PRODUCT CATALOGUE

Welding & Cutting
EQUIPMENT

2021

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OERLIKON

CITOSTEEL S RANGE

Reliable Workhorses

CITOSTEEL S RANGE
i355S, i425S, i505S

- Complete solution for **Industrial** users
- New **heavy duty design**
- Innovative User Interface with **ArcFX™** technology
- Low energy consumption compliant with upcoming **ECO design** regulations
- Optional **Cool Arc®26** supports water cooled guns

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PICTOGRAM MEANING

1 PHASE	Single phase input power	CC	For constant current stick and TIG processes	15-110 VDC	15-110 Volt DC Wire feeder input power	S300	Plastic spool S300	D	Engine Driven: Diesel
3 PHASE	Three phase input power	CV	For constant voltage MIG, flux-cored and subarc processes	40 VDC	40 Volt DC Wire feeder input power	S200	Plastic spool S200	GENERATOR READY	Motor generator compatible
1/3 PHASE	Single or three phase input power	CC CV	For multi-process constant current or constant voltage applications	115V	115 Volt input	SYN SYNERGIC SETTINGS	Synergic setting	INTERNAL COMPRESSOR	Internal Compressor
DC	Direct current welding output	24-42 VAC	24-42 Volt AC Wire feeder input power	230V	230 Volt input	PFC	Power factor control	LONG : 70 m SECTION : 3 x 2.5 mm²	Cable length: 70 m
AC DC	Alternating or direct current welding output	34-44 VAC	34-44 Volt AC Wire feeder input power		CrossLinc® Technology		2-Roll Wire Feeder	WATER COOLING	Water Cooling
50/60 Hz	50/60 Hz input power	42 VAC	42 Volt AC Wire feeder input power	STT	STT process capability		4-Roll Wire Feeder		

MIG CONVENTIONAL

OVERVIEW

MIG CONVENTIONAL

MODEL	REFERENCE	INPUT		OUTPUT			PROCESS				FEATURES				
		Phase (50/60Hz)	Voltage (V)	Rated Output (A)	Current Range (A)	Number of voltage steps	Mode / Polarity	MIG	Flux-Cored	Max wire spool size (mm)	Wire Drive System	WFS (m/min)	Synergic	V/A metres	Warranty (years)
MIG Compact															
CITOSTEP 255C	W000403587	3	230/400	250A35%	25-250	20	CV/DC	•	•	300	2R	1-20	–	KIT	3
CITOSTEP 305C	W000403588	3	230/400	300A/35%	30-300	30	CV/DC	•	•	300	4R	1-20	–	KIT	3
CITOSTEP 355C	W000403589	3	230/400	350A/40%	30-350	30	CV/DC	•	•	300	4R	1-20	•	•	3
MIG Separate															
CITOSTEP 355S	W000403592	3	230/400	350A/40%	30-350	30	CV/DC	•	•	–	–	–	•	–	3
CITOSTEP 425S	W000403593	3	230/400	420A/40%	30-420	30	CV/DC	•	•	–	–	–	•	–	3
CITOSTEP 505S	W000404225	3	230/400	500A/40%	30-500	30	CV/DC	•	•	–	–	–	•	–	3

• – only with WF 24S

CITOSTEP 255C, 305C

Powerful, compact, economical.

WARRANTY 3 YEARS

- Excellent starting performance (stable and dynamic).
- Voltage selectors with multiple settings for precise adjustment.
- Excellent drive system with large diameter drive roll.
- Equipped with large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.
- Products developed with a focus on applications.

Processes

MIG, Flux-cored

Applications

- General Fabrication
- Construction site
- Maintenance and Repair
- Light industry

Input

3 PHASE, 50/60 Hz

Output

CV, DC

S300, GENERATOR READY

UNIT INCLUDES

Undercarriage
Input cable (5 m), no plug
Work clamp and cable assembly (3 m)
Gas hose (2 m)
Drive roll for solid wire 0,8 / 1,0

Product	Reference	Primary Voltage (50-60 Hz)	Fuse Size (A) (slow)	Rated Output (A)	Wire Drive System	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEP 255C	W000403587	230/400V/3Ph	25/16	250A/26,5V/35%	2R	95	810 x 467 x 932	IP23
CITOSTEP 305C	W000403588		32/20	300A/29V/35%, 225A/25,2V/60%	4R	96,5		

CITOSTEP 355C

Premium arc, synergic style.

WARRANTY 3 YEARS

- Superb arc behavior with argon mix and 100% CO_2.
- Synergic settings for easier control.
- Voltage selectors with multiple settings for precise adjustment.
- Excellent drive system (four rolls) with large diameter drive roll and powerful motor.
- Bright, digital volt and ammeter.
- Large diameter wheels, push/pull bar and lifting eyes for full manoeuvrability.

Processes

MIG, Flux-cored

Applications

- General Fabrication
- Construction site
- Maintenance and Repair
- Light industry

Input

3 PHASE, 50/60 Hz

Output

CV, DC, SYN SYNERGIC SETTINGS

S300, GENERATOR READY

UNIT INCLUDES

Undercarriage
Input cable (5 m), no plug
Work clamp and cable assembly (3 m)
Gas hose (2 m)
Drive roll for solid wire 1,0 / 1,2

Product	Reference	Primary Voltage (50-60 Hz)	Fuse Size (A) (slow)	Rated Output (A)	Synergic	Wire Drive System	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEP 355C	W000403589	230/400V/3Ph	40/25	350A/31,5V/40%, 285A/28,2V/60%	•	4R	147	890 x 565 x 1040	IP23

SEPARATE

CITOSTEP 355S, 425S, 505S

Powerful potential.

- Superb arc behavior with argon mix and 100% CO_2.
- Voltage selectors with multiple settings for precise adjustment.
- Two choke tabs to support superb Arc behavior.
- Synergic settings for easier control with WF 24S.
- Bright, digital volt and ammeter with WF 24 and WF 24S.
- Large diameter wheels, push/pull bar and lifting eyes.
- Simple water cooling convertion with COOLER 25.
- Fan as needed (F.A.N.™).

WARRANTY 3 YEARS

Processes

MIG, Flux-cored

Applications

- Heavy Fabrication
- Structural
- General Fabrication
- Shipbuilding

Input

3 PHASE, 50/60 Hz

Output

CV, DC

SYN* SYNERGIC SETTINGS, GENERATOR READY

* with WF 24S

UNIT INCLUDES
Undercarriage
Input cable (5 m), no plug
Work clamp and cable assembly (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Fuse Size (A) (slow)	Rated Output (A)	Synergic	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEP 355S	W000403592	230/400V/3Ph	40/25	350A/31,5V@40%, 285A/28,2V@60%	•	141	880 x 700 x 1030	IP23
CITOSTEP 425S	W000403593		50/32	420A/35V@40%, 345A/31,5V@60%		151		
CITOSTEP 505S	W000404225		63/40	500A/39V@40%, 400A/34,5V@60%		159,5		

• – only with WF 24S

COMPATIBLE FEEDERS *

Product	Reference	CITOSTEP 355	CITOSTEP 425S	CITOSTEP 505S
WF 24	W000403599	•	•	•
WF 24S	W000403600	•	•	•

* see chapter "SEMI-AUTOMATIC WIRE FEEDERS" for details

Description	CITOSTEP 255C	CITOSTEP 305C	CITOSTEP 305C PRO	CITOSTEP 355C	WF 24	WF 24S
LGS2 250 G	●					
LGS2 240 G	●					
PROMIG NG 241	●					
LGS2 360 G	●	●	●	●	●	●
PROMIG NG 341	●	●	●	●	●	●
PROMIG NG 441	●	●	●	●	●	●
PROMIG NG 241W					●	●
PROMIG NG 341W					●	●
PROMIG NG 441W					●	●
LGS2 505 W					●	●
PROMIG NG 450W					●	●
PROMIG NG 501W					●	●

PROMIG NG 181 T

LGS2 360G

PROMIG NG 450W

LGS2 150G

PROMIG NG 341

LGS2 505W

	Reference									
	141T	181T	241	341	441	241 W	341 W	441 W	450 W	501 W
3 m	W000275406	W000275408	W000345060	W000345066	W000345072	W000345063	W000345069	W000345075	W000274865	–
4 m	W000275407	W000275419	W000345061	W000345067	W000345073	W000345064	W000345070	W000345076	W000274866	W000274871
5 m	–	W000275420	W000345062	W000345068	W000345074	W000345065	W000345071	W000345077	W000274867	–

	Reference				
	LGS2-150G	LGS2-250G	LGS2-240G	LGS2-360G	LGS2-505W
3 m	W10429-15-3M	W10429-25-3M	W10429-24-3M	W10429-36-3M	W10429-505-3M
4 m	W10429-15-4M	W10429-25-4M	W10429-24-4M	W10429-36-4M	W10429-505-4M
5 m	W10429-15-5M	W10429-25-5M	W10429-24-5M	W10429-36-5M	W10429-505-5M

Choose your gun

rating calculated using CO_2

air cooled
water cooled

MORE DETAILS PAGE 59

ACCESSORIES

Product	Reference	CITOSTEP 255C	CITOSTEP 305C	CITOSTEP 355C	CITOSTEP 355S	CITOSTEP 425S	CITOSTEP 505S	WF 24	WF 24S
Water cooler COOLER 25	W000403601				●	●	●		
Freezcool 9,6l	W000010167				●	●	●		
Interconnection cables AIR	K10347-PG-xM *				●	●	●	●	●
Interconnection cables WATER	K10347-PGW-xM *				●	●	●	●	●
Drive roll kit (2R)	KP14016-x *	●	●						
Drive roll kit (4R)	KP14017-x *		●	●				●	●
DR system kit (grill)	K14071-2				●	●	●		
Spool adapter 300 mm (15 kg)	K10158	●	●	●				●	●
Spool adapter 300 mm (15 kg)	K10158-1	●	●	●				●	●
HD wheels kit	K14032-1							●	●
A/V Meter kit	K14049-1	●	●						
CO_2 supply socket heater connection kit	K14009-1	●	●	●	●	●	●		
Polarity change kit	K14077-1	●	●						

* see chapter "Options" for details

COOLER 25
W000403601

FREEZCOOL
W000010167

INTERCONNECTION CABLE
K10347-PG(W)-XM

DRIVE ROLL KIT Ø 37 mm
KP14016-XX
KP14017-XX

SPOOL ADAPTER 300 mm (15 KG)
K10158

SPOOL ADAPTER 300 MM (15 KG)
K10158-1

MIG & MULTI PROCESS INVERTER WELDERS

MIG & MULTI PROCESS INVERTER WELDERS

		INPUT		OUTPUT			PROCESS								FEATURES				
MODEL	REFERENCE	Phase (50/60 Hz)	Voltage (V)	Rated Output (A)	Current Range (A)	Mode	Polarity	GMAW	PULSE	FCAW-G	FCAW-S	SMAW	CAG (Gouging)	DC TIG Lift	Wire Drive System	Max wire spool size (mm)	Synergic	V/A metres	Warranty (years)
MIG Inverter Welders																			
CITOSTEEL 250C	W100000096	3	400	250A/60%	10-250	CC/CV	DC	•		•	•	•			4R	300		•	3
CITOSTEEL 320C	W100000098	3	400	320A/40%	10-320	CC/CV	DC	•		•	•	•			4R	300		•	3
CITOSTEEL 250C PRO	W100000097	3	400	250A/60%	10-250	CC/CV	DC	•		•	•	•			4R	300	•	•	3
CITOSTEEL 320C PRO	W100000099	3	400	320A/40%	10-320	CC/CV	DC	•		•	•	•			4R	300	•	•	3
CITOSTEEL 380C PRO	W100000100	3	400	380A/40%	10-380	CC/CV	DC	•		•	•	•			4R	300	•	•	3
CITOSTEEL 450C PRO	W100000101	3	400	450A/80%	10-450	CC/CV	DC	•		•	•	•	•		4R	300	•	•	3
CITOSTEEL 355S	W000404457	3	400	350A/50%	20-350	CC/CV	DC	•		•	•	•	•				•		3
CITOSTEEL 425S	W000404458	3	400	420A/100%	20-420	CC/CV	DC	•		•	•	•	•				•		3
CITOSTEEL 505S	W000404459	3	400	500A/60%	20-500	CC/CV	DC	•		•	•	•	•				•		3
Multi Process Inverter Welders																			
CITOMIG 185MP	W000403579	1	230	200A/25%	20-200	CC/CV	DC	•		•	•	•		•	2R	200			2
CITOMIG 210MP	W000403578	1	115/230	200A/25%	20-200	CC/CV	DC	•		•	•	•		•	2R	200	•	•	2
CITOPULS III 320C	W000385051	3	400	320A/40%	15-320	CC/CV	DC	•	•	•	•	•			4R	300	•	•	3
CITOPULS III 420	W000383663	3	400	420A/60%	15-420	CC/CV	DC	•	•	•	•	•	•				•	•	3
CITOPULS III 520	W000383664	3	400	500A/60%	15-500	CC/CV	DC	•	•	•	•	•	•				•	•	3

ADVANCED PROCESS WELDERS

		INPUT		OUTPUT			PROCESS								FEATURES				
MODEL	REFERENCE	Phases	Voltage (V)	Rated output	Current range	Mode	Polarity	GMAW	PULSE	FCAW-G	FCAW-S	SMAW	Gouging	DC TIG Lift	Wire Drive System	Max wire spool size (mm)	Synergic	V/A metres	Warranty
Advanced Process Welders																			
CITOWAVE III 420	W000384991	3	400	420A/60%	15-420	CC/CV	•	•	•	•	•	•	•	•	4R	300	•	•	3
CITOWAVE III 520	W000384992	3	400	500A/60%	15-500	CC/CV	•	•	•	•	•	•	•	•	4R	300	•	•	3

CITOSTEEL 250C & 320C

MIG welder ready for tomorrow.

WARRANTY 3 YEARS

- Premium arc performance with repeatable arc ignition, excellent arc stabillity and rapid parameter adjustment.
- MIG/MAG and STICK process.
- Innovative, intuitive interface: simple navigation, easy settings and process selection.
- Perfect feedability: optimized wire positioning, four driven rolls and inspection window.
- Designed with welders for welders: perfect handling, innovative and easy communication.
- Ready for the heaviest industrial conditions: developed and tested under the hardest conditions (TRUE HD) to guarantee the reliability you need.

Processes

MIG, Flux-Cored, Stick

Applications

- General Fabrication
- Construction site
- Maintenance and Repair
- Light industry

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC, S300, GENERATOR READY

UNIT INCLUDES

Input cable (5 m)
Ground cable (3 m)
Gas hose (2 m)
Rolls 1,0 / 1,2 for solid wire
USB with Operator's Manual

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Wire Feed Type / Speed Range (m/min)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEEL 250C	W100000096	400V 3Ph ±15% 50/60 Hz	16A	250A@60%, 195A@100%	10-250	4R / 1-20	67	878,3 x 560 x 934,7	IP23
CITOSTEEL 320C	W100000098		20A	320A@40%, 250A@60%, 195A@100%	10-320				

CITOSTEEL 250C & 320C PRO

MIG welder ready for tomorrow.

WARRANTY 3 YEARS

- NEW features: Date&Calendar, Speaker and stronger encoders.
- Premium arc performance with repeatable arc ignition, excellent arc stabillity and rapid parameter adjustment.
- MIG/MAG and STICK process.
- Innovative, intuitive interface: easy settings, simple navigation, multi-language.
- Fully featured Synergic and Manual MIG, Auto settings, adjustable functions, Memory, TFT 7' colour screen, USB connectivity.
- Perfect feedability: optimized wire positioning, four driven rolls and inspection window.
- Designed with welders for welders: perfect handling, innovative and easy communication.
- Ready for the heaviest industrial conditions: developed and tested under the hardest conditions (TRUE HD) to guarantee the reliability you need.

Processes

MIG, Flux-Cored, Stick

Applications

- General Fabrication
- Construction site
- Maintenance and Repair
- Light industry

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC, S300, SYN SYNERGIC SETTINGS, GENERATOR READY

NEW

UNIT INCLUDES

Input cable (5 m)
Ground cable (3 m)
Gas hose (2 m)
Rolls 1,0 / 1,2 for solid wire
USB stick with Operator's Manual

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Wire Feed Type / Speed Range (m/min)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEEL 250C PRO	W100000097	400V 3Ph ±15% 50/60 Hz	16A	250A@60%, 195A@100%	10-250	4R / 1-20	70	878,3 x 560 x 934,7	IP23
CITOSTEEL 320C PRO	W100000099		20A	320A@40%, 250A@60%, 195A@100%	10-320				

CITOSTEEL 380C PRO & 450C PRO

MIG welder ready for tomorrow.

- NEW features: Date&Calendar, Speaker and stronger encoders.
- Premium arc performance with repeatable arc ignition, excellent arc stabillity and rapid parameter adjustment.
- MIG/MAG and stick process.
- Innovative, intuitive interface: easy settings, simple navigation, multi-language.
- Fully featured Synergic and Manual MIG, Auto settings, adjustable functions, Memory, TFT 7' colour screen, USB connectivity.
- Perfect feedability: optimized wire positioning, four driven rolls and inspection window.
- Water version: ready to connect COOL ARC® 26 cooler.
- Designed with welders for welders: perfect handling, innovative and easy communication.
- Ready for the heaviest industrial conditions: developed and tested under the hardest conditions (TRUE HD) to guarantee the reliability you need.

WARRANTY 3 YEARS

Processes

MIG, Flux-Cored, Stick, CAG (only i450)

Applications

- General Fabrication
- Construction site
- Maintenance and Repair
- Light industry

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC

S300

SYN SYNERGIC SETTINGS, GENERATOR READY

NEW

UNIT INCLUDES

Input cable (5 m)
Ground cable (3 m)
Gas hose (2 m)
Rolls 1,0 / 1,2 for solid wire
USB with Operator's Manual

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Wire Feed Type / Speed Range (m/min)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEEL 380C PRO	W100000100	400V 3Ph ±15% 50/60 Hz	25A	380A@40%, 320A@60%, 240A@100%	10-380	4R / 1-20	70	878,3 x 560 x 934,7	IP23
CITOSTEEL 450C PRO	W100000101		32A	450A@80%, 420A@100%	10-450		82		

NEW

CITOSTEEL 355S, 425S & 505S

High output, reliable industrial machine.

- Premium welding behavior on CV MIG & Stick welding.
- Ready for the heaviest industrial conditions.
- Synergic capability (with WF 56D).
- Optimized ergonomics, Lincoln reliability (True HD).
- Water cooled version (COOL ARC® 26 as an option).

WARRANTY 3 YEARS

Processes

MIG, Flux-Cored, Stick, Innershield, Gouging

Applications

- Heavy Fabrication
- Structural
- General Fabrication
- Shipbuilding

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC

GENERATOR READY

UNIT INCLUDES

Input cable (5 m)
Work clamp and cable assembly (3 m)
Gas hose (2 m)
Chain
USB stick with Operator's Manual

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Efficiency	Idle Power	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOSTEEL 355S	W000404457	400V 3Ph ±15% 50/60 Hz	25A	350A@50%, 300A@100%	20-350	> 85%	< 35W	68	932 x 560 x 925	IP23
CITOSTEEL 425S	W000404458		32A	420A@100%	20-420			78		
CITOSTEEL 505S	W000404459			500A@60%, 420A@100%	20-500			79		

COMPATIBLE FEEDERS *

Product	Reference	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S
WF 52D	W100000176	•	•	•
WF 56D	W100000177	•	•	•

* see chapter "SEMI-AUTOMATIC WIRE FEEDERS" for details

LINCOLN RELIABILITY OPTIMIZED ERGONOMICS

Gun Holder: always at hand, ready to work

Lifting eye

Front UI protection cover
keep your UI safe

Simple navigation
also when using welding gloves

Cable Management System (option)

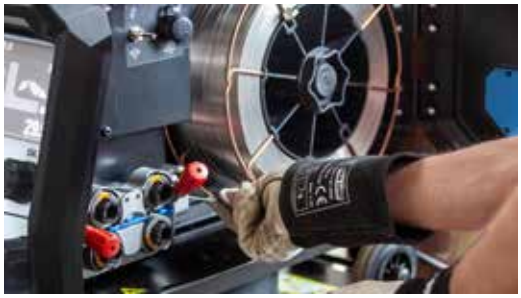
Inspection window

COOL ARC® 26
(option)

Heavy duty undercarriage with big wheels
Very solid, stable, metal made construction, low gas cylinder entry makes loading very easy.

Cable connections on front (in standard) and back rear side (in option). Strain relievers on both ends to keep connections well protected.

Rubber bumpers protecting feet



Full access for wire spool installation
Perfect feedability with 4 rolls and internal lights.

CITOMIG 185MP & 210MP

Many tasks, many locations.

- Innovative, robust, compact, portable and lightweight design ready to be used anywhere.
- Multiple Tasks CITOMIG 185MP: CV MIG, FCAW, Stick \ CITOMIG 210MP: CV MIG, CV Synergic, FCAW, Stick, TIG Lift.
- Power Factor Correction (PFC) – more welding power, energy and cost savings, generator compatible.
- User-friendly icon control panel.
- With complete two year parts and labour warranty.

WARRANTY 2 YEARS

Processes

Stick, Flux-Cored, Lift TIG (200C), MIG

Applications

- Small workshops
- Light steel construction
- General repairs
- Maintenance workshops

Input

1 PHASE, 50/60 Hz, 230V, 115V *

* only Citomig 210MP

Output

CC CV, DC, S200

PFC, GENERATOR READY

UNIT INCLUDES

Input cable (2,2 m)
Ground cable (3 m)
Gas hose (2 m)
Drive rolls (0,8-1,0 mm)

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Wire Feed Type / Speed Range (m/min)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOMIG 185MP	W000403579	230V/1Ph 50/60 Hz	16A (25A)	200/24V/25%	20-200	2R / 1,5-15	17,3	396 x 246 x 527	IP23
CITOMIG 210MP	W000403578	115/230V/1Ph 50/60 Hz							

CITOPULS III 320C

Robust and reliable, multi-process, compact, industrial inverter with Pulse mode.

- User-friendly control panel: easy settings and process selection.
- Technological advance: 99 programs that can be used with the trigger, welding cycle sequencer.
- Ready for the heaviest industrial conditions: developed and tested under the hardest conditions to guarantee the reliability you need.
- Synergic mode – more than 99 synergic programs are available for precise control of welding parameters.
- Modular concept to meet all users' requirements.

WARRANTY 3 YEARS

Processes

MIG, FCAW, Stick

Applications

- Metallic construction (on site and in workshop)
- Workshop & yard maintenance

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC, S300

GENERATOR READY

UNIT INCLUDES

Input cable (5 m)
Work clamp and cable assembly (5 m)
Gas hose (2 m)
Wire spool adapter (300 mm)

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Feeding System	WFS Range (m/min)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOPULS III 320C	W000385051	400V 3Ph ±20% 50/60 Hz	20A	320A/30V/40%	15-320	4 rolls / 37 mm	0,5-25	28	755 x 300 x 523	IP23

CITOPULS III 420 & 520

Superior quality welding with advanced processes and features.

- New inverter generation offering 30% less primary consumption regarding conventional equipment.
- User-friendly control panel: easy settings and process selection.
- More than 100 synergic lines for any base material.
- Powerful installation up to 500 A at 60%.
- Full A1 automatic interface. This level of synchronization does not require an additional card, for simpler automatisation.
- Storage of 100 welding programs (with expert wire feeder DMU P500 or advanced remote control RC JOB).
- Call programs by trigger torch.

UNIT INCLUDES
Input cable (5 m)
Work clamp and cable assembly (5 m)

WARRANTY 3 YEARS

Processes

Standard MIG/MAG, Pulsed MIG/MAG, Special arc transfer, MIG brazing, MMA coated electrodes, Gouging (up to 6,3 mm diameter electrode)

Applications

- Heavy Fabrication
- Structural
- General Fabrication
- Shipbuilding

Input

3 PHASE, 50/60 Hz

Output

CC CV, DC

Product	Reference	Input (V)	Fuse Type rG or Circuit Breaker Type Z	Rated Output (A)	Output Range (A)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOPULS III 420	W000383663	400V 3Ph 50/60 Hz ±20%	25A	420A/60%	15-420	34	525 x 295 x 720	IP23
CITOPULS III 520	W000383664		32A	500A/60%	15-500	40		

COMPATIBLE FEEDERS *

Product	Reference	CITOPULS III 420	CITOPULS III 520
DMU P400	W000275265	•	•
DMU P500	W000275915	•	•

* see chapter "SEMI-AUTOMATIC WIRE FEEDERS" for details

CITOWAVE III 420 & 520

- Outstanding welding performance.
- Technology at your service.
- Ensure your productivity.
- Experience the future.
- Opt for the high-end range.
- High level automation.

WARRANTY 3 YEARS

Processes

MIG/MAG (solid & Flux Cored Wire; Carbon Steel, Stainless steel; Aluminium; Inconel, Duplex & special wire; CuAl & CuSi wire; Ø 0,6-1,6 mm), MMA, Lift TIG (by trigger), Gouging: up to 8 mm electrod

Product	Reference	Input (V)	Rated Output (A)	Output Range (A)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOWAVE III 420	W000384991	400V ±20%	420A/60%	15-420	34	521 x 273 x 738	IP23
CITOWAVE III 520	W000384992		500A/60%	15-500	40		

COMPATIBLE FEEDERS *

Product	Reference	CITOWAVE III 420	CITOWAVE III 520
DMU W500	W000371926	•	•

* see chapter "SEMI-AUTOMATIC WIRE FEEDERS" for details

CITOWAVE III – EXPERIENCE THE FUTURE

CONNECTIVITY & MONITORING

OERLIKON intends to be a major player in the digital revolution that is currently encountered in the industry. With CITOWAVE III, a new level has been attained.

Maximum connectivity

- Compatibility USB 2,0 / Ethernet.
- Wi-Fi communication - optional.
- Part serial number management with bar code scanner. Complete Remote control through VNC Application.
- Import/Export of welding programs and customized synergic curves from a machine to another.

Digital precision

Entirely digitalized, **CITOWAVE III** provides more than 200 synergic curves developed by our engineers. It ensures outstanding welding for a wide range of combinations of materials, diameters, wire and gas.

Create and store your own curves

CITOWAVE III offers the possibility to create up to **50** customizable synergic curves. Finally, a machine which completely suits your needs!

IDLE power consumption

CITOWAVE III 420	35 W
CITOWAVE III 520	38 W

ECO FRIENDLY WELDING &CUTTING

With the low consumption function, you can save up to **30%** on your energy bill.

TECHNOLOGY AT YOUR SERVICE

CITOWAVE III provides a full range of processes for all your applications:

Carbon Steel & Stainless Steel

Speed Short Arc - SSA

A semi controlled short circuit mode which allows to shift globular behavior using wire feed speed normally reachable only in pulse mode:

- Welding speed around 20% higher than traditional CV mode
- Handling ability largely improved and easy for welder's to use
- Lower heat input and less deformation

Pure Controlled Metal - PCM

NEW

A fully controlled short arc for a clean weld:

- Spatters emission close to zero
- Bridges large gaps
- Unrivalled welding quality on galvanized steel

Galvanized steel

Painted steel

All materials

Pulse

A universal pulse mode allowing welding of all materials:

- Handling ability, low spatters

Soft Silent Puls - SSP

The best for stainless steel welding:

- Clearly better wetting than traditional puls mode
- Undercut effect almost nonexistent
- Around 50% noise arc reduction (Valuable for welding work in a confined area)

Advanced SeQuencer - ASQ

By combining two differents wire feed speeds related to different arc transfer modes (ex. : CV / Puls) possibilities are endless:

- Weld bead with tig appearance with productivity 5 times higher than tig
- Vertical up (no weaving) even with solid wire
- Low heat input, less completion, less deformation

Carbon Steel

High Penetration Speed - HPS

A special spray mode but with a focused arc offering higher penetration:

- Limited or no preparation for thickness less than 8 mm
- Undercut effect almost nonexistent
- No sticking effect for deep bevel weld

Aluminum

Spray Modal - SM

This is the solution for porosity issues in aluminium welding.
Spray modal is based on a frequency modulation principle with very low value:

- Reduction and even elimination of porosity
- Productivity increase by 20%
- For manual or automatic application

SWAN

Supervising Welding Administrator Network

A laptop software to manage welding parameters:

- Welding current.
- Welding voltage.
- Wire speed.
- Motor consumption.
- Heat input.
- Programs.

Directly exportable through the network and on USB, these reports indicate the date, time and connected user during welding. It has never been so easy to monitor and assess the quality of welding in respect of WPQR/WPS.

Ask for the Brochure.

Ask for a live demo.

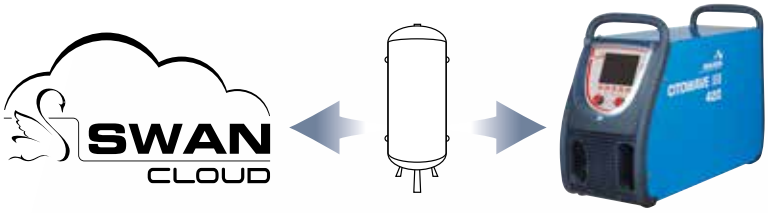
SWAN CLOUD

Digitalizing your welding activities...

Whole welding activities management software :

- WPQR / WPS management.
- Welder & consumable certification management.
- Parts sketch tools embedded allowing weld identification.
- Weld control.
- Machine configuration management.
- And more...

Edit your welding book in one click!



Program management

CITOWAVE III can memorize up to 100 welding programs to ensure a perfect reproducibility of your welds. And for complex parts, the necessary programs can be gathered into a list and chained with the trigger during welding for an easy and quick access.

The modular concept of CITOWAVE III allows you to build the perfect configuration for your requirements, from offshore & shipbuilding to boiler makers, train production and small workshops.

Power sources

2016-399

420 A @ 60 %	CITOWAVE III 420	W000384991
500 A @ 60 %	CITOWAVE III 520	W000384992

Cooling unit

2010-464-r

COOLER III	W000273516
Safety device for COOLER II	W000376539

Remote control

2013-452

RC JOB II (10 m)
W000371925

RC SIMPLE (10 m)
W000275904

Wire feeders

2016-404

DMU W500
W000371926

- 100 programs
- possibility to lock welding parameters
- LCD display

Trolley

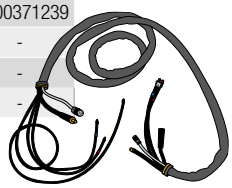
for installation

2015-030

TROLLEY III
W000383000

Harnesses

Length	Air	Water	
		Standard	Aluminium
2 m	W000275894	W000275898	W000371044
5 m	W000275895	W000275899	W000371045
10 m	W000275896	W000275900	W000371175
15 m	W000275897	W000275901	W000371174
25 m	W000276901	W000276902	W000371239
30 m	W000371246	-	-
40 m	W000371245	-	-
50 m	W000371244	-	-



Flowmeter

to mesure gas flowrate

Flowmeter
W000275905

Support

for wire feeder in vertical suspension

W000377985

Trolley

for wire feeder

2010-462

TROLLEY WF II
W000275908

Option Push-pull II electronic circuit

2011-113

Push-pull II
W000275907

Allowing to connect a push-pull torch or gun.

Anti-dust filter

for power source protection

W000373703

2011-458

TIG torch connector

W000379466

Aluminium welding kit

ALUKIT DVU 1,0 -1,2	W000277622
ALUKIT DVU 1,2-1,6	W000277623

A composition of wire guides and rollers for perfect aluminium welding.

Product	Reference	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S	CITOPULS III 420	CITOPULS III 520	CITOWAVE III 420	CITOWAVE III 520
DMU P400	W000275265				●	●		
DMU P500	W000275915				●	●		
DMU W500	W000371926						●	●
WF 52D	W100000176	●	●	●				
WF 56D	W100000177	●	●	●				

DMU P400
W000275265

DMU P500
W000275915

DMU W500
W000371926

WF 52D
W100000176

WF 56D
W100000177

PROMIG NG 181 T

PROMIG NG 341

PROMIG NG 450W

LGS2 150G

LGS2 360G

LGS2 505W

See page 9

MORE DETAILS PAGE 59

Product	Reference	CITOMIG 185MP	CITOMIG 210MP	CITOSTEEL 250C	CITOSTEEL 320C	CITOSTEEL 250C PRO	CITOSTEEL 320C PRO	CITOSTEEL 380C PRO	CITOSTEEL 450C PRO	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S	CITOPULS III 320C	CITOPULS III 420 / 520	CITOWAVE III 420 / 520
COOLERS															
COOLARC® 26	K14182-1							●	●	●	●	●			
COOLER III PW COMPACT	W000404340												●		
COOLER III PW	W000273516													●	●
Freezcool – cooling liquid for torches (9,6 l)	W000010167							●	●	●	●	●	●	●	●

COOLER III PW COMPACT
W000404340

COOLER III PW
W000273516

COOL ARC® 26
K14182-1

FREEZCOOL
W000010167

Product	Reference	CITOMIG 185MP	CITOMIG 210MP	CITOSTEEL 250C	CITOSTEEL 320C	CITOSTEEL 250C PRO	CITOSTEEL 320C PRO	CITOSTEEL 380C PRO	CITOSTEEL 450C PRO	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S	CITOPULS III 320C	CITOPULS III 420 / 520	CITOWAVE III 420 / 520
UNDERCARRIAGE															
2-wheeled undercarriage	W000375730												●		
4-wheeled MODULAR TROLLEY II	W000383000												●	●	●
ROLLS*															
Drive Roll KIT (1pc / diameter 37 mm)	KP14016-xx	●	●												
Drive Roll KIT (2pcs / diameter 37 mm)	KP14017-xx												●		
Drive Roll KIT (4pcs / diameter 37 mm)	KP14150-xx			●	●	●	●	●	●						
Aluminium welding KIT 1,0-1,2	W000277622												●		
Aluminium welding KIT 1,2-1,6	W000277623												●		
CABLES*															
Interconnection cable Air cooled	W00027xxxx													●	●
Interconnection cable Water cooled Standard	W00027xxxx													●	●
Interconnection cable Water cooled Aluminium	W000371xxx													●	●
Interconnection cable Air cooled	K14198-PG-xM									●	●	●			
Interconnection cable Water cooled	K14199-PGW-xM									●	●	●			
Extension Welding Cable 70 mm² (5; 10; 15; 30 m) TM(M)-TM(F)	K14166-x (x=1, 2, 3, 4)									●	●	●	●	●	●
Extension Welding Cable 95 mm² (5; 10; 15; 30 m) TM(M)-TM(F)	K14167-x (x=1, 2, 3, 4)									●	●	●	●	●	●
REMOTE CONTROL															
Remote control 15m (6PIN / 1POT)	K10095-1-15M					●	●	●	●						
Extension cable for remote control (6PIN) 15 m	K10398					●	●	●	●						
12PIN to 6PIN Adapter	K2909-1					●	●	●	●						
Remote Control MIG Yoystick 7m	K14091-1					●	●	●	●						
Remote control Simple Puls 10m	W000275904												●	●	
RC JOB 10 m	W000273134													●	●
Foot Amptrol™	K870					●	●	●	●						

* see chapter OPTION's for details

UNIVERSAL TROLLEY
W000375730

MODULAR TROLLEY II
W000383000

DRIVE ROLL KIT Ø 37 mm
KP14016-XX
KP14017-XX

DRIVE ROLL KIT Ø 37 mm
KP14150-XX

ALUMINIUM WELDING KIT
W000277622

INTERCONNECTION CABLE
K14198-PG-XM
K14199-PGW-XM

EXTENSION CABLE
K10398

FOOT AMPTROL™
K870

REMOTE CONTROL SIMPLE PULS 10 m
W000275904

REMOTE CONTROL
K10095-1-15M

Product	Reference	CITOMIG 185MP	CITOMIG 210MP	CITOSTEEL 250C	CITOSTEEL 320C	CITOSTEEL 250C PRO	CITOSTEEL 320C PRO	CITOSTEEL 380C PRO	CITOSTEEL 450C PRO	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S	CITOPULS III 320C	CITOPULS III 420 / 520	CITOWAVE III 420 / 520
OTHER OPTIONS															
Arclink-T Flex	K14131-1									●	●	●			
Adapter 5Pin(M)/12Pin(F)	K14132-1									●	●	●			
12-PIN Remote control socket KIT	K14290-1					●	●	●	●						
Polarity change KIT	K14173-1			●	●	●	●								
Control panel cover KIT	K14327-1				●	●	●								
Gas flow meter KIT	K14175-1			●	●	●	●	●	●						
Gas heater supply KIT (24Vac/80W)	K14176-1			●	●	●	●	●	●	●	●	●			
Bumpers KIT	K14328-1			●	●	●	●								
Cable management kit	K14201-1									●	●	●			
Water connection kit	K14208-1									●	●	●			
Dust Filter	W000373703												●	●	●
ACCESSORIES															
Adapter for wire spool 200 mm	R-1019-125-1/08R			●	●	●	●	●	●				●		
Adapter for wire spool 300 mm	K10158-1			●	●	●	●	●	●				●		
Adapter for wire spool 300 mm	K10158			●	●	●	●	●	●				●		
Welding cable 3/5m with Electrode Holder 200A (x=3, 5)	E/H-200A-25-xM	●	●												
Welding cable 5/10m with Electrode Holder 300A (x=5, 10)	E/H-300A-50-xM			●	●	●	●						●		
Welding cable 5/10m with Electrode Holder 400A (x=5, 10)	E/H-400A-70-xM			●	●	●	●	●	●	●	●	●	●	●	●
Welding cable 5/10m with Ground Clamp 200A (x=5, 10)	GRD-200A-35-xM	●	●												
Welding cable 5/10m with Ground Clamp 300A (x=5, 10)	GRD-300A-50-xM			●	●	●	●						●		
Welding cable 5/10/15m with Ground Clamp 400A (x=5, 10, 15)	GRD-400A-70-xM			●	●	●	●	●	●	●	●		●	●	
Welding cable 5/10m with Ground Clamp 600A (x=5, 10)	GRD-600A-95-xM			●	●	●	●	●	●	●	●	●	●	●	●
Stick Welding Cable KIT 200A-25mm²-3m	KIT-200A-25-3M	●	●												
Stick Welding Cable KIT 200A-35mm²-5m	KIT-200A-35-5M	●	●												
Stick Welding Cable KIT 300A-50mm²-5m	KIT-300A-50-5M			●	●	●	●						●		
Stick Welding Cable KIT 400A-70mm²-5m	KIT-400A-70-5M							●	●				●	●	

* see chapter "Options" for details

ELECTRODE HOLDER
E/H-200A-25-XM
E/H-300A-50-XM
E/H-400A-70-XM

GROUND CABLE
GRD-200A-35-XM
GRD-300A-50-XM
GRD-400A-70-XM
GRD-600A-95-XM

6-PIN/12-PIN ADAPTER
K2909-1

DUST FILTER
W000373703

SPOOL ADAPTER 300 mm (15 KG)
K10158-1

SPOOL ADAPTER 300 mm (15 KG)
K10158

SEMI-AUTOMATIC WIRE FEEDERS

SEMI-AUTOMATIC WIRE FEEDERS

		INPUT	OUTPUT	WIRE SIZE RANGE (mm)				FEATURES								
MODEL	REFERENCE	Input Power	Rated Output (A)	Solid Wires	Cored Wires	Aluminum Wires	Wire Drive System	A/V Metres	Weels	EURO socket	Socket for Electrode	Flow meter	Synergic	Control Cable	MIG gun Cooling	Warranty (years)
Digital																
WF 52D	W100000176	40V DC	500A/60%	0,8-1,6	0,9-1,6	1,0-1,6	4R	LEDs	•	•	•	O	•	5P	A/W	3
WF 56D	W100000177	40V DC	500A/60%	0,8-1,6	0,9-1,6	1,0-1,6	4R	TFT	•	•	•	O	•	5P	A/W	3
DMU P400	W000275265	34-44V AC	500A/60%	0,6-1,6	1,0-1,6	1,0-1,6	4R		•	•	•	O		19P	A/W	3
DMU P500	W000275915	34-44V AC	500A/60%	0,6-1,6	1,0-1,6	1,0-1,6	4R	LEDs+LCD	•	•	•	O	•	19P	A/W	3
DMU W500	W000371926	34-44V AC	500A/60%	0,6-1,6	1,0-1,6	1,0-1,6	4R	LEDs+LCD	•	•	•	O	•	19P	A/W	3
Analogue																
WF 24	W000403599	34-44V AC	500A/60%	0,8-1,6	1,0-1,6	1,0-1,6	4R	LEDs	•	•				9P	A/W	3
WF 24S	W000403600	34-44V AC	500A/60%	0,8-1,6	1,0-1,6	1,0-1,6	4R	LEDs	•	•			•	9P	A/W	3

O – Option

WF 52D & WF 56D

Designed to work with new Citosteel S power sources.

WARRANTY 3 YEARS

Input 40 VDC

Output

S300

- NEW features: Date&Calendar, Speaker and stronger encoders (WF56D).
- Small, rugged and easy to handle feeders with bright digital meters.
- Digital communication protocol for welding, making it the best choice for seamless, time critical integration with the power source.
- Perfect feedability, four roll drive system with powerful motor.
- Easy-to-understand user interface panels make it easy to set weld parameters.
- Optimized wire spool installation, inspection window and lifting eye.
- Equipped with wheels as standard.

NEW

NEW SYN SYNERGIC SETTINGS

UNIT INCLUDES

Drive roll 1,0-1,2 mm

User manual on USB

Product	Reference	Drive Roll	Cooling	Rated Output (A)	Input Power	WFS Range (m/min)	Wire Size Range (mm)			Weight (kg)	Dimensions H x W x D (mm)
							Solid	Cored	Aluminium		
WF 52D	W100000176	4	A/W	500A@60%	40V DC	1,5-22	0,8-1,6	1,0-1,6	1,0-1,6	17	516 x 302 x 642
WF 56D	W100000177									17,7	

DMU P400 & DMU P500

Designed to work with digital power sources.

WARRANTY 3 YEARS

Input 42 VAC

Output

S300

- Small, rugged and easy to handle feeders with bright digital meters (P400 excl.).
- Four roll drive system with powerful motor.
- Storage of 100 welding programs with expert wire feeder DVU P500.
- Parameter locking with a digital code (with expert wire feeder DVU P500).
- Equipped with wheels as standard.

UNIT INCLUDES

Adapter for 300mm spool wire

Product	Reference	Drive Roll	Cooling	Rated Output (A)	Input Power	WFS Range (m/min)	Wire Size Range (mm)			Weight (kg)	Dimensions H x W x D (mm)
							Solid	Cored	Aluminium		
DMU P400	W000275265	4	A/W	500A@60%	34-44V AC	0,5-25	0,6-1,6	1,0-1,6	1,0-1,6	17,5	262 x 603 x 446
DMU P500	W000275915										

DMU W500

- Fully digital wire feeder.
- Customizable display.
- Program management (100 programs).
- Remote control connection.
- Can work 50 metres from the power source.

WARRANTY 3 YEARS

Input 42 VAC

Output

S300

UNIT INCLUDES

Steel roller diameter 1 and 1,2 mm
European connector
Gas bleed cold wire button

Product	Reference	Drive Roll	Cooling	Rated Output (A)	Input Power	WFS Range (m/min)	Wire Size Range (mm)			Weight (kg)	Dimensions H x W x D (mm)
							Solid	Cored	Aluminium		
DMU W500	W000371926	4	A/W	500A@60%	34-44V AC	0,5-25	0,6-1,6	1,0-1,6	1,0-1,6	17,5	262 x 603 x 446

CARBOFIL & ULTRAFIL

MILD STEEL MIG WIRES

The right choice of solid wire for all applications

OERLIKON

WF 24 & WF 24S

Small, robust, flexible & complete.

- Continuous control of wire feed speed.
- Trigger mode selection – for standard two-steps or interlocking four-steps.
- Gas purge – to strike the arc with full shielding.
- Burnback – preventing the wire sticking in the weld pool.
- Cold inch control – used to feed the wire into the torch.
- Delivered mounted on an undercarriage.

WARRANTY 3 YEARS

Input 34-44 VAC

Output

S300

UNIT INCLUDES

Drive roll kit 1,0-1,2 mm

SEMIAUTOMATIC WIRE FEEDERS

Product	Reference	Drive Roll	Cooling	Rated Output (A)	Input Power	WFS Range (m/min)	Wire Size Range (mm)			Weight (kg)	Dimensions H x W x D (mm)
							Solid	Cored	Aluminium		
WF 24	W000403599	4R	A/W	500A / 60%	34-44V AC	1-20	0,8-1,6	1,0-1,6	1,0-1,6	17	440 x 275 x 636
WF 24S	W000403600										

WF 56D & WF 52D

DESIGNED TO ENHANCE YOUR WELDING CAPABILITY

OERLIKON

Product	Reference	Wire Feed WF24/WF24S	Wire Feed 52D	Wire Feed 56D	DMU P400/P500/W500
ROLLS*					
Drive Roll KIT (1pc / diameter 37 mm)	KP14016-xx	●(1)			
Drive Roll KIT (2pcs / diameter 37 mm)	KP14017-xx	●			
Drive Roll KIT (4pcs / diameter 37 mm)	KP14150-xx		●	●	
Drive Roll KIT (2pcs / diameter 37 mm)	W000…..				●
Aluminium welding KIT 1,0-1,2	W000277622				●
Aluminium welding KIT 1,2-1,6	W000277623				●
CABLES*					
Interconnection cable Air cooled	K10347-PG-xM	●			
Interconnection cable Water cooled	K10347-PGW-xM	●			
Interconnection cable Air cooled	K14198-PG-xM		●	●	
Interconnection cable Water cooled	K14199-PGW-xM		●	●	
Interconnection cable Air cooled	W00027xxxx				●
Interconnection cable Water cooled Standard	W00027xxxx				●
Interconnection cable Water cooled Aluminium	W000371xxx				●
REMOTE CONTROL					
Remote control 15m (6PIN / 1POT)	K10095-1-15M			●	
Extension cable for remote control (6PIN) 15 m	K10398			●	
Remote Control MIG Yoystick 7m	K14091-1			●	
Remote Control 6PIN (7,6M)	K857			●(2)	
Remote Control 6PIN (30,4M)	K857-1			●(2)	
Remote Control 12PIN (7,6M)	K857-2			●	
Remote Control 12PIN (30,4M)	K857-3			●	
Remote control Simple Puls 10m	W000275904				●
RC JOB 10m	W000273134				●
OTHER OPTIONS					
Gas flow meter KIT	K14175-1		●	●	
Wire feeder drum quick connector	K14204-1		●	●	
12PIN to 6PIN Adapter	K2909-1			●	
Gas flow meter KIT for DMU	W000275905				●
ACCESSORIES					
Adapter for wire spool 200 mm	R-1019-125-1/08R	●	●	●	●
Adapter for wire spool 300 mm	K10158-1	●	●	●	●
Adapter for wire spool 300 mm	K10158	●	●	●	●
Welding cable 5/10m with Electrode Holder 300A (x=5, 10)	E/H-300A-50-xM		●	●	●
Welding cable 5/10m with Electrode Holder 400A (x=5, 10)	E/H-400A-70-xM		●	●	●
UNDERCARRIAGE					
Heavy duty four-wheeled undercarriage	K14032-1	●			
Trolley for wire feeder	W000275908				●

* see chapter "Options" for details

(1) require 2pcs
(2) require K2909-1 adapter

TIG WELDERS

TIG WELDERS

MODEL	REFERENCE	INPUT			OUTPUT			PROCESS					FEATURES				
		Phase	Voltage (V)	Frequency (Hz)	Mode	Polarity	Current Range (A)	Stick	Lift TIG	TIG HF	TIG Pulse	PFC	Motor generator compatibility	Up/Down	Memory	Metres (A/V)	Warranty (years)
TIG DC (1 phase)																	
CITOTIG 1600 HPF	W000273517	1	230	50/60	CC	DC	5-160	•	•	•		•	•				2
CITOTIG 1800 FORCE	W000382579	1	230	50/60	CC	DC	5-160	•	•	•	•	•	•		•	•	2
CITOTIG 2200 FORCE	W000382580	1	230	50/60	CC	DC	5-220	•	•	•	•	•	•		•	•	2
TIG DC (3 phase)																	
CITOTIG 315 DC	W000403581	3	400	50/60	CC	DC	5-300	•	•	•	•		•	•	•	•	3
CITOTIG 415 DC	W000403583	3	400	50/60	CC	DC	5-400	•	•	•	•		•	•	•	•	3
TIG AC/DC (1 phase)																	
CITOTIG 200 AC/DC	W000404214	1	115/230	50/60	CC	AC/DC	2-200	•	•	•	•	•	•	•	•	•	3
TIG AC/DC (3 phase)																	
CITOTIG 315 AC/DC	W000403604	3	230/400	50/60	CC	AC/DC	2-300	•	•	•	•	•	•		•	•	3

CITOTIG 1600 HPF

Leading technology in TIG DC welding. User friendly interface.

WARRANTY 2 YEARS

- Robust design – varnished PC boards.
- Improved generator compatibility: +/- 20% Input voltage variation, PFC controller.
- Usable with great length of primary cable (up to 70 m in 2,5 mm² section).
- Good welding in TIG HF and TIG Lift mode.
- Hot start function and anti-sticking device.
- Portable – light weight: only 10,2 kg.
- Reduced noise – "intelligent" cooling fan.
- Save energy – low current consumption.
- Simple control panel – full control, easy set up.
- 2 year warranty for labour and parts without limitations.
- Motor generator compatible.

Processes

Stick, Lift TIG, TIG HF

Applications

- Light industry
- Motorsports
- Maintenance and repair
- Process and food industry
- Intervention service

Input

1 PHASE, 50/60 Hz

Output

CC, DC

PFC, GENERATOR READY

LONG : 70 m
SECTION : 3 x 2.5 mm²

UNIT INCLUDES

Input cable with schuko plug (3 m)
Ground cable (3 m)
Gas connection kit

Product	Reference	Voltage (V)	Input voltage tollerance	Frequency (Hz)	Output range (A)	Rated Output	Fuse Size (A) (slow)	Cooling (Air / Water)	Dimensions H x W x D (mm)	Weight (kg)	Protection / Insulation Class
CITOTIG 1600 HPF	W000273517	230	+/- 20%	50/60	5-160	160A@35% 120A@100%	16	Air	205 x 345 x 460	9,5	IP23S / H

CITOTIG 1800 FORCE

Advanced inverter technology for superior TIG performance.
Very good HF arc ignition; stable, focused and fast arc.

WARRANTY 2 YEARS

- Robust design – varnished PC boards.
- Improved generator compatibility: +/- 20% input voltage variation, PFC controller.
- Usable with great length of primary cable (up to 70 m in 2,5 mm² section).
- Decent welding in TIG HF and TIG Lift mode.
- Hot start function and anti-sticking device.
- Portable – light weight: only 10,2 kg.
- Reduced noise – "intelligent" cooling fan.
- Energy-saving – low current consumption.
- Simple control panel – easy setup, full control.
- Unlimited labour and parts 2 year warranty.
- Optional remote control.
- Possibility to use with autonomous water cooler system FREEZTIG (W000382728).
- Program storage capability (30).
- Digital display.
- Motor generator compatible.

Processes

Stick, Lift TIG, TIG HF, TIG Pulse

Applications

- Light industry
- Motorsports
- Maintenance and repair
- Process and food industry
- Intervention service

Input

1 PHASE, 50/60 Hz

Output

CC, DC

PFC, GENERATOR READY

LONG : 70 m
SECTION : 3 x 2.5 mm²

WATER COOLING

UNIT INCLUDES

Input cable with schuko plug (3 m)
Ground cable (3 m)
Gas connection kit

Product	Reference	Voltage (V)	Input voltage tollerance	Frequency (Hz)	Output range (A)	Rated Output	Fuse Size (A) (slow)	Cooling (Air / Water)	Dimensions H x W x D (mm)	Weight (kg)	Protection / Insulation Class
CITOTIG 1800 FORCE	W000382579	230	+/- 20%	50/60	5-160	160A@40% 130A@100%	16	Air / Water	205 x 345 x 460	10,2	IP23S / H

CITOTIG 2200 FORCE

Advanced inverter technology for superior TIG performance.
Very good HF arc ignition; stable, focused and fast arc.

WARRANTY 2 YEARS

Processes
Stick, Lift TIG, TIG HF, TIG Pulse

Applications
- Light industry
- Motorsports
- Maintenance and repair
- Process and food industry
- Intervention service

- Robust design – varnished PC boards.
- Improved generator compatibility: +/- 20% input voltage variation, PFC controller.
- Program storage capability (30).
- Usable with great length of primary cable (up to 70 m in 2,5 mm² section).
- Excellent welding in TIG HF and TIG Lift mode.
- Hot start function and anti-sticking device.
- Digital display.
- Portable – light weight: only 10,2 kg.
- Reduced noise – "intelligent" cooling fan.
- Energy-saving – low current consumption.
- Simple control panel – easy setup, full control.
- Unlimited labour and parts 2 year warranty.
- Possibility to use with autonomous water cooling system FREEZTIG (W000382728).
- Optional remote control.
- Motor generator compatible.

LONG : 70 m
SECTION : 3 x 2.5 mm²

Input
1 PHASE
50/60 Hz

Output
CC
DC

PFC
GENERATOR READY

UNIT INCLUDES
- Input cable with schuko plug (3 m)
- Ground cable (3 m)
- Gas connection kit

Product	Reference	Voltage (V)	Input voltage tollerance	Frequency (Hz)	Output range (A)	Rated Output	Fuse Size (A) (slow)	Cooling (Air / Water)	Dimensions H x W x D (mm)	Weight (kg)	Protection / Insulation Class
CITOTIG 2200 FORCE	W000382580	230	+/- 20%	50/60	5-220	220A@40% 150A@100%	16	Air / Water	205 x 345 x 460	10,2	IP23S / H

CITOTIG 315 DC & 415 DC

Advanced inverter technology for superior DC TIG performance.
Industrial TIG welder for tough conditions.

WARRANTY 3 YEARS

Processes
Stick, Lift TIG, TIG HF, TIG pulse

Applications
- Heavy industrial applications
- Industrial plants
- Maintenance and repair
- Pipe construction
- Process and food industry
- Metal construction
- Aerospace industry
- Nuclear industry
- Chemical industry

- Fully functional, user-friendly control panel layout with graph and numeric display makes it easy to set all welding parameters.
- Rugged construction: electrical safety (IP23S), potted PC boards and optimum airflow reduce contamination to extend the equipment's lifespan in the harshest environmental conditions.
- HF and Lift TIG ignition meeting all requirements.
- Perfect TIG HF starting with pre-settable starting mode.
- Complete TIG parameters setting: Pulse TIG with variable frequency that allows the welder to adjust the arc focus to suit the applications, 10 memory slots for personalized welding settings, TIG Spot welding.
- Water Coolers and Carts available.
- 3 year warranty – for labour and parts.
- Optional remote control.
- Up/down function.
- Cellulosic capability.
- Motor generator compatible.

Input
3 PHASE
50/60 Hz

Output
CC
DC

GENERATOR READY
WATER COOLING

UNIT INCLUDES
- Input cable (2m)
- Gas connection kit

Product	Reference	Voltage (V)	Input voltage tollerance	Frequency (Hz)	Output range (A)	Rated Output	Fuse Size (A) (slow)	Cooling (Air / Water)	Dimensions H x W x D (mm)	Weight (kg)	Protection / Insulation Class
CITOTIG 315 DC	W000403581	400	+/- 15%	50/60	5-300	300A/22V/40% 220A/18,8V/100%	20	Air / Water	349 x 247 x 502	22,1	IP23S / H
CITOTIG 415 DC	W000403583				5-400	400A/26V/35% 300A/22V/100%	30		455 x 301 x 632	37	

CITOTIG 200 AC/DC

Leading technology in TIG AC/DC welding with a user-friendly interface and innovative remote control system in the torch.

WARRANTY 3 YEARS

- Superb arc performance – Excellent HF ignition, stable & fast arc, minimum current 2A.
- Advanced TIG AC & DC Functions – Four wave shapes, Pulse, adjustable Balance and Offset, innovative and simple control panel, AC auto setting.
- Generator compatible, ideal for site use.
- Cellulosic capability.
- Bright digital display – easy setup buttons, 9 memory slots, new control in the TIG torch.
- Energy efficient 1 phase buck-boost circuit for energy saving.
- Robust design – Potted PCBs, True HD design (special protection for use in harsh conditions).
- Best aluminium welding performance.
- Up/down function.
- Water Coolers and Cart available.
- Motor generator compatible.

Processes

Stick DC, Stick AC, TIG DC, TIG AC, TIG Lift, TIG HF, TIG Pulse

Applications

- Industrial applications
- Industrial plants
- Maintenance and repair
- Pipe construction
- Process and food industry
- Metal construction
- Aerospace industry
- Chemical industry
- Aluminium solutions

WATER COOLING

Input

1 PHASE, 50/60 Hz

Output

CC, AC/DC

PFC, GENERATOR READY

UNIT INCLUDES

- Input cable (3 m)
- Gas connection kit

Product	Reference	Primary Voltage (50-60 Hz)	Current Range (A)	Rated Output	Fuse Size (A) (slow)	Weight (kg)	Dimensions WxLxD (mm)	Protection Class
CITOTIG 200 AC/DC	W000404214	115/230V/1Ph +/- 15%	2-200	200A@35% 130A@100%	16A	23	419 x 246 x 506	IP23

CITOTIG 315 AC/DC

For superior TIG performance.

WARRANTY 3 YEARS

- Advanced waveform technology for the best aluminium welding performance.
- Superb welding characteristics with TIG DC, TIG AC and Stick welding processes.
- Adjustable cleaning and penetration for perfect aluminium welding.
- Variable AC frequency (40-400 Hz) for the control of travel speed and penetration.
- Fully functional, user-friendly control panel layout with graph and a numeric display makes it easy to set all welding parameters.
- Cellulosic capability.
- Energy efficient 3 phase buck-boost circuit for energy saving.
- Robust design – Potted PCBs, True HD design (special protection for use in harsh conditions).
- Best aluminium welding performance.
- Water Coolers and Cart available.
- Motor generator compatible.

Processes

Stick DC, Stick AC, TIG DC, TIG AC, TIG Lift, TIG HF, TIG Pulse

Applications

- Heavy industrial applications
- Industrial plants
- Maintenance and repair
- Pipe construction
- Process and food industry
- Metal construction
- Aerospace industry
- Chemical industry
- Nuclear industry
- Aluminium solutions

Input

3 PHASE, 50/60 Hz

Output

CC, AC/DC

GENERATOR READY, WATER COOLING

UNIT INCLUDES

- Input cable (3 m)
- Gas connection kit

Product	Reference	Primary Voltage (50-60 Hz)	Current Range (A)	Rated Output	Fuse Size (A) (slow)	Weight (kg)	Dimensions WxLxD (mm)	Protection / Insulation Class
CITOTIG 315 AC/DC	W000403604	230/400V/3Ph	2-300	300A/22V/35% 200A/18V/100%	32/20	43	455 x 301 x 632	IP23 / H

Series	Size	Rate	Application	Extra Flex Cable	HD expendables	Up /Down	Ergonomic handle	Adjustable neck	Valve version available	Flex Neck version available	Round Handle	110A	125A	135A	150A	180A	200A	220A	250A	320A	350A	450A
PROTIG IIIS	10	35%	Industrial	●	●						●											
	20			●	●						●											
	30			●	●						●											
	40			●	●						●											
	10W	100%		●	●						●											
	35W			●	●						●											
	40W			●	●						●											
PROTIG NGS	10	35%	Industrial	●	●	●	●	●														
	20			●	●	●	●	●														
	30			●	●	●	●															
	40			●	●	●	●															
	10W	100%		●	●	●	●	●														
	35W			●	●	●	●															
	40W			●	●	●	●															
WTT2	9	35%	Professional				●		●	●												
	17						●		●	●												
	26						●		●	●												
	20	100%					●			●												
	18						●			●												

PROTIG IIIS

PROTIG NGS

WTT2

air cooled

water cooled

MORE DETAILS PAGE 69

TIG WELDERS

	5 m	8 m	CITOTIG 1600 HPF	CITOTIG 1800 FORCE	CITOTIG 2200 FORCE	CITOTIG 315 DC	CITOTIG 415 DC	CITOTIG 200 AC/DC	CITOTIG 315 AC/DC
TIG PREMIUM TORCHES AIR									
PROTIG IIIS 10 RL	W000382715-2	W000382716-2	●	●					
PROTIG IIIS 20 RL	W000382717-2	W000382718-2	●	●	●			●	
PROTIG IIIS 30 RL	W000382719-2	W000382720-2			●	●	●	●	●
PROTIG IIIS 40 RL	W000382721-2	W000382722-2				●	●		●
PROTIG NGS 10 EB	W000278394-2	W000278395-2	●	●					
PROTIG NGS 20 EB	W000278396-2	W000278397-2	●	●	●			●	
PROTIG NGS 30 EB	W000278398-2	W000278399-2			●	●	●	●	●
PROTIG NGS 40 EB	W000278400-2	W000278401-2				●	●		●
TIG PREMIUM TORCHES WATER									
	5 m	8 m							
PROTIG IIIS 10W RL	W000382723-2	W000382724-2		●	●	●		●	
PROTIG IIIS 35W RL	W000382725-2	W000382726-2				●	●		●
PROTIG IIIS 40W RL	W000382727-2	–					●		
PROTIG NGS 10W EB	W000278402-2	W000278403-2		●	●	●		●	
PROTIG NGS 35W EB	W000278404-2	W000278405-2				●	●		●
PROTIG NGS 40W EB	W000278406-2	W000278407-2					●		
TIG TORCHES AIR									
	4 m	8 m							
WTT2 17 RL C5B	W000278884	W000278917	●	●	●				
WTT2 17 EB C5B	W000278882	W000278919	●	●	●				
WTT2 26 RL C5B	W000278890	W000278913	●	●	●	●	●	●	●
WTT2 26 EB C5B	W000278887	W000278915	●	●	●	●	●	●	●
TIG TORCHES WATER									
	4 m	8 m							
WTT 18W RL C5B	W000278898	W000278899				●	●		●
WTT 18W EB C5B	W000278896	W000278901				●	●		●
WTT 20W RL C5B	W000278894	W000278905		●	●	●	●	●	●
WTT 20W EB C5B	W000278892	W000278909		●	●	●	●	●	●

Tungsten electrodes

WS 2-Rare Earths

Ø (mm)	Length (mm)	Reference
1,6	175	W000335167
2,4	175	W000335169
3,2	175	W000335171

WLa 15-Lanthanum 1,5%

Ø (mm)	Length (mm)	Reference
1,6	150	W000402663
2,0	150	W000402664
2,4	150	W000402665
3,2	150	W000402667

WP-Pure Tungsten

Ø (mm)	Length (mm)	Reference
1,6	150	W000010010
1,6	175	W000010375
2,0	150	W000010011
2,4	150	W000010012
2,4	175	W000010377
3,2	150	W000010014
3,2	175	W000010378
4,0	150	W000010015

WLa20-Lanthanum 2%

Ø (mm)	Length (mm)	Reference
1,0	150	W000010373
1,6	150	W000010016
1,6	175	W000010385
2,0	150	W000010017
2,0	175	W000010386
2,4	150	W000010018
2,4	175	W000010387
3,2	150	W000010020
3,2	175	W000010388
4,0	150	W000010021

WCe-Cerium 2%

Ø (mm)	Length (mm)	Reference
1,6	150	W000010023
1,6	175	W000335153
2,0	150	W000010024
2,4	150	W000010025
2,4	175	W000335154
3,2	150	W000335150
3,2	175	W000335157
4,0	150	W000010028

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Product	Reference	CITOTIG 1600 HPF	CITOTIG 1800 FORCE	CITOTIG 2200 FORCE	CITOTIG 315 DC	CITOTIG 415 DC	CITOTIG 200 AC/DC	CITOTIG 315 AC/DC
Freeztig	W000382728		●	●				
Freezcool – cooling liquid for torches (9,6 l)	W000010167		●	●	●	●	●	●
COOLERTIG 3	W000403940				●			
COOL ARC® 24	K14190-1						●	
COOLERTIG 4	W000403941					●		●
Kit 25C50	W000260684	●	●	●			●	
Kit 35C50	W000011139				●			●
Kit 50C50	W000260681				●			●
Kit 50C50+	W000260682					●		
Electrode holder – 300A – 50 mm² – 5 m	E/H-300A-50-5M				●	●		●
Ground cable 200A – 35 mm² – 5 m	GRD-200A-35-5M	●	●	●			●	
Ground cable 200A – 35 mm² – 10 m	GRD-200A-35-10M		●	●			●	
Ground cable 300A – 50 mm² – 5 m	GRD-300A-50-5M				●			●
Ground cable 300A – 50 mm² – 10 m	GRD-300A-50-10M				●			●
Ground cable 400A – 70 mm² – 5 m	GRD-400A-70-5M					●		
Ground cable 400A – 70 mm² – 10 m	GRD-400A-70-10M					●		
Foot pedal	W000241602		●	●				
Remote control – 10 m	W000219557		●	●				
Foot Amptrol™	K870		●	●	●	●	●	●
Remote control – hand 15 m	K14147-1		●	●	●	●	●	●
Extension for hand remote control – 15 m	K14148-1		●	●	●	●	●	●
Two-wheeled undercarriage	W0200002			●				
CART 3	W000404145				●			
CART 4	W000404146					●		●
Cart 24	K14191-1						●	
Universal Trolley	W000375730	●	●	●				

COOLERTIG 3
W000403940

COOLERTIG 4
W000403941

FREEZTIG
W000382728

COOL ARC®24
K14190-1

FREEZCOOL
W000010167

TWO-WHEELED UNDERCARRIAGE
W0200002

CART 24
K14191-1

UNIVERSAL TROLLEY
W000375730

CART 3
W000404145

CART 4
W000404146

CABLE KITS
W000011138
W000260683
W000260684
W000011139
W000260681
W000260682

GROUND CABLE
GRD-200A-35-5M
GRD-200A-35-10M
GRD-300A-50-5M
GRD-300A-50-10M
GRD-400A-70-5M
GRD-400A-70-10M

FOOT PEDAL
W000241602

FOOT AMPTROL™
K870

REMOTE CONTROL
K14147-1

EXTENSION FOR REMOTE CONTROL
K14148-1

ELECTRODE HOLDER
E/H-300A-50-5M

STICK WELDERS

STICK WELDERS

MODEL	REFERENCE	INPUT			OUTPUT			PROCESS					FEATURES		
		Phase	Voltage (V)	Frequency (Hz)	Mode	Polarity	Current Range (A)	Stick	Lift TIG	TIG Scratch	Cellulosic capability	Gouging	Display	PFC	Warranty (years)
Conventional															
CITOROD 4005XT	W000403564	3	230/400	50/60	CC	DC	15-400	•	•		•	•	•		3
CITOROD 6700XT	W000403565	3	230/400	50/60	CC	DC	15-670	•	•		•	•	•		3
Inverter															
MINIARC 3,2	W000385238	1	230	50/60	CC	DC	10-150	•		•					2
CITOARC 1600	W000385242	1	230	50/60	CC	DC	5-150	•		•					2
CITOARC 1750	W000385243	1	230	50/60	CC	DC	5-160	•		•					2
CITOARC 1650 FORCE	W000385256	1	230	50/60	CC	DC	10-160	•	•					•	2
CITOARC 1850 FORCE	W000385253	1	230	50/60	CC	DC	10-180	•	•					•	2
CITOARC 1900C FORCE	W000385258	1	230	50/60	CC	DC	5-160	•	•		•		•	•	2
CITOARC 270	W000403606	3	400	50/60	CC	DC	5-270	•	•				•		3

CITOROD 4005XT

Electrodes diameter from 1,6 to 6,3 mm.
The rugged and distinguished workhorses.

WARRANTY 3 YEARS

- Rugged, conventional welding rectifier with excellent arc characteristics.
- Capable of welding with Rutile, Basic and Cellulosic electrodes.
- Arc gouging capability.
- Easy to understand graphic control panels.
- Ready to be moved. Equipped with wheels, pull bar and two lifting hooks.
- Hot Start supporting excellent arc starting.
- Arc Force to prevent sticking of the electrode in the welding pool.
- Digital meters showing welding amperage.
- Built-in Fan-on-Demand (F.A.N.™) reduces power consumption and the intake of dust and fumes.
- Lift TIG DC capability.

Processes

Stick, EL cellulosic, Lift TIG, Gouging

Applications

- Pipeline construction
- Heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging

Input

3 PHASE, 50/60 Hz

Output

CC, DC

GENERATOR READY

UNIT INCLUDES

Input cable (2 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOROD 4005XT	W000403564	230 / 400V / 3Ph	400A / 36V@35% 240A / 29V@100%	15-400	63 / 40	126	640 x 580 x 700	IP23 / H

CITOROD 6700XT

Electrodes diameter from 1,6 to 6,3 mm.
The rugged and distinguished workhorses.

WARRANTY 3 YEARS

- Rugged, conventional welding rectifier with excellent arc characteristics.
- Capable of welding with Rutile, Basic and Cellulosic electrodes.
- Arc gouging capability.
- Easy to understand graphic control panels.
- Ready to be moved. Equipped with wheels, pull bar and two lifting hooks.
- Hot Start supporting excellent arc starting.
- Arc Force to prevent sticking of the electrode in the welding pool.
- Digital meters showing welding amperage.
- Built-in Fan-on-Demand (F.A.N.™) reduces power consumption and the intake of dust and fumes.
- Lift TIG DC capability.

Processes

Stick, EL cellulosic, Lift TIG, Gouging

Applications

- Pipeline construction
- Heavy industrial fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry
- Arc-Air gouging

Input

3 PHASE, 50/60 Hz

Output

CC, DC

GENERATOR READY

UNIT INCLUDES

Input cable (2 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOROD 6700XT	W000403565	230 / 400V / 3Ph	670A / 44V@35% 400A / 36V@100%	15-670	100 / 63	150	670 x 580 x 700	IP23 / H

MINIARC 3.2

WARRANTY 2 YEARS

Electrodes diameter from 1,6 to 3,2 mm.
The MINIARC 3,2, well known for its exceptional "weight/power" ratio, is suitable for any maintenance activities and everyday intervention operations. Product advantages: User-friendly interface; versatile; precise welding quality; compact.

- MMA welding equipment Small but powerful.
- Professional: compatible with motor generators.
- Reliable and safe: 2 year warranty.
- Easy-to-use: excellent arc striking and stability thanks to the Hot Start, Arc Force and anti-stick functions.
- Power supply: 230 V single-phase.
- Input cable with 16A plug installed.
- Ultra light: less than 3,8 kg.
- Ready for use: delivered with case and accessories.

Processes
Stick, Tig scratch

Applications
- Small maintenance
- Light construction
- Light metal fabrication
- On-site repair
- Outside and workshop welding jobs
- Hobby

Input
1 PHASE, 50/60 Hz

Output
CC, DC

UNIT INCLUDES

Input cable with schuko plug (3 m)
Ground cable
Electrode holder cable
Plastic suitcase
Welding mask
Hammer
Small electrodes pack

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
MINIARC 3.2	W000385238	230V/1Ph +/- 15%	150A@10% 55A@100%	10-150	16A	3,8	220 x 120 x 320	IP23S / H

CITOARC 1600

WARRANTY 2 YEARS

Electrodes diameter from 1,6 to 4,0 mm.
Professional performance, industrial perfection.

- Exceptional performance: high duty cycle at 40 °C.
- Easy to use: Hot Start function to improve the arc striking and Arc Force function to avoid electrode sticking.
- Versatile: welding with any coated electrode (except cellulosic).
- Compatible with motor generator.
- Lightweight: less than 7 kg.
- Handy: thanks to the handy carrying strap.

Processes
Stick, TIG Scratch

Applications
- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Process industry

Input
1 PHASE, 50/60 Hz

Output
CC, DC

UNIT INCLUDES

Input cable (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 1600	W000385242	230V/1Ph +/-20%	150A@35% 100a@100%	5-150	19	7	145 x 230 x 365	IP23S

CITOARC 1750

Electrodes diameter from 1,6 to 4,0 mm.
Professional performance, industry perfection.

- Exceptional performance high duty cycle at 40°C
- Easy to use : Hot start function to improve the arc striking and Arc Force function to avoid electrode sticking
- Versatile: welding with any coated electrode (except cellulosic)
- Compatible with motor-generator
- Lightweight : less than 7Kg
- Input cable with schuko plug 16A
- Handy: thanks to the handy carrying strap

Processes
Stick, Tig scratch

Applications
- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site interventions
- Process industry

Input
1 PHASE
50/60 Hz

Output
CC
DC

UNIT INCLUDES
Input cable (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 1750	W000385243	230V/1Ph +/-20%	160A@20% 100A@100%	5-160	16	7	145 x 230 x 365	IP23S

CITOARC 1650 FORCE

WARRANTY 2 YEARS

Electrodes diameter from 1,6 to 4,0 mm
Professional performance, industrial perfection.

- Exceptional performance: high duty cycle at 40 °C.
- Easy to use: Hot Start function to improve the arc striking and Arc Force function to avoid electrode sticking.
- Versatile: welding with any coated electrode (except cellulosic) and LIFT TIG).
- Works connected to domestic plug (16A fuse).
- Compatible with motor generator.
- Power Factor Correction (PFC). PFC delivers: low current consumption, energy saving, low current harmonics and reduction of the total CO_2 produced by the welding process.
- Lightweight: less than 7 kg.
- Handy: thanks to the handy carrying strap.
- Noise reduction due to smart fan system.

Processes
Stick, Lift TIG

Applications
- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Process industry

Input
1 PHASE
50/60 Hz

Output
CC
DC

PFC
GENERATOR READY

LONG : 70 m
SECTION :
3 x 2.5 mm²

UNIT INCLUDES
Input cable (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 1650 FORCE	W000385256	230V / 1Ph +15-20%	160A@30% 120a@100%	10-160	16	7	320 x 170 x 395	IP23 / H

CITOARC 1850 FORCE

Electrodes diameter from 1,6 to 4,0 mm.
Professional performance, industrial perfection.

- Exceptional performance: high duty cycle at 40 °C.
- Easy to use: Hot Start function to improve the arc striking and Arc Force function to avoid electrode sticking.
- Versatile: welding with any coated electrode (except cellulosic) and LIFT TIG.
- Works connected to domestic plug (16A fuse).
- Compatible with motor generator.
- Power Factor Correction (PFC). PFC delivers: low current consumption, energy saving, low current harmonics and reduction of the total CO_2 produced by the welding process.
- Lightweight: less than 7 kg.
- Handy: thanks to the handy carrying strap.
- Noise reduction due to smart fan system.

WARRANTY 2 YEARS

LONG : 70 m
SECTION :
3 x 2.5 mm²

Processes
Stick, Lift TIG

Applications
- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Process industry

Input
1 PHASE
50/60 Hz

Output
CC
DC

PFC
GENERATOR READY

UNIT INCLUDES
Input cable (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 1850 FORCE	W000385253	230V / 1Ph +15-20%	180A@20% 120A@100%	10-180	16	7	320 x 170 x 395	IP23 / H

CITOARC 1900C FORCE

Electrodes diameter from 1,6 to 4,0 mm.
For demanding activities such as on site welding. Sturdy equipment with high liability and high duty cycle works.

- Exceptional performance: high duty cycle at 40 °C.
- Easy to use: Hot Start function to improve the arc striking and Arc Force function to avoid electrode sticking.
- Versatile: welding with any coated electrode and LIFT TIG.
- Compatible with motor generator.
- Digital display.
- Power Factor Correction (PFC) , PFC delivers: low current consumption, energy saving, low current harmonics and reduction of the total CO_2 produced by the welding process.
- Lightweight: less than 9 kg.
- Works connected to domestic plug (16A fuse).
- VRD function to increase safety when working in a humid environment with electroshock risk.
- Ideal for cellulosic application.
- Remote control.

WARRANTY 2 YEARS

LONG : 70 m
SECTION :
3 x 2.5 mm²

Processes
Stick, Lift TIG

Applications
- Light fabrication
- Plant construction
- Maintenance service
- Repair and maintenance
- On-site intervention
- Light industry
- Pipeline repair

Input
1 PHASE
50/60 Hz

Output
CC
DC

PFC
GENERATOR READY

UNIT INCLUDES
Input cable (3 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 1900C FORCE	W000385258	230V/1Ph +/- 20%	160A@50% 130A@100%	5-160	16	9	320 x 170 x 395	IP23 / H

CITOARC 270

Electrodes diameter from 1,6 to 5,0 mm.
Professional welder built for tough working conditions.

WARRANTY 3 YEARS

- Robust, built for heavy environmental conditions.
- Fully featured and user friendly control panel with digital display allows precise setting of welding current.
- Soft and Crisp mode – multiple arc modes for different electrode types.
- Auto Adaptive Arc force standard in Soft and Crisp modes – the automatic variable Arc Force operates when required.
- Adjustable Hot Start and Arc Force allow a smooth start/ restart of the electrode and prevent sticking of the electrode in the weld pool.
- Features "Lift TIG" with no tungsten contamination.
- Maximum output of 270A allows the use of 5,0 mm electrodes.

Processes
Stick, Lift TIG

Applications
- Heavy fabrication
- Plant construction
- Pressure vessels
- Nuclear power station
- Shipbuilding
- Hardfacing
- Process industry

Input
3 PHASE, 50/60 Hz

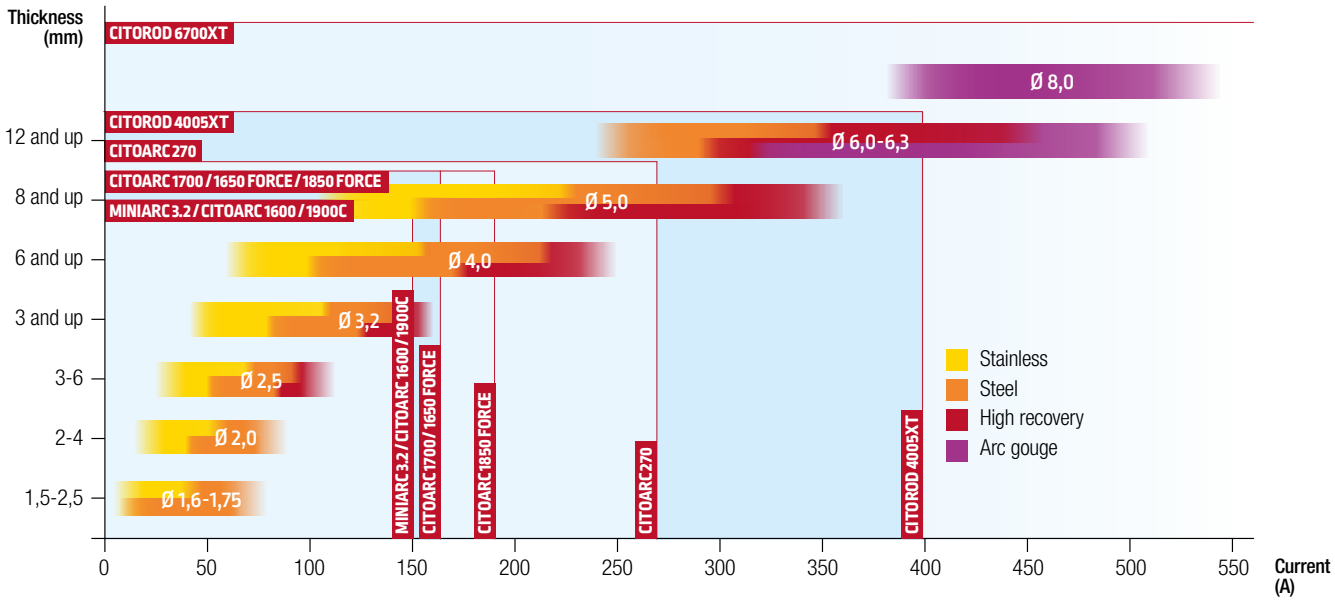
Output
CC, DC

GENERATOR READY

UNIT INCLUDES
Input cable (2 m)

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output (A)	Output Range (A)	Fuse Size (A) (slow)	Weight (kg)	Dimensions H x W x D (mm)	Protection Class
CITOARC 270	W000403606	400V / 3Ph	270A / 30,8V@35% 200A / 28V@100%	5-270	20	22	389 x 247 x 502	IP23 / H

PRODUCT APPLICATION CHART



STICK WELDERS

Product	Reference	MINIARC 3,2	CITOARC 1600	CITOARC 1750	CITOARC 1650 FORCE	CITOARC 1850 FORCE	CITOARC 1900C FORCE	CITOARC 270	CITOROD 4005XT	CITOROD 6700XT
Kit 25C25	W000011138	●	●	●	●	●				
Kit 25C50	W000260684						●			
Kit 35C50	W000011139						●	●		
Kit 50C50+	W000260682								●	●
TIG welding torch WTT2 17V – 135A – 4 m, valve, conn. 9 mm	W000278880		●	●	●	●				
TIG welding torch WTT2 17V – 135A – 4m, valve, conn. 13 mm	W10529-17-4V						●	●	●	●
Remote control, 15 m	K10095-1-15M							●	●	●
Extension cable for remote control box, 15 m	K10398							●	●	●
Two-wheeled undercarriage	W0200002							●		
Ground cable 400A – 70 mm² – 5 / 10 / 15 m	GRD-400A-70-xM								●	●
Ground cable 600A – 95 mm² – 10 m	GRD-600A-95-10M									●
Electrode holder – 400A – 70 mm² – 5 / 10 m	E/H-400A-70-xM								●	●
Cable Extension	EXT-70-10M								●	●
Flair® 600 / 1600 gouging torch	W000010136								●	●
TIG welding torch WTT2 9V – 110A – 4 m coon 9 mm	W000278876	●								

TWO-WHEELED UNDERCARRIAGE
W0200002

ELECTRODE HOLDER
E/H-400A-70-XM

CABLE KITS
W000011138
W000260683
W000260684
W000011139
W000260681
W000260682

REMOTE CONTROL
K10095-1-15M

GROUND CABLE
GRD-400A-70-XM
GRD-600A-95-10M

FLAIR® 600 / 1600
W000010136
W000010118

TIG WELDING TORCH WTT2 V
W000278880
W000278876
W10529-17-4V
W000278885

PLASMA CUTTING

PLASMA CUTTING RANGE

MODEL	REFERENCE	INPUT			OUTPUT				PROCESS			FEATURES		
		Phase	Voltage (V)	Frequency (Hz)	Mode	Polarity	Current Range (A)	Cutting capacity (mm)	Plasma cutting	Plasma gouging	Grid Mode	Compressor integrated	Piercing capability	Remote kit
1 phase														
CITOCUT 25i	W000404424	1	230	50/60	CC	DC	10-25	10	•			•		
3 phase														
CITOCUT 60	W000403595	3	400	50/60	CC	DC	20-60	25	•	•	•		•	
CITOCUT 100	W000403597	3	400	50/60	CC	DC	20-100	40	•	•	•		•	•

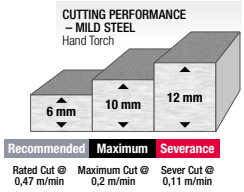
CITOCUT 25i

Portable, flexible cutting power of up to 10 mm, powered from a standard 230V input supply, ideal for work on site.

WARRANTY 2 YEARS

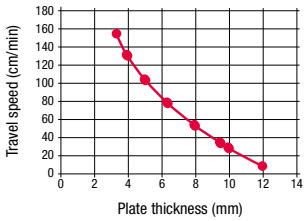
- Flexible: only 230 V input required.
- High performance: innovative, advanced electrode and nozzle design.
- Robust: long life compressor.
- Portable: only 18,5 kg, small and compact.
- Different materials: mild steel, stainless steel, aluminium and many more.
- Concentrated plasma stream: less heat input, less distortion.
- Internal compressor or external compressed air supply.

CITOCUT 25i



PERFORMANCE

Comparison at 25A



PC-210 external compressed air

Processes

Plasma cutting

Applications

- On-site maintenance
- Service tasks
- Small construction sites
- General installations
- Air ducting installation (HVAC)
- Rental

Input

1 PHASE — 50/60 Hz

Output

CC — DC

GENERATOR READY

UNIT INCLUDES

- 2 m input cable with 16A plug
- Mounted 3 m hand cutting torch
- Ground clamp and cable
- Air connection kit
- Cutting torch consumables kit

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output	Cutting Capacity (mm)	Flow Rate	Inlet Pressure	Output Range (A)	Weight (kg)	Dimensions HxWxD (mm)
CITOCUT 25i	W000404424	230V/1Ph	25A/90V/35% 20A/88V/60% 15A/86V/100%	10	80l/min+/-20%@5,0bar	6,0 bar	10-25	18,5	385 x 215 x 480

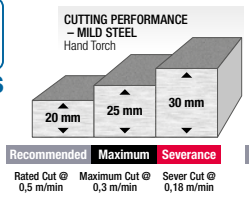
CITOCUT 60 & 100

High performance plasma cutting machines: built to handle harsh environmental conditions, suitable for on-site operations with a generator or within a workshop environment.

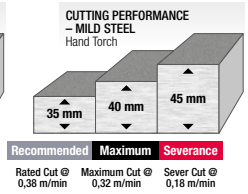
WARRANTY 3 YEARS

- Starting: innovative, advanced arc starting without HF.
- Performance: innovative, advanced electrode and nozzle design.
- Longer lifetime: innovative, advanced design increases lifetime of consumables.
- Faster: higher travel speeds and plate thickness.
- Flexible: multiple torch configurations.
- Different materials: mild steel, stainless steel, aluminium and many more.
- Concentrated plasma stream: less heat input, less distortion.
- Torch Connection – central connector, 9-pin.
- Stepless current control.
- Remote kit (optional) that allows the unit to receive an external ON-OFF trigger for mechanized processes (only for CITOCUT 100).

CITOCUT 60



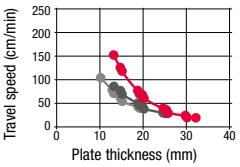
CITOCUT 100



PERFORMANCE

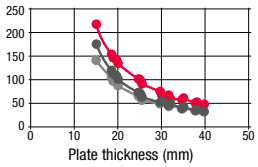
CITOCUT 60 with LC65

Comparison at 60A



CITOCUT 100 with LC105

Comparison at 100A



Aluminium — Mild — Stainless

Processes

Plasma cutting, Plasma gouging, Grid Mode

Type of Gas

- Compressed air
- Nitrogen

Applications

- On-site maintenance
- Service tasks
- Small construction sites
- General installations
- Air ducting installation (HVAC)
- Demolition work
- Rental

Input

3 PHASE — 50/60 Hz

Output

CC — DC

GENERATOR READY

UNIT INCLUDES

- 2 m-input cable
- 7,5 m-hand cutting torch
- Ground clamp and cable
- Air connection kit
- Cutting torch consumables kit

Product	Reference	Primary Voltage (50-60 Hz)	Rated Output	Cutting Capacity (mm)	Piercing Capacity (mm)*	Flow Rate	Inlet Pressure	Output Range (A)	Weight (kg)	Dimensions H x W x D (mm)
CITOCUT 60	W000403595	400V/3Ph	60A/40% 40A/100%	25	Max. 12	130l/min+/-20%@5,5 bar	6,0 bar	20-60	22	389 x 247 x 489
CITOCUT 100	W000403597		100A/40% 60A/100%	40	Max. 20	280l/min+/-20%@5,5 bar	7,0 bar	20-100	36	455 x 301 x 618

PLASMA TORCHES	3 m	7,5 m	15 m	CITOCUT 25i	CITOCUT 60	CITOCUT 100
LC25 (Hand)	PTH-C25A-SL-3MR	–	–	●		
LC65 (Hand)	–	PTH-061A-CX-7M5A	PTH-061A-CX-15MA		●	
LC65M (Machine)	–	PTM-061A-CX-7M5A	PTM-061A-CX-15MA		●	
LC105 (Hand)	–	PTH-101A-CX-7M5A	PTH-101A-CX-15MA			●
LC105M (Machine)	–	PTM-101A-CX-7M5A	PTM-101A-CX-15MA			●

LC 25 (HAND)

LC 65 (HAND)

LC 65M (MACHINE)

LC 105 (HAND)

LC 105M (MACHINE)

PLASMA-BOX LC25
W03X0893-118A

PLASMA-BOX LC65
W03X0893-113A

PLASMA-BOX LC105
W03X0893-115A

MORE DETAILS PAGE 101

ACCESSORIES		CITOCUT 25i	CITOCUT 60	CITOCUT 100
Air Filter LAF1250	W88X1456A	●	●	●
Filter Cartridge	W8800117R	●	●	●
Cutting circle	W0300699A	●	●	●
Two-wheeled undercarriage	W0200002	●		
Remote Control	K12049-1			●
Remote Control Kit	W05X1086A			●
Bevel Tool	W03X0893-119A		●	●

AIR FILTER LAF1250
W88X1456A

CUTTING CIRCLES
W0300699A

BEVEL TOOL
W03X0893-119A

TWO-WHEELED UNDERCARRIAGE
W0200002

EQUIPMENT OPTIONS

W000403940
COOLERTIG 3

W000403941
COOLERTIG 4

W000403601
COOLER 25

W000382728
FREEZTIG

K14190-1
COOL ARC®24

K14182-1
COOL ARC® 26

W000273516
COOLER III PW

W000404340
COOLER III PW COMPACT

Product	Reference	CITOTIG 1800 FORCE	CITOTIG 2200 FORCE	CITOTIG 315 DC	CITOTIG 415 DC	CITOTIG 200 AC/DC	CITOTIG 315 AC/DC	CITOSTEP 355S	CITOSTEP 425S	CITOSTEP 505S	CITOSTEEL 380C PRO	CITOSTEEL 450C PRO	CITOSTEEL 355S	CITOSTEEL 425S	CITOSTEEL 505S	CITOPULS III 320C	CITOPULS III 420	CITOPULS III 520	CITOWAVE III 420	CITOWAVE III 520
FREEZTIG	W000382728	•	•																	
COOLERTIG 3	W000403940			•																
COOLERTIG 4	W000403941				•		•													
COOLARC® 24	K14190-1					•														
COOLER 25	W000403601							•	•	•										
COOLARC® 26	K14182-1										•	•	•	•	•					
COOLER III PW	W000273516																•	•	•	•
COOLER III PW COMPACT	W000404340															•				

Product	Reference	Input Voltage	Plug	Flow sensor	Cooling Power @1l/min	Tank capacity (l)	Maximum pressure rate (Mpa)	Position	Weight (kg)	Dimensions H x W x D (mm)
FREEZTIG	W000382728	230V 50/60Hz 1Ph	16A Schuko plug	•	0,83	4,0	0,4	Horizontal	13	220 x 250 x 570
COOLERTIG 3	W000403940	400V* 50/60Hz 1Ph	Molex	•	0,75	3,6	0,4	Horizontal	18	276 x 246 x 540
COOLERTIG 4	W000403941	230V/400V* 50/60Hz 1Ph	9pin socket	•	1,0	6,0	0,4	Horizontal	22,7	255 x 300 x 700
COOLARC® 24	K14190-1	390V dc*	Molex	•	0,87	2,3	0,43	Horizontal	18	276 x 246 x 540
COOLER 25	W000403601	230V 50/60Hz 1Ph	16A Schuko plug	-	1,05	8,5	0,4	Vertical	17	748 x 238 x 248
COOLARC® 26	K14182-1	230V/400V* 50/60Hz 1Ph	Molex	•	0,84	4,0	0,47	Vertical	18	680 x 260 x 150
COOLER III PW	W000273516	230V* 50/60Hz 1Ph	Molex	-	1,3	5,0	0,45	Horizontal	16	268 x 700 x 279
COOLER III PW COMPACT	W000404340	400V* 50/60Hz 1Ph	Molex	-	1,3	5,0	0,45	Horizontal	20	268 x 700 x 279

* supplied by the welding power source

W0200002
TWO-WHEELED UNDERCARRIAGE

W000375730
UNIVERSAL TROLLEY

W000404145
CART 3

W000404146
CART 4

K14191-1
CART 24

W000383000
MODULAR TROLLEY

Product	Reference	CITOARC 270	CITOTIG 1800 FORCE	CITOTIG 2200 FORCE	CITOTIG 315 DC	CITOTIG 415 DC	CITOTIG 200 AC/DC	CITOTIG 315 AC/DC	CITOCUT 25i	CITOCUT 60	CITOCUT 100	CITOPULS III 320C	CITOPULS III 420	CITOPULS III 520	CITOWAVE III 420	CITOWAVE III 520	Wire Feed WF24	Wire Feed WF24	DMU P400	DMU P500	DMU W500
Two-wheeled undercarriage	W0200002	●		●					●												
CART 3	W000404145				●																
CART 4	W000404146					●		●													
Cart 24	K14191-1						●														
Universal trolley	W000375730		●	●																	
Modular trolley	W000383000											●	●	●	●	●					
Heavy duty four-wheeled undercarriage	K14032-1																●	●			
Trolley for wire feeder	W000275908																		●	●	●

Product	Reference	CITOARC 270	CITOROD 4005XT	CITOROD 6700XT	CITOTIG 1600 HPF	CITOTIG 1800 FORCE	CITOTIG 2200 FORCE	CITOTIG 315 DC	CITOTIG 415 DC	CITOTIG 200 AC/DC	CITOTIG 315 AC/DC	CITOCUT 100	CITOSTEEL 250C PRO	CITOSTEEL 320C PRO	CITOSTEEL 380C PRO	CITOSTEEL 450C PRO	CITOPULS III 320C	CITOPULS III 420 / 520	CITOWAVE III 420 / 520	Wire Feed 56D	DMU P400	DMU P500	DMU W500
Remote control 15m (6PIN / 1POT)	K10095-1-15M	●	●	●									●(1)(2)	●(1)(2)	●(1)(2)	●(1)(2)				●(1)			
Extension cable for remote control (6PIN) 15 m	K10398	●	●	●									●	●	●	●				●			
Remote control – hand 15m K14147-1	K14147-1				●	●	●	●	●	●	●		●(1)(2)	●(1)(2)	●(1)(2)	●(1)(2)				●(1)			
Extension for hand remote control – 15m	K14148-1				●	●	●	●	●	●	●		●	●	●	●				●			
Foot Amptrol™	K870				●	●	●	●	●	●	●		●(1)(2)	●(1)(2)	●(1)(2)	●(1)(2)				●(1)			
Remote control – 10m	W000219557					●	●																
Foot pedal	W000241602					●	●																
Remote Control	K12049-1											●(3)								●			
Remote Control MIG Yoystick 7m	K14091-1												●(2)	●(2)	●(2)	●(2)				●			
Remote control Simple Puls 10m	W000275904																●	●	●		●	●	●
RC JOB 10m	W000273134																	●			●	●	●
RC JOB II	W000371925																		●				
Remote Control 6PIN (30,4M)	K857-1												●(1)(2)	●(1)(2)	●(1)(2)	●(1)(2)				●(1)			
Remote Control 12PIN (7,6M)	K857-2												●(2)	●(2)	●(2)	●(2)				●			
Remote Control 12PIN (30,4M)	K857-3												●(2)	●(2)	●(2)	●(2)				●			

(1) K2909-1 adapter required
(2) K14290-1 kit required
(3) W05X1086A kit required

K10095-1-15M	**Remote control (1pot) 6pin (15 m)**
K14147-1	**Remote control TIG HF (1pot) 6pin (15 m)**

K10398	**Extension for K10095-1-15M (15 m)**
K14148-1	**Extension for K14147-1 (15 m)**

K857	**Remote control 6pin (7,6 m)**
K857-1	**Remote control 6pin (30,4 m)**
K857-2	**Remote control 12pin (7,6 m)**
K857-3	**Remote control 12pin (30,4 m)**

K870	**Foot amptrol 6pin (7,6 m)**

W000241602	**Foot pedal**

W000275904	**Remote control Simple Puls**

Product	Reference	CITOSTEP 355S/425S/505S	CITOSTEEL 355S/425S/505S	CITOPULS III 420 / 520	CITOWAVE III 420 / 520	Wire Feed WF24/WF24S	Wire Feed 52D/56D	DMU P400/P500	DMU W500
Air cooled connection cable (TM-TM welding cable, gas hose & control cable)									
Intermediate cable 2,5 m (70 mm², 14Pin-9Pin), AIR	K10347-PG	●				●			
Intermediate cable 5 m (70 mm², 14Pin-9Pin), AIR	K10347-PG-5M	●				●			
Intermediate cable 10 m (70 mm², 14Pin-9Pin), AIR	K10347-PG-10M	●				●			
Intermediate cable 15 m (95 mm², 14Pin-9Pin), AIR	K10347-PG-15M	●				●			
Intermediate cable 20 m (95 mm², 14Pin-9Pin), AIR	K10347-PG-20M	●				●			
Intermediate cable 25 m (95 mm², 14Pin-9Pin), AIR	K10347-PG-25M	●				●			
Intermediate cable 30 m (95 mm², 14Pin-9Pin), AIR	K10347-PG-30M	●				●			

K10347-PG-xM

Water cooled connection cable (TM-TM welding cable, water hoses, gas hose & control cable)									
Intermediate cable 2,5 m (70 mm², 14Pin-9Pin), WATER	K10347-PGW	●				●			
Intermediate cable 5 m (70 mm², 14Pin-9Pin), WATER	K10347-PGW-5M	●				●			
Intermediate cable 10 m (70 mm², 14Pin-9Pin), WATER	K10347-PGW-10M	●				●			
Intermediate cable 15 m (95 mm², 14Pin-9Pin), WATER	K10347-PGW-15M	●				●			
Intermediate cable 20 m (95 mm², 14Pin-9Pin), WATER	K10347-PGW-20M	●				●			
Intermediate cable 25 m (95 mm², 14Pin-9Pin), WATER	K10347-PGW-25M	●				●			
Intermediate cable 30 m (95 mm², 14Pin-9Pin), WATER	K10347-PGW-30M	●				●			

K10347-PGW-xM

Air cooled connection cable (TM-TM welding cable, gas hose & control cable)									
Intermediate cable 1 m (70 mm², 5Pin-5Pin), AIR	K14198-PG		●				●		
Intermediate cable 3 m (70 mm², 5Pin-5Pin), AIR	K14198-PG-3M		●				●		
Intermediate cable 5 m (70 mm², 5Pin-5Pin), AIR	K14198-PG-5M		●				●		
Intermediate cable 10 m (70 mm², 5Pin-5Pin), AIR	K14198-PG-10M		●				●		
Intermediate cable 15 m (95 mm², 5Pin-5Pin), AIR	K14198-PG-15M		●				●		
Intermediate cable 20 m (95 mm², 5Pin-5Pin), AIR	K14198-PG-20M		●				●		
Intermediate cable 25 m (95 mm², 5Pin-5Pin), AIR	K14198-PG-25M		●				●		
Intermediate cable 30 m (95 mm², 5Pin-5Pin), AIR	K14198-PG-30M		●				●		

K14198-PG-xM

Water cooled connection cable (TM-TM welding cable, water hoses, gas hose & control cable)									
Intermediate cable 1 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW		●				●		
Intermediate cable 3 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-3M		●				●		
Intermediate cable 5 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-5M		●				●		
Intermediate cable 10 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-10M		●				●		
Intermediate cable 15 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-15M		●				●		
Intermediate cable 20 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-20M		●				●		
Intermediate cable 25 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-25M		●				●		
Intermediate cable 30 m (95 mm², 5Pin-5Pin), WATER	K14199-PGW-30M		●				●		

K14199-PGW-xM

Air cooled Standard harnesses (TM-TM welding cable, gas hose & control cable)									
Harness AIR 2 m – univ. steel 70 mm	W000275894			●	●			●	●
Harness AIR 5 m – univ. steel 70 mm	W000275895			●	●			●	●
Harness AIR 10 m – univ. steel 70 mm	W000275896			●	●			●	●
Harness AIR 15 m – univ. steel 70 mm	W000275897			●	●			●	●
Harness AIR 25 m – univ. steel 70 mm	W000276901			●	●			●	●
Harness AIR 30 m – univ. steel 70 mm	W000371246			●	●			●	●

Product	Reference	CITOSTEP 355S/425S/505S	CITOSTEEL 355S/425S/505S	CITOPULS III 420 / 520	CITOWAVE III 420 / 520	Wire Feed WF24/WF24S	Wire Feed 52D/56D	DMU P400/P500	DMU W500
Water cooled Standard harnesses (TM-TM welding cable, water hoses, gas hose & control cable)									
Harness WATER 2 m – univ. steel 95 mm	W000275898			•	•			•	•
Harness WATER 5 m – univ. steel 95 mm	W000275899			•	•			•	•
Harness WATER 10 m – univ. steel 95 mm	W000275900			•	•			•	•
Harness WATER 15 m – univ. steel 95 mm	W000275901			•	•			•	•

Water cooled Aluminium harnesses (TM-TM welding cable, water hoses, gas hose & control cable)									
Harness WATER 2 m – alu. steel 95 mm	W000371044			•	•			•	•
Harness WATER 5 m – alu. steel 95 mm	W000371045			•	•			•	•
Harness WATER 10 m – alu. steel 95 mm	W000371175			•	•			•	•
Harness WATER 15 m – alu. steel 95 mm	W000371174			•	•			•	•
Harness WATER 25 m – alu. steel 95 mm	W000371239			•	•			•	•

SOLUTIONS FOR REDUCING FUME EMISSION

PURE STREAM

OERLIKON

Product	Reference	CITOSTEP 255C	CITOSTEP 305C	CITOSTEP 355C	CITOMIG 185MP/210MP	CITOSTEEL 250C/320C	CITOSTEEL 250C/320C/380C/450C PRO	CITOPULS III 320C	Wire Feed WF24/WF24S	Wire Feed 52D/56D	DMU P400/P500	DMU W500
DRIVE ROLL KIT (2R) – KIT CONTAINS 1 ROLL Ø 37 mm												
Solid wires:												
DRIVE ROLL V0,6-0,8 DIA37	KP14016-0,8	●	●	●	●			●	●		●	●
DRIVE ROLL V0,8-1,0 DIA37	KP14016-1,0	●	●	●	●			●	●		●	●
DRIVE ROLL V1,0-1,2 DIA37	KP14016-1,2	●	●	●	●			●	●		●	●
Cored wires:												
DRIVE ROLL VK0,9-1,1 DIA37	KP14016-1,1R	●	●	●	●			●	●		●	●
DRIVE ROLL VK1,2-1,6 DIA37	KP14016-1-6R	●	●	●	●			●	●		●	●
Aluminium wires:												
DRIVE ROLL U1,0-1,2 DIA37	KP14016-1,2A	●	●	●	●			●	●		●	●

DRIVE ROLL KIT (4R) – KIT CONTAINS 2 ROLLS Ø 37 mm												
Solid wires:												
DRIVE ROLLS V0,6-0,8 DIA37	KP14017-0,8			●				●	●		●	●
DRIVE ROLLS V0,8-1,0 DIA37	KP14017-1,0			●				●	●		●	●
DRIVE ROLLS V1,0-1,2 DIA37	KP14017-1,2			●				●	●		●	●
DRIVE ROLLS V1,2-1,4 DIA37	KP14017-1-4			●				●	●		●	●
ROLL V1,3-V1,4 DIAM37 2PCS	KP14017-V13/V14			●				●	●		●	●
DRIVE ROLLS V1,2-1,6 DIA37	KP14017-1,6			●				●	●		●	●
Cored wires												
DRIVE ROLLS VK0,9-1,1 DIA37	KP14017-1,1R			●				●	●		●	●
DRIVE ROLLS VK1,2-1,6 DIA37	KP14017-1,6R			●				●	●		●	●
DRIVE ROLLS VK1,6-2,4 DIA37	KP14017-2,4R			●				●	●		●	●
Aluminium wires												
DRIVE ROLLS U1,0-1,2 DIA37	KP14017-1,2A			●				●	●		●	●
DRIVE ROLLS U1,2-1,6 DIA37	KP14017-1,6A			●				●	●		●	●

DRIVE ROLL KIT (4R/TWIN) – KIT CONTAINS 4 ROLLS Ø 37 mm AND WIRE GUIDES												
Solid wires												
ROLL KIT 0,6/0,8VT FI37 4PCS GREEN/BLUE	KP14150-V06/08					●	●			●		
ROLL KIT 0,8/1,0VT FI37 4PCS BLUE/RED	KP14150-V08/10					●	●			●		
ROLL KIT 0,9/1,1VT FI37 4PCS	KP14150-V09/11					●	●			●		
ROLL KIT 1,0/1,2VT FI37 4PCS RED/ORANGE	KP14150-V10/12					●	●			●		
ROLL KIT 1,2/1,6VT FI37 4PCS ORANGE/YELL	KP14150-V12/16					●	●			●		
ROLL KIT 1,4/2,0VT FI37 4PCS	KP14150-V14/20					●	●			●		
ROLL KIT 1,6/2,4VT FI37 4PCS YELL/GREY	KP14150-V16/24					●	●			●		
Cored wires												
ROLL KIT 0,9/1,1RT FI37 4PCS	KP14150-V09/11R					●	●			●		
ROLL KIT 1,0/1,2RT FI37 4PCS -/ORANGE	KP14150-V10/12R					●	●			●		
ROLL KIT 1,2/1,6RT FI37 4PCS ORANGE/YELL	KP14150-V12/16R					●	●			●		
ROLL KIT 1,4/2,0RT FI37 4PCS	KP14150-V14/20R					●	●			●		
ROLL KIT 1,6/2,4RT FI37 4PCS YELL/GREY	KP14150-V16/24R					●	●			●		
Aluminium wires												
ROLL KIT 0,6/0,8AT FI37 4PCS GREEN/BLUE	KP14150-U06/08A					●	●			●		
ROLL KIT 0,8/1,0AT FI37 4PCS BLUE/RED	KP14150-U08/10A					●	●			●		
ROLL KIT 1,0/1,2AT FI37 4PCS RED/ORANGE	KP14150-U10/12A					●	●			●		
ROLL KIT 1,2/1,6AT FI37 4PCS ORANGE/YELL	KP14150-U12/16A					●	●			●		
ROLL KIT 1,6/2,4AT FI37 4PCS YELL/GREY	KP14150-U16/24A					●	●			●		

Product	Reference	CITOSTEP 255C	CITOSTEP 305C	CITOSTEP 355C	CITOMIG 185MP/210MP	CITOSTEEL 250C/320C	CITOSTEEL 250C/320C/380C/450C PRO	CITOPULS II 320C	Wire Feed WF24/WF24S	Wire Feed 52D/56D	DMU P400/P500	DMU W500
DRIVE ROLL KIT (2R) – KIT CONTAINS 1 ROLL Ø 37 mm												
Solid wires:												
ROLL D37 SW 0,6-0,8 MM	W000305125	●	●	●	●			●	●		●	●
ROLL D37 SW 0,8-1,0 MM	W000267598	●	●	●	●			●	●		●	●
ROLL D37 SW 1,0-1,2 MM	W000267599	●	●	●	●			●	●		●	●
ROLL D37 SW 1,2-1,6 MM	W000305126											
Cored wires:												
ROLL D37 CW 0,9-1,2 MM	W000277010	●	●	●				●	●		●	●
ROLL D37 CW 1,2-1,6MM	W000266330	●	●	●				●	●		●	●
ROLL D37 CW 1,4-1,6 MM	W000277011	●	●	●				●	●		●	●
Aluminium wires:												
ALUKIT 1,0-1,2	W000277622							●			●	●
ALUKIT 1,2-1,6	W000277623							●			●	●

MIG GUNS

PROMIG NG TORCHES

A complete range of MIG/MAG torches for industrial applications.

High quality.

Resistant to mechanical damage and high temperatures.

Wide range.

Compliant with **EN 60974-7**

Ergonomic ball joint handle.

Ultra-lightweight and durable BIKOX® cable.*

Long-life, proprietary wear parts.

Two models with turnable heads (T).

MODEL		AIR COOLING					WATER COOLING				
		141T	181T	241	341	441	241 W	341 W	441 W	450 W	501 W
Duty cycle (M21 shielding gas)		150 A @ 60%	180 A @ 60%	250 A @ 60%	320 A @ 60%	380 A @ 60%	250 A @ 100%	320 A @ 100%	380 A @ 100%	450 A @ 100%	500 A @ 100%
Duty cycle (CO_2 shielding gas)		160 A @ 60%	200 A @ 60%	270 A @ 60%	350 A @ 60%	420 A @ 60%	270 A @ 100%	350 A @ 100%	420 A @ 100%	500 A @ 100%	550 A @ 100%
Applications		1		2	3	4	2	3	4		
Wire diameter (mm)		0,6-0,8	0,8-1,0	0,8-1,0	1,0-1,2	1,0-1,6	0,8-1,0	1,0-1,2	1,0-1,6	1,0-1,6	1,2-3,2
Original equipment	Contact tip (mm)	0,8	0,8	1,0	1,2	1,2	1,0	1,2	1,2	1,2	1,6
	Conical nozzle (mm)	11	12	14	16	16	14	16	16	16	18

1 Thin plates, automotive industry
2 Thin plates, light fabrication
3 Vessel manufacture, steel structures
4 Heavy duty, high production

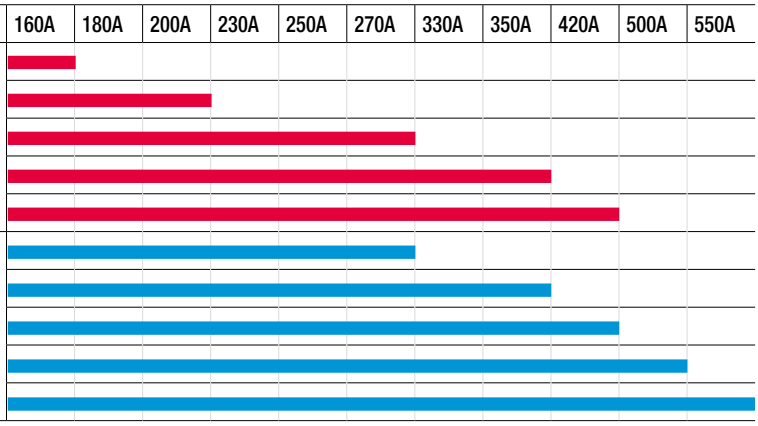
	141T	181T	241	341	441	241 W	341 W	441 W	450 W	501 W
3 m	W000275406	W000275408	W000345060	W000345066	W000345072	W000345063	W000345069	W000345075	W000274865	–
4 m	W000275407	W000275419	W000345061	W000345067	W000345073	W000345064	W000345070	W000345076	W000274866	W000274871
5 m	–	W000275420	W000345062	W000345068	W000345074	W000345065	W000345071	W000345077	W000274867	–

Choose your gun

rating calculated using CO_2

air cooled
water cooled

SERIES	Size	Rate
PROMIG NG	141T	60%
	181T	60%
	241	60%
	341	60%
	441	60%
	241 W	100%
	341 W	100%
	441 W	100%
	450 W	100%
	501 W	100%



* BIKOX® is registered tradmark of ABICOR BINZEL

PROMIG NG 141T

Nozzle	
D14 POINT	W000345405
D11	W000345403
D14	W000345404

	Ø mm		Contact tip
Steel	0,6	M 4 x 25	W000345571
	0,8		W000345572
	1,0		W000345573

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	Graphite brass liner 3 m	4 m
141T	Steel (Steel liner)	0,6	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–
		0,8					
		0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)		
		1,0				W000271824	W000271825

PROMIG NG 181T

Nozzle	
D12	W000345408
D14	W000345409

	Ø mm		Contact tip
Steel	0,8	M 6 x 32	W000345574
	1,0		W000345575
	1,2		W000345577

Diffuser
W000345335

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	Graphite brass liner 3 m	4 m
181T	Steel (Steel liner)	0,8	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–
		0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)		
		1,0					
		1,2				W000271824	W000271825

PROMIG NG 241 / 241W

Nozzle	
D12	W000345410
D14	W000345411

Diffuser
W000345335

	Ø mm		Contact tip
Steel	0,8	M 6 x 32	W000345574
	1,0		W000345575
	1,2		W000345577
Aluminium	1,0		W000345576
	1,2		W000345578

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m	Graphite brass liner 3 m	4 m
241 / 241W	Steel (steel liner)	0,6	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–	–	–
		0,8								
		0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)					
		1,0								
		1,2								
	Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)				W000271824	W000271825
		1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)	–	–
		1,2								

PROMIG NG 341 / 341W

Nozzle	
D12	W000345420
D14	W000345421
D16	W000345422

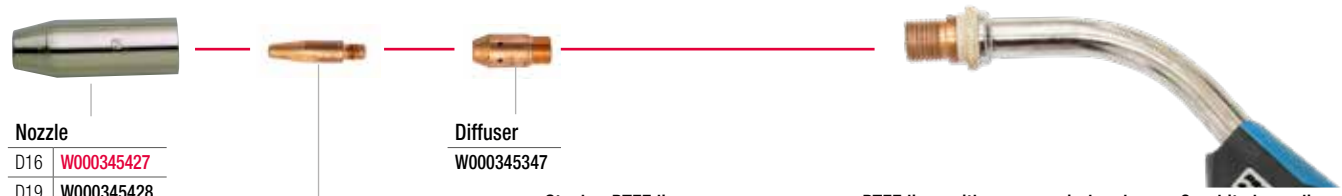
Diffuser
W000345341

	Ø mm		Contact tip
Steel	1,0	M 8 x 32	W000345580
	1,2		W000345582
	1,4		W000345584
	1,6		W000345585
Aluminium	1,0		W000345581
	1,2		W000345583

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m	Graphite brass liner 3 m	4 m
241 / 241W	Steel (steel liner)	0,6	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–	–	–
		0,8								
		0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)					
		1,0								
		1,2								
	Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)				W000271824	W000271825
		1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)	–	–
		1,2								

Original equipment parts

PROMIG NG 441 / 441W



Nozzle

D16	W000345427
D19	W000345428

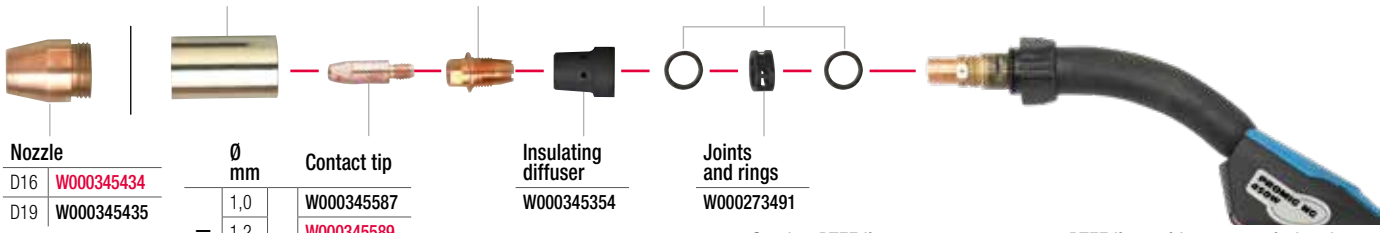
Diffuser

W000345347

	Ø mm		Contact tip
Steel	0,8	M 8 x 43,5	W000345586
	1,0		W000345587
	1,2		W000345589
	1,4		W000345591
	1,6		W000345592
Aluminium	1,0		W000345588
	1,2		W000345590
	1,6		W000345593

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m	Graphite brass liner 3 m	4 m
441 / 441W	Steel (S teel liner)	0,8	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–	–	–
		1,0	W000010733 (red)	W000010734 (red)	W000010735 (red)					
		1,2	W000010867 (yellow)	W000010868 (yellow)	W000010869 (yellow)					
		1,4								
		1,6								
	Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)				W000271824	W000271825
		1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)	–	–
		1,2								
		1,6	W000010745 (yellow)	W000010746 (yellow)	W000010747 (yellow)	–	–	–		

PROMIG NG 450W



Nozzle holder

W000345440

Contact tip holder

W000345349

Joints and rings

W000167673

Nozzle

D16	W000345434
D19	W000345435

Insulating diffuser

W000345354

Joints and rings

W000273491

	Ø mm		Contact tip
Steel	1,0	M 8 x 43,5	W000345587
	1,2		W000345589
	1,4		W000345591
	1,6		W000345592
Aluminium	1,0		W000345588
	1,2		W000345590
	1,6		W000345593

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
450W	Steel (S teel liner)	1,0	W000010733 (red)	W000010734 (red)	W000010735 (red)	–	–	–
		1,2						
		1,4	W000010867 (yellow)	W000010868 (yellow)	W000010869 (yellow)			
		1,6						
	Aluminium (PTFE liner)	1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-4M (red)
		1,2						
		1,4	W000010745 (yellow)	W000010746 (yellow)	W000010747 (yellow)	–	–	–
		1,6						

PROMIG NG 501W

Insulating piece

W000345357

Nozzle holder

W000345441

Joints and rings

W000145310

Nozzle

D16	W000345429
D18	W000345436

Joints and rings

W000169216

	Ø mm		Contact tip
Steel	1,0	M 8 x 43,5	W000345587
	1,2		W000345589
	1,4		W000345591
	1,6		W000345592
	2,4		W000345595
Aluminium	1,2		W000345590
	1,6		W000345593

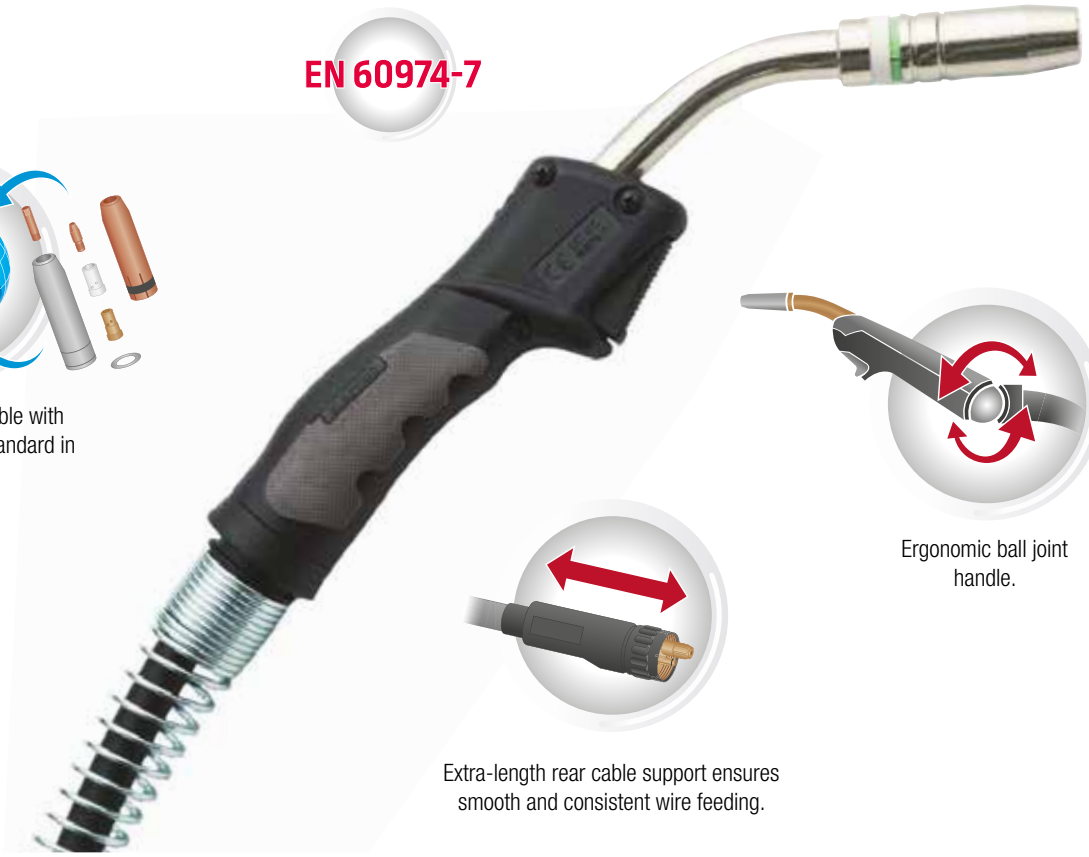
		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
501W	Steel (S teel liner)	1,0	W000010733 (red)	W000010734 (red)	W000010735 (red)	–	–	–
		1,2						
		1,4	W000010867 (yellow)	W000010868 (yellow)	W000010869 (yellow)			
		1,6						
		2,4	W000010742 (gray)	W000010743 (gray)	W000010744 (gray)			
	Aluminium (PTFE liner)	1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-4M (red)
		1,2						
		1,4	W000010745 (yellow)	W000010746 (yellow)	W000010747 (yellow)	–	–	–
		1,6						

LGS2 TORCHES

Simple and reliable – this range is adapted to the most common applications.

Compliant with

EN 60974-7



Wear parts compatible with the most common standard in Europe.

Ergonomic ball joint handle.

Extra-flexible cable.

Extra-length rear cable support ensures smooth and consistent wire feeding.

MODEL		AIR COOLING				WATER COOLING
		LGS2-150G	LGS2-250G	LGS2-240G	LGS2-360G	LGS2-505W
Duty cycle (CO_2 shielding gas)		180 A @ 60%	230 A @ 60%	250 A @ 60%	330 A @ 60%	500 A @ 100%
Applications		1	2	2	3	4
Wire diameter		Up to 1,0 mm	Up to 1,2 mm	Up to 1,2 mm	Up to 1,6 mm	Up to 2,4 mm
Original equipment	Contact tip	0,8 mm	1,0 mm	1,0 mm	1,2 mm	1,2 mm
	Conical nozzle	12 mm	15 mm	12,5 mm	16 mm	16 mm

1 Thin plates, automotive industry
2 Thin plates, light fabrication
3 Vessel manufacture, steel structures
4 Heavy duty, high production

Reference					
3 m	W10429-15-3M	W10429-25-3M	W10429-24-3M	W10429-36-3M	W10429-505-3M
4 m	W10429-15-4M	W10429-25-4M	W10429-24-4M	W10429-36-4M	W10429-505-4M
5 m	W10429-15-5M	W10429-25-5M	W10429-24-5M	W10429-36-5M	W10429-505-5M

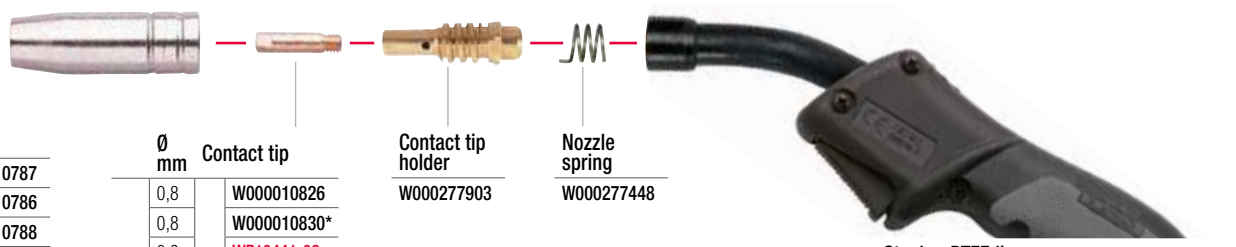
Choose your gun

rating calculated using CO_2

air cooled
water cooled

SERIES	Size	Rate	160A	180A	200A	230A	250A	270A	330A	350A	420A	500A
LGS2	150G	60%										
	250G											
	240G											
	360G											
	505W	100%										

LGS2 150G



Nozzle	
Con. D10	W000010787
Con. D12,5	W000010786
Cyl. D16	W000010788
Innershield	WP10468

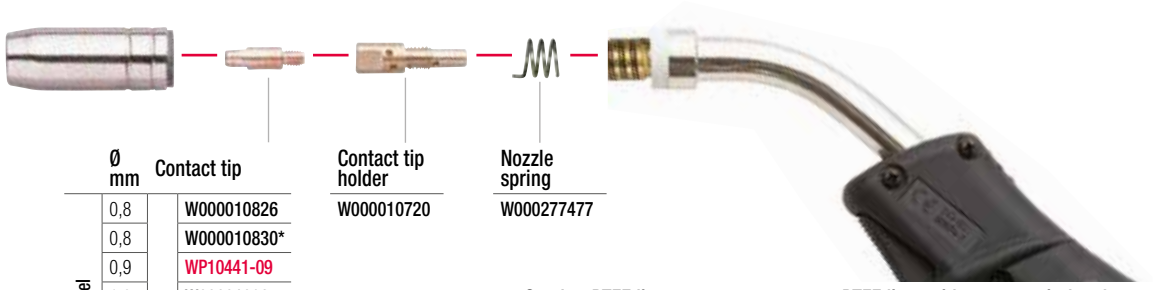
	Ø mm		Contact tip
Steel	0,8	M 6 x 28	W000010826
	0,8		W000010830*
	0,9		WP10441-09
	1,0		W000010827
	1,0		W000010831*
	1,2		W000010828
	1,2		W000010832*
Aluminium	0,8		WP10441-08A
	1,0		W000010850
	1,2		W000010851

Contact tip holder
W000277903

Nozzle spring
W000277448

	Ø mm	Steel or PTFE liner 3 m	4 m	5 m
LGS2 150G Steel (Steel liner)	0,6	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)
	0,8			
	0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)
	1,0			

LGS2 250G



Nozzle	
Con. D11	W000010791
Con. D15	W000010790
Cyl. D20	W000010792

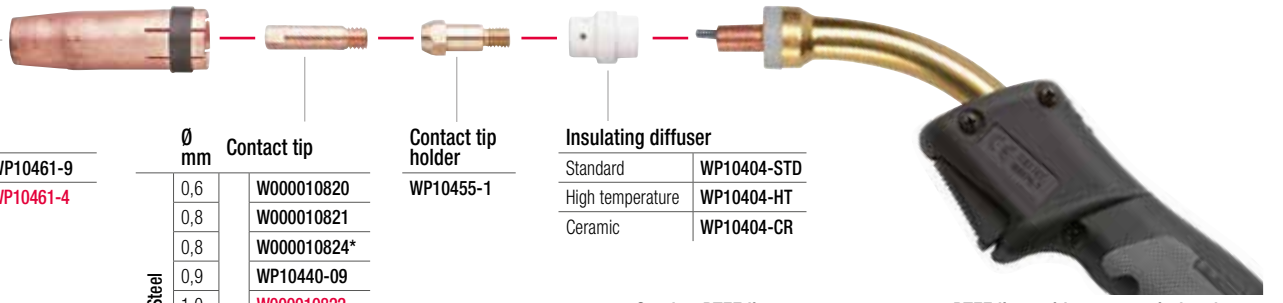
	Ø mm		Contact tip
Steel	0,8	M 6 x 28	W000010826
	0,8		W000010830*
	0,9		WP10441-09
	1,0		W000010827
	1,0		W000010831*
	1,2		W000010828
	1,2		W000010832*
Aluminium	0,8		WP10441-08A
	1,0		W000010850
	1,2		W000010851

Contact tip holder
W000010720

Nozzle spring
W000277477

	Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
LGS2 250G Steel (Steel liner)	0,8	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–
	0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)			
	1,0						
	1,2						
LGS2 250G Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)			
	1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)
	1,2						

LGS2 240G



Nozzle	
Con. D10	WP10461-9
Con. D12,5	WP10461-4

	Ø mm		Contact tip
Steel	0,6	M 6 x 25	W000010820
	0,8		W000010821
	0,8		W000010824*
	0,9		WP10440-09
	1,0		W000010822
	1,0		W000010825
	1,2		WP10440-12
	1,2		WP10440-12C*
Aluminium	0,8		WP10440-08A
	1,0		WP10440-10A
	1,2		WP10440-12A

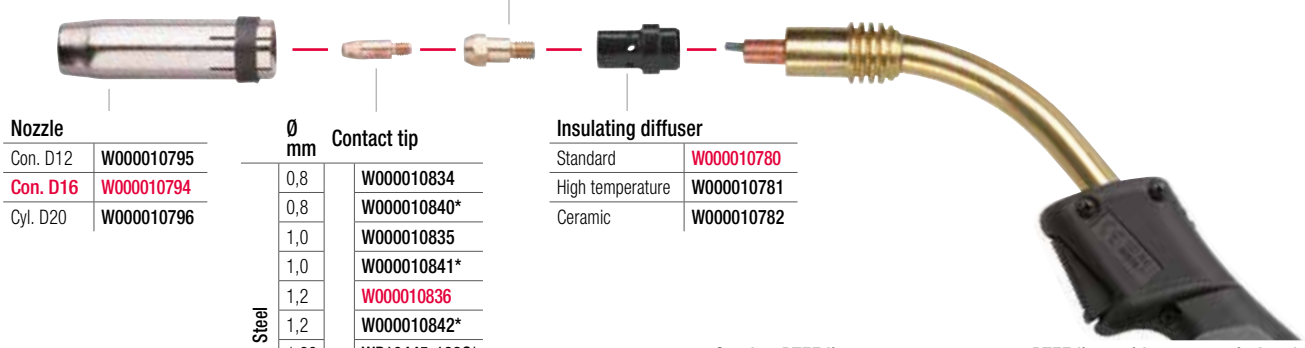
Contact tip holder
WP10455-1

Insulating diffuser	
Standard	WP10404-STD
High temperature	WP10404-HT
Ceramic	WP10404-CR

	Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
LGS2 240G Steel (steel liner)	0,6	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–
	0,8						
	0,9	W000010733 (red)	W000010734 (red)	W000010735 (red)			
	1,0						
	1,2						
LGS2 240G Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)			
	1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)
	1,2						

Original equipment parts * CuCrZr contact tips

LGS2 360G



Contact tip holder

W000010722 (M8)

Nozzle

Con. D12	W000010795
Con. D16	W000010794
Cyl. D20	W000010796

Contact tip

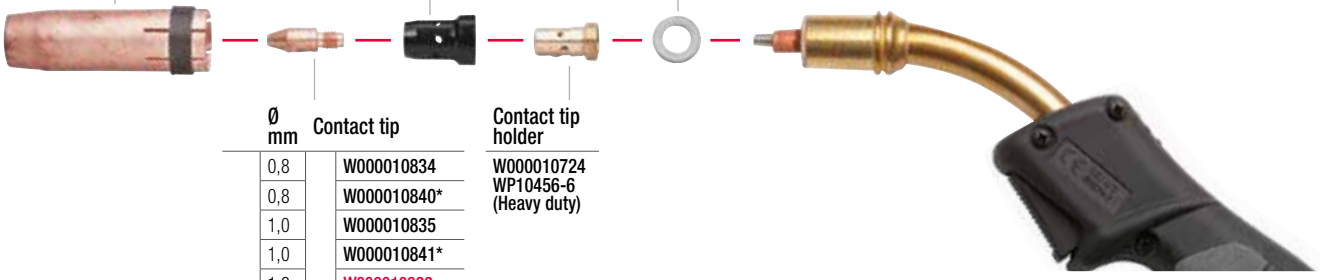
	Ø mm		
Steel	0,8	M 8 x 30	W000010834
	0,8		W000010840*
	1,0		W000010835
	1,0		W000010841*
	1,2		W000010836
	1,2		W000010842*
	1,32		WP10445-132C*
	1,4		W000262703
	1,4		W000262704*
	1,6		W000010837
	1,6		W000010843*
Aluminium	0,8		WP10445-08A
	1,0		W000010853
	1,2		W000010854
	1,6		W000010855

Insulating diffuser

Standard	W000010780
High temperature	W000010781
Ceramic	W000010782

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
LGS2 360G	Steel (Steel liner)	0,8	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–
		1,0	W000010733 (red)	W000010734 (red)	W000010735 (red)			
		1,2	W000010867 (yellow)	W000010868 (yellow)	W000010869 (yellow)			
		1,4						
		1,6						
	Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)			
		1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)
		1,2						
		1,6	W000010745 (yellow)	W000010746 (yellow)	W000010747 (yellow)	–	–	–

LGS2 505W



Nozzle

Con. D14	W000010798
Con. D16	W000010797
Cyl. D20	W000010799

Insulating diffuser

Standard	W000010783
High temperature	W000010784
Ceramic	W000010785

Insulating washer

WP10450-L77

Contact tip holder

W000010724 WP10456-6 (Heavy duty)

Contact tip

	Ø mm		
Steel	0,8	M 8 x 30	W000010834
	0,8		W000010840*
	1,0		W000010835
	1,0		W000010841*
	1,2		W000010836
	1,2		W000010842*
	1,32		WP10445-132C*
	1,4		W000262703
	1,4		W000262704*
	1,6		W000010837
	1,6		W000010843*
Aluminium	0,8		WP10445-08A
	1,0		W000010853
	1,2		W000010854
	1,6		W000010855

		Ø mm	Steel or PTFE liner 3 m	4 m	5 m	PTFE liner with copper spiral end 3 m	4 m	5 m
LGS2 505W	Steel (Steel liner)	0,8	W000010730 (blue)	W000010731 (blue)	W000010732 (blue)	–	–	–
		1,0	WP10410-3M (uncoated)	WP10410-4M (uncoated)	WP10410-5M (uncoated)			
		1,2	WP10411-3M (uncoated)	W000010740 (uncoated)	W000010741 (uncoated)			
		1,4						
		1,6						
	Aluminium (PTFE liner)	0,8	WP10422-3M (blue)	WP10422-4M (blue)	WP10422-5M (blue)			
		1,0	W000010736 (red)	W000010737 (red)	W000010738 (red)	WP10419-3M (red)	WP10419-4M (red)	WP10419-5M (red)
		1,2						
		1,6	W000010745 (yellow)	W000010746 (yellow)	W000010747 (yellow)	–	–	–

Original equipment parts * CuCrZr contact tips

DIGITORCH TORCHES

With DIGITORCH the operator can set the parameters from the handle.

DIGITORCH II E

for Citowave II & III power source

1. Digital display of parameters
2. +/- setting buttons
3. Mode selection button (programme, current, arc length).

DIGITORCH P

for Citowave II & III, Citosteel, Citosteel III, Citopuls, Citopuls II & III power sources.

Double potentiometer for setting:

- Energy and arc length in synergic mode.
- Welding current and voltage in manual mode.

MODEL		AIR COOLING		WATER COOLING			
		DIGITORCH II E 341	DIGITORCH P 341	DIGITORCH II E 341W	DIGITORCH P 341W	DIGITORCH E 441W	DIGITORCH P 441W
Duty cycle (CO_2 shielding gas)		350 A @ 60%	350 A @ 60%	350 A @ 100%	350 A @ 100%	420 A @ 100%	420 A @ 100%
Duty cycle (Ar + CO_2 shielding gas)		320 A @ 60%	320 A @ 60%	320 A @ 100%	320 A @ 100%	380 A @ 100%	380 A @ 100%
Wire diameter (mm)		1,0-1,2	1,0-1,2	1,0-1,2	1,0-1,2	1,0-1,6	1,0-1,6
Original equipment	Wire (steel) (mm)	1,2	1,0	1,2	1,2	1,2	1,2
	Ø Nozzle (mm)	16	14	16	16	16	16

MODEL	AIR COOLING		WATER COOLING			
	DIGITORCH II E 341	DIGITORCH P 341	DIGITORCH II E 341W	DIGITORCH P 341W	DIGITORCH E 441W	DIGITORCH P 441W
3 m	–	–	W000373836	W000385932	–	–
4 m	W000373831	W000345014	W000373832	W000345016	W000373833	W000345018

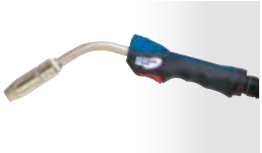
DIGITORCH II E 341

DIGITORCH II E 341W

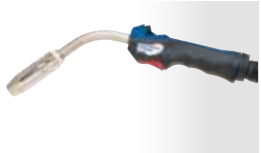
DIGITORCH P 341

DIGITORCH P 341W

DIGITORCH II E 441W



DIGITORCH P 441W



NEW

PUSH-PULL TORCHES

Welding of light alloys with a diameter from 1,0 mm to 1,6 mm.

PROMIG PP 341 & PP 441W

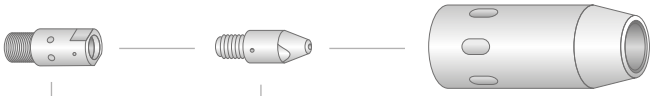
Push-Pull torches and guns for Digipuls and Digiwave. Dedicated to welding of light alloy wires. They come as standard with a 45° neck.

MODEL		AIR COOLING	WATER COOLING
		PROMIG PP 341	PROMIG PP 341W
Welding current	CO_2	350 A @ 60%	420 A @ 100%
	Mixed gas	320 A @ 60%	380 A @ 100%
Voltage class		L-113V	
Gas flow rate	Mini	10 l/min	
	Maxi	18 l/min	
Max water inlet		–	45°C
Min power of the cooling system		–	800W

PROMIG PP 341

Wear parts

Straight nozzle	W000385867
Liner for nozzles	W000385869
45° curved nozzle	W000385865
Rollers for wires, diameter 1,0	W000385956
Rollers for wires, diameter 1,2	W000385957
Rollers for wires, diameter 1,6	W000385958



Diffuser
W0000345341

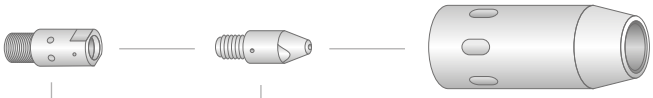
	Ø mm		Contact tip
Aluminium	1,0	M 8 x 32	W000345581
	1,2		W000345583

Ø mm	Nozzle
D12	W000345420
D14	W000345421
D16	W000345422

PROMIG PP 441

Wear parts

Straight nozzle	W000385868
Liner for nozzles	W000385871
45° curved nozzle	W000385866
Rollers for wires, diameter 1,0	W000385956
Rollers for wires, diameter 1,2	W000385957
Rollers for wires, diameter 1,6	W000385958



Diffuser
W0000345347

	Ø mm		Contact tip
Aluminium	1,0	M 8 x 43,5	W000345688
	1,2		W000345690
	1,6		W000345693

Ø mm	Nozzle
D16	W000345427
D19	W000345428

Equipment supplied and other versions

	PROMIG PP 341	PROMIG PP 341W
	Length 8 m – Swan neck 45°	
Standard	–	W000385862
With potentiometer	W000385861	W000385863

1 Standard version
2 Version with potentiometer

To obtain a gun with a straight nozzle 3 disassemble the curved swan neck of your model and replace it with a straight neck, as shown here below:

	PROMIG PP 341	PROMIG PP 341W
Straight nozzle	W000385867	W000385868

TIG TORCHES

PROTIG NG S

The ergonomic handle with button (EB).

The best WELDLINE torches with advanced ergo-design using a coloured soft grip for maximum comfort.

These torches will give you optimum welding quality and increase the communication between the welder and the machine.

The modular system provides increased control over the power source. All torches are delivered with a single button module.

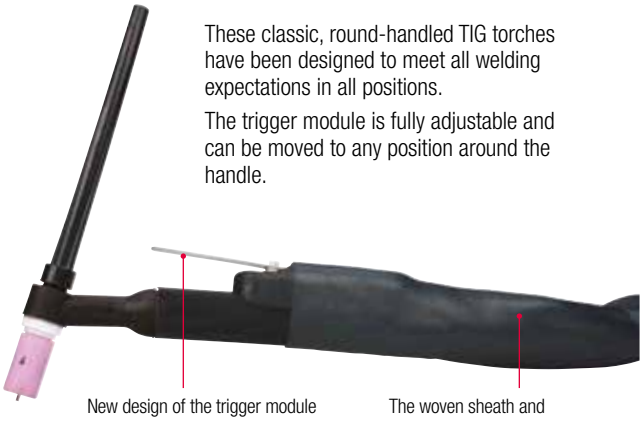
The ball joint provides excellent flexibility. The first meter of the harness is made of leather which increases the lifespan of the welding hose.

PROTIG III S

The round handle with a blade trigger (RL).

These classic, round-handled TIG torches have been designed to meet all welding expectations in all positions.

The trigger module is fully adjustable and can be moved to any position around the handle.



New design of the trigger module with metal blade.

The woven sheath and the handle sleeve ensure full flexibility of the harness.

MODEL			AIR COOLED							
			PROTIG 10		PROTIG 20		PROTIG 30		PROTIG 40	
Duty cycle 35%			125 A		150 A		200 A		250 A	
Duty cycle 60%			80 A		100 A		130 A		200 A	
Fitted as standard	back cap		Long							
	nozzle		Ø 9,6 mm				Ø 12 mm			
	electrode		Ø 1,6 mm		Ø 2,0 mm		Ø 2,4 mm			
Length			5 m	8 m	5 m	8 m	5 m	8 m	5 m	8 m
PROTIG III S	Connection	C5B/S	W000382715-2	W000382716-2	W000382717-2	W000382718-2	W000382719-2	W000382720-2	W000382721-2	W000382722-2
PROTIG NG S			W000278394-2	W000278395-2	W000278396-2	W000278397-2	W000278398-2	W000278399-2	W000278400-2	W000278401-2

MODEL			WATER COOLED (*)					
			PROTIG 10W		PROTIG 35W		PROTIG 40W	
Duty cycle 100%			220 A		350 A		450 A	
Fitted as standard	back cap		long					
	nozzle		Ø 12,8 mm		Ø 15 mm		Ø 14 mm	
	electrode		Ø 2,4 mm		Ø 4,0 mm		Ø 4,8 mm	
Length			5 m	8 m	5 m	8 m	5 m	8 m
PROTIG III S	Connection	C5B/S	W000382723-2	W000382724-2	W000382725-2	W000382726-2	W000382727-2	-
PROTIG NG S			W000278402-2	W000278403-2	W000278404-2	W000278405-2	W000278406-2	W000278407-2

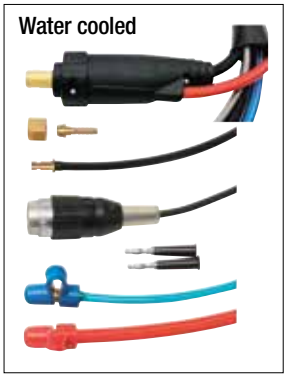
Connectors & adapters

Connectors

The connectors are newly designed, compact and fully protected and deliver both strength and quality. All hoses are made of rubber with a woven sheath for heavy duty work.

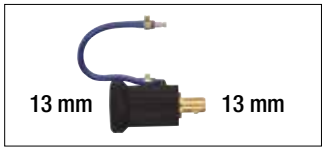
Air cooled

Water cooled



Adapters

For old torches with central gas to be connected to power sources with separate gas, use **W000306140**.



Dinse 9 to 13 mm
W000306139

For torches with separate gas to be connected to power sources with central gas, use **W000306141.**

Dinse 13 to 9 mm
038055011

OPTIONS ON PROTIG NG S

Adjustable heads

Optional, adjustable torch bodies are available. They have been designed to make welding in limited access locations easier and come with small and large heads mounted on air or water cooled bodies.

Customize your PROTIG NG torch with the following body bents and heads:

· Air cooled body bent (10/20)	W000279381
· Water cooled body bent (10W)	W000279382
· Head PROTIG NG 10/10W	W000279383
· Head PROTIG NG 20	W000279384

Modular system

All EB torches come with a single button module as standard. Additional control modules can be ordered.

Single button

Other buttons

Horizontal potentiometer

W000279370 (4,7 Kohm)
WP10529-3 (10 Kohm)

Vertical potentiometer

W000279246 (4,7 Kohm)
WP10529-4 (10 Kohm)

3 buttons module

WP10529-2

Blade

W000279245

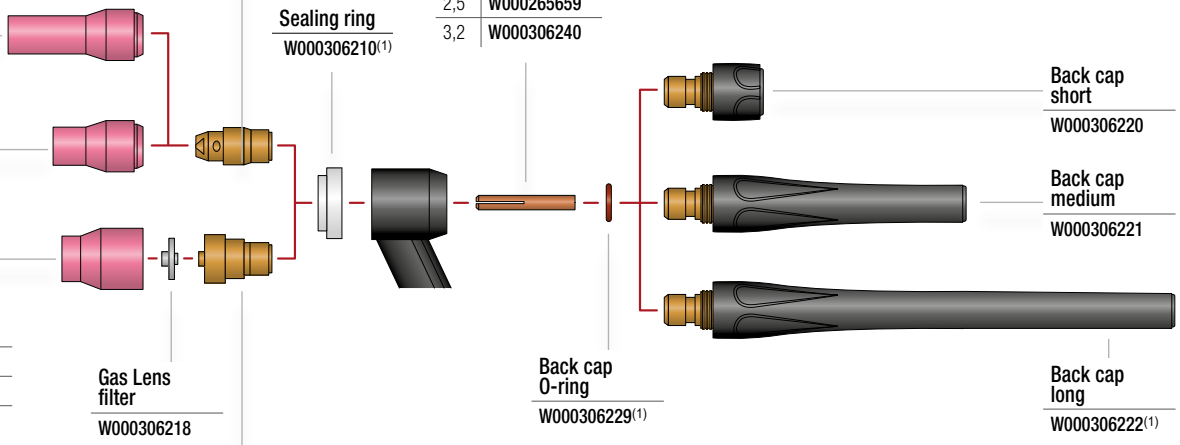
⚠ Plug kits are needed in addition to the button modules: see below table

Choose your module & your plug kit for Protig NG S

Button modules		or		or	
Reference	WP10529-2	WP10529-4 (10 Kohm)	WP10529-3 (10 Kohm)	W000279246 (4,7 Kohm)	W000279370 (4,7 Kohm)
Plug kit	· No plug kit needed · Torch is connected to the machine through the C5B plug (5 pins)	+ WP10529-9		+ WP10529-8	
Compatible with	· CITOTIG 315 / 415 DC · CITOTIG 200 AC / DC	· CITOTIG 315 / 415 DC · CITOTIG 315 AC / DC		· CITOTIG 1800 / 2200 FORCE	

The above modules work only with the PROTIG NG S torches (EB handle).

PROTIG 10 / 10W



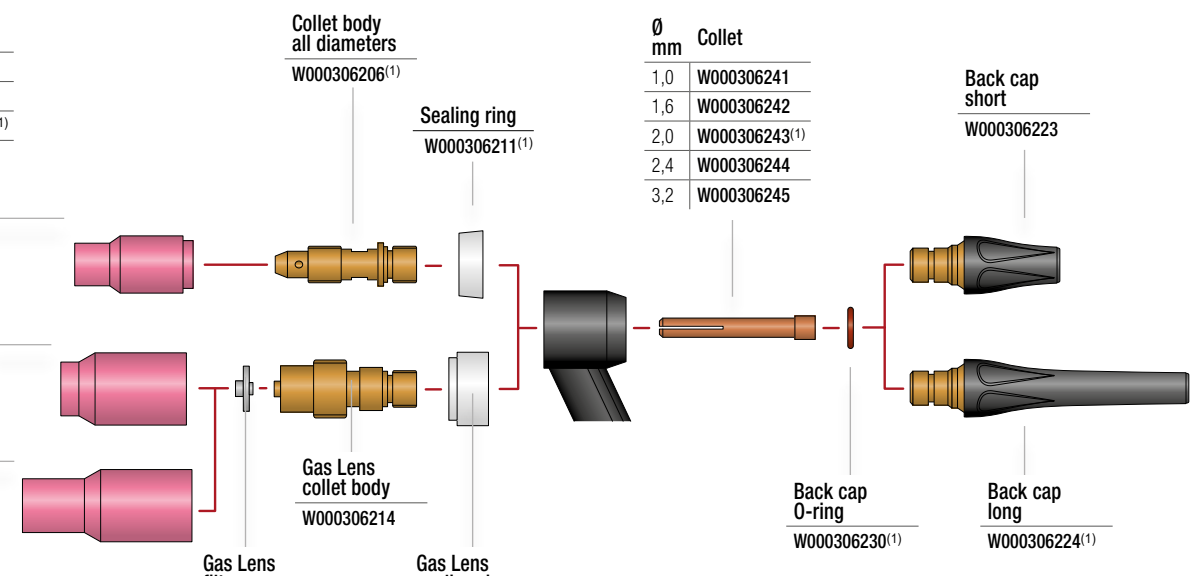
(1) Standard on all our models
(2) Standard on PROTIG 10 (NG-III) only
(3) Standard on PROTIG 10W (NG-III) only

Gas lense, for welding where access is difficult.
The gas lense collet body is supplied with a filter and a sealing ring.
The ring and the filter are supplied on their own.

Nozzles : choice of diameter

Welding current (A)	70	90	120	200
Diameter (mm)	6	8	10	12

PROTIG 20



(1) Standard

Gas lense, for welding where access is difficult.
The gas lense collet body is supplied with a filter and a sealing ring.
The ring and the filter are supplied on their own.

Nozzles : choice of diameter

Welding current (A)	70	90	120	200	350
Diameter (mm)	6	8	10	12	15

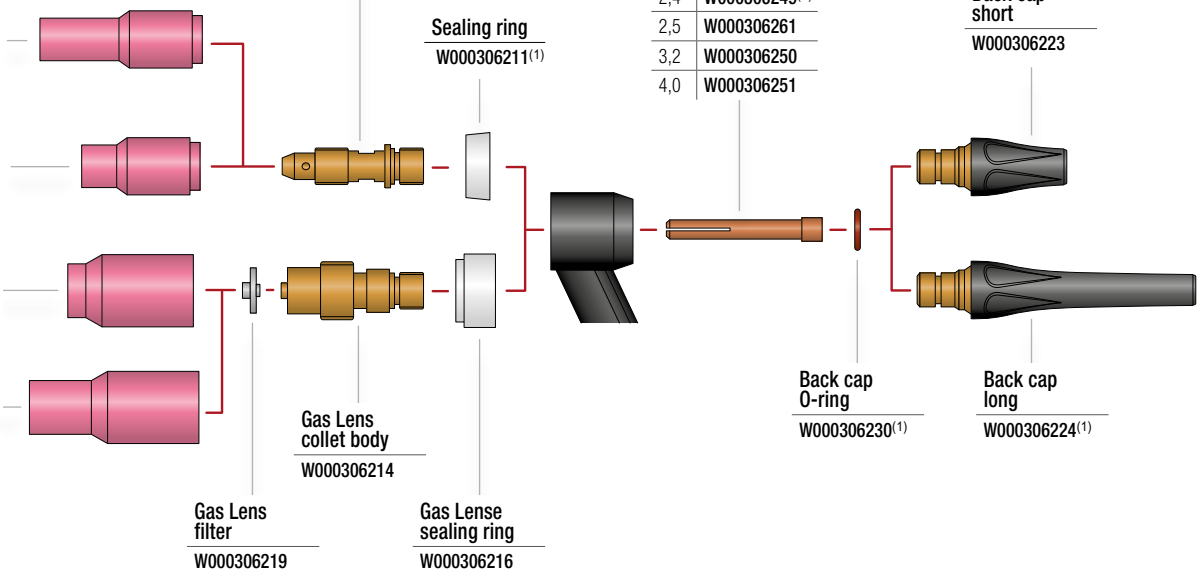
PROTIG 30

Ø mm	Nozzle
6,4	W000306277
8,0	W000306278
9,6	W000306279
12,8	W000306280(1)
15,7	W000306281

Ø mm	Gas Lens nozzle
6,4	W000306462
8,0	W000306463
9,6	W000306464
11,2	W000306465

Ø mm	Gas Lens nozzle
8,0	W000306287
9,6	W000306288
12,8	W000306289
15,7	W000306290

Ø mm	Gas Lens long nozzle
8,0	W000306467
9,6	W000306468
11,2	W000306469
12,8	W000306470



Ø mm	Collet
1,0	W000306246
1,6	W000306247
2,0	W000306248
2,4	W000306249(1)
2,5	W000306261
3,2	W000306250
4,0	W000306251

(1) Standard

Gas lense, for welding where access is difficult.
The gas lense collet body is supplied with a filter and a sealing ring.
The ring and the filter are supplied on their own.

Nozzles : choice of diameter

Welding current (A)	70	90	120	200	350
Diameter (mm)	6	8	10	12	15

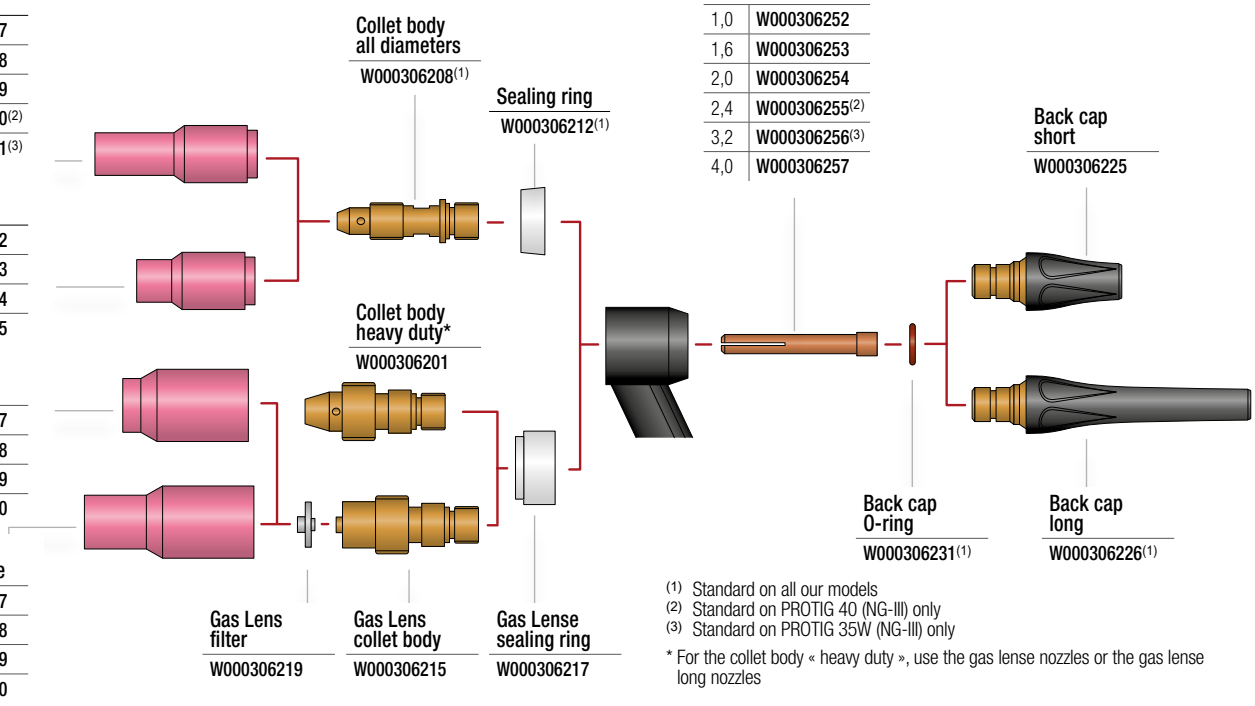
PROTIG 35W / 40

Ø mm	Nozzle
6,4	W000306277
8,0	W000306278
9,6	W000306279
12,8	W000306280(2)
15,7	W000306281(3)

Ø mm	Nozzle
6,4	W000306462
8,0	W000306463
9,6	W000306464
11,2	W000306465

Ø mm	Gas Lens nozzle
8,0	W000306287
9,6	W000306288
12,8	W000306289
15,7	W000306290

Ø mm	Gas Lens long nozzle
8,0	W000306467
9,6	W000306468
11,2	W000306469
12,8	W000306470



Ø mm	Collet
1,0	W000306252
1,6	W000306253
2,0	W000306254
2,4	W000306255(2)
3,2	W000306256(3)
4,0	W000306257

(1) Standard on all our models
(2) Standard on PROTIG 40 (NG-III) only
(3) Standard on PROTIG 35W (NG-III) only

* For the collet body « heavy duty », use the gas lense nozzles or the gas lense long nozzles

Gas lense, for welding where access is difficult.
The gas lense collet body is supplied with a filter and a sealing ring.
The ring and the filter are supplied on their own.

Nozzles : choice of diameter

Welding current (A)	70	90	120	200	350
Diameter (mm)	6	8	10	12	15

PROTIG 40W

Ø mm	Nozzle
11,0	W000306282
14,0	W000306283(1)

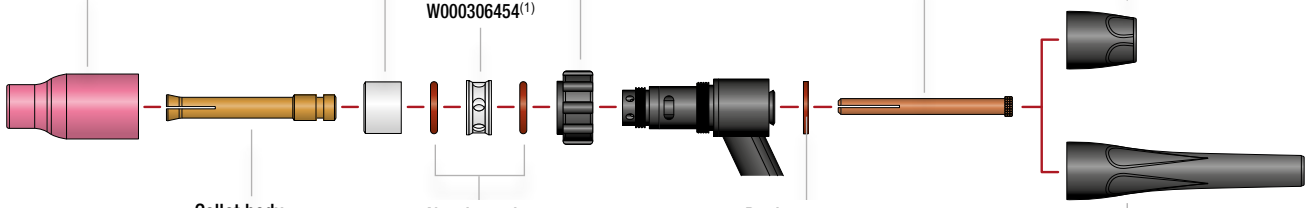
Insulating nut
W000306452(1)

Sealing ring
W000142664(1)

Ø mm	Collet
2,4	W000306262
3,2	W000306263(1)
4,0	W000306264
4,8	W000306265

Back cap short
W000306227

Water distributor
W000306454(1)



Collet body all diameters
W000306200(1)

Nozzle seals
W000167673(1)

Back cap O-ring
W000306232(1)

Back cap long
W000306228(1)

(1) Standard

Nozzles : choice of diameter

Welding current (A)	200	450
Diameter (mm)	11	14

ACCESSORIES

WEAR PART BOX PROTIG 10 / 10W
W000306441

Short back cap M8	
Medium back cap M8	
Long back cap M8	
Collet body Protig 20	
Collet Protig 10	1,0 mm
	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
Std nozzle	6,4 mm
	8,0 mm
	9,6 mm
	12,8 mm

WEAR PART BOX PROTIG 20
W000306442

Short back cap M10	
Long back cap M10	
Collet body Protig 20	
Collet Protig 20	1,0 mm
	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
Std nozzle	6,4 mm
	8,0 mm
	9,6 mm
	12,8 mm

WEAR PART BOX PROTIG 30
W000306443

Short back cap M10	
Long back cap M10	
Collet body Protig 30	
Collet Protig 30	1,0 mm
	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
	4,0 mm
Std nozzle	6,4 mm
	8,0 mm
	9,6 mm
	12,8 mm
	15,7 mm

WEAR PART BOX PROTIG 35W / 40
W000306444

Short back cap P40	
Long back cap P40	
Collet body	
Back cap o-ring (x2)	
Collet Protig 40	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
	4,0 mm
	4,8 mm
Std nozzle	6,4 mm
	8,0 mm
	9,6 mm
	12,8 mm
	15,7 mm

WEAR PART BOX PROTIG 40W
W000306445

Short back cap P40W	
Long back cap P40W	
Collet body	
Back cap o-ring (x2)	
Elastic ring	
Nozzle seals (x2)	
Water distributor	
Insulating nut	
Collet Protig 40	2,4 mm
	3,2 mm
	4,0 mm
	4,8 mm
Std nozzle	11,0 mm
	14,0 mm

WEAR PART BOX PROTIG
W000306441
W000306442
W000306443
W000306444
W000306445

EXTENSION CABLE AIR
W000306135 -15M

EXTENSION CABLE WATER
W000306136 -15M

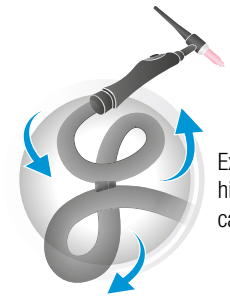
ADAPTERS
W000306140
W000306139
W000306141
038055011

WTT2 TORCHES

Simple and reliable, this range is adapted to the most common applications.

Standardized wear parts.

Easy pivoting handle (for EB handles).



Extra-flexible, high-performance cable.

Handle – made with high temperature silicon rubber.

MODEL				AIR COOLING					
				WTT2 9		WTT2 17		WTT2 26	
Duty cycle at 40 °C			60%	80 A		100 A		130 A	
			35%	110 A		135 A		180 A	
Original equipment			back cap	Long					
			nozzle	Ø 9,6 mm		Ø 9,6 mm		Ø 12,8 mm	
			electrode	Ø 1,6 mm		Ø 2,0 mm		Ø 2,4 mm	
Length				4 m	8 m	4 m	8 m	4 m	8 m
Handle	RL	Connection	S	W000278878	W000278923	W000278883	W000278918	W000278888	W000278914
			C5B	W000278879	W000278922	W000278884	W000278917	W000278890	W000278913
	EB		S	W000278877	W000278929	W000278881	W000278920	W000278886	W000278916
			C5B	W000278875	–	W000278882	W000278919	W000278887	W000278915
	V		V (Conn. 9 mm)	W000278876	–	W000278880	–	–	–
			V (Conn. 13 mm)	–	–	W10529-17-4V	–	W000278885	–
	EB-FLEX		S / C5B	W000382781	–	W000382782	W000382783	W000382784	W000382785

Connections

C5B

S

Connector:

Shaped cable output for improved robustness.

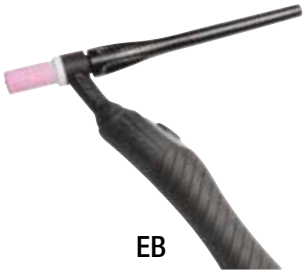
Air cooling

Water cooling

MODEL				WATER COOLING			
				WTT2 20 W		WTT2 18 W	
Duty cycle at 40 °C			100%	200 A		320 A	
			60%	250 A		350 A	
Original equipment			back cap	Long			
			nozzle	Ø 12,8 mm		Ø 16 mm	
			electrode	Ø 2,4 mm		Ø 3,2 mm	
Length				4 m	8 m	4 m	8 m
Handle	RL	Connection	S	W000278893	W000278906	W000278897	W000278900
			C5B	W000278894	W000278905	W000278898	W000278899
	EB		S	W000278891	W000278911	W000278895	W000278902
			C5B	W000278892	W000278909	W000278896	W000278901
	EB-FLEX		S / C5B	W000382786	W000382787	W000382788	W000382789

Handle

RL



EB

V

EB-FLEX

WTT2 TIG TORCHES WEAR PARTS

Model WTT2
9/9V & 20 W

Back cap short
W000306398

Back cap medium
W000306400

Back cap long
W000306402 (1)

Back cap O-ring
W000306404

Ø mm	Collet
1,0	W000306406
1,6	W000306407 (2)
2,0	W000306408
2,4	W000306409 (3)
3,2	W000306410

Sealing ring
W000306396 (1)

Ø mm	Collet body
1,0	W000306376
1,6	W000306377 (2)
2,0	W000306378
2,4	W000306455 (3)
3,2	W000306379

Ø mm	Nozzle
6,4	W000306417
8,0	W000306418
9,6	W000306419 (2)
11,2	W000306420
12,8	W000306421 (3)
16,0	W000306422

Ø mm	Long nozzle
4,8	W000306456
6,4	W000306457
8,0	W000306458
9,6	W000306459

Ø mm	Gas Lens collet body
1,0	W000306385
1,6	W000306386
2,0	W000306460
2,4	W000306387
3,2	W000306388

Ø mm	Gas Lens nozzle
6,4	W000306429
9,6	W000306431
11,2	W000306432
12,8	W000306433

Gas Lens

The gas lense provides a laminar gas flow delivering concentrated shielding of the tungsten electrode and allowing an increased stickout, which improves access to restricted joint configurations.

(1) Standard on all our models
(2) Standard on WTT2 9 EB / 9 RL / 9V only
(3) Standard on WTT2 20W EB / 20W RL only

WEAR PART BOX
WTT2 9 / 9V / 20W
W000371535

Short back cap 9-20	
Medium back cap 9-20	
Long back cap 9-20	
Collet body	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
Collet Protig 10	1,6 mm
	2,0 mm
	2,4 mm
	3,2 mm
Std nozzle	8,0 mm
	9,6 mm
	11,2 mm
	12,8 mm

WEAR PART BOX
WTT2 9 / 9V / 20W
W000371535

WTT2 TIG TORCHES WEAR PARTS

Model WTT2
17/17V, 26/26V & 18 W

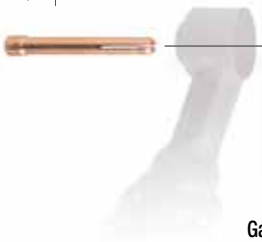
Ø mm	Nozzle
6,4	W000306423
8,0	W000306424
9,6	W000306425 (2)
11,2	W000306426
12,8	W000306427 (3)
16,0	W000306428 (4)
19,2	W000306461

Ø mm	Long nozzle
6,4	W000306462
8,0	W000306463
9,6	W000306464
11,2	W000306465

Ø mm	Collet body
1,0	W000306380
1,6	W000306381
2,0	W000270781 (2)
2,4	W000306382 (3)
3,2	W000306383 (4)
4,0	W000306384

Sealing ring
W000306397 (1)

Ø mm	Collet
1,0	W000306411
1,6	W000306412
2,0	W000306413 (2)
2,4	W000306414 (3)
3,2	W000306415 (4)
4,0	W000306416



Back cap O-ring
W000306405 (1)

Back cap short
W000306399

Back cap long
W000306403 (1)

Gas Lense sealing ring
W000306466

Ø mm	Gas Lens collet body
1,0	W000306389
1,6	W000306390
2,4	W000306391
3,2	W000306392
4,0	W000306393

Ø mm	Gas Lens nozzle
6,4	W000306434
8,0	W000306435
9,6	W000306436
11,2	W000306437
12,8	W000306438
16,0	W000306439

Ø mm	Long Gas Lense nozzle
8,0	W000306467
9,6	W000306468
11,2	W000306469
12,8	W000306470

(1) Standard on all our models
(2) Standard on only WTT2 17
(3) Standard on only WTT2 18W
(4) Standard on only WTT2 26

Gas Lens

The gas lense provides a laminar gas flow delivering concentrated shielding of the tungsten electrode and allowing an increased stickout, which improves access to restricted joint configurations.

WEAR PART BOX
WTT2 17 / 26 / 18W
W000371536

Short back cap 17-18-26	
Long back cap 17-18-26	
Collet body	1,6 mm
	2,4 mm
	3,2 mm
	4,0 mm
Collet	1,6 mm
	2,4 mm
	3,2 mm
	4,0 mm
Std nozzle	9,6 mm
	11,2 mm
	12,8 mm
	16,0 mm

WEAR PART BOX
WTT2 17 / 26 / 18W
W000371536

TUNGSTEN ELECTRODES

A complete range of tungsten electrodes.

Product advantages:

- Very high life cycle
- Perfect arc ignition
- Very stable arc
- Tip longevity

CAUTION: before use, carefully read and understand the safety datasheet available on our websites.

Type	Metal		Arc stability	Striking	Lasting	Thermal resistance
	Aluminium	Steel & Stainless steel				
WP – pure tungsten	*		**	*	*	*
WC 20 – Cerium 2%		*	**	*	**	**
WL 15 – Lanthanum 1,5%	**	***	**	***	***	***
WL 20 – Lanthanum 2%	*	***	**	***	***	***
WS 20 – Rare earths(1) 2%	*	*	**	***	***	***

*** Excellent ** Good * Average

(1) Rare earths = any of the abundant metallic elements, including scandium (atomic number 21), yttrium (39), and the 15 elements from 57 to 71 (lanthanide series include lanthanum and cerium) in the Mendeleyev classification.

- Pure tungsten
- Tungsten + cerium
- Tungsten + lanthanum
- Tungsten + rare earths

WS 2-Rare Earths

Ø (mm)	Length (mm)	Reference
1,6	175	W000335167
2,4	175	W000335169
3,2	175	W000335171

WLa 15-Lanthanum 1,5%

Ø (mm)	Length (mm)	Reference
1,6	150	W000402663
2,0	150	W000402664
2,4	150	W000402665
3,2	150	W000402667

WP-Pure Tungsten

Ø (mm)	Length (mm)	Reference
1,6	150	W000010010
1,6	175	W000010375
2,0	150	W000010011
2,4	150	W000010012
2,4	175	W000010377
3,2	150	W000010014
3,2	175	W000010378
4,0	150	W000010015

WLa20-Lanthanum 2%

Ø (mm)	Length (mm)	Reference
1,0	150	W000010373
1,6	150	W000010016
1,6	175	W000010385
2,0	150	W000010017
2,0	175	W000010386
2,4	150	W000010018
2,4	175	W000010387
3,2	150	W000010020
3,2	175	W000010388
4,0	150	W000010021

WCe-Cerium 2%

Ø (mm)	Length (mm)	Reference
1,6	150	W000010023
1,6	175	W000335153
2,0	150	W000010024
2,4	150	W000010025
2,4	175	W000335154
3,2	150	W000335150
3,2	175	W000335157
4,0	150	W000010028

PLASMA TORCHES

		AIR COOLING				
		LC 25 (Hand)	LC 65 (Hand)	LC 105 (Hand)	LC 65 (Machine)	LC 105 (Machine)
Flow rate		96 l/min@5,0 bar	130 l/min@5,0 bar	130 l/min@5,0 bar	280 l/min@5,5 bar	280 l/min@5,5 bar
Duty Cycle		25A@60%	60A@60%	60A@60%	100A@60%	100A@60%
Thickness (mm)	mild steel	10	25	25	40	40
	severance	12	30	30	45	45

	LC 25	LC 65	LC 105	LC 65	LC 105
	Hand			Machine	
3 m	PTH-C25A-SL-3MR	–	–	–	–
7,5 m	–	PTH-061A-CX-7M5A	PTH-101A-CX-7M5A	PTM-061A-CX-7M5A	PTM-101A-CX-7M5A
15 m	–	PTH-061A-CX-15MA	PTH-101A-CX-15MA	PTM-061A-CX-15MA	PTM-101A-CX-15MA

LC 25 (Hand)

10/12 mm

Electrode
W03X0893-75A

Gas distributor
W03X0893-5R

Tip
W03X0893-76A (25A)

Shield cup body
W03X0893-77A

Spacer
W03X0893-78R

25/30 mm

LC 65 (Hand)

Electrode
W03X0893-25A
(contact, stand off, shielded & gouging)

Electrode
W03X0893-53A
(extended)

Gas distributor
W03X0893-50R

Tip
W03X0893-26A (40A)
(contact)

Tip
W03X0893-27A (40A)
W03X0893-28A (50A)
W03X0893-29A (60A)
(stand off)

Retaining cap
W03X0893-41A

Spacer
W03X0893-14R

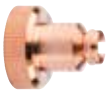
STAND OFF

Tip
W03X0893-33A (50A)
W03X0893-34A (60A)
(shielded)

Tip
W03X0893-39A
(gouging)

Tip
W03X0893-40A (40A)
W03X0893-54A (60A)
(extended)

Shield cup body
W03X0893-43A



SHIELDED

Shield cap
W03X0893-44A

GOUGING

Shield cap
W03X0893-48A

EXTENDED

Shield cap
W03X0893-21A

LC 65 (Machine)

25/30 mm

Electrode	Gas distributor	Tip	Shield cup body	Shield cup
W03X0893-25A	W03X0893-50R	W03X0893-52A (40A) W03X0893-33A (50A) W03X0893-34A (60A)	W03X0893-43A	W03X0893-46A

SHIELDED

LC 105 (Hand)

40/45 mm

Electrode
W03X0893-60A
(shielded & gouging)

Electrode
W03X0893-57A
(extended)

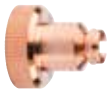
Gas distributor
W03X0893-70R

Tip
W03X0893-61A (40A)
W03X0893-62A (60A)
W03X0893-63A (80A)
W03X0893-64A (100A)
(shielded)

Tip
W03X0893-65A
(gouging)

Tip
W03X0893-58A (40A)
W03X0893-59A (60A)
W03X0893-72A (80A)
W03X0893-73A (100A)
(extended)

Shield cup body
W03X0893-66A



SHIELDED

Shield cap
W03X0893-67A

GOUGING

Shield cap
W03X0893-69A

EXTENDED

Shield cap
W03X0893-74A

LC 105 (Machine)

40/45 mm

Electrode	Gas distributor	Tip	Shield cup body	Shield cup
W03X0893-101A	W03X0893-102A (40-80A) W03X0893-103A (100A)	W03X0893-104A (40A) W03X0893-105A (60A) W03X0893-106A (80A) W03X0893-107A (100A)	W03X0893-66A W03X0893-112A (OHMIC)	W03X0893-110A (40-80A) W03X0893-111A (100A)

SHIELDED

AIR FILTER LAF1250

Sub-micron filter for compressed air. Designed to remove moisture, oils and sprays particles from air compressors, thus providing clean, free of oil and dry air.

- Better quality of the cut
- Longer life time of consumables
- Increases time life of the torch itself
- Compatible with any plasma cutting machine and torch
- Filter cartridge easily replaceable
- Useful also for different applications machines (spray painting, pneumatic tools, ...)

Reference	
Air filter LAF1250	W88X1456A
Filter cartridge	W8800117R

BEVEL TOOL

CUTTING ATTACHMENT FOR LC25/65/105

BEVEL TOOL
W03X0893-119A

CUTTING CIRCLES (max diam. 820 mm)
W0300699A

WELDLINE
WELDLINE™
by Lincoln Electric

WELDLINE™
by Lincoln Electric

MORE COMFORT AND SAFETY FOR WELDERS

Weldline® by Lincoln Electric is the transversal brand for the Welder's Environment.

By a complete offer of individual protective equipment as well as tools and accessories dedicated to welding applications, our objective is to create more comfort and safety for the welder. The portfolio is a careful selection of quality products including:

- Welding torches and expendables
- Personal protection equipment
- Other accessories for welding applications

WELDING HELMETS

WELDLINE™ by Lincoln Electric

	Euroone	Chamelon 3VO Squad / Streetart	Eurospeed LS	Chameleon 4V LS	Eurolux 4500 LS	Zephyr / Flipair 4500 LS
Lens Switching Speed (sec)	1/16,000 (0,06 ms)	1/16,000 (0,06 ms)	1/25,000 (0,04 ms)	1/20,000 (0,05 ms)	1/25,000 (0,04 ms)	1/25,000 (0,04 ms)
Variable Shade/Control	9-13 External	8-13 Internal	9-13 Internal	8-13 Internal	5-13 Internal	5-13 Internal
Light Shade (LS)	No	No	Yes	Yes	Yes	Yes
Grind Mode Shade / Control	DIN3,5 / External	DIN4 / No	DIN3,5 / Internal	DIN3 / External	DIN3 / External	DIN3 / External
Light Sensitivity Control	By infinitely dial knob	By infinitely dial knob	By infinitely dial knob	Continuous	Continuous	Continuous
Delay Control Dark to Light (sec)	0,1-1,0 by infinitely dial knob	0,1-1,0 by infinitely dial knob	0,1-1,0 by infinitely dial knob	Variable from 1-0,1	0,1-1,0 fully adjustable	0,1-1,0 fully adjustable
Additional Features	–	–	Planch of stickers	–	X-mode INFOTRACK	X-mode INFOTRACK
Arc Sensors	2	2	2	3	4	4
TIG Amp Rating	≥10 A /DC ≥ 10 A /AC	≥5 A /DC ≥5 A /AC	≥5 A /DC ≥5 A /AC	≥5 A /DC ≥5 A /AC	≥5 A /DC ≥5 A /AC	≥5 A /DC ≥5 A /AC
Cartridge Size (mm)	110 x 90 mm	110 x 90 mm	110 x 90 mm	110 x 90 mm	110 x 90 mm	110 x 90 mm
Viewing Area (mm²)	4 312	3 880	4 312	4 559	5 820	5 820
Weight (g)	490	445	475	614	542	938 + 1760
Optical Clarity	1/1/1/2	1/1/1/2	1/1/1/2	1/1/1/2	1/1/1/2	1/1/1/2
Headgear	FLEXONE	FLEX3V0	FLEXSPEED LS + cushion	FLEXTECH I	FLEXTECH I	FLEXTECH I
Battery Type	Solar cells, no battery change required	Solar cell + 2 alcaline battery	Solar cell + Battery replaceable (2xAAA alkaline batteries)	Solar cells +2 exchangeable lithium batteries	Solar cells +2 exchangeable lithium batteries	Solar cells +2 exchangeable lithium batteries
Low Battery Indicator	–	–	Yes	Yes	Yes	Yes
Harmonized standards	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997	EN 166:2001, EN 379:2003 +A1:2009, EN 175:1997, EN 12941:2009-02
Warranty (months)	12	12	18	24	24	24

WELDLINE™ by Lincoln Electric
www.weldline.eu

EUROONE

Comfortable and light retail helmet with decent specs.

- The viewing area of 4 312 mm².
- Lense switching speed: 0,06 ms.
- Two arc sensors.
- DIN 3,5/9-13.
- Delivered with two outside and two inside protection plates plus a sweat band.

Processes
Stick
MIG
Plasma Cutting
Grinding

WARRANTY 1 YEAR

RoHS Compliant 2002/95/EC

Reference	
Euroone Helmet	W000403823
Auto-Darkening Filter	W000404067

CHAMELON 3VO SQUAD / STREETART

Comfortable and light retail helmet with Auto-Start ADF Filter.

- The viewing area of 3 880 mm².
- Lense switching speed: 0,06 ms.
- Two arc sensors.
- DIN 4/8-13.
- Delivered with two outside, one inside protection plates plus antifog treated screen, one anti-transpiration headband and one comfort cushion.

Processes
Stick
MIG

WARRANTY 1 YEAR

RoHS Compliant 2002/95/EC

Reference	
Chamelon 3VO Squad	W000403546
Chamelon 3VO Streetart	W403547
Auto-Darkening Filter	W000377928

EUROSPEED LS / EUROSPEED LS *Female*

All the comfort and security of an autodarkening helmet, delivered with different stickers for personalization.

- The viewing area of 4 312 mm².
- Lense switching speed: 0,04 ms.
- Two arc sensors.
- DIN 3,5/9-13.
- Delivered with two outside and one inside protection plates plus a sweat band and a comfort cushion on the headgear.
- Magnifying "cheater" lense capability.
- New, pivot-style headgear.

Processes
Stick
TIG
Pulsed TIG
MIG
Pulsed MIG
Flux-Cored
Gouging
Plasma Cutting
Grinding

WARRANTY 18 MONTH

RoHS Compliant 2002/95/EC

Reference	
Eurospeed LS Helmet	W000403824
Eurospeed LS Helmet Blackrobot Edition	W000403824-1
Eurospeed LS Helmet Female Edition	W000403824-2
LCD cell	W000404097

CHAMELEON 4V+ LS

Autodarkening helmet adapted for TIG welding, switching at very low amperage (5A).

- The viewing area of 4 559 mm².
- Lense switching speed: 0,05 ms.
- Three arc sensors.
- DIN 3/8-13.
- Prepared especially for TIG.
- Grinding mode with external button.
- Delivered with five outside and two inside protection plates plus a sweat band and a comfort cushion on the headgear.

Reference	
Chameleon 4V+ LS Helmet	W000403668
LCD cell	W000402680

Processes
Stick
TIG
Pulsed TIG
MIG
Pulsed MIG
Flux-Cored
Gouging
Plasma Cutting
Grinding

WARRANTY 2 YEARS

RoHS 2002/95/EC compliant

EUROLUX LS

Light-weight autodarkening helmet with optimized head protection and an exclusive design.

- The viewing area of 5 820 mm².
- Lense switching speed: 0,04 ms.
- Four arc sensors.
- DIN 3/5-13.
- INFOTRACK & X-mode.
- Grinding mode with external button.
- Four independent optical sensors.
- Delivered with five outside and two inside protection plates plus a sweat band and a comfort cushion on the headgear.

Reference	
Eurolux LS Helmet	W000403672
LCD cell	W000402681

Processes
Stick
TIG
Pulsed TIG
MIG
Pulsed MIG
Flux-Cored
Gouging
Plasma Cutting
Grinding

WARRANTY 2 YEARS

RoHS 2002/95/EC compliant

PREMIUM RANGE

ZEPHYR LS / FLIPAIR LS

Bring the fume protection and filtered air directly to the operator working in difficult conditions.

- Large viewing area of 5 820 mm².
- Lense switching speed: 0,04 ms.
- Four arc sensors.
- DIN 3/5-13.
- INFOTRACK & X-mode.
- Helmet with powered and filtered airflow.
- ZEPHIR LS: Grinding mode with external button.
- FLIPAIR LS: FLIP UP version.
- Flip-up LCD filter for grinding (Flipair LS).
- The ultimate welder protection.
- Delivered in a rugged carry bag with accessories.

Reference	
Zephyr LS Helmet	W000403674
Zephyr LS LCD cell	W000402681
Flipair LS Helmet	W000403675
Flipair LS LCD cell	W000402682

Processes
Stick
TIG
Pulsed TIG
MIG
Pulsed MIG
Flux-Cored
Gouging
Plasma Cutting
Grinding

WARRANTY 2 YEARS

RoHS 2002/95/EC compliant

WELDING GEAR

MIG UNIVERSAL COMFORT

- The UNIVERSAL COMFORT gloves are designed to protect the hand during normal welding applications in MMA/MIG/MAG/TIG processes and have a grain leather palm for extra sensitivity.

Heat resistance ★★★☆☆
Dexterity ★★★★★
Abrasion resistance ★★★★☆
Molten metal splashes ★★★★★

Recommended use
Stick, MIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 12477: 2001+A1:2005
UNI EN 388: 2016
UNI EN 407: 2004

Reference	
Size 9	WG-MIG-1-CE-T9
Size 10	WG-MIG-1-CE
Size 11	WG-MIG-1-CE-T11

MIG UNIVERSAL COMFORT +

- The UNIVERSAL COMFORT + gloves are designed to protect the hand during normal welding applications in MMA/MIG/MAG processes.

Heat resistance ★★★★☆
Dexterity ★★★★☆
Abrasion resistance ★★★★★
Molten metal splashes ★★★★★

Recommended use
Stick, MIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 12477: 2001+A1:2005
UNI EN 388: 2016
UNI EN 407: 2004

Reference	
Size 9	WG-MIG-2-CE-T9
Size 10	WG-MIG-2-CE
Size 11	WG-MIG-2-CE-T11

MIG IRON PROTECT

- The MIG IRON PROTECT gloves are designed to deliver a high level of protection during normal welding applications in MMA/MIG/MAG processes.

Heat resistance ★★★★★
Dexterity ★★★☆☆
Abrasion resistance ★★★☆☆
Molten metal splashes ★★★★★

Recommended use
Stick, MIG

European Standard of gloves
EN 420: 2009 3
EN 388: 2016 4 2 3 4 x x
EN 407: 2004 4 1 3 2 4 x
EN 12477: 2001 + A1 2005

Reference	
Size 10	WG-MIG-3-CE
Size 11	WG-MIG-3-CE-T11

WELDLINE™ by Lincoln Electric
www.weldline.eu

MIG IRON PROTECT +

- The MIG IRON PROTECT+ gloves are designed to deliver a high level of protection during normal welding applications in MMA/MIG/MAG processes.
- The natural grain leather palm gives extra sensitivity.

Heat resistance ★★★★★
Dexterity ★★★★☆
Abrasion resistance ★★★☆☆
Molten metal splashes ★★★★★

Recommended use
Stick, MIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 388: 2016
UNI EN 407: 2004
UNI EN 12477: 2001+A1:2005

Reference	
Size 10	WG-MIG-4-CE
Size 11	WG-MIG-4-CE-T11

TIG FLEX SENSITIVE

- The TIG FLEX SENSITIVE gloves are designed to give a high level of dexterity and flexibility for normal welding applications in TIG/Flame processes.
- The favourite gloves of TIG welders.
- Made of goat leather.

Heat resistance ★★☆☆☆
Dexterity ★★★★★
Abrasion resistance ★★☆☆☆
Molten metal splashes ★★★☆☆

Recommended use
TIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 388: 2016
UNI EN 407: 2004
UNI EN 12477: 2001+A1:2005

Reference	
Size 8	WG-TIG-8-CE
Size 9	WG-TIG-9-CE
Size 10	WG-TIG-10-CE
Size 11	WG-TIG-11-CE

STOPCALOR ALU

The STOPCALOR ALU gloves are designed to deliver a high level of protection during heavy welding applications.

- COMFORT: the split leather and cotton fleece lining increase the gloves' thermal insulation.
- RESISTANCE: the aluminized KevlarR textile back offers strong resistance to heat, radiation and small splashes of molten metal.
- SAFETY: the split leather cuff helps to protect a large part of the forearm against mechanical hazards.

Heat resistance ★★★★★
Dexterity ★★★☆☆
Abrasion resistance ★★★★★
Molten metal splashes ★★★★★

Recommended use
Stick, MIG

European Standard of gloves
EN 420: 2003 5
EN 388: 2003 3143 x x
EN 407: 2004 41344 x
EN 12477: 2000 typeA

Reference	
Size 10	W000010420

TIG FLEX SENSITIVE
Female

- The TIG FLEX SENSITIVE FEMALE gloves are designed to ensure the high level of dexterity and flexibility for regular welding applications in TIG/ Flame processes.
- Made of goat leather, they are the favourite gloves of female TIG welders.

Heat resistance	Dexterity	Abrasion resistance	Molten metal splashes
★★☆☆☆	★★★★★	★★☆☆☆	★★★☆☆

Recommended use
TIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 388: 2016
UNI EN 407: 2004
UNI EN 12477: 2001+A1:2005

Reference	
Size 8	WG-TIG-8-CEL TIG
Size 9	WG-TIG-9-CEL TIG

MIG UNIVERSAL COMFORT
Female

- The UNIVERSAL COMFORT FEMALE gloves are designed to protect hands during regular welding applications in MMA/MIG/ MAG/TIG processes and have grain leather palms for extra sensitivity.

Heat resistance	Dexterity	Abrasion resistance	Molten metal splashes
★★★☆☆	★★★★★	★★★★☆	★★★★★

Recommended use
Stick, MIG

European Standard of gloves
UNI EN 420: 2013+A1:2009
UNI EN 388: 2016
UNI EN 407: 2004
UNI EN 12477: 2001+A1:2005

Reference	
Size 8	WG-MIG-1-CET8-L
Size 9	WG-MIG-1-CET9-L

WORKER GLOVES FULL LEATHER STEEL

- Top grain cowhide leather delivers excellent fit and dexterity while the goat skin back allows the glove to breathe.
- The palm is padded for comfort and the hook and loop soft rubber tabbed wrist closure with a flexible elastic band ensures a snug, comfortable fit.

Recommended use
Fabrication work

European Standard of gloves
Personal Protective Equipment Regulation PPER (EU) 2016/425.
EN 388: 2016+A1:2018

Reference	
Size S	W2977-S-CE
Size M	W2977-M-CE
Size L	W2977-L-CE
Size XL	W2977-XL-CE

THERMAL SCREEN

Thermal protection added to a glove.

- Dimensions 200 x 150 mm.
- Fitted with two elastic straps at palm and cuff level.
- Split leather lined with Kevlar. Heat and flame resistant.
- One aluminized side reflects 95% of radiant heat.
- Double Kevlar thread seams.
- The set consists of two pieces.

Reference
W000335162

YOUR SAFETY IN THE WELD'FIT COMFORT!

WELD'fit products are heat and flame resistant and provide the highest protection for the welders.

Composition:

- Jacket: split leather, grain leather.
- Apron, sleeves and gaiters: split leather, grain leather.

Standard:

Rules (EU) 2016/425 European Regulation on Personal Protective Equipment

UNI EN ISO 13688:2013: (general requirements for innocuousness, ergonomics and sizes), **UNI EN ISO 11611:2015:** (use in welding operations and related procedures)
Products are manufactured according to the Rules (EU) 2016/42

SHORT AND LONG SLEEVES

The short and long sleeves in split leather are intended to protect arms from fine welding spatters.

- Made of split leather tanned with chromium salts (mineral substances).
- Fixed with leather straps.
- Elastic ribbing on the wrists.
- Single size.

PPE II° category
Certified by EU 425/2016
EN 11611 A1 Class 2

Reference	
Short oversleeves	W000404083
Long oversleeves	W000404084

Long oversleeves
Our long oversleeves cover sleeves up to 60 cm wide. They are ergonomic, elastic at the wrist and easy to fasten with leather laces on the shoulders.

Short oversleeves
Short oversleeves cover sleeves up to 40 cm wide, and are ergonomic and elastic at the ends.

SPLIT LEATHER WELDING JACKET

Fastened with snap buttons covered with leather, our comfortable split leather jacket has an inside pocket. Split leather welding jackets are designed to protect the upper body of the user from fine welding spatters and grinding particles.

- The jacket fastens at the front with an overlap of leather and Velcro for additional protection against spatters; the inner neck is made of double cotton for comfort.
- Elastic ribbing on the wrists.
- Finished in red trim.
- Length: +/- 780 mm.
- Available sizes: S, M, L, XL, 2XL, 3XL, 4XL and 5XL.

PPE II° category
Certified by EU 425/2016
EN 11611 A1 Class 2

Reference	
Size S*	W000404090-S
Size M*	W000404090-M
Size L	W000404090-L
Size XL	W000404090
Size 2XL	W000404091
Size 3XL*	W000404090-3XL
Size 4XL*	W000404090-4XL
Size 5XL*	W000404090-5XL

* On demand

Button closure under flap

Customize your welding jacket thanks to the removable velcro band

Breathable

GRAIN LEATHER WELDING JACKET

Fastened with snap buttons covered with leather, our comfortable, regular fit grain leather jacket has an inside pocket and is elastic at the wrist.

- Half of the back is made from flame retardant cotton, ensuring the jacket is light and flexible.
- The jacket fastens at the front with an overlap of leather and Velcro for additional protection against spatters; the inner neck is made of double cotton for comfort.
- Elastic ribbing on the wrists.
- Finished in red trim.
- Length: +/- 780 mm.
- Available sizes: S, M, L, XL, 2XL, 3XL, 4XL and 5XL.

PPE II° category
Certified by EU 425/2016
EN 11611 A1 Class 2

Reference	
Size S*	W000404092-S
Size M*	W000404092-M
Size L	W000404092-L
Size XL	W000404092
Size 2XL	W000404093
Size 3XL*	W000404092-3XL
Size 4XL*	W000404092-4XL
Size 5XL*	W000404092-5XL

* On demand

Button closure under flap

Customize your welding jacket thanks to the removable velcro band

Breathable

With the blank velcro, you can add your company's logo, name or message of your choice.

GRAIN LEATHER WELDING JACKET
Female

Fastened with snap buttons covered with leather, grain leather jackets for HER are adjustable and comfortable. These welding jackets are designed to protect the upper body.

- 100% leather.
- The jacket overlaps at the front offering additional protection against spatters. The inner neck coating consists of two layers of cotton for extra comfort.
- Finished in pink trim.
- Length: +/- 780 mm.
- Available sizes: S, M, L, XL.
- One split leather bag included.

PPE II° category
Certified by EU 425/2016
EN 11611 A1 Class 2

Reference	
Size S	WJL-S-2019
Size M	WJL-M-2019
Size L	WJL-L-2019
Size XL	WJL-XL-2019

Included: one split leather bag.

Use the bag provided with the jacket to create your personalized package.

GAITERS

Split leather gaiters fastened with straps or with leatherband are used to protect the bottom of the trousers and shoes from sparks and heat generated during welding and grinding operations.

Width: 30 cm.

- The gaiters are manufactured from four pieces that are stitched together. Adjustable leather belt/velcro strap and under-strap are added to secure the shoes.

PPE II° category
Certified by EU 425/2016
EN 11611 A1 Class 2

Reference	
Gaiters with straps	W000404081
Gaiters with velcro	W000404082

LEATHER APRON

Designed to protect clothes from welding spatters and grinding particles.

Grain leather apron

- Protective welding apron made of premium grain leather tanned with chromium salts (mineral substances).
- Leather strap fixed through bound eyelets to the waist and the flap.
- Single size.

Split leather apron

- Premium split leather protective welding apron is tanned with chromium salts (mineral substances).
- Leather or cotton strap with quick release clips attached to the waist and the flap.

Reference	
Grain leather apron 1100 x 800	W000404085
Split leather apron 1100 x 800	W000404086
Split leather apron 900 x 600 leather laces	W000404087
Split leather apron 900 x 600 fabric laces	W000404088

Grain leather apron

Split leather apron

Fastened with clips or cotton straps.

Available from May

WELDLINE™ by Lincoln Electric
www.weldline.eu

WELD'FIT COTTON CLOTHING

WELD'fit WELDING GARMENTS are made from 305 gr/m² flame retardant fabric – high heat resistance and spatter, contain multiple pockets which are fastened with velcro and manufactured according to EN ISO 11611:2015 Class 1/A1+A2.

As requested by en norms, our items have clear and permanent marking and are sold together with their instruction manual.

Regulation:

Personal Protective Equipment Regulation PPER (EU) 2016/425.

EN ISO 11611 - Protective clothing for welding and related processes.

Clothing produced according to EN ISO 11611 serves to protect the wearer whilst welding or performing allied processes involving comparable risks. This clothing provides protection against spatter (minor splashes of molten metal) and so-called welding beads as well as brief contact with flames and radiant heat from the arc. Under normal welding conditions, it off ers limited electrical insulation against DC voltage of up to approximately 100 V. According to EN ISO 11611, the clothing is divided into the following classes depending on their level of protection:
Class 1 or Class 2.

Class 1 – protection against less hazardous welding techniques and situations causing lower levels of spatter and radiant heat.

A1-A2 – Protection against limited flame spread.

Customizable velcro

Sleeve tightening snap button

BLACK WELDING TROUSERS – FLAME RETARDANT COTTON

Practical and comfortable trousers in flame retardant cotton. Black & Red flame retardant fabric 305 gr./m².

- Knee protection.
- Left side back pocket, fastened with velcro.
- Black Kevlar thread (Aramid fabric).
- Machine Washable 40°.

Personal Protective Equipment Regulation

PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
Size M	WP10570-M
Size L	WP10570-L
Size XL	WP10570-XL
Size 2XL	WP10570-2XL

Available from May

WELDING HOOD – FLAME RETARDANT COTTON

One size fits all. Head and neck cover. Black & Red flame retardant fabric 305 gr./m². Width: 30 cm.

- Black Kevlar thread (Aramid fabric).
- Machine Washable 40°.

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
All size	W2995-ALL-CE

DOO RAG – FLAME RETARDANT COTTON

One size fits all. Let your WELDLINE by LINCOLN ELECTRIC colours show! This premium doo rag, made from 305 gr./m² flame retardant fabric, features an athletic mesh for fast sweat evaporation.

- Black Kevlar thread (Aramid fabric).
- Machine Washable 40°.

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
All size	W2993-ALL-CE

WELDING BEANIE – FLAME RETARDANT COTTON

One size fits all. Protect your head with this authorized WELDLINE by LINCOLN ELECTRIC flame retardant beanie.

- Black Kevlar thread (Aramid fabric).
- Stretch.
- Machine Washable 40°.

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
All size	W2994-ALL-CE

Available from May

WELDLINE™ by Lincoln Electric
www.weldline.eu

TRADITIONAL SPLIT LEATHER-SLEEVED JACKET

Split cowhide sleeves resist spatter and wear, while lightweight material on the chest and back keep the wearer cool and comfortable. This basic jacket features an inside pocket and adjustable sleeves. Stylish and comfortable. Adjustable sleeves snap into place. Made with 100% flame-retardant material for maximum protection. Black & Red flame retardant fabric 305 gr./m².

- One Internal left pocket.
- Sleeve tightening snap button.
- Collar fastened with velcro.
- Black Kevlar thread (Aramid fabric).
- Not Washable.

Customize your welding jacket thanks to the removable velcro band

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
Size M	W3106-M-CE
Size L	W3106-L-CE
Size XL	W3106-XL-CE
Size 2XL	W3106-2XL-CE
Size 3XL	W3106-3XL-CE

GRAIN LEATHER-SLEEVED JACKET

For optimal protection and freedom of movement for MIG or stick welding, choose our full-grain leather sleeve jacket with a flame-retardant, 100% cotton chest panel. The flip-up collar secures with an adjustable hook and loop closure, and the front panel secures with an extra flap for full closure. Horizontal hip pockets provide secure compartments for personal items. Comfort and dexterity for MIG or stick welding. Black & Red flame retardant fabric 305 gr./m².

- Two external pockets which are closable with velcro.
- Sleeve tightening snap button.
- Collar fastened with velcro.
- Black Kevlar thread (Aramid fabric).
- Not washable.

Customize your welding jacket thanks to the removable velcro band

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
Size M	W2987-M-CE
Size L	W2987-L-CE
Size XL	W2987-XL-CE
Size 2XL	W2987-2XL-CE
Size 3XL	W2987-3XL-CE

Available from May

WELDING JACKET – FLAME RETARDANT COTTON

Made from 100% flame-retardant material, our cloth jacket is ideal for light-duty welding. A convenient inside pocket stows personal items. Protection for light & duty welding. Black & Red flame retardant fabric 305 gr./m².

- One Internal left pocket.
- Sleeve tightening snap button.
- Collar fastened with velcro.
- Black Kevlar thread (Aramid fabric).
- Machine Washable 40°.

Customize your welding jacket thanks to the removable velcro band

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
Size M	W2985-M-CE
Size L	W2985-L-CE
Size XL	W2985-XL-CE
Size 2XL	W2985-2XL-CE
Size 3XL	W2985-3XL-CE

WELDING LAB COAT – FLAME RETARDANT COTTON

This knee-length coat is ideal for instructors, supervisors and occasional welders. Made from 100% flame retardant material, it's designed for use by not just the welder but anyone in the immediate work area. Pockets at the hips and chest store chalk, grease pens or other items. Black & Red flame retardant fabric 305 gr./m². Ideal for instructors, supervisors. Protection for light & duty welding.

- Two external pockets at waist height and one on the left chest. All are fastened with velcro.
- Sleeve tightening snap button.
- Collar fastened with velcro.
- Black Kevlar thread (Aramid fabric).
- Machine Washable 40°.

Customize your welding jacket thanks to the removable velcro band

Personal Protective Equipment Regulation
PPER (EU) 2016/425
EN ISO 11611:2015 Class 1/A1+A2

Reference	
Size M	W3112-M-CE
Size L	W3112-L-CE
Size XL	W3112-XL-CE

PANTER-FUSION 49 S3

Our safety boots with special cuff for welding protection are produced from extra thick, breathable and fireproof full grain leather. Extremely strong and durable, they protect against high temperatures.

- Protective footwear against thermal risks and splashes of molten metal, resistant to flames and sewn with flame retardant yarn.
- Non-metallic, anti-impact toe cap and flexible, puncture-proof midsole.
- Special nitrile rubber sole is resistant to high temperatures (300 °C) and offers effective insulation from cold and extreme heat. Adherent to all kinds of surfaces, it provides traction and stability and is resistant to oils and hydrocarbons.
- Antistatic boot.
- Wide frame that does not restrain the foot.
- Removable, interchangeable, antibacterial, antistatic and anti-fungus insoles.
- Very breathable, wear-resistant lining.
- Anti-scratch, custom-fit, ankle supporting padding.
- Reinforced toe that protects the area most exposed to bumps and chafing guarantees a longer shoe life.
- Double closure for better fit and protection against metal sparks. Finished with high performance industrial fabric and inner laces with leather bellows tongue that prevent the entry of foreign objects.

level of protection
S3+WG+Hi1+Ci+HRO+AN
EN ISO 20345
EN ISO 20349

Size	Reference
36	W49S3T36
37	W49S3T37
38	W49S3T38
39	W49S3T39
40	W49S3T40
41	W49S3T41
42	W49S3T42
43	W49S3T43
44	W49S3T44
45	W49S3T45
46	W49S3T46
47	W49S3T47
48	W49S3T48

Natural, full grain leather combining maximum hydrofugation and flameproof treatment.

- Thick and resistant to tear.
- Seams made of flame retardant wire.
- Resistant to flame and splashes of molten metal.
- Design, yarns, fiber and engineering complying with EN ISO 20349.

200 J Plastic

- Impact resistant to over 200 joules.
- Extra wide.
- Very light.
- Elastic memory.
- Eletrically insulating.
- Maximum EN ISO 20345 certification.

PU + High Temperature (300 °C). Nitrile rubber.

- Resistance to heat contact up to 300 °C.
- Resistant to oils and hydrocarbons.
- Resistant to abrasion – effective cold and extreme hot insulation.
- Electrically insulation.
- Special, anti-slip design and system of energy absorption in the heel.

Heat resistant.

- Antifungal.
- Antistatic.
- Antibacterial.

Puncure-proof, non-metallic.

- Extremely flexible and light.
- Soft, reflecting the natural shape of the foot.
- Comfort and protection.
- Zero penetration.
- Super flexible and light.
- Maximum EN ISO 20345 certification.

WELDING ACCESSORIES

SPRAYS

WELDLINE™ by Lincoln Electric
www.weldline.eu

Anti-spatters

CERASKIN

- Ceramic coating.
- Exceptionally fast drying, long lasting and durable coating.
- The ceramic base makes a barrier and prevents weld spatter adhering to welding equipment and welded parts.
- Guarantees eight consecutive hours of welding work (a full working day), without any extra applications of the product.

Reference
W000277679

SPRAYMIG H_2O

- Water based and odourless.
- No influence on porosity and cold cracks.
- No influence of the content of diffusible hydrogen in the weld metal.
- Soluble and silicone free.
- Biodegradable.
- Allows parts to be lacquered.

Reference	
Spray (400 ml)	W000010001
Drum (20 liters)	W000011074

SPRAYMIG SVB

- Silicone free.
- Compatible with paint.
- Use on cold parts.
- Use on nozzles and outside contact tips only.

Reference
W000011092

NETMIG

- Protects nozzles and contact tips from spatters by immersion.
- Silicone and solvent free.
- Odourless.

Reference
W000011071

Anti-corrosion

GALVASPRAY

- Protection of welded joints.
- Allows welded parts to be lacquered.

Reference	
Volume : 500 ml (nominal)	W000011094

Cracks detection

FLUXO S190 – CLEANER

Cleans the workpiece and removes excessive penetrant.

- Propellant: butane / propane.
- Volume : 500 ml (net) – 650 ml (nominal).

Reference
W000374827

FLUXO P125 – PENETRANT

Type II – level 2 – Methode AC. non-destructive testing.

- Propellant: butane / propane.
- Volume : 500 ml (net) – 650 ml (nominal).

Reference
W000374825

FLUXO R175 – DEVELOPER

Detection of cracks and surface faults.

- Propellant: butane / propane.
- Volume : 500 ml (net) – 650 ml (nominal).

Reference
W000374826

Heat protection

THERMISHIELD

- Designed to stop heat from travelling through most metals during welding, brazing or soldering.
- Prevents metals and plastics distortion caused by the heat of the welding torch.
- Volume: 500 ml.

Reference
W000274839

REACH Ready

EN3552-2, ASME,RCCM (NUCLEAR)*

*For FLUXO and ARDROX

ELECTRODE HOLDERS

WELDLINE™ by Lincoln Electric
www.weldline.eu

Screw type electrode holders

TWIST 200 / 400

VESTALETTE 250

STUBBY 400

MASTER 500

VESTALE 500

CURVA 400 / 600

	TWIST 200	TWIST 400	VESTALETTE 250	STUBBY 400	MASTER 500	VESTALE 500	CURVA 400	CURVA 600
Reference	W000010565	W000010566	W000010035	W000010036	W000010037	W000010038	W000010573	W000010574
Amperage	200A at 35%	300A at 35%	250A at 35%	400A at 35%	500A at 35%	500A at 35%	400A at 35%	500A at 35%
Cable Ø (mm)	25 max.	50 max.	35 max.	70 max.	95 max.	95 max.	50 max.	95 max.
Electrode Ø (mm)	3,2 max.	5,0 max.	4,0 max.	6,3 max.	8,0 max.	8,0 max.	6,3 max.	8,0 max.
Weight	335 g	480 g	295 g	450 g	530 g	470 g	540 g	720 g

Lever type closed head electrode holders

SEGURA 300 / 400 / 600

COBRA 300

TONG GRIP 400

OPTIMUS 300 / 400 / 500

	SEGURA 300	SEGURA 400	SEGURA 600	COBRA 300	TONG GRIP 400	OPTIMUS 300	OPTIMUS 400	OPTIMUS 500
Reference	W000010570	W000010571	W000010572	W000010039	W000010622	W000010410	W000010411	W000010412
Amperage	300 at 35%	400 at 35%	500 at 35%	300 at 35%	400 at 35%	300 at 35%	400 at 35%	500 at 35%
Cable Ø (mm)	35 max.	50 max.	70 max.	50 max.	70 max.	35 max.	50 max.	70 max.
Electrode Ø (mm)	4,0 max.	5,0 max.	8,0 max.	6,3 max.	6,3 max.	4,0 max.	5,0 max.	6,3 max.
Weight	415 g	570 g	590 g	420 g	500 g	415 g	570 g	590 g

Lever type opened head electrode holders

CAÏMAN 200 / 400 / 600

	CAÏMAN 200	CAÏMAN 400	CAÏMAN 600
Reference	W000010567	W000010568	W000010569
Amperage	200 at 35%	400 at 35%	600 at 35%
Cable Ø (mm)	25 max.	50 max.	95 max.
Electrode Ø (mm)	3,2 max.	6,3 max.	10 max.
Weight	370 g	425 g	500 g

Hobby and light duty electrode holders

HOBBY 200

CAÏMY 200

	HOBBY 200	CAÏMY 200
Reference	W000268399	W000010576
Amperage	200 at 35%	200 at 35%
Cable Ø (mm)	25 max.	25 max.
Electrode Ø (mm)	3,2 max.	3,2 max.
Weight	135 g	220 g

GOUGING ELECTRODES

- First class metal removal rates.
- Removing defective welds, preparing joints for welding, severing, pad washing, beveling.
- 17 separate models ranging from 4 x 305 to 19 x 430.
- More consistent melting rate results in uniform, smooth grooves.
- Dense copper coating improves arc stability.
- High mechanical strength for improved durability.
- Constant quality for a safe process.

Process

CAC-A (gouging)

Applications

Removing defective welds, preparing joints for welding, severing, pad washing, beveling

CARBONAIR

Pointed electrodes

Versatile, multi-purpose, round, gouging electrodes (most popular type).

Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I max (A)	Air pressure (bars)	Airflow (m³/h)	Reference
4 x 305	100	0,7508	150	200	5,0	10	W000010645
5 x 305	100	1,1582	200	300	5,0	10	W000010443
6,4 x 305	50	0,935	300	400	6,0	10,5	W000010444
8 x 305	50	1,4026	450	550	7,0	12	W000010445
10 x 305	50	1,9154	600	700	8,0	13	W000010446
13 x 305	50	3,4112	900	1100	9,0	14	W000010447

Flat electrodes

Rectangular shape for close tolerance metal removal and/or rectangular grooves production.

Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I max (A)	Air pressure (bars)	Airflow (m³/h)	Reference
5 x 15 x 305	50	2,15	500	600	8,0	13	W202010453
5 x 18 x 355	25	1,6945	600	750	8,0	13	W202010454

Hollow electrodes

Round electrode with hollow core allows for faster travel speed without sacrificing groove depth.

Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I max (A)	Air pressure (bars)	Airflow (m³/h)	Reference
5 x 305	100	1,0472	200	300	5,0	10	W202010455
8 x 305	50	1,3394	450	550	7,0	12	W202010456
9,5 x 305	50	2,0554	500	700	7,0	12	W202010457
12,7 x 305	50	3,3476	850	1100	8,0	13	W202010458

CARBONAIR PLUS

Jointed electrodes

Round electrodes with male and female connections to eliminate stub loss. Applicable in medium and heavy duty metal cutting. This process requires MMA direct current (DC) power source, a gouging torch and compressed air source.

Diameter x length (mm)	Quantity per box	Gross weight per box (kg)	I mini (A)	I max (A)	Air pressure (bars)	Airflow (m³/h)	Reference
8 x 355	50	1,713	400	500	7,0	12	W000010448
10 x 430	50	3,0726	700	850	8,0	13	W000010449
13 x 430	50	5,0886	1000	1200	9,0	14	W000010450
16 x 430	25	3,8728	1300	1500	10,0	16	W000010451
19 x 430	25	5,3048	1500	1700	10,0	16	W000010452

GOUGING TORCHES

FLAIR® 600 / 1600

- The torch can rotate 360° on the monocable, allowing unrestricted movement.
- Smoothly finished body for perfect airflow – manufactured with the greatest accuracy. The inner body is perfectly shaped which results in a perfect airflow, better cooling and longer lifespan.
- Highly conductive extruded body and nozzle (non-casted) – better conduction and less heat development and consequently a longer product lifetime.
- Thicker heat resistant insulation – ensures not only longer product lifetime, but also safer, more convenient and more productive working conditions.
- Flexible monocable (2,5 meter) ensures more ergonomical, effective working conditions.
- The airflow can be regulated on the torch.

	FLAIR® 600	FLAIR® 1600
Reference	W000010136	W000010118
Output Power	600A@60%	1600A@60%
Open arc voltage	> 60 VDC	
Required Voltage	35-56 VDC	
Compressed air	400-900 l/min @5-7 bar	
Electrode diam. max.	10 mm	19 mm

OTHER ACCESSORIES

MMA KITS

	Kit 25C25	Kit 25C25+	Kit 25C50	Kit 35C50	Kit 50C50	Kit 50C50+
Reference	W000011138	W000260683	W000260684	W000011139	W000260681	W000260682
I max	200 at 35%	300 at 35%	300 at 35%	300 at 35%	300 at 35%	400 at 35%
Electrode holder	CAÏMAN 200	SEGURA 300	SEGURA 300	SEGURA 300	SEGURA 400	SEGURA 600
Cable length	3 m	3 m	3 m	4 m	4 m	4 m
Earth clamp	HIPPO 200	HIPPO 400	HIPPO 400	HIPPO 400	HIPPO 400	HIPPO 600
Cable length	3 m	2 m	3 m	4 m	4 m	4 m
Plug diameter	9 mm	9 mm	13 mm	13 mm	13 mm	13 mm

MIG PLIERS (ORIGINAL FIX®)

Useful to:

- Cut the wire.
- Clean the nozzles.
- Unscrew the tips.
- Unscrew the nozzles.

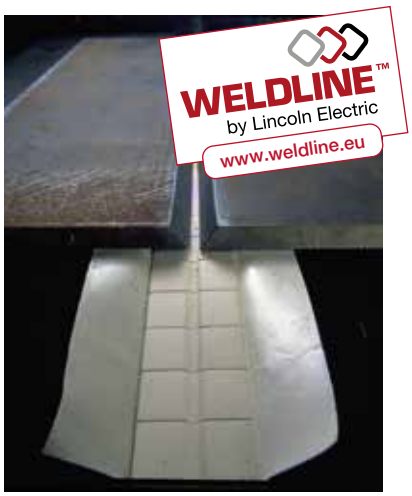
Ø NOZZLE 12-15 mm	Ø NOZZLE 15-18 mm
W000010453	W000010454

CERAMIC BACKINGS

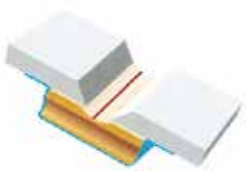
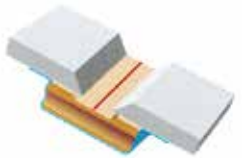
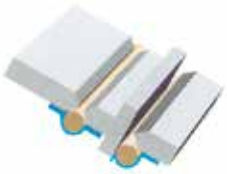
The selection of KERALINE slat types for different welding processes.

	MMA	TIG	MIG/MAG	SAW
KERALINE TA 1	-	✔	✔	-
KERALINE TA 2	-	✔	✔	-
KERALINE TA 3	✔	-	✔	-
KERALINE TF 1	-	✔	✔	-
KERALINE TF 2	-	✔	✔	-
KERALINE TF 3	✔	-	✔	-
KERALINE TR 1	✔	-	✔	-

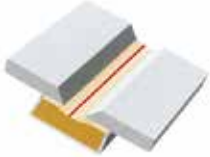
	MMA	TIG	MIG/MAG	SAW
KERALINE TR 2	✔	-	✔	-
KERALINE TR 3	✔	-	✔	-
KERALINE TR 4	✔	-	✔	-
KERALINE TR 5	✔	-	✔	-
KERALINE TR 6	✔	-	✔	-
KERALINE TM 1	✔	✔	✔	✔
KERALINE TM 2	✔	✔	✔	✔



Ceramic-on-aluminum tape

Type	Reference	Dimensions (mm)	3D diagram	Application	Packing
KERALINE TA1 – 6 mm	W000010391	27, 6, 1.3, 7.3			600 mm / piece 10 pieces per bag (6 metres) 6 bags/carton (36 metres)
KERALINE TA2 – 9 mm	W000010392	27, 9, 1.3, 7.3			
KERALINE TA3 – 13 mm	W000010393	27, 13, 1.3, 7.3			
KERALINE TF1 – 6 mm	W000010394	27, 6, 1.3, 7.3			
KERALINE TF2 – 9 mm	W000010395	27, 9, 1.3, 7.3			600 mm / piece 10 pieces per bag (6 metres) 6 bags/carton (36 metres)
KERALINE TF3 – 13 mm	W000010396	27, 13, 1.3, 7.3			
KERALINE TR1 – 6 mm	W000010397	Ø 6			600 mm / piece 50 pieces per bag (30 metres) 5 bags/carton (150 metres)
KERALINE TR2 – 7 mm	W000010398	Ø 7			
KERALINE TR3 – 8 mm	W000010399	Ø 8			600 mm / piece 20 pieces per bag (12 metres) 8 bags/carton (96 metres)
KERALINE TR4 – 9 mm	W000010400	Ø 9			600 mm / piece 20 pieces per bag (12 metres) 7 bags/carton (84 metres)
KERALINE TR5 – 12 mm	W000010401	Ø 12			600 mm / piece 20 pieces per bag (12 metres) 5 bags/carton (60 metres)
KERALINE TR6 – 15 mm	W000010402	Ø 15			600 mm / piece 15 pieces per bag (9 metres) 5 bags/carton (45 metres)

Ceramic-on-metallic support

Type	Reference	Dimensions (mm)	3D diagram	Application	Packing
KERALINE TM1 – 13 mm	W000010403	24, 13, 1, 6.5			600 mm / piece 10 pieces per bag (6 metres) 7 bags/carton (42 metres)
KERALINE TM2 – 18 mm	W000010404	34, 18, 1.5, 8.5			600 mm / piece 9 pieces per bag (5,4 metres) 5 bags/carton (27 metres)

WELDLINE™
by Lincoln Electric

New Weldline PPE Collection

for Women

cunha mendes cunha, lda
Equipamentos Industriais

email:cmc@cmc.pt web:www.cmc.pt

OERLIKON

CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to enquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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OE-E1-20EN-M701