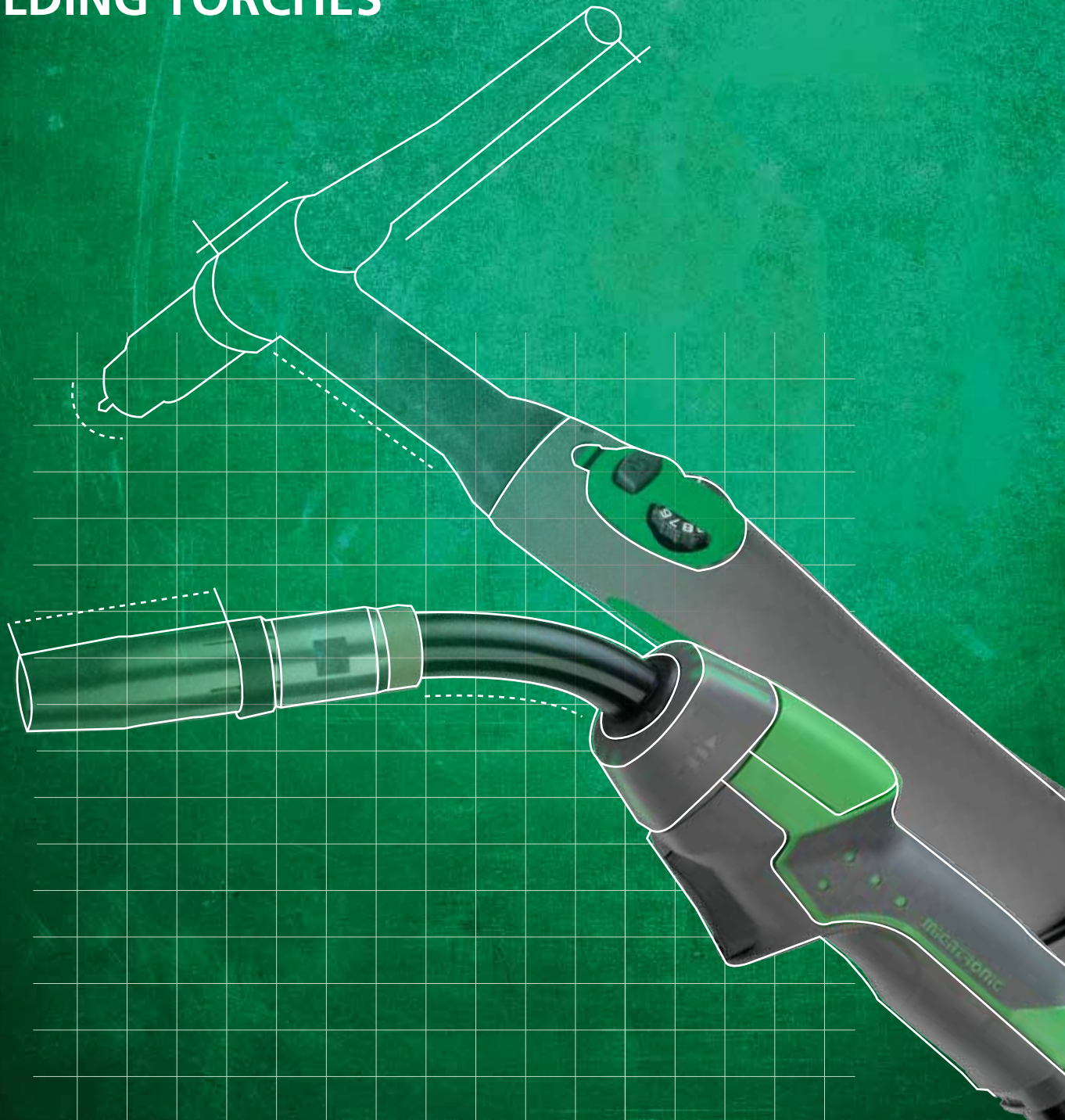


WELDING TORCHES



DEALER CATALOGUE





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*We reserve the right to make corrections in the event of a misprint.
The products delivered may differ from the photos in the catalogue.*



SWITCH ON, PRESS AND WELD

Being one of the leading suppliers of professional welding solutions, Migatronic focuses on developing and supplying high-quality welding torches for MIG/MAG, TIG, MMA and plasma welding. Migatronic welding torches are in ergonomically correct design; they fit both right and left hands, and welders avoid straining wrists and fingers.

For terms of sale and delivery and warranty conditions, please refer to www.migatronic.com.

In this catalogue you will find information about:

- Welding Torches
- Technical Data

Contact

If you have any questions, please do not hesitate to contact us.



Air-cooled MIG Welding Torches



MIG-A Twist®

- Turnable swan neck
- Ergonomically correct working posture whichever welding angle you use
- Can be turned up to 90° in both directions, step-by-step at intervals of 15°
- Available in 60 different configurations
- Accessories: gas nozzles, swan necks, gas diffusers and liners
- Three different modules can be mounted/remounted at the handle
- Suits all welding machine makes

ABBREVIATIONS MIG:

- ML** = Migatronic air-cooled torch
- 300** = Model size
- R** = Remote control/Dialog
- 8 m** = Length
- AH** = Advanced handle/Manager
- ALU** = Teflon liner
- ZA** = Euro connection
- FKS** = Double cooling chamber with extra cooling of gas nozzle
- KD** = Separate tip adaptor (changeable tipholder)

Art. no.	Model
80191180	ML161 3m RallyMIG 161i
80191181	ML161 Softgrip 360° 3m 0.8 ZA
80191182	ML161 Softgrip 360° 3m XE
80197150	ML150 TWIST 3m 0.8
80197151	ML150 TWIST 4m 0.8
80197153	ML 150 TWIST 5m 0.8
80197156	ML150 TWIST 3m 1.0 ALU
80196150	ML150 TWIST R 3m 0.8
80196151	ML150 TWIST R 4m 0.8
80196155	ML150 TWIST R 3m 1.0 ALU
80197250	ML250 TWIST 3m 0.8
80197251	ML250 TWIST 4m 0.8
80197253	ML250 TWIST 5m 0.8
80196250	ML250 TWIST R 3m 0.8
80196251	ML250 TWIST R 4m 0.8
80196252	ML250 TWIST R 3m 1.0 ALU
80196257	ML250 TWIST R 4m 1.0 ALU
80191190	ML241 Softgrip 360° 3m 1.0 ZA
80191191	ML241 Softgrip 360° 4m 1.0 ZA
80191192	ML241 Softgrip 360° 4m 1.2 ZA
80197240	ML240 TWIST 3m 0.8
80197241	ML240 TWIST 4m 0.8
80197243	ML240 TWIST 5m 0.8
80197242	ML240 TWIST 3m 1.0 ALU
80197244	ML240 TWIST 3m 1.0 Alu/Stainless
80196240	ML240 TWIST R 3m 0.8
80196243	ML240 TWIST R 3m 1.0 ALU

Art. no.	Model
80196244	ML240 TWIST R 3m 1.2 ALU
80196241	ML240 TWIST R 4m 0.8
80196245	ML240 TWIST R 4m 1.0 ALU
80197300	ML300 TWIST 3m 1.0
80197301	ML300 TWIST 4m 1.0
80197303	ML300 TWIST 5m 1.0
80197304	ML300 TWIST 3m 1.0 ALU
80197302	ML300 TWIST 4m 1.2
80196300	ML300 TWIST R 3m 1.0
80196301	ML300 TWIST R 4m 1.0
80197360	ML360 TWIST 3m 1.0
80197361	ML360 TWIST 4m 1.0
80197363	ML360 TWIST 5m 1.0
80197364	ML360 TWIST 4m 1.2
80197374	ML360 TWIST 3m 1.6
80196360	ML360 TWIST R 3m 1.0
80196361	ML360 TWIST R 4m 1.0
80197400	ML400 TWIST 3m 1.2
80197401	ML400 TWIST 4m 1.2
80197403	ML400 TWIST 5m 1.2
80197500	ML500 TWIST 3m 1.2
80197501	ML500 TWIST 4m 1.2
80197503	ML500 TWIST 5m 1.2
80194242	Manager ML240 3m AH ZA 25 0.8KD
80194243	Manager ML240 4m AH ZA 25 0.8KD
80194244	Manager ML240 3m AH ZA 1.0 ALU
80194362	Manager ML360 3m AH ZA 50 1.0KD

All models are supplied with Spring Pin.

Technical Data

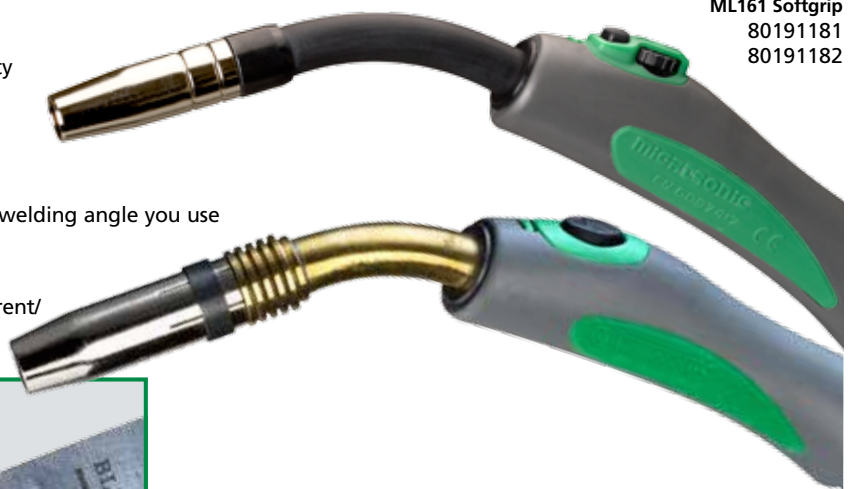
MODEL TWIST	ML 150/161	ML 240/241	ML 250	ML 300	ML 360	ML 400	ML 500
Duty cycle CO ₂ 60%	180 A	250 A	230 A	295 A	380 A	400 A	500 A
Duty cycle CO ₂ 100%	160 A	225 A	205 A	260 A	340 A	350 A	450 A
Mixgas 60%	170 A	220 A	225 A	255 A	310 A	360 A	450 A
Mixgas 100%	150 A	195 A	200 A	225 A	270 A	310 A	400 A
Gas flow +/-5%	15 l/min.*	15 l/min.*	15 l/min.*	15 l/min.*	15 l/min.*	18 l/min.*	20 l/min.*
Wire diameter, mm	0.6-1.2	0.6-1.6	0.6-1.6	0.6-1.6	0.6-1.6	0.8-2.4	0.6-2.4
Cabel, mm ²	16	25	25	35	50	55	55
Weight	0.9 kg	1.2 kg	1.3 kg	1.6 kg	1.8 kg	1.9 kg	2.0 kg
Total weight kg, 3 m	1.8 kg	2.1 kg	2.1 kg	2.5 kg	2.9 kg	3.5 kg	3.6 kg
Connection	ZA	ZA	ZA	ZA	ZA	ZA	ZA

* = Minimum gas flow for compliance with maximum performance.



ML 161 & ML 241

- Small handle, ease of operation and large flexibility
- Ball-and-socket joint between hose and handle
- Softgrip on the side of the handle
- The swan neck can be turned 360° without tools
- Ergonomically correct working posture whichever welding angle you use
- Supplied with a standard range of gas nozzles, swan necks, gas diffusers and liners
- A module for infinitely variable adjustment of current/wire can be mounted/remounted at the handle



ML161 Softgrip
80191181
80191182



ML241 Softgrip
80191190
80191191
80191192

The swan neck can be turned 360° without tools



Art. no. 80300100
Keypad unit
Standard equipment



Art. no. 80300273
Keypad unit with
horizontal MIG control
knob (RH).
Requires
electronic box MPS-4TF.
Art. no. 76116982



Connection XE

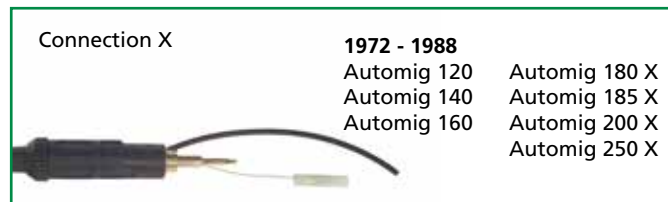
1988 - 1998
Autmig 180 XE
Autmig 200 XE



Connection ZA

1998 -
Autmig 181
Autmig 183
Autmig 221
Autmig 223
Autmig 231
Autmig 271
Autmig 273
Autmig 250 XE

Art. no.	Model	No of pcs.
80191177	ML150C/ XR 3m	1
80191178	ML150C / XE 3m	1
80191179	ML150C ZA 3m 0,8	1



Connection X

1972 - 1988
Autmig 120
Autmig 140
Autmig 160
Autmig 180 X
Autmig 185 X
Autmig 200 X
Autmig 250 X



Connection XE

1988 - 1998
Autmig 180 XE
Autmig 200 XE



Connection ZA

1998 -
Autmig 181
Autmig 183
Autmig 221
Autmig 223
Autmig 231





Air-cooled MIG Welding Torches



Trigger and trigger stop
Trigger with soft bottom stop and changeover between short and long travel

1. Trigger switch complete for MIG-A-Twist
Art. no.....80100400

2. MIG-A Twist Trigger adjust PAL
Art. no.....45050418



All models are supplied with spring pin.

Spring pin for ZA air
Art. no.....80100810

Spring pin for ZA water
Art. no.....80100811



Ball-and-socket joint



ZA, water

MIG Manager® - digital communication with FLEX², Sigma² and Galaxy welding machines

- Ergonomically correct and user-friendly
- Adjustment and readout of parameters in display



Technical Data

MODEL MANAGER	ML 240	ML 360
Duty cycle CO ₂ 60%	250 A	380 A
Duty cycle CO ₂ 100%	225 A	340 A
Mixgas 60%	220 A	310 A
Mixgas 100%	195 A	270 A
Gas flow +/-5%	15 l/min.*	15 l/min.*
Wire diameter, mm	0.6-1.6	0.6-1.6
Cable, mm ²	25	50
Weight	1.2 kg	1.8 kg
Total weight kg, 3 m	2.1 kg	4.0 kg
Connection	ZA	ZA

* = Minimum gas flow for compliance with maximum performance.

SUITABLE FOR		MIG/MAG inverter machines			
		FLEX ² 3000	SIGMA ² & SIGMA GALAXY 300 C / S	SIGMA ² & SIGMA GALAXY 400 C / S	SIGMA ² & SIGMA GALAXY 500 C / S
WELDING TORCHES					
80194242	Manager ML240 3M AHZA 25 0.8KD	KIT	KIT		
80194243	Manager ML240 4M AHZA 25 0.8KD	KIT	KIT		
80194244	Manager ML240 3M AHZA 1.0 ALU	KIT	KIT		
80194362	Manager ML360 3M AHZA 50 1.0KD	KIT	KIT	(KIT)	(KIT)

KIT Requires MIG Manager kit.

(KIT) Requires MIG/Manager kit. Not recommendable for maximum performance.



Air-cooled MIG Welding Torches

SUITABLE FOR WELDING TORCHES		MIG/MAG conventional stepregulated machines						MIG/MAG inverter machines					
		Automig 183-223	Automig ² 233i	Automig 273 Automig ² 273i	Automig ² 183i DUO Automig ² 233i DUO Automig ² 273i DUO	MIG S 385x	MIG S 445x	RallyMIG	FLEX ² 3000	Omega ² 300 Omega Yard 300	SIGMA ² & SIGMA GALAXY 300 C / S	SIGMA ² & SIGMA GALAXY 400 C / S Omega ² 400 C / S	SIGMA ² & SIGMA GALAXY500 C / S Omega ² 550 C / S
80191180	ML161 3m RallyMIG 161i							*					
80191181	ML161 Softgrip 360° 3m 0.8	*			(*)					(*)			
80197150	ML150 TWIST 3m 0.8	*			(*)					(*)			
80197151	ML150 TWIST 4m 0.8	*			(*)					(*)			
80197153	ML 150 TWIST 5m 0.8	*			(*)					(*)			
80197156	ML150 TWIST 3m 1.0 ALU	*			(*)					(*)			
80196150	ML150 TWIST R 3m 0.8	*			(*)					(*)			
80196151	ML150 TWIST R 4m 0.8	*			(*)					(*)			
80196155	ML150 TWIST R 3m 1.0 ALU	*			(*)					(*)			
80191190	ML241 Softgrip 360° 3m 1.0	*	*	(*)	(*)	(*)			(*)	(*)	(*)		
80191191	ML241 Softgrip 360° 4m 1.0	*	*	(*)	(*)	(*)			(*)	(*)	(*)		
80191192	ML241 Softgrip 360° 4m 1.2	*	*	(*)	(*)	(*)			(*)	(*)	(*)		
80197240	ML240 TWIST 3m 0.8	*	*		*	(*)			(*)	*	(*)		
80197241	ML240 TWIST 4m 0.8	*	*		*	(*)			(*)	*	(*)		
80197242	ML240 TWIST 3m 1.0 ALU	*	*		*	(*)			(*)	*	(*)		
80197243	ML240 TWIST 5m 0.8	*	*		*	(*)			(*)	*	(*)		
80196240	ML240 TWIST R 3m 0.8	*	*		*	(*)			(*)	*	(*)		
80196241	ML240 TWIST R 4m 0.8	*	*		*	(*)			(*)	*	(*)		
80196243	ML240 TWIST R 3m 1.0 ALU	*	*		*	(*)			(*)	*	(*)		
80196244	ML240 TWIST R 3m 1.02 ALU	*	*		*	(*)			(*)	*	(*)		
80196245	ML240 TWIST R 4m 1.0 ALU	*	*		*	(*)			(*)	*	(*)		
80197250	ML250 TWIST 3m 0.8	*	*	*	*	(*)			(*)	*	(*)		
80197251	ML250 TWIST 4m 0.8	*	*	*	*	(*)			(*)	*	(*)		
80197253	ML250 TWIST 5m 0.8	*	*	*	*	(*)			(*)	*	(*)		
80196250	ML250 TWIST R 3m 0.8	*	*	*	*	(*)			(*)	*	(*)		
80196251	ML250 TWIST R 4m 0.8	*	*	*	*	(*)			(*)	*	(*)		
80196252	ML250 TWIST R 3m 1.0 ALU	*	*	*	*	(*)			(*)	*	(*)		
80196257	ML250 TWIST R 4m 1.0 ALU	*	*	*	*	(*)			(*)	*	(*)		
80197300	ML300 TWIST 3m 1.0	*			*	*	(*)		*	*	*		
80197301	ML300 TWIST 4m 1.0	*			*	*	(*)		*	*	*		
80197303	ML300 TWIST 5m 1.0	*			*	*	(*)		*	*	*		
80196300	ML300 TWIST R 3m 1.0	*			*	*	(*)		*	*	*		
80196301	ML300 TWIST R 4m 1.0	*			*	*	(*)		*	*	*		
80197304	ML300 TWIST R 4m 1.0 ALU	*			*	*	(*)		*	*	*		
80197302	ML300 TWIST R 4m 1.2 ALU	*			*	*	(*)		*	*	*		
80197360	ML360 TWIST 3m 1.0					*	(*)		*	*	(*)	(*)	
80197361	ML360 TWIST 4m 1.0					*	(*)		*	*	(*)	(*)	
80197363	ML360 TWIST 5m 1.0					*	(*)		*	*	(*)	(*)	
80196360	ML360 TWIST R 3m 1.0					*	(*)		*	*	(*)	(*)	
80196361	ML360 TWIST R 4m 1.0					*	(*)		*	*	(*)	(*)	
80197364	ML360 TWIST R 4m 1.2					*	(*)		*	*	(*)	(*)	
80197374	ML360 TWIST R 3m 1.6 KD					*	(*)		*	*	(*)	(*)	
80197400	ML400 TWIST 3m 1.2					*	*				*	(*)	
80197401	ML400 TWIST 4m 1.2					*	*				*	(*)	
80197403	ML400 TWIST 5m 1.2					*	*				*	(*)	
80197500	ML500 TWIST 3m 1.2											*	
80197501	ML500 TWIST 4m 1.2											*	

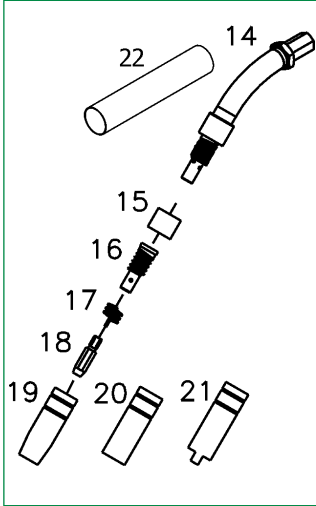
* Recommended

(*) Not recommendable for maximum performance



Wear Parts for Air-cooled MIG Welding Torches

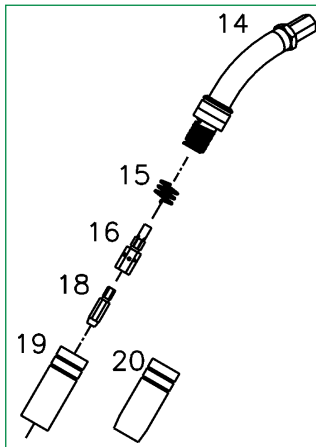
Wear parts for ML 150 TWIST / ML 161 / ML 150C



Position no.	Art. no.	Description	No of pcs.
14	*	80152202 Swan neck ML150 MIG-A Twist	1
	□	80150038 Swan neck ML 161 w/fitting	1
	Δ	80150037 Swan neck ML 150C w/fitting	1
15	* □ Δ	80120500 Insulating bush	10
16	*	80110020 Contact nozzle	10
	* □	80110021 Contact nozzle ML 161, ML150C	10
17	* □ Δ	80100021 Retaining clamp ML120/130/150	10
18	* □ Δ	80130202 CONTACT TIP. PLEASE SEE PAGE 19	50
19	* □ Δ	80140023 Gas Nozzle ML120/130/150 Conic	10
20		80140500 Gas Nozzle ML120/130/150 Cylindric	10
21		80140022 Gas Nozzle ML120/130/150 SPOT	10
22		80100073 Protection cover	1
		81100252 Wearparts box ML150 Ergo/Twist 0.6 steel	1
		81100223 Wearparts box ML150 Ergo/Twist 0.8 steel	1

* = ML150 pre-assembled as standard. □ = ML161 pre-assembled as standard. Δ = ML150C pre-assembled as standard

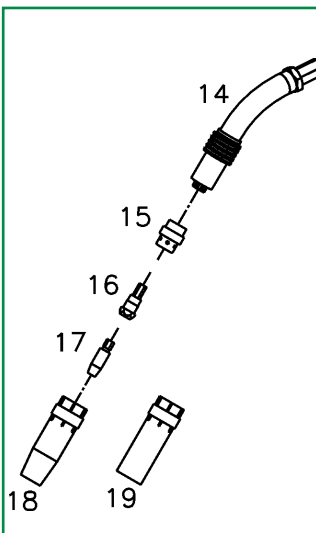
Wear parts for ML 250 TWIST



Position no.	Art. no.	Description	No of pcs.
14		80152302 Swan neck ML250 MIG-A Twist	1
15		80100600 Retaining clamp ML250	10
16	*	80110601 Tip adaptor ML250 M6 37mm	10
		80110602 Tip adaptor ML250 M6 35mm	10
18	*	80130202 CONTACT TIP. PLEASE SEE PAGE 19	50
19		80140600 Gas Nozzle ML250 Cylindric	10
20	*	80140601 Gas Nozzle ML250 Conic	10
		81100253 Wearparts box ML 250 0.6 steel	1
		81100224 Wearparts box ML 250 0.8-1.0 steel	1
		81100220 Wearparts box ML250 1.0 alu	1

* = Pre-assembled as standard

Wear parts for ML 240 TWIST / Manager ML 240 / ML 241



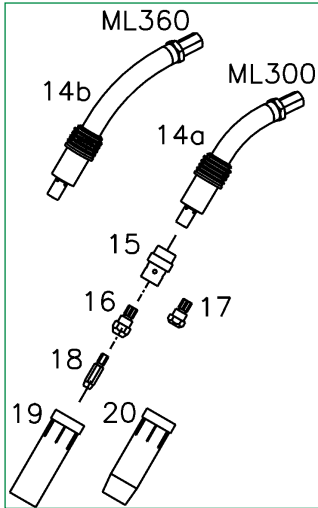
Position no.	Art. no.	Description	No of pcs.
14		80152402 Swan neck ML 240 MIG-A Twist	1
		80151403 Swan neck ML 240 Manager	1
		80150039 Swan neck ML 241 w/fitting	1
15	*	83077480 Gas diffuser ML/MV24 Black	10
		83077481 Gas diffuser ML/MV24 White	10
16	*	80110604 Tip adaptor ML-MV240 CuCrZr 5mm	10
		83077149 Tip adaptor ML-MV240 brass 5mm	10
		80110603 Tip adaptor ML-MV240 brass 7mm	10
17		80131200 CONTACT TIP. PLEASE SEE PAGE 19	10
18	*	80140610 Gas Nozzle ML/MV240 Conic	10
19		80140611 Gas Nozzle ML/MV240 Cylindric	10
		81100214 Wearparts box ML240 0.6-0.8 steel	1
		81100231 Wearparts box ML240 1.0 steel	1
		81100221 Wearparts box ML/MV240 1.0 alu	1

* = Pre-assembled as standard



Wear Parts for Air-cooled MIG Welding Torches

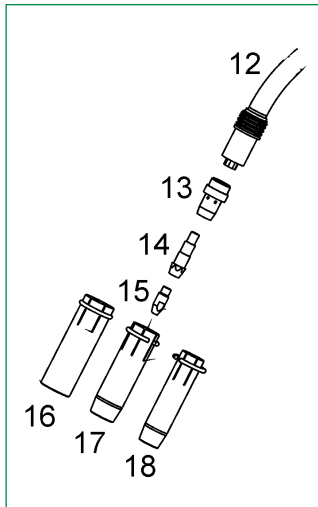
Wear parts for ML 300 TWIST/ML 360 TWIST/Manager ML 360



Position no.	Art. no.	Description	No of pcs.
14a	80152502	Swan neck ML300 MIG-A Twist	1
14b	80152602	Swan neck ML360 MIG-A Twist	1
15	* 80120301	Gas diffuser ML300/360 White	10
	80120306	Gas diffuser ML360 32mm White	10
16	80112636	Tip adaptor ML300/360 M8-6 25mm	10
	80112637	Tip adaptor ML300/360 M8-6 32mm	10
	* 80112640	Tip adaptor ML300/360 M8-6 25mm	10
	80112638	Tip adaptor ML300/360 M8-8 28mm	10
	80112639	Tip adaptor ML300/360 M8-8 32mm	10
17	80110026	Tip adaptor ML300/360 M8-6 22mm	10
	80110300	Tip adaptor ML300/360 M8-8 23mm	10
18	* 80131201	CONTACT TIP. PLEASE SEE PAGE 19	10
19	80240300	Gas nozzle ML/MV Cylindric	10
	80140701	Gas nozzle ML360 Cylindric nickelled	10
20	* 80240303	Gas nozzle ML/MV Conic	10
	80140700	Gas nozzle ML360 Conic nickelled	10
	81100232	Wearparts box ML 300 1.0 steel	1
	81100254	Wearparts box ML 300 1.0 steel CuCrZr	1

* = Pre-assembled as standard

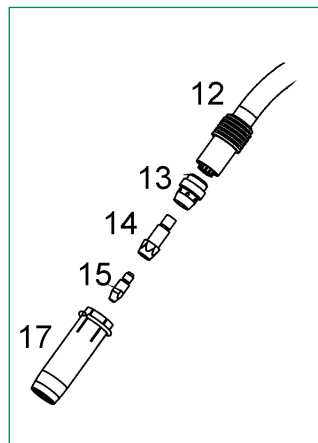
Wear parts for ML 400 TWIST



Position no.	Art. no.	Description	No of pcs.
12	80152702	Swan neck ML400 MIG-A Twist	1
13a	* 80120310	Gas diffuser ML400 White	10
13b	80120311	Gas diffuser ML400 Ceramic	10
13c	* 80120312	Gas diffuser ML400 Black	10
14a	* 80110040	Tip adaptor ML400 M8-8 43mm	10
14b	80110041	Tip adaptor ML400 M8-8 47mm	10
15	80231103	CONTACT TIP. PLEASE SEE PAGE 19	50
16	80140722	Gas Nozzle ML400 Cylindric	10
17	* 80140721	Gas Nozzle ML400 Conic ø 18mm	10
18	80140720	Gas Nozzle ML400 Conic ø 14mm	10

* = Pre-assembled as standard

Wear parts for ML 500 TWIST



Position no.	Art. no.	Description	No of pcs.
12	80152802	Swan neck ML500 MIG-A Twist	1
13	* 80120313	Gas diffuser ML500 White	10
14	80110042	Tip adaptor ML500 M10/M8 43mm, CuCrZr	10
15	* 80231103	CONTACT TIP. PLEASE SEE PAGE 19	50
17	* 80140723	Gas Nozzle ML500 Conic ø 20mm	10

* = Pre-assembled as standard



Water-cooled MIG Welding Torches

MIG-A Twist®

- Turnable swan neck
- Ergonomically correct working posture whichever welding angle you use
- Can be turned up to 45° in both directions, step-by-step at intervals of 15°
- Available in 60 different configurations
- Accessories: gas nozzles, swan necks, gas diffusers and liners
- Three different modules can be mounted/remounted at the handle
- Suits all welding machine makes

ABBREVIATIONS MIG:

- MV** = Migatronic water-cooled torch
- 300** = Model size
- R** = Remote control/Dialog
- 8 m** = Length
- AH** = Advanced handle/Manager
- ALU** = Teflon liner
- ZA** = Euro connection
- FKS** = Double cooling chamber with extra cooling of gas nozzle
- KD** = Separate tip adaptor



Technical Data

MODEL TWIST & MANAGER	MV 240	MV 400 FKS	MV 450**	MV 450 KD	MV 500 FKS	MV 550**	MV 550 KD
Duty cycle CO ₂ 60%	300 A	415 A	450 A	400 A	560 A	550 A	500 A
Duty cycle CO ₂ 100%	300 A	415 A	450 A	400 A	560 A	550 A	500 A
Mixgas 60%	270 A	350 A	400 A	350 A	520 A	500 A	450 A
Mixgas 100%	270 A	350 A	400 A	350 A	520 A	500 A	450 A
Min. flow rate watercooling 1 bar	1 l/min.	1 l/min.	1 l/min.	1 l/min.	1 l/min.	1 l/min.	1 l/min.
Gas flow +/-5%	15 l/min.*	18 l/min.*	18 l/min.*	18 l/min.*	18 l/min.*	18 l/min.*	18 l/min.*
Wire diameter, mm	0.6-1.8	0.8-2.4	0.6-3.2	0.6-3.2	0.8-2.4	0.6-3.2	0.6-3.2
Cable, mm ²	16	16	16	16	16	16	16
Weight**	1.5 kg	1.6 kg	1.6 kg	1.6 kg	1.7 kg	1.6 kg	1.6 kg
Total weight kg, 3 m	3.0 kg	3.1 kg	3.0 kg	3.0 kg	3.2 kg	3.0 kg	3.0 kg
Connection	ZA	ZA	ZA	ZA	ZA	ZA	ZA

* = Minimum gas flow for compliance with maximum performance. ** = Integrated tip adaptor



Basic module
80100401

Potentiometer module
(80100402)

Potentiometer module
for Kemppi (80100410)

Sequence module,
3 steps (80100403)

MIG-A Twist® welding torches are configurable with four different modules. A module is easily replaced as required, without tools.



Turn the fitting Remove the cover Attach the module Lock the fitting

Please note: all trademarks mentioned in this catalogue are property of the respective companies.



Water-cooled MIG Welding Torches

Art. no.	Model
80297240	MV240 Twist 3m 1.0
80297241	MV240 Twist 4m 1.0
80297245	MV240 Twist 5m 1.0
80296240	MV240 Twist R 3m 1.0
80296241	MV240 Twist R 4m 1.0
80296242	MV240 Twist R 3m 1.0 ALU
80297602	MV400 FKS Twist 3m 1.2
80297603	MV400 FKS Twist 4m 1.2
80297605	MV400 FKS Twist 5m 1.2
80296602	MV400 FKS Twist R 3m 1.2
80296603	MV400 FKS Twist R 4m 1.2
80297700	MV500 FKS Twist 3m 1.2
80297701	MV500 FKS Twist 4m 1.2
80297705	MV500 FKS Twist 5m 1.2
80296700	MV500 FKS Twist R 3m 1.2
80296701	MV500 FKS Twist R 4m 1.2
80297450	MV450 Twist 3m 1.2 KD
80297451	MV450 Twist 4m 1.2 KD
80297452	MV450 Twist 3m 1.2
80297453	MV450 Twist 4m 1.2
80297457	MV450 Twist 3m 1,0 KD
80297454	MV450 Twist 4m 1.0 KD
80297455	MV450 Twist 5m 1.2 KD
80297456	MV450 Twist 5m 1.2

Art. no.	Model
80296464	MV450 TWIST R 3m 1.0 HD ALU
80296450	MV450 Twist R 3m 1.2 KD
80296451	MV450 Twist R 4m 1.2 KD
80296452	MV450 Twist R 3m 1.2
80296453	MV450 Twist R 4m 1.2
80297550	MV550 Twist 3m 1.2 KD
80297551	MV550 Twist 4m 1.2 KD
80297552	MV550 Twist 3m 1.2
80297553	MV550 Twist 4m 1.2
80297555	MV550 Twist 5m 1.2 KD
80297556	MV550 Twist 5m 1.2
80296550	MV550 Twist R 3m 1.2 KD
80296551	MV550 Twist R 4m 1.2 KD
80296557	MV550 TWIST R 6m 1.2 KD
80296552	MV550 Twist R 3m 1.2
80296553	MV550 Twist R 4m 1.2
80294245	Manager MV240 3M AH ZA 16 1.0KD
80294246	Manager MV240 4M AH ZA 16 1.0KD
80294248	Manager MV240 4M AH ZA 16 ALU
80294660	Manager FKS400 3M AH ZA 16 1.2
80294661	Manager FKS400 4M AH ZA 16 1.2
80294663	Manager FKS400 4M AH ZA 1.2ALU
80294702	Manager FKS500 3M AH ZA 16 1.2
80294703	Manager FKS500 4M AH ZA 16 1.2

All models are supplied with Spring Pin.



Advanced Cooling System

FKS welding torches feature double cooling chamber for efficient cooling at the gas nozzle; also available with Dialog adjustment of welding current or the digital MIG Manager®. FKS is designed specifically for pulse welding and spray transfer welding.



SUITABLE FOR		MIG/MAG inverter machines			
		FLEX ² 3000	SIGMA ² & SIGMA GALAXY300 C / S	SIGMA ² & SIGMA GALAXY400 C / S Omega 400 C	SIGMA ² & SIGMA GALAXY500 C / S
WELDING torches					
80294245	Manager MV240 3M AHZA 16 1.0KD	(KIT)	KIT	(KIT)	
80294246	Manager MV240 4M AHZA 16 1.0KD	(KIT)	KIT	(KIT)	
80294248	Manager MV240 4M AHZA 16 ALU	(KIT)	KIT	(KIT)	
80294660	Manager FKS400 3M AH ZA 16 1.2	KIT	KIT	KIT	(KIT)
80294661	Manager FKS400 4M AH ZA 16 1.2	KIT	KIT	KIT	(KIT)
80294663	Manager FKS400 4M AH ZA 1.2ALU	KIT	KIT	KIT	(KIT)
80294702	Manager FKS500 3M AH ZA 16 1.2	KIT	KIT	KIT	KIT
80294703	Manager FKS500 4M AH ZA 16 1.2	KIT	KIT	KIT	KIT

KIT Requires MIG Manager kit

(KIT) Not recommendable for maximum performance - requires MIG/Manager kit.



Water-cooled MIG Welding Torches

SUITABLE FOR WELDING TORCHES		MIG/MAG conventional stepregulated machines		MIG/MAG inverter machines			
		MIG S 385x	MIG S 445x	FLEX ² 3000	SIGMA ² , SIGMA ² OFFSHORE & SIGMA GALAXY 300 C / S	SIGMA ² , SIGMA ² OFFSHORE & SIGMA GALAXY 400 C / S Omega ² 400 C / S	SIGMA ² , SIGMA ² OFFSHORE & SIGMA GALAXY500 C / S OMEGA ² 550 C / S
80297240	MV240 TWIST R 5m 1.0	*	*	*	(*)	(*)	
80297241	MV240 TWIST 4m 1.0	*	*	*	(*)	(*)	
80297245	MV240 TWIST 5m 1.0	*	*	*	(*)	(*)	
80296240	MV240 TWIST R 3m 1.0	*	*	*	(*)	(*)	
80296241	MV240 TWIST R 4m 1.0	*	*	*	(*)	(*)	
80296242	MV240 TWIST R 3m 1.0 ALU	*	*	*	(*)	(*)	
80297602	MV400 FKS TWIST 3m 1.2	*	*	*	*	*	(*)
80297603	MV400 FKS TWIST 4m 1.2	*	*	*	*	*	(*)
80297605	MV400 FKS TWIST 5m 1.2	*	*	*	*	*	(*)
80296602	MV400 FKS TWIST R 3m 1.2	*	*	*	*	*	(*)
80296603	MV400 FKS TWIST R 4m 1.2	*	*	*	*	*	(*)
80297450	MV450 TWIST 3m 1.2 KD	*	*	*	*	*	(*)
80297451	MV450 TWIST 4m 1.2 KD	*	*	*	*	*	(*)
80297452	MV450 TWIST 3m 1.2	*	*	*	*	*	(*)
80297453	MV450 TWIST 4m 1.2	*	*	*	*	*	(*)
80297457	MV450 TWIST 3m 1.0 KD	*	*	*	*	*	(*)
80297454	MV450 TWIST 4m 1.0 KD	*	*	*	*	*	(*)
80297455	MV450 TWIST 5m 1.2 KD	*	*	*	*	*	(*)
80297456	MV450 TWIST 5m 1.2	*	*	*	*	*	(*)
80296450	MV450 TWIST R 3m 1.2 KD	*	*	*	*	*	(*)
80296451	MV450 TWIST R 4m 1.2 KD	*	*	*	*	*	(*)
80296452	MV450 TWIST R 3m 1.2	*	*	*	*	*	(*)
80296453	MV450 TWIST R 4m 1.2	*	*	*	*	*	(*)
80296464	MV450 TWIST R 3m 1.0 HD ALU	*	*	*	*	*	(*)
80297700	MV500 FKS TWIST 3m 1.2	*	*		*	*	*
80297701	MV500 FKS TWIST 4m 1.2	*	*		*	*	*
80297705	MV500 FKS TWIST 5m 1.2	*	*		*	*	*
80296700	MV500 FKS TWIST R 3m 1.2	*	*		*	*	*
80296701	MV500 FKS TWIST R 4m 1.2	*	*		*	*	*
80297550	MV550 TWIST 3m 1.2 KD	*	*		*	*	*
80297551	MV550 TWIST 4m 1.2 KD	*	*		*	*	*
80297552	MV550 TWIST 3m 1.2	*	*		*	*	*
80297553	MV550 TWIST 4m 1.2	*	*		*	*	*
80297555	MV550 TWIST 5m 1.2 KD	*	*		*	*	*
80297556	MV550 TWIST 5m 1.2	*	*		*	*	*
80296550	MV550 TWIST R 3m 1.2 KD	*	*		*	*	*
80296551	MV550 TWIST R 4m 1.2 KD	*	*		*	*	*
80296557	MV550 TWIST R 6m 1.2 KD	*	*		*	*	*
80296552	MV550 TWIST R 3m 1.2	*	*		*	*	*
80296553	MV550 TWIST R 4m 1.2	*	*		*	*	*

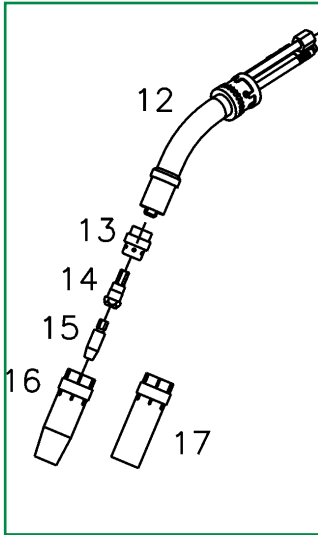
* Recommended

(*) Not recommendable for maximum performance



Wear Parts for Water-cooled MIG Welding Torches

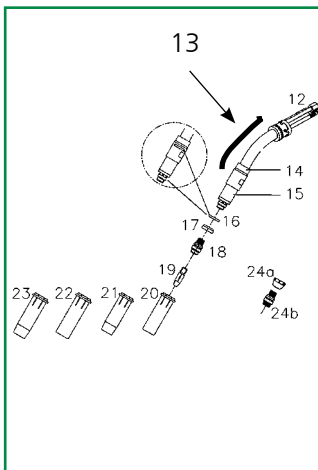
Wear parts for MV 240 TWIST / Manager MV 240



Position no.	Art. no.	Description	No of pcs.
12	80252101 80251107	Swan neck MV240 MIG-A Twist Swan neck MV 240 Manager	1 1
13a	* 83077480	Gas diffuser ML/MV24 Black	10
13b	83077481	Gas diffuser ML/MV24 White	10
13c	80220311	Gas diffuser ML/MV24 Ceramic	10
14	* 80110604 83077149 80110603	Tip adaptor ML-MV240 CuCrZr 5mm Tip adaptor ML-MV240 brass 5mm Tip adaptor ML-MV240 brass 7mm	10 10 10
15	* 80131201	CONTACT TIP. PLEASE SEE PAGE 19	10
16	* 80140610	Gas Nozzle ML/MV240 Conic	10
17	80140611	Gas Nozzle ML/MV240 Cylindric	10
	81100221	Wearparts box ML/MV 240 1.0 alu	1

* = Pre-assembled as standard

Wear parts for FKS 400 TWIST / Manager FKS 400



Position no.	Art. no.	Description	No of pcs.
12	80252500 80251501	Swan neck MV400 FKS Twist Swan neck MV 400 FKS Manager	1 1
13	92555041	Shrink FLEX Ø24 /8mm 1.2m glue	1
14	80100769	Insulator for cooling unit FKS400	1
15	80100767	Water cooling unit FKS 400	1
16	80100764	O-Ring FKS400W (2 pcs.)	1
17	80220201	Insulation ring FKS400W	10
18	* 80110408	Tip adaptor MV400FKS 24mm	10
19	* 80231202	CONTACT TIP. PLEASE SEE PAGE 19	10
20	80240308	Gas Nozzle MV400FKS Cylindric 62mm	10
21	* 80240307	Gas Nozzle MV400FKS Conic 62mm	10
22	80240318	Gas Nozzle MV400FKS Cylindric 67mm	10
23	80240317	Gas Nozzle MV400FKS Conic 67mm	10
24a	80110411	Tip adaptor for isolator 400FKS	10
24b	80220315	Gas difuser isolator 400FKS	10
	81100236	Wearparts box MV 400 FKS 1.0-1.2 steel	1

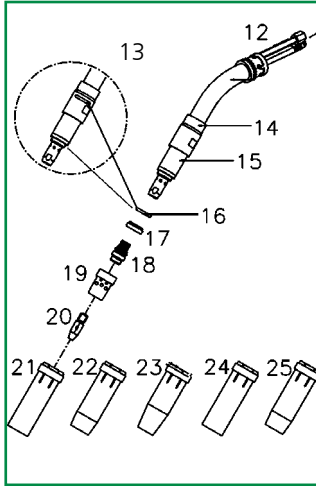
* = Pre-assembled as standard

Note: 24a and 24b must be used together



Wear Parts for Water-cooled MIG Welding Torches

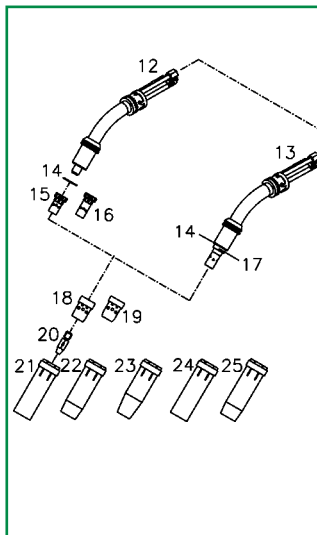
Wear parts for MV FKS 500 TWIST / Manager FKS 500



Position no.	Art. no.	Description	No of pcs.	
12	80252502	Swan neck MV500 FKS Twist	1	
13	92555041	Shrink FLEX Ø24 /8MM 1.2m Glue	1	
14	80100772	Insulator for cooling unit FKS500	1	
15	80100770	Water cooling unit FKS 500	1	
16	80100766	O-Ring FKS500W (2 pcs.)	1	
17	80220202	Insulation ring FKS500W	10	
18	*	80110410	Tip adaptor MV500FKS 38mm CuCrZr	10
19	*	80220312	Gas diffuser MV FKS/HD-S White	10
		80220313	Gas diffuser Ceramic HD-S+500FKS	10
20	*	80231202	CONTACT TIP. PLEASE SEE PAGE 19	10
21		80240300	Gas Nozzle ML/MV Cylindric	10
22	*	80240303	Gas Nozzle ML/MV Conic	10
23		80240304	Gas Nozzle ML/MV Super Conic	10
24		80140701	Gas Nozzle ML360 Cylindric nickelled	10
25		80140700	Gas Nozzle ML360 Conic nickelled	10
		81100237	Wearparts box MV 500 FKS 1.0-1.2 steel	1

* = Pre-assembled as standard

Wear parts for MV 450 / 550 TWIST



Position no.	Art. no.	Description	No of pcs.	
12	80252202	Swan neck MV450KD MIG-A Twist	1	
12	80252302	Swan neck MV550KD MIG-A Twist	1	
13	80252204	Swan neck MV450 MIG-A Twist	1	
13	80252304	Swan neck MV550 MIG-A Twist	1	
14	80220303	Insulating Washer MV450/550	10	
15.1	80110401	Tip adaptor MV450/550 M8 25mm	10	
15.2	*	80110406	Tip adaptor MV450-550 CuCrZr 25	10
15.3		80110403	Tip adaptor MV450/550 M6 25mm	10
16.1	80110402	Tip adaptor MV450/550 M8 29mm	10	
16.2	80110409	Tip adaptor MV450-550 CuCrZr 29mm	10	
17	80200307	Threaded Ring	1	
18.1	*	80220309	Gas diffuser MV450/550 White	10
18.2		80220306	Gas diffuser MV450/550 Black	10
18.3		80220310	Gas diffuser MV450/550 Ceramic	10
19		80220307	Gas diffuser MV450/550 Cylindric	10
20	*	80231202	CONTACT TIP. PLEASE SEE PAGE 19	10
21		80240300	Gas Nozzle ML/MV Cylindric	10
22	*	80240303	Gas Nozzle ML/MV Conic	10
23		80240304	Gas Nozzle ML/MV Super Conic	10
24		80140701	Gas Nozzle ML360 Cylindric nickelled	10
25		80140700	Gas Nozzle ML360 Conic nickelled	10
		81100216	Wearparts box MV450/550 1.0-1.2 steel	1

* = Pre-assembled as standard



Push Pull Welding Torches – Air-cooled/Water-cooled

Art. no.	Push Pull Welding Torches - Air-cooled
80790302	MPL 300F Straight 8m II
80790303	MPL 300F Curved 8m II
80790305	MPL 300F Curved 8m II turnable

Art. no.	Push Pull Welding Torches - Water-cooled
80890402	MPV 400F Straight 8m II
80890403	MPV 400F Curved 8m II
80890404	MPV 400F Straight 8m II turnable
80890405	MPV 400F Curved 8m II turnable
80890406	MPV 400F FKS 8m Straight II
80890407	MPV 400F FKS Curved 8M turnable

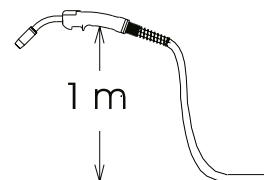
Art. no.	Wire feed rolls
80700401	Wire feed roll 0.8 mm
80700403	Wire feed roll 1.0 mm
80700404	Wire feed roll 1.2 mm
80700406	Wire feed roll Alu U-grove 1.0
80700407	Wire feed roll for Alu U-grove 1.2
80700408	Wire feed roll for Alu U-grove 1.6
40510305	Allen bolt for roll



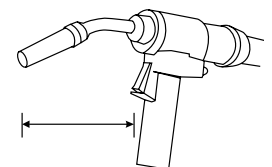
Technical Data

MODEL	MPL 300	MPV 400	MPV400 FKS Configurable
Duty cycle CO2 60%	-	365 A	415 A
Duty cycle CO2 100%	275 A	365 A	415 A
Mixgas 60%		325 A	350 A
Mixgas 100%	250 A	325 A	350 A
Cooling	Luft	Vand	Vand
Water-cooling 1 bar	÷	1 l/min.	1 l/min.
Max. pressure (water)	÷	5 bar	5 bar
Max. water temperature	÷	70°C	70°C
Gas flow +/-5%	15 l/min.*	18 l/min.*	18 l/min.*
Wire diameter, mm	0.8-1.2	0.8-1.6	0.8-1.6
Cable, mm ²	60	25	25
Weight **	2 kg	1.7 kg	1.7 kg
Total weight kg, 8 m	9.5 kg	8.2 kg	8.2 kg
Connection	ZA + 8 pol	ZA + 8 pol	ZA + 8 pol
Length of swan neck***	Straight 18 cm Curved 16.5 cm	Straight 23 cm Curved 20 cm	Straight 18 cm Curved 17 cm
Norm	IEC 60974-7 IEC 60974-10	IEC 60974-7 IEC 60974-10	IEC 60974-7 IEC 60974-10

** Weight



*** Length of swan neck

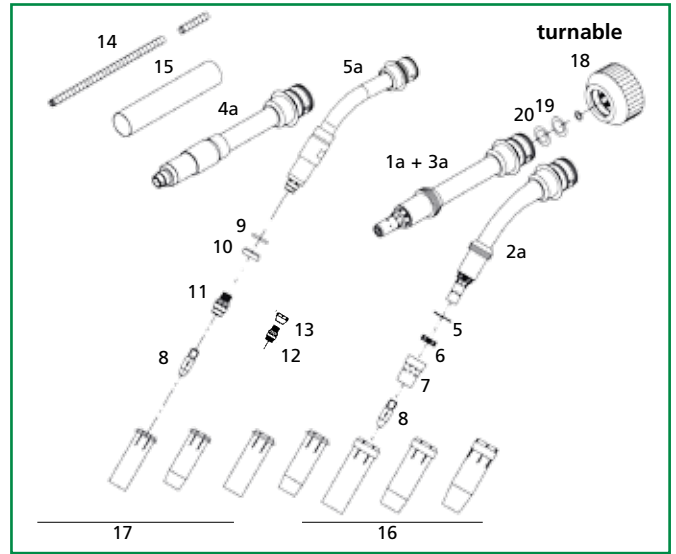
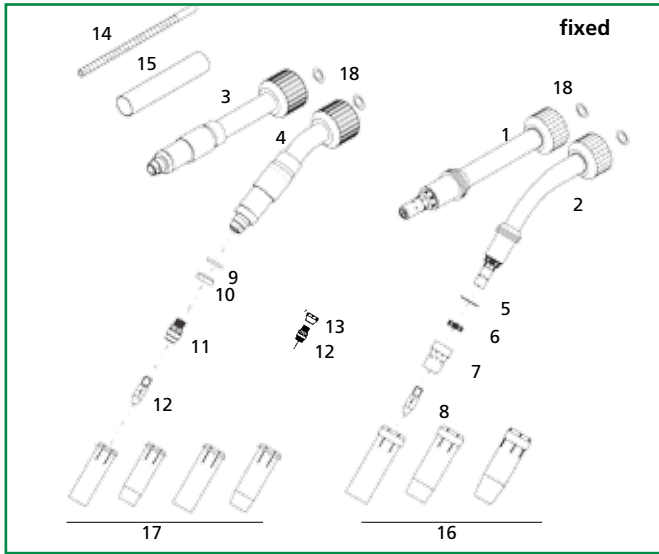


* Minimum gas flow for compliance with maximum performance

The products delivered may differ from the photos in the catalogue.



Wear parts for MPL 300 / MPV 400 / MPV 400 FKS



Pos. no.	Art. no.	Description FIXED
1	80850401	Swan neck PP 450 straight fixed
2	80850402	Swan neck PP 450, curved fixed
3	80850405	Swan neck PP 400 FKS straight fixed
4	80850406	Swan neck PP 400 FKS curved fixed
5	80220303	INSULATING WASHER MV450/550
6	80200307	Threaded Ring
7	80220306	Gas diffuser MV450/550 Black
	80220309	Gas diffuser MV450/550 White
	80220310*	Gas diffuser MV450/550 Ceramic
8	80231202*	Contact tip. Please see page 19
9	80100764	O-Ring FKS400W (2 pcs.)
10	80220201	Insulation ring FKS400W
11	80110408*	Tip adaptor MV400FKS 24mm
12	80110411	Tip adaptor for isolator 400FKS
13	80220315	Gas difuser isolator 400FKS
14	80160035	Bronze liner incl. Nipple
15	92555041	Shrink FLEX Ø24 /8MM 1.2m Glue
16	80240300	Gas Nozzle ML/MV Cylindric
	80240303*	Gas Nozzle ML/MV Conic
	80240304	Gas Nozzle ML/MV Super Conic
17	80240307	Gas Nozzle MV400FKS Conic 62mm
	80240308	Gas Nozzle MV400FKS Cylindric 62mm
	80240317	Gas Nozzle MV400FKS Conic 67mm
	80240318	Gas Nozzle MV400FKS Cylindric 67mm
18	43570013	O-ring ø6x1 Viton

* = Pre-assembled as standard

Note: 12 and 13 must be used together

Pos. no.	Art. no.	Description turnable
1a	80850403	Swan neck PP 550 KD straight turnable
2a	80850404	Swan neck PP 550 KD, curved fixed
3a	80850407	Swan neck PP 450 KD straight turnable
4a	80850410	Swan neck PP 400 FKS straight turnable
5a	80850411	Swan neck PP 400 FKS curved turnable
5	80220303	INSULATING WASHER MV450/550
6	80200307	Threaded Ring
7	80220306	Gas diffuser MV450/550 Black
	80220309	Gas diffuser MV450/550 White
	80220310*	Gas diffuser MV450/550 Ceramic
8	80231202*	Contact tip. Please see page 19
9	80100764	O-Ring FKS400W (2 pcs.)
10	80220201	Insulation ring FKS400W
11	80110408	Tip adaptor MV400FKS 24mm
12	80110411	Tip adaptor for isolator 400FKS
13	80220315	Gas difuser isolator 400FKS
14	80160035	Bronze liner incl. Nipple
15	92555041	Shrink FLEX Ø24 /8MM 1.2m Glue
16	80240300	Gas Nozzle ML/MV Cylindric
	80240303	Gas Nozzle ML/MV Conic
	80240304	Gas Nozzle ML/MV Super Conic
17	80240307	Gas Nozzle MV400FKS Conic 62mm
	80240308	Gas Nozzle MV400FKS Cylindric 62mm
	80240317	Gas Nozzle MV400FKS Conic 67mm
	80240318	Gas Nozzle MV400FKS Cylindric 67mm
18	80800108	Connecting nut
19	43570018	O-ring ø5.5x1.5
20	43572417	O-ring

* = Pre-assembled as standard

Note: 12 and 13 must be used together



Push Pull Welding Torches – Air-cooled/Water-cooled

SUITABLE FOR		Step-regulated MIG/MAG machines		MIG/MAG inverter machines					
		MIG 385x S	MIG 445x S	Omega ² 400 S	Omega ² 550 S	FLEX ² 3000	SIGMA ² 300 C / S	SIGMA ² 400 C / S	SIGMA ² 500 C / S
Push pull torches aircooled									
80790302	MPL 300F Straight 8m II	KIT	KIT	(KIT)	(KIT)	KIT	KIT	(KIT)	(KIT)
80790303	MPL 300F Curved 8m II	KIT	KIT	(KIT)	(KIT)	KIT	KIT	(KIT)	(KIT)
80790305	MPL 300F Curved 8m II turnable	KIT	KIT	(KIT)	(KIT)	KIT	KIT	(KIT)	(KIT)
Push pull torches watercooled									
80890402	MPV400F 8m Straight II	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)
80890403	MPV400F 8m Curved II	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)
80890404	MPV400F 8m Straight II TURNAB.	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)
80890405	MPV400F 8m Curved II turnable	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)
80890406	MPV 400F FKS 8m Straight II	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)
80890407	MPV 400F FKS Curved 8m turnable	KIT	KIT	KIT	(KIT)	KIT	KIT	KIT	(KIT)

KIT = Requires Push pull kit. (KIT) = Not recommendable for maximum performance - requires Push pull kit.

Migair Welding Torches with Fume Extraction

Art. no.	ML 240 aircooled
80193310	ML240 MIG AIR 4m
80193311	ML240 MIG AIR 5m
Art. no.	MV 400 FKS watercooled
80293017	MV400 FKS MIG AIR 4m
80293018	MV400 FKS MIG AIR 5m



Technical Data

Model	ML 240 MigAir	MV 400 FKS MigAir
Duty cycle CO2 60%	250 A	415 A
Duty cycle CO2 100%	225 A	415 A
Mixgas 60%	220 A	350 A
Mixgas 100%	195 A	350 A
Cooling	Air	Water
Min. flowrate water-cooling 1 bar	-	1 l/min.
Max pressure (water)	-	5 bar
Max water temp.	-	70° C
Gas flow +/-5%	10-20 l/min.	10-20 l/min.
Wire diameter, mm	0.8-1.2	0.8-1.6
Cable, mm ²	25	16
Weight	1.4 kg	1.7 kg
Total weight kg, 4m	4.8 kg	4.9 kg
Connection	ZA	ZA
Norm	IEC 60974-7, IEC 60974-10	

Art. no.	Description
80160520	Steel liner 4.4m 0.6-0.8 white
80160550	Steel liner 5.4m 0.6-0.8 white
80160545	Steel liner 4.4m 1.2-1.6 red
80160546	* Steel liner 5.4m 1.2-1.6 red
80200345	Fume nozzle long
80100793	Fume nozzle short
* = Pre-assembled as standard	
Wear parts: Please refer to MV 240 and MV 400 FKS page 13	



Contact Tips and Tip Adaptors

Choice of Contact Tip

With the exception of ML 150/250 types, a Migatronic ML/MV torch is equipped as standard with a CuCrZr (copper, chromium, zirconium) contact tip, in the most frequently used dimension as well as a gas nozzle. This

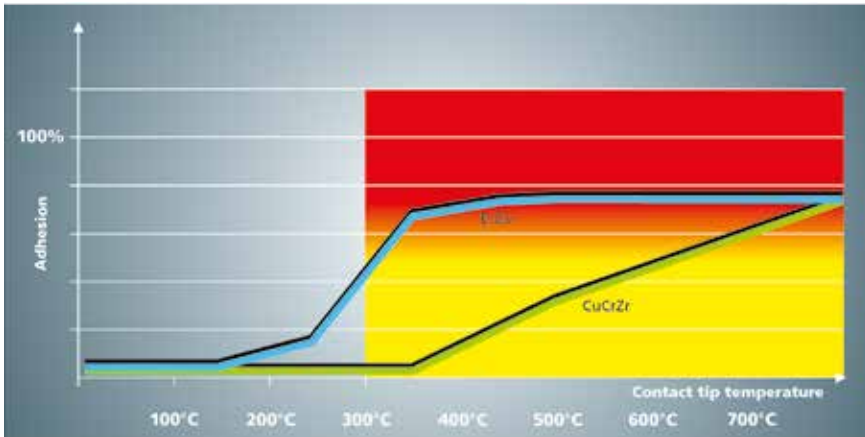
is the most optimal choice of contact tip in terms of welding properties and/or operating costs.

Contact tips for ML/MV are available in different materials and lengths so as to ensure best possible welding result.

For MIG pulse welding and welding in aluminium, we recommend longer contact tips combined with longer gas nozzles, for optimization of welding current transmission and gas shielding. A slim contact tip will have a lower temperature, as it will receive less radiant heat from the arc.

That is why we recommend CuCrZr (copper, chromium, zirconium) contact tips which are considerably harder and less sensitive to high temperatures. An ordinary E-Cu (copper) type of contact tip will become soft and adhere to the welding wire if the temperature in the contact tip exceeds 300°C. A CuCrZr contact tip will do that much later (see graph to the left).

Please refer to the list of contact tips.



Choice of Tip Adaptor - Material and Design

Some types of torches can be equipped with various designs of tip adaptors. This allows the welder to optimise to another type of contact tip (thread/length). A tip adaptor made of CuCrZr will increase the performance of the torch. A standard tip adaptor is

made of Ms (brass) which is characterized by strength and non-optimal thermal conductivity. CuCrZr is characterized by the strength and ductility of Ms and the thermal conductivity of E-Cu. That is why it is possible to achieve better performance by using a CuCrZr contact tip.

replaceable. FKS types have separate tip adaptors with direct connection to the cooling water. That is why they are up to the performance standard of torches with integrated tip adaptors.

MV 500 FKS is equipped as standard with separate CuCrZr tip adaptor.

Please refer to the list of tip adaptors.

ML / MV 240



MV 450/550 torches are supplied with integrated or separate tip adaptors.

For maximum performance we recommend integrated tip adaptors but if thread for contact tip becomes defective, the swan neck must be replaced. The performance of a torch with separate tip adaptor is typically lower, but in return, the tip adaptor is

MV 450 / MV 550



MV 450 FKS / MV 550 FKS





Contact Tips

Contact tip - design and length	Art. no.	Item description	ML 150	ML 250	ML 240	ML 300	ML 360	ML 400	ML 500
M 6									
	80130001	ø 0.6 M6 ø 6 x 25 mm Cu nickel-plated	(•)	(•)	(•)	(•)	(•)		
	80130002	ø 0.8 M6 ø 6 x 25 mm Cu nickel-plated	(•)	(•)	(•)	(•)	(•)		
	80130003	ø 1.0 M6 ø 6 x 25 mm Cu nickel-plated	(•)	(•)	(•)	(•)	(•)		
	80130004	ø 1.2 M6 ø 6 x 25 mm Cu nickel-plated	(•)	(•)	(•)	(•)	(•)		
	80130101	ø 0.6 M6 ø 6 x 25 mm Cu	(•)	(•)	(•)				
	80130102	ø 0.8 M6 ø 6 x 25 mm Cu	(•)	(•)	(•)				
	80130103	ø 1.0 M6 ø 6 x 25 mm Cu	(•)	(•)	(•)				
	80130104	ø 1.2 M6 ø 6 x 25 mm Cu	(•)	(•)	(•)				
	80130201	ø 0.6 M6 ø 8 x 28 mm Cu	•	•	•	•	•		
	80130202	ø 0.8 M6 ø 8 x 28 mm Cu	•	•	•	•	•		
	80130203	ø 1.0 M6 ø 8 x 28 mm Cu	•	•	•	•	•		
	80130204	ø 1.2 M6 ø 8 x 28 mm Cu	•	•	•	•	•		
	80131200	ø 0.8 M6 ø 8 x 28 mm CuCrZr	•	•	•	•	•		
	80131201	ø 1.0 M6 ø 8 x 28 mm CuCrZr	•	•	•	•	•		
	80131202	ø 1.2 M6 ø 8 x 28 mm CuCrZr	•	•	•	•	•		
	80131203	ø 1.4 M6 ø 8 x 28 mm CuCrZr	•	•	•	•	•		
	80131204	ø 1.6 M6 ø 8 x 28 mm CuCrZr	•	•	•	•	•		
M 8									
	80231220	ø 0.8 M8 ø 8 x 30 mm CuCrZr heavy duty						•	•
	80231221	ø 1.0 M8 ø 8 x 30 mm CuCrZr heavy duty						•	•
	80231222	ø 1.2 M8 ø 8 x 30 mm CuCrZr heavy duty						•	•
	80231101	ø 0.8 M8 ø 10 x 30 mm E-Cu						•	•
	80231102	ø 1.0 M8 ø 10 x 30 mm E-Cu						•	•
	80231103	ø 1.2 M8 ø 10 x 30 mm E-Cu						•	•
	80231106	ø 1.4 M8 ø 10 x 30 mm E-Cu						•	•
	80231104	ø 1.6 M8 ø 10 x 30 mm E-Cu						•	•
	80231200	ø 0.8 M8 ø 8 x 30 mm CuCrZr						•	•
	80231201	ø 1.0 M8 ø 8 x 30 mm CuCrZr						•	•
	80231202	ø 1.2 M8 ø 8 x 30 mm CuCrZr						•	•
	80231203	ø 1.6 M8 ø 8 x 30 mm CuCrZr						•	•
	80231204	ø 1.4 M8 ø 8 x 30 mm CuCrZr						•	•
	80231205	ø 0.8 M8 ø 10 x 30 mm CuCrZr						•	•
	80231206	ø 1.0 M8 ø 10 x 30 mm CuCrZr						•	•
	80231207	ø 1.2 M8 ø 10 x 30 mm CuCrZr						•	•
	80231208	ø 1.4 M8 ø 10 x 30 mm CuCrZr						•	•
	80231209	ø 1.6 M8 ø 10 x 30 mm CuCrZr						•	•

• = Mild steel Fe, stainless steel CrNi and FCW. (•) = Alternative, but we recommend •. • = Aluminium welding.
 • = For gas nozzles with special length (depending on torch model). (•) = Alternative, but we recommend •.



Contact Tips

Contact tip - design and length	Art. no.	Item description	MV 240	MV 450	MV 550	MV 400 FKS	MV 500 FKS
M 6							
	80130001	∅ 0.6 M6 ∅ 6 x 25 mm Cu nickel-plated	(•)				
	80130002	∅ 0.8 M6 ∅ 6 x 25 mm Cu nickel-plated	(•)				
	80130003	∅ 1.0 M6 ∅ 6 x 25 mm Cu nickel-plated	(•)				
	80130004	∅ 1.2 M6 ∅ 6 x 25 mm Cu nickel-plated	(•)				
	80130201	∅ 0.6 M6 ∅ 8 x 28 mm Cu	•				
	80130202	∅ 0.8 M6 ∅ 8 x 28 mm Cu	•				
	80130203	∅ 1.0 M6 ∅ 8 x 28 mm Cu	•				
	80130204	∅ 1.2 M6 ∅ 8 x 28 mm Cu	•				
	80131200	∅ 0.8 M6 ∅ 8 x 28 mm CuCrZr	•				
	80131201	∅ 1.0 M6 ∅ 8 x 28 mm CuCrZr	•				
	80131202	∅ 1.2 M6 ∅ 8 x 28 mm CuCrZr	•				
	80131203	∅ 1.4 M6 ∅ 8 x 28 mm CuCrZr	•				
	80131204	∅ 1.6 M6 ∅ 8 x 28 mm CuCrZr	•				
M 8							
	80231101	∅ 0.8 M8 ∅ 10 x 30 mm E-Cu		•	•	•	•
	80231102	∅ 1.0 M8 ∅ 10 x 30 mm E-Cu		•	•	•	•
	80231103	∅ 1.2 M8 ∅ 10 x 30 mm E-Cu		•	•	•	•
	80231106	∅ 1.4 M8 ∅ 10 x 30 mm E-Cu		•	•	•	•
	80231104	∅ 1.6 M8 ∅ 10 x 30 mm E-Cu		•	•	•	•
	80231110	∅ 0.8 M8 ∅ 8 x 35 mm CuCrZr		••	••	••	••
	80231111	∅ 1.0 M8 ∅ 8 x 35 mm CuCrZr		••	••	••	••
	80231112	∅ 1.2 M8 ∅ 8 x 35 mm CuCrZr		••	••	••	••
	80231113	∅ 1.6 M8 ∅ 8 x 35 mm CuCrZr		••	••	••	••
	80231121	∅ 1.0 M8 ∅ 10 x 35 mm E-Cu		(•) (•)	(•) (•)	(•) (•)	(•) (•)
	80231122	∅ 1.2 M8 ∅ 10 x 35 mm E-Cu		(•) (•)	(•) (•)	(•) (•)	(•) (•)
	80231123	∅ 1.6 M8 ∅ 10 x 35 mm E-Cu		(•) (•)	(•) (•)	(•) (•)	(•) (•)
	80231200	∅ 0.8 M8 ∅ 8 x 30 mm CuCrZr		•	•	•	•
	80231201	∅ 1.0 M8 ∅ 8 x 30 mm CuCrZr		•	•	•	•
	80231202	∅ 1.2 M8 ∅ 8 x 30 mm CuCrZr		•	•	•	•
	80231203	∅ 1.6 M8 ∅ 8 x 30 mm CuCrZr		•	•	•	•
	80231204	∅ 1.4 M8 ∅ 8 x 30 mm CuCrZr		•	•	•	•
	80231220	∅ 0.8 M8 ∅ 8 x 30 mm CuCrZr heavy duty		•	•	•	•
	80231221	∅ 1.0 M8 ∅ 8 x 30 mm CuCrZr heavy duty		•	•	•	•
	80231222	∅ 1.2 M8 ∅ 8 x 30 mm CuCrZr heavy duty		•	•	•	•
	80231205	∅ 0.8 M8 ∅ 10 x 30 mm CuCrZr		•	•	•	•
	80231206	∅ 1.0 M8 ∅ 10 x 30 mm CuCrZr		•	•	•	•
	80231207	∅ 1.2 M8 ∅ 10 x 30 mm CuCrZr		•	•	•	•
	80231208	∅ 1.4 M8 ∅ 10 x 30 mm CuCrZr		•	•	•	•
	80231209	∅ 1.6 M8 ∅ 10 x 30 mm CuCrZr		•	•	•	•
	80231300	∅ 0.8 M8 ∅ 10 x 38 mm CuCrZr			•••	•••	•••
	80231301	∅ 1.0 M8 ∅ 10 x 38 mm CuCrZr			•••	•••	•••
	80231302	∅ 1.2 M8 ∅ 10 x 38 mm CuCrZr			•••	•••	•••
	80231303	∅ 1.6 M8 ∅ 10 x 38 mm CuCrZr			•••	•••	•••

• = Mild steel Fe, stainless steel CrNi and FCW. (•) = Alternative, but we recommend •. •• = Aluminium welding.
 • = For gas nozzles with special length (depending on torch model). (•) = Alternative, but we recommend •.



Contact Tips

Contact tip - design and length	Art. no.	Item description	MV 400 FKS	MV 500 FKS
M 8				
	80231401	ø 1.0 M8 ø 10 x 41 mm CuCrZr	••	••
	80231402	ø 1.2 M8 ø 10 x 41 mm CuCrZr	••	••

- = Mild steel Fe, stainless steel CrNi and FCW. (•) = Alternative, but we recommend •. • = Aluminium welding.
- = For gas nozzles with special length (depending on torch model). (•) = Alternative, but we recommend •.

Spare Parts for ZA

Art. no.	Description
80200303	Swivel nut
26920008	Gas nipple Ms
80100004	Gas nipple Ms
26910008	Gas nipple CrNi
80100710	O-ring
80200312	Spring pin without spring 21.5 mm ø 5
80100773	Spring pin without spring 19.0 mm ø 6.5
80100747	Spring pin with spring 24.0 mm ø 5.2
80100810	Spring pin for ZA air 24mm ø 6.5
80100811	Spring pin for ZA water 12mm ø 6.5
80100706	ZA-ML Spring pin air
80200332	ZA-ML Spring pin water
80200301	Nut for ZA hose

Swivel nut: 80200303 	Gas nipple: 26920008 Ms 80100004 Ms 26910008 CrNi	O-ring: x 1 80100710 x 2 x 1 	Spring pins: without spring 21.5 mm 80200312 ø5.0 without spring 19.0 mm 80100773 ø6.5 with spring 24.0 mm 80100747 ø5.2 Spring pin for ZA air 24.0 mm 80100810 ø6.5 Spring pin for ZA Water 12.0 mm 80100811 ø6.5 Socket Ø4 red, separate (2 pcs.) 18270004
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





Wire Liners

Wire Liners	
Art. no.	Description
80160520	Steel liner 4.4m 0.6-0.8 white
80160521	Steel liner 4.4m 0.8-1.0 blue
80160522	Steel liner 4.4m 1.2-1.6 red
80160523	Steel liner 4.4m 1.6-2.4 yellow
80160550	Steel liner 5.4m 0.6-0.8 white
80160551	Steel liner 5.4m 0.8-1.0 blue
80160552	Steel liner 5.4m 1.2-1.6 red
80160553	Steel liner 5.4m 1.6-2.4 yellow

Wire Liners	
Art. no.	Description
80160554	Steel/teflonliner (PTFE) Ø4 4.4m 0,8-1,2
80160555	Steel/teflonliner (PTFE) Ø5 4.4m 1,0-1,6
80160556	Steel/teflonliner (PTFE) Ø4 5.4m 0,8-1,2
80160557	Steel/teflonliner (PTFE) Ø5 5.4m 1,0-1,6
80160558	Steel/teflonliner (PTFE) Ø4 3.4m 0,8-1,2
80160559	Steel/teflonliner (PTFE) Ø5 6.4m 1,0-1,6
80160711	Plastic liner (PEH) with bronze neck
80160713	Plastic liner (PEH) with bronze neck
80160700	Carbon teflon liner (carbon PTFE) with bronze neck
80160707	Carbon teflon liner (carbon PTFE) with bronze neck

Migatronik recommends

Wire	Wire diameter	Steelliner / Steelteflonliner				Plastic liner (PEH) with bronze neck	Carbon teflon liner (carbon PTFE) with bronze neck
							
Length of liner		3.4 m	4.4 m	5.4 m	6.4 m	4.4 m	4.4 m
Fe Mild steel	0.6 mm 0.8 mm 1.0 mm 1.2 mm 1.4 mm 1.6 mm 2.0 mm 2.4 mm	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523	80160550 80160551 80160551 80160552 80160552 80160552 80160553 80160553			
CrNi Stainless steel	0.8 mm 1.0 mm 1.2 mm	80160558 80160558 80160558	80160554 80160554 80160554	80160556 80160556 80160556			80160700 80160700 80160707
Cu Copper alloys	1.2 mm 1.4 mm 1.6 mm		80160555 80160555 80160555	80160557 80160557 80160557	80160559 80160559 80160559		80160707 80160707 80160707
Fe Flux Steel with flux cored wire	0.6 mm 0.8 mm 1.0 mm 1.2 mm 1.4 mm 1.6 mm 2.0 mm 2.4 mm	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523	80160520 80160521 80160521 80160522 80160522 80160522 80160523 80160523	80160550 80160551 80160551 80160552 80160552 80160552 80160553 80160553			
CrNi Flux Stainless steel with flux cored wire	0.8 mm 1.0 mm 1.2 mm 1.2 mm 1.4 mm 1.6 mm	80160558 80160558 80160558	80160554 80160554 80160554	80160556 80160556 80160556	80160559 80160559 80160559		80160700 80160707 80160707 80160707
Al Aluminium	0.8 mm 1.0 mm 1.2 mm 1.2 mm 1.4 mm 1.6 mm	80160558 80160558 80160558	80160554 80160554 80160554	80160556 80160556 80160556	80160559 80160559 80160559	80160711 80160713 80160713 80160713	

Fields highlighted in grey apply to steel teflon liner only

For liner diameter Ø4 choose wire diameter 0.8 - 1.2 mm. For liner diameter Ø5 choose wire diameter 1.2 - 1.6 mm

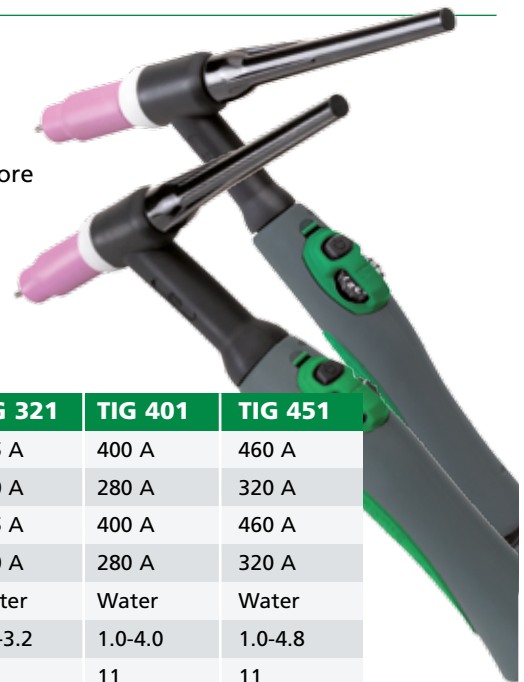


TIG Ergo Welding Torches

TIG Ergo – for optimal TIG Welding

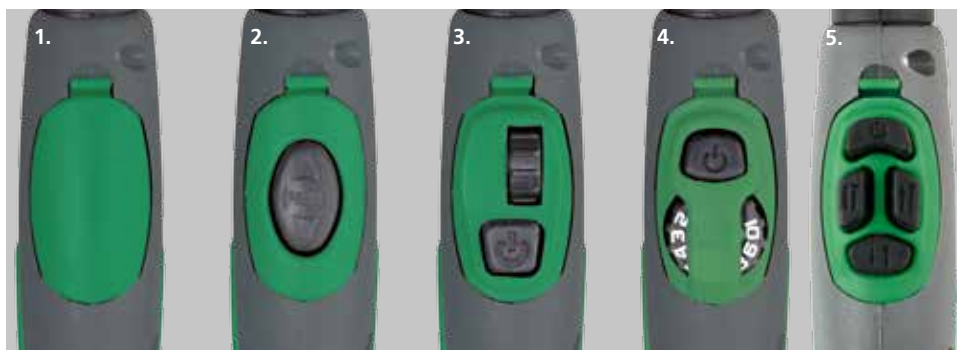
TIG Ergo is designed with focus on ergonomics, user-friendliness, movability and reliability. The TIG Ergo range includes more than 50 different models – from small air-cooled to heavy duty water-cooled models for welding with more than 400 amps.

All TIG Ergo models are configurable with different control units as well as handle in two sizes with ball-and-socket joint and soft grip.



Technical Data

MODEL	TIG 101	TIG 201	TIG 221	TIG 301	TIG 321	TIG 401	TIG 451
Duty cycle DC 60%	90 A	110 A	130 A	230 A	325 A	400 A	460 A
Duty cycle AC 60%	65 A	75 A	90 A	160 A	230 A	280 A	320 A
Duty cycle DC 100%	80 A	90 A	110 A	225 A	325 A	400 A	460 A
Duty cycle AC 100%	55 A	65 A	80 A	160 A	230 A	280 A	320 A
Cooling	Air	Air	Air	Water	Water	Water	Water
Electrode diameter, mm	1.0-2.4	1.0-2.4	1.0-2.4	1.0-3.2	1.0-3.2	1.0-4.0	1.0-4.8
Gas flow +-5%. l / min.	7	7	7	9	9	11	11
Cable, mm	15	15	21	4/6 (8 m)	12/15 (8 m)	12/15 (8 m)	18 (8m)
Weight at 1 m height	0.8 kg	1.0 kg	1.1 kg	0.8 kg	1.0 kg	1.1 kg	1.2 kg
Total weight , 4 m	1.7 kg	1.9 kg	2.0 kg	1.5 kg	2.0 kg	2.2 kg	2.7 kg



1. Blank cover for use with e.g. foot switch
80300102

2. Keypad unit
80300100 (old model)
80300060 (new model)

3. Keypad unit with vertical TIG control knob (RV)
80300101 (old model)
80300061 (new model)

4. Keypad unit with horizontal TIG control knob (RH)
80300130 (old model)
80300070 (new model)

5. Regulation module with push buttons for change of welding parameters.
80300063



Cable connector for water-cooled TIG 321/401/451 welding torch



Cable connector for water-cooled TIG 301 welding torch



Old model, use:
80300100
80300101
80300130

New model (2012 →), use:
80300060
80300061
80300070
80300063



Cable connector for air-cooled TIG 101/201 welding torch



Cable connector for air-cooled TIG 221 welding torch



Art. no.	TIG 101 RANGE
80392655	TIG Ergo 101 4m 7P
80392658	TIG Ergo 101 Flex 4m 7P
80392656	TIG Ergo 101 8m 7P
80392657	TIG Ergo 101 Flex 8m 7P
80392650	TIG Ergo 101RH 4m 7P
80392653	TIG Ergo 101RH Flex 4m 7P
80392651	TIG Ergo 101RH 8m 7P
80392652	TIG Ergo 101RH Flex 8m 7P
80392659	TIG101RV 4m 7P
80392660	TIG101RV 8m 7P
80392615	TIG ERGO 101V 4m

Art. no.	TIG 201 RANGE
80392795	TIG ERGO 201 4m 7P
80392801	TIG ERGO 201 FLEX 4m 7P
80392796	TIG ERGO 201 8m 7P
80392794	TIG ERGO 201 FLEX 8m 7P
80392797	TIG ERGO 201RH 4m 7P
80392802	TIG ERGO 201RH FLEX 4m 7P
80392798	TIG ERGO 201RH 8m 7P
80392799	TIG ERGO 201RH FLEX 8m 7P
80392803	TIG ERGO 201RV 4 m 7P
80392804	TIG ERGO 201RV 8 m 7P

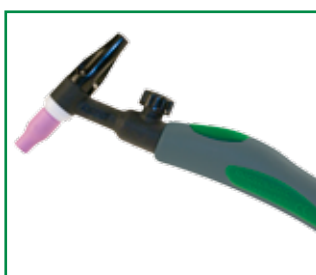
Art. no.	TIG 221 RANGE
80392875	TIG ERGO 221 4m 7 POL
80392876	TIG ERGO 221 8m 7 POL
80392887	TIG ERGO 221 15M 7 POL
80392877	TIG ERGO 221RH 4m 7 POL
80392878	TIG ERGO 221RH 8m 7 POL
80392888	TIG ERGO 221RH 15M 7 POL
80392879	TIG ERGO 221RV 4m 7 POL
80392880	TIG ERGO 221RV 8m 7 POL
80392881	TIG ERGO 221 FLEX 4m 7 POL
80392882	TIG ERGO 221 FLEX 8m 7 POL
80392883	TIG ERGO 221RH FLEX 4m 7 POL
80392884	TIG ERGO 221RH FLEX 8m 7 POL

Art. no.	TIG 301 RANGE
80492140	TIG ERGO 301 4m 7P
80492143	TIG ERGO 301 FLEX 4m 7P
80492141	TIG ERGO 301 8m 7P
80492142	TIG ERGO 301 FLEX 8m 7P
80492135	TIG ERGO 301RH 4m 7P
80492138	TIG ERGO 301RH FLEX 4m 7P
80492136	TIG ERGO 301RH 8m 7P
80492137	TIG ERGO 301RH FLEX 8m 7P
80492144	TIG ERGO 301RV 4m 7P
80492145	TIG ERGO 301RV 8m 7P

Art. no.	TIG 321 RANGE
80492150	TIG ERGO 321 4m 7P
80492151	TIG ERGO 321 8m 7P
80492152	TIG ERGO 321RH 4m 7P
80492153	TIG ERGO 321RH 8m 7P

Art. no.	TIG 401 RANGE
80492215	TIG ERGO 401 4m 7P
80492216	TIG ERGO 401 8m 7P
80492235	TIG ERGO 401RH 4m 7P
80492236	TIG ERGO 401RH 8m 7P
80492237	TIG ERGO 401RV 4m 7P
80492238	TIG ERGO 401RV 8m 7P
80492241	TIG ERGO 401RH FLEX 4m
80492242	TIG ERGO 401RH FLEX 8m

Art. no.	TIG 451 RANGE
80492315	TIG ERGO 451 4m 7P
80492316	TIG ERGO 451 8m 7P
80492335	TIG ERGO 451 RH 4m 7P
80492336	TIG ERGO 451 RH 8m 7P
80492337	TIG ERGO 451 RV 4m 7P
80492338	TIG ERGO 451 RV 8m 7P



TIG Ergo 101V, 4m
Art. no.....80392615



7/6 pole adaptor
Art. no.....80300116



7 pole TIG ZA adaptor
Art. no.....75990007

ABBREVIATIONS TIG:

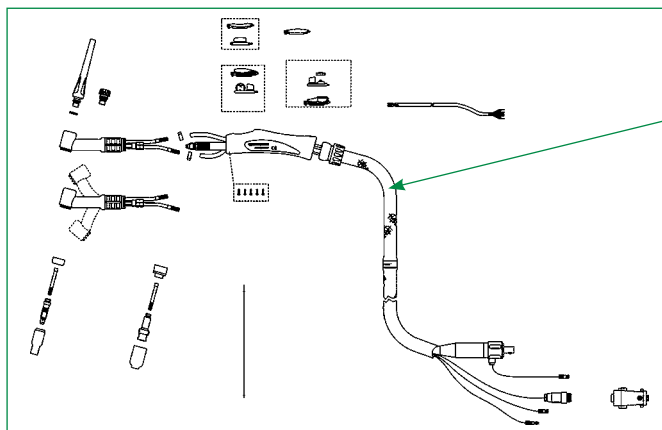
- TIG 201** = Model
- R** = Remote control/Dialog
- FLEX** = Flexible torch body
- 8 m** = Length
- RH** = Horizontal regulation
- RV** = Vertical regulation



TIG Ergo Welding Torches

SUITABLE FOR	TIG & MMA machines							
	RallyMIG	PI 200 Air / Focus TIG 160/200	PI 200 Water	PI 250 Air	PI 250 Water	PI 350 Air	PI 350 W	PI 500
WELDING TORCHES								
TIG ERGO 101V	*							
TIG ERGO 101 RANGE 7 pole		(*)		(*)				
TIG ERGO 201/221 RANGE 7 pole		*		*		(*)		
TIG ERGO 301/321 RANGE 7 pole			*		*		*	(*)
TIG ERGO 401 RANGE 7 pole			*		*		*	(*)
TIG ERGO 451 RANGE 7 pole			*		*		*	*

* Recommended. *) Not recommendable for maximum performance



Leather cover with zip
For protection of the welding hose.



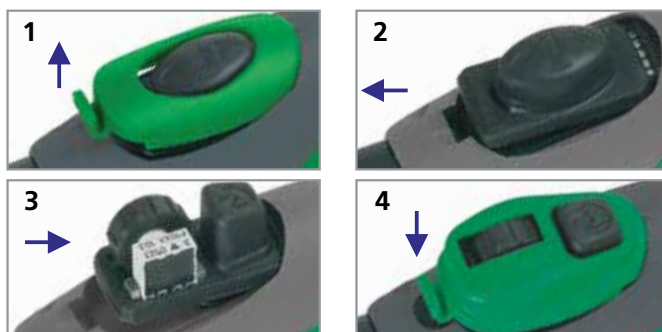
For TIG 101/301
Art. no..... 80300134

For TIG 201/221/321/401/451
Art. no..... 80300135



TIG Extension Cable

For extension of TIG welding hose; after use, you can choose the short TIG welding hose again. If you use a water-cooled TIG extension cable, the duty cycle of the standard torch remains unchanged because the TIG extension cable does not load the cooling unit.



A Migatronic TIG welding torch is equipped with an easily replaceable control unit on the torch handle. As standard, the control unit consists of a keypad unit but for use on Migatronic TIG welding machines, we recommend a control unit with both keypad unit and control knob.

Art. no.	Description
74303610	10m 25mm ² Air 7-P w/o box
74303615	15m 25mm ² Air 7-P w/o box
74303620	20m 25mm ² Air 7-P w/o box
74355710	10m 50mm ² Water 7-P w/o box
74355715	15m 50mm ² Water 7-P w/o box
74355720	20m 50mm ² Water 7-P w/o box
80300134	ZIP leather for TIG 101/301
80300135	ZIP leather for TIG 201/221/321/401/451



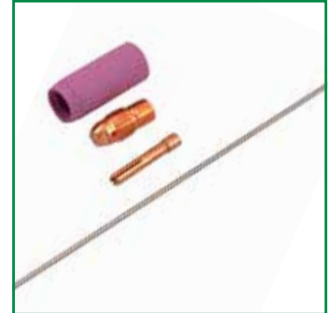
Wear Parts for TIG Ergo Welding Torches

Wear parts boxes for TIG Ergo 101 - 401

81100228 Wear parts box TIG 101/301/321		
80300219	1 pcs.	Insulator TIG101/301
80361372	10 pcs.	Tungsten electrode WS2 Ø1.6 superblue
80361374	10 pcs.	Tungsten electrode WS2 Ø2.4 superblue
80400115	1 pcs.	Electrode clamp short TIG 101-301
80400116	1 pcs.	Electrode clamp MEDIUM TIG 101-301
80400117	1 pcs.	Electrode clamp long TIG 101-301
80400204	2 pcs.	O-Ring Electrode cap TIG100/300
80410202	2 pcs.	Electrode holder Ø1.6 TIG101/301
80410203	2 pcs.	Electrode holder Ø2.4 TIG101/301
80430212	5 pcs.	Electrode clamp Ø1.6 MM CuCr
80430213	5 pcs.	Electrode clamp Ø2.4 MM CuCr
80440202	5 pcs.	Gas Nozzle TIG101/301 #5
80440203	5 pcs.	Gas Nozzle TIG101/301 #6
80440204	5 pcs.	Gas Nozzle TIG101/301 #7



Wear parts box for TIG 101/301/321
Art. no.....81100228



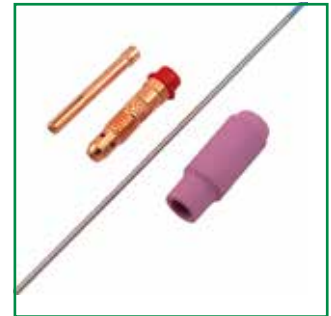
Set of standard wear parts
Ø1.6 TIG101-321 80300117
Ø2.4 TIG101-321 80300119

Set of wear parts, gas lenses (Not shown)
Ø1.6 TIG 101-32180300140
Ø2.4 TIG 101-32180300141

81100230 Wear parts box TIG 201/221/401		
80300189	2 pcs.	Insulator TIG 201-401
80361372	10 pcs.	Tungsten electrode WS2 Ø1.6 superblue
80361374	10 pcs.	Tungsten electrode WS2 Ø2.4 superblue
80300200	1 pcs.	Electrode cap short TIG 201-401
80300201	1 pcs.	Electrode cap long TIG201-401
80300223	2 pcs.	O-Ring for cap TIG201/401
80310000	2 pcs.	Electrode holder Ø1.6 TIG201/401
80310001	2 pcs.	Electrode holder Ø2.4 TIG201/401
80330111	5 pcs.	Electrode clamp Ø1.6 MM CuCr
80330112	5 pcs.	Electrode clamp Ø2.4 MM CuCr
80340002	5 pcs.	Gas Nozzle TIG201/401 #5
80340003	5 pcs.	Gas Nozzle TIG201/401 #6
80340004	5 pcs.	Gas Nozzle TIG201/401 #7



Wear parts box for TIG 201/221/401
Art. no.....81100230



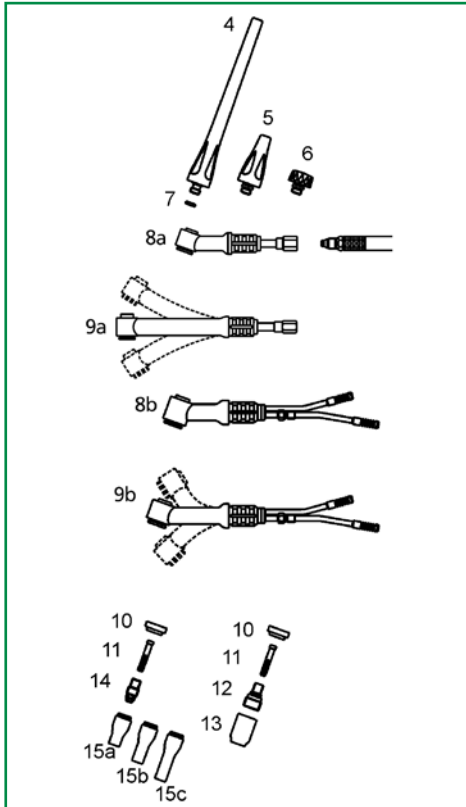
Set of standard wear parts
Ø1.6 TIG 201-40180300274
Ø2.4 TIG 201-40180300118

Set of wear parts, gas lenses (Not shown)
Ø1.6 TIG 201-40180300142
Ø2.4 TIG 201-40180300143



Wear Parts for TIG Ergo Welding Torches

Wear parts for TIG Ergo 101/301/321



TIG 101 is a small, lightweight air-cooled TIG welding torch for use in hard-to-reach locations and where welding current does not exceed approx. 100 A DC.

TIG 101 is typically used for welding in stainless materials.

TIG 301 and 321 are extra robust water-cooled TIG welding torches. Water-cooling provides low temperature in the torch and handle as well as better comfort and longer durability.

TIG 301 and 321 are typically used for welding in steel, stainless steel and aluminium.

TIG 301/321 can be equipped with all wear parts displayed to the right, and the control unit is easily replaced.

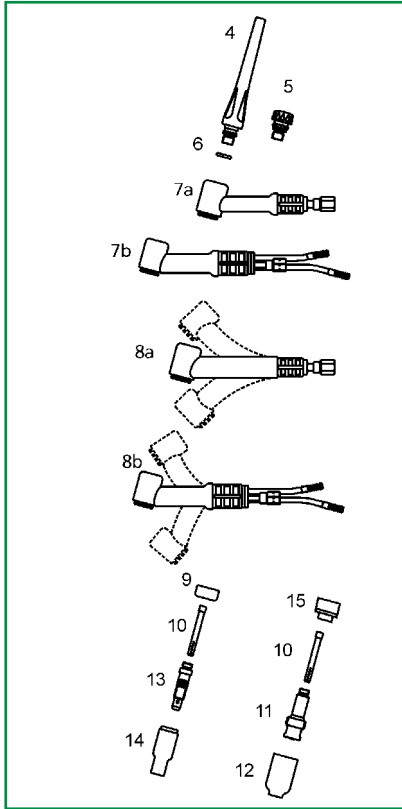
Position no.	Art. no.	Description	No of pcs.
4	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80400117	Electrode clamp long TIG 101-301	1
5	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80400116	Electrode clamp MEDIUM TIG 101-301	10
6	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80400115	Electrode clamp short TIG 101-301	10
7	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80400204	O-Ring Electrode cap TIG100/300	10
8a	80300194	Torch body TIG 301 55 mm	1
9a	80300195	Torch body TIG 101F 60 mm	1
	80300051	Torch body TIG 101 F 100 mm	1
	80300052	Torch body TIG 101 F 135 mm	1
8b	80400310	Insulator TIG101/301	1
9b	80400311	Torch body TIG 301F 55 mm	10
	80400315	Torch body TIG 301 F 105 mm	10
	80400316	Torch body TIG 301 F 135 mm	10
10	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80300219	Insulator TIG101/301	10
11	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80430211	Electrode clamp Ø1.0 mm CuCr	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80430212	Electrode clamp Ø1.6 mm CuCr	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80430213	Electrode clamp Ø2.4 mm CuCr	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80430214	Electrode clamp Ø3.2 mm CuCr	10
12	80410210	Gas lens 1,0 mm 101-301 copper/brass	10
	80410211	Gas lens 1,6 mm 101-301 copper/brass	10
	80410212	Gas lens 2,4 mm 101-301 copper/brass	10
	80410213	Gas lens II 3,2 mm 101-301 copper/brass	10
	80410214	Gas lens II 1,0 mm 101-301 cast brass	10
	80410215	Gas lens II 1,6 mm 101-301 cast brass	10
	80410216	Gas lens II 2,4 mm 101-301 cast brass	10
80410217	Gas lens II 3,2 mm 101-301 cast brass	10	
13	80440210	Gas Nozzle GAS L TIG101/301 #4	10
	80440211	Gas Nozzle GAS L TIG101/301 #5	10
	80440212	Gas Nozzle GAS L TIG101/301 #6	10
	80440213	Gas Nozzle GAS L TIG101/301 #7	10
	80440214	Gas Nozzle GAS L TIG101/301 #8	10
14	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80410201	Electrode holder Ø1.0 TIG101/301	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80410202	Electrode holder Ø1.6 TIG101/301	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80410203	Electrode holder Ø2.4 TIG101/301	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80410204	Electrode holder Ø3.2 TIG101/301	10
15a	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80440201	Gas Nozzle TIG101/301 #4	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80440202	Gas Nozzle TIG101/301 #5	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80440203	Gas Nozzle TIG101/301 #6	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80440204	Gas Nozzle TIG101/301 #7	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80440205	Gas Nozzle TIG101/301 #8	10
15b	80440221	Gas Nozzle long 48 mm #4L	10
	80440222	Gas Nozzle long 48 mm #5L	10
	80440223	Gas Nozzle long 48 mm #6L	10
15c	80440231	Gas Nozzle X-long 64 mm #4XL	10
	80440232	Gas Nozzle X-long 64 mm #5XL	10
	80440233	Gas Nozzle X-long 64 mm #6XL	10
19	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80361372	Tungsten electrodes. See page 38	10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80361374		10
	<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> 80361376		10
*	80300117	Std. wearing part set Ø1.6 TIG 101/301/321	1
	80300119	Std. wearing part set Ø2.4 TIG 101/301/321	1
<input type="checkbox"/>	81100228	Wearing part box TIG 101/301/321 1.6/2.4	1
<input type="checkbox"/>	81100248	Wearing part box TIG 101/301/321 2.4/3.2	1
	80300140	Wearing part set 1.6 gas TIG 101-301-321	1
	80300141	Wearing part set 2.4 gas TIG 101-301-321	1

The size of the gas nozzle (inside diameter), e.g. #4 = 4 x 1.6 mm = 6.4 mm.
 = Incl. in wearing part box/set.



Wear Parts for TIG Ergo Welding Torches

Wear parts for TIG Ergo 201/221/401



TIG 201 is typically used for production and on-site repairs in stainless steel and aluminium.

TIG 221 is typically used for production and heavy-duty welding in aluminium.

TIG 401 is designed for production and site repairs in stainless steel and aluminium in thick wall thicknesses, using up to 400 A DC.

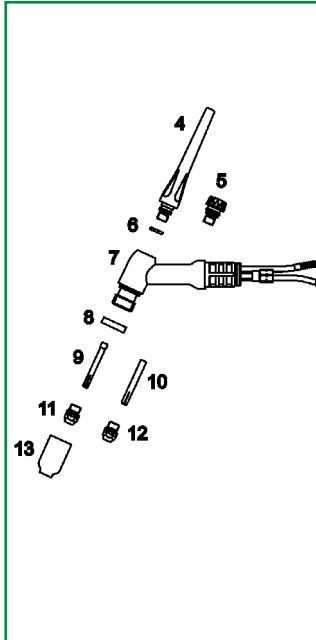
Position no.	Art. no.	Description	No of pcs.
4	<input type="checkbox"/> 80300201	Electrode cap long TIG201-401	10
5	<input type="checkbox"/> 80300200	Electrode cap short TIG 201-401	10
6	<input type="checkbox"/> 80300223	O-Ring for cap TIG201/401	1
7a	<input type="checkbox"/> 80300196	Torch body TIG 201 70 mm	1
	<input type="checkbox"/> 80300237	TIG 221 Torch body	1
7b	<input type="checkbox"/> 80400422	Torch body TIG 401 80 mm	1
8a	<input type="checkbox"/> 80300197	Torch body TIG 201F 70 mm	1
	<input type="checkbox"/> 80300198	Torch body TIG 201F 90 mm	1
	<input type="checkbox"/> 80300238	TIG 221F Torch body	1
8b	<input type="checkbox"/> 80400423	Torch body TIG 401F 80 mm	1
9	<input type="checkbox"/> 80300189	Insulator TIG 201-401	10
10	<input type="checkbox"/> 80330110	Electrode clamp Ø1.0 mm CuCr	10
	<input type="checkbox"/> 80330111	Electrode clamp Ø1.6 mm CuCr	10
	* <input type="checkbox"/> 80330112	Electrode clamp Ø2.4 mm CuCr	10
	<input type="checkbox"/> 80330113	Electrode clamp Ø3.2 mm CuCr	10
	<input type="checkbox"/> 80330114	Electrode clamp Ø4.0 mm CuCr	10
11	<input type="checkbox"/> 80310411	Gas lens 1.0 mm TIG 201-401	10
	<input type="checkbox"/> 80310412	Gas lens 1.6 mm TIG 201-401	10
	<input type="checkbox"/> 80310413	Gas lens 2.4 mm TIG 201-401	10
	<input type="checkbox"/> 80310414	Gas lens 3.2 mm TIG 201-401	10
	<input type="checkbox"/> 80310415	Gas lens 4.0 mm TIG 201-401	10
12	<input type="checkbox"/> 80340400	Nozzle for gas lense TIG 201/221/401/451 #4	10
	<input type="checkbox"/> 80340401	Nozzle for gas lense TIG 201/221/401/451 #5	10
	<input type="checkbox"/> 80340402	Nozzle for gas lense TIG 201/221/401/451 #6	10
	<input type="checkbox"/> 80340403	Nozzle for gas lense TIG 201/221/401/451 #7	10
	<input type="checkbox"/> 80340404	Nozzle for gas lense TIG 201/221/401/451 #8	10
	<input type="checkbox"/> 80340406	Nozzle for gas lense TIG 201/221/401/451 #11	10
13	<input type="checkbox"/> 80310004	Electrode holder Ø1.0 TIG201/401	10
	<input type="checkbox"/> 80310000	Electrode holder Ø1.6 TIG201/401	10
	* <input type="checkbox"/> 80310001	Electrode holder Ø2.4 TIG201/401	10
	<input type="checkbox"/> 80310002	Electrode holder Ø3.2 TIG201/401	10
	<input type="checkbox"/> 80310003	Electrode holder Ø4.0 TIG201/401	10
14	<input type="checkbox"/> 80340001	Gas Nozzle TIG201/401 #4	10
	<input type="checkbox"/> 80340002	Gas Nozzle TIG201/401 #5	10
	* <input type="checkbox"/> 80340003	Gas Nozzle TIG201/401 #6	10
	<input type="checkbox"/> 80340004	Gas Nozzle TIG201/401 #7	10
	<input type="checkbox"/> 80340005	Gas Nozzle TIG201/401 #8	10
	<input type="checkbox"/> 80340006	Gas Nozzle TIG201/401 #10	10
	<input type="checkbox"/> 80340007	Gas Nozzle TIG201/401 #12	10
15	<input type="checkbox"/> 80300220	Gas lens Insulator TIG201-401	10
19	<input type="checkbox"/> 80361372	Tungsten electrodes. See page 38	10
	* <input type="checkbox"/> 80361374	Tungsten electrodes. See page 38	10
	* <input type="checkbox"/> 80300118	Std. wearing part set Ø2.4 TIG 201/221/401	1
	<input type="checkbox"/> 80300274	Std. wearing part set Ø1.6 TIG 201/221/401	1
	<input type="checkbox"/> 81100230	Wearing part box TIG 201/221/401	1
	<input type="checkbox"/> 80300142	Wearing part set 1.6 gas TIG 201-401	1
	<input type="checkbox"/> 80300143	Wearing part set 2.4 gas TIG 201-401	1

The size of the gas nozzle (inside diameter), e.g. #4 = 4 x 1.6 mm = 6.4 mm.
 * Δ = Incl. in wearing part box/set.



Wear Parts for TIG Ergo Welding Torches

Wear parts for TIG Ergo 451



TIG 451 is the strongest model in our range of TIG welding torches. TIG 451 is water-cooled and designed for heavy-duty welding.

TIG 451 is typically used for high performance production and on-site repairs in stainless steel and aluminium in thick wall-thicknesses, using up to 400A DC welding current.

TIG 451 can be equipped with all wearing parts displayed to the right, and the control unit is easily replaced.

Position no.	Art. no.	Description	No of pcs.
4	80300201	Electrode cap long TIG201-401	10
5	80300200	Electrode cap short TIG 201-401	10
6	80300223	O-Ring for cap TIG201/401	1
7	80400425	Torch body TIG 451	1
8	□ Δ 80300239	Insulator TIG 451	10
9	80330110	Electrode clamp Ø1.0 mm CuCr	10
	80330111	Electrode clamp Ø1.6 mm CuCr	10
	* 80330112	Electrode clamp Ø2.4 mm CuCr	10
	Δ 80330113	Electrode clamp Ø3.2 mm CuCr	10
	80330114	Electrode clamp Ø4.0 mm CuCr	10
10	80330106	Collet HD TIG451 4,0 mm	10
	80330107	Collet HD TIG451 4,8 mm	10
11	*Δ 80310010	Collet body TIG451 1,0-3,2 mm	10
12	80310011	Collet body TIG451 3,2-4,8 mm	10
13	80340400	Nozzle for gas lense TIG 201/221/401/451 #4	10
	80340401	Nozzle for gas lense TIG 201/221/401/451 #5	10
	80340402	Nozzle for gas lense TIG 201/221/401/451 #6	10
	* 80340403	Nozzle for gas lense TIG 201/221/401/451 #7	10
	Δ 80340404	Nozzle for gas lense TIG 201/221/401/451 #8	10
	80340406	Nozzle for gas lense TIG 201/221/401/451 #11	10
18	* 80361374	Tungsten electrodes. See page 38	10
	Δ 80361376		10
	* 80300136	Std. wearing part set Ø2.4 TIG 451	1
	Δ 80300138	Std. wearing part set Ø3.2 TIG 451	1

The size of the gas nozzle (inside diameter), e.g. #4 = 4 x 1.6 mm = 6.4 mm.

** □ Δ = Incl. in wearing part box/set.*



TIG Adjust

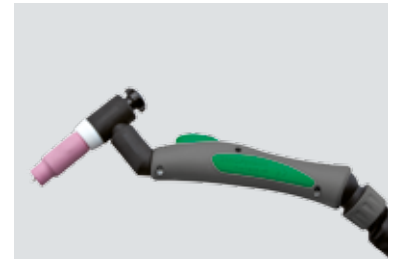
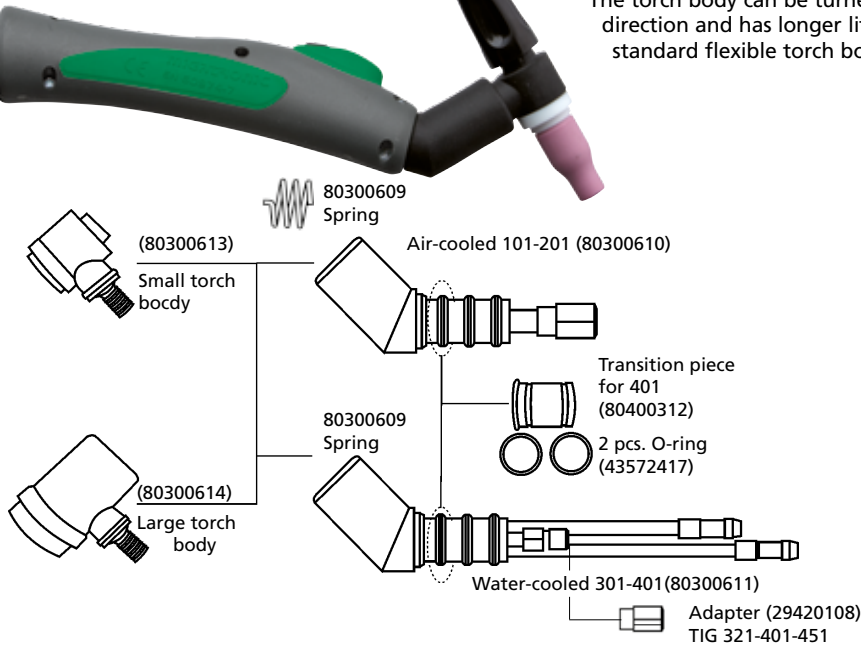
The TIG Adjust air-cooled or water-cooled torches allow you to weld in hard-to-reach places.

TIG Adjust provides full 360 degree-of-freedom

TIG Adjust is designed for welding operations requiring frequent adjustments of the torch body.

The torch body can be turned in any direction and has longer life than standard flexible torch bodies.

- Air-cooled or water-cooled models
- Torch bodies in two different sizes
- Small torch body: standard wear parts from the TIG 101-301 range
- Large torch body: standard wear parts from the TIG 201-401 range
- Supplied without wear parts as standard
- TIG Adjust suits the two different size torch handles of the TIG Ergo range, and all TIG Ergo control units are applicable.
- Available in all 4 m and 8 m TIG Ergo models and also in special lengths for regular orders.
- Can be ordered as a standard custom-built solution



	Variant	Article no.
TIG 101 Small torch body	TIG 101 Adjust 4 m*	80392705
	TIG 101 Adjust 8 m*	80392706
	TIG 101R Adjust 4 m*	80392700
	TIG 101R Adjust 8 m*	80392701
TIG 201 Large torch body	TIG 201 Adjust 4 m*	80392845
	TIG 201 Adjust 8 m*	80392846
	TIG 201R Adjust 4 m*	80392847
	TIG 201R Adjust 8 m*	80392848

	Variant	Article no.
TIG 301 Small torch body	TIG 301 Adjust 4 m*	80492190
	TIG 301 Adjust 8 m*	80492191
	TIG 301R Adjust 4 m*	80492185
	TIG 301R Adjust 8 m*	80492186
TIG 401 Large torch body	TIG 401 Adjust 4 m*	80492265
	TIG 401 Adjust 8 m*	80492266
	TIG 401R Adjust 4 m*	80492285
	TIG 401R Adjust 8 m*	80492286

Art. no.	TIG ADJUST RANGE
80392705	TIG 101 Ergo ADJUST 4m 7p
80392706	TIG 101 Ergo ADJUST 8m 7p
80392700	TIG 101RH Ergo ADJUST 4m 7p
80392701	TIG 101RH Ergo ADJUST 8m 7p
80392845	TIG 201 Ergo ADJUST 4m 7p
80392846	TIG 201 Ergo ADJUST 8m 7p
80392847	TIG 201RH Ergo ADJUST 4m 7p
80392848	TIG 201RH Ergo ADJUST 8m 7p
80492190	TIG 301 Ergo ADJUST 4m 7p
80492191	TIG 301 Ergo ADJUST 8m 7p
80492185	TIG 301RH Ergo ADJUST 4m 7P
80492186	TIG 301RH Ergo ADJUST 8m 7P
80492265	TIG 401 Ergo ADJUST 4m 7p
80492266	TIG 401 Ergo ADJUST 8m 7p
80492285	TIG 401RH Ergo ADJUST 4m 7p
80492286	TIG 401RH Ergo ADJUST 8m 7p

Art. no.	TIG ADJUST RANGE	No of pcs.
80300613	Small torch body	1
80300614	Large torch body	1
80300610	Body gascooled	1
80300611	Body watercooled	1
80300609	Spring TIG Adjust	1
80400312	Transition piece for 201HD-401	1
43572417	O-ring	1
29420108	Adaptor 1/4"UNF-3/8"24UNF left	1

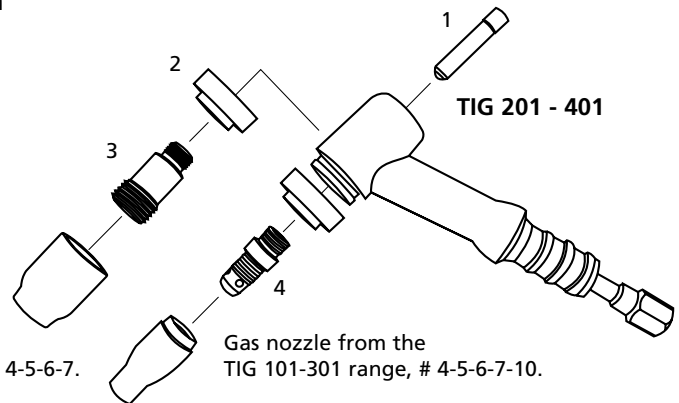
The products delivered may differ from the photos in the catalogue.



Special Parts for TIG 201/221/401

Special solution for TIG 201/221/401 "Stubby" system

Stubby parts are used for TIG 201 and TIG 401. Stubby parts reduce the height of the torch and provide better access to hard-to-reach locations.



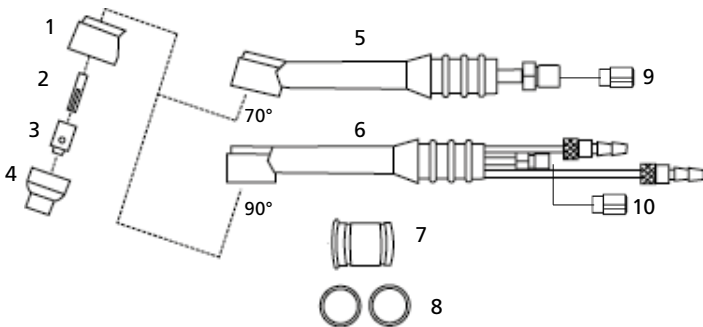
Gas nozzle from the TIG 101-301 range, # 4-5-6-7.

Gas nozzle from the TIG 101-301 range, # 4-5-6-7-10.

Pos. no.	Art. no.	System "Stubby"	No of pcs
1	80330030	Collet Ø1.0mm "Stubby"	10
	80330031	Collet Ø1.6mm "Stubby"	10
	80330032	Collet Ø2.4mm "Stubby"	10
	80330033	Collet Ø3.2mm "Stubby"	10
2	80300236	Insulator for gas lens "Stubby"	1
3	80310421	Gas lens 1.0mm "Stubby"	10
	80310422	Gas lens 1.6mm "Stubby"	10
	80310424	Gas lens 2.4mm "Stubby"	10
4	80310020	Electrodeholder "Stubby"	10
	80300286	Wearing parts set TIG Stubby ø1.6	1
	80300287	Wearing parts set TIG Stubby ø2.4	1
	80300288	Wearing parts set TIG Stubby ø1.6 gaslense	1
	80300289	Wearing parts set TIG Stubby ø2.4 gaslense	1

Special torch body WP24

The torch body fits in everywhere.



Pos. no.	Art. no.	WP24	No of pcs
1	80300225	Insulator	1
2	80330009	Electrode clamp 1.0mm	10
	80330010	Electrode clamp 1.6mm	10
	80330011	Electrode clamp 2.4mm	10
3	80310006	Electrode holder 1.0mm	10
	80310007	Electrode holder 1.6mm	10
	80310008	Electrode holder 2.4mm	10
4	80340024	Gas nozzle #4 Ø6.5mm	10
	80340025	Gas nozzle #5 Ø8.0mm	10
	80340026	Gas nozzle #6 Ø9.5mm	10
5	80300028	WP24G torch head body air 70°	1
6	80400309	WP24W torch head body water 90°	1
7	80400312	Transition piece for 201HD-401	1
8	43572417	O-ring	1
9	29420111	Socket 3/8"24UNF right W11X15	1
10	29420108	Adaptor 1/4"UNF-3/8"24UNF left	1
	80300284	Wearing parts set TIG WP24 ø1.6	1
	80300285	Wearing parts set TIG WP24 ø2.4	1
	81100238	Wear parts box TIG WP24/DSF225	1

The size of the gas nozzle (inside diameter), e.g. #4 = 4 x 1.6 mm = 6.4 mm.



Custom-built and Special Solutions

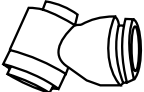
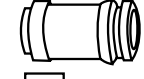
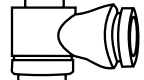
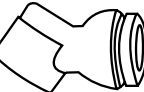


Special torch body/-head DSF 225 FLEX



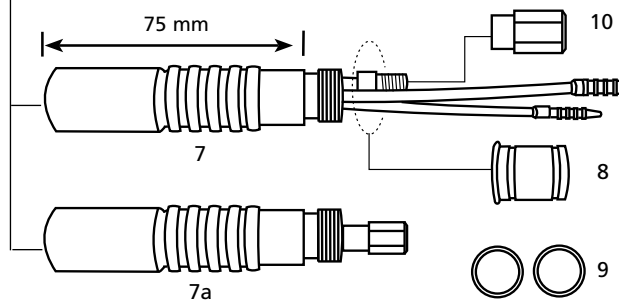
DSF 225 FLEX is a flexible water-cooled torch body with replaceable head.



TIG 201 DSF 225x3B #	4 m	7 pole	80392889
TIG 201 DSF 225x3B #	8 m	7 pole	80392890
TIG 301 DSF 225x3B #	4 m	7 pole	80492339
TIG 301 DSF 225x3B #	8 m	7 pole	80492340

- 1  70°
Small torch body # (*) 101/301
- 2  180°
Small torch body # (*) 101/301
- 3  90°
Small torch body (*) 101/301
- 4  70°
Small torch body # (**) WP24
- 5  70°
Large torch body (*) 201/401
- 6  180°
Large torch body (*) 201/401

Pos. nr.	Art. no.	DSF FLEX
	80392889	TIG Ergo 201 DSF 225x3B 4m 7p
	80392890	TIG Ergo 201 DSF 225x3B 8m 7p
	80492339	TIG Ergo 301 DSF 225x3B 4m 7p
	80492340	TIG Ergo 301 DSF 225x3B 8m 7p
1	80300016	Torch head small 70°
2	80300191	Torch head small straight
3	80300017	Torch head small 90°
4	80300226	Torch head small WP24 70°
5	80300187	Torch head big 70°
6	80300190	Torch head big 180°
7	80400307	FLEX torch body DSF 225
7a	80300249	FLEX torch body DSF 225 Air C
8	80400312	Transition piece for 201HD-401
9	80300301	O-ring Ø17.5x1.5mm
10	29420108	Adaptor 1/4" UNF-3/8" 24UNF left
11	81100228	Wearing part box TIG 101/301/321 1,6/2,4
	81100238	Wearing part box TIG WP24/DSF225
	81100230	Wearing part box TIG 201/221/401



(*) Small torch body = wear parts 101-301. Large torch body = wear parts 201-401. (**) wp 24 wear parts.



Wear Parts according to Individual Requirements

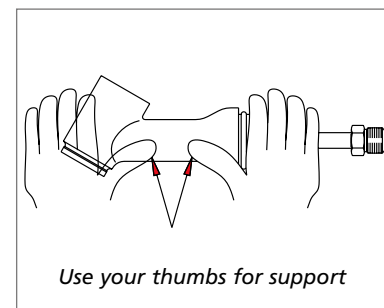
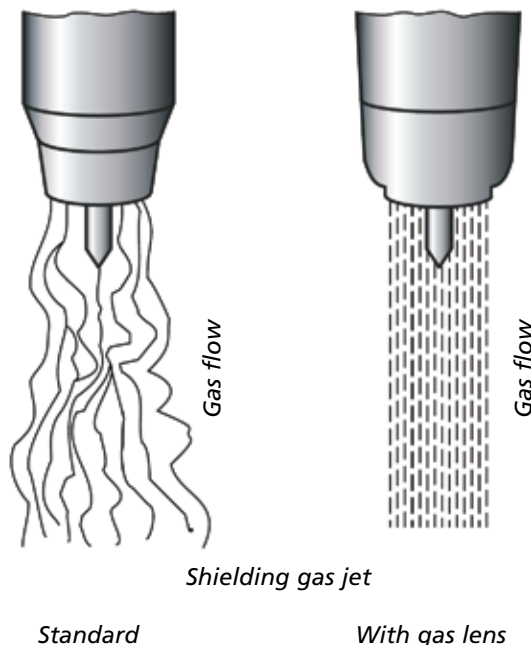
As standard, Migatronic TIG welding torches are supplied without wear parts. This allows you to equip your torches with wear parts as required. For list of wear parts for the individual models of TIG welding torches, please refer to previous pages.

If you choose **standard wear parts**, the TIG torch body will be equipped with electrode holder and electrode clamp as well as ceramic gas nozzle, the function of which is to guide the shielding gas towards the weld zone so as to displace the atmospheric air.

For better **precision and control** during TIG welding, we recommend gas lenses for the TIG torch body which give a very uniform flow of the shielding gas and allow a longer electrode stickout. Use of gas lens may also reduce the gas consumption.

TIG FLEX torch body
Migatronic TIG FLEX torch bodies are flexible and shapeable for difficult welding operations. If several shapings are required, we recommend a turnable TIG torch body. For custom-built and special solutions, please refer to page 32.

Shaping the torch body requires caution; the torch body must be cooled off and the maximum bending angle is 45°. Use your thumbs for support of the torch body as shown below.





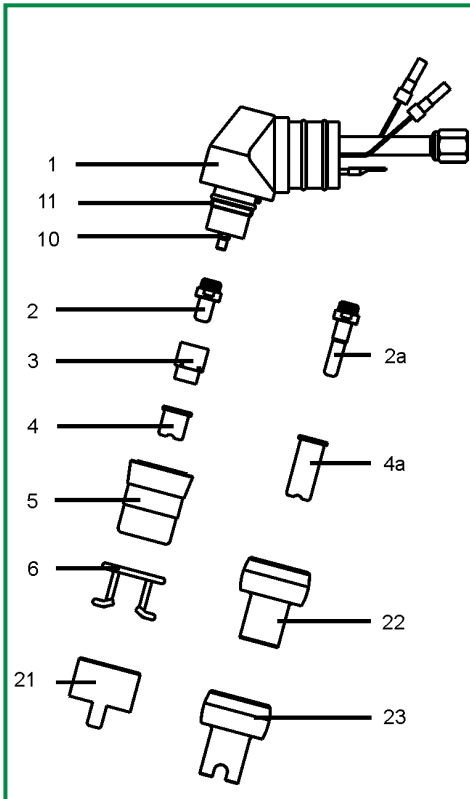
Plasma Cutting Torches



Plasma cutting torch for Zeta
60, 6 m hose
Art. no.....80690091

Wearing part box
Art. no.....81100233

Wear Parts for Plasma Cutting Handle



Pos. no.	Art. no.	Description	No of pcs.
Zeta 60			
1	80650007	Torch body	1
2	80610009*	Electrode	10
2a	80610010	Electrode, long	1
3	80640119*	Insulating ring	1
4	80630024	Cutting nozzle, short ø0.9	10
4	80630023	Cutting nozzle, short ø1.0	10
4	80630022*	Cutting nozzle, short ø1.1	10
4	80630021	Cutting nozzle, short ø1.2	10
4a	80630025	Cutting nozzle, long ø0.9	1
4a	80630026	Cutting nozzle, long ø1.0	1
4a	80630027	Cutting nozzle, long ø1.1	1
4a	80630028	Cutting nozzle, long ø1.2	1
5	80640112*	Protection cap	1
6	80600109*	Distance spring	1
10	80600116	Diffuser	1
11	80600115	O-ring	1
21	80600118	Distance ring (2 legs)	1
22	80600119	Distance ring ø12mm	1
23	80600120	Distance ring ø12mm (4 legs)	1
	81100233	Wearing part box	1



Plasma Cutting Torches



Plasma cutting torch for Zeta 100, 6 m hose
Art. no.....80690095

Plasma torch for Zeta 100, 10 m
Art. no.....80690097

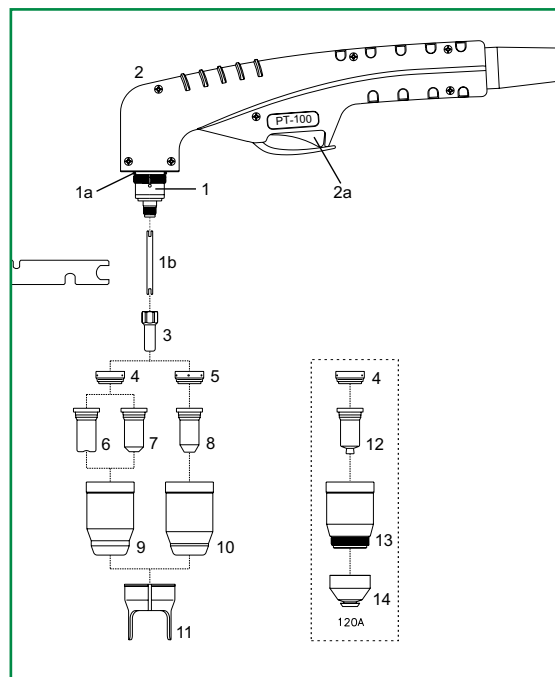
Plasma torch for Zeta 100, 15 m
Art. no.....80690098



Plasma cutting torch for Zeta 100, 6 m hose (automation)
Art. no.....80690096

Pos no.	Art. no.	Description	No of pcs.
1	80650010	Torch cutting head	1
1	80650011	Torch cutting head	1
1a	80600121	O-ring	1
1b	80600122	Cooling tube	1
2	80600130	Handle, incl. switch	1
2	80600132	Machine tube handle	1
2a	80600117	Switch	1
3*	80610011	Electrode	10
4	80600124	Gas diffuser 30-70A	1
5*	80600125	Gas diffuser 80-120A	1
6	80630204	Cutting nozzle, ø0.9	10
7.1	80630205	Cutting nozzle, ø1.0	10
7.2	80630206	Cutting nozzle, ø1.1	10
7.3	80630207	Cutting nozzle, ø1.2	10
8.1	80630208	Cutting nozzle, ø1.4	10
8.2*	80630209	Cutting nozzle, ø1.5	10
8.3	80630210	Cutting nozzle, ø1.6	10
9	80640113	Protection cap 30-70A	1
10*	80640114	Protection cap 80-120A	1
11*	80600126	Distance ring (2 legs)	1
12	80630211	Gouging tip	1
13	80640115	Protection cap	1
14	80640116	Protection cap, gouging	1
	81100239	Wearing part box	1

* = Pre-assembled as standard



Wearing part box
Art. no.....81100239



Plasma Welding Torches

Art. no.	PWM-4A / PWM-300	Comments
84022578	PWM-4A1 180° w/o hose	
84022847	PWM-300 180° w/o hose	
80922100	Hose PWM-4A/PWM300 1,0 m	
80922150	Hose PWM-4A/PWM300 1,5 m	
80922200	Hose PWM-4A/PWM300 2,0 m	
80922250	Hose PWM-4A/PWM300 2,5 m	
80922300	Hose PWM-4A/PWM300 3,0 m	
80922350	Hose PWM-4A/PWM300 3,5 m	
80922400	Hose PWM-4A/PWM300 4,0 m	
80922450	Hose PWM-4A/PWM300 4,5 m	
80922500	Hose PWM-4A/PWM300 5,0 m	
80922550	Hose PWM-4A/PWM300 5,5 m	
80922600	Hose PWM-4A/PWM300 6,0 m	
80922650	Hose PWM-4A/PWM300 6,5 m	
80922700	Hose PWM-4A/PWM300 7,0 m	
80922750	Hose PWM-4A/PWM300 7,5 m	
80922800	Hose PWM-4A/PWM300 8,0 m	
73800001	Assembly box for Plasma hoses	For Plasma welding with hoses longer than 8m
74330800	Extension hose PMW4A/300 8.0 m	



Assembly box for Plasma hoses
Art. no.....73800001



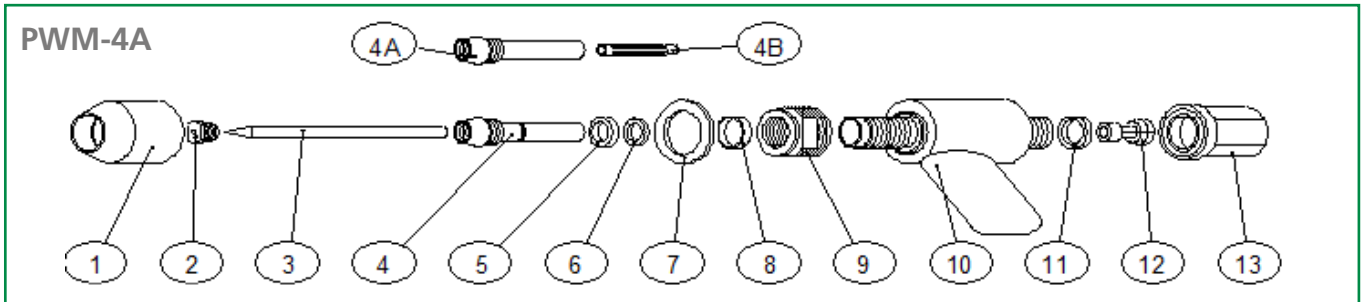
Extension hose PMW4A/300 8.0 m
Art. no.....74330800



Hose PWM-4A/PWM300
Art. no.....80922100 - 80922800

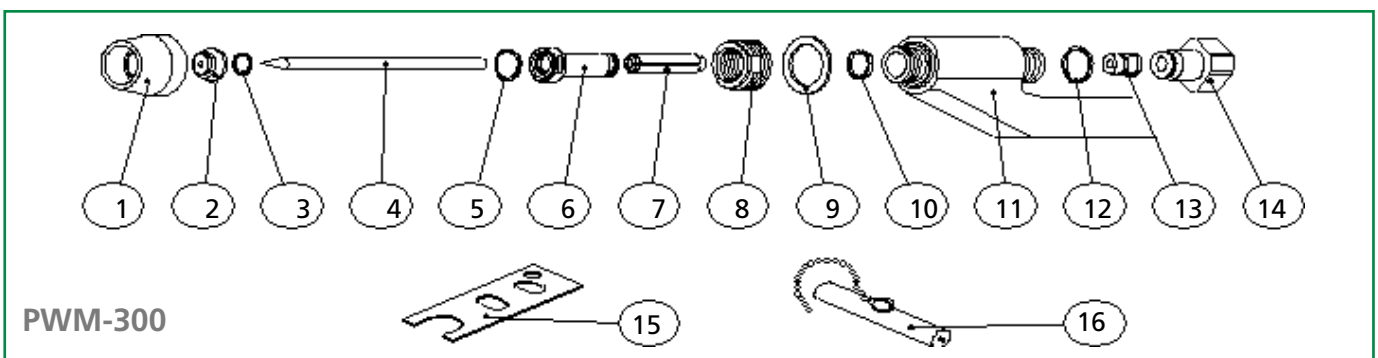


Wear Parts for Plasma Welding Torches



Position no.	Art. no.	PWM-4A
1	84084064	Ceramic nozzle std. f/4A
2	84091847	Nozzle std. 1.58 100A f/4A
	84091848	Nozzle std. 2.37 180A f/4A
	84091849	Nozzle std. 3.18 220A f/4A
	84091889	Weld.tip 40A long
	84091890	Weld.tip 90A long
	84091891	Weld.tip 150A long
	84091892	Weld.tip 190A long
3	84091827	Electrode std. f/PWM-4A & 300
	84091834	Electrode long f/4A
4	84084012	Gas guidance & distributor 4A
4A	84084011	Gas guide f/4A
4B	84092204	Gasdistributor white f/PWM-4A
5	84080560	O-ring f/4A (red)
6	84080528	O-ring f/4A & 6A
7	84084069	Washer f/ceramic nozzle 4A
8	84084024	Collar f/4A
9	84084040	Gas lens f/4A
10	84084014	Torch body PWH-4A 70°
	84084054	Torch body PWM-4A1
11	84080530	O-ring f/4A
12	84091876	Electrode tong f/PWM-4A
13	84084158	Electrode cap f/4A
	84091877	Back cup PWM-4A long
14	84091873	Adjusting device f/4A & 6A

Position no.	Art. no.	PWM-300
1	84086542	Ceramic nozzle f/PWM-300 & 6A
2	84086575	Nozzle 2.36 200A f/300
	84086582	Nozzle 2.87 250A f/300
	84086572	Nozzle 3.18 300A f/300
	84084370	Nozzle 200AMP-LG PWM-300
	84084371	Nozzle 250AMP-LG PWM-300
	84084372	Nozzle 300 AMP-LG PWM-300
3	84092863	O-ring PWM-6A
4	84091827	Electrode std. f/PWM-4A & 300
5	84092956	O-ring PWM-6A
6	84086509	Gas guide f/6A & 300
7	84086651	Gas distributor white f/300
8	84086541	Adaptor f/ceramic nozzle 6A
9	84086512	Washer f/6A
10	84080531	O-ring 25 x 015 f/6A
11	84086649	Torch body PWM-300
12	84083487	O-ring f/6A & PWM-300
13	84086650	Elektrode tong f/PWM-300
14	84086654	Electrode cap f/300
15	84086517	Key f/nozzle PWM-300
16	84086653	Adjusting device f/PWM-300





Tungsten Electrodes

Migatronic's range of high-quality tungsten electrodes is developed in co-operation with Europe's leading manufacturer of tungsten electrodes.

- No risk of radioactive radiation of users and environment
- Pointed electrode tip and stable arc after long service life
- Excellent ignition and reignition properties
- Improved welding quality and welding safety

Here you can see the difference between arcs ignited with high-quality and low-quality tungsten electrodes respectively.



High-quality tungsten



Low-quality tungsten: typically sideways arc ignition, the arc flashes and wanders slowly to the electrode tip which has to be cut off and reground.

Art. no.	Description	No of pcs.
80360022	Tungsten electrode WP Ø1.6 green	10
80360024	Tungsten electrode WP Ø2.4 green	10
80360026	Tungsten electrode WP Ø3.2 green	10
80360042	Tungsten electrode WL10 Ø1.6 black	10
80360043	Tungsten electrode WL10 Ø2.4 black	10
80360044	Tungsten electrode WL10 Ø3.2 black	10
80360092	Tungsten electrode WL20 Ø1.6 blue	10
80360094	Tungsten electrode WL20 Ø2.4 blue	10
80360095	Tungsten electrode WL20 Ø3.2 blue	10
80361371	Tungsten electrode WS2 Ø1.0 superblue	10
80361372	Tungsten electrode WS2 Ø1.6 superblue	10
80361373	Tungsten electrode WS2 Ø2.0 superblue	10
80361374	Tungsten electrode WS2 Ø2.4 superblue	10
80361376	Tungsten electrode WS2 Ø3.2 superblue	10
80361377	Tungsten electrode WS2 Ø4.0 superblue	10
80361378	Tungsten electrode WS2 Ø4.8 superblue	10





Wear Parts in Retail Blister Packs

Standard MigatroniC wear parts are also available in blister packs that are ready to hang on wall displays.

Blister packs are intended for customers requiring small quantity purchases.

Clear labeling with barcode, item text and item number makes re-ordering easy.

Please contact MigatroniC for more information.



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