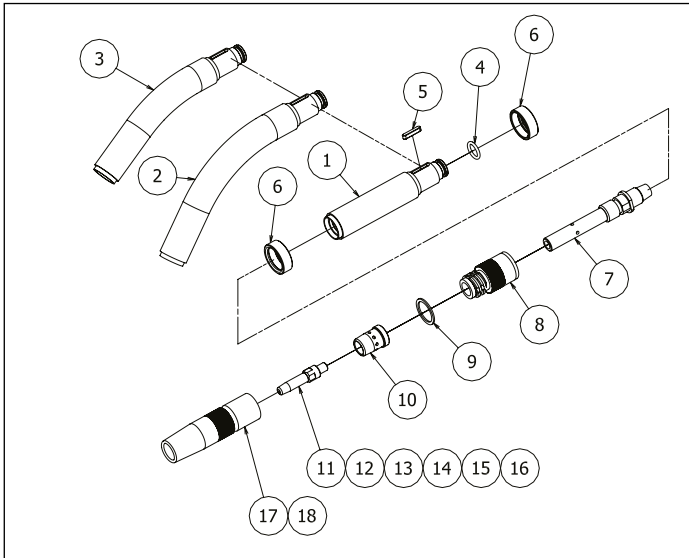
- ▶ Enables fully synchronised operation with the FD series robots
- ▶ The central bore in the flange plate is intended for the passage of mediums.
- ▶ Max. load capacity 250 kg
- ▶ Rotational speed 26°/s
- ▶ Torque 205 Nm
- ▶ Repeat accuracy ± 0.1 mm
- ▶ Weight approx. 110 kg



RT 3500H

for Easy ARC 01.01 FD-B 6 Welbee P400 &
Easy ARC 01.03 FD-B6 Welbee P400

- ▶ Interchangeable neck system, gas-cooled, steel 1.0 mm
- ▶ Torch neck: 45°
- ▶ Max. load: 350 A / gas-cooled
- ▶ Collision protection: B-type integrated

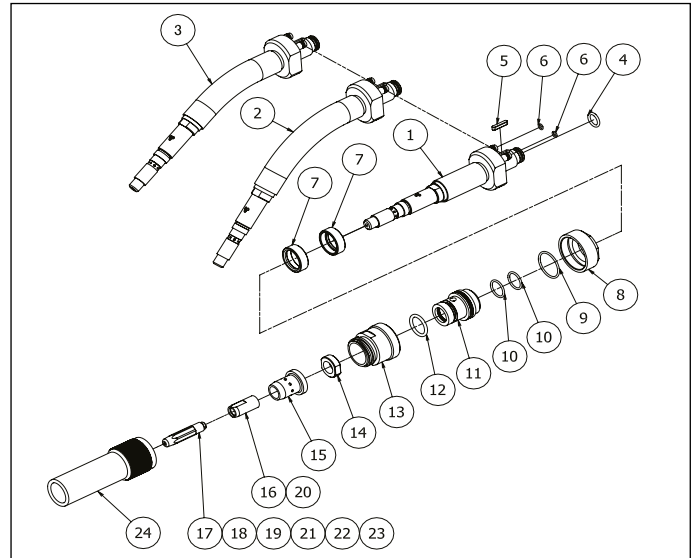


No.	Designation	Art. no.	PU
1	Torch neck	1851001	1
4	O-ring	1851002	2
5	Feather key	1851003	1
6	Teflon seal	1851004	2
7	Gas nozzle carrier	1851005	1
8	Insulating piece	1851006	1
9	Disc	1851007	1
10	Nozzle holder	1851008	1
11	Contact tip 1.2 mm	1851009	10
12	Contact tip 0.8 mm	1851010	10
13	Contact tip 0.9 mm	1851011	10
14	Contact tip 1.0 mm	1851012	10
15	Contact tip 1.4 mm	1851013	10
16	Contact tip 1.6 mm	1851014	10
17	Gas nozzle	1851015	1

RTW 5000H

for Easy ARC 01.02 FD-B6 Welbee P500L &
Easy Arc 01.04 FD-B6 Welbee P500L

- ▶ Water-cooled interchangeable neck system, 1.2 mm steel
- ▶ Torch neck: 45°
- ▶ Max. load: 500 A / water-cooled
- ▶ Collision protection: B-type integrated



No.	Designation	Art. no.	PU
2	Torch neck	1851020	1
4	O-ring	1851002	2
5	Feather key	1851003	1
6	O-ring H	1851021	2
7	Rubber bush	1851022	2
8	Lock nut	1851023	1
9	O-ring	1851024	2
10	O-ring	1851025	2
11	Insulating bush	1851026	1
12	O-ring	1851027	2
13	Front body	1851028	1
14	Nut	1851029	1
15	Nozzle holder	1851030	1
16	Nozzle nut	1851031	1
17	Contact tip 1.2 mm	1851032	10
18	Contact tip 1.4 mm	1851033	10
19	Contact tip 1.6 mm	1851034	10
20	Nozzle nut	1851035	1
24	Gas nozzle	1851036	1

ACCESSORIES



ACCESSORIES for Easy ARC 01.01 & Easy ARC 01.03	Art. no.
Programming tip set	1851016
Wire feed roller 0.9 / 1.0 / 1.2mm RT3500H	1851017
Wire feed roller 0.8 / 0.9 / 1.0mm RT3500H	1851018
Wire guide hose 1.5 m RT3500H	1851050
Wire guide 1.5mm	1851051
Wire guide 0.9 - 1.2 mm	1851052
Wire guide 0.8 - 0.9 mm	1851053
Coaxial cable 0.9m for FD-B6	1851060
Contact tube nut	1851037

ACCESSORIES for Easy ARC 01.02 & Easy ARC 01.04	Art. no.
Coaxial cable 0.9m for FD-B6	1851060
Contact tube nut	1851037
① Gas nozzle	1851038

Convince yourself of our performance and ask for a demonstration of the welding robot!

Contact: +49 (0) 951 96 555-501
easyweld@schweisskraft.de



INDUCTION Safe heating

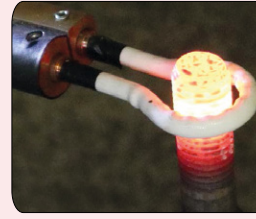
Functionality and benefits of the induction principle for the bodywork and commercial vehicle sector

How it works:

The induction heater and its accessories ensure that heat is only applied where it is actually needed, without contact. Since electromagnetic induction only occurs with conductive materials, non-conductive materials (such as glass, rubber, plastic, painted surfaces, etc.) are spared from heating and the resulting damage; an open flame is no longer necessary and the associated fire hazard is virtually eliminated.

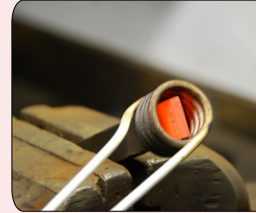
Area of application and benefits:

- ▶ For quick and easy removal of parts on vehicles by applying heat, e.g.: Glass panes, panelling, stickers, films or similar
- ▶ Targeted and precisely dosed heat application within seconds thanks to state-of-the-art microprocessor technology
- ▶ Complete protection of surrounding areas and prevention of damage to painted surfaces, glass, rubber, plastic, etc.



Mechanics and maintenance

- ▶ Loosening or disassembly (steering push rods, tie rod end parts, brake discs, brake hoses, exhaust flanges, exhaust pipes, damper nuts, secured screws)
- ▶ Heating of longitudinal beams (except HSS steel)
- ▶ Loosening bolts



Car body

- ▶ Removal of steel or aluminium elements
- ▶ Straightening warped chassis (except HSS steel)



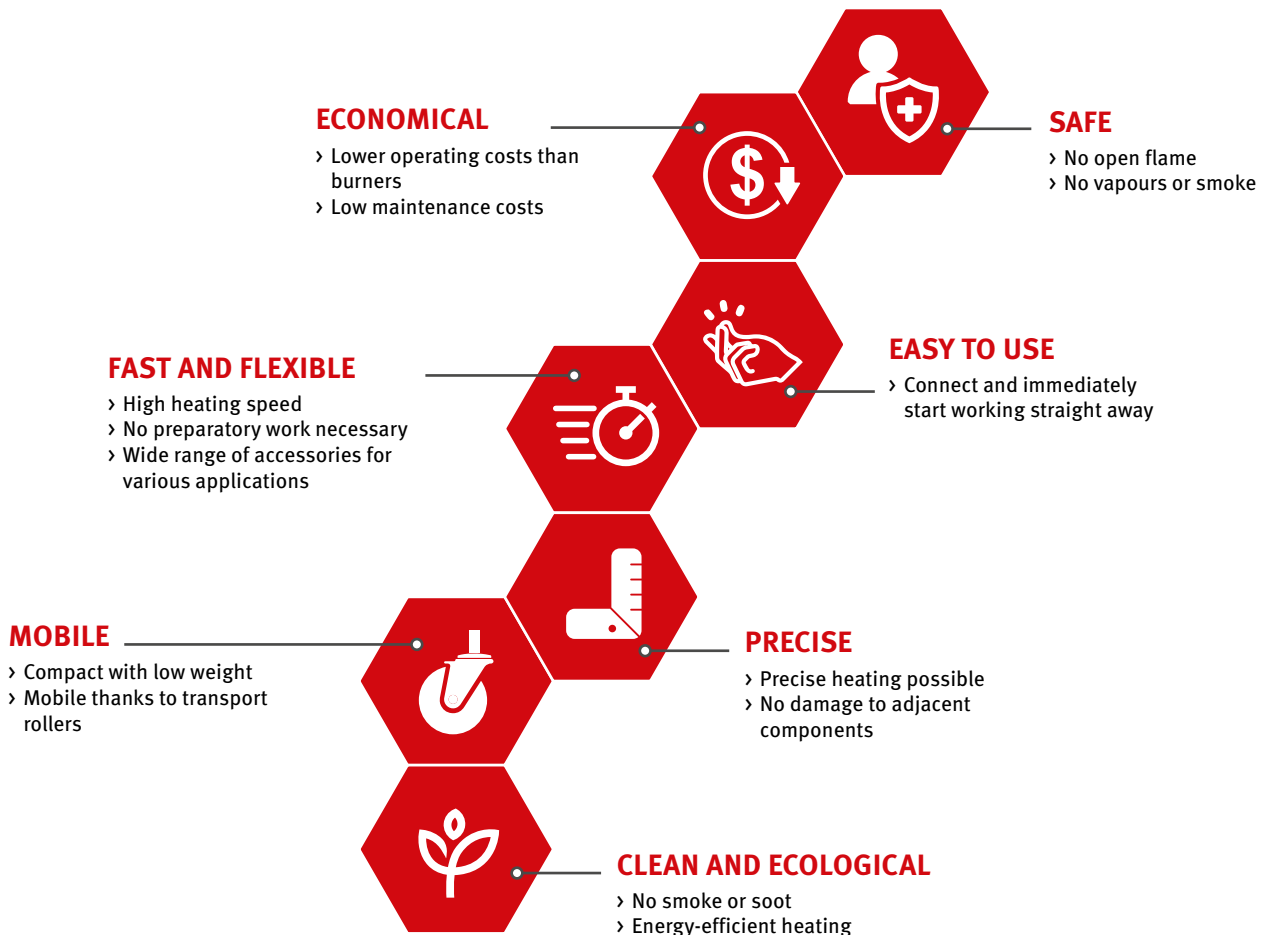
Soft and hard soldering

- ▶ in the manufacture of air conditioning systems, etc.
- ▶ Hard soldering of copper pipes with silver
- ▶ Soft soldering with tin



Heating in manufacturing and industry

- ▶ Heating and warming before welding
- ▶ Heating metal parts
- ▶ Heating for bending work
- ▶ Point heating
- ▶ Straightening
- ▶ Forging
- ▶ Preheating



IHG 1500 - Induction heater. Extremely versatile in the bodywork and commercial vehicle sector



- ▶ Due to its extremely **small design** and its **low weight**, the IHG 1500 **can be taken almost anywhere and to any location** using a carrying or shoulder strap and **used**.
- ▶ Handle for the highest ergonomic demands and outstanding ease of use
- ▶ Removal of minor panelling, stickers, films and similar items, e.g. on bodywork and commercial vehicle parts and commercial vehicle parts
- ▶ Ergonomic handle for comfortable handling



4.5 KG ONLY



Scope of delivery:

Coil holder
Front coil M 8
Front coil M12
Winding cord
Flat spiral coil
Carrying strap
Plastic case



Control concept

- ▶ Targeted and precisely dosed heat application within seconds thanks to state-of-the-art microprocessor technology
- ▶ Heating the parts to over 800°C
- ▶ Quick and easy to use
- ▶ High efficiency
- ▶ Prevention of overheating thanks to two fans
- ▶ High operational reliability thanks to self-monitoring with visual status signal

Accessories

	Art. no.
Front coil (L = 220 mm)	
- Ø 15 mm / M6	1760015
- Ø 19 mm / M8	1760019
- Ø 20 mm / M8	1760020
- Ø 23 mm / M10	1760023
- Ø 26 mm / M12	1760026
- Ø 32 mm / M16	1760032
- Ø 38 mm / M20	1760038
- Ø 45 mm / M22	1760045
Side coil (L = 220 mm)	
- Ø 15 mm / M6	1760115
- Ø 19 mm / M8	1760119
- Ø 20 mm / M8	1760120
- Ø 23 mm / M10	1760123
- Ø 26 mm / M12	1760126
- Ø 32 mm / M16	1760132
- Ø 38 mm / M20	1760138
- Ø 45 mm / M22	1760145
Customised heating coil (L=750mm, Ø=4mm)	1760201
Winding cord (flexible heating coil) (L = 800 mm)	1760202
Flat spiral coil (PAD coil)	1760203
Customised heating coil (L=750mm, Ø=4mm)	1760204
Flexible ceramic heating coil L = 800 mm	1760205

Technical data		IHG 1500
Article number		1750000
Protection	A	16
Protection class		IP 21 S
Cable length	mm	700
Output power ~50 Hz	kVA	1.5 / 230
Dimensions (L x W x H) approx.	mm	200 x 75 x 140
Weight approx.	kg	4.5

IHG 3500 - Induction heater for heating and loosening stuck and rusted parts

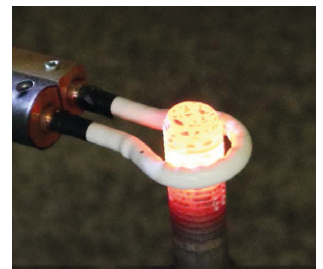


- ▶ Powerful and easy to use
- ▶ Control with up to ten parameters, e.g. setting the maximum temperature or duration of the heating process
- ▶ High repeatability by setting the desired parameters
- ▶ Inexpensive, safe and clean alternative to heating with a burner
- ▶ Interchangeable attachments for numerous applications
- ▶ Loosening smaller panelling parts, stuck and rusted parts such as bolts, nuts, screws, bearings, gear wheels or similar

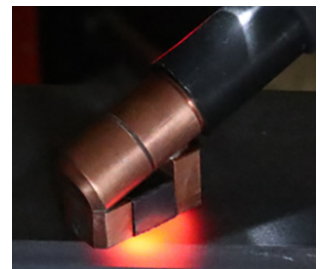
- ▶ Localised heating of parts for soldering, pressing, bending or gluing
- ▶ Melting of materials with a low melting point
- ▶ Integrated water cooling, thanks to easy to fill thanks to water level indicator
- ▶ Simple software updates via USB connection
- ▶ Easy to transport thanks to its compact design and low weight



› Heating a nut with the focus coil at an angle



› Heating a threaded bolt with the water-cooled coil



› Heating a component with the focus coil at an angle

- › Easy handling with high repeatability
- › Quick loosening of screws and nuts
- › Heating parts for pressing, bending or gluing



Convince yourself of our efficiency and ask for an individual consultation!
Contact: +49 (0) 951 96 555-506
beratung@schweisskraft.de

Scope of delivery:
 Handle for coil with 2 m cable
 Lateral focus coil
 Cooling circuit filling 2.5 litres

Technical data		IHG 3500
Article number		1750005
Induction power	kW	3.5
Output frequency	kHz	18 – 60
Protection class		IP 22
Coolant volume	l	2.5
Protection	A	16
Power consumption ~50 Hz	kVA	3.5 / 230
Dimensions (L x W x H) approx.	mm	440 x 240 x 200
Weight approx.	kg	13.5
Weight of the device	kg	9

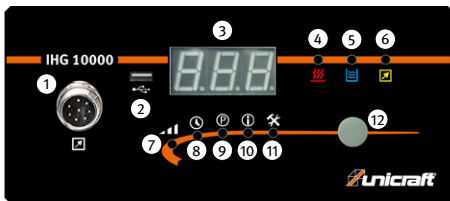


Accessories	Article no.
Handle extension	1760200
Customised heating coil (L=750mm, Ø=4mm)	1760201
Lateral focus coil (1)	1760202
Straight focus coil	1760203
Adapter for water-cooled coils	1760204
Water-cooled coil Ø20 mm	1760205
Water-cooled coil Ø25 mm	1760206
Coolant 3l canister	1760207
Remote control/foot pedal	1760208

(1) included in the scope of delivery

IHG - Powerful, mobile induction heaters with chassis

- ▶ Ideal for every workshop - for use in the automotive, railway and aviation industries, shipbuilding and industry in general, metalworking, maintenance, welding, repair workshops
- ▶ For heating before hardening, straightening, bending or forging pipes, round steel and profiles
- ▶ Localised heating of parts for soldering, pressing, bending and gluing
- ▶ Loosening smaller panelling parts and stuck and rusted parts such as bolts, nuts, screws, bearings, gears or similar
- ▶ Mobile device with chassis and integrated water cooling
- ▶ Inexpensive, safe and clean alternative to heating with a burner
- ▶ Power 12 kVA - high load factor
- ▶ Very quiet operation
- ▶ Flexible and simple operation
- ▶ Water-cooled induction coils
- ▶ Infinitely variable power control from 10 to 100 per cent
- ▶ Timer for high repeatability
- ▶ Clear display for showing and setting the parameters
- ▶ Operating modes constant power CP and constant magnetic field CF selectable



IHG 10000

- 1) Remote control connection (not available)
- 2) USB connection
- 3) Display
- 4) Heating indicator
- 5) Cooling and overheating indicator
- 6) Remote display (function not available)
- 7) Regulation display
- 8) Timer display
- 9) Programme display
- 10) Info display
- 11) Settings
- 12) Encoder



IHG 10000



IHG 13000



Preheating before welding



Hardening of surfaces

Scope of delivery IHG 10000:

Handle for coil with 4 m cable
Round focus coil, 32 mm
Cooling circuit filling 10 litres

Scope of delivery IHG 13000:

Rectangular focus coil

Technical data		IHG 10000	IHG 13000
Article number		1751000	1751005
Induction power	kW	10	13
Output frequency	kHz	18 - 45	18 - 35
Protection class		IP 21	IP 21
Coolant volume	l	10	17.5
Power consumption ~50 Hz	kVA	12 / 400	19 / 400
Dimensions (L x W x H) approx.	mm	400 x 760 x 700	850 x 540 x 960
Weight approx.	kg	58	96

Accessories IHG 10000

Accessories IHG 10000	Art. no.
Ring coil	
- Ø22 mm with one winding	1761050
- Ø28 mm with one winding	1761051
- Ø34 mm with one winding	1761052
- Ø40 mm with one winding	1761053
- Ø47 mm with one winding	1761054
- Ø57 mm with one winding	1761055
Ring coil Ø22 mm with two windings	1761070
Round focus coil, 32 mm	1761010
Round frontal focus coil, 32 mm	1761015
U-profile coil, 14 mm	1761080
Replacement ferrite core	1761085
Coolant 10 litre canister	1761090
Remote control/foot pedal	1761101
Accessories IHG 13000	Art. no.
Rectangular focus coil	1761110
Round focus coil	1761111
Coolant 10 litre canister	1761090

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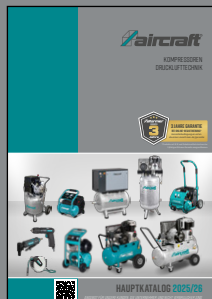
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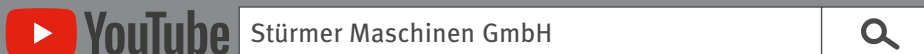


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