

GENERAL WELDING PRODUCTS CATALOG

# FARM SUPPLY





# AUTOMOTIVE AFTER MARKET

# TOOL& EQUIPMENT



# MASS MARKET

**VICTOR**®

THERMAL DYNAMICS

Tweco.

THERMAL ARC

<u>Firepower</u>





The **Thermadyne Specialty Markets** group operates within multiple distribution channels to meet the needs of several distinct industry segments.

These segments consist of:

Farm Supply - farm and tractor supply and equipment companies.

**Automotive Aftermarket** - including national automotive retailers who advertise to a broad audience ranging from weekend repair and DIY to small automotive service and repair businesses.

**Tool and Equipment Distribution Companies** - those who carry light construction, industrial, and related products.

**Mass Market Retailers** - an area that has seen significant growth through direct sales via direct mail, catalog and internet sales, serving a variety of industries.

The organization and structure of this unit is designed to be more responsive to market segments that will benefit from the technology and the heritage of the brands developed by Thermadyne. The Thermadyne brands include Victor, Tweco, Thermal Dynamics, Thermal Arc, Arcair, Cigweld (outside the U.S. and Americas) and Stoody. Thermadyne Specialty Markets Group will continue to market the Firepower line of products as well.

The Thermadyne Specialty Market group utilizes the company's expertise in engineering, brand design/development and global sourcing to offer the best value for these consumer markets.

Thermadyne is committed to superior quality products and service. Thermadyne is ISO 9001:2000 certified and most of our branded products are tested and certified by independent, accredited agencies including UL, CSA and ETL.





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#### **Machines at a Glance**

#### MIG • GMAW • Flux-Cored • FCAW • Welders

Model	Part #	Page	Flux- Cored	MIG	Input Voltage	Rated Amps	Rated Cycle Duty	Maximum Thickness
Fabricator 140	W1002500	5	Yes	Yes	120V	90 Amps	20%	3/16''
Fabricator 180	W1002600	6	Yes	Yes	230V	130 Amps	25%	5/16''
Fabricator 190	W1001500	7	Yes	Yes	230V	190 Amps	15%	5/16''
Fabricator 210	100047B-001	8	Yes	Yes	230V	210 Amps	40%	1/2''
Fabricator 251	100047D-002	9	Yes	Yes	230V	250 Amps	60%	5/8''
Fabricator 281	W1001600	10	Yes	Yes	230V	300 Amps	40%	5/8''
FP95	1444-0322	11	Yes	No	120V	80 Amps	15%	3/16''
FP125	1444-0324	12	Yes	Yes	120V	88 Amps	20%	1/4''
FP135	1444-0326	13	Yes	Yes	120V	90 Amps	40%	1/4''
FP165	1444-0328	14	Yes	Yes	230V	130 Amps	20%	3/8''
FP260	1444-0312	15	Yes	Yes	230V	200 amps	60%	5/8''

#### TIG • Arc/Stick • GTAW • SMAW • Welders

Model	Part #	Page	AC	DC	Input Voltage	Rated Amps	Rated Cycle Duty	Maximum Thickness
95S	W1003202	23	No	Yes	120V	90 Amps	20%	1/4''
95S	W1003203	24	No	Yes	120V	90 Amps	20%	1/4''
ArcMaster 160S	10-3066	25	No	Yes	120/208-230V	85 Amps	100%	1/4''
ArcMaster 185 AC/DC	10-3073	26	Yes	Yes	208-230V	185 Amps	30%	3/16''
ArcMaster 200 AC/DC	10-3083	27	Yes	Yes	208-230V	200 Amps	20%	3/16''
ArcMaster 300 AC/DC	10-3074	28	Yes	Yes	208-230V	300 Amps	25%	3/8''
FP100	1443-0402	29	Yes	No	120V	65 Amps	15%	3/16''
FP235	1444-0404	30	Yes	No	230V	200 Amps	20%	1/2''
FP235 AC/DC	1444-0406	31	Yes	Yes	230V	200 Amps	20%	1/2''

#### **Plasma Systems**

Model	Part #	Page	Weight	Requires	Input	Rated	Rated	Maximum
				Shop Air	Voltage	Amps	<b>Cycle Duty</b>	Thickness
AirCut 15C	1-1110-1	34	29 lbs.	No	120V	15 Amps	35%	3/16''
CutMaster 39	1-3830	35	39 lbs.	Yes	120-230V	30 Amps	35%	5/8''
CutMaster 52	1-5130-1	36	43 lbs.	Yes	208-230V	60 Amps	40%	1-1/8''
CutMaster 82	1-1130-1	37	43 lbs.	Yes	208-230V	80 Amps	40%	1-1/2''
CutSkill C-20A	1-1625	38	44 lbs.	Yes	120-230V	20 Amps	30%	3/8''
CutSkill C-35A	1-1635-1	39	44 lbs.	Yes	230V	35 Amps	35%	1/2''
Cutskill C-70A	1-1670-1	40	66 lbs.	Yes	230V	70 Amps	35%	1''



#### **Fabricator® 140: W1002500**

Machine Specifica	tions	
Maximum output		140 Amp
Duty cycle @ 104°F		20% @ 90 Amp at 18.5V
Current range		30-140 Amp
Number of voltage set	tings	4
Welding voltage range		16.3-20 Volt
Maximum plate thickness		3/16" (4.8mm)
Wire diameter range Mild steel:		.023"035" (0.6 - 0.9mm)
Stainless steel:		.023"035" (0.6 - 0.9mm)
	Aluminum:	.030"035" (0.8 - 0.9mm)
Flux cored:		.030"045" (0.8 - 1.2mm)
Fitted feed roll suits M	IG wire	.023"030"/.035" (0.6 - 0.8 / 0.9mm)
Dimensions (HxWxD)		15.8"x8.9"x21.3" (400x255x540mm)
Weight		70 lb (31.8kg)



The new portable Fabricator 140 dual purpose wire welder delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard household outlet and delivers a high maximum output of 140 amps. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cord & plug, spool of flux cored wire and an operating manual. Fabricator 140's high output and duty cycle makes this a great all round package. Optional cart and aluminum welding spool gun is also available.

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair
- Sheet metal fabrication
- Auto body repairs

Primary Power	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6ft (1.8m)
Maximum input current @ 140 Amp	24 Amp
Rated kVA @ 190 Amps	2.8 kVA
Approvals	CSA
	IEC 60974-1 (CE)

Package Options	
<ul> <li>Fabricator™ 140 package</li> </ul>	W1002500
<ul> <li>Fabricator™ 140 package c/w Cart</li> </ul>	W1002501
• Fabricator™ 140 package c/w Spool Gun	W1002502
<ul> <li>Fabricator™ 140 package c/w Cart &amp; Spool Gun</li> </ul>	W1002503



#### **Fabricator® 180: W1002600**

Machine Specific	ations	
Maximum output		180 Amp
Duty cycle @ 104°F		25% @ 130 Amp at 20.5V
Current range		30-180 Amp
Number of voltage se	ttings	6
Welding voltage range		16-20.5 Volt
Maximum plate thickness		5/16" (7.9mm)
Wire diameter range Mild steel:		.023"035" (0.6 - 0.9mm)
Stainless steel:		.023"035" (0.6 - 0.9mm)
	Aluminum:	.030"035" (0.8 - 0.9mm)
Flux cored:		.030"045" (0.8 - 1.2mm)
Fitted feed roll suits N	1IG wire	.023"030"/.035" (0.6 - 0.8 / 0.9mm)
Dimensions (HxWxD)		15.8"x8.9"x21.3" (400x255x540mm)
Weight		81 lb (36.8kg)



The new portable Fabricator 180 dual purpose wire welder delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard 230 Volt outlet and delivers a high maximum output of 180 amps. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cord & plug, spool of flux cored wire and an operating manual. Fabricator 180's high output and duty cycle makes this a great all round package. Optional cart and aluminum welding spool gun is also available.

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair
- Sheet metal fabrication
- Auto body repairs

Primary Power	
Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	6ft (1.8m)
Maximum input current @ 140 Amp	21 Amp
Rated kVA @ 190 Amps	5 kVA
Approvals	CSA
	IEC 60974-1 (CE)

Package Options	
<ul> <li>Fabricator™ 180 package</li> </ul>	W1002600
<ul> <li>Fabricator<sup>™</sup> 180 package c/w Cart</li> </ul>	W1002601
• Fabricator™ 180 package c/w Spool Gun	W1002602
<ul> <li>Fabricator™ 180 package c/w Cart &amp; Spool Gun</li> </ul>	W1002603

Mild steel:

Aluminum:

Flux cored:

Stainless steel:

190 Amp

145 Amp at 22V

30-190 Amp

15.8-25 Volt

5/16" (7.9mm)

8

15% @ 190 Amp at 23.4V

.023" - .035" (0.6 - 0.9mm)

.023" - .035" (0.6 - 0.9mm)

.030" - .035" (0.8 - 0.9mm)

.030" - .045" (0.8 - 1.2mm)

.023" - .030"/.035" (0.6 - 0.8 / 0.9mm)

33"x16.3"x34.1" (838x414x866mm)

**Machine Specifications** 

Output @ 30% duty cycle @ 104°F

Number of voltage settings

Maximum plate thickness

Fitted feed roll suits MIG wire

Welding voltage range

Wire diameter range

Dimensions (HxWxD)

Maximum output

Current range

Duty cycle @ 104°F



## Fabricator 190: W1001500 The affordable workhorse

The Fabricator 190 is a 230 Volt integrated MIG machine with a high 190 Amp maximum output, 8 voltage steps, spot timer and industrial spool capacity of 33/44 lb. Supplied as standard with a wheel kit, cylinder rack, regulator and quality Tweco Weldskill gun. Fabricator 190's standard features plus its comprehensive setup chart makes this package ideal for car panel and sheetmetal fabrication up to 5/16" (7.9mm) plate.

- Auto body repairs
- Farm/Ranch
- Maintenance and repairs
- Hobbyist
- Sheet metal fabrication



Primary Power	
Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10ft (3m)
Maximum input current @ 140 Amp	34 Amp
Rated kVA @ 190 Amps	7.9 kVA
Approvals	CSA
	IEC 60974-1 (CE)

Supplied with



For more information visit: www.thermalarc.com



# Fabricator 210: 100047B-001 The essential sheetmetal companion

<b>Machine Specifications</b>	
Maximum output	250 Amp
Duty cycle @ 104°F	30% @ 250 Amp at 26.2V
Output @ 40% duty cycle @ 104°F	210 Amp at 25.3V
Output @ 60% duty cycle @ 104°F	176 Amp at 23.6V
Output @ 100% duty cycle @ 104°	°F 137 Amp at 21.0V
Current range	20-250 Amp
Number of voltage settings	16
Welding voltage range	15.2-26.2 Volt
Maximum plate thickness	1/2" (12.7mm)
Wire diameter range Mild steel:	.023"045" (0.6 - 1.2mm)
Stainless steel:	.023"045" (0.6 - 1.2mm)
Aluminum:	.030"045" (0.8 - 1.2mm)
Flux cored:	.030"045" (0.8 - 1.2mm)
Fitted feed roll suits MIG wire	.035"045" (0.9 - 1.2mm)
Dimensions (HxWxD)	32"x21"x36.8" (813x533x935mm)
Weight	200 lb (91kg)



The Fabricator 210 is a 208-230 Volt integrated MIG machine with a leading performance of 250 Amp maximum output @ 30% duty cycle, 16 voltage steps, spool gun ready and spot/stitch timers. Supplied as standard with a wheel kit, cylinder rack, regulator, comprehensive setup chart and quality Tweco® Weldskill gun. The Fabricator 210 is extremely versatile with an optimized low end performance for .023" (0.6mm) down to 20 Amps and a top end of 250 Amps to comfortably run .045" (1.2mm) wires. Fabricator 210 is the ideal choice for sheetmetal work, training schools and light fabrication up to 1/2" (12.7mm) plate.

#### Applications include:

- Auto body repairs
- Farm/Ranch
- Maintenance and repairs
- Hobbyist
- Vocational schools
- Technical schools
- Light fabrication
- · Aluminum welding with a spool gun

Primary Power	
Primary voltage	208/230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10ft (3m)
Maximum input current @ 140 Amp	54/49 Amp
Rated kVA @ 190 Amps	11.2 kVA
Approvals	CSA
	IEC 60974-1 (CE)

#### **Additional Features**

- Spool gun compatible
- · Easy spool gun fit-up, with no tools required
- · Spot, stitch and dwell timers
- Storage box for consumable parts, drive rolls, etc

For more information visit: www.thermalarc.com



#### **Machine Specifications** Maximum output 300 Amp Duty cycle @ 104°F 40% @ 300 Amp at 31.7V Output @ 60% duty cycle @ 104°F 250 Amp at 26.5V Output @ 100% duty cycle @ 104°F 195 Amp at 24V Current range 20-300 Amp Number of voltage settings 24 Welding voltage range 14.5-31.7 Volt Maximum plate thickness 5/8" (15.9mm) .023" - .045" (0.6 - 1.2mm) Wire diameter range Mild steel: .023" - .045" (0.6 - 1.2mm) Stainless steel: Aluminum: .030" - .045" (0.8 - 1.2mm) Flux cored: .030" - .045" (0.8 - 1.2mm) Fitted feed roll suits MIG wire .035" - .045" (0.9 - 1.2mm) Dimensions (HxWxD) 32"x27.2"x36.8" (813x691x935mm) Weight 227 lb (103kg)



# Fabricator 251: 100048D-002 The accomplished all-rounder

The Fabricator 251 is a 208-230 Volt integrated MIG machine with a best in class performance of 300 Amp maximum output @ 40% duty cycle (250 Amp @ 60%), 24 voltage steps, spool gun operation on demand, digital meters and spot/stitch timers. Supplied as standard with a wheel kit, dual cylinder rack, regulator, comprehensive setup chart and quality Tweco Weldskill gun. The Fabricator 251 is also extremely versatile with an optimized low end performance for .023" (0.6mm) down to 20 Amps and a top end of 300 Amps to comfortably run 1/16" (1.6mm) wires. Fabricator 251 is the ideal choice for sheetmetal work, training schools and light to medium fabrication up to 5/8" (15.9mm) plate.

#### Applications include:

- · Light to medium fabrication
- Farm/Ranch
- Maintenance and repairs
- Vocational schools
- Technical schools
- Sheet metal fabrication
- Aluminum welding with a spool gun

Primary Power	
Primary voltage	208/230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10ft (3m)
Maximum input current @ 140 Amp	68/62 Amp
Rated kVA @ 190 Amps	15 kVA
Approvals	CSA
	IEC 60974-1 (CE)

#### **Additional Features**

- · Spool gun compatible
- · Easy spool gun fit-up, with no tools required
- Spot, stitch and dwell timers
- Storage box for consumable parts, drive rolls, etc
- Digital meter

For more information visit: www.thermalarc.com



# Fabricator 281: 1001600 The versatile heavyweight all-rounder

<b>Machine Specifications</b>	
Maximum output	300 Amp
Duty cycle @ 104°F	40% @ 300 Amp at 31.7V
Output @ 60% duty cycle @ 10	04°F 250 Amp at 26.5V
Output @ 100% duty cycle @ 1	104°F 195 Amp at 24V
Current range	20-300 Amp
Number of voltage settings	24
Welding voltage range	14.5-31.7 Volt
Maximum plate thickness	5/8" (15.9mm)
Wire diameter range Mild st	teel: .023"045" (0.6 - 1.2mm)
Stainless st	teel: .023"045" (0.6 - 1.2mm)
Alumin	um: .030"045" (0.8 - 1.2mm)
Flux co	red: .030"045" (0.8 - 1.2mm)
Fitted feed roll suits MIG wire	.035"045" (0.9 - 1.2mm)
Dimensions (HxWxD)	32"x27.2"x36.8" (813x691x935mm)
Weight	249 lb (113kg)



The Fabricator 281 is identical to the popular Fabricator 251 in standard features and performance including best in class output of 300 Amp @ 40% duty cycle (250 Amp @ 60%). However, the 281 has a complete separate wirefeeder system with 26 feet of interconnecting cables from the power source. The wirefeeder conveniently fits on a pivot mount on top of the power source. The wirefeeder can simply be lifted off the pivot and carried up on top of equipment or machinery, 26 feet away. Additionally the spool gun connects to the wirefeeder allowing even further distance. The Fabricator 281 is the most versatile all round performer in the range.

#### Applications include:

- · Agricultural equipment manufacture and repair
- · Transport equipment manufacture and repair
- Farm/Ranch
- · General maintenance and repairs
- · Light to medium fabrication
- Aluminum welding with a spool gun

Primary Power	
Primary voltage	208/230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10ft (3m)
Maximum input current @ 140 Amp	68/62 Amp
Rated kVA @ 190 Amps	15 kVA
Approvals	CSA
	IEC 60974-1 (CE)

#### **Additional Features**

- Separate wirefeeder with 26ft (8m) interconnecting cables
- Spool gun compatible with automatic switching
- · Easy spool gun fit-up, with no tools required
- · Spot, stitch and dwell timers
- Storage box for consumable parts, drive rolls, etc
- · Digital meter

### For more information visit: www.thermalarc.com



#### **Available Spring 2009**

<b>Machine Specifications</b>	
Maximum output	90 Amp
Duty cycle @ 104°F	15% @ 80 Amp at 17.5V
Current range	20-90 Amp
Number of voltage settings	2
Maximum plate thickness	3/16" (4.8mm)
Wire diameter range	.030"035" (0.8 - 0.9mm)
Dimensions (HxWxD)	11"x7.75"x14.5" (340x195x370mm)
Weight	45 lb (20.6kg)



# FP95: 1444-0322 Flux Cored Welding System

The new portable FP 95 flux-cored wire welder delivers a basic yet effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system is designed to operate from a standard household outlet and delivers a maximum output of 90 amps output. Requiring no shielding gas its ideal for outside use. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cored & plug, spool of flux cored wire and an operating manual. Optional cart also available.

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs

Primary Power	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	4ft (1.2m)
Rated kVA @ 90 Amps	2.5 kVA
Approvals	CSA
	IEC 60974-1 (CE)



#### FP125: 1444-0324 MIG/Flux Cored Welding System

#### **Machine Specifications** Maximum output 110 Amp Duty cycle @ 104°F 20% @ 88 Amp at 18V Current range 20-125 Amp Number of voltage settings 4 Maximum plate thickness 1/4" (6mm) Wire diameter range .023" - .035" (0.6 - 0.9mm) Dimensions (HxWxD) 12.75"x9.75"x17.35"(375x250x440mm) Weight 51 lb (23.5kg)

#### **Available Spring 2009**

The FP125 dual-purpose MIG welder offers maximum versatility. The unit features quick-change internal polarity adjustment that makes changing from MIG (GMAW) to flux cored (FCAW) welding quick and easy. With a standard 115 volt household current, it is suitable to use for home projects, but its versatility and 20% duty cycle also makes it ideal for medium duty general repair work and light industrial applications.

#### Applications include:

- Maintenance and repairs
- Farm/Ranch
- Home DIY Hobbyist



<b>Primary Power</b>	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6ft (1.8m)
Rated kVA @ 90 Amps	2.8 kVA
Approvals	CSA
	IEC 60974-1 (CE)



#### **Available Spring 2009**

<b>Machine Specifications</b>	
Maximum output	135 Amp
Duty cycle @ 104°F	40% @ 90 Amp at 18V
Current range	20-135 Amp
Number of voltage settings	4
Maximum plate thickness	1/4" (6mm)
Wire diameter range	.023"035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75"x9.75"x17.35"(375x250x440mm)
Weight	56 lb (25.5kg)

# FP135: 1444-0326 MIG/Flux Cored Welding System

The new portable FP 135 dual purpose wire welder delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard household outlet and delivers a high maximum output of 135 amps. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cord & plug, spool of flux cored wire and an operating manual. FP 135's high output and duty cycle makes this a great all round package. Optional cart also available.

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- · General light duty fabrication & repair





**Available Spring 2009** 

#### FP165: 1444-0328 MIG/Flux Cored Welding System

<b>Machine Specifications</b>	
Maximum output	165 Amp
Duty cycle @ 104°F	20% @ 130 Amp at 30V
Current range	20-165 Amp
Number of voltage settings	4
Maximum plate thickness	3/8" (9mm)
Wire diameter range	.023"035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75"x9.75"x17.35"(375x250x440mm)
Weight	60 lb (27.3kg)

# delivers a very versatile and effective welding performance. With its simple operation and key set up chart even the novice can achieve high quality, professional results. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard 230 v outlet and delivers a high maximum output of 165 amps. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cord & plug, spool of flux cored wire and an operating manual. FP 135's high output. Optional

The new portable FP 165 dual purpose wire welder

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch

cart available.

- Maintenance and repairs
- · General light duty fabrication & repair



Primary Power	
Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	6ft (1.8m)
Rated kVA @ 90 Amps	2.8 kVA
Approvals	CSA
	IEC 60974-1 (CE)



#### FP260: 1444-0312 Welding System

<b>Machine Specifications</b>	
Maximum output	270 Amp
Duty cycle @ 104°F	60% @ 200 Amp at 30V
Current range	20-270 Amp
Number of voltage settings	7
Maximum plate thickness	1/2" (12.5mm)
Wire diameter range	.023"035" (0.6 - 0.9mm)
Dimensions (HxWxD)	12.75"x9.75"x17.35"(375x250x440mm)
Weight	60 lb (27.3kg)

The FP 260 dual purpose wire welder delivers a very versatile and effective welding performance. This system features a quick change internal polarity adjustment to change between MIG (GMAW) and flux cored (FCAW) welding. Designed to operate from a standard 230 v outlet and delivers a high maximum output of 270 amps. The ready to weld system comes complete with Tweco gun, return cable & clamp, input power cord & plug and an operating manual. This system offers industrial grade performance at an affordable price. A spool gun option for welding aluminum is also available.

#### Applications Include:

- Home DIY Hobbyist
- Farm / Ranch
- Maintenance and repairs
- General light duty fabrication & repair
- Light industrial



Primary Power	
Primary voltage	208/230 Volt
Supply plug	NEMA 6-50P
Lead cord length	10ft (3m)
Rated kVA @ 190 Amps	11.2 kVA
Approvals	CSA
	IEC 60974-1 (CE)



#### **Fabricator MIG Consumables**

#### **CONTACT TIPS**

CUNTACT	IIPS
Model	Description
Fabricator 1	40, 180, 190
11-23	.023" (0.6mm)
11-30	.030" (0.8mm)
11-35	.035" (0.9mm)
11-40	.040" (1.0mm)
11-45	.045" (1.2mm)
Fabricator 2	10
14-23	.023" (0.6mm)
14-30	.030" (0.8mm)
14-35	.035" (0.9mm)
14-40	.040" (1.0mm)
14-45	.045" (1.2mm)
Fabricator 2	51 and 281
14-23	.023" (0.6mm)
14-30	.030" (0.8mm)
14-35	.035" (0.9mm)
14-40	.040" (1.0mm)
14-45	.045" (1.2mm)

#### **NOZZLES**

Model	Description		
Fabricator 1	40, 180, 190		
21-37	3/8" (9.5mm)		
21-50	1/2" (12.7mm)		
21-62	5/8" (16mm)		
Fabricator 2	10		
22-37	3/8" (9.5mm)		
22-50	1/2" (12.7mm)		
22-62	5/8" (16mm)		
Fabricator 251 and 281			
24A-37SS	3/8" (9.5mm)		
24A-50	1/2" (12.7mm)		
24A-62	5/8" (16mm)		
24A-75	3/4" (19mm)		

#### **CONDUITS**

Model	Description
Fabricator 140	), 180, 190 and 210
42-23-15	.023", 15ft (7.6m)
42-3035-15	.030"035", 15ft (4.5m)
42-4045-15	.040"045", 15ft (4.5m)
Fabricator 251	l and 281
42-23-15	.023", 15ft (7.6m)
42-3035-15	.030"035", 15ft (4.5m)
44-3545-15	.035"045', 15ft (4.5m)
44N-3545-15	.035"-3/64", 15ft (4.5m)



Fabricator MIG gun Options:

MIG gun options	Fabricator 190	Fabricator 210	Fabricator 251 / 281
Tweco MINI-MIG gun	yes	yes	
Tweco Spray Master® 250	yes	yes	yes
Tweco Professional #2	yes	yes	
Tweco Professional #4			yes
Tweco Weldskill Spool Gun		yes	yes
Single Cylinder Rack		yes	yes



#### Tweco® MINI-MIG Gun

The 160 amp, air-cooled Tweco Mini MIG gun is ideal for light-duty, hobby-style do-it-yourself welding applications.

#### **Duty cycle rating**

• 60% duty cycle with CO2 gas at 160 Amps

#### **Benefits & features**

Reduces operator fatigue

· Light-duty hobby gun

Easy to use

Designed for do-it-yourself application

Out-of-the-box welding

• Fully assembled, ready to use MIG gun

Included features

- Air-cooled MIG gun
- Wire size capacity .030"-.035" (0,8mm 0,9mm)
- Gun lengths in 10-ft (3M) and 12-ft (4M)

#### Optional kits

• Kits for Miller® rear connection and Lincoln® rear connection

Part No. 35-10, 10-ft (3M) (Stock No. 1000-1131)

Part No. 35-12, 12-ft (4M) (Stock No. 1000-1132)

Part No. HB35M-10 (Stock No.1000-1101) MIG Hobby Kit for Miller rear connection

Part No. HB35L-10 (Stock No. 1000-1100) MIG Hobby Kit for Lincoln rear connection

#### Tweco® Spray Master® 250 MIG Gun

The 250 amp, air-cooled Tweco Spray Master is the coolest MIG gun for spray transfer welding applications.

#### **Duty cycle rating**

• 80% duty cycle with Argon mixed gas at 250 Amps

#### **Benefits & features**

Reduces operator fatigue

With its ergonomic handle design

Ease of installation and ease of use

With its simplified direct rear plug

Easy to repair and maintain

Improves welding productivity

- By using spray and pulse transfer welding with Argon mixed gases
- Reduces spatter build-up and thereby reduces spatter clean-up time

#### Out-of-the-box welding

• Fully assembled, ready to use MIG gun

#### Included features

- Air-cooled MIG gun
- Wire size capacity .030"-.045" (0,9mm 1,2mm)
- Gun lengths in 12-ft (4M) and 15-ft (5M)

Part No. MS212-3545 12-ft (4M) (Stock No. 1023-1101)

Part No. MS215-3545 15-ft (5M) (Stock No. 1023-1102)





#### Tweco® Professional's Choice #2 MIG Gun

The 200 amp, air-cooled Tweco #2 MIG gun is professional's choice for air-cooled 200 amp MIG welding application.

#### **Duty cycle rating**

• 60% duty cycle with CO2 gas at 200 Amps

#### **Benefits & features**

Most preferred gun style

Industry's most popular handle design

Ease of installation and ease of use

• With its simplified direct rear plug

Easy to repair and maintain

Out-of-the-box welding

· Fully assembled, ready to use MIG gun

Included features

- Air-cooled MIG gun
- Wire size capacity .030"-.035" (0,8mm 0,9mm)
- Gun lengths in 10-ft (3M), 12-ft (4M), and 15-ft (5M)

Part No. 210-3035, 10-ft (3M) (Stock No. 1020-1111)

Part No. 212-3035, 12-ft (4M) (Stock No. 1020-1112)



#### Tweco® Professional's Choice #4 MIG Gun

The 400 amp, air-cooled Tweco #4 MIG gun is the most popular professional's choice gun for air-cooled 400 amp MIG welding application.

#### **Duty cycle rating**

• 60% duty cycle with CO2 gas at 400 Amps

#### **Benefits & features**

Industry standard MIG gun

Industry's most popular MIG gun

Ease of installation and ease of use

With its enhanced direct rear plug

Easy to repair and maintain

- · Out-of-the-box welding
- · Fully assembled, ready to use MIG gun

Included features

- Air-cooled MIG gun
- Wire size capacity .030"-.045" (0,9mm 1,2mm)
- Gun lengths in 10-ft (3M), 12-ft (4M), and 15-ft (5M)

Part No. 410-3545, 10-ft (3M) (Stock No. 1040-1101)

Part No. 412-3545, 12-ft (4M) (Stock No. 1040-1102)

Part No. 415-3545, 15-ft (5M) (Stock No. 1040-1103)





#### Tweco® WeldSkill® Spool Gun

The 200 amp, air-cooled Spool gun is ideal for your aluminum & stainless steel, and other MIG welding applications.

#### **Duty cycle rating**

• 60% duty cycle with CO2 gas at 200 Amps

#### **Benefits & features**

Reduces operator fatigue

- With comfortable handle design
- With its lightweight design, weighing 2.8 lbs

Ease of installation and ease of use

Adjustable wire feed speed control

Improves welding productivity

Easy spool tension control

Easy to repair and maintain

Out-of-the-box welding

• Fully assembled, ready to use MIG spool gun

Included features

- Wire size capacity .023"-.035" (0,6mm 0,9mm)
- Gun assembly cable lengths in 25-ft (8M)

Part No. WSP225-3545K3 (Stock No. 1027-1381)



#### Firepower Semi-automatic Spool Gun

The 200 amp, Firepower semi-automatic Spool gun is designed to be used with FP 200 & FP 260 for your mild steel and other MIG welding applications.

#### **Duty cycle rating**

• 60% duty cycle with CO2 gas at 200 Amps

#### **Benefits & features**

Reduces operator fatigue

- Compact design maximizes operator control and reduces hand arm fatigue
   Ease of installation and ease of use
  - Gun mounted potentiometer enables easy adjustment of wire feed speed control
  - 20-ft quick connect cable system

Improves welding productivity

Easy spool tension control

Easy to repair and maintain

Out-of-the-box welding

• Fully assembled, ready to use MIG spool gun

Included features

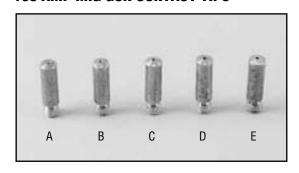
- Wire size capacity .023"-.035" (0,6mm 0,9mm)
- Gun assembly cable lengths in 20-ft (8M)

Part No. 1444-0408





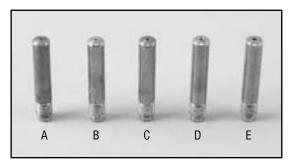
#### **180 AMP MIG GUN CONTACT TIPS**



#### **180 Amp MIG Gun Contact Tips**

Model	Part #	Description	
FP11-23	1444-0025	.023 wire, Tip ID .031 (10 pk)	
FP11-30	1444-0026	.030 wire, Tip ID .038 (10 pk)	
FP11-35	1444-0027	.035 wire, Tip ID .044 (10 pk)	
FP11-40	1444-0028	.040 wire, Tip ID .048 (10 pk)	
FP11-45	1444-0029	.045 wire, Tip ID .054 (10 pk)	
	FP11-23 FP11-30 FP11-35 FP11-40	FP11-23 1444-0025 FP11-30 1444-0026 FP11-35 1444-0027 FP11-40 1444-0028	

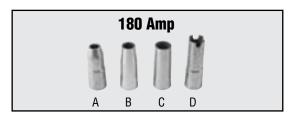
#### 250 & 400 AMP MIG GUN CONTACT TIPS



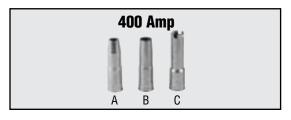
#### 250 & 400 Amp MIG Gun Contact Tips

		P	
	Model	Part #	Description
Α	FP14-23	1444-0220	.023 wire, Tip ID .031 (10 pk)
В	FP14-30	1444-0221	.030 wire, Tip ID .038 (10 pk)
С	FP14-35	1444-0222	.035 wire, Tip ID .044 (10 pk)
D	FP14-40	1444-0223	.040 wire, Tip ID .048 (10 pk)
Ε	FP14-45	1444-0224	.045 wire, Tip ID .054 (10 pk)

#### **MIG GUN NOZZLES**



25	O An	np	
A	B	C	



#### **Nozzles - 180 Amp Guns**

	Model	Part #	Description
Α	FP21-37	1444-0050	3/8" Bore (1pk)
В	FP21-50	1444-0051	1/2" Bore (1pk)
С	FP21-62	1444-0052	5/8" Bore (1pk)
D	FP21-62-FAS	1444-0053	5/8" Bore, Arc Spot (1pk)

#### **Nozzles - 250 Amp Guns**

	0	71111p ddiilo		
	Model	Part #	Description	
Α	FP22-50	1444-0140	1/2" Bore (1pk)	
В	FP22-62	1444-0141	5/8" Bore (1pk)	
С	FP22-62-FAS	1444-0142	5/8" Bore, Arc Spot (1pk)	

#### **Nozzles - 400 Amp Guns**

Mod	lel	Part #	Description
A FP2	4A-50	1444-0240	1/2" Bore (1pk)
B FP2	4A-62	1444-0241	5/8" Bore (1pk)
C FP2	4A-62-FAS	1444-0242	5/8" Bore, Arc Spot (1pk)



#### **MIG NOZZLE INSULATORS**



#### **MIG NOZZLE INSULATORS**

Model	Part #	Description
FP-32	1444-0075	Insulator for 250 amp gun (2 pk)
FP-34A	1444-0261	Insulator for 400 amp gun (2 pk)

#### **GAS DIFFUSERS**



#### **GAS DIFFUSERS**

Model	Part #	Description
FP-51	1444-0080	Diffuser for 180 amp gun (2 pk)
FP-52	1444-0165	Diffuser for 250 amp gun (2 pk)
FP-54A	1444-0265	Diffuser for 400 amp gun (2 pk)
FP-35-50	1444-0082	Male Thread diffuser for Tweco style gun
FP-35	1444-0489	Female Thread diffuser for Tweco style gun

#### **WELDING SYSTEM REPLACEMENT MIG GUNS**



#### **REPLACEMENT MIG GUNS**

Model	Part #	Description
FP 300	1444-0406	MIG Gun Fits FP 200, FP 260 Welders Euro Connect Maximum Output Amps 230/270
FP 200	1444-0413	MIG Gun (Helvi) Fits FP 120, FP 130, FP 160 Welders Maximum Output Amps 120/155 Requires adaptor
	1444-0417	Adaptor for use with Model 1444-0413. Adaptor is required only when replacing a Tweco® Style Mig gun with a Helvi gun

# Tweco.

#### **Welding Carts**

#### **Benefits & features**

Rugged and durable

MIG Welding cart holds welding machine on top tray and a single cylinder rack in the bottom tray and the gas bottle can be securely tied down with chains

Part No. 1444-0407 MIG Welding Cart for FP120, FP130, FP160, FP260



**Welding Cart** 

#### FirePower Air-Carbon Arc Gouging Torch

The FirePower Arc Gouging Torch is the perfect tool for metal removal applications on the farm, in metal shops and much more. The arc gouging process melts the metal with an electric arc and then blows it away with ordinary compressed air in a single pass!

#### **Benefits & features**

Reduces operator fatigue

- Natural 15° torch angle and 360° swivel cable provide comfort and operator ease
- Torch weight is only 3.6 lbs (1.6 kg)

#### Applications

- · Bead removal on welded joints
- Back gouging, edge preparation
- Defect repair

#### Included features

- Length: 7-ft
- Rugged construction for the harsh environment

#### Operating parameters

- Carbon specs: 1/8" (3,2 mm) to 1/4" (6.5mm) round carbon electrodes and is rated up to 450 amps
- Operates with compressed air from 40 PSI (2.8 kg/cm2) to 60 PSI (4.2 kg/cm2)
- Requires a minimum of a 300 amp 3 Phase, arc welding machine. AC or DC; DC preferred

Part No. 1443-0042



#### Fabricator 140 & 180 Accessories:



#### Small Cart with Running Gear/ Cylinder Rack

Sturdy construction. For gas cylinders no larger than 7" (178mm) diameter, maximum weight 75 lb (34 kg).

Part No. W4011500



#### 180 Amp Spool Gun (19 ft)

Spool gun assembly with 19 ft cable, 180 Amp @ 30%. No interface kit required, just plug and play.

Part No. W4011100



#### **Available Spring 2009**

Machine Specifications		
Input voltage	115 VAC 1 Phase 50/60Hz	
Rated output	Stick 90 Amp / 23.6V @ 20%	
	TIG 95 Amp / 13.8V @ 20%	
Nominal OCV	60 Volt	
SMAW Electrode Range	1/16" – 3/32"	
GTAW DC Tungsten Range	.040" - 3/32"	
Dimensions (HxWxD)	13"x5.1"x9.0" (330x130x230mm)	
Weight	9.7 lb (4.4kg)	



Above: 95S Stick (SMAW) package option - part no. W1003202

#### 95S Inverter: W1003202 Stick/Lift TIG Welding System

The Thermal Arc 95 S Inverter is a versatile multiprocess machine with stick and lift TIG capability. With up to 95 amps of welding power it delivers excellent performance on a wide variety of materials. In DC Lift TIG mode the 95 S provides 95 amps of welding power suitable for a wide range of materials from Chrome-Moly and steel tubing to general fabrication of mild and stainless steels. Delivering a superior smooth and stable arc performance down to 5 amps for the thinnest of materials. Extremely lightweight and portable yet designed to handle the toughest jobs.

#### Applications include:

- Maintenance and repairs
- Sheet metal fabrication
- Farm/Ranch
- · Auto body repair
- Home DIY Hobbyist

<b>Primary Power</b>	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6ft (1.8m)
Maximum input current @ 140 Amp	24 Amp
Rated kVA @ 190 Amps	2.8 kVA
Approvals	IEC 60974-1 (CE)

Package Options	
95S Stick (SMAW) package	W1003202
• 95S TIG (GTAW) package	W1003203



#### 95S Inverter: W1003203 Stick/Lift TIG Welding System

Machine Specifications		
Input voltage	115 VAC 1 Phase 50/60Hz	
Rated output	Stick 90 Amp / 23.6V @ 20%	
·	TIG 95 Amp / 13.8V @ 20%	
Nominal OCV	60 Volt	
SMAW Electrode Range	1/16" – 3/32"	
GTAW DC Tungsten Range	.040" - 3/32"	
Dimensions (HxWxD)	13"x5.1"x9.0" (330x130x230mm)	
Weight	9.7 lb (4.4kg)	



Above: 95S TIG (GTAW) package option - part no. W1003203

#### **Available Spring 2009**

The Thermal Arc 95 S Inverter is a versatile multiprocess machine with stick and lift TIG capability. With up to 95 amps of welding power it delivers excellent performance on a wide variety of materials. In DC Lift TIG mode the 95 S provides 95 amps of welding power suitable for a wide range of materials from Chrome-Moly and steel tubing to general fabrication of mild and stainless steels. Delivering a superior smooth and stable arc performance down to 5 amps for the thinnest of materials. Extremely lightweight and portable yet designed to handle the toughest jobs.

#### Applications include:

- Maintenance and repairs
- Sheet metal fabrication
- Farm/Ranch
- Auto body repair
- Home DIY Hobbyist

Primary Power	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6ft (1.8m)
Maximum input current @ 140 Amp	24 Amp
Rated kVA @ 190 Amps	2.8 kVA
Approvals	IEC 60974-1 (CE)

Package Options	
95S Stick (SMAW) package	W1003202
• 95S TIG (GTAW) package	W1003203



# ArcMaster 160S Inverter Stick/Lift TIG Welding System: 10-3066 Tough, compact and portable

<b>Machine Specifications</b>	
Input Voltage	115/230 VAC 1 Phase
Input Frequency	50 / 60 Hz
Output range	5 – 85 amps (115V)
	5 - 160 amps (230V)
Rated Output @ Duty Cycle	85A @ 23V 100% Duty Cycle (115V)
	160A @ 26V 35% Duty Cycle (230V)
Max OCV	65
Consumable Size	3/32" - 1/8" STICK electrode
Dimensions (HxWxD)	10.2"x5.1"x12.6" (260x130x320mm)
Weight	17.6 lbs. (8 kg)

The Thermal Arc ArcMaster 160 S is a multi voltage; full digital control, DC, Stick/Lift TIG inverter power supply. Standard features include: lift TIG start, VRD, adjustable hot start, arc force control and cellulose E6010 compatibility. This is the ultimate compact, highly portable unit designed for Stick and lift TIG welding processes.

#### Features:

- High 160 Amp output
- E6010 Stick (Cellulose) compatible
- Arc force control
- Programmable hot start
- Smart Logic<sup>®</sup> and Easy Link multi-voltage 115, 208-230 Vac, single phase
- Embedded microprocessor with digital controls
- Intelligent heat sensing fan operating on demand
- Standards compliant integrated voltage reducing device (VRD)
- · Intelligent self diagnostic
- Light weight, compact and portable



#### **Package Options**

• 160S w/ stick kit & case 10-3066 A-1

• 160S w/ stick kit, TIG Kit w/valve & case 10-3066 A-2

 160S w/ stick kit, TIG Kit TIG Kit w/valve, Argon regulator & foot control

10-3066 A-3

 160S w/ TIG torch with valve & built-in amperage control, work clamp & cable Argon regulator & case

10-3066 A-4

For more information visit: www.thermalarc.com



# ArcMaster 185 AC/DC Inverter TIG Welding System: 10-3073 Compact and portable

<b>Machine Specifications</b>	
Input Voltage	208/230 VAC, 1 Phase
Input Frequency	50/60 Hz
Output range	5-185 amps DC mode TIG
	10-185 amp AC mode TIG (60Hz cleaning 50%)
	5-160 amp DC mode STICK
	10-160 amp AC mode STICK
Rated Output @ Duty Cycle	185A/17.4V @ 30% TIG
	160A/27V @ 40% STICK
Max OCV	65
SMAW Electrode Range	3/32" - 5/32"
GTAW DC Tungsten Range	.040" - 5/32"
Dimensions (HxWxD)	14.2" x 7.1" x 16.5" (360 x 180 x 420mm)
Weight	37.5 lb (17 kg)



The Thermal Arc ArcMaster 185 AC/DC is a multi voltage, full digital control, AC/DC, Stick/ Lift TIG/ HF TIG inverter power supply. Standard features include: High frequency start, lift TIG start, up/ down slope, pulse, repeat (latch) function, spot timer, job Save & Load, VRD and cellulose E6010 compatibility. This is the ultimate unit designed for precision TIG and Stick welding of all weldable materials. Superior, true square wave output combines with highly developed balance and cleaning features to deliver an unbeatable welding performance with extended tungsten life on aluminum and magnesium alloys without the need for continuous high frequency.

#### Features:

- Fully featured with outstanding TIG welding performance
- E6010 Stick (Cellulose) compatible
- · Rapid Pulse output
- Job Save & Load
- Smart Logic<sup>®</sup> and Easy Link multi voltage 208/230 VAC, single phase
- Embedded microprocessor with digital controls
- Intelligent heat sensing fan operating on demand
- Standards compliant integrated voltage reducing device (VRD)
- · Intelligent self diagnostic
- · Compact and portable

#### **Package Options**

- 185 ACDC w/ air cooled 150 Amp TIG torch & accessory kit, work clamp, stick electrode holder, Argon regulator, gas hose & foot control
   10-3073A-1
- 185 ACDC w/ air cooled 150 Amp TIG torch with built-in on/off switch, work clamp, Argon regulator,
   10-3073A-2

For more information visit: www.thermalarc.com



## ArcMaster 200 AC/DC Inverter TIG Welding System: 10-3083 Portable with maximum flexibility

Input Voltage	208/230/460 VAC, 1 & 3 Phase
Input Frequency	50/60 Hz
Output range	5-200 amp DC mode TIG
	10-200 amp AC mode TIG (60Hz cleaning 50%)
	5-160 amp DC mode STICK
	10-160 amp AC mode STICK
Rated Output @ Duty Cycle	200A/18V @ 20% TIG
	160A/26V @ 40% STICK
Max OCV	65
SMAW Electrode Range	3/32" - 5/32"
GTAW DC Tungsten Range	.040" - 5/32"
Dimensions (HxWxD)	14.2" x 7.1" x 16.5" (360 x 180 x 420mm)
Weight	37.5 lb (17 kg)



The Thermal Arc ArcMaster 200 AC/DC is the same full digital control, AC/DC, Stick/ Lift TIG/ HF TIG inverter power supply as the 200 AC/DC with a higher output and expanded input voltage capabilities for maximum user flexibility. Standard features include: High frequency start, lift TIG start, up/ down slope, pulse, repeat (latch) function, spot timer, job Save & Load, VRD and cellulose E6010 compatibility. This is the ultimate unit designed for precision TIG and Stick welding of all weldable materials. Superior, true square wave output combines with highly developed balance and cleaning features to deliver an unbeatable welding performance with extended tungsten life on aluminum and magnesium alloys without the need for continuous high frequency.

#### Features:

- Fully featured with outstanding TIG welding performance
- E6010 Stick (Cellulose) compatible
- · Rapid Pulse output
- Job Save & Load
- Smart Logic<sup>®</sup> and Easy Link multi voltage 208/230/460 VAC, single and three phase.
- Embedded microprocessor with digital controls
- Intelligent heat sensing fan operating on demand
- Standards compliant integrated voltage reducing device (VRD)
- · Intelligent self diagnostic
- · Compact and portable

#### **Package Options**

- 200 ACDC w/ air cooled 200 Amp TIG torch & accessory kit, work clamp, stick electrode holder, Argon regulator, gas hose & foot control
   10-3083 A1
- 200 ACDC w/ air cooled 200 Amp TIG torch with built-in on/off switch, work clamp, Argon regulator,
   10-3083 A2

For more information visit: www.thermalarc.com



# ArcMaster 300 AC/DC Inverter TIG Welding System: 10-3074 Powerful and portable with maximum flexibility

<b>Machine Specifications</b>	
Input Voltage	208/230/460 VAC, 1 & 3 Phase
Input Frequency	50/60 Hz
Output range	5-300 amp DC mode 5-300 amp AC mode TIG (60Hz cleaning 50%)
Rated Output @ Duty Cycle	300A/32V @ 25% (1/3 Phase) 250A/30V @ 40% (1/3 Phase)
Max OCV	65
SMAW Electrode Range	3/32" - 5/32
GTAW DC Tungsten Range	.040" - 5/32"
GMAW Wire Dia. Range^	.023"045"
CAG Electrode Range	1/8" – 3/16"
Dimensions (HxWxD)	16.5" x 8.3" x 17.7" (420 x 210 x 450mm)
Weight	53 lb (24 kg)
Dimensions (HxWxD)	16.5" x 8.3" x 17.7" (420 x 210 x 450mm)

<sup>^</sup>Requires Portafeed VS 212 in CC mode.



The Thermal Arc ArcMaster 300 AC/DC is the top end high out put, multi voltage, full digital control, AC/DC, Stick/Lift TIG/ HF TIG inverter power supply. Standard features include: High frequency start, lift TIG start, up/ down slope, pulse, repeat (latch) function, spot timer, job Save & Load, VRD and cellulose E6010 compatibility. This is the ultimate unit designed for precision TIG and Stick welding of all weldable materials. Superior, true square wave output combines with highly developed balance and cleaning features to deliver an unbeatable welding performance with extended tungsten life on aluminum and magnesium alloys without the need for continuous high frequency.

#### Features

- Fully featured with outstanding TIG welding performance
- E6010 Stick (Cellulose) compatible
- · Rapid Pulse output
- Job Save & Load
- Smart Logic® and Easy Link multi voltage 208/230/460 VAC, single and three phase
- Embedded microprocessor with digital controls
- Intelligent heat sensing fan operating on demand
- Standards compliant integrated voltage reducing device (VRD)
- Intelligent self diagnostic
- · Compact and portable

#### **Package Options**

300 ACDC w/ air cooled 200 Amp TIG torch & accessory kit, work clamp, stick electrode holder, Argon regulator, gas hose & foot control
 10-3074 A1

For more information visit: www.thermalarc.com



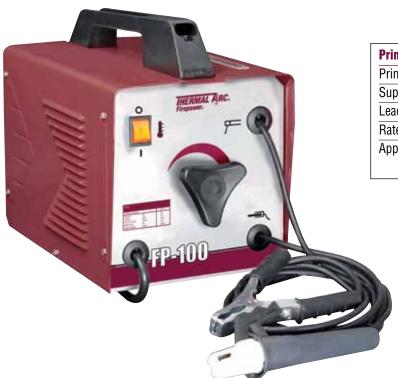
#### FP100: 1443-0402 Welding System

Machine Specifications		
Output range	5 – 85 amps (120V)	
Rated Output @ Duty Cycle	65A @ 15% Duty Cycle (120V)	
Max OCV	65	
Consumable Size	1/16" to 3/32" STICK electrode	
Dimensions (HxWxD)	11-1/2" x 9" x 13-1/4" (290x225x338mm)	
Weight	27 lbs. (12 kg)	

Enjoy the convenience of arc welding repairs at an affordable price. The FP100 operates on standard 120 volt household current and is designed to be simple to operate. The FP100 portable arc welding system features AC welding output as well as infinite amperage control making it easy for even novice welders to obtain professional results. The rugged easy grip handle and its light weight make this unit both practical and portable. The FP100 is ideal for home, farm and light maintenance repairs.

#### Applications include:

- Home DIY hobbyist
- Farm/ranch
- Maintenance & repairs
- General fabrication



Primary Power	
Primary voltage	120 Volt
Supply plug	NEMA 5-15P
Lead cord length	6ft (1.8m)
Rated kVA @ 85 Amps	2.5 kVA
Approvals	CSA
	IEC 60974-1 (CE)



#### FP235: 1443-0404 Welding System

<b>Machine Specifications</b>	
Output range	20 – 235 amps (230V)
Rated Output @ Duty Cycle	200A @ 20% Duty Cycle
Max OCV	65
Consumable Size	1/16" to 5/32" STICK electrode
Dimensions (HxWxD)	23" x 17-1/2" x 14" (597x441x360mm)
Weight	17.6 lbs. (8 kg)



The FP235 offers powerful 235 Amp AC (SMAW) welding performance at an affordable price. The FP235 features infinite amperage adjustment, which provides precise welding control. This versatile unit is ideal for both light and heavy-duty repairs. The FP235's rugged design delivers the reliability and performance to make it an ideal unit for general fabrication as well as farm, ranch, automotive and light maintenance repairs.

#### Applications include:

- Home DIY hobbyist
- Farm/ranch
- Maintenance & repairs
- General fabrication

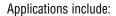
Primary Power			
Primary voltage	230 Volt		
Supply plug	NEMA 6-50P		
Lead cord length	6ft (1.8m)		
Approvals	CSA		
	IEC 60974-1 (CE)		



#### FP235 AC/DC: 1443-0406 Welding System

20 – 235 amps (230V)	
200A @ 20% AC Duty Cycle 135A @ 20% DC Duty Cycle	
65	
1/16" to 5/32" STICK electrode	
23" x 17-1/2" x 14" (597x441x360mm)	
113 lbs. (51 kg)	

The FP235 AC/DC provides powerful 235 Amp AC/185 Amp DC Arc (SMAW) welding performance at an affordable price. DC output produces better visual welds, with more control and less splatter. Its the preferred method for overhead out of position welding. The FP235 features infinite amperage adjustment, which provides precise welding control. This versatile unit is ideal for both light and heavyduty repairs. The FP235's rugged, portable design delivers the reliability and performance to make it an ideal unit for general fabrication as well as farm, ranch, automotive and light maintenance repairs.



- Home DIY hobbyist
- Farm/ranch
- Maintenance & repairs
- · General fabrication



Primary Power	
Primary voltage	230 Volt
Supply plug	NEMA 6-50P
Lead cord length	6ft (1.8m)
Rated kVA @ XX Amps	XX kVA
Approvals	CSA
	IEC 60974-1 (CE)

# Tweco

#### FirePower Electrode Holder

The industry standard for your stick electrode welding applications with 200 amp capacity.

#### **Benefits & features**

Long lasting

- Heavy duty, shock-proof nylon handle
- Ball point cable connection

Ease of use and ease of installation

Reversible top and bottom insulators

Included features

- 6-position jaw pattern to hold welding electrode in place
- Fully insulated
- Supplied with an Allen wrench and cable connection ferrule assuring efficient connection and minimizing cable strand breakage at the connection

Part No. 1443-0015



Provides a unique style, with Tweco-style head provides the gripping force to hold the stick electrode in place. It has 400 amp capacity for heavy duty welding applications.

#### **Benefits & features**

Long lasting

- Rugged and reliable design
- Ball point cable connection

Ease of use and ease of installation

Included features

- Fully insulated
- Supplied with an Allen wrench and cable connection ferrule assuring efficient connection and minimizing cable strand breakage at the connection

Part No. WHT-400 (Stock No. 9120-1010)



#### **Cable Connectors**

Part No.	Stock #	Description	Cable Capacity	Standard Package
1-WPC	9425-1125	Complete Set of Connectors	4, 2, 1	1
2-WPC	9425-1225	Complete Set of Connectors	1/0, 2/0, 3/0	1





#### **Tweco Welding Ground Clamps – Steel levers**

Comes in 300 amp and 500 amp capacities. These can be used in stick welding, submerged arc welding, gas metal arc welding, gas tungsten arc welding applications for light and medium duty metal fabrication.

#### **Benefits & features**

Long lasting

- · Heavy duty spring
- Ball point screw to secure the welding cable to the ground clamp

Ease of use and ease of installation with large jaw opening of 2" with jaw opening depth of 1-3/4" Included features

- Steel upper and lower levers
- Heavy duty spring providing clamping force to the work surface
- Connector body with ball point screw
- · Overall length 9"
- Cable connection capacity of 1/2" stud connection

Part No. SGC-300 (Stock No. 9205-1230) - 300 amp capacity Part No. SGC-500 (Stock No. 9205-1250) - 500-amp capacity

#### **Tweco Welding Ground Clamps - Copper**

Comes in 200 amp and 300 amp capacities. These can be used in stick welding, submerged arc welding, gas metal arc welding, gas tungsten arc welding applications for light and medium duty metal fabrication.

#### **Benefits & features**

Long lasting

- Rugged and reliable in design
- Ball point screw to secure the welding cable to the ground clamp

Ease of use and ease of installation with large jaw opening of depth of 3" (200 amp) and 4" (300 amp) Included features

- Copper cast upper and lower jaws
- Heavy duty spring providing clamping force to the work surface
- Overall length 6" (200 amp) and 8-1/2" (300 amp)

Part No. GC-200 (Stock No. 9205-1120) – 200 amp capacity Part No. GC-300 (Stock No. 9205-1130) – 300 amp capacity

#### **Tweco Switchable Magnetic Ground Clamps**

Can be used as a ground clamp device around pipe and flat applications, or with any large magnetic base metal. It is used to lay the ground clamp magnetically attached to the metal being welded, thus providing the electrical ground.

#### **Benefits & features**

Long lasting - rugged and reliable in design

Very easy to use and easy to install

- Get a very secure grip by turning the knob and release the grip by turning it back
- These are switchable, meaning that the ground clamp can easily be removed by turning "off" the magnetic function thereby releasing the ground clamp from the base metal structure

Included features

• 200 amp and 300 amp capacities

Part No. SMGC-200 (Stock No. 9255-1060) – 200 amp capacity Part No. SMGC300 (Stock No. 9255-1061) – 300 amp capacity



#### AirCut™ 15C 1-1110-1

Portable Plasma Cutting System with Built-In Air Compressor

Internal Air Compressor. This unit comes standard with a built-in air compressor. Lightweight. Weighs only 29 lbs. (13.2kg), almost 50% lighter than the

competition.

Superior Cutting Capacity. 1/8" (3mm) Recommended Cut,

3/16" (5mm) maximum capability.

Easy to Use. 120V, 15 Amp plug standard. Plug it in anywhere! Faster Cut Speeds. 25% more cutting power provides 25% faster

cut speeds than the competition.

**Specifications** 

**Cut Capacity:** 1/8" (3mm) Recommended Cut

**Output Current:** 15 Amps Fixed

**Input Power:** 120V (± 10%), Single Phase,

60Hz., leff: 12 Amps

**Duty Cycle:** 35% @ 15A

**Dimensions:** Length 18" (457mm)

> Width 6.5" (165mm) Height 9.5" (241mm)

29 lbs. (13.2 kg)

Weight: **Ship Weight:** 38 lbs. (17.2 kg)

(includes Unit, Power Cable, Torch and Leads)

**Work Cable:** 19.5 ft. (5.9m) **Input Cable:** 8.5 ft. (2.6m)

**Gas Type:** Air from Built-In Air Compressor

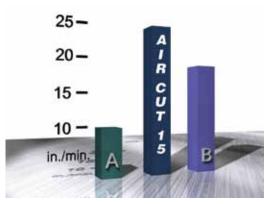
**Pilot:** CD Start

**Control:** Hand Torch Switch

Torch: PCH-10

**Torch** 

**Configuration:** Hand 70°, 20' (6.1m) Leads



**Cut Speed Comparison** 1/8" (3mm)



# **CUTMASTER 39** 1-3830

The CUTMASTER 39 provides the same reliability and performance you have come to expect from the CUTMASTER Series. This 30 Amp unit produces quality cuts from gauge all the way up to maximum cut of 5/8" (15mm). Unlike some of its competition, the CUTMASTER 39 also offers features like auto pilot restart, ATC® torch quick disconnect, and automatic voltage selection.

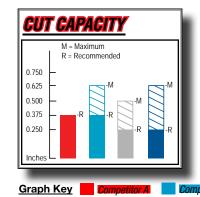
The CUTMASTER 39 is the most durable 1/4" (6mm) plasma cutting machine on the market today. It is the only system in its class to offer the protection of TRUE GUARD<sup>TM</sup>.

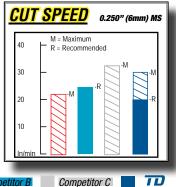
#### Applications include:

- Auto body/marine repair
- Plumbing & HVAC
- Home Shop
- Metal Building & Roofing Construction
- Rental Fleets

Max Amperage Output - (Amps)	30
Output Power - (Kw)	2.8
Recommended Cut - Inches (mm)	0.250 (6)
Max Cut - Inches (mm)	0.625 (15)
Pierce Rating - Inches (mm)	0.250 (6)
Input Voltage - (Volts, Phase, Hz)	120-230V, 1, 50/60
Duty Cycle (@40°C)	35%@ 30A, 60%@ 22A
Amperage Draw	29 (120V, 1 ph) 14 (230V, 1 ph)
Dimensions (H x W x L) Inches (mm)	15 x 12 x 24 (381 x 305 x 610)
Weight - Ibs. (kg)	39 (17.7)
Torch Model	SL60
Air Pressure - psi (bar)	65 (4.5)
Flow - Cfm (I/m)	5 (141)
Warranty (Unit/Torch) Parts and Labor	4/1









# **CUTMASTER 52** 1-5130-1

The CUTMASTER 52 is the most powerful and lightest weight 1/2" (12mm) machine on the market today. The CUTMASTER TRUE Series are the only systems that offer the precision of the TRUE Cut Drag Tip Series™. The 60 Amp tip allows the system to drag cut up to 1/4" (6mm) with ease. Giving the absolute best cut quality possible.

This unit cuts through mild, stainless, or aluminum up to 1 1/8" (30mm) thick. The CUTMASTER 52 combines power with the well known performance and features of the industry-leading 1Torch®.

Applications include:

- Construction
- Maintenance/Repair
- Fabrication



UT CAPACITY	CUT SPEED 0.50" (12mm) MS
I.25 M = Maximum R = RecommendedM	M = Maximum 40
1.00	M 40 M
75 - M - M - M	30 -
R   S   S   S	20 – R
50 -R -R -R	-R
25 _	10 — R
nches L	
Indies —	In/Min L

Max Amperage Output - (Amps)	60	
Output Power - (Kw)	6.2	
Recommended Cut - Inches (mm)	0.500 (12)	
Max Cut - Inches (mm)	1.125 (30)	
Pierce Rating - Inches (mm)	0.500 (12)	
Input Voltage - (Volts, Phase, Hz)	• 208/230 - 460 1/3 Phase 50/60Hz • 400V 3 Phase 50Hz • 600V 3 Phase 50/60Hz	
Duty Cycle (@40°C)	40%@ 60A, 60%@ 55A, 100%@ 50A	
Amperage Draw	45 (230V, 1 ph) 24 (230V, 3 ph) 16 (460V, 3 ph)	
Dimensions (H x W x L) Inches (mm)	15 x 12 x 24 (381 x 305 x 610)	
Weight - Ibs (kg)	43 (19.5)	
Torch Model	SL60 Hand SL100 Mechanized	
Air Pressure - psi (bar)	75 (5.2)	
Flow - Cfm (I/m)	6.7 (190)	
Warranty (Unit/Torch) Parts and Labor	4/1	



# **CUTMASTER 82** 1-1130-1

The CUTMASTER 82 weighs in at a mere 43 lbs. (19.5 kg) almost 50% less than its leading competitor, while still offering superior cutting power.

Don't let the size of this unit fool you, it's more than capable of cutting 3/4" (20mm) with a maximum capability of  $1\frac{1}{2}$ " (40mm). This unit, like all other TRUE CUTMASTERs, is equipped with the  $1\text{Torch}^{\otimes}$ .

#### Applications include:

- · Heavy Fabrication
- Manufacturing
- Contractors

Max Amperage Output - (Amps)	80
Output Power - (Kw)	9
Recommended Cut - Inches (mm)	0.750 (20)
Max Cut - Inches (mm)	1.500 (40)
Pierce Rating - Inches (mm)	0.625 (15)
Input Voltage - (Volts, Phase, Hz)	• 208/230 - 460 1/3 Phase 50/60Hz • 400V 3 Phase 50Hz • 600V 3 Phase 50/60Hz
Duty Cycle (@40°C)	40%@ 80A, 60%@ 65A 100%@ 55A
Amperage Draw	72 (230V, 1 ph) 39 (230V, 3 ph) 21 (460V, 3 ph)
Dimensions (H x W x L) Inches (mm)	15 x 12 x 24 (381 x 305 x 610)
Weight - Ibs (kg)	43 (19.5)
Torch Model	SL60 Hand SL100 Mech & Auto
Air Pressure - psi (bar)	70 (4.8)
Flow - Cfm (I/m)	6.7 (190)
Warranty (Unit/Torch) Parts and Labor	4/1



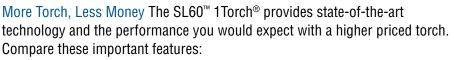




# **CUTSKILL C-20A** 1-1625

Fast, Easy Cuts on Most Metals. A favorite for HVAC installations, sheet metal fabrication, metal art, and home projects, this machine delivers clean cuts on most metals including stainless steel, aluminum, mild steel copper or brass, with minimum heat input & distortion of metal. It also cuts through rusted, painted or coated surfaces without prior surface preparation.

Portable and Powerful This inverter based power supply automatically links the unit to primary voltage from 115 to 230 Volts, single phase, 50 or 60 Hz, typically found in most homes and maintenance shops. Weighing just 44 lbs. (20 kg), the C-20A is easy to move from location to location. Connect to an air compressor, and this simple-to-use system is ready to cut.



- Precision-engineered consumable parts are easy to change and require no tools
- Easy-to-use torch trigger release and ergonomic handle provide comfort during long cutting sessions
- Latch feature allows the cutting arc to remain active without constantly depressing the torch switch
- Starts without high-frequency so it won't interfere with controls or computers
- Surelok® electrode eliminates tip wobble found in some blow-apart torch designs, resulting in a cleaner arc and longer parts life
- Protective interlock circuitry disables the power supply if torch consumable parts are incorrectly assembled
- Light-weight, flexible 20 ft. (6.1m) torch leads
- Full 1-year warranty on repair parts and labor

Cut Capacity	Input	Output	Duty Cycle	Panel Indicators	Dimensions	Weight
3/8" (10mm)	115V +/-10%, 1 ph, 50/60 Hz, 20A 230V +/-10%, 1 ph, 50/60 Hz, 14A	20A @ 115VAC 25A @ 230VAC	30% @ 20 Amps	AC, Over Temp, Air, Latch	H: 14.8" (375mm) W: 8.3" (210mm) L: 20.0" (510mm)	Net: 44 lbs. (20 kg) Ship: 53 lbs. (24 kg)

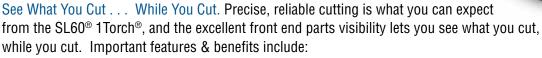
ntrols or computers
ow-apart torch designs,
torch consumable parts



# CUTSKILL C-35A 1-1635-1

Clean Cuts with Little or No Dross. Designed for the 1/2" (12mm) cutting market, this economical plasma cutter is a favorite for auto body repair, light duty maintenance, and sheet metal fabrication, and it is also very useful around the farm or ranch. It cuts quickly through stainless steel, aluminum, mild steel copper or brass, with minimum heat input & distortion of metal and it also cuts through rusted, painted or coated surfaces without prior surface preparation.

Portable and Powerful. This inverter-based system operates on standard 230 VAC single phase input power and provides adjustable current from 15 to 35 amps. Weighing just 44 lbs. (20 kg), this lightweight power source is easy to move from location to location. Simply connect to an air compressor or other air source and you are ready to cut.



- Precision-engineered consumable parts are easy to change and require no tools
- Easy-to-use torch trigger release and ergonomic handle provide comfort during long cutting sessions
- Two modes of operation available standoff cutting or drag cutting
- Light-weight, flexible 20 ft. (6.1m) torch leads
- Latch feature allows the cutting arc to remain active without constantly depressing the torch switch
- Starts without high-frequency so it won't interfere with controls or computers
- Surelok® electrode eliminates tip wobble found in some blow-apart torch designs, resulting in a cleaner arc and longer parts life
- Protective interlock circuitry disables the power supply if torch consumable parts are incorrectly assembled
- Full 1-year warranty on repair parts and labor

Cut Capacity	Input	Output	Duty Cycle	Panel Indicators	Dimensions	Weight
1/2" (12mm)	230V +/-10%, 1 ph, 50/60 Hz, 32A	15-35 Amps, Continuously Adjustable	35% @ 35 Amps	1 ' ' '	H: 14.8" (375mm) W: 8.3" (210mm) L: 20.0" (510mm)	Net: 44 lbs. (20 kg) Ship: 53 lbs. (24 kg)



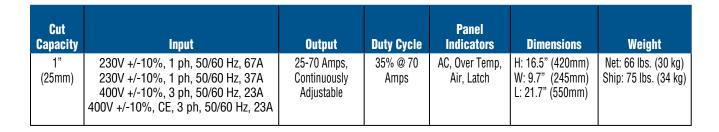
# CUTSKILL C-70A 1-1670-1

Great for Fabrication or Scrapping A favorite for use in heavy maintenance, fabrication and scrap metal, this machine delivers clean cuts on most 1" (25mm) metals including stainless steel, aluminum, mild steel, copper or brass, with minimum heat input & distortion of metal. It also cuts through rusted, painted or coated surfaces without prior surface preparation.

Reliable, Powerful Power Supply This inverter based power supply operates on standard 230 Volt, single or 3-phase power. (CE model only available at 3ph.) Simply connect to an air compressor or other air source, and this system is ready to cut. 1Torch® for Excellent Cutting Results

This state-of-the-art torch provides the level of performance and features you would expect from a more expensive torch. Compare these important features:

- Precision-engineered consumable parts are easy to change and require no tools.
- Easy-to-use torch trigger release and ergonomic handle provide comfort during long cutting sessions
- Two modes of operation available standoff cutting or drag cutting
- Latch feature allows the cutting arc to remain active without constantly depressing the torch switch
- Starts without high-frequency so it won't interfere with controls or computers
  - Protective interlock circuitry disables the power supply if torch consumable parts are incorrectly assembled
  - Surelok® electrode eliminates tip wobble found in some blow-apart torch designs, resulting in a cleaner arc and longer parts life
  - Light-weight, flexible 20 ft. (6.1m) torch leads
- Full 1-year warranty on repair parts and labor



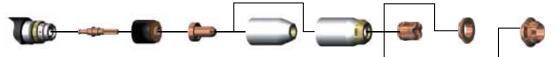




#### **AirCut™ 15C Parts and Accessories**

**Accessories** Part No. PCH-10 70° Torch / 20' (6.1m) Leads 2-1020 **Cutting Guide Kit** 7-8910 20 ft. (6.1m) Leather Leads Cover 9-1260 Shield Cup 9-6003 Tip 9-6099 Gas Distributor 9-6007 Electrode 9-6006

# Cutmaster 39 / 52 / 82 Parts and Accessories



Current Range	Mode Of Operation	Amps	Electrode	Start Cartridge	Tip	Shield Cup	Shield Cup Body	Drag Shield Cap	Deflector	Gouging Shield Cap
20-40 Amps	Drag Tip / Cutting	20A 30A 40A 20A 30A 40A	9-8215	9-8213	9-8205 9-8206 9-8207 9-8205 9-8206 9-8207	9-8218 9-8218 9-8218	9-8237 9-8237 9-8237		9-8243 9-8243 9-8243	
	Standoff Cutting	40A 40A			9-8208 9-8208	9-8218	9-8237		9-8243	9-8241
	Gouging	Tip A			9-8225		9-8237			
	Drag Tip Cutting	60A			9-8252	9-8218				
50-60	Standoff Cutting	50-55A 60A 50-55A 60A			9-8209 9-8210 9-8209 9-8210	9-8218 9-8218	9-8237 9-8237		9-8243 9-8243	
Amps	Drag Shield Cutting	50-55A 60A	9-8215	9-8213	9-8209 9-8210		9-8237 9-8237	9-8235 9-8235		
	Gouging	Tip B Tip C Tip D			9-8226 9-8227 9-8228		9-8237 9-8237 9-8237			9-8241 9-8241 9-8241
	Standoff Cutting	70A 80A 90A-100A 70A 80A 90A-100A	9-8215	9-8213	9-8231 9-8211 9-8212 9-8231 9-8211 9-8212	9-8218 9-8218 9-8218	9-8237 9-8237 9-8237		9-8243 9-8243 9-8243	
70-100 Amps	Drag Shield Cutting	70A 80A 90A-100A			9-8231 9-8211 9-8212		9-8237 9-8237 9-8237	9-8236 9-8236 9-8236		
	Gouging	Tip B Tip C Tip D			9-8226 9-8227 9-8228		9-8237 9-8237 9-8237			9-8241 9-8241 9-8241
120	Standoff Cutting	120A			9-8253		9-8237		9-8243	
Amps	Drag Shield Cutting	120A	9-8215	9-8213	9-8253		9-8237	9-8258	9-8243	
	Gouging	Tip E			9-8254		9-8237		9-8243	9-8241

Accessories



#### **Cutskill C-20A Parts and Accessories**

11000001100	
TORCH	
SL60, 20 ft. (6.1m) Leads	7-5200
Shield Cup	9-8218
Tip (pkg. of 5)	9-8206
Start Cartridge	9-8213
Electrode (pkg. of 5)	9-8215
0-Ring	8-3487
0-Ring	8-3486
Accessories	Part No.
Cutting Guide Kit	7-8910
Single Stage Air Filter	7-7507
20 ft. (6.1m) Leather Leads Cover	9-1260



Cutting Guide Kit Part No. 7-8910



Leather Leads Cover Part No. 9-1260

#### **Cutskill C-35A Parts and Accessories**

Accessories	Part No.
TORCH	
SL60, 20 ft. (6.1m) Leads	7-5200
Shield Cup	9-8218
Tip - 40A (pkg. of 5)	9-8207
Start Cartridge	9-8213
Electrode (pkg. of 5)	9-8215
O-Ring	8-3487
0-Ring	8-3486
Accessing	Dord No.
Accessories	Part No.
Cutting Guide Kit	7-7501
Single Stage Air Filter	7-7507
20 ft. (6.1m) Leather Leads Cover	9-1260
Standoff Guide	9-8251



Single Stage Air Filter

Part No. 7-7507

Standoff Guide Part No. 9-8251



Single Stage Air Filter Part No. 7-7507



Cutting Guide Kit Part No. 7-7501



Leather Leads Cover Part No. 9-1260

# **Cutskill C-70A Parts and Accessories**

Accessories	Part No.
TORCH	
SL100, 20 ft. (6.1m) Leads	7-5202
Shield Cup	9-8218
Tip - 70A (pkg. of 5)	9-8231
Start Cartridge	9-8213
Electrode (pkg. of 5)	9-8215
O-Ring	8-3487
0-Ring	8-3486
Accessories	Part No.
Cutting Guide Kit	7-7501
Single Stage Air Filter	7-7507
20 ft. (6.1m) Leather Leads Cover	9-1260
Standoff Guide	9-8281



Standoff Guide Part No. 9-8281



Single Stage Air Filter Part No. 7-7507



Cutting Guide Kit Part No. 7-7501



Leather Leads Cover Part No. 9-1260



Heavy Duty Outfit Ordering Information			
Part Number	Model Number	Description	
0384-2600	CS350-510	CutSkill® Heavy/Medium Duty Outfit	

- RC 350 Series Regulators
- WH 370FC-V Torch handle with built-in flashback arrestors and check valves
- CA 370-V Cutting Attachment
- 2-UM Welding Nozzle
- Series 1 Cutting Tip
- Toolbox
- 25' x 1/4" RM Grade Hose, Lighter, and Soft-Sided Goggles
- Cuts up to 3/4" (19mm)
- 6" (153mm) with optional tips
- Welds up to 1/8" (3.2mm)
- 3" (76mm) with optional nozzles



Heavy Duty Outfit Ordering Information				
Part Number	<b>Model Number</b>	Description		
0384-2500	CS250-510	CutSkill® Medium Duty Outfit		

- RC 250 Series Regulators
- WH 270FC-V Torch handle with built-in flashback arrestors and check valves
- CA 270-V Cutting Attachment
- 0-UM-1 Welding Nozzle
- Series 3 Cutting Tip
- Toolbox
- 20' x 3/16" RM Grade Hose, Lighter, and Soft-Sided Goggles
- Cuts up to 1/2" (12mm)
- 5" (127mm) with optional tips
- Welds up to 5/64" (1.9mm)
- 1-1/4" (31mm) with optional nozzles





Heavy Duty Outfit Ordering Information		
Part Number	<b>Model Number</b>	Description
0384-2652	FP350-510FC	FirePower® Heavy/Medium Duty Outfit
0384-2650	FP350-300FC	FirePower® Heavy/Medium Duty Outfit
0384-2651	FP350-993FC	FirePower® Heavy/Medium Duty Outfit

- RF 350 Heavy/Medium Duty Regulators
- WH 370FC-FS Torch handle with built-in flashback arrestors and check valves
- CA 350-FS Cutting Attachment
- 2-UM Welding Nozzle
- Series 1 Cutting Tip
- 25' x 1/4" "R" Grade Hose
- Welds up to 1/8" (3.17 mm)
- 3" (76.2 mm) with optional nozzles
- Cuts up to 3/4" (19 mm)
- 5" (127 mm) with optional tips
- · Includes Striker and Goggles



Medium Duty Outfit Ordering Information		
Part Number Model Number		Description
0384-0656	150-510-FSDLX	Medium Duty Outfit

- 150 Series outfit includes a #0 welding nozzle and #0 cutting tip that welds up to 5/64" and cuts to 1/2" Optional tips allow you to weld to 1" and cut to 4"
- Includes built-in Flashback Arrestors
- Torch handle includes built-in reverse flow check valves for added safety and protection against "reverse flow of gases"
- Solid brass and stainless steel construction provide extended trouble-free service
- Tri-Lingual packaging appeals to broad customer base
- 2 year limited warranty
- U.L. listed





Medium Duty Outfit Ordering Information		
Part Number	Model Number	Description
0384-2551	FP250-510FC	FirePower® Medium Duty Outfit
0384-2550	FP250-300FC	FirePower® Medium Duty Outfit
0384-2552	FP250-510CS	FirePower® Medium Duty Outfit (clamshell)

- RF 250 Medium Duty Regulators
- WH 270FC-FS Torch handle with built-in flashback arrestors and check valves
- CA 250-FS Cutting Attachment
- 0-UM-1 Welding Nozzle
- · Series 3 Cutting Tip
- 12.5' x 3/16" "R" Grade Hose
- Welds up to 5/64" (1.98 mm)
- 3" (76.2 mm) with optional nozzles
- Cuts up to 1/2" (12.7 mm)
- 3" (76.2 mm) with optional tips
- Includes Striker and Goggles

# 0384-0990

- · Cutting attachment
- Cutting tip (#0)
- Torch handle
- Universal gas mixer
- · Built-in reverse flow check valves and flashback arrestors
- Welding nozzle (#2)
- Oxygen and acetylene regulators
- 12.5' x 3/16" R Grade hose
- Cylinder wrench with chain
- · Rugged carrying case
- · Spark lighter & goggles
- MC acetylene cylinder: 10 cu. ft.
- R oxygen cylinder: 20 cu. ft.
- Tip flow chart
- Instruction manual (English/French/Spanish)
- Two year warranty







	Ordering Information		
Part Number	<b>Model Number</b>	Description	
0387-0463	SMP-31	Propane/MAPP® Self Lighting Torch	
0387-0464	SMPK-31	Propane/MAPP® Self Lighting Torch Kit with Propane Tank	

- Lights with a pull of the trigger
- Trigger guard protects against accidental light-ups
- Safety trigger lock holds flame for extended periods and prevents accidental lighting
- Pressure regulated with pre-set flame
- Comfortable "easy grip" handle made of high impact plastic for an ergonomic feel and lasting durability
- Stainless steel burn tube with brass tip
- 180° swivel tip for easy positioning
- Can be used with MAPP® or Propane without changing the orifice
- Fits any standard propane or MAPP® cylinder, CGA 600
- U.L. Listed







0387-0464

Ordering Information		
Part Number	<b>Model Number</b>	Description
0387-0465	SMP-41	Propane/MAPP® Self Lighting Swirl Combustion Torch

#### **CONTENTS:**

- Pull the trigger to light the torch
- Swirl combustion tip provides maximum heat and reduces brazing time by 30%
- Safety trigger lock holds flame for extended periods and prevents accidental lighting
- Pressure regulated with adjustable flame control valve
- "Easy grip" handle made of high impact plastic for lasting durability
- 180° swivel tip for easy positioning
- Can be used with MAPP® or Propane without changing the orifice, tank CGA, 600
- Trigger guard protects against accidental light-ups when not locked
- U.L. Listed



0387-0465



Ordering Information		
Part Number	<b>Model Number</b>	Description
0387-0470	P-10	Propane Torch
0387-0471	PK-10	Standard kit includes torch & 14.1 oz. propane tank

- Solid brass construction provides lasting durability
- Flame control valve allows precise heat adjustment for every application
- U.L. listed





0387-0470

0387-0471

Ordering Information		
Part Number	<b>Model Number</b>	Description
0387-0400	MP-90	Hand torch with regulator and
		MPT-3 tip

- Ideal for silver soldering copper tubing, bronze brazing steel pipe, or soldering with water in the line
- Swirl combustion tip design provides maximum heat and reduces brazing time by 30%
- 360° swivel tip for easy access
- Produces target heats of 2,400° F (MAPP®); 1,750° F (Propane)
- Rugged, brass regulator
- · Easy to clean orifice for maximum, repeat performance
- Fits any standard propane or MAPP® tank, CGA 600
- Attractive P.O.P. clamshell packaging
- 6 to a master pack/cut case
- U.L. Listed regulator



0387-0400



# **Disposable Air-Fuel Tanks**

Ordering Information		
Part Number	<b>Model Number</b>	Description
0387-0436	FP-1	14.1 oz. Propane Tank, 8.65 CF, CGA 600
0916-0122	MPT-1	14.1 oz. Map-Pro™ Tank, 8.65 CF, CGA 600







0916-0122

# **Vers-A-Flame Outfits All Season Torch System**

#### **FEATURES:**

- Used for burning weeds, removing paint, melting ice, preheating asphalt/tar, removing road markings and preheating large castings for welding
- For use with propane tanks of 20 lbs. or larger
- Complete outfit is U.L. listed
- P.O.L. Excess flow "Safety Valve" shuts off gas flow if hose is accidentally cut or burnt
- · Single flint striker included in every outfit
- 10 Foot Hose withstands temperatures from –104° to +140° F
- Large brass control knob on handle will not freeze in cold conditions
- 2 year limited warranty

Ordering Information			
Part Number	Model Number	Description	
0384-1280	HT-350FP	350,000 BTU Single Unit Display	
0384-1260	HT-500FP	500,000 BTU Single Unit Display	
0384-1290	HT-500FP6	500,000 BTU 6-Pack POP Display	
1412-0141	VF-10-RH	10' Replacement Hose for all Vers-A-Flame Torches, includes P.O.L. valve.	



0384-1260



### **Powder Spray Torch Outfit**

This amazing torch provides an easy and cost effective method to build-up broken parts, resurface worn parts. and build-up cracks in cast iron parts.

#### **BUILD-UP APPLICATIONS: Machinable**

Great for farm implement and cast iron build-up. A variety of metal powders are offered for various applications.

#### Build-up Powder Options:

- FPBP-22 (22 Rockwell) Shaft build-up; cast iron repair, cracked exhaust manifolds Easily machined
- FPBP-40 Bearing surfaces, gear teeth, shaft build-up Machinable

#### WEAR APPLICATIONS: NON-MACHINABLE

Special hardfacing powder is fused onto part surface with an oxy-acetylene torch for extended part life.

#### Wear Powder Build-up Options:

- FPWP-60 Cam lobes, sealing surfaces Not machinable
- FPWP-100

Plow shears, cultivator sweeps, disk blades, augers, harvesters knives Excellent for metal to earth wear

 FPWP-600 Same as above - for high wear applications



Comes with "How To" Video





Powder Spray Torch		
Part Number	Model Number	Description
0384-1266	FPSK-260	Complete Powder Spray Torch Kit

Build-Up Powders		
Part Number	Model Number	Description
1440-0040	FPBP-22	1# Bottle: Used for Shaft build-up; cast iron repair, cracked exhaust manifolds.
1440-0042	FPBP-40	1# Bottle: Used for Bearing surfaces, gear teeth shaft build-up. Machinable.

Build-Up Powders		
Part Number	Model Number	Description
1440-0043	FPWP-60	1# Bottle: Used for Cam lobes, sealing surfaces. Not machinable.
1440-0044	FPWP-100	1# Bottle: Used for Plow shears, augers, harvesters knives.
1440-0041	FPWP-600	1# Bottle: Used for Construction Equipment



# **Cutskill Victor Style Acetylene 150/250 Series Cutting Tips**

Size	Catalog Order Number	Product Reference Number
000	CS3101 000	6700C2438
00	CS3101 00	6700C2439
0	CS3101 0	6700C2440
1	CS3101 1	6700C2441
2	CS3101 2	6700C2442
3	CS3101 3	6700C2443
4	CS3101 4	6700C2444
5	CS3101 5	6700C2445



**General Purpose -** Hand and Machine cutting. **Medium Preheat** 

# **Cutskill Victor Style Acetylene 350 Series Cutting Tips**

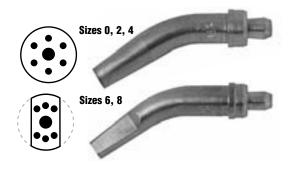
Size	Catalog Order Number	<b>Product Reference Number</b>
000	CS1101 000	6700C2408
00	CS1101 00	6700C2409
0	CS1101 0	6700C2410
1	CS1101 1	6700C2411
2	CS1101 2	6700C2412
3	CS1101 3	6700C2413
4	CS1101 4	6700C2414
5	CS1101 5	6700C2415
6	CS1101 6	6700C2416



**General Purpose -** Hand and Machine cutting. **Medium Preheat** 

# **Cutskill Victor Style Acetylene Gouging Tips**

Size	<b>Catalog Order Number</b>	<b>Product Reference Number</b>
0	CS1108 0	6700C2990
1	CS1108 1	6700C2991
2	CS1108 2	6700C2992
3	CS1108 3	6700C2993
4	CS1108 4	6700C2994
6	CS1118 6 (flat)	6700C2703
8	CS1118 8 (flat)	6700C2704



**Special Purpose -** Gouging, grooving, rivet washing and removing welds.

**Medium Preheat** 



# **Cutting Tips – Smith Style**

Size	Catalog Order Number	Product Reference Number
0	CSSC50 0	6700C2250
1	CSSC50 1	6700C2251
2	CSSC50 2	6700C2252
3	CSSC50 3	6700C2253
4	CSSC50 4	6700C2254
5	CSSC50 5	6700C2255
6	CSSC50 6	6700C2256
0	CSSC12 0	6700C2190
1	CSSC12 1	6700C2191
2	CSSC12 2	6700C2192
3	CSSC12 3	6700C2193
4	CSSC12 4	6700C2194
5	CSSC12 5	6700C2195
1	CSSC60 1	6700C2311
2	CSSC60 2	6700C2312
3	CSSC60 3	6700C2313
4	CSSC60 4	6700C2314





**General Purpose -** Scrap cutting and beveling and other heavy preheat applications.

**Heavy Preheat** 



**General Purpose -** Hand and Machine cutting. **Medium Preheat** 





**General Purpose -** Hand and Machine cutting. **Medium Preheat** 



# **Cutting Tips – Harris Style**

Size	<b>Catalog Order Number</b>	Product Reference Nu	mber
00	CS6290NX 00	6700C1509	1/22
0	CS6290NX 0	6700C1510	
1	CS6290NX 1	6700C1511	( Kung)
2	CS6290NX 2	6700C1512	General Purpose - Hand and Machine cutting.
3	CS6290NX 3	6700C1513	Medium Preheat
4	CS6290NX 4	6700C1514	Medium i Teneat
5	CS6290NX 5	6700C1515	
00	CS6290 00	6700C1429	
0	CS6290 0	6700C1430	
1	CS6290 1	6700C1431	(••)
2	CS6290 2	6700C1432	General Purpose - Hand and Machine cutting.
3	CS6290 3	6700C1433	Medium Preheat
4	CS6290 4	6700C1434	modium i ronout
5	CS6290 5	6700C1435	
1	CS6290GG 1	6700C1551	
2	CS6290GG 2	6700C1552	
3	CS6290GG 3	6700C1553	AND I

# **General Purpose -** Gouging, grooving, rivet washing and removing welds. **Medium Preheat**

# **Cutting Tips – Airco Style**

Size	Catalog Order Number	Product Reference Nu	mber
0	CS144 0	6700C1010	
1	CS144 1	6700C1011	•••
2	CS144 2	6700C1012	(••)
3	CS144 3	6700C1013	General Purpose - Hand and Machine cutting.
4	CS144 4	6700C1014	Medium Preheat
0	CS164 0	6700C1040	
1	CS164 1	6700C1041	
2	CS164 2	6700C1042	(•••)
3	CS164 3	6700C1043	General Purpose - Scrap cutting and other
4	CS164 4	6700C1044	heavy preheat applications.  Heavy Preheat



# **Cutskill Victor Style 150/250 Series Cutting Tips**

Size	<b>Catalog Order Number</b>	Product Reference Number
000	CS3GPN 000	6700C2498
00	CS3GPN 00	6700C2499
0	CS3GPN 0	6700C2500
1	CS3GPN 1	6700C2501
2	CS3GPN 2	6700C2502
3	CS3GPN 3	6700C2503
4	CS3GPN 4	6700C2504
5	CS3GPN 5	6700C2505





**General Purpose -** Hand and Machine cutting. **Medium Preheat** 

# **Cutskill Victor Style 350 Series Cutting Tips**

Size	<b>Catalog Order Number</b>	<b>Product Reference Number</b>
000	CSGPN 000	6700C2468
00	CSGPN 00	6700C2469
0	CSGPN 0	6700C2470
1	CSGPN 1	6700C2471
2	CSGPN 2	6700C2472
3	CSGPN 3	6700C2473
4	CSGPN 4	6700C2474
5	CSGPN 5	6700C2475
6	CSGPN 6	6700C2476





**General Purpose -** Hand and Machine cutting. **Medium Preheat** 



# 150/250 Series Welding Nozzles for use with WH 270FC-V torch handle (formerly WH26)

Size	Part Number	
00	0387-0019 (Clamshell)	
0	0387-0020 (Clamshell)	
1	0387-0021 (Clamshell)	
2	0387-0022 (Clamshell)	
3	0387-0023 (Clamshell)	
4	0387-0024 (Clamshell)	
5	0323-0131 (Boxed)	

# 350 Series Welding Nozzles for use with WH 370FC-V torch handle (formerly WH36)

Size	Part Number	
0	0387-0030 (Clamshell)	
1	0387-0031 (Clamshell)	The state of the s
2	0387-0032 (Clamshell)	
3	0387-0033 (Clamshell)	
4	0387-0034 (Clamshell)	

# 150/250 Series Multiflame Nozzles

Size	Part Number
4	0387-0071 (Clamshell)
6	0387-0072 (Clamshell)
8	0387-0073 (Clamshell)

# **350 Series Multiflame Nozzles**

Size	Part Number
4	0387-0060 (Clamshell)
6	0387-0061 (Clamshell)
8	0387-0062 (Clamshell)



# **150 Series Regulators**

Part #	Model#	GAS	CGA Range
0781-8960	150-60-540-FB	Oxygen	540 CGA, 4-60 PSIG
0781-8961	150-15-510-FB	Acetylene	510 CGA, 2-15 PSIG
0781-8965	FPR-160AR-200	*Acetylene	200 CGA, 2-15 PSIG
		(Tote)	
0781-8966	FPR-150CR-540	*Oxygen	540 CGA, 4-60 PSIG
		(Tote)	

<sup>\*</sup>Note: The tote regulators are ported from the back of the regulator body.



# **250 Series Regulators**

Part #	Model#	GAS	CGA Range
0781-9111	250-80-540-FB	Oxygen	540 CGA, 4-80 PSIG
0781-9116	250-125-540-FB	Oxygen	540 CGA, 5-125 PSIG
0781-9112	250-15-510-FB	Acetylene	510 CGA, 2-15 PSIG
0781-9800	250-15-300-FB	Acetylene	300 CGA, 2-15 PSIG
0781-9115	250-40-510LP-FB	LP	510 LP CGA, 2-40 PSIG
0781-9850	FPR250-125-580	Inert Gas	580 CGA, 5-125 PSIG
0781-9851	FPR250-200-580	Inert Gas	580 CGA, 10-200 PSIG



# **350 Series Regulators**

Part #	Model#	GAS	CGA Range
0781-9171	350-125-540-FP	Oxygen	CGA 540, 2-125 PSIG
0781-9172	350-15-510-FP	Acetylene	CGA 510, 2-15 PSIG





# **Flowmeter Regulators**

#### **REGULATOR WITH METERING SIGHT-GAUGE (TUBE)**

- Maximum inlet pressure 3,000 PSIG, outlet pressure is preset for 80 PSIG.
- Flow range is 10-50/Argon gas, 580 CGA male threaded connection.
- Model includes 10' gas hose.
- · Easy to read flow tube for accurate adjustments.
- Specifically designed for MIG, TIG and other inert gas welding applications.

Part #	Model #	DESCRIPTION
0781-2733	HRF 1480-580FPH	Preset at 80 PSIG, CGA 580, clamshell, with hose



# **Flowgauge Regulators**

#### **REGULATOR WITH TRADITIONAL DELIVER GAUGE**

- Efficient gas shielding for MIG/TIG welding applications.
- · Solid brass and stainless steel construction.
- 50mm gauge size.

Part #	Model #	DESCRIPTION
0781-1102	AF150-580-FB	Argon Flow Gauge, in P.O.P. Box, CGA 580





# **Regulators/Gauges**





1424=0147



1424=0405

1424=0014



1424=0290



- Solid brass and stainless steel construction
- Argon, argon-CO<sub>2</sub> capabilities
- Preset @ 18.5 SCF/H
- Use with MIG or TIG applications
- · U.L. listed

# PRESET FLOW REGULATOR Part # DESCRIPTION

0387-1232 Preset Argon, argon-CO<sub>2</sub> regulator CGA 580

# REPLACEMENT GAUGES 1 1/2"

Part #	DESCRIPTION		
1424=0147	30#, boxed, acetylene only	1/8" NPT	
1424=0148	100#, boxed, all gases	1/8" NPT	
1424=0149	400#, boxed, all gases	1/8" NPT	
1424=0150 4000#, boxed, all gases 1/8" NPT			
High quality Lexan® crystals			

#### 150 SERIES GAUGES 1 5/8" Part # DESCRIPTION

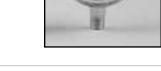
1424=0405	30#, boxed, acetylene only	1/8" NPT
1424=0406	100#, boxed, all gases	1/8" NPT
1424=0407	400#, boxed, all gases	1/8" NPT
1424=0408	4000#, boxed, all gases	1/8" NPT
1424=0409	30#, SCFH Argon CO <sub>2</sub> , all gases	1/8" NPT
High quality Lexan® crystals		

# 250 SERIES GAUGES 2" Part # DESCRIPTION

4 / 4 !! NIDT		
1/4" NPT		
High quality Lexan® crystals		

#### **350 SERIES GAUGES 2 1/2"**

Part #	DESCRIPTION	
1424=0290	30#, in a box, acetylene only	1/4" NPT
1424=0292	200#, in a box, all gases	1/4" NPT
1424=0293	400#, in a box, all gases	1/4" NPT
1424=0294	4000#, in a box, all gases	1/4" NPT
High quality	Lexan® crystals	





# **Cutting Attachments CA250 / CA350**

- · Stainless steel triangular tube design, provides strength
- · Brass construction for strength and durability
- Universal mixer for all fuel gases
- · Double o-ring seal, hand tight connection to torch handle
- U.L. Listed

#### **250 SERIES CUTTING ATTACHMENT**

Part #	Model#	<b>Cut Capacity</b>	Gas/Tip Model
0381-0740	CA25-FS	Capacity to 6" with proper tip	Acetylene 3-101 Series
350 SERIES (	CIITTING AT	<b>FACHMENT</b>	Natural Gas & Propane 3-GPN Series

350 SERIES CUTTING ATTACHMENT			
Part #	Model#	<b>Cut Capacity</b>	Gas/Tip Model
0381-0744	CA35-FS	Capacity to 8" with proper tip	Acetylene 1-101 Series
			Natural Gas & Propane GPN Series



0381-0744

0381-0740

# **Welding Torch Handles**

- Build-in Flashback Arrestors and reverse flow check valves for added protection
- Standard "B" hose 9/16" x 18 connection
- U. L. Listed

#### **250 SERIES CUTTING ATTACHMENT**

Part #	Model#	Description
0382-0143	WH26FC-FS	Torch Handle for 250 Series Cutting Attachment
0382-0136	WH36FC-FS	Torch Handle for 350 Series Cutting Attachment



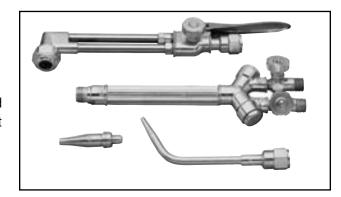
0382-0143





#### **Torch Conversion Kit**

This kit contains all you need to make the conversion from other style torches to Firepower® style (The World's Most Popular) torch products. Like all Firepower® products, the torch handle features patented built-in Flashback Arrestors and patented built-in reverse flow check valves. The world's safest oxygen and acetylene cutting apparatus. Firepower® oxygen and acetylene apparatus feature solid brass and stainless steel construction providing you years of trouble free service.



0384-0904

#### Kit includes:

- 250 Series Cutting Attachment
- 250 Series Torch Handle
- #1 Cutting Tip
- #1 Welding Tip
- Mixer Nut
- Tip Cleaner
- · Patented Built-in Flashback Arrestors
- · Patented Built-in Reverse Flow Check Valves
- U.L. Listed

# **Straight Cutting Torch ST900FC-FS**



- For use with any fuel gas 5 PSIG and above using 350 Series cutting tips
- 90° head, Tri-tube design
- Length 21".
- Cuts from 1/8" to 6"
- · U. L. Listed

#### ST900FC-C STRAIGHT CUTTING TORCH

Part #	Model#	Description
0381-0751	ST900C-FS	Straight Cutting Torch 90° head, length 21"
		Uses 350 Series cutting tips
		Series 1-101 and Series GPN



# **Oxy-Acetylene Accessories**

- Provide the ultimate protection against "Flashback" in your oxy-acetylene system. Comes with "B" 9/16"-18 threads
- · Arrestors have high flow capacity
- Arrestors are 100% tested
- FPKC Kwik connects allow the changing of torch handles without a wrench tight connection

FLASHBACK	ARRESTORS
D4 4	Madal #

Part #	Model #	DESCRIPTION
0656-0015	FPTA	Torch Flashback arrestor set with check valves
0656-0016	FPRA	Regulator Flashback arrestor set with check
0656-0000	KC-1 Kwik Connect™	valves Pair Pak (Oxygen and Fuel)







0656-0016

0656-0000

0656-0015

# **Welding Hose**

Premium quality hose produced to stringent specifications.
 Meets or exceeds the requirement of RMA and CGA.

#### Warning!

"Grade R" welding Hose is recommended for use with Acetylene Gas only.

#### **WELDING HOSE**

Model	Size	Grade	
1412-0012	3/16" x 12 1/2 ft. (Dual)	R	
1412-0020	3/16" x 25 ft.	R	
1412-0021	1/4" x 25 ft.	R	
1412-0022	1/4" x 50 ft.	R	



1412-0020 1412-0012 1412-0021



1412-0022



# **Cylinders**

#### AC-MC (0916-0002)

- •Type "MC" Acetylene Cylinder, 10 cu. ft. capacity
- •CGA 200 Connection
- Fits TurboTote 0386-1241 Case
- Fits CutSkill Tote 1421-0084
- DOT, TC Certified

#### OX-20 (0916-0003)

- •Type "R" Oxygen Cylinder, 20 cu. ft. capacity
- •CGA 540 Connection
- •Fits TurboTote 0386-1241 Case
- •Fits CutSkill Tote 1421-0084
- •DOT, TC Certified

#### NT-40 (0916-0028)

- •40 cu. ft. nitrogen cylinder
- •CGA 580 Connection
- •DOT, TC Certified





0916-0003

# Cylinder Wrench 0386-1226 • Fits B & MC Tanks

# **Replacement Cylinder Tote**

#### **FLASHBACK ARRESTORS**

Part # DESCRIPTION

1421-0085 Cylinder Tote Only





# **Firepower Arc Welding Electrodes**



#### **Firepower Arc Welding Electrodes**

Туре 6011	1 lb. Box	5 lb. Box	10 lb. Box	50 lb. Box
Rod Size	Part #	Part #	Part #	Part #
3/32"	1440-0115	1440-0116	1440-0117	1440-0118
1/8"	1440-0105	1440-0106	1440-0107	1440-0108
5/32	1440-0095	1440-0096	1440-0097	1440-0098

Туре 6013	1 lb. Box	5 lb. Box	10 lb. Box	50 lb. Box
Rod Size	Part #	Part #	Part #	Part #
3/32"	1440-0145	1440-0146	1440-0147	1440-0148
1/8"	1440-0134	1440-0135	1440-0136	1440-0137
5/32	1440-0124	1440-0125	1440-0126	1440-0127

<b>туре 7014</b>	1 lb. Box	5 lb. Box	10 lb. Box	50 lb. Box
Rod Size	Part #	Part #	Part #	Part #
3/32"	1440-0205	1440-0206	1440-0207	1440-0208
1/8"	1440-0200	1440-0201	1440-0202	1440-0203
5/32	1440-0150	1440-0151	1440-0152	1440-0153

Туре 7018	1 lb. Box	5 lb. Box	10 lb. Box	50 lb. Box
Rod Size	Part #	Part #	Part #	Part #
3/32"	1440-0195	1440-0196	1440-0197	1440-0198
1/8"	1440-0185	1440-0186	1440-0187	1440-0188
5/32	1440-0180	1440-0181	1440-0182	1440-0183

#### Features: Type 6011

- Premium AWS Class E-6011
- Mild steel type
- Deep penetration, welds through rust, scale, oil and dirt
- Use when you are unable to prepared the welding surface
- AC or DC, reverse polarity
- 60,000 PSI tensile strength
- All position electrode

#### **Type 6013**

- Premium AWS Class E-6013
- Mild steel type
- Designed for General Purpose
- Excellent for low heat applications
- Best used with clean or prepared welding surface
- AC or DC, reverse polarity
- 60,000 PSI tensile strength
- · All position electrode

#### **Type 7014**

- Premium AWS Class E-7014
- Iron powder type
- Designed for high deposition and high electrode travel speed
- Medium to low penetration
- Best used with clean or prepared welding surface
- AC or DC, reverse polarity
- 70,000 PSI tensile strength
- · All position electrode

#### **Type 7018**

- Premium AWS Class E-7018
- Low Hydrogen Type
- Designed to produce X-Ray quality welds
- Medium penetration
- Best used with clean or prepared welding surface
- AC or DC, either polarity
- 70,000 PSI tensile strength
- All position electrode



# **Firepower Job Packs**



#### FIREPOWER JOB PACKS

Part #	Description	No. Rods
1440-0400	Bronze Flux Coated Brazing Rods, 3/32" diameter x 14" long No brazing flux needed	4
1440-0401	Bronze Bare Brazing Rods, 3/32" diameter x 14" long Requires brazing flux	4
1440-0402	Aluminum Welding Electrodes, 1/8" diameter x 14" long Use with ANY Aluminum Application	3
1440-0403	Cutting Electrodes, 1/8" diameter x 14" long Use your Electric Welder as a cutting Torch	3
1440-0404	Steel Welding Electrodes, 3/32" diameter x 14" long Excellent problem solver type electrode	4
1440-0405	6013 General Purpose Electrodes, 1/16" x 10" long	4
1440-0406	6013 General Purpose Electrodes, 3/32" diameter x 14" long Excellent for use with all types of Arc Welders	4
1440-0407	General Purpose Electrodes, 1/8" diameter x 14" long Excellent for ALL Mild Steel Applications	3
1440-0409	6011 Welding Electrodes, 1/8" diameter x 14" long Excellent for Maintenance & Repair Applications	3
1440-0411	Nickel 55 Welding Electrodes, 1/8" diameter x 14" long For ALL Cast-Iron Welding Applications	4
1440-0423	ENiCl Pure Nickel Electrode 3/32" diameter x 14" long	5
1440-0424	ENiCl Pure Nickel Electrode 1/8" diameter x 14" long	3
1440-0440	Cast Iron (60% Nickel) 3/32" diameter x 14" long	3
1440-0441	6011 Mild Steel 3/32" diameter x 14" long	4



# **Specialty Electrodes - Hardfacing Electrodes**



1440-0080/1440-0081

This high quality, all purpose electrode produces outstanding impact and abrasion resistance. The high deposition rate prolongs surface life of new and worn parts. Ideal for repairing all types of agriculture, construction equipment, auger, buckets, concrete mixers, etc.

Amperage Recommendations:	AMPS	DIA.
	110-140	1/8"

#### HARDFACING ELECTRODES

Part #	Pack Size	Electrode Description
1440-0080	1 lb. tube	1/8" #35 High Abrasion/Hardfacing
1440-0081	5 lbs. Box	1/8" #35 High Abrasion/Hardfacing

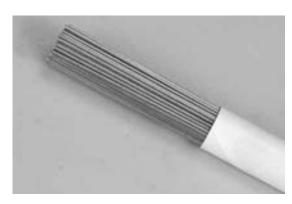
# **Gas Brazing Rods**



Flux coated, low furning brazing rod. Provides all properties for best tensile strength and ductility. Rod fuses well with cast iron, malleable iron, galvanized iron, steel, brass and copper. 65,000 PSI tensile strength.

#### MANGANESE BRONZE FLUX COATED GAS RODS

Part #	Description
1440-0429	3/32" x 36" 5 lb.
1440-0430	1/8" x 36" 5 lb.



Bare brazing rod low furning highest quality. Balanced zinc and copper alloy. Excellent for brazing fenders, radiators, water tanks and sheet metal. 63,000 PSI tensile strength.

#### **MANGANESE BRONZE BARE GAS RODS**

Part #	Description
1440-0427	3/32" x 36" 5 lb.
1440-0428	1/8" x 36" 5 lb.

# **Gas Welding Rods Electrodes**



Low carbon steel rod manufactured to the highest quality standards. Copper coating prevents rusting and improves corrosion resistance. A great rod for shop, home, commercial and maintenance repairs. 65,000 PSI tensile strength.

#### **OXYGEN/ACETYLENE MILD STEEL (Copper Coated)**

Part #	Description	
1440-0432	1/16" x 36" 10 lb.	
1440-0433	3/32" x 36" 10 lb.	
1440-0442	1/16" x 18" 5 lb.	



Aluminum rod is excellent for all types of sheet or cast aluminum. This product greatly simplifies the process and requires no flux. Applications include aluminum boats, lawn equipment, outboard motors and castings.

#### **EASY-FLO ALUMINUM BRAZING ROD**

Part #	Description
1440-0434	1/8" x 18" 1 lb.

#### **Cast Iron 55 Electrodes**



- 55% Nickel
- For welding cast iron
- Deposits are machinable
- · DC reverse polarity preferred
- 1/8" x 14" all positions electrodes

#### **CAST IRON 55 ELECTRODES**

Part #	Pack Size	Electrode Description
1440-0083	1lb. tube	1/8" Castweld/Cast Iron Repair



#### **308 Stainless Steel Electrodes**



1440-0165

- For welding all 200 and 300 series stainless up to and including 308
- Provides equal or better corrosion resistance than the base metal
- Can be used for fabricating and repairing austenitic manganese steel

#### **308 STAINLESS STEEL**

Part #	Pack Size	Electrode Description	
1440-0165	1lb Box	3/32" x 14" Electrodes	
1440-0155	1lb Box	1/8" x 14" Electrodes	
1440-0156	5 lb Box	1/8" x 14" Electrodes	



1440-0155/1440-0156

# **Brazing & Silverflow Rods**





1440-0026

- Lead-free, 0% Silver, 7.1 Phosphorus, balance copper Known as "poor man's" silver
- Free flowing/very fluid, no flux required
- Not for ferrous material, use only with copper base alloys
- Use flame torch

#### SILVERFLOW BRAZING ALLOY

Part #	Pack Size	Electrode Description
1440-0025	.5 lb tube	1/16" x 1/8" x 18" long flat rods, 16 pieces per tube

- Low fuming, flux coated bronze, 59%
- For brazing iron based materials (except stainless steel)
- Also used for brazing steel to copper or brass
- Use flame torch

#### **BRONZEFLOW BRAZING ALLOY**

Part #	Pack Size	Electrode Description
1440-0026	.5 lb tube	3/32" x 18" round rods,
		12 pieces per tube



## **ENIFECI Nickel 55 Cast Iron Electrodes (Machinable)**



**NICKEL 55 CAST IRON** 

Part #	Description
1440-0440	3/32" Job pack (3 rods)
1440-0083	1/8", 1 lb.
Tensile strength 70,00	0 PSI. Elongation 12%

The most versatile cast iron electrode. The best solution for repairing cast iron, heavy cast iron sections. The smooth arc characteristics produce strong, sound welds at low amps. Repairs cylinder blocks, exhaust manifold, and machine bases.

Current: AC/DC - DC+ recommended

Amperage Recommendations:	AMPS	DIA.
	70-90	3/32"
	80-120	1/8"

# **ESt Cast Iron Electrodes (Non-Machinable, Steel Core)**



**CAST IRON** 

Part #	Description
1440-0449	1/8" 1 lb.
1440-0443	1/8" 5 lb.
Tensile strength 62,000 PSI	. Elongation 20%

This cast iron electrode is specifically developed for dirty and oil soaked cast iron applications. It is also ideal for heat affected cast iron repairs. This electrode offers the least expensive method of repairing cast iron. Great for repairing castings, transmission housings, etc. Non-Machinable.

Current: AC/DC - DC+ recommended Amperage Recommendations: 70-125

# **ENICI Pure Nickel 99% Cast Iron Electrodes (Machinable)**



**PURE NICKEL 99% CAST IRON** 

Part #	Description
1440-0423	3/32" Job pack (5 rods)
1440-0424	1/8" Job pack (3 rods)
1440-0425	1/8", 1 lb.
1440-0374	1/8", 5 lb.
Tensile strength 55,000	PSI. Elongation 10%

The highest quality nickel electrode available. Welds well in all positions. The high (99%) nickel content has a natural attraction to cast iron giving it superior performance when welding cast iron material. Nickel 99 can be used on cast iron parts that are subject to heating and cooling, such as engine blocks, cylinder heads, exhaust manifolds, etc. Excellent machinability.

Current: AC/DC - DC+ recommended

Amperage Recommendations:	AMPS	DIA.
	70-90	3/32
	70-110	1/8"



#### E308-16 Stainless Steel Electrodes



**E308L-16 STAINLESS STEEL** 

Part #	Description
1440-0165	3/32" 1 lb.
1440-0155	1/8" 1 lb.
1440-0156	1/8" 5 lb.

All position, high strength electrode produces unique and superior performance for joining all types of steel with outstanding strength and elongation. Produces an exceptionally smooth arc and smooth beads. Corrosion resistant, crack resistant even on high carbon, manganese, stainless and dissimilar steels. Tensile strength 128,000 PSI. Elongation 32%.

Current: AC/DC - DC+ recommended

	AMPS	DIA.
Amperage Recommendations:	35-70	3/32"
	60-110	1/8"

## **E4043 Aluminum Arc Electrodes**



#### **ALUMINUM ARC**

Part #	Description
1440-0419	1/8" 1 lb.
1440-0420	1/8" 5 lb.

This flux coated aluminum electrode is designed to give a weld with strength ductility and corrosion resistance equal to parent metal. Applications include aluminum, sheet metal, plates, castings, tanks and piping. Tensile strength 34,000 PSI. Elongation 18%.

Current: DC+

	AMPS	DIA.
Amperage Recommendations:	70-120	1/8"



#### **E6024 - Quick Start Electrodes**



Mild steel type electrode has a special quick start tip. Stable arc and automatic action that makes it easy to use on thin metals requiring low amperage. Features self-cleaning action that works well in all positions. Tensile Strength 60,000 PSI.

Current: AC/DC

AMPS DIA. Amperage Recommendations: 25-90 1/16"

#### E6024 - QUICK START

Part #	Description
1440-0412	1/16" 1 lb.
1440-0413	1/16" 5 lb.

# **Cutting Electrodes**



CUTTING	
Part #	Description
1440-0426	1/8" 1 lb.

A special heavy duty coating produces 7000° heat at high-arc velocity. Use this electrode for a fast, low-cost means of cutting cast iron and stainless steel without special equipment.

Current: AC



#### **ER70S-6 MIG Wire Solid**



- Premium AWS CLASS ER70S-6
- · For general purpose MIG welding
- Designed to be used on mild steel
- Best used with clean or prepared welding surface
- Requires a shielding gas
- · DC reverse polarity

#### **SOLID WIRE**

Part #	Spool Size	Wire Size
1440-0210	2 lbs.	.023"
1440-0211	11 lbs.	.023"
1440-0212	33 lbs.	.023"
1440-0215	2 lbs.	.030"
1440-0216	11 lbs.	.030"
1440-0217	33 lbs	.030"
1440-0220	2 lbs.	.035"
1440-0221	11 lbs.	.035"
1440-0222	33 lbs	035"

#### **E71T-GS Fluxed Cored**



- Premium AWS CLASS E 71T-GS
- Also called "Self-Shielding" or "Gasless"
- · For general purpose MIG welders
- · Designed to be used on mild steel
- Best used with clean or prepared welding surface
- Requires no shielding gas
- DC straight polarity

#### **FLUX CORED WIRE**

Part #	Spool Size	Wire Size
1440-0230	2 lbs.	.030"
1440-0231	10 lbs.	.030"
1440-0235	2 lbs.	.035"
1440-0236	10 lbs.	.035"



### **ER 308L MIG Wire Stainless Steel**



- Premium AWS CLASS ER308L
- · For stainless steel MIG welding
- · Best when used with a clean or prepared welding surface
- Requires a shielding gas
- DC reverse polarity

### STAINLESS STEEL

Part #	Spool Size	Wire Size	
1440-0245	2 lbs	.030"	

### **ER5356 MIG Wire Aluminum**



- Premium AWS CLASS ER 5356
- For aluminum MIG welding
- · Best when used with a clean or prepared welding surface
- Requires a shielding gas
- DC reverse polarity

### **ALUMINUM**

Part #	Spool Size	Wire Size	
1440-0240	1#	.030"	
1440-0241	1#	.035"	
1440-0445	3#	.035"	



### **Solders**

#### **Lead Free Solder:**

Is used for non-electrical applications.
Applications include Plumbing and
Refrigeration systems. Contains No Lead,
Cadmium or Antimony.

### **Acid Flux Core Solder:**

Is used for non-electrical applications. Applications include, Sheet Metal joint and fitting connections, works well on many types of metals (Copper, Brass, Nickel and Galvanized Steel).

#### **Rosin Flux Core Solder:**

Used for electrical applications.
Completely non-corrosive and electrically non-conductive.

Lead Free Solder Model	Item	Weight
1423-1115	Lead Free, 95/5	1/8" x 1 lb.
Acid Flux Core Solder Model	Item	Weight
1423-1102	Acid Flux Core, Comm.	1/8" x 1 lb.
1423-1109	Acid Flux Core, 30/70	1/8" x 1/2 lb.
1423-1108	Acid Flux Core, 40/60	1/8" x 1/4 lb.
Rosin Flux Core Solder Model	Item	Weight
1423-1114	Rosin Flux Core, 40/60	1/8" x 1 lb.
1423-1113	Rosin Flux Core, 30/70	3/32" x 1/2 lb.
1423-1110	Rosin Flux Core, 40/60	1/16" x 1/4 lb.
1423-1112	Rosin Flux Core, 40/60	3/32" x 1/4 lb.

# **Anti-Spatter Nozzle Shield**

- Prevents spatter adhesion on surface reduces clean-up time
- Non-flammable contains no silicones

Model	Item
1440-0296	Anti-Spatter Spray, 16 oz.



# **Soldering Flux and Paste**

Soft Soldering/Tinning Flux that is active between 200°F and 600°F. Very effective on copper and repairing automotive radiators.

Model	<u>Item</u>
1423-1111	2 oz. Soldering Flux
1423-1101	2 oz. Soldering Paste



### **Welder's Gloves**

### 1423-0051 - Welder's Gloves with Thumb Strap, Russet

- Top Quality "Russet" Select Split Leather
- One Piece Back with Thumb Strap
- Gunn Cut with Straight Thumb
- Lock-Stitch Construction
- Fully Welted Seams

- Full Sock-Type Lining
- Turned Cuff for Safety
- Kevlar Sewn
- Large Size
- Length: 14"



### 1423-4133 - Premium Welder's Glove

- Premium Quality "Blue" Shoulder Split Leather
- Special Thermal Lining Resists Heat
- One Piece Back with Wing Strap
- Fully Welted Seams

- Lock-Stitch Construction
- . Turned Cuff for Safety
- Kevlar Sewn
- Length: 14"



# **Welding Protective Blanket and Equipment Cover**

### 1423-1404 - Welding Blanket (38" x 24")

- Use our exclusive fabric to protect personnel and equipment during welding, cutting, grinding and other potentially hazardous operations
- Service range up to 1000° F./ 538° C., 20% higher than conventional welding fabrics
- Resistant to abrasion
- Fabric can be draped over equipment or used as a curtain to isolate hazardous operations
- Grommets (36"-Centers) for versatility





### **Welder's Safety and Chemical Splash Goggles**

### 1423-0019 - Welder's Cup-Type Goggle, 50mm

- Lightweight, hard plastic goggles (50mm)
- Comes with tough polycarbonate lens (Shade No. 5)
- · Adjustable elastic headband and nose piece
- Meets/Exceeds ANSI Z87.1 and various International Standards

### 1423-0017 - Fixed Front, Welders Goggle Soft Frame, 2" x 4-1/4"

- Furnished with filter lens (Shade No. 5)
- Soft vinyl frame fits easily over corrective glasses
- Hooded vents prevent fogging nd offers excellent ventilation
- Adjustable elastic headband
- Meets/Exceeds ANSI Z87.1 and various International Standards

### 1423-0018 - Lift Front, Welder's Goggle Soft Frame, 2" x 4-1/4"

- Filter lens frame raises easily for on-the-job versatility (Lift Front Type)
- Furnished with filter lens (Shade No. 5)
- Soft vinyl frame fits easily over corrective glasses
- Hooded vents prevent fogging and offers excellent ventilation
- Adjustable elastic headband
- Meets/Exceeds ANSI Z87.1 and various International Standards

### 1423-0020 - Clear Safety Goggle, with Clear Lens

- Furnished with tough polycarbonate clear lens
- For protection against flying particles and dust
- Soft vinyl frame fits snugly and can be worn for extended periods with comfort
- Transparent frame allows vision in all directions
- · Hooded vents prevent fogging and offers ventilation
- Adjustable elastic headband
- Meets/Exceeds ANSI Z87.1 and various International Standards

#### 1423-4173 - Chemical Splash Goggle, 4 Vents

- Dust, splash and light impact resistant
- Indirect ventilation through four screened vents for added protection
- Clear polycarbonate lens
- · Clear frame allows wide angle vision
- Soft vinyl frame fits snugly and can be worn for extended periods with comfort
- Adjustable elastic headband
- Meets/Exceeds ANSI 787.1 and various International Standards







# **Grinding Shield**

### 1423-4175 - Grinding Shield

- Complete with Clear Visor, 8" x 12" x .040"
- · Ratchet quickly adjusts headband to various sizes
- Meets/Exceeds ANSI Z87.1 and various International Standards



# **Replacement Visors**

### 1441-0015 - Replacement Visor

- Clear visor for face shield, 8" x 12" x .040"
- High grade PETG, for excellent protection against paints & mild chemicals
- Wide flare for maximum protection
- Universal hole pattern fits most brand name headgear

Caution: Use PETG visors for protection against lower level impacts only





# **Safety Glasses**

### Optimax™, 58 mm, Safety Glasses

• Meets or Exceeds ANSI Z87.1 and various International Standards

**Model**1423-4120
Shade 5



### Luxur™, Fashion Safety Glasses, One-piece Lens, Adjustable Templates

• Meets or Exceeds ANSI Z87.1 and various International Standards

**Model** Lens Shade 1423-4177 Shade 5



### Regal™, Safety Glasses, 48 mm

• Meets or Exceeds ANSI Z87.1 and various International Standards

ModelLens Shade1423-4126Clear1423-4127Dark Green



### Symetrix™, Wrap-a Round Visitor Glasses

• Meets or Exceeds ANSI Z87.1 and various International Standards

ModelLens Shade1441-3408Symetrix™, Clear





# **Thermal Arc Auto Darkening Welding Helmets**

### **Welding Helmet Features**

The New Thermal Arc® Professional Auto-Darkening Welding Helmet is designed to meet the needs of the professional user. The helmet offers the latest safety features while providing maximum performance and comfort. Features of the helmet can be easily identified by the icon information outlined below.

#### **AUTO DARKENING**



Variable Shade This welding helmet is fitted with an auto-darkening filter lens that has variable adjustment from Shade 9 to Shade 13.

#### **IMPACT RATING**



High Impact Rating This welding helmet complies to ANSI Z87.1 high impact requirements (high mass and velocity impact).



W4011700 - USA Helmet



W4011800 - Canada Helmet



2 Year Warranty This product is manufactured to stringent Thermal Arc quality standards and is covered by a conditional Two Year warranty.

### **Auto-Darkening Filter Lens features**

- Variable shade from 9–13
- · Battery powered with solar assist for extended battery life
- 1/20,000 second reaction time
- Fully adjustable sensitivity and delay controls
- Low battery indicator







W4012000 - Black Helmet



### **Eclipse Welding Helmets**

- Extended head, face, neck and ear coverage protects against sparks and slag - preventing burns and harmful Ultra-violet and Infra-red rays
- Channels smoke and fumes away from the welder Making breathing easier and unique shape that allows room for respirators
- Built-in magnifier holder is adjustable to multiple positions
- Adaptable to most Auto-darkening Filters
- Helmet includes Shade 10 filter plate and adjustable locking headgear with sweatband
- Meets or Exceeds: ANSI Z87-1 & CE Standards

Model	Item
1441-0024	Fixed Front Helmet, 2" x 4-1/4"
1441-0026	Fixed Front Helmet, 5-1/4" x 4-1/2"
1441-0025	Lift Front Helmet, 2" x 4-1/4"
1441-0059	Auto Darkening Helmet, 2" x 4-1/4"
	Fixed Shade #10, 4.9" View
1423-4110*	Headgear for Eclipse™ Helmet











1441-0059

<sup>\*</sup>not shown

**Firepower**®

# **Eclipse Welding Helmets**

- Streamlined, compact design allows welders to get into tight places
- Meets or Exceeds: ANSI Z87-1, CE and various International Standards



Item
Hand Welding Shield, 2" x 4-1/4"
Fixed Front Helmet, 2" x 4-1/4"
Economy, Black
Fixed Front Helmet, 4-1/2" x 5-1/4"
Economy, Black
Lift/Fixed Front Combo Helmet,
4-1/2" x 5-1/4", Black
Adjustable Ratchet Headgear



1441-0023



1441-0038



1441-0004



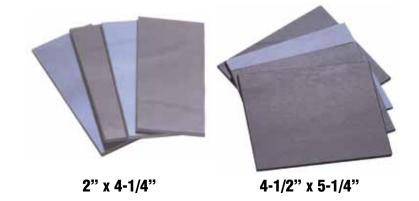
1441-0042



### **Glass Filter Plates**

- Hardened glass is heat-treated for strength.
- Meets or Exceeds: ANSI Z87-1, all current applicable Federal Specs., CSA Z94.3, CE and various International Standards.

Model	Shade
Filter Plate 2" x 4-1/4"	
1423-4124	Shade #5
1441-0047	Shade #10
Filter Plate 4-1/2" x 5-1, 1441-0049	/4" Shade #10



# **Polycarbonate Cover and Safety Plates**

- Polycarbonate clear safety or cover plates, as components of welding goggles or helmets exceed the high velocity and high impact requirements of the ANSI Z87.1-1989 and Canadian CSA Z94.3 Standards
- Functions as either cover or safety plate
- Eliminates the accidental use of a cover plate in instances where a safety plate is necessary





# **Hose Repair Dealer Kit**

- Streamlined, compact design allows welders to get into tight places
- Meets or Exceeds: ANSI Z87-1, CE and various International Standards

Part #	Model #	DESCRIPTION
1420-0296	DK-FP	Complete Dealer Kit*
*Includes: '	'A" and "B" size	hose fitting with KI2B vise-grip type

<sup>\*</sup>Includes: "A" and "B" size hose fitting with KI2B vise-grip type crimping tool. Contains nuts, nipples, couplers, splicers and ferrules for 1/4" and 3/16" I.D. hose.



# Crimper™, Heavy Duty Lug/Splicer Crimping Tool

- Durable spring loaded mechanism holds Terminal/Lug in place
- Delivers 1400-1800 Lbs. pull-out resistance (Terminal To Cable)

Model #	Jaw Opening	Cable Capacity
1423-1209	Up to 1"	6-4/0





# Welper® MIG Pliers (8 tools in one!)

- Designed for hammering, wire cutting, insulator bushing removal and installation and drawing out wire
- Perfect for removal and installation of contact tips and nozzles

Model	Item
1423-1428	Welper®, MIG Pliers



# **Lightnin' Bug® Torch Lighter**

- Tested to 300,000 Strikes!
- Easy and accurate ignition insured by multi-spark discharge
- Zinc Plated body resists rust and corrosion

Model	Item
1423-1423	Lightnin' Bug®, Torch Lighter



# **Single Flint, Triple Flint and Flint Replacements**

- Tested to 300,000 Strikes!
- Easy and accurate ignition insured by multi-spark discharge
- Zinc Plated body resists rust and corrosion

Model	Item
Single Flint	
1423-0026	Single Flint Spark Lighter
1423-0032	Flints for Single Flint Spark Lighter
	1 Holder/pk. (5 pcs)
Triple Flint	
1423-0050	Triple Flint Spark Lighter
1423-0052	Flints for Triple Flint Spark Lighter
	2 per Pack









1423-0032



### **Tip Cleaners**

#### **Standard**

Set of 13 cleaners with file. Sizes #6 through #26 for cleaning Drill Size 77-49.

### **King Size**

Set of 13 cleaners Extra Long with file. Sizes #6 through #26 for cleaning Drill Size 77-49.

Model	Item
1423-0016	Standard Tip Cleaner
0387-0487	King Size Tip Cleaner



			Cleans	Hole .
Gage	Wire Dia.	Ridge Dia.	Diameter Inch	Drill Size
6	0.014	0.016	.018020	77-76
7	0.018	0.020	.021022	75-74
8	0.021	0.023	.024026	73-71
10	0.024	0.026	.028031	70-68
12	0.028	0.030	.032035	67-65
14	0.032	0.034	.036038	64-62
15	0.035	0.038	.039040	61-60
16	0.037	0.040	.041042	59-58
17	0.039	0.042	.043046	57
18	0.042	0.044	.046051	56
22	0.048	0.050	.052055	55-54
24	0.055	0.057	.060064	53-52
26	0.062	0.065	.067073	51-49

# Tip Drill Cleaner Kit (12 piece)

- Cleans and Trues most Standard Orifices
- Contains most commonly used 12 drills (#57-74) in assorted sizes
- Complete with Built-in Chuck and Pocket Clip

Model	Item	
1423-1408	Tip Drill Kit, 12 pc.	
	Drill sizes: #52-74	





# **Soapstone**

Model	Item
1423-0095	Flat Soapstone, 6 pcs./pk
1423-0094	Round Soapstone, 6 pcs./pk





ooa.poto		
Model	Item	
1423-0097	Flat Soapstone Holder	
1423-0096	Round Soapstone Holder	

# Handyguard™, Welding Rod Storage Tube

Weld rod storage tubes provide great storage for all your welding electrodes, rods and filler metals. Chloride-free and features a threaded cap with long lasting neoprene seal to keep electrodes airtight-preventing them from being contaminated with atmospheric moisture.

• Holds up to 10 lbs. of 12" or 14" Electrodes

Model	Item
1421-0062	Handy Guard™, Weld Rod Storage Tube

# **Chipping Hammer**

- Hammer heads are hardened to precisely controlled temperatures for durability and strength
- Wide-blade design removes slag faster and adds to life of the tool
- Holds up to 10 lbs. of 12" or 14" Electrodes

Model	Item	Length	Weight
1423-0086	Cone and Chisel	12"	14 oz.



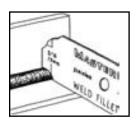


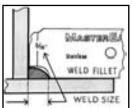
### Mastergage™ Fillet Weld Gage



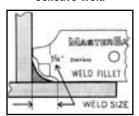
- High quality stainless steel (SUS 304) blades to resist rust for longer life
- Permits quick and accurate measuring of most popular weld fillet sizes in inches and metric: 1/8"-1" (3.2mm - 25.4mm)
- Set of seven blades come in a handy, vinyl pocket case with snap lock

Model	Item
1423-1464	MasterGage™, Fillet Weld Gage





**Convex Weld** 



**Concave Weld** 



Fillet Weld Gage by MasterGage™

# **Rap-Around Measuring Tape (For Pipe Measurement)**

- An inexpensive tool for marking straight lines around pipe, or for use as a straight edge
- Double-ruled: It's never upside down
- Printed in scale inches, pitch chart, tangent chart and other useful markings
- Packaged in a clear plastic tube for easy identification and protection between jobs

Model	Item
1423-1405	Rap-Around Tape, 4" x 72"



# **4-Way Pick Set**

- Knurled 5" aluminum handle
- Four tempered steel picks 3" long screw into handle

Model	Item
1423-1435	4-Way Pick Set





# **Locking Pliers/Clamps**

Model	Item
1423-1432	Locking Plier, 11"



# **Steel Ground Clamps**

- Large contact area assures positive grounding
- Zinc plated
- Large hex screw cable connection assures safe cable connection every time
- Pure copper braided shunts on 1443-0027-allows both jaws to carry welding current

Model	Amperage Capacity	Jaw Opening	Cable Capacity	Length
1443-0025	200	Up to 1"	1/0	6"
1443-0026	300	Up to 2"	2-1	8"
1443-0027	500	Up to 2"	1/0-4/0	10"

# **Cable Lugs**

Model	Cable Capacity	Amperage	Stud Hole	ID of Socket	Pack
1443-0002	6-8	75	21/64"	10/32"	2 pc./pk.
1443-0003	4-6	100	21/64"	11/32"	2 pc./pk.
1443-0004	6-2	150	17/32"	1/2"	2 pc./pk.
1443-0005	1-2/0	200	17/32"	35/64"	2 pc./pk.



# Mag Tool™ Multi-Purpose Magnetic Holders

Mag Tool™ will hold both sheet and tube at angles of 45°, 90 and 135°

 Model
 1423-1425
 1423-1426

 Size
 Medium
 Large

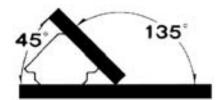
**Dimensions** 4.7" x 3.4" x 0.56" 6.3" x 4" x 0.63"

Magnet: Anisotropic Ferrite

\*\* In contact with ferrous objects of adequate thickness and smooth surface finish











1423-1426

# **C-Clamps / Malleable Iron**

- Steel spindles are copper plated for splatter protection
- · Swivel pads adjust freely to bear evenly on clamped parts
- Lacquered Finish

Model	Size	<b>Throat Capacity</b>	Depth	Spindle Diameter
1423-1419	4"	0"-4"	2-1/4"	7/16"





### **Scratch Brushes**

### **Curved Long Handle Brushes**

Model:	Wire	No. of Rows	Trim Length
1423-0087	Carbon Steel	3 x 19	1-3/16"
1423-0082	Stainless Steel	3 x 19	1-3/16"

### **Shoe Handle Brushes**

Model:	Wire	No. of Rows	Trim Length
1423-0083	Carbon Steel	4 x 16	1-3/16"
1423-1442	Stainless Steel	4 x 16	1-3/16"



# **Welders Toothbrush Style**

Model:	Wire	No. of Rows	Trim Length
1423-1400	Brass	2 x 9	1/2"
1423-0084	Brass	3 x 7	1/2"
1423-0081	Stainless Steel Tinning	3 x 7	1/2"



Model	Trim Width	Trim Length	<b>Total Length</b>	Pack
1423-0093	1/2"	3/4"	5-3/4"	3 pc./Pk.



Model	Handle	Length	
1423-1402	Plastic	10-1/2"	





### **Power Brushes: End Brushes**

Firepower small diameter wire brushes are designed for use in restricted or hard-to-reach areas. They are excellent for deburring, blending and cleaning of surfaces. Small diameter brushes are especially designed for use on portable air and electric tools. Applications include deburring, blending, removal of rust, cleaning. End brushes are great for cylinder heads, pistons and valve ports, rubber and plastic flash removal, removal of rust, paint scale, tool polishing, and weld cleaning.







		Wheel		Wire	Max.
_	Model	Diameter	Туре	Size	RPM
	Circular Type	1/4" Shank	Carbon Stee	el Wire	
	1423-2100	1-1/2"	Coarse	.014"	4,500
	1423-2101	2"	Coarse	.014"	4,500
	1423-2102	3"	Coarse	.014"	4,500
_	1423-2103	3"	Fine	.008"	4,500
	Crimp Type	1/4" Shank	Carbon Steel	Wire	
	1423-2104	3/4"	Coarse	.014"	4,500
_	1423-2117	1"	Coarse	.014"	4,500
	Knot Type	1/4" Shank	Carbon Steel	Wire	
à	1423-2105	3/4"	-	.020"	20,000
	1423-2118	1-1/2"	-	.020"	20,000
		1	1	I	ı

#### Safety First - Always Grind Safely

#### Warning! Failure to Observe Safety Procedures May Result in Serious Injury:

Complies with Safety Standards of the Industrial Division of the American Brush Manufactures Association and the American National Standards Institute ANSI B165.1-1985 "Safety Requirements for the Design, Care and Use of Power Driven Brushing Tools".

### **Always Wear Protective Equipment:**

Impact resistant Safety Glasses or Goggles, Full Face Shield, Safety shoes, Arm Guards, Leather Gloves, Apron and other appropriate protective clothing must be worn by all operators and other employees working in the area of power brush operations. Always wear a respirator to avoid inhalation of dust particles.

#### **Machine Guards Must Be Used:**

Power brushes should be used only on machines that are equipped with Safety Guards, and they must be in place at all times.

#### **Check Specifications On Mounting Brushes:**

Check appropriate RPM before mounting any brush on a power tool. Arbor hole and spindle diameter should be a free fit. Spindle length should be sufficient to accept a full-nut mounting. Direction of spindle nut thread should be opposite to the direction of the spindle rotation so that the nut will tighten as the spindle revolves.

### Always Inspect Before Use:

Carefully check all brushes in the original carton. Do Not Use if they are rusty or damaged. Brushes should be stored in the original cartons and should not be exposed to high humidity or other detrimental environmental conditions.

### **Always Observe Speed Limitations:**

Observe all speed restrictions indicated on the brushes, containers, labels, or printed in pertinent literature. For reasons of safety, the "Max. RPM" Must Not be exceeded under any circumstances.



# **Power Brushes: Wire Cup Type**

Firepower wire cup brushes are designed for use on portable power tools. Made with high quality tempered wire, Firepower brushes provide fast cutting action for removal of light encrustation of scale, rust, paint or weld splatter. The relative high flexibility of fire power wire cup brushes allows cleaning on irregular surfaces as well as flat surfaces.

**Cup Brushes with 1/4" Stem:** Small diameter cup brushes are designed for use in restricted or hard to reach areas. They are excellent for carbon cleaning, polishing, removal of scale, slag, rust and paint.

**Cup Brushes Crimped Wire:** Heavy-duty cup brushes with arbor adapters and threads to fit most grinders.

**Cup Brushes Stainless Steel Knotted Wire:** Heavy-duty cup brushes with arbor adapters and threads for most grinders. Stainless steel wire brushes are used to reduce discoloration and corrosion on stainless and aluminum alloys. Stainless steel wire brushes are highly corrosion resistant and should be used where contamination or after rust is a problem.

Madal		Cup	Wire	Max.
Model Crimp Type:		<u>Diameter</u> Parbon Steel Wire, 1	Size	RPM
		<u> </u>	I	4.500
1423-2106		1-1/2"	.014"	4,500
1423-2107		2-1/2"	.014"	4,500
1423-2108		2-1/2"	.008" (Fine)	4,500
Crimp Type:	С	arbon Steel Wire, 5	5/8" - 11 NC Threaded	Arbor
1423-2109		3"	.014"	12,500
1423-3158		4"	.014"	8,500
Knot Type:	Cá	arbon Steel Wire, 3/	8" - 24 NF Threaded	Arbor
1423-3159		3"	.020"	12,500
Knot Type:	Cá	arbon Steel Wire, 5/	8" - 11 NC Threaded	Arbor
1423-2110		3"	.020"	12,500
1423-2115		4"	.020"	8,500
1423-2116		6"	.020"	6,500











### **Wire Wheel Brushes: Crimped and Knot Style**

Firepower knot-style wire wheel brushes are designed for tough jobs. Each individual knot contains an equal number of top quality high carbon tempered wires, which gives the wheel an exact balance and long-life. Firepower brushes can be furnished in either standard twist in carbon and stainless steel. Firepower brushes are well-suited for use in the welding and fabricating industries. They are used for surface preparation prior to welding and brazing and for removing weld scale and spatter after the welding operation.







	Wheel	Wire	Arbor	Maximum	
Model	Diameter/Width	Size	Hole	RPM	
Crimped Type:	Carbon Steel Wire				
1423-2327	4"dia. x 1/2" wide	.014"	5/8"-11 NC	8,000	
1423-2121	6" dia. x 1/2" wide	.014"	5/8"-1/2"	6,000	
1423-2122	6" dia. x 1" wide	.014"	5/8"-1/2"	6,000	
1423-2123	8" dia. x 11/4" wide	.014"	5/8"-1/2"	4,500	
Stringer Bead (	Stringer Bead Carbon and Stainless Steel Wire				
1423-2111	4" dia.	.020"	5/8"-11 NC	12,500	
Standard Twist: Carbon and Stainless Steel Wire					
1423-2113	4" dia.	.020"	5/8"-11 NC	12,500	
1423-2120	6" dia.	.020"	5/8"-1/2"	9,000	

### Arbor Reducing Adaptors:

For both cup and wheel brushes - the fixed 5/8"-11 arbor hole of each brush can be adapted to M10 x 1.25, M10 x 1.50 and 3/8-24NF by using arbor reducing adapter.

1423-2124 Arbor Reducing Adaptor, 5/8"-11 to M10 x 1.25 1423-2125 Arbor Reducing Adaptor, 5/8"-11 to M10 x 1.5



# **Steel Rotary Files**

- Rotary files offer perfect solutions for the welding jobs:
   Trimming welds, grinding smooth fillets & preparation for welds
- Repairs can be easily done because of a variety of shapes and sizes available
- All rotary files have a standard shank of 1/4" (6mm)
- Note: use lower speeds when cutting harder ferrous materials and higher speeds for softer non-ferrous materials





Model	Size	Shape	
1423-2224	1/2" x 7/8"	Cylindrical	
1423-2226	1/2" x 1/2"	Ball	



# **Steel Rotary Rasps**

Model	Size	Shape
1423-3177	1/2" x 7/8"	Cylindrical

**Caution!** - Rotary files are for use on electrical power drills only. They are not recommended for use on pneumatic or hydraulic tools.





### **Abrasive**

Specification Example: A-36-S-B-F

Abrasive	Grit	Grade	Bond Type	Reinforcement
A	<b>36</b>	S	В	F

Abrasive:	Grits	Grades	Bond Types	Reinforcement
<b>A</b> = Aluminum Oxide	Coarse:	Soft:	<b>B</b> = Resinoid	<b>1 FG</b> = Inter-woven
A = Aluminum Oxide	#16-24	H, I, J, K	<b>V</b> = Vitrified	2 FG = Double Reinforced
C = Silicon Carbide	Medium:	Medium:		
	#30-60	L, M, N, O, P		
	Fine:	Hard:		
	#80-220	Q, R, S, T		

# Safety First - Always Grind Safely

### Safety: Always DO the following:

- 1. Always handle and store abrasives in a careful manner.
- 2. Always visually inspect all abrasives before mounting for possible damage in transit, storage, or prior use.
- 3. Always "Ring Test" the wheel by tapping gently with a light metallic implement such as the handle of a screwdriver for light wheels, or Wooden or Plastic Mallet for heavier wheels. An undamaged wheel will give a clear tone.
- 4. Always make sure the operating speed established for the equipment does not exceed the wheel speed.
- 5. Always check mounting flanges for equal and correct diam-
- 6. Always use mounting blotters when supplied with abrasives.
- 7. Always keep work rest properly adjusted within 1/8" (3mm) of wheel face.
- 8. Always direct grinding sparks downward and away from the face and body.
- 9. Always wear protective equipment such as, impact resistant 13. Do Not stand directly in front of a grinding wheel whenever a safety glasses or goggles, full face shield, safety shoes, arm guards, leather gloves and apron must be used for operator protection for all grinding operations. Always wear a respirator to avoid inhalation of dust particles.
- 10. Always use a safety guard covering at least one-half of the wheel diameter.
- 11. Always allow newly mounted wheels to run at operating speed, with the guard in place, for at least one minute before starting to grind.
- 12. Always observe all safety recommendations supplied by the Equipment Manufacturer.

#### **DO NOT** attempt the following:

- 1. Do Not use a wheel that has been dropped.
- 2. Do Not use wheels that have been soaked in water
- 3. Do Not use wheels without guards for grinding or cutoff work.
- 4. Do Not force a wheel onto the spindle or alter the hole of size the wheel.
- **5. Do Not** use a wheel that fits the arbor too loosely.
- 6. Do Not exceed maximum operation speed established for the
- **7. Do Not** use dirty, nicked, warped or sprung mounting flanges.
- 8. Do Not tighten the mounting nut excessively.
- 9. Do Not grind on the side of the wheel unless the wheel is specifically designed for that purpose.
- 10. Do Not start machine unless the machine guard is in place.
- 11. Do Not jam work into the wheel. Let the wheel do the work.
- 12. Do Not apply excessive pressure.
- grinder is started.
- 14. Do Not grind near flammable material.
- 15. Do Not grind or cut material for which the wheel is not designed.
- **16. Do Not** flat grind. Minimum grinding angle is 15°.
- 17. Do Not use relieved or recessed flanges with threaded hole cup wheels, cone or plugs.
- 18. Never use a wheel or a disc that has been dropped, chipped, mishandled or appears defective.



# **Depressed Center Grinding Wheels, Type 27**

Firepower depressed center wheels are fully reinforced with resin bonded aluminum oxide to ensure safety at high speed and to increase bonding and impact strength. Designed for use on air or electric powered right angle or vertical shaft grinders. Available with or without hubs.

Model	Size	Max. RPM	Grade
Without Hubs	s:		
1423-3151	4" x 1/8" x 5/8"	13,700	A36S
1423-2186	4" x 1/8" x 5/8" (5 pc./Pk)	13,700	A36S
1423-3152	4" x 1/4" x 5/8"	13,700	A24R
1423-2187	4" x 1/4" x 5/8" (5 pc./Pk)	13,700	A24R
1423-3186	4-1/2" x .045" x 7/8"	13,300	A36S
1423-3199	4-1/2" x 1/8" x 7/8"	13,300	A36S
1423-3153	4-1/2" x 1/4" x 7/8"	13,300	A36S
1423-2188	4-1/2" x 1/4" x 7/8" (5 pc./Pk)	13,300	A24R
1423-2189	5" x 1/4" x 7/8"	12,000	A24R
1423-2191	9" x 1/4" x 7/8"	6,500	A24R
With Hubs:			
1423-3201	4 1/2" x 1/8" x 5/8"-11NC	13,300	A24R
1423-2232	4 1/2" x 1/4" x 5/8"-11NC	13,300	A24R
1423-3203	7" x 1/8" x 5/8"-11NC	8,500	A24S
1423-2190	7" x 1/4" x 5/8"-11NC	8,500	A24S
1423-2192	9" x 1/4" x 5/8"-11NC	6,500	A24S





#### Techniques/Tips for proper Firepower Grinding Wheels:

- 1. Use this method to achieve the desired aggressiveness of stock removal and quality finish - for fast material removal increase the grinding angle between the wheel and the workpiece. For blending and finishing decrease the grinding angle and apply light pressure in a fluid motion.
- For maximum efficiency, Type 27 Depressed Center Wheels should be used with a approach angle of 30°-35° to the workpiece.
- 3. Material being cut or ground should always be clamped or securely positioned, especially in cutting-off operations.
- 4. Proper machine speed is essential for maximum efficiency. Low speed causes "Jumping" of the disc, and can cause the circumference to wear unevenly.
- 5. Only flat cut-off wheels can be brushed, not depressed center wheels. Only 7/8" arbors can be made to 5/8"-11.



# **Cut-Off Abrasive Wheels, Type 1 (For Metal)**

Firepower Double Reinforced Cut-Off Wheels are designed for heavy duty cut-off jobs using circular saws, chop-saws and straight grinding machines. They ensure optimum effectiveness for dry applications on a broad range of ferrous and non-ferrous metals, soft ceramics, masonry materials, reinforced plastic and fiber glass. Most Firepower cut-off wheels are double reinforced with two layers of fiber glass.

	l <b>.</b>		1
<u> Model</u>	Size	Max. RPM	Grade
Type 1, Abrasi	ve Cut-Off Wheels:		
1423-3149	3" x 1/32" x 3/8"	25,000	A60T2FG
1423-3181	3" x 1/32" x 3/8" (5 pc./Pk)	25,000	A60T2FG
1423-3142	3" x 1/16" x 1/4"	25,000	A46T2FG
1423-3143	3" x 1/16" x 3/8"	25,000	A46T2FG
1423-3155	3" x 1/16" x 3/8" (5 pc./Pk)	25,000	A46T2FG
1423-2178	3" x 1/16" x 3/8" (10 pc./Pk)	25,000	A46T2FG
1423-3208	3" x 1/8" x 1/4"	25,000	A46T2FG
1423-3144	3" x 1/8" x 3/8"	25,000	A46T2FG
1423-2180	3" x 1/8" x 3/8" (5 pc./Pk)	25,000	A46T2FG
1423-3150	4" x 1/32" x 3/8"	18,000	A60T2FG
1423-3182	4" x 1/32" x 3/8" (5 pc./Pk)	18,000	A60T2FG
1423-3145	4" x 1/16" x 3/8"	18,000	A46T2FG
1423-3147	4" x 1/16" x 5/8"	18,000	A46T2FG
1423-3157	4" x 1/16" x 5/8" (5 pc./Pk)	18,000	A46T2FG
1423-3146	4" x 1/8" x 3/8"	18,000	A46T2FG
1423-3148	4-1/2" x 1/16" x 7/8"	13,300	A46T2FG
1423-3184	4-1/2" x 1/16" x 7/8" (5 pc./Pk)	13,300	A46T2FG
1423-3185	4-1/2" x 1/8" x 7/8"	13,300	A46T2FG
1423-3188	6" x .045" x 7/8"	10,200	A60T2FG
1423-3211	6" x 1/16" x 5/8"	10,200	A60T2FG

### **Use Tips for Firepower Cut-Off Wheels:**

- 1. When using cut-off wheels, a soft pressure should be used for initial contact with the workpiece cutting should be done with even constant pressure.
- 2. For stationary cut-off machinery, it is important to have good stability and steadiness to prevent vibration. Also, the motor should be powerful enough to keep the cutting time as short as possible to prevent burning or discoloring the material
- 3. Material being cut or ground should always be clamped or securely positioned, especially in cutting-off operations.
- 4. Proper machine speed is essential for maximum efficiency. Low speed causes "Jumping" of the disc, and can cause the circumference to wear unevenly.
- 5. Flat cut-off wheels can be brushed, if required.



### **Cut-Off and Chop-Saw Abrasive Wheels, Type 1 (for metal)**

- · Single reinforced cut-off wheels are recommended for stationary Chop-Saws only
- 7" (175mm) diameter wheels are equipped with Diamond Center hole for easymounting on portable circular saws

Model	Size	Max. RPM	Grade	
Large - Type 1	Large - Type 1, Abrasive Cut-Off Wheels:			
1423-2213	7" x 1/8" x 5/8" Diamond Hole	8,500	A36S 2FG	
For Stationary	Chop-Saws Only:			
1423-2305	10" x 1/8" x 5/8"	6,100	A36S 2FG	
1423-3189	10" x 3/32" x 1"	6,100	A46S 1FG	
1423-2197	12" x 3/32" x 1"	5,100	A46S 1FG	
1423-2198	14" x 3/32" x 1"	4,400	A46S 1FG	
For Portable High Speed Chop-Saws:				
1423-3191	12" x 5/32" x 1"	6,300	A36S 2.5FG	
1423-3193	14" x 5/32" x 1"	5,400	A36S 2.5FG	



### Firepower Cut-Off Wheel Safety and Cutting Procedures:

- 1. Cut-off wheels should never be stored on edges. They should be laid on a solid flat surface and away from excessive heat to prevent warpage.
- 2. Machines must have adequate power transmission and capacity, spindle speeds and proper guarding of the wheel. It is best to have extra power to insure good cutting efficiency. Check the speed of the machine spindle against the maximum speed specified for the wheel by the manufacturer. The maximum specified speed for the wheel should never be exceeded.
- 3. Flanges should be clean, straight and of the same diameter, so the wheel can turn true. For wheel diameters above 10" (250mm) it is highly recommended that the flange be a least 1/3 the diameter of the wheel.
- 4. The bore size of the wheel is so constructed that the wheel should fit freely on the machine spindle without any slack. Never attempt to force a wheel on the spindle! Always use blotters, when supplied with the wheel. Be sure the flanges are tightened securely but not too tightly to avoid springing the flanges and change the pressure area.
- 5. Be sure work-piece is securely held down, including both sides of the cut, if practical. Cut-off wheels withstand a great deal of radial stress but not any side stress. Even reinforced wheels are not completely unbreakable. Side pressure must be avoided to insure straight cuts and avoid possible wheel breakage. The wheel must be brought into contact with the work without "Bumping" or impact. The wheel should cut freely without forcing and the speed of the wheel should not be reduced by the cutting operation.
- 6. Abrasive cutting generates a great deal of localized heat, which causes rapid expansion of the piece being cut. Wheels operated at speeds significantly below efficient speed or if fed through the cut to slowly will generate excessive heat. Result: rapid wheel wear, fraying around the edge of reinforced wheels and wheel breakage. Always use at the "efficient speed" as specified for the wheel by the manufacturer.



### **Mandrel Set**

- Made of high strength alloy steel
- Ideal for small diameter cut-off wheels with a thickness of 1/32" to 1/4"



Model No.	Size
1423-2185	For 1/4" & 3/8" Arbors, with 1/4" Shank

# **Mounting Points**

- Offer maximum performance for grinding of ferrous and non-ferrous metals. For use with horizontal or straight shaft, die and pencil grinders on jobs where larger cones and plugs won't fit
- Excellent for medium to heavy duty applications in metal fabrication, foundries, steel mills. Used for grinding ferrous and non-ferrous metals
- Ideal for rapid stock removal on high alloy steel, castings and special steel

	Type &	Size		
Model	Shape	(Dia. x Length x Shank)	Max. RPM	
1423-2202	A11	7/8" x 2-3/4" x 1/4"	19,000	_





# **Bench Grinding Wheels, Type 1**

- Wheels are individually precision balanced, trued and faced for smooth operation
- Each wheel is individually boxed so they stay clean and undamaged until use
- Designed for versatile off-hand grinding in deburring barstock after cutting and touching up, reconditioning and sharpening tools where precision grinding is not required
- Grinding is done on the wheel periphery only
- Aluminum oxide wheel grinds metal of high tensile strength, like steel and steel alloy

Model	Size	Grit	
1423-2311	6" x 3/4"	36	
1423-2310	6" x 3/4"	60	
1423-2312	6" x 3/4"	80	





### Safety First - Always Grind Safely!

Always ensure grinding wheels and machines are in good working condition. Damaged or improperly used grinding wheels are dangerous. Machine guards are for protection - use them. Wear adequate personal protection. All Firepower abrasives are manufactured under rigid quality conditions to ensure product strength and safety. However, approved guards and protective equipment, such as, impact resistant safety glasses, full face shield, safety shoes, arm guards, leather gloves and apron must be used for operator protection for all grinding operations. always wear a respirator to avoid inhalation of dust particles. For information on product safety, please ask us for ANSI B7.1 "Safety Requirements for the use, Care and Protection of Abrasive Wheels".



### Flap Discs Zirconia, Type 29

Firepower flap discs durability over the conventional fibre disc results in reduction of both labor and material costs. They are designed to wear away evenly and present a constantly fresh working surface.

- Cut and finish at the same time with consistent finish for coarse and intermediate grinding and machining of welds, deburring, rust removal, snagging, removal of paint, etc. This means fewer change-overs
- Suitable for almost all materials: ferrous and non-ferrous metals, wood, leather, glass, marble and plastics
- No loading-up, as new sharp abrasive particles are constantly exposed
- No backing pad required comes with fiberglass backing plate with higher RPM rating than resin fiber discs



 We recommend using the following grit sizes to attain a maximum stock removal rate

Grit 36\*: For all alloyed and low-alloyed steels

Grits 60 & 80\*: For high alloyed steel, stainless steel, high-temperature and heat treatable steel and high tensile, non-ferrous metals

- \* A coarser grit offers the advantage of a higher stock removal rate and service life
- Firepower flap discs have the ideal operating angle of 10°. This allows for maximum use of the laminates and guarantees optimum stock removal produced by a continuously free cutting abrasive.
- Excessive pressure leads to a higher wheel-wear, without increasing performance

### Safety First - Always Grind Safely!

To avoid injury always wear impact-resistant protective glasses, full face shield, safety shoes, arm guards, leather gloves and apron for all grinding operations.

For Abrasive Disc Grinding:

- 1. Never use a larger diameter disc than specified by manufacturer
- 2. Never exceed maximum RPM
- 3. Check for concentricity
- 4. Always check for snug fit and full-thread contact
- 5. Always use grinders safety pad
- 6. Always check spindle for wobble
- 7. Always check disc retainer nut for thread wear





Model	Grit	
4 1/2" x 7/8" (with	out Hub):	
Max RPM: 13,300		
1423-3162	ZA 36	
1423-3163	ZA 60	
1423-3164	ZA 80	
4 1/2" x 5/8"-11N0	C (with Hub):	
Max RPM;13,300		
1423-2220	ZA 36	
1423-2221	ZA 60	



# **Resin Fiber Sanding Disks and Hand Pads**

Firepower resin fibre discs have the best combination of the highest quality aluminum oxicide grains and heavy-duty vulcanized fibre-cloth backing bonded with strong, heat resistant resin

- Excellent for removing rust, oxides and surface imperfections
- Maximum performance on portable right angle grinders
- Firepower resin fibre discs should be mounted on a rubber backing pad, for optimum performance

Model	Grit
5" x 7/8" (3 Pc./	Pack):
Max RPM: 11,00	0
1423-2164	A.C 24
1423-2165	A.C 36
1423-2166	A.C 50
7" x 7/8" (3 Pc./	•
Max RPM: 7,600	
1423-2171	A.C 24
1423-2172	A.C 36
1423-2173	A.C 50



### Safety First - Always Grind Safely!

To avoid injury always wear complete body protection at all times: Impact-resistant protective glasses, full face shield, safety shield, safety shoes, arm guards, leather gloves and apron for all grinding operations. Always wear a respirator to avoid inhalation of dust particles. Persons entering an area where grinding is taking place, must always wear adequate and approved face and body protection.

For Abrasive Disc Grinding:

- 1. Never grind without a proper back-up pad
- 2. Never use larger diameter disc than specified by the manufacturer
- 3. Never use back pad without first inspecting it for signs of irregularities such as fractures, excessive wear, nicks, cuts at the edges or the centre hole.
- 4. Always check the pad for concentricity. Always check the grinder spindle for wobble, Always check the disc retainer nut for thread wear. Install the pad on the tool securely. Check for snug fit and three thread contact.
- 5. Direct grinding sparks downward and away from the face and body. Do Not Grind near any flammable material.
- 6. Never use another grinding disc as a back-up pad.
- 7. Never exceed maximum RPM.
- 8. Always use the grinders safety pad.
- 9. Operate grinder with disc and pad inclined approximately 5°-15° from the work surface. Grind depressions, moulding, lips and heavy welds with the grinder moving away from the work area and not into it. Avoid grinding near the edge, corner or projections that can snag the edge of the pad or disc.
- 10. Always observe all safety recommendations supplied by the equipment manufacturer.



# **Quick Change and Surface Conditioning Discs, Type III**

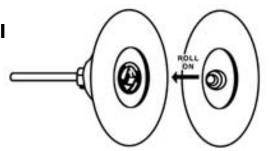
- Provide low vibration, less tool down time, and longer disc life
- Designed for quick disc and grit changes
- These time saving discs are quickly and firmly mounted on a special reusable 1/4" mandrel
- Surface conditioning discs provide superior performance for: Scratch removal, Removing flash, rust and oxidation, light deburring, blending welds, blending and conditioning metal surfaces and removing heat discoloration
- Maximum RPM: 5,000

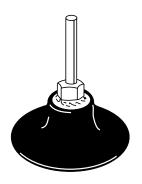
Model	Grit/Color	Туре	Pcs./Pk.	
1423-2140	Brown	Coarse	10	
1423-2141	Maroon	Medium	10	
Surface Condition Discs. 3"				

irrace Condition Discs, 3

1423-2143

3" x 1/4" Shank









### **Mounted Flap Wheels**

Firepower flap wheels are constructed of hundreds of resin bonded cloth abrasive sheets firmly attached to a balanced core. During use, each flexible sheet adapts quickly to the contours of the workpiece - continuously exposing fresh, sharp grit for extended product life. The controllable aggressiveness, working speed, and low cost of the wheels make them superior to wire brush, grit-impregnated plastic, fibrous and setup wheels in a wide range of applications.

Model Mounted Flap \	Wheel Dimensions	Grit	Max.RPM
Mounteu Flap	Wileels		
1423-2160	1" x 1" x 1/4"	60	25,000
1423-2161	1" x 1" x 1/4"	80	25,000
1423-2157	1-1/2" x 1/2" x 1/4"	60	25,000
1423-2158	1-1/2" x 1/2" x 1/4"	80	25,000
1423-2254	1-1/2" x 1/2" x 1/4" (5 pc./Pack)	80	25,000
1423-2255	1-1/2" x 1/2" x 1/4" (5 pc./Pack)	120	25,000
1423-2151	3" x 1" x 1/4"	60	18,000
1423-2152	3" x 1" x 1/4"	80	18,000



### Tips for Firepower Abrasive Flap Wheels:

- 1. Make sure flap wheel is run in correct direction of rotation. For automatic in-feeding of workpiece, the direction of flap wheel rotation should be contrary to the feed direction.
- 2. For a given finish, choose a grit one or two sizes coarser compared to abrasive belts.
- 3. Coarse grit sizes used at high speeds work finer. Fine grit sizes used at lower speeds work coarser.
- 4. Grinding oil or grease may be used for improved finish and the flap wheel life.
- 5. Use light pressure at low speeds, added pressure at high speeds. Do Not use excessive pressure or allow the flaps to bend back to far. If more stock removal is necessary, choose a coarser grit.
- Abrasive flap wheels can be shaped to fit contours and other configurations by using a file, abrasive stone, or other cutting tool to cut the mop face. Always use proper safety equipment.
- 7. Make sure that mounting plates are of the proper size and are correctly fitted when used. Never over tighten fastening nuts or hub damage may result. Always use proper machine guards.







### **World Class Service**

Thermadyne prides itself not only on premier products, but on world class customer service as well. Should you have any questions on our products, please call **800-858-4232**. Dedicated Thermadyne Specialty Markets Customer Care associates are available 5 days a week (M-F) from 8 AM to 5 PM Central Time. General information including a directory of service centers and product literature can be accessed 24 hours a day on our website, **www.thermadyne.com** 

### **Duty Cycle Explanation**

The duty rating defines how long the machine can be used before work must be stopped, in order to let the machine cool down. Duty cycle ratings are expressed as a percentage of a ten-minute period. It represents the maximum welding and cutting time allowed at the specified amperage setting. The remaining balance of the ten-minute period is required for cooling down the machine. For example, if the machine has a 40% duty cycle at 150 amps it can weld up to 4 minutes and then needs to cool off for the remaining 6 minutes. If a machine is operated below its rated output, the duty cycle typically increases.

# **Welding Tips**

- Keep the torch handle at a 45° angle with respect to the metal. Maintain the nozzle about 1/4" (0.6mm) from the surface.
- Move the torch handle with prudence and steadiness.
- Avoid MIG welding in areas with too much draft. Too much draft blows away the shielding gas from the weld pool and may cause porosity in the weld.
- Keep the wire and its cover clean. DO NOT use rusted wire.
- Avoid sharp bends and kinks on the MIG gun cable.
- If possible, clean the wire liner with compressed air when replacing the wire spool.
- Periodically, remove the dust using low pressure air or nitrogen (2-3 Bar/30-45 PSI) from the inside of the power source, to assure adequate heat dissipation from power source during operation.



### STATEMENT OF WARRANTY

(as of March 15, 2009)

**LIMITED WARRANTY:** THERMADYNE warrants that its products will be free of defects in workmanship or material. Should any failure to conform to this warranty appear within the time period applicable to the THERMADYNE products as stated below, THERMADYNE shall, upon written notification thereof and substantiation that the product has been stored, installed, operated, and maintained in accordance with THERMADYNE's specifications, instructions, recommendations and recognized standard industry practice, and not been subject to misuse, repair, neglect, alteration, or accident, correct such defects by suitable repair or replacement, at THERMADYNE's sole option, of any components or parts of the product determined by THERMADYNE to be defective.

# THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

**LIMITATION OF LIABILITY:** THERMADYNE shall not under any circumstances be liable for special, indirect or consequential damages, such as, but not limited to, damage or loss of purchased or replacement goods, business interruption or loss of profit, or claims of customers of distributor (hereinafter the "Purchaser") for service interruption. The remedies of the Purchaser set forth herein are exclusive and the liability of THERMADYNE with respect to any contract, or anything done in connection therewith such as the performance or breach thereof, or from the manufacture, sale, delivery, resale, or use of any goods covered by or furnished by THERMADYNE whether arising out of contract, negligence, strict tort, or under any warranty, or otherwise, shall not, except as expressly provided herein, exceed the price of the goods upon which such liability is based.

# THIS WARRANTY BECOMES INVALID IF REPLACEMENT PARTS OR ACCESSORIES ARE USED WHICH MAY IMPAIR THE SAFETY OR PERFORMANCE OF ANY THERMADYNE PRODUCT.

#### THIS WARRANTY IS INVALID IF THE PRODUCT IS SOLD BY NON-AUTHORIZED PERSONS.

This warranty is effective for the time stated in the Warranty Schedule beginning on the date that the authorized distributor delivers the products to the Purchaser. Warranty repairs or replacement claims under this limited warranty must be submitted by an authorized THERMADYNE repair facility within thirty (30) days of the repair. No transportation costs of any kind will be paid under this warranty. Transportation charges to send products to an authorized warranty repair

facility shall be the responsibility of the Purchaser. All returned goods shall be at the Purchaser's risk and expense. This warranty supersedes all previous THERMADYNE warranties.

### **WARRANTY SCHEDULE**

The warranty is effective below for the time stated in the Warranty Schedule beginning on the date that the authorized distributor delivers the products to the purchaser. THERMADYNE reserves the right to request documented evidence of date of purchase.

GAS WELDING AND CUTTING EQUIPMENT	Parts / Labor
Victor® Professional	5 years / NA
Victor CutSkill®	2 years / NA
Victor FirePower®	1 year / NA
Victor VSP	2 years / NA
Aluminum Cylinders	10 years / NA
Steel Cylinders	1 year / NA
TurboTorch®	3 years / NA
Transformers	5 years / NA
Parts Used in Rental Applications	1 year from date sold by seller to authorized distributor

ARC ACCESSORIES, ARC GOUGING & SLICE EQUIPMENT	Parts / Labor
TC and TCV Water Coolers	1 year / NA
TSC-96 Smoke Collector	1 year / NA
ESG-1, EPG-CR1, EPG-CR2 Control Boxes for Eliminator Spool & Pull Guns	1 year / NA
Eliminator® Spool and Pull Guns	90 days / NA
PulseMaster™ MIG Guns & PullMaster™ Pull Guns	90 days / NA
All other products 30 days from date of purchase including but not limited to:	30 days / NA
MIG Guns     Arc Gouging Equipment     Slice Equipment	

PLASMA CUTTING SYSTEMS	Parts / Labor
CUTMASTER® TRUE™ Series	4 years / 4 years
CUTMASTER 1Series™	3 years / 3 years
AirCut™ 15C	1 year / 1 year
Drag-Gun® Plus	2 years / 1 year
Drag-Gun	1 year / 1 year
PAK® 200	2 years / 1 year
Torches	1 year / 1 year
Consoles, Control Equipment, Heat Exchangers and Accessory Equipment	1 year / 1 year



# **WARRANTY SCHEDULE**

(as of March 15, 2009)

The warranty is effective below for the time stated in the Warranty Schedule beginning on the date that the authorized distributor delivers the products to the purchaser. THERMADYNE reserves the right to request documented evidence of date of purchase.

Fabricator® 140, 180, 190, 210, 251, 281; Fabstar® 4030; PowerMaster® 350, 350P, 500, 500P, 320SP, 400SP, 500SP; Excel-Arc® 6045; Wire Feeders: Ultrafeed®, Porta-feed® Original Main Power Transformer and Inductor Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  GTAW (TIG) & MULTI-PROCESS INVERTER WELDING EQUIPMENT Parts / Labor  160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP Original Main Power Magnetics Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Original Main Power Transformer and Inductor Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  GTAW (TIG) & MULTI-PROCESS INVERTER WELDING EQUIPMENT Parts / Labor  160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP Original Main Power Magnetics Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors  All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  GTAW (TIG) & MULTI-PROCESS INVERTER WELDING EQUIPMENT  160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP Original Main Power Magnetics  Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors  All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Switches, Contactors, Solenoids, Fans, Electric Motors  GTAW (TIG) & MULTI-PROCESS INVERTER WELDING EQUIPMENT  160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP  Original Main Power Magnetics  Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors  All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
160TS, 300TS, 400TS, 185AC/DC, 200AC/DC, 300AC/DC, 400GTSW, 400MST, 300MST, 400MSTP Original Main Power Magnetics Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
300MST, 400MSTP Original Main Power Magnetics Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Original Main Power Rectifiers, Control P.C. Boards, Power Switch Semi-Conductors  All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Switches, Contactors, Solenoids, Fans, Electric Motors  SMAW (Stick) WELDING EQUIPMENT  Parts / Labor	
Dragster™ 85; 95S	
Original Main Power Magnetics 1 year / 1 year	
Original Main Power Rectifiers, Control P.C. Boards 1 year / 1 year	
All Other Original Circuits and Components Including, but not Limited to, Relays,  Switches, Contactors, Solenoids, Fans, Power Switch Semi-Conductors	
Original Main Power Magnetics 5 years / 3 years	
Original Main Power Rectifiers, Control P.C. Boards 3 years / 3 years	
All Other Original Circuits and Components Including, but not Limited to, Relays, Switches, Contactors, Solenoids, Fans, Power Switch Semi-Conductors  1 year / 1 year	
GENERAL ARC EQUIPMENT Parts / Labor	
FirePower® MIG Welders 5-2-1 years / NA	
Water Recirculators 1 year / 1 year	
Plasma Welding Torches 180 days / 180 days	'S
Gas Regulators (Supplied with Power Sources) 180 days / NA	
MIG and TIG Torches (Supplied with Power Sources)  90 days / NA	
Replacement Repair Parts 90 days / NA	
MIG, TIG and Plasma Welding Torch Consumable Items  NA / NA	

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