

# Guns and torches

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**Designed for comfortable and productive welding.**

Many welding tasks carry exceptional responsibility for the business and craftsman completing the work. So whether you're welding ship hulls or pleasure boats, rail cars or racing cars, you can trust Kemppi welding guns and torches to deliver value to every weld.





## MIG/MAG welding gun range

### Designed for **comfortable and productive welding**

**The best combination of weight and balance ensures welding craftsmen comfortably deliver their skill weld after weld. Choose from a wide range of Euro connected MIG/MAG welding guns in a variety of lengths from 3 to 8 meters.**

**FE guns** are specifically designed for regular fabrication tasks using ferrous filler wires and are available from 3.5 to 5 meters in length.

**MMT guns** are suitable for use across a wide range of materials and tasks, and they are available in both air and water cooled models from 3 to 4.5 meters in length.

**PMT guns** suit a variety of professional applications and include both air and water cooled models. PMT-MN models are air cooled only and designed specifically for root pass welding. **MN stands for Multi-Neck**, a 'fast change' gun neck system, allowing one of three neck variants to be selected and fitted to the gun handle in seconds. All PMT models accept the RMT10 remote control device, and when connected with compatible Kemppi MIG/MAG equipment, provides 'real time' selection of welding power or memory channels during welding.

**WS guns** offer extended reach and distance for stainless steel and aluminium welding and are available in both air and water cooled models from 6 to 8 meters in length. WS guns use a patented DL liner material that reduces friction loss and makes distance wire feeding possible.

## Technical specifications and ordering information

| FE                                  |       | FE 20     | FE 25     | FE 27     | FE 32     | FE 35     | FE 42     |
|-------------------------------------|-------|-----------|-----------|-----------|-----------|-----------|-----------|
| Load capacity, Ar + CO <sub>2</sub> | 35 %  | 200A      | 250 A     | 270 A     | 320 A     | 350 A     | 420 A     |
| Cooling                             |       | Air       | Air       | Air       | Air       | Air       | Air       |
| Filler wires                        | ø mm  | 0.6...1.2 | 0.6...1.2 | 0.6...1.2 | 0.8...1.6 | 0.8...1.6 | 0.8...1.6 |
| Length /                            | 3.5 m | 6602003   | 6602503   | 6602703   | 6603203   | 6603503   | 6604203   |
| Ordering code                       | 5 m   | 6602004   | 6602504   | 6602704   | 6603204   | 6603504   | 6604204   |

| MMT                                 |       | MMT 25     | MMT 27     | MMT 32     | MMT 35     | MMT 42     | MMT 42C   | MMT 30W    | MMT 42W    | MMT 52W    |
|-------------------------------------|-------|------------|------------|------------|------------|------------|-----------|------------|------------|------------|
| Load capacity, Ar + CO <sub>2</sub> | 35 %  | 250 A      | 270 A      | 320 A      | 350 A      | 420 A      | -         | -          | -          | -          |
|                                     | 100 % | -          | -          | -          | -          | -          | 350 A     | 300 A      | 400 A      | 500 A      |
| Cooling                             |       | Air        | Air        | Air        | Air        | Air        | Air       | Water      | Water      | Water      |
| Filler wires                        | ø mm  | 0.6...1.2  | 0.6...1.2  | 0.8...1.6  | 0.8...1.6  | 0.8...1.6  | 0.8...1.6 | 0.8...1.6  | 0.8...1.6  | 0.8...1.6  |
| Length /                            | 3 m   | 6252513MMT | 6252713MMT | 6253213MMT | 6253513MMT | 6254213MMT | 6254205   | 6253043MMT | 6254203MMT | 6255203MMT |
| Ordering code                       | 4.5 m | 6252514MMT | 6252714MMT | 6253214MMT | 6253514MMT | 6254214MMT | 6254207   | 6253044MMT | 6254204MMT | 6255204MMT |

| PMT                                 |       | PMT 25    | PMT 27    | PMT 32    | PMT 35    | PMT 42    | PMT 30W   | PMT 42W   | PMT 52W   |
|-------------------------------------|-------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Load capacity, Ar + CO <sub>2</sub> | 35 %  | 250 A     | 270 A     | 320 A     | 350 A     | 420 A     |           |           |           |
|                                     | 100 % |           |           |           |           |           | 300 A     | 400 A     | 500 A     |
| Cooling                             |       | Air       | Air       | Air       | Air       | Air       | Water     | Water     | Water     |
| Filler wires                        | ø mm  | 0.6...1.2 | 0.6...1.2 | 0.8...1.6 | 0.8...1.6 | 0.8...1.6 | 0.8...1.6 | 0.8...1.6 | 0.8...1.6 |
| Length /                            | 3 m   | 6252513   | 6252713   | 6253213   | 6253513   | 6254213   | 6253043   | 6254203   | 6255203   |
| Ordering code                       | 4.5 m | 6252514   | 6252714   | 6253214   | 6253514   | 6254214   | 6253044   | 6254204   | 6255204   |

The gun's standard delivery has welding set for steel wire.

| PMT MN       | 3.5 m, ø 1.0 mm |                   | 3.5 m, ø 1.2 mm |                 | 5 m, ø 1.0 mm |                   | 5 m, ø 1.2 mm |                 |
|--------------|-----------------|-------------------|-----------------|-----------------|---------------|-------------------|---------------|-----------------|
| Filler wires | Ordering code   | Neck              | Ordering code   | Neck            | Ordering code | Neck              | Ordering code | Neck            |
| 0.8...1.6    | 62503230N01     | Fe, 45°, L222     | 62503230N02     | Fe, 45°/222     | 62503250N01   | Fe, 45°, L222     | 62503250N02   | Fe, 45°/222     |
| 0.8...1.6    | 62503230N01SS   | Ss, 45°, L222     | 62503230N02SS   | Ss, 45°/222     | 62503250N01SS | Ss, 45°, L222     | 62503250N02SS | Ss, 45°/222     |
| 0.6...1.2    | 62503230N05     | Fe, L168, RP      | 62503230N06     | Fe, 60°/168, RP | 62503250N05   | Fe, 60°, L168, RP | 62503250N06   | Fe, 60°/168, RP |
| 0.6...1.2    | 62503230N07     | Fe, 60°, L198     | 62503230N08     | Fe, 60°/198     | 62503250N07   | Fe, 60°, L198     | 62503250N08   | Fe, 60°/198     |
| 0.6...1.2    | 62503230N09     | Fe, 60°, L168     | 62503230N10     | Fe, 60°/168     | 62503250N09   | Fe, 60°, L168     | 62503250N10   | Fe, 60°/168     |
| 0.6...1.2    | 62503230N03     | Fe, L198, RP      | 62503230N04     | Fe, 60°/198, RP | 62503250N03   | Fe, 60°, L198, RP | 62503250N04   | Fe, 60°/198, RP |
| 0.6...1.2    | 62503230N03SS   | Ss, 60°, L198, RP | 62503230N04SS   | Ss, 60°/198, RP | 62503250N03SS | Ss, 60°, L198, RP | 62503250N04SS | Ss, 60°/198, RP |
| 0.6...1.2    | 62503230N05SS   | Ss, 60°, L168, RP | 62503230N06SS   | Ss, 60°/168, RP | 62503250N05SS | Ss, 60°, L168, RP | 62503250N06SS | Ss, 60°/168, RP |
| 0.6...1.2    | 62503230N07SS   | Ss, 60°, L198     | 62503230N08SS   | Ss, 60°/198     | 62503250N07SS | Ss, 60°, L198     | 62503250N08SS | Ss, 60°/198     |
| 0.6...1.2    | 62503230N09SS   | Ss, 60°, L168     | 62503230N10SS   | Ss, 60°/168     | 62503250N09SS | Ss, 60°, L168     | 62503250N10SS | Ss, 60°/168     |

RP= Root pass, Ss models with Chili liner, Fe models with spiral liner. All packages air-cooled, load capacity 320 A @ 35% A (Ar + CO<sub>2</sub>)

| WS                                                                                  |             | WS35       | WS30W       | WS42W       | MMG                                                          | MMG 20                | MMG 22       |
|-------------------------------------------------------------------------------------|-------------|------------|-------------|-------------|--------------------------------------------------------------|-----------------------|--------------|
| Load capacity, Ar + CO <sub>2</sub>                                                 |             | 300 A/35 % | 250 A/100 % | 300 A/100 % |                                                              | 200 A (35 %)          | 200 A (35 %) |
| Cooling                                                                             |             | Air        | Water       | Water       |                                                              | Air                   | Air          |
| Filler wires                                                                        | Ss          | 1.0        | 1.0...1.2   | 1.0...1.2   | Fe                                                           | 0.6...1.0             | 0.6...1.0    |
| ø mm                                                                                | Al          | 1.2        | 1.2 (1.6)   | 1.2 (1.6)   | Ss, Al                                                       | 0.8...1.0             | 0.8...1.0    |
| Ordering codes                                                                      | 6 m, Al 1.2 | 6253516A12 | 6253046A12  | 6254206A12  | 3 m                                                          | 6250200               | 6250200      |
|                                                                                     | 6 m Ss 1.0  | 6253516S10 | 6253046S10  | 6254206S10  | MMG 20 and MMG 22 guns are used only in MinarcMig equipment. |                       |              |
|                                                                                     | 6 m Ss 1.2  | -          | 6253046S12  | 6254206S12  |                                                              |                       |              |
|                                                                                     | 8 m, Al 1.2 | -          | 6253048A12  | 6254208A12  | Wire liners:                                                 |                       |              |
|                                                                                     | 8 m Ss 1.0  | -          | 6253048S10  | 6254208S10  |                                                              |                       |              |
|                                                                                     | 8 m Ss 1.2  | -          | 6253048S12  | 6254208S12  |                                                              |                       |              |
| The ordering number comprises the gun, the DL Teflon wire liner and 5 contact tips. |             |            |             |             | MMG 22                                                       | 0.6...1.0 mm (Fe)     | 4307650      |
|                                                                                     |             |            |             |             |                                                              | 0.8...1.0 mm (Ss, Al) | 4307660      |

# Consumable and replacement parts

Kemppi consumable and replacement parts are specifically designed for their application and manufactured under the ISO quality system. Please ensure that you always select and replace damaged or worn gun parts with original Kemppi equipment. All parts listed suit the model specifications at the time of publication.

## Wire liners

Kemppi gun liners are strong, durable and efficient. Designed to suit specific filler wire materials and applications, Kemppi liners support the filler wire and ensure reliable delivery to the welding arc. The liner selection tables describe gun type, filler material, liner colour, item code and gun length. Steel spiral liners carry the same colour coding as Kemppi machine feed rolls and drive rolls, making wire size, liner and drive roll matching easier if the gun is connected to Kemppi equipment. Steel spiral liners are suitable for welding solid and cored filler wires of corresponding wire diameter.

Kemppi DL Chili -Teflon liners are the latest solution for reliable feeding of aluminium, stainless steel, acid-resistant and solid steel filler wires. Kemppi's patented technology, two layer DL Chili liner material significantly reduces friction losses between the filler wire material and liner wall, ensuring reliable and worry-free feeding for listed wires types, even in guns up to 8 meters in length. Please refer to the following tables to ensure accurate selection of liners for your chosen welding gun and application.

### Wire liners for FE guns

| Steel/<br>cored wire                | Filler wire<br>ø, mm | Order<br>number,<br>3.5 m | Order<br>number,<br>5 m |
|-------------------------------------|----------------------|---------------------------|-------------------------|
|                                     | 0.6...0.8            | 4188573                   | 4188576                 |
|                                     | 0.9...1.2            | W006453                   | W006454                 |
|                                     | 1.4...1.6            | W006455                   | W006456                 |
| Steel/Aluminium/<br>Stainless steel | Filler wire<br>ø, mm | Order<br>number,<br>3.5 m | Order<br>number,<br>5 m |
| DL Chili 4.7/1.5                    | 0.6...1.0            | W007675                   | W007676                 |
| DL Chili 4.7/2.0                    | 1.0...1.2            | W007677                   | W007680                 |
| DL Chili 4.7/2.5                    | 1.2...1.6            | W007681                   | W007683                 |

### Wire liners for WeldSnake

| Steel/Aluminium/<br>Stainless steel | Filler wire<br>ø, mm | Order<br>number,<br>6 m | Order<br>number,<br>8 m |
|-------------------------------------|----------------------|-------------------------|-------------------------|
| DL Chili 5.9/1.5                    | 0.6...1.0            | W005943                 | W005946                 |
| DL Chili 5.9/2.0                    | 1.0...1.2            | W005944                 | W005947                 |
| DL Chili 5.9/2.5                    | 1.2...1.6            | W005945                 | W005948                 |
| Aluminium                           |                      |                         |                         |
| DL Chili 5.9/3.0                    | 1.6                  | W007672                 | W007958                 |

### Wire liner system for automation

| Steel spiral liner (min. 10 m)        | W005195 |
|---------------------------------------|---------|
| Liner connector (2 needed)            | W005197 |
| DT 400/400L/410 connector             | W005188 |
| DT 400/400L/410 adapter               | W005174 |
| Wire spool / drum connector, isolated | W005189 |

### Wire liners for MMT, PMT guns

| Steel/<br>cored wire                | Filler wire<br>ø, mm | Order<br>number,<br>3 m | Order<br>number,<br>4.5 m |
|-------------------------------------|----------------------|-------------------------|---------------------------|
|                                     | 0.6...0.8            | 4188571                 | 4188572                   |
|                                     | 0.9...1.2            | 4188581                 | 4188582                   |
|                                     | 1.4...1.6 (1.2)      | 4188591                 | 4188592                   |
|                                     | 1.6...2.0            | 4188601                 | 4188602                   |
|                                     | 2.0...2.4            | 4188611                 | 4188612                   |
|                                     | 2.8...3.2            | 4188621                 | 4188622                   |
| Steel/Aluminium/<br>Stainless steel | Filler wire<br>ø, mm | Order<br>number,<br>3 m | Order<br>number,<br>4.5 m |
| DL Chili 5.9/1.5                    | 0.6...1.0            | W005920                 | W005937                   |
| DL Chili 5.9/2.0                    | 1.0...1.2            | W005921                 | W005938                   |
| DL Chili 5.9/2.5                    | 1.2...1.6            | W005922                 | W005939                   |
| Aluminium                           |                      |                         |                           |
| DL Chili 5.9/3.0                    | 1.6                  | W007671                 | W007957                   |

### Wire liners for PMT MN guns

| Steel/<br>cored wire                | Filler wire<br>ø, mm | Order<br>number,<br>3.5 m | Order<br>number,<br>5 m |
|-------------------------------------|----------------------|---------------------------|-------------------------|
|                                     | 0.9...1.2            | W007968                   | W007969                 |
|                                     | 1.4...1.6            | W007970                   | W007971                 |
| Steel/Aluminium/<br>Stainless steel | Filler wire<br>ø, mm | Order<br>number,<br>3.5 m | Order<br>number,<br>5 m |
| DL Chili 5.9/1.5                    | 0.6...1.0            | W007959                   | W007960                 |
| DL Chili 5.9/2.0                    | 1.0...1.2            | W007961                   | W007962                 |
| DL Chili 5.9/2.5                    | 1.2...1.6            | W007963                   | W007964                 |

# Contact tips

When you replace the contact tip, always check the label on the tip to make sure that the part is suitable for the filler wire. As a general rule, the contact tip hole must be 0.2–0.5 mm greater than the filler wire diameter.

## Standard contact tips M8 (DHP) for solid mild steel and flux-cored wire

Marking: Kemppi 1.2



| Wire ø | Hole ø | Tolerance   | Order number |
|--------|--------|-------------|--------------|
| 0.8    | 0.9    | +0.1/-0.0   | 9580122      |
| 0.9    | 1.05   | +0.05/-0.02 | 9580121      |
| 1.0    | 1.15   | +0.05/-0.02 | 9580123      |
| 1.2    | 1.4    | +0.05/-0.05 | 9580124      |
| 1.4    | 1.6    | +0.05/-0.05 | 9580125      |
| 1.6    | 1.8    | +0.1/-0.0   | 9580126      |
| 2.0    | 2.3    | +0.0/-0.1   | 9580127      |
| 2.4    | 2.7    | +0.05/-0.05 | 9580128      |
| 2.8    | 3.1    | +0.1/-0.0   | 9580129      |
| 3.2    | 3.6    | +0.05/-0.05 | 9580130      |

## Contact tips M8 (DHP) for Aluminium wire

Marking: Kemppi 1.2 A

|     |      |             |          |
|-----|------|-------------|----------|
| 0.8 | 1.05 | +0.05/-0.02 | 9580122A |
| 0.9 | 1.15 | +0.05/-0.02 | 9580121A |
| 1.0 | 1.4  | +0.05/-0.05 | 9580123A |
| 1.2 | 1.6  | +0.05/-0.05 | 9580124A |
| 1.4 | 1.8  | +0.10/-0.00 | 9580125A |
| 1.6 | 2.0  | +0.00/-0.10 | 9580126A |

## Contact tips M8 (CuAg) for Fe and flux cored wire

Marking: Kemppi 1.2 Ag

|     |      |             |           |
|-----|------|-------------|-----------|
| 1.0 | 1.15 | +0.05/-0.02 | 9580123AG |
| 1.2 | 1.4  | +0.05/-0.05 | 9580124AG |

## Contact tips M8 (CuCrZr) for solid mild steel and flux cored wire

Marking: Kemppi 1.2 CRZR

|     |      |             |           |
|-----|------|-------------|-----------|
| 1.0 | 1.15 | +0.05/-0.02 | 9580123ZR |
| 1.2 | 1.4  | +0.05/-0.05 | 9580124ZR |
| 1.4 | 1.6  | +0.05/-0.05 | 9580125ZR |

## Contact tips M8 (DHP) for stainless and high acid-resistant steel

Marking: Kemppi 1.2 SS

|     |      |             |           |
|-----|------|-------------|-----------|
| 0.8 | 1.15 | +0.05/-0.02 | 9580122SS |
| 0.9 | 1.4  | +0.05/-0.05 | 9580121SS |
| 1.0 | 1.6  | +0.05/-0.05 | 9580123SS |
| 1.2 | 1.8  | +0.10/-0.00 | 9580124SS |
| 1.6 | 2.3  | +0.00/-0.10 | 9580126SS |

## Contact tips M8 (LIFE+ material) for solid mild steel and flux cored wire

Marking: Kemppi 1.2 LIFE+



|     |      |             |         |
|-----|------|-------------|---------|
| 0.8 | 0.9  | +0.1/-0.0   | W007919 |
| 0.9 | 1.05 | +0.05/-0.05 | W007920 |
| 1.0 | 1.15 | +0.05/-0.05 | W006826 |
| 1.2 | 1.4  | +0.05/-0.05 | W006518 |
| 1.6 | 1.8  | +0.1/-0.0   | W007921 |

## Standard contact tips M6 (DHP) for solid mild steel and flux cored wire

Marking: Kemppi 1.2

|     |      |             |         |
|-----|------|-------------|---------|
| 0.6 | 0.8  | +0.05/-0.02 | 9876634 |
| 0.8 | 0.95 | +0.05/-0.02 | 9876635 |
| 0.9 | 1.05 | +0.05/-0.02 | 9876633 |
| 1.0 | 1.15 | +0.05/-0.02 | 9876636 |
| 1.2 | 1.37 | +0.05/-0.02 | 9876637 |
| 1.6 | 1.8  | +0.05/-0.02 | 9876639 |

## Contact tips M6 (CuCrZr) for solid mild steel and flux cored wire

Marking: Kemppi 0.8 CrZr

|     |      |             |           |
|-----|------|-------------|-----------|
| 0.8 | 0.95 | +0.05/-0.02 | 9876635ZR |
|-----|------|-------------|-----------|

## Contact tips M6 ROOT (DHP) for solid mild steel and flux cored wire

Marking: Kemppi 1.2



|     |      |             |         |
|-----|------|-------------|---------|
| 0.8 | 0.95 | +0.05/-0.02 | 9876647 |
| 0.9 | 1.05 | +0.05/-0.02 | 9876648 |
| 1.0 | 1.15 | +0.05/-0.02 | 9876649 |
| 1.2 | 1.37 | +0.05/-0.02 | 9876650 |

# Consumable parts for wire feed mechanisms

## Wire guide tubes for 2-roll wire feed mechanism SL250

| Wire ø mm  |           | Wire guide tube ø mm |     |         |         |               |                 |
|------------|-----------|----------------------|-----|---------|---------|---------------|-----------------|
| Fe, Mc, Fc | 0.6...0.8 |                      | 1.0 | 3134140 | } brass | 4285900 → 1.8 | plastic 4102283 |
|            | 0.9...1.6 |                      | 2.0 | 3133700 |         |               |                 |
| Ss, Al     | 0.8...1.6 |                      | 2.5 | 3134290 |         |               |                 |



## Wire guide tubes for 4-roll wire feed mechanism SL500

| Wire ø mm  |           | Wire guide tube ø mm |     |         |           |     |         |
|------------|-----------|----------------------|-----|---------|-----------|-----|---------|
| Fe, Mc, Fc | 0.6...0.8 |                      | 1.0 | 3134140 | } plastic | 2.0 | 4267220 |
|            |           |                      | 2.0 | 3134120 |           | 2.0 | 4266970 |
|            | 0.9...1.6 |                      | 2.0 | 3133700 | } plastic | 4.0 | 4270180 |
|            | 1.6...2.4 |                      | 4.0 | 3134130 |           | 4.0 | 4267030 |
| Ss, Al     | 0.8...1.6 |                      | 2.5 | 3134290 | } plastic | 2.0 | 4267220 |
|            | 1.6...2.4 |                      | 3.0 | 3134710 |           | 4.0 | 4270180 |



| Feed rolls                             |  | 2-roll      |         | 4-roll      |         |
|----------------------------------------|--|-------------|---------|-------------|---------|
|                                        |  | ø mm        |         | ø mm        |         |
| Fe, Ss, Al<br>V-groove, plain          |  | 0.6/0.8     | 3133810 | 0.6/0.8     | 3133810 |
|                                        |  | 0.8/0.8 (L) | 3143180 | 0.8/0.8 (L) | 3143180 |
|                                        |  | 1.0/1.2     | 3133210 | 1.0/1.2     | 3133210 |
|                                        |  | 1.0/1.0 (L) | 3138650 | 1.0/1.0 (L) | 3138650 |
|                                        |  | 1.2/1.2 (L) | 3137390 | 1.2/1.2 (L) | 3137390 |
|                                        |  | 1.4-1.6     | 3133820 | 1.4-1.6/2.0 | 3133820 |
|                                        |  | 1.6/1.6 (L) | 3141120 | 1.6/1.6 (L) | 3141120 |
|                                        |  |             |         | 2.4         | 3133880 |
|                                        |  |             |         | 3.2         | 3133910 |
| Fe, Fc, Mc<br>V-groove, knurled        |  | 1.0/1.2     | 3133940 | 1.0/1.2     | 3133940 |
|                                        |  | 1.2/1.2 (L) | 3137380 | 1.2/1.2 (L) | 3137380 |
|                                        |  | 1.4-1.6     | 3133990 | 1.4-1.6/2.0 | 3133990 |
|                                        |  | 1.6/1.6 (L) | 3141130 | 1.6/1.6 (L) | 3141130 |
|                                        |  |             |         | 2.4         | 3134030 |
|                                        |  |             |         | 3.2         | 3134060 |
| Al<br>U-groove                         |  | 1.0/1.2     | 3133960 | 1.0/1.2     | 3133960 |
|                                        |  | 1.2/1.6     | 3141590 | 1.2/1.6     | 3141590 |
| Fe, Fc, Mc, Ss, Al<br>Trapezoid groove |  | 1.2/1.2 (L) | 3142210 | 1.2/1.2 (L) | 3142210 |
|                                        |  | 1.4/1.4 (L) | 3142220 | 1.4/1.4 (L) | 3142220 |
|                                        |  | 1.6/1.6 (L) | 3142200 | 1.6/1.6 (L) | 3142200 |
|                                        |  |             |         | 2.0/2.0 (L) | 3142230 |
|                                        |  |             |         | 2.4 (L)     | 3142240 |

(L) = Fitted with ball bearings

## Gear wheel, 2-roll wire feed mechanism

|         |              |         |         |
|---------|--------------|---------|---------|
| ø 28 mm | (0–18 m/min) | 4265240 | plastic |
| ø 28 mm | (0–18 m/min) | 4287860 | steel   |

## Gear wheel, 4-roll wire feed mechanism

|         |              |         |         |
|---------|--------------|---------|---------|
| ø 28 mm | (0–18 m/min) | 4265240 | plastic |
| ø 28 mm | (0–18 m/min) | 4287860 | steel   |
| ø 40 mm | (0–25 m/min) | 4265250 | plastic |
| ø 40 mm | (0–25 m/min) | 4297270 | steel   |

**Wire feed mechanism DuraTorque™ 400 / DT400 / DT400L / DT410 / MXF 63 -65 -67 / MSF 53 -55 -57 / MF 29 / Kempact MIG 2530 -Pulse 3000 -Pulse 3000MVU**
**Wire feed mechanism GT04 / Fastmig MXP 37**

| Feed rolls (plastic) |    |   |         |         |         |         |                       |         |         |         |
|----------------------|----|---|---------|---------|---------|---------|-----------------------|---------|---------|---------|
| Wire ø mm            |    |   | 0.6     | 0.8/0.9 | 1.0     | 1.2     | 1.4                   | 1.6     | 2.0     | 2.4     |
| Fe,SS, (Al, Mc, Fc)  | V  | 1 | W001045 | W001047 | W000675 | W000960 | W001049               | W001051 | W001053 | W001055 |
| V-groove, plain      |    | 2 | W001046 | W001048 | W000676 | W000961 | W001050               | W001052 | W001054 | W001056 |
| Fc, Mc (Fe)          | V≡ | 1 |         |         | W001057 | W001059 | W001061 (ø 1.4 - 1.6) |         | W001063 | W001065 |
| V-groove, knurled    |    | 2 |         |         | W001058 | W001060 | W001062 (ø 1.4 - 1.6) |         | W001064 | W001066 |
| Al, (Fc, Mc, SS, Fe) | U  | 1 |         |         | W001067 | W001069 | W001071               |         |         |         |
| U-groove             |    | 2 |         |         | W001068 | W001070 | W001072               |         |         |         |

1= lower feed roll, 2= upper feed roll.

**Wire feed mechanism DuraTorque™ 400 / DT400 / DT400L / DT410 / MXF 63 -65 -67 / MSF 53 -55 -57 / MF 29 / Kempact MIG 2530 -Pulse 3000 -Pulse 3000MVU**
**Wire feed mechanism GT04 / Fastmig MXP 37**

| Feed rolls (metal) Wire ø mm                           |    |   | 0.8/0.9 | 1.0     | 1.2     | 1.4                   | 1.6     | 2.0     |  |
|--------------------------------------------------------|----|---|---------|---------|---------|-----------------------|---------|---------|--|
| Fe,SS, (Al, Mc, Fc)<br>V-groove, plain                 | V  | 1 | W006074 | W006076 | W004754 |                       | W006078 |         |  |
|                                                        |    | 2 | W006075 | W006077 | W004753 |                       | W006079 |         |  |
| Fc, Mc (Fe)<br>V-groove, knurled                       | V≡ | 1 |         | W006080 | W006082 | W006084 (ø 1.4 - 1.6) |         | W006086 |  |
|                                                        |    | 2 |         | W006081 | W006083 | W006085 (ø 1.4 - 1.6) |         | W006087 |  |
| Al, (Fc, Mc, SS, Fe)<br>U-groove<br>(not Al with GT04) | U  | 1 |         | W006088 | W006090 |                       | W006092 |         |  |
|                                                        |    | 2 |         | W006089 | W006091 |                       | W006093 |         |  |

1= lower feed roll, 2= upper feed roll

**Wire feed mechanism DuraTorque™ 400 / DT400 / DT400L / DT410 / MXF 63 -65 -67 / MSF 53 -55 -57 / MF 29 / Kempact MIG 2530 -Pulse 3000 -Pulse 3000MVU**

| Wire guide tube                                  |                         |         |         |         |         |                       |         |         |         |
|--------------------------------------------------|-------------------------|---------|---------|---------|---------|-----------------------|---------|---------|---------|
| Wire ø mm                                        |                         | 0.6     | 0.8/0.9 | 1.0     | 1.2     | 1.4                   | 1.6     | 2.0     | 2.4     |
| Wire guide tube IN: SS, Al (Fe, Mc, Fc) plastic  |                         | W007293 | W007294 | W007295 | W007296 | W007297               | W007298 | W007299 | W007300 |
| Wire guide tube IN: Fe, Fc, Mc metal             |                         |         | W007536 | W007537 | W007538 | W007539 (ø 1.4 - 1.6) |         | W007540 | W007541 |
| Wire guide tube MID: SS, Al (Fe, Mc, Fc) plastic | ref.<br>length<br>33 mm | W007429 | W007430 | W007431 | W007432 | W007433               | W007434 | W007435 | W007436 |
| Wire guide tube MID: Fe, Fc, Mc metal            |                         |         | W007465 | W007466 | W007467 | W007469 (ø 1.4 - 1.6) |         | W007470 | W007471 |
| Wire guide tube OUT: SS, Al (Fe, Mc, Fc) plastic | ref.<br>length<br>64 mm | W007437 | W007438 | W007439 | W007440 | W007441               | W007442 | W007443 | W007444 |
| Wire guide tube OUT: Fe, Fc, Mc metal            |                         |         | W007454 | W007455 | W007456 | W007458 (ø 1.4 - 1.6) |         | W007459 | W007460 |

**Wire feed mechanism GT04 / Fastmig MXP 37**

| Wire guide tube                                  |                   |         |         |         |         |                       |         |          |         |
|--------------------------------------------------|-------------------|---------|---------|---------|---------|-----------------------|---------|----------|---------|
| Wire ø mm                                        |                   | 0.6     | 0.8/0.9 | 1.0     | 1.2     | 1.4                   | 1.6     | 2.0      | 2.4     |
| Wire guide tube IN: SS, Al (Fe, Mc, Fc) plastic  |                   | W007293 | W007294 | W007295 | W007296 | W007297               | W007298 | W007299  | W007300 |
| Wire guide tube IN: Fe, Fc, Mc metal             |                   |         | W007536 | W007537 | W007538 | W007539 (ø 1.4 - 1.6) |         | W007540  | W007541 |
| Wire guide tube MID: SS, Al, Fe, Mc, Fc plastic  | ref. length 33 mm | W007273 | W007274 | W007275 | W007276 | W007277               | W007278 | W007279  | W007280 |
| Wire guide tube OUT: SS, Al (Fe, Mc, Fc) plastic | ref. length 64 mm | W007285 | W007286 | W007287 | W007488 | W007289               | W007290 | W0072491 | W007292 |
| Wire guide tube OUT: Fe, Fc, Mc metal            |                   |         | W007454 | W007455 | W007456 | W007458 (ø 1.4 - 1.6) |         | W007459  | W007460 |

# Consumable parts for wire feed mechanisms

| Wire feed mechanism DuraTorque™ 400 / Kempact 253R -253A -253RMV -253AMV -323R -323A -323RMV -323AMV |    |     |         |         |         |
|------------------------------------------------------------------------------------------------------|----|-----|---------|---------|---------|
| Wire feed mechanism GT02C / Kempact 181A -251R -251A                                                 |    |     |         |         |         |
| Feed rolls (plastic)                                                                                 |    |     |         |         |         |
| Wire ø mm                                                                                            |    | 0.6 | 0.8/0.9 | 1.0     | 1.2     |
| Fe,SS, (Al, MC, Fc)<br>V-groove, plain                                                               | V  | 1   | W001045 | W001047 | W000675 |
|                                                                                                      |    | 2   | W001046 | W001048 | W000676 |
| Fc, Mc (Fe)<br>V-groove, knurled                                                                     | V≡ | 1   |         |         | W001057 |
|                                                                                                      |    | 2   |         |         | W001058 |
| Al, (Fe, Fc, Mc, SS)<br>U-groove                                                                     | U  | 1   |         |         | W001067 |
|                                                                                                      |    | 2   |         |         | W001068 |

1= lower feed roll, 2= upper feed roll

| Wire feed mechanism DuraTorque™ 400 / Kempact 253R -253A -253RMV -253AMV -323R -323A -323RMV -323AMV |                   |         |         |         |         |
|------------------------------------------------------------------------------------------------------|-------------------|---------|---------|---------|---------|
| Wire guide tube                                                                                      |                   |         |         |         |         |
| Wire ø mm                                                                                            |                   | 0.6     | 0.8/0.9 | 1.0     | 1.2     |
| Wire guide tube MID: Fe,SS, (Al, MC, Fc) plastic                                                     | ref. length 33 mm | W007429 | W007430 | W007431 | W007432 |
| Wire guide tube MID: Fe, Fc, Mc metal                                                                |                   |         | W007465 | W007466 | W007467 |
| Wire guide tube OUT: Fe,SS, (Al, MC, Fc) plastic                                                     | ref. length 78 mm | W007448 | W007445 | W007446 | W007447 |
| Wire guide tube OUT: Fe, Fc, Mc metal                                                                |                   |         | W007461 | W007462 | W007463 |
| Wire guide tube Kempact RA                                                                           |                   |         |         |         | W006410 |
| WF Backsleeve 2.0 mm Kempact RA                                                                      |                   |         |         |         | W005784 |

| Wire feed mechanism GT02C / Kempact 181A -251R -251A |                    |         |         |         |         |
|------------------------------------------------------|--------------------|---------|---------|---------|---------|
| Wire guide tube                                      |                    |         |         |         |         |
| Wire ø mm                                            |                    | 0.6     | 0.8/0.9 | 1.0     | 1.2     |
| Wire guide tube OUT: Fe,SS, (Al, MC, Fc) plastic     | ref. length 106 mm | W007532 | W007533 | W007534 | W007535 |
| Wire guide tube Kempact RA                           |                    |         |         |         | W006410 |
| WF Backsleeve 2.0 mm GT02 Kempact RA                 |                    |         |         |         | W006019 |

| Wire feed mechanism GT02 / FitWeld 300                                                                                   |   |         |         |         |
|--------------------------------------------------------------------------------------------------------------------------|---|---------|---------|---------|
| Feed rolls (plastic)                                                                                                     |   |         |         |         |
| Wire ø mm                                                                                                                |   | 0.8/0.9 | 1.0     | 1.2     |
| Fe,SS, (Al, MC, Fc)<br>V-groove, plain  | 1 | W001047 | W000675 | W000960 |
|                                                                                                                          | 2 | W001048 | W000676 | W000961 |
| Fc,Mc (Fe)<br>V-groove, knurled         | 1 |         | W001057 | W001059 |
|                                                                                                                          | 2 |         | W001058 | W001060 |
| Al, (Fc, Mc, SS, Fe)<br>U-groove        | 1 |         | W001067 | W001069 |
|                                                                                                                          | 2 |         | W001068 | W001070 |
| 1= lower feed roll, 2= upper feed roll                                                                                   |   |         |         |         |

| Wire feed mechanism GT02 / FitWeld 300                                                                                     |           |         |         |         |
|----------------------------------------------------------------------------------------------------------------------------|-----------|---------|---------|---------|
| Feed rolls (metal)                                                                                                         | Wire ø mm | 0.8/0.9 | 1.0     | 1.2     |
| Fe,SS, (Al, MC, Fc)<br>V-groove, plain  | 1         | W006074 | W006076 | W004754 |
|                                                                                                                            | 2         | W006075 | W006077 | W004753 |
| Fc,Mc (Fe)<br>V-groove, knurled          | 1         |         | W006080 | W006082 |
|                                                                                                                            | 2         |         | W006081 | W006083 |
| Al, (Fc, Mc, SS, Fe)<br>U-groove        | 1         |         | W006088 | W006090 |
|                                                                                                                            | 2         |         | W006089 | W006091 |
| 1= lower feed roll, 2= upper feed roll                                                                                     |           |         |         |         |

#### Wire feed mechanism GT02 / FitWeld 300

##### Wire guide tube

|                                                  |         |
|--------------------------------------------------|---------|
| Wire guide tube IN: Al, SS (Fe, Mc, Fc) plastic  | W003962 |
| Wire guide tube IN: Fe, Fc, Mc metal             | W003536 |
| Wire guide tube OUT: Al, SS (Fe, Mc, Fc) plastic | W003963 |
| Wire guide tube OUT: Fe, Fc, Mc metal            | W003881 |

#### Wire feed mechanism SuperSnake GT02S / GT02SW

| Feed rolls kit metal                                                                                                        | Wire ø mm | 0.8     | 1.0     | 1.2     | 1.6     | 2.0     |
|-----------------------------------------------------------------------------------------------------------------------------|-----------|---------|---------|---------|---------|---------|
| Fe, SS, (Al, MC, Fc)<br>V-groove, plain  |           | W004276 | W004277 | W004278 | W004279 |         |
|                                                                                                                             |           |         |         | W004281 | W006608 | W006609 |
| Fc, Mc (Fe)<br>V-groove, knurled         |           |         |         |         |         |         |
|                                                                                                                             |           |         |         | W004280 |         |         |
| Al, (Fe, Fc, Mc, SS)<br>U-groove         |           |         |         |         |         |         |
|                                                                                                                             |           |         |         |         |         |         |

#### Wire feed mechanism SuperSnake GT02S / GT02SW

|                              |                    |         |
|------------------------------|--------------------|---------|
| <b>Wire guide tube OUT</b>   | 0.8-1.6            |         |
| Wire ø mm                    | W004185            |         |
| SS, Al, (Fe, MC, Fc) plastic |                    |         |
| <b>Wire guide tube OUT</b>   | 0.8-1.2            | 1.4-2.0 |
| Wire ø mm                    | W004083    W006617 |         |
| Fc, Mc, Fe metal             |                    |         |

#### Wire feed mechanism SuperSnake GT02S / GT02SW

|                               |         |         |         |         |
|-------------------------------|---------|---------|---------|---------|
| <b>Wire liner DL-Teflon</b>   | 10 m    | 15 m    | 20 m    | 25 m    |
| Wire ø mm 0.8-1.6, SS, Al     | W004145 | W004219 | W004220 | W004221 |
| <b>Wire liner (Spiral)</b>    | 10.5 m  | 15.5 m  | 20.5 m  | 25.5 m  |
| Wire ø mm 0.8-1.6, Fe, Fc, Mc | W004214 | W004216 | W004217 | W004218 |
| <b>Wire liner (Spiral)</b>    |         | 15.5 m  |         | 25.5 m  |
| Wire ø mm 1.4-2.0, Fe, Fc, Mc |         | 4308620 |         | 4308630 |

# FE 20, FE 25, MMT 25 , PMT 25



## Gas nozzle

|              |                      |
|--------------|----------------------|
| 1. 9580101*  | Standard             |
| 2. 958010101 | With insulating ring |
| 3. 4113470   | For spot welding     |
| 4. 9580101E  | Thick wall           |

## Insulating bush

9591010\*

## Contact tip

|          |             |       |
|----------|-------------|-------|
| 9876635* | 0,8 mm / M6 | FE 20 |
| 9876636* | 1,0 mm / M6 |       |

Please see page 67 for a full listing of available contact tips.

## Contact tip adapter

9580173\*

## Insulating ring

9591079\*

## Locking spring

4275240\*

## Neck 45°

4153040\*

## Wire liners

|          |        |           |             |
|----------|--------|-----------|-------------|
| 4188573* | Spiral | 0.6...0.8 | 3.5 m/white |
| 4188576* | Spiral | 0.6...0.8 | 5 m/white   |
| 4188581* | Spiral | 0.9...1.2 | 3m/red      |
| 4188582* | Spiral | 0.9...1.2 | 4.5m/red    |
| W006453* | Spiral | 0.9...1.2 | 3.5 m/red   |
| W006454* | Spiral | 0.9...1.2 | 5 m/red     |

Suitable liners: white, red, yellow, DL Chili-Teflon.

\* Standard delivery

# FE 27, MMT 27, PMT 27, FE 32, MMT 32, PMT 32, MMT 30W, PMT 30W, WS 30W



## Gas nozzle

|             |               |
|-------------|---------------|
| 1. 4295760* | Standard / M8 |
| 2. 4295760L | Long          |
| 3. 4295760C | Conical       |
| 4. 4294970  | Standard / M6 |

## Contact tip

9580123\* 1.0 / M8

Please see page 67 for a full listing of available contact tips.

## Contact tip adapter

4295740\* M8

4294890 M6

## Gas diffuser

4294880\*

4294880CER



## 1. Neck 50°

3146800 MMT 30W/PMT 30W/WS 30W

## 2. Neck 50°

3146780 FE 27/MMT 27/PMT 27  
FE 32/MMT 32/PMT 32

## Wire liners

|          |        |           |           |
|----------|--------|-----------|-----------|
| 4188581* | Spiral | 0.9...1.2 | 3m/red    |
| 4188582* | Spiral | 0.9...1.2 | 4.5m/red  |
| W006453* | Spiral | 0.9...1.2 | 3.5 m/red |
| W006454* | Spiral | 0.9...1.2 | 5 m/red   |

Suitable liners: white, red, yellow, DL Chili-Teflon.

\* Standard delivery/WeldSnake according to filler wire.

# FE 35, MMT 35, PMT 35, WS 35, MMT 42W, PMT 42W, WS 42W



## Gas nozzle

|             |                    |
|-------------|--------------------|
| 1. 4307050* | Standard, isolated |
| 2. 4300260  | Standard           |
| 3. 4300260L | Long               |
| 4. 4300260C | Conical            |

## Insulating bush

4307020\*

## Contact tip

9580123\* 1.0 / M8

Please see page 67 for a full listing of available contact tips.

## Contact tip adapter

4295740\* M8 PMT/MMT/WS 35

## Contact tip adapter

W006183\* Brass PMT/MMT/WS 42W

W006182 Copper PMT/MMT/WS 42W

## Gas diffuser

W006146 PMT/MMT/WS 42W

W004390 FE/PMT/MMT/WS 35

## 1. Neck 50°

SP004539\* MMT 42W/PMT 42W/WS 42W

## 2. Neck 50°

SP004585\* FE 35/PMT 35/MMT 35

## 3. Neck 50° (temperature resistant)

SP600317 PMT 35/MMT 35

## Wire liners

|          |        |           |           |
|----------|--------|-----------|-----------|
| 4188581* | Spiral | 0.9...1.2 | 3m/red    |
| 4188582* | Spiral | 0.9...1.2 | 4.5m/red  |
| W006453* | Spiral | 0.9...1.2 | 3.5 m/red |
| W006454* | Spiral | 0.9...1.2 | 5 m/red   |

Suitable liners: white, red, yellow, DL Chili-Teflon.

\* Standard delivery/WeldSnake according to filler wire.

# FE 42, MMT 42, PMT 42, MMT 52W, PMT 52W



## Gas nozzle

|             |                        |
|-------------|------------------------|
| 1. 4307070* | Standard, isolated     |
| 2. 4300380  | Standard               |
| 3. 4300380L | Long                   |
| 4. 4300380C | Conical                |
| 5. 4308190  | Special long (89.5 mm) |

## Insulating bush

4307030\*

## Contact tip

9580123\* 1.0 / M8

Please see page 67 for a full listing of available contact tips.

## Contact tip adapter

|             |                     |
|-------------|---------------------|
| W004508 M8* | PMT 52W/MMT 52W     |
| 4304600 M8* | FE 42/PMT 42/MMT 42 |

## Gas diffuser

|         |                     |
|---------|---------------------|
| W004505 | PMT 52W/MMT 52W     |
|         | FE 42/PMT 42/MMT 42 |

## 1. Neck 50°

|          |                 |
|----------|-----------------|
| SP004563 | PMT 52W/MMT 52W |
|----------|-----------------|

## 2. Neck 50°

|          |                     |
|----------|---------------------|
| SP004578 | FE 42/PMT 42/MMT 42 |
|----------|---------------------|

## 3. Neck 50°

|          |               |
|----------|---------------|
| SP600316 | PMT 42/MMT 42 |
|----------|---------------|

## Wire liners

|                                                       |        |           |           |
|-------------------------------------------------------|--------|-----------|-----------|
| 4188581*                                              | Spiral | 0.9...1.2 | 3m/red    |
| 4188582*                                              | Spiral | 0.9...1.2 | 4.5m/red  |
| W006453*                                              | Spiral | 0.9...1.2 | 3.5 m/red |
| W006454*                                              | Spiral | 0.9...1.2 | 5 m/red   |
| Suitable liners: white, red, yellow, DL Chili-Teflon. |        |           |           |

\* Standard delivery



# PMT MN (ROOT pass welding, MIG/MAG welding)



|                              |                 |
|------------------------------|-----------------|
| <b>1. Neck 60° 168 RP</b>    | <b>SP007810</b> |
| Changeable neck liner 165 mm | W007798         |
| <b>2. Neck 60° 198 RP</b>    | <b>SP007811</b> |
| Changeable neck liner 195 mm | W007799         |
| <b>3. Neck 60° 198</b>       | <b>SP008006</b> |
| Changeable neck liner 195 mm | W007799         |
| <b>4. Neck 60° 168</b>       | <b>SP008007</b> |
| Changeable neck liner 165 mm | W007798         |

| <b>Gas nozzle</b> |                   |
|-------------------|-------------------|
| 1. W006181        | ROOT pass welding |
| 2. 4295760*       | Standard / M8     |
| 3. 4295760L*      | Long              |
| 4. 4295760C*      | Conical           |
| 5. 4294970*       | Standard / M6     |

| <b>Contact tip</b> |          |                   |
|--------------------|----------|-------------------|
| 9876647            | 0.8 / M6 | ROOT pass welding |
| 9580124*           | 1.2 / M8 |                   |

Please see page 67 for a full listing of available contact tips.

| <b>Contact tip adapter</b> |    |
|----------------------------|----|
| 4295740*                   | M8 |
| 4294890                    | M6 |

| <b>Gas diffuser</b> |  |
|---------------------|--|
| 4294880*            |  |
| 4294880CER          |  |

| <b>Wire liners</b> |        |           |           |
|--------------------|--------|-----------|-----------|
| W006453*           | Spiral | 0.9...1.2 | 3.5 m/red |
| W006454*           | Spiral | 0.9...1.2 | 5 m/red   |

Suitable liners: red, yellow, DL Chili-Teflon.

Please see page 66 for a full listing of DL Chili liners.

\* Standard delivery

# PMT MN (MIG/MAG welding)



## Neck 45° L222

SP007229

Changeable neck liner 232 mm

W007800

## Gas nozzle

1. 4255530\*

2. 4255530E

3. 4273510

## Insulating bush

4248710\*

## Contact tip

9580124\*

1.2 / M8

Please see page 67 for a full listing of available contact tips.

## Contact tip adapter

4255421\*

M8

## Insulating ring, neck

4254670\*

## Wire liners

W006453\* Spiral 0.9...1.2 3.5 m/red

W006454\* Spiral 0.9...1.2 5 m/red

Suitable liners: red, yellow, DL Chili-Teflon.

Please see page 66 for a full listing of DL Chili liners.

\* Standard delivery

# MMT 42C



| Gas nozzle  |                        |
|-------------|------------------------|
| 1. 4307070* | Standard, isolated     |
| 2. 4300380  | Standard               |
| 3. 4300380L | Long                   |
| 4. 4300380C | Conical                |
| 5. 4308190  | Special long (89.5 mm) |

| Insulating bush |  |
|-----------------|--|
| 4307030*        |  |

| Contact tip                                                      |  |
|------------------------------------------------------------------|--|
| 9580123* 1.0 / M8                                                |  |
| Please see page 67 for a full listing of available contact tips. |  |

| Contact tip adapter |  |
|---------------------|--|
| 4304600 M8*         |  |

| Gas diffuser |  |
|--------------|--|
| W004505*     |  |

| Insulating ring, neck |  |
|-----------------------|--|
| 9591079*              |  |

| Neck      |  |
|-----------|--|
| SP006008* |  |

| Neck part |            |    |
|-----------|------------|----|
| 4302150   | 0.8–1.6 mm | Al |
| 4302740   | 0.8–1.0 mm | Ss |
| 4302750   | 1.2–1.6 mm | Ss |

| Wire liners                                           |        |           |          |
|-------------------------------------------------------|--------|-----------|----------|
| 4188581*                                              | Spiral | 0.9...1.2 | 3m/red   |
| 4188582*                                              | Spiral | 0.9...1.2 | 4.5m/red |
| Suitable liners: white, red, yellow, DL Chili-Teflon. |        |           |          |
| * Standard delivery                                   |        |           |          |



# MMG 20, MMG 22



| Gas nozzle  |            |  |
|-------------|------------|--|
| 1. 9580101* |            |  |
| 2. 9580101E | Thick wall |  |

| Insulating bush |  |
|-----------------|--|
| 9591010*        |  |

| Contact tip                                                      |  |
|------------------------------------------------------------------|--|
| 9876635* 0.8 / M6                                                |  |
| Please see page 67 for a full listing of available contact tips. |  |

| Contact tip adapter |  |
|---------------------|--|
| 9580173* M6         |  |

| Insulating ring, neck |  |
|-----------------------|--|
| 9591079*              |  |

| Locking spring |  |
|----------------|--|
| 4275240*       |  |

| Neck 45° |  |
|----------|--|
| 4153040* |  |

| Wire liners         |        |           |     |  |
|---------------------|--------|-----------|-----|--|
| 4307650 *           | Fe     | 0.6...1.0 | 3 m |  |
| 4307660             | Ss, Al | 0.8...1.0 | 3 m |  |
| * Standard delivery |        |           |     |  |



# TIG welding torch range

## Welding craftsmen deserve the best tools

**Kemppi TIG torches just feel that little bit better in the hand for those quality welding tasks.** Kemppi TIG torches suit a variety of equipment and are available from 4 to 16 meters in length. Manufactured using the best materials, you can trust Kemppi TIG torches to perform, allowing you to concentrate on completing beautiful looking TIG welds.

**The TTM range** is equipped with manual gas valves to regulate the shielding gas flow, ensuring basic TIG welding tasks are easily completed. Use with MMA power sources for scratch and TouchArc TIG ignition.

**The TTK range** fits a wide range of industrial TIG welding machines. Standard thread terminations easily connect for power, gas and water (model dependent) and every model is fitted with an ignition switch, cable and plug as standard.

**The TTC range** is designed for use with specific Kemppi TIG machines and available in both air and water cooled models. TTC torches support RTC10 and RTC20 remote control units that replace the standard on/off switch with a convenient and precise remote current regulator for easy ignition and power control at distance.

## Technical specifications and Ordering information

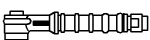
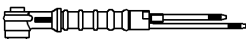
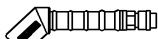
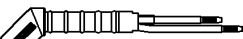
|                   | TTM 15V 4M  | TTM 15V BC 4M | TTC 220 GV 4M |
|-------------------|-------------|---------------|---------------|
| Output, DC TIG    | 140 A (35%) | 150 A (35%)   | 220 A (40%)   |
| Machine connector | R1/4        | R3/8          | R3/8          |
| Ordering code     | 6271432     | 627143201     | 627022304     |

## Technical specifications and Ordering information

| TTK                      |               | TTK 130   | TTK 130F  | TTK 160   | TTK 160S  | TTK 220   | TTK 220S  | TTK 300W  | TTK 350W  | TTK 250WS |
|--------------------------|---------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Output                   | DC 40 % ED    | 130 A     | 130 A     | 160 A     | 160 A     | 220 A     | 220 A     | 300 A     | 350 A     | 250 A     |
|                          | DC 100 % ED   | -         | -         | -         | -         | -         | -         | 200 A     | 250 A     | 200 A     |
|                          | AC 40 % ED    | 100 A     | 100 A     | 120 A     | 110 A     | 160 A     | 120 A     | 250 A     | 300 A     | 250 A     |
|                          | AC 100 % ED   | -         | -         | -         | -         | -         | -         | 140 A     | 200 A     | 140 A     |
| Electrodes               | ø mm          | 1.0...2.4 | 1.0...2.4 | 1.0...2.4 | 1.0...2.4 | 1.0...3.2 | 1.0...3.2 | 1.0...2.4 | 1.0...4.0 | 1.0...4.0 |
| Connection               | Gas/current   | R¼        | R¼        | R¼        | R¼        | R¼        | R¼        | -         | -         | -         |
|                          | Water/current | -         | -         | -         | -         | -         | -         | R3/8      | R3/8      | R3/8      |
|                          | Gas           | -         | -         | -         | -         | -         | -         | R¼        | R¼        | R¼        |
| Length/<br>Ordering code | 4 m           | 627063004 | 627063104 | 627066004 | 627066204 | 627072004 | 627072304 | 627080504 | 627085504 | 627075704 |
|                          | 8 m           | 627063008 | 627063108 | 627066008 | 627066208 | 627072008 | 627072308 | 627080508 | 627085508 | 627075708 |
|                          | 16 m          | 627063016 | 627063116 | 627066016 | 627066216 | 627072016 | 627072316 | 627080516 | 627085516 | 627075716 |

| TTC                      |             | TTC 130   | TTC 130F  | TTC 160   | TTC 160S  | TTC 220   | TTC 220S  | TTC 200W        | TTC 250W        | TTC 250WS       |
|--------------------------|-------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------------|-----------------|-----------------|
| Output                   | DC 40 % ED  | 130 A     | 130 A     | 160 A     | 160 A     | 220 A     | 220 A     | 300 A           | 350 A           | 250 A           |
|                          | 100 % ED    | -         | -         | -         | -         | -         | -         | 200 A           | 250 A           | 200 A           |
| Electrodes               | ø mm        | 1.0...2.4 | 1.0...2.4 | 1.0...2.4 | 1.0...2.4 | 1.0...3.2 | 1.0...2.4 | 1.0...2.4       | 1.0...4.0       | 1.0...4.0       |
| Connection               | Gas/current | R¼        | R¼        | R¼        | R¼        | R¼        | R¼        | R¼              | R¼              | R¼              |
|                          | Water       | -         | -         | -         | -         | -         | -         | Snap connection | Snap connection | Snap connection |
| Length/<br>Ordering code | 4 m         | 627013004 | 627013104 | 627016004 | 627016204 | 627022004 | 627022204 | 627020504       | 627025504       | 627025704       |
|                          | 8 m         | 627013008 | 627013108 | 627016008 | 627016208 | 627022008 | 627022208 | 627020508       | 627025508       | 627025708       |
|                          | 16 m        | 627013016 | 627013116 | 627016016 | 627016216 | 627022016 | -         | 627020516       | 627025516       | 627025716       |
|                          | 30 m        | -         | -         | -         | 627016230 | -         | -         | -               | -               | -               |

RTC 10 (6185477) and RTC 20 (6185478) remote control units are available as options

| TTC/TTK                  |                        |                                                                                     | TTC 130<br>TTK 130 | TTC 130F<br>TTK 130F | TTC 160<br>TTK 160 | TTC 160S<br>TTK 160S | TTC 220<br>TTK 220 | TTC 220S<br>TTK 220S | TTC 200W<br>TTK 300 W | TTC 250W<br>TTK 350 W | TTC 250WS<br>TTK 250 WS |
|--------------------------|------------------------|-------------------------------------------------------------------------------------|--------------------|----------------------|--------------------|----------------------|--------------------|----------------------|-----------------------|-----------------------|-------------------------|
| <input type="checkbox"/> | 4285650                |  | ■                  | ●                    | ●                  | ●                    | ●                  | ●                    |                       |                       |                         |
| <input type="checkbox"/> | 9878040 (Flex)         |  | ●                  | ■                    | ●                  | ●                    | ●                  | ●                    |                       |                       |                         |
|                          | 4270580                |  | ●                  | ●                    | ■                  | ●                    | ■                  | ●                    |                       |                       |                         |
| <input type="checkbox"/> | 4285660                |  |                    |                      |                    |                      |                    |                      | ■                     | ●                     | ●                       |
|                          | 4270600                |  |                    |                      |                    |                      |                    |                      | ●                     | ■                     | ●                       |
|                          | 4276530                |  | ●                  | ●                    | ●                  | ■                    | ●                  | ■                    |                       |                       |                         |
| <input type="checkbox"/> | 4276300                |  | ●                  | ●                    | ●                  | ■                    | ●                  | ●                    | ●                     | ●                     | ■                       |
|                          | 4276290                |  | ●                  | ●                    | ●                  | ●                    | ●                  | ■                    | ●                     | ●                     | ●                       |
|                          | 4276550                |  |                    |                      |                    |                      |                    |                      | ●                     | ●                     | ■                       |
| ■                        | Standard delivery      |                                                                                     |                    |                      |                    |                      |                    |                      |                       |                       |                         |
| ●                        | Accessory              |                                                                                     |                    |                      |                    |                      |                    |                      |                       |                       |                         |
| <input type="checkbox"/> | Small consumable parts |                                                                                     |                    |                      |                    |                      |                    |                      |                       |                       |                         |

# Consumable and replacement parts

Big torch head: TTK 160, 220, 220S, 350W, TTC 160, 220, 250W

| 1. Gas nozzle                                                  |                 | mm          |         |      |      |
|----------------------------------------------------------------|-----------------|-------------|---------|------|------|
| No.                                                            | Ordering number | a           | b       | c    | d    |
| 4                                                              | 7990766         | 18.0        | 11.5    | 6.5  | 47.5 |
| 5                                                              | 7990770         | 18.0        | 12.5    | 8.0  | 47.5 |
| 6                                                              | 7990771 *       | 18.0        | 14.5    | 9.5  | 47.5 |
| 7                                                              | 7990772         | 18.0        | 16.0    | 11.0 | 47.5 |
| 8                                                              | 7990773         | 18.0        | 18.0    | 12.5 | 47.5 |
| 10                                                             | 7990775         | 21.0        | 21.0    | 16.0 | 47.5 |
| 12                                                             | 7990776         | 24.0        | 24.0    | 19.0 | 47.5 |
| 2. Gas nozzle/lens                                             |                 | mm          |         |      |      |
| No.                                                            | Ordering number | a           | b       | c    | d    |
| 5                                                              | 7990783         | 25.0        | 12.5    | 7.5  | 42.0 |
| 6                                                              | 7990784         | 25.0        | 14.0    | 9.0  | 42.0 |
| 7                                                              | 7990785         | 25.0        | 15.5    | 11.0 | 42.0 |
| 8                                                              | 7990786         | 25.0        | 16.5    | 12.0 | 42.0 |
| 11                                                             | 7990787         | 25.0        | 22.0    | 17.0 | 42.0 |
| Housing for tightening bush                                    |                 |             |         |      |      |
| 1. standard                                                    |                 | 2. gas lens |         |      |      |
| ø 1.6                                                          | 7990681         | ø 1.6       | 7990711 |      |      |
| ø 2.4                                                          | 7990682 *       | ø 2.4       | 7990712 |      |      |
| ø 3.2                                                          | 7990683         | ø 3.2       | 7990713 |      |      |
| ø 4.0                                                          | 7990684         | ø 4.0       | 7990714 |      |      |
| Insulating ring                                                |                 |             |         |      |      |
| 1. 9580266 *                                                   |                 |             |         |      |      |
| 2. 9876860                                                     |                 |             |         |      |      |
| 3. 9580267                                                     |                 |             |         |      |      |
| Torch body                                                     |                 |             |         |      |      |
| Find codes of the torch body from the separate table, page 81. |                 |             |         |      |      |
| Tightening bush                                                |                 |             |         |      |      |
| ø 1.6                                                          | 9876867         |             |         |      |      |
| ø 2.4                                                          | 9876868 *       |             |         |      |      |
| ø 3.2                                                          | 9876869         |             |         |      |      |
| ø 4.0                                                          | 9876870         |             |         |      |      |
| Electrode shield including O-ring                              |                 |             |         |      |      |
| short                                                          | 7990731         |             |         |      |      |
| medium                                                         | 7990735         |             |         |      |      |
| long                                                           | 7990741 *       |             |         |      |      |
| O-ring                                                         | 7990791         |             |         |      |      |

\* Delivery equipment is for ø 2.4 mm electrode. Lens equipment is delivered as an accessory. The above mentioned dimensions are directive.



## Small torch head: TTK 130, 130F, 160S, 250WS, 300W, TTC130, 130F, 160S, 200W, 250WS

| 1. Gas nozzle |                 | mm   |      |      |    |
|---------------|-----------------|------|------|------|----|
| No.           | Ordering number | a    | b    | c    | d  |
| 4             | 7990760         | 14.5 | 10.0 | 6.5  | 30 |
| 5             | 7990761*        | 14.5 | 11.0 | 8.0  | 30 |
| 6             | 7990762         | 14.5 | 14.5 | 10.0 | 30 |
| 7             | 7990763         | 14.5 | 14.5 | 11.0 | 30 |

| Special gas nozzle |                 | mm   |      |     |    |
|--------------------|-----------------|------|------|-----|----|
| No.                | Ordering number | a    | b    | c   | d  |
| 4                  | 9878019         | 15.0 | 10.5 | 6.5 | 48 |
| 5                  | 9878020         | 15.0 | 11.5 | 8.0 | 48 |
| 6                  | 9878021         | 15.0 | 13.5 | 9.5 | 48 |

| 2. Gas nozzle/gas lens |                 | mm   |      |      |      |
|------------------------|-----------------|------|------|------|------|
| No.                    | Ordering number | a    | b    | c    | d    |
| 4                      | 7990779         | 18.5 | 10.5 | 7.0  | 25.5 |
| 5                      | 7990780         | 18.5 | 12.0 | 8.0  | 25.5 |
| 6                      | 7990781         | 18.5 | 13.5 | 9.5  | 25.5 |
| 7                      | 7990782         | 18.5 | 15.0 | 11.0 | 25.5 |

### Housing for tightening bush

| 1. standard |           | 2. lens |         |
|-------------|-----------|---------|---------|
| ø 1.0       | 7990660   | ø 1.0   | 7990700 |
| ø 1.6       | 7990661   | ø 1.6   | 7990701 |
| ø 2.4       | 7990662 * | ø 2.4   | 7990702 |

### Insulating ring

9878013 \*

### Torch body

Find codes of the torch body from the separate table, page 81.

### Tightening bush

| 1.    |           | 2. short |         |
|-------|-----------|----------|---------|
| ø 1.0 | 7990635   | ø 1.0    | 7990640 |
| ø 1.6 | 7990636   | ø 1.6    | 7990641 |
| ø 2.4 | 7990637 * | ø 2.4    | 7990642 |

### Electrode shield including O-ring

|        |           |
|--------|-----------|
| short  | 7990730   |
| medium | 7990734 * |
| long   | 7990740   |

### O-ring

7990790

\* Delivery equipment is for ø 2.4 mm electrode. Lens equipment is delivered as an accessory. The above-mentioned dimensions are directive.

