

**PLASMA ARC WELDING**



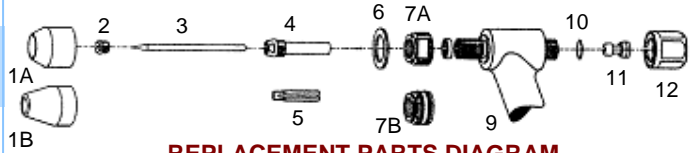
**TORCH REPLACEMENT PARTS**

**KITS PARTS**

**Definition of Plasma:** Plasma is a state of matter derived from gas being heated to an extremely high temperature and ionized so that the gas becomes electrically conductive. The plasma welding process uses this plasma to transfer an electric arc to the work piece and to constrict the arc during the welding.

**2A Torch**

Diag. No	DESCRIPTION	Part No.	Price EA
2A	<b>COMPLETE SPARE PARTS KIT</b>	5-2984	\$443.91
9	Torch Head Assembly (70 deg.)	8-2027	\$1,050.00
9	Torch Head Assembly (90 deg.)	8-2028	\$1,050.00
9	Torch Head Assembly (180 deg. offset)	8-2097	\$1,028.00
1B	Shield Cup (use w/ extended tip)	8-3236	\$32.07
1A	Shield Cup ( use w/ standard. tip)	8-2071	\$29.48
2	Tip (.045) 35A - Standard	8-2023	\$5.24
2	Tip (.062) 62A - Standard	8-2024	\$5.24
2	Tip (.081) 75A - Standard	8-2025	\$5.24
2	Tip (.031) 15A - Extended	8-2079	\$6.91
2	Tip (.045) 25A - Extended	8-2080	\$6.91
2	Tip (.062) 35A - Extended	8-2082	\$6.91
2	Tip (.081) 50A - Extended	8-2083	\$6.91
3	Electrode (.093) - Standard	8-2033	\$16.12
3	Electrode (.093) - Extended	8-2006	\$15.92
3	Electrode (.040) - Standard	8-2044	\$27.31
3	Electrode (.040) - Extended	8-2046	\$32.01
4	Liner	N/A	-
5	Gas Distributor (.093)	8-2040	\$50.91
5	Gas Distributor (.040)	8-2042	\$58.31
6	Gasket - Shield Cup	8-2036	\$3.25
7	Shield Gas Diffuser	N/A	-
10	O-Ring-Electrode Cap	8-2035	\$3.00
11	Collet (.093 Electrode)	8-2039	\$22.58
11	Collet (.040 Electrode)	8-2041	\$22.58
12	Electrode Cap Standard	8-2032	\$38.04
12	Electrode Cap - Extended	8-2030	\$44.97



**REPLACEMENT PARTS DIAGRAM**

For Plasma Welding Torches 2A, 3A, 4A and PWM-300

**3A Torch**

Diag. No	DESCRIPTION	Part No.	Price EA
3A	<b>COMPLETE SPARE PARTS KIT</b>	5-2985	\$443.91
9	Torch Head Assembly (70 deg.)	8-3030	\$1,028.00
9	Torch Head Assembly (90 deg.)	8-3031	\$1,028.00
9	Torch Head Assembly (180 deg. offset)	8-3032	\$1,028.00
1B	Shield Cup Narrow	8-3038	\$18.81
1A	Shield Cup Standard	8-3040	\$18.81
1	Shield Cup Spot Welding	8-3035	\$95.24
2	Tip (.014) 10A - Standard	8-3052	\$5.32
2	Tip (.022) 15A - Standard	8-3053	\$5.32
2	Tip (.031) 30A - Standard	9-1782	\$5.32
2	Tip (.046) 50A - Standard	9-1783	\$5.32
2	Tip (.062) 75A - Standard	9-1784	\$5.32
2	Tip (.081) 100A - Standard	9-1785	\$5.32
2	Tip (.093) 130A - Standard	9-1795	\$5.31
2	Tip (.031) 30A - Extended	9-1788	\$6.81
2	Tip (.046) 50A - Extended	9-1789	\$6.81
2	Tip (.062) 75A - Extended	9-1790	\$6.81
2	Tip (.081) 100A - Extended	9-1791	\$6.81
2	Tip (.093) 130A - Extended	9-1811	\$6.81
2	Electrode (.093) - Standard	8-2007	\$19.04
3	Electrode (.093) - Extended	9-1775	\$21.18
4	Liner	N/A	-
5	Gas Distributor insulating sleeve	9-2240	\$48.22
6	Gasket - Shield Cup	8-3057	\$3.25
7	Shield Gas Diffuser	8-3059	\$22.11
10	O-Ring-Electrode Cap	8-0527	\$3.00
11	Collet	9-1780	\$21.85
12	Electrode Cap - Standard	9-1779	\$27.12
12	Electrode Cap - Extended	9-1803	\$33.58

**4A Torch**

Diag. No	DESCRIPTION	Part No.	Price EA
4A	<b>COMPLETE SPARE PARTS KIT</b>	5-2986	\$731.22
9	Torch Head Assembly (70 deg.)	8-4014	\$1,028.00
9	Torch Head Assembly (90 deg.)	8-4015	\$1,028.00
9	Torch Head Assembly (180 deg. offset)	8-4016	\$1,028.00
9	Torch Head Assembly (180 deg. inline)	8-4054	\$1,028.00
1B	Shield Cup (use w/ ext. tip) - Narrow	8-4064	\$33.50
1A	Shield Cup ( use w/ std. tip) - Standard	8-4088	\$19.52
2	Tip (.046) 50A - Standard	9-1846	\$6.60
2	Tip (.062) 100A - Standard	9-1847	\$6.60
2	Tip (.093) 125A - Standard	9-1848	\$6.60
2	Tip (.125) 150A - Standard	9-1849	\$6.60
2	Tip (.062) 100A - Extended	9-1890	\$10.14
2	Tip (.093) 125A -Extended	9-1891	\$10.14
2	Tip (.125) 50A - Extended	9-1892	\$10.14
3	Electrode (.187) - Standard	9-1827	\$51.67
3	Electrode (.187) - Extended	9-1834	\$67.30
4	Liner	8-4011	\$50.64
5	Gas Distributor	9-2204	\$81.45
6	Gasket - Shield Cup	8-4069	\$3.25
7A	Shield Gas Diffuser	8-4040	\$60.55
7B	Shield Gas Diffuser	8-4087	\$57.02
8	Collar	8-4024	\$19.50
10	O-Ring-Electrode Cap	8-0530	\$3.00
11	Collet	9-1876	\$22.58
12	Electrode Cap Standard	8-4158	\$31.94
12	Electrode Cap - Extended	9-1877	\$51.946

**PWM-300 Torch**

Diag. No	DESCRIPTION	Part No.	Price EA
PWM-300	<b>COMPLETE SPARE PARTS KIT</b>	5-2910	\$1,470.14
1	Shield Cup - (brass)	8-4373	\$32.40
2	Tip (.093) 200A	8-4370	\$16.78
2	Tip (.113) 250A	8-4371	\$16.78
2	Tip (.125) 300A	8-4372	\$16.78
3	Electrode	9-1827	\$36.17
4	Liner	8-6509	\$95.88
5	Gas Distributor Insulating Sleeve	8-6651	\$107.90
6	Gasket - Shield Cup	8-6512	\$3.25
7	Shield Gas Diffuser	8-6652	\$74.40
10	O-Ring-Electrode Cap	8-0534	\$3.00
11	Collet	8-6650	\$43.21
12	Electrode Cap - Standard	8-6654	\$42.51

**Replacement Torch Leads w/out Torch Head**

**FOR 2A TORCH**

Length.	Part No.	Price Ea
12.5 ft (3.8 m)	4-2539	\$755.00
25 ft (7.6 m)	4-2585	\$870.00

**FOR 3A TORCH**

Length.	Part No.	Price Ea
12.5 ft (3.8 m)	4-2615	\$755.00
25 ft (7.6 m)	4-2624	\$878.00

**FOR 4A & PWM-300 TORCHES**

Length.	Part No.	Price Ea
12.5 ft (3.8 m)	4-2525	\$725.00
25 ft (7.6 m)	4-2544	\$840.00