







SET-UP AND MAINTENANCE GUIDE

ARCT SERIES

INTELLIGENT
TORCH SOLUTIONS

 EN English Quick Guide
 ES Spanish Guía Consulta Rápida
 PL Polish Szybki przewodnik
 PT Portuguese Guia de consulta rápida

 RU Russia Краткое руководство
 SV Swedish Snabbguide
 CH Chinese 快速指南

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RATINGS AT A GLANCE

IEC/EN 60974-7



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Air-Cooled

| Technical Data: | | T1A/CWT1A Auto | T3A/CWT3A Auto |
|-----------------------|----|------------------------|-------------------------|
| Cooling Method | | Air-Cooled | |
| Rating: | DC | 140A | 240A |
| | AC | 100A | 170A |
| Duty Cycle | | 60% | 60% |
| Electrode Size | | 1.0-3.2mm / 0.04"-1/8" | 1.0-4.8mm / 0.04"-3/16" |
| Operating Temperature | | -20°C ...+40°C | |

Liquid-Cooled

| Technical Data: | | T1WA/CWT1WA Auto | | T3WA/CWT3WA Auto | | T5WA/CWT5WA Auto | | |
|---------------------------------|-------|-------------------------|------|-------------------------|------|------------------------|------|------|
| Cooling Method | | Liquid-Cooled | | | | | | |
| | | 12.5ft | 25ft | 12.5ft | 25ft | 12.5ft | 25ft | |
| Rating: | 1200W | DC | 330A | 330A | 400A | 400A | 550A | 450A |
| | | AC | 230A | 230A | 280A | 280A | 385A | 315A |
| | 1600W | DC | - | - | - | - | 550A | 450A |
| | | AC | - | - | - | - | 385A | 315A |
| Duty Cycle | | 100% | 100% | 100% | 100% | 100% | 100% | |
| Electrode Size | | 1.0-4.0mm / 0.04"-5/32" | | 1.0-4.0mm / 0.04"-5/32" | | 1.6-6.4mm / 1/16"-1/4" | | |
| Minimum Water Flow | | 1.5 l/min | | 1.5 l/min | | 1.5 l/min | | |
| Minimum Water Inlet Pressure | | 2.5 Bar | | | | | | |
| Maximum Water Inlet Pressure | | 5.0 Bar | | | | | | |
| Maximum Water Inlet Temperature | | 50°C | | | | | | |
| Operating Temperature | | -20°C ...+40°C | | | | | | |

Technical Data

ES Datos Técnicos PL Dane techniczne PT Dados Técnicos
RU Краткое руководство SV Snabbguide CH 技术参数

Rating

ES Rango PL Obciążalność PT Capacidade
RU Параметры SV Strömstyrka CH 电流

Duty Cycle

ES Ciclo de Trabajo PL Cykl pracy PT Ciclo de Trabalho
RU ПБ SV Intermittens CH 暂载率

Electrode Size

ES Diametro Electrodo PL Średnica elektrody
PT Diâmetro Eletrodo RU Диаметр электрода
SV Elektroddiameter CH 电极尺寸

Air-Cooled

ES Refrigerado Aire PL Chłodzenie gazowe
PT Refrigerado Gás RU Воздушное охлаждение
SV Gaskylid CH 空冷

Liquid-Cooled

ES Refrigerado Agua PL Chłodzenie cieczą
PT Refrigerado Água RU Жидкостное охлаждение
SV Vattenkyld CH 水冷

Minimum Water Flow

ES Mínimo Flujo Agua PL Minimalny przepływ cieczy PT Fluxo Água Mínimo
RU Минимальная скорость подачи охлаждающей жидкости
SV Vattenflöde minimum CH 最低水流

Minimum Water Inlet Pressure

ES Presión Mínima Entrada Agua PL Minimalne ciśnienie wejściowe
PT Pressão Mínima Entrada Água RU Минимальное давление на входе
SV Vattentryck minimum CH 最低进水口压力

Maximum Water Inlet Pressure

ES Presión Máxima Entrada Agua PL Maksymalne ciśnienie wejściowe
PT Pressão Máxima Entrada Água RU Максимальное давление на входе
SV Vattentryck maximum CH 最高进水口压力

Maximum Water Inlet Temperature

ES Máxima Temperatura Entrada Agua PL Maksymalna temperatura cieczy
PT Máxima Temperatura Entrada Água RU Максимальная температура охлаждающей жидкости на входе
SV Maxtemperatur vatten CH 进水口最高温度

- ✓ IEC/EN 60974-7
- ✓ ISO9001:2015
- ✓ LVD 2014/35/EU
- ✓ REACH 1907/2006/EC
- ✓ RoHS2 2011/65/EU, amend 2015/863/EU

GETTING STARTED







Auto Standard Set-Up



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- 1 Ensure you have all the parts



-  Asegúrese que tienes todas las piezas
-  Upewnij się, że masz wszystkie części w zestawie
-  Certifique-se de ter todas as peças
-  Убедитесь, что у Вас есть все части горелки.
-  Kontrollera att alla delar finns
-  准备好需要安装的备件







- 2 Push the gasket onto the head
Twist and push the gasket until in place



-  Coloque el sello de goma en la cabeza de la antorcha.
Nota: Hay una pequeña ranura en la parte superior de la cabeza de la antorcha.
Es necesario girar e insertar la pieza hasta el tope.
-  Załóż silikonową uszczelkę na główkę palnika
-  Coloque a vedação de borracha na cabeça do queimador.
Nota: Há uma pequena saliência na parte superior da cabeça da tocha.
É necessário girar e inserir a peça até o seu travamento.
-  Наденьте резиновый уплотнитель на голову горелки.
Внимание: на голове горелки есть небольшой выступ.
Необходимо повернуть и вставить уплотнитель до упора.
-  Montera packningen på huvudet. Observera räfflan på huvudet. Vrid och tryck på packningen tills den är i rätt läge
-  按照图示方法, 将橡胶绝缘套装到枪头上







- 3 Assemble the heat isolator.
Tighten with the enclosed spanner



-  Armar el aislador de calor. Apretar con llave de boca.
-  Złożyć izolator ze stali nierdzewnej
-  Montar o isolador de calor.
Apertar com chave de boca.
-  Наденьте теплоизолятор. Закрепите с помощью прилагающегося ключа.
-  Montera värmeisolatorn och spänn fast med det medföljande verktyget
-  按照图示方法, 将不锈钢隔热套旋到枪头螺纹上, 并使用专用扳手拧紧。

- 4 Insert the collet and locate the collet slot on the pin at the back of the head



-  Inserte la pinza y localice la ranura de la pinza en el pasador en la parte posterior del cabezal.
-  Umieść tuleję zaciskową na
-  Insira a pinça e localize a ranhura da pinça no pino na parte posterior da cabeça.
-  Вставьте цангу с задней стороны головы горелки.
-  Rikta in spännhylsan på huvudets baksida
-  按照图示方法, 将钨极夹装到枪头内孔, 装配时注意钨极夹上的轴向定位导槽对准枪头孔内的定位销。

GETTING STARTED



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5 Assemble the back cap to pinch the collet



- Gire el capuchón para apretar la pinza
- Przykręć korek w celu zaciśnięcia oprawy elektrody
- Gire a capa para apertar a pinça
- Закрепите колпачок, чтобы зажать цангу.
- Montera spännhuven för att spänna fast spännhylsan
- 按照图示方法，将后帽与钨极夹通过螺纹连接到一起

6 Insert the tungsten



- Insertar el tungsteno
- Włóż elektrodę wolframową od przodu palnika
- Inserir o Tungsténio
- Вставьте вольфрамовый электрод.
- Montera elektroden
- 按照图示方法，将钨极装到钨极夹的内孔中，顺时针旋转后帽夹紧钨极。

7 Assemble the ceramic - push on



- Ubicar la cerámica - encajar
- Zamocuj dyszę ceramiczną
- Posicionar o bocal de cerâmica - encaixar
- Закрепите керамическое сопло.
- Tryck på gashylsan
- 按照图示方法，将陶瓷喷嘴装到不锈钢隔热套上，并推紧。

8 Tighten the back cap. You're ready to go!



- Armar el capuchón. Usted está listo!
- Dokręć korek w celu zaciśnięcia elektrody wolframowej w palniku
- Apertar a capa do tungsténio. Você esta pronto!
- Затяните колпачок. Горелка готова к работе!
- Dra åt spännhuven. Nu är det klart att svetsa!
- 按照图示方法，逆时针旋转后帽松开钨极位置，调整钨极位置，顺时针旋转后帽夹紧并固定钨极位置。

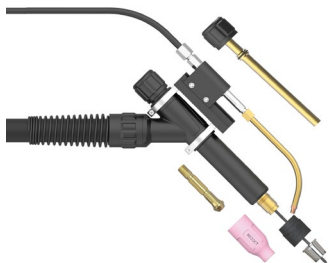
GETTING STARTED

Auto Cold-Wire Set-Up



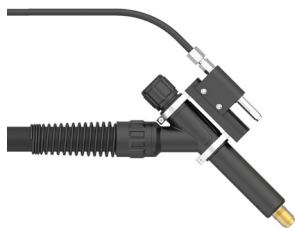
MAKE WORK
LIFE EASIER

1 Ensure you have all the parts



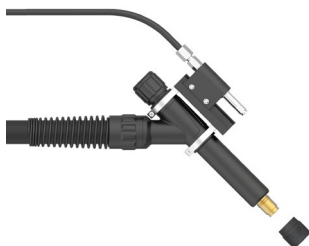
- Asegúrese que tienes todas las piezas
- Upewnij się, że masz wszystkie części w zestawie
- Certifique-se de ter todas as peças
- Убедитесь, что у Вас есть все части горелки.
- Kontrollera att alla delar finns
- 准备好需要安装的备件

2 Remove the cold-wire neck assembly



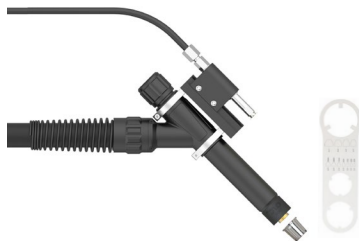
- Retire el conjunto cold-wire del cuello
- Zdemontuj rurkę prowadzącą
- Remova o conjunto cold-wire do pescoço
- Снимите узел холодного провода
- Ta bort den kalla trådens halsanslutning
- 取下冷丝弯管

3 Push the gasket onto the head Twist and push the gasket until in place



- Coloque el sello de goma en la cabeza de la antorcha.
Nota: Hay una pequeña ranura en la parte superior de la cabeza de la antorcha.
Es necesario girar e insertar la pieza hasta el tope.
 Załóż silikonową uszczelkę na główkę palnika
- Coloque a vedação de borracha na cabeça do queimador.
Nota: Há uma pequena saliência na parte superior da cabeça da tocha.
É necessário girar e inserir a peça até o seu travamento.
- Наденьте резиновый уплотнитель на голову горелки.
Внимание: на голове горелки есть небольшой выступ.
Необходимо повернуть и вставить уплотнитель до упора.
- Montera packningen på huvudet. Observera räfflan på huvudet. Vrid och tryck på packningen tills den är i rätt läge
- 按照图示方法, 将橡胶绝缘套装到枪头上。

4 Assemble the heat isolator. Tighten with the enclosed spanner



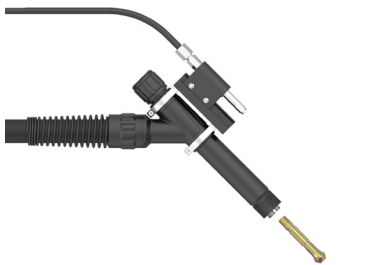
- Armar el aislador de calor. Apretar con llave de boca.
- Złóż izolator ze stali nierdzewnej
- Montar o isolador de calor.
Apertar com chave de boca.
- Наденьте теплоизолятор. Закрепите с помощью прилагающегося ключа.
- Montera värmeisolatorn och spänn fast med det medföljande verktyget
- 按照图示方法, 将不锈钢隔热套旋到枪头螺纹上, 并使用专用扳手拧紧。

GETTING STARTED



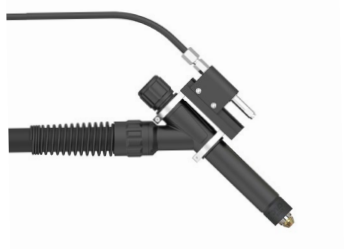
MAKE WORK
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5 Insert the collet and locate the collet slot on the pin at the back of the head



- Ubique la pinza en el pasador en la parte posterior del cabezal
- Umieść tuleję zaciskową na
- Localizar a pinça no pino atrás da cabeça da tocha.
- Вставьте цангу с задней стороны головы горелки.
- Rikta in spännhylsan på huvudets baksida
- 按照图示方法，将钨极夹装到枪头内孔，装配时注意钨极夹上的轴向定位导槽对准枪头孔内的定位销。

6 Assemble the back cap to pinch the collet



- Montar el capuchón largo para apretar la pinza
- Przykręć korek w celu zaciśnięcia oprawy elektrody
- Montar a capa do eletrodo para apertar a pinça
- Закрепите колпачок, чтобы зажать цангу.
- Montera spännhuvnen för att späanna fast spännhylsan
- 按照图示方法，将后帽与钨极夹通过螺纹连接到一起。

7 Insert the tungsten



- Insertar el tungsteno
- Włóż elektrodę wolframową od przodu palnika
- Inserir o Tungstênio
- Вставьте вольфрамовый электрод.
- Montera elektroden
- 按照图示方法，将钨极装到钨极夹的内孔中，顺时针旋转后帽夹紧钨极。

8 Assemble the ceramic - push on



- Ubicar la cerámica - encajar
- Zamocuj dyszę ceramiczną
- Posicionar o bocal de cerâmica - encaixar
- Закрепите керамическое сопло.
- Tryck på gashylsan
- 按照图示方法，将陶瓷喷嘴装到不锈钢隔热套上，并推紧。

GETTING STARTED







Auto Cold-Wire Set-Up



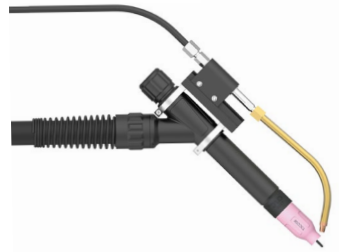
MAKE WORK
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9 Tighten the back cap



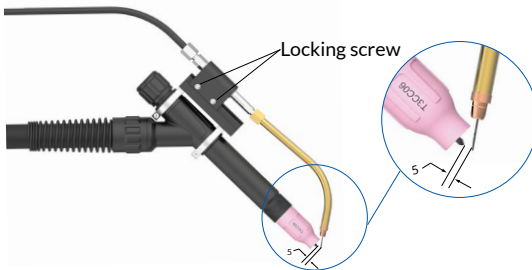
-  Armar el capuchón.
-  Dokręć korek w celu zaciśnięcia elektrody wolframowej w palniku
-  Apertar a capa do tungsténio.
-  Затяните колпачок.
-  Dra åt spännhuv.
-  按照图示方法，逆时针旋转后帽松开钨极，调整钨极位置，顺时针旋转后帽夹紧并固定钨极位置。







10 Install the cold-wire neck assembly



-  Instale el conjunto cold-wire en el cuello
-  Zamontuj rurkę prowadzącą
-  Instale o conjunto cold-wire no pescoço
-  Установите холоднотермопроводную шейную сборку
-  Montera cold-wire-halsassemblagen
-  装上冷丝弯管

11 Feeding welding wire, adjust the distance and tighten the locking screw



-  Alimentar el hilo de soldadura, ajustar la distancia y apretar el tornillo de bloqueo
-  wyreguluj odległość drutu spawalniczego od elektrody.
-  Alimentar o arame de solda, ajustar a distância e apertar o parafuso de fixação.
-  Подавать сварочную проволоку, отрегулировать расстояние и затянуть фиксирующий винт
-  Mata in svetsstråden, justera avståndet och dra åt låsskruven.
-  送入焊丝，调整距离并拧紧锁定螺丝。

ARC TIG WEAR PARTS SET-UP OVERVIEW



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T1A/T1WA CWT1A/CWT1WA Series



Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 4 | 6mm 1/4" | 6 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 8 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 8 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
Quartz cups can be used for Aluminium welding but only in short runs

Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 4 | 6mm 1/4" | 5 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 8 l/min | 14mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 8 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
Quartz cups can be used for Aluminium welding but only in short runs



Short Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 5 | 8mm 5/16" | 6 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 8 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |



Short Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Steel, Aluminium and Stainless Steel

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 5 | 8mm 5/16" | 6 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 8 l/min | 8mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |



ARC TIG WEAR PARTS SET-UP OVERVIEW



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T3WA/CWT3WA



Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 |
| 4 | 6mm 1/4" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 11mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 7 l/min | 12mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 10 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 12 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

Quartz cups can be used for Aluminium welding but only in short runs

Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless Steel, Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 |
| 4 | 6mm 1/4" | 5 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 7 l/min | 14mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 8 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 20mm | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

Quartz cups can be used for Aluminium welding but only in short runs

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Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 |
| 4 | 6mm 1/4" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 11mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 7 l/min | 12mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 10 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 12 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● |
| 12 | 19mm 3/4" | 15 l/min | 18mm | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

Quartz cups can be used for Aluminium welding but only in short runs

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Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless Steel, Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 4 | 6mm 1/4" | 5 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 5 | 8mm 5/16" | 6 l/min | 10mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 6 | 10mm 3/8" | 7 l/min | 13mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 7 | 11mm 7/16" | 7 l/min | 14mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 8 | 12mm 1/2" | 8 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 20mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 12 | 19mm 3/4" | 13 l/min | 20mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
Quartz cups can be used for Aluminium welding but only in short runs

T3A /T5WA CWT3A /CWT5WA



Large Gas Lens Nozzle With Large Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless Steel, Steel and Aluminium

| Nozzle Size | Bore Size | Suggested Gas Flow Rate | Maximum Tungsten Stick-out | Ceramic Nozzle | Tungsten Size | | | | | | | |
|-------------|-------------|-------------------------|----------------------------|----------------|---------------|-----|-----|-----|-----|-----|-----|---|
| | | | | | 1.0 | 1.6 | 2.4 | 3.2 | 4.0 | 4.8 | 6.4 | |
| 8 | 12mm 1/2" | 8 l/min | 15mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 10 | 15mm 5/8" | 10 l/min | 20mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 12 | 19mm 3/4" | 13 l/min | 20mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| 14 | 24mm 15/16" | 15 l/min | 25mm | ● | ● | ● | ● | ● | ● | ● | ● | ● |

Note: The Tungsten stick out should be minimum 10mm for Aluminium welding

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