AS 18-TW

water-cooled

Different modular switch units available:

single push-button
double push-button
up/down (4 push-buttons)
single push-button
with potentiometer

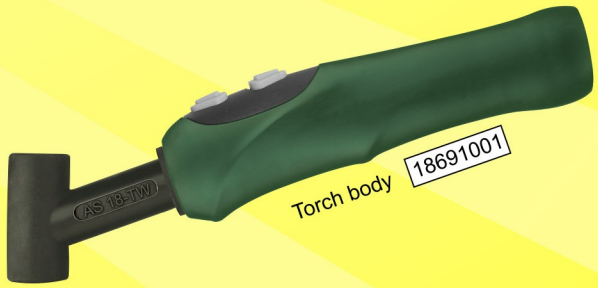
320 Amp./100% duty cycle (DC)
240 Amp./100% duty cycle (AC)

HSN 564

AS 18-TW

water-cooled

Equipment: **A** standard
B gas lens
D gas lens jumbo



O-ring black ID9-W2,5mm included
17089011

A **B** **D**

Gas lens insulator
17089021

Gas lens insulator jumbo
17089031

Collet L52mm
17□□5202 **for** 1,0/1,6/2,4
18□□5202 **for** 3,2/4,0
□□**Please fill in size**

Collet L52mm
17□□5202 **for** 1,0/1,6/2,4
18□□5202 **for** 3,2/4,0
□□**Please fill in size**

Collet L52mm
17□□5202 **for** 1,0/1,6/2,4
18□□5202 **for** 3,2/4,0
□□**Please fill in size**

Collet body
1796□□02 **for** 1,0/1,6/2,4
1896□□02 **for** 3,2/4,0
□□**Please fill in size**

Gas lens
1796□□11 **for** 1,0/1,6/2,4
1896□□11 **for** 3,2/4,0
□□**Please fill in size**

Gas lens jumbo
1796□□21 **for** 1,0/1,6/2,4
1896□□21 **for** 3,2/4,0
□□**Please fill in size**

Ceramic nozzle L47mm
for standard collet body
Please state size
Also available in special length
L76mm

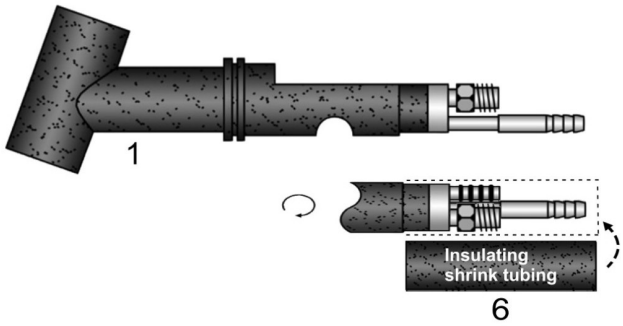
Ceramic nozzle L42mm
for gas lens
Please state size
Also available in special length
L76mm

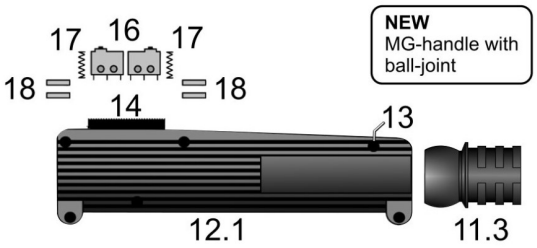
Ceramic nozzle L 48mm
for gas lens jumbo
Please state size

HSN 737-1

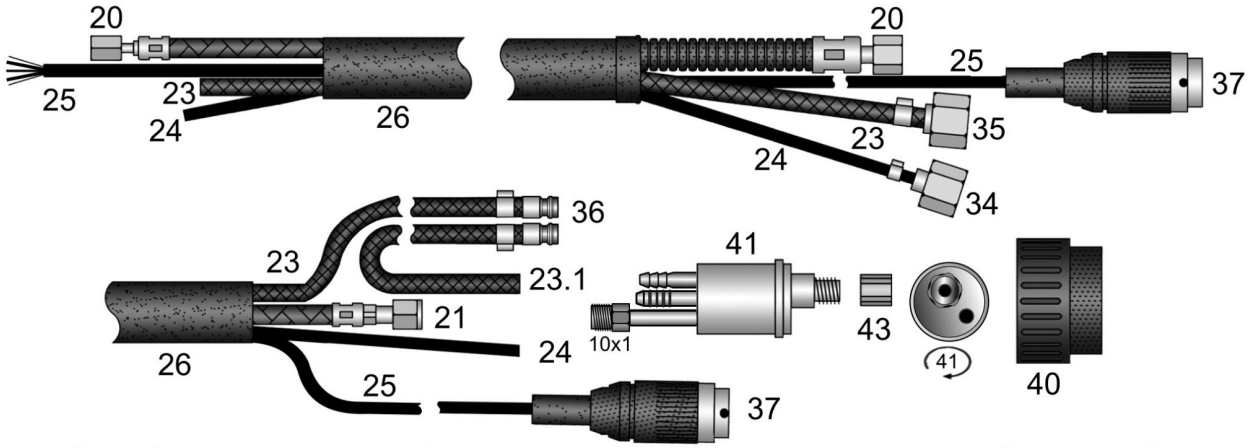
AS 18-TW water-cooled

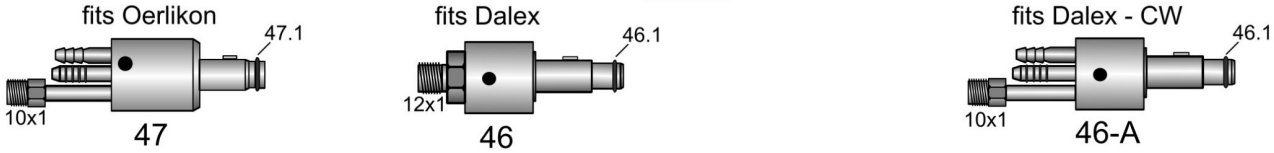
320 Ampere at 100% duty cycle (DC) - 240 Ampere at 100% duty cycle (AC)

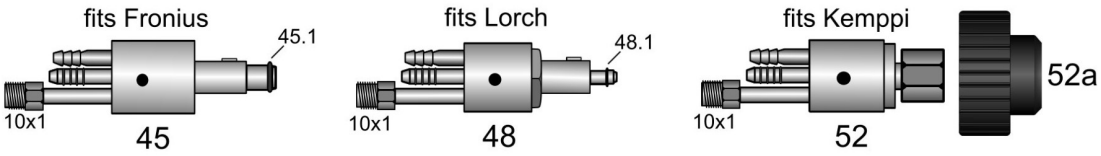


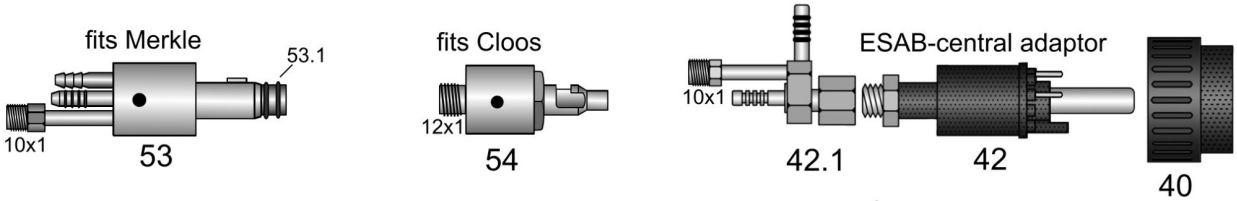


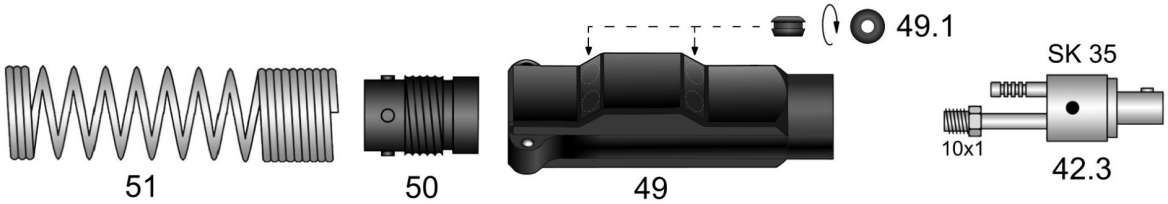
Forma WIG-handle with ball joint - different modular switch units - special switching modules on request





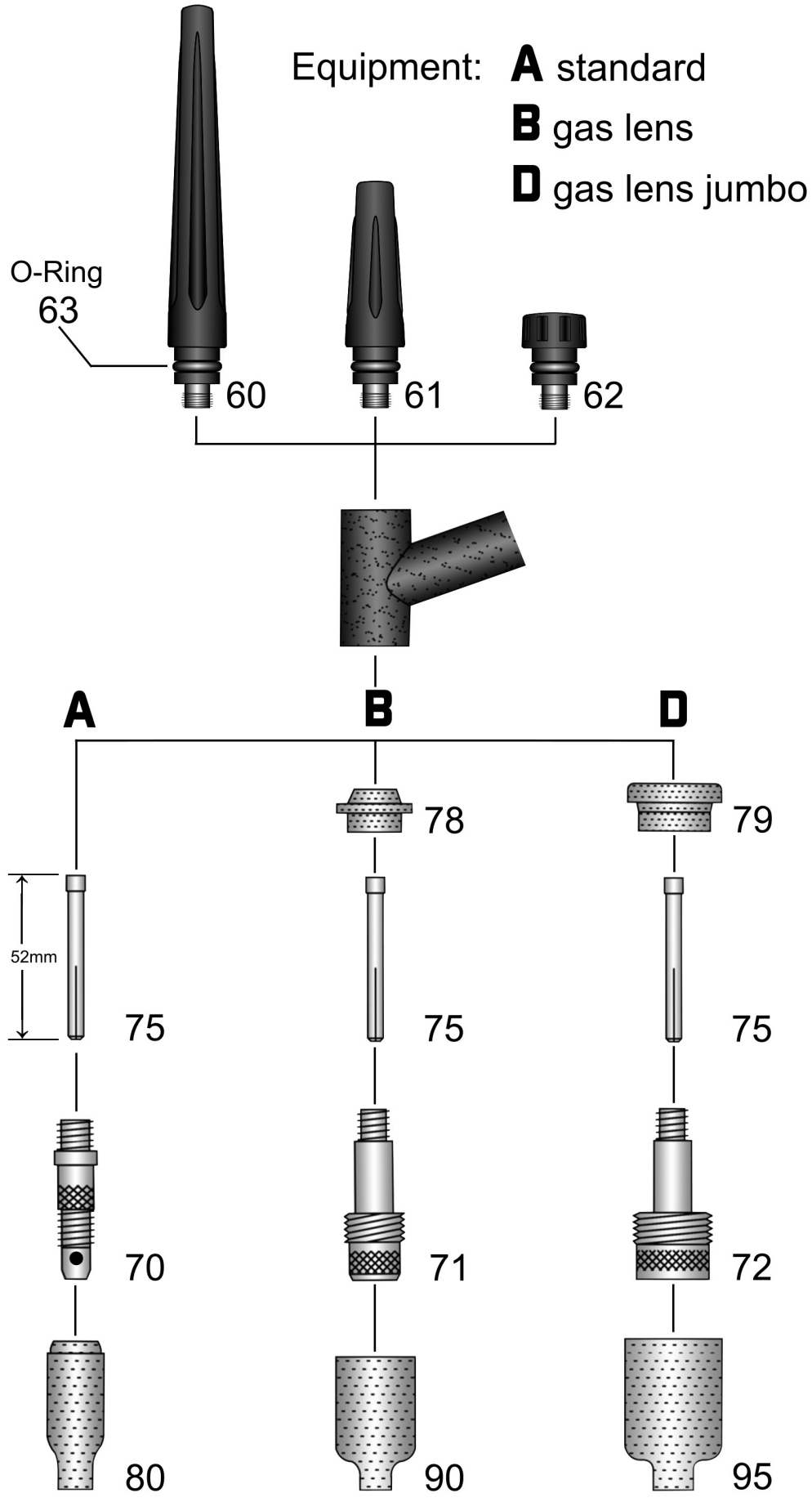






HSN 525-2

AS 18 - TW water-cooled spare parts



HSN 107-1

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

	Art.-No.	
		Torches with first meter leather hose. Prices without leather on request. Machine side separa connections with Tuchel plug.
		In variation to the torches listed below, the torches can also be produced with other power/water cables (e.g. HT 180 silicone superflexible). This can also be combined with hose in a lot of different qualities. Torches and cable assemblies can be produced in excess lengths Please find the different options and surcharges in the attachment "Custom made products" appendix C. We produce torches for more than 40 different brands of machines with different connection systems.
	18600401	Torch AS 18-TW / 4m cable assembly ST 80 PVC-NIT
	18600801	Torch AS 18-TW / 8m cable assembly ST 80 PVC-NIT
		The following torches are equipped with very flexible and heat resistant HT110 rubber fabric hoses.
	1860040P	Torch AS 18-TW / 4m cable assembly HT 110
	1860080P	Torch AS 18-TW / 8m cable assembly HT 110
		TIG-spare cable assemblies in different qualities, machine side with separate connections an Tuchel plug, or, if ordered so, with the following connection systems:
	wig92402	TIG-spare cable assembly water-cooled 4m - please state desired design!
	wig92802	TIG-spare cable assembly water-cooled 8m - please state desired design!
		The following surcharges for machine side connections are only to find prices quickly. Please use our catalogue "TIG machine side connections" to find a "T"number which identifies a machine side connection system completely.
	29002102	Surcharge: machine side power/water plug SK35 bayonet connection AD13mm
	29000201	Surcharge: machine side with EURO central adapter
	29002109	Surcharge: machine side power/water plug fits Merkle with 2 O-rings
	29002106	Surcharge: machine side power/water plug fits Fronius with 1 O-ring
	29002101	Surcharge: machine side power/water plug fits Dalex with 1 O-ring
	29002108	Surcharge: machine side power/water plug fits Oerlikon with 1 O-ring
	29002104	Surcharge: machine side power/water plug fits Lorch SK35 + gas-nipple
	29002105	Surcharge: machine side power/water plug fits Kemppi IT-G1/4"
	29002110	Surcharge: machine side power/water plug fits Cloos
	29000212	Surcharge: machine side fits ESAB central adapter, 4 pins installed at position 3,4,5,6
		Please note that there might be additional charges for special control line plugs. See appendi
1	18691001	Torch body AS 18-TW
6	18050002	Ignition insulating hose L75mm / ID32mm down to ID16mm
11.1	91914601	Forma TIG handle with screws, ball joint, without modular switch unit
11.2	91914602	Forma screw for handle
11.3	91914603	Forma hose bracket with ball joint ID21,5mm (also fits MG-handle)
11.4	91914611	Forma modular switch unit: 1 button with connecting adapter
11.5	91914621	Forma modular switch unit: 2 buttons with connecting adapter
11.6	91914631	Forma modular switch unit: 1 button + potentiometer (10k) with connecting adapter
11.7	91914641	Forma modular switch unit: 2 buttons + up/down (4 switches) with connecting adapter
11.8	91914651	Forma connecting adapter fits control line to modular switch unit
N.i.	91914661	Forma switch module safety nipple
N.i.	91914671	TW-steadying adapter, anti turn locking for TW-torch bodies
12.1	91914061	MG-handle with ball joint, push-button, 2 return springs, 2 microswitches and 4 cylindrical pins
13	91914421	MG-tapping screw

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

	Art.-No.	
14	91915002	MG-push button
16	91914121	MG-microswitch
17	91914221	MG-return spring
18	91914321	MG-cylindrical pin
		Please state the machine side connection for the following power/water cables.
		For 4m long torches:
20	12942401	ST 80 PVC-NIT power/water cable 10mm² 12/18/20-TW / 4m
20	12942403	HT 110 rubber fabric hose power/water cable 10mm² 12/18/20-TW / 4m
20	12942405	HT 130 TPE power/water cable 10mm² 12/18/20-TW / 4m
20	12942408	HT 180 silicone super flexible power/water cable 10mm² 12/18/20-TW / 4m
		For 8m long torches:
20	12942801	ST 80 PVC-NIT power/water cable 10mm² 12/18/20-TW / 8m
20	12942803	HT 110 Rubber fabric hose power/water cable 10mm² 12/18/20-TW / 8m
20	12942805	HT 130 TPE power/water cable 10mm² 12/18/20-TW / 8m
20	12942808	HT 180 silicone super flexible power/water cable 10mm² 12/18/20-TW / 8m
		The following power/water cables are produced with M10x1 inner thread at the machine side for EURO central adapters. (fits to all Holch connection systems with outher thread M10x1).
		For 4m long torches:
21	12942411	ST 80 PVC-NIT power/water cable 10mm² 12/18/20-TW / 4m
21	12942413	HT 110 rubber fabric hose power/water cable 10mm² 12/18/20-TW / 4m
21	12942415	HT 130 TPE power/water cable 10mm² 12/18/20-TW / 4m
21	12942418	HT 180 silicone super flexible power/water cable 10mm² 12/18/20-TW / 4m
		For 8m long torches:
21	12942811	ST 80 PVC-NIT power/water cable 10mm² 12/18/20-TW / 8m
21	12942813	HT 110 rubber fabric hose power/water cable 10mm² 12/18/20-TW / 8m
21	12942815	HT 130 TPE power/water cable 10mm² 12/18/20-TW / 8m
21	12942818	HT 180 silicone super flexible power/water cable 10mm² 12/18/20-TW / 8m
		Reel goods:
		Prices are per meter and only applicable for purchasing of complete rolls
23	50150001	Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm blue for water (100m)
23	51700002	Meter HT 110 rubber fabric hose ID5,0-W1,7mm blue for water (150m)
23.1	50151001	Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm red for water (100m)
23.1	51700003	Meter HT 110 rubber fabric hose ID5,0-W1,7mm red for water (150m)
24	31000001	Meter ST 70 PVC hose ID3,0-W1,0mm black for gas (100m)
24	51700001	Meter HT 110 rubber fabric hose ID5,0-W1,7mm black for gas (150m)
24	31200002	Meter HT 130 TPE hose ID3-W1,2mm yellow for gas (100m)
N.i.	91902701	Meter control line 3x0,34mm² shielded black (100m)
N.i.	91902711	Meter control line 3x0,5mm² green (100m)
25	91902721	Meter control line 5x0,25mm² grey (100m)
26	22150002	Meter neoprene protective hose ID22mm black (40m)
N.i.	91915004	Leather protective hose ID22mm / 1 meter long
N.i.	91915007	Leather protective hose ID22mm / 1 meter long with ball joint and hose connector
N.i.	91915013	Hose connector leather protective hose / protection hose ID22,5mm (black) with slot, OD with grooves
34	91901501	Coupling nut IT-G1/4"
N.i.	91901211	Hose connector 4mm fits coupling nut R1/4""

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

	Art.-No.	
35	91901601	Coupling nut IT-G3/8"
N.i.	91901301	Hose connector 5mm fits Coupling nut R3/8"
36	91901001	Cooling liquid plug nipples EURO
N.i.	91901008	Closing cap blue fits cooling liquid plug nipples EURO
N.i.	91901009	Closing cap red fits cooling liquid plug nipples EURO
37	91904101	Plug 3-poles Tuchel with bayonet-catch
37	91904111	Plug 5-poles Tuchel with bayonet-catch
		More control line plugs see appendix D
40	91900701	Terminal nut insulated fits EURO central adapter
41	91900211	TIG central adapter EURO central adapter water cooled
42	91900301	TIG central adapter identical ESAB, 4 contact pins at position 3,4,5,6
42.1	91918571	TIG power/cooling liquid junction fits ESAB central adapter
42.3	91918312	TIG central adapter SK-35 bayonet connection AD13mm
43	91900901	Swivel nut IT-M10x1 (rounded edges) fits EURO central adapter
45	91918327	Power/water plug fits Fronius with 1 O-ring (OT-M10x1 / like EURO central adapter)
45.1	62190001	O-ring ID6,2-W1,9mm fits Fronius
46	9190417e	Power/water plug fits Dalex (1 O-ring) (OT-12x1)
46-A	9190418n	Power-/gasplug fits Dalex with waterdeviation to outside, CW-System with 1 O-ring
46.1	63240001	O-ring ID6,3-W2,4mm fits Dalex
47	9190423n	Power/water plug fits Oerlikon with 1 O-ring (OT-M10x1 / like EURO central adapter)
47.1	60717801	O-ring ID6,07-W1,78mm fits Oerlikon
48	9190420n	Power/water plug fits Lorch SK35 + gas-nipple (OT-10x1 / like EURO central adapter)
48.1	91900801	O-ring ID4-W1mm fits gas-nipple EURO central adapter
o.A	91900552	TIG cable support long (like MIG-MAG) with screws fits ESAB central adapter
N.i.	91900554	Attachment screw M4x8mm fits ESAB central adapter
49	91900557	TIG cable support short with screws (fits water-cooled)
N.i.	91920702	Screw M3x11,5mm fits Ratio/Industry/RAUCH handle and cable support
N.i.	91920703	M3 mounting socket fits Ratio/Industry/RAUCH handle and cable support
o.A.	91900602	Screw M4x6mm fits TIG cable support short
49.1	91901012	Reduction-eyelet (rubber) from ID10,5mm to ID5mm fits TIG cable support short
N.i.	91921701	PUR hose ID8,5-W1,0mm 150mm long fits leading water hoses into cable support
50	91912801	Spring-socket fits cable support
51	91912601	Cable support spring
52	9190419n	Power/water plug fits Kemppi IT-G1/4" (AG-M10x1 / like EURO central adapter)
52a	91903503	Insulating sleeve with inner hexagonal shape A/F17 for TIG power-connection IT-G1/4"
53	9190424n	Power/water plug fits Merkle with 2 O-rings (OT-M10x1 / like EURO central adapter)
53.1	81600001	O-ring ID8-W1,6mm fits Lorch/Merkle
54	9190415n	Powerplug fits Cloos (special-plug) (OT-12x1)
60	17091311	Holch back cap long (german version with black O-ring) AS17-AS18-ABL220 57Y02-D
61	17091321	Holch back cap medium (german version with black O-ring) AS17-AS18-ABL220 57Y03-D
62	17091301	Holch back cap short (german version with black O-ring) AS17-AS18-ABL220 57Y04-D
63	17089011	O-ring black ID9-W2,5mm for back cap
70	17961002	Collet body 17-18-26-220 / 1,0 10N30
70	17961602	Collet body 17-18-26-220 / 1,6 10N31

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

	Art.-No.	
70	17962402	Collet body 17-18-26-220 / 2,4 10N32
70	18963202	Collet body 17-18-26-220 / 3,2 10N28
70	18964002	Collet body 17-18-26-220 / 4,0 406488
71	17961011	Gas lens 17-18-26-220 / 1,0 45V24
71	17961611	Gas lens 17-18-26-220 / 1,6 45V25
71	17962411	Gas lens 17-18-26-220 / 2,4 45V26
71	18963211	Gas lens 17-18-26-220 / 3,2 45V27
71	18964011	Gas lens 17-18-26-220 / 4,0 45V28
72	17961021	Jumbo-Gas lens 17-18-26-220 / 1,0 45V0204
72	17961621	Jumbo-Gas lens 17-18-26-220 / 1,6 45V116
72	17962421	Jumbo-Gas lens 17-18-26-220 / 2,4 45V64
72	18963221	Jumbo-Gas lens 17-18-26-220 / 3,2 995795
72	18964021	Jumbo-Gas lens 17-18-26-220 / 4,0 45V63
		Brazen collets L-52mm **suitable equipment line (A) standard collet body** **suitable equipment line (B) gas lens** **suitable equipment line (D) gas lens jumbo**
75	17105202	Collet L52mm AS17-AS18-ABL220 / 1,0 10N22-D
75	17165202	Collet L52mm AS17-AS18-ABL220 / 1,6 10N23-D
75	17245202	Collet L52mm AS17-AS18-ABL220 / 2,4 10N24-D
75	18325202	Collet L52mm AS17-AS18-ABL220 / 3,2 10N25-D
75	18405202	Collet L52mm AS17-AS18-ABL220 / 4,0 10N20-D
78	17089021	PTFE-Gas-lens insulator 17-18-26-220 54N01
79	17089031	PTFE-Gas-lens insulator Jumbo 17-18-26-220 54N63
		Ceramic gas nozzles in different lengths **suitable equipment line (A) standard collet body**
80	17930401	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.4 10N50 (pu=10pieces)
80	17930501	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.5 10N49 (pu=10pieces)
80	17930601	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.6 10N48 (pu=10pieces)
80	17930701	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.7 10N47 (pu=10pieces)
80	17930801	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.8 10N46 (pu=10pieces)
80	17930101	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.10 10N45 (pu=10pieces)
80	17930121	Ceramic gas nozzle L47mm 17-18-26-220 / Gr.12 10N44 (pu=10pieces)
N.i.	17930404	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.4 10N50L (pu=10pieces)
N.i.	17930504	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.5 10N49L (pu=10pieces)
N.i.	17930604	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.6 10N48L (pu=10pieces)
N.i.	17930704	Ceramic gas nozzle L76mm 17-18-26-220 / Gr.7 10N47L (pu=10pieces)
		Ceramic gas nozzles in different lengths **suitable equipment line (B) gas lens**
90	22093041	Gas nozzle for gas lens L42mm / Gr.4 54N18 (pu=10pieces)
90	22093051	Gas nozzle for gas lens L42mm / Gr.5 54N17 (pu=10pieces)
90	22093061	Gas nozzle for gas lens L42mm / Gr.6 54N16 (pu=10pieces)
90	22093071	Gas nozzle for gas lens L42mm / Gr.7 54N15 (pu=10pieces)
90	22093081	Gas nozzle for gas lens L42mm / Gr.8 54N14 (pu=10pieces)
90	22093111	Gas nozzle for gas lens L42mm / Gr.11 54N19-11 (pu=10pieces)
90	22093121	Gas nozzle for gas lens L42mm / Gr.12 54N19 (pu=10pieces)

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

	Art.-No.	
N.i.	22093054	Gas nozzle for gas lens L76mm / Gr.5 54N17L (pu=10pieces)
N.i.	22093064	Gas nozzle for gas lens L76mm / Gr.6 54N16L (pu=10pieces)
N.i.	22093074	Gas nozzle for gas lens L76mm / Gr.7 54N15L (pu=10pieces)
N.i.	22093084	Gas nozzle for gas lens L76mm / Gr.8 54N14L (pu=10pieces)
		Ceramic gas nozzles jumbo in different lengths suitable eqipment line (D) gas lens jumbo
95	22093066	Jumbo gas nozzle L48mm / Gr.6 57N75 (pu=10pieces)
95	22093086	Jumbo gas nozzle L48mm / Gr.8 57N74 (pu=10pieces)
95	22093106	Jumbo gas nozzle L48mm / Gr.10 53N88 (pu=10pieces)
95	22093126	Jumbo gas nozzle L48mm / Gr.12 53N87 (pu=10pieces)
N.i.	22093067	Jumbo gas nozzle L73mm / Gr.6 57N75L (pu=10pieces)
N.i.	22093087	Jumbo gas nozzle L73mm / Gr.8 57N74L (pu=10pieces)
N.i.	22093107	Jumbo gas nozzle L73mm / Gr.10 53N88L (pu=10pieces)
N.i.	22093127	Jumbo gas nozzle L73mm / Gr.12 53N87L (pu=10pieces)
		Top quality tungsten electrodes in 8 different qualities, see appendix A.