



***SR-B 9, SR-B 17, SR-B 26,  
SR-B 26-HD, SR-B 18, SR-B 20,  
SR-B 21, SR-B 400, XCT-B 400W***



**Instruction manual**





## EU DECLARATION OF CONFORMITY

According to  
The Low Voltage Directive 2014/35/EU  
The RoHS Directive 2011/65/EU

**Type of equipment**

TIG welding torch

**Type designation**

Air/gas-cooled variants:

SR-B 9, 9FX and 9V;  
SR-B 17, 17FX and 17V;  
SR-B 26, 26FX and 26V;  
SR-B 26-HD, 26FX-HD and 26V-HD.

Liquid-cooled variants:

SR-B 18 and 18FX;  
SR-B 20 and 20FX;  
SR-B 21 and 21FX;  
SR-B 400; XCT-B 400W.

**Brand name or trademark**

ESAB

**Manufacturer or his authorised representative established within the EEA****Name, address, and telephone No:**

ESAB AB  
Lindholmsallén 9, Box 8004, SE-402 77 Göteborg, Sweden  
Phone: +46 31 50 90 00, [www.esab.com](http://www.esab.com)

**The following harmonised standard in force within the EEA has been used in the design:**

EN 60974-7:2013, Arc Welding Equipment - Part 7: Torches

**By signing this document, the undersigned declares as manufacturer, or the manufacturer's authorised representative established within the EEA, that the equipment in question complies with the safety requirements stated above.**

Date

Gothenburg  
2019-08-26

Signature

  
Flavio Santos  
General Manager,  
Global Equipment Solutions

CE 2019

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# 1 SAFETY

**As used throughout this manual: Means Attention! Be Alert!**

**DANGER!**

Means immediate hazards which, if not avoided, will result in immediate, serious personal injury or loss of life.

**WARNING!**

Means potential hazards which could result in personal injury or loss of life.

**CAUTION!**

Means hazards which could result in minor personal injury.

**WARNING!**

Before use, read and understand the instruction manual and follow all labels, employer's safety practices and Safety Data Sheets (SDSs).



Users of ESAB equipment have the ultimate responsibility for ensuring that anyone who works on or near the equipment observes all the relevant safety precautions. Safety precautions must meet the requirements that apply to this type of equipment. The following recommendations should be observed in addition to the standard regulations that apply to the workplace.

All work must be carried out by trained personnel well-acquainted with the operation of the equipment. Incorrect operation of the equipment may lead to hazardous situations which can result in injury to the operator and damage to the equipment.

1. Anyone who uses the equipment must be familiar with:
  - its operation
  - location of emergency stops
  - its function
  - relevant safety precautions
  - welding and cutting or other applicable operation of the equipment
2. The operator must ensure that:
  - no unauthorised person is stationed within the working area of the equipment when it is started up
  - no-one is unprotected when the arc is struck or work is started with the equipment
3. The workplace must:
  - be suitable for the purpose
  - be free from drafts

4. Personal safety equipment:
  - Always wear recommended personal safety equipment, such as safety glasses, flame-proof clothing, safety gloves
  - Do not wear loose-fitting items, such as scarves, bracelets, rings, etc., which could become trapped or cause burns
5. General precautions:
  - Make sure the return cable is connected securely
  - Work on high voltage equipment **may only be carried out by a qualified electrician**
  - Appropriate fire extinguishing equipment must be clearly marked and close at hand
  - Lubrication and maintenance must **not** be carried out on the equipment during operation

**WARNING!**

Arc welding and cutting can be injurious to yourself and others. Take precautions when welding and cutting.

**ELECTRIC SHOCK - Can kill**

- Install and ground the unit in accordance with instruction manual.
- Do not touch live electrical parts or electrodes with bare skin, wet gloves or wet clothing.
- Insulate yourself from work and ground.
- Ensure your working position is safe

**ELECTRIC AND MAGNETIC FIELDS - Can be dangerous to health**

- Welders having pacemakers should consult their physician before welding. EMF may interfere with some pacemakers.
- Exposure to EMF may have other health effects which are unknown.
- Welders should use the following procedures to minimize exposure to EMF:
  - Route the electrode and work cables together on the same side of your body. Secure them with tape when possible. Do not place your body between the torch and work cables. Never coil the torch or work cable around your body. Keep welding power source and cables as far away from your body as possible.
  - Connect the work cable to the workpiece as close as possible to the area being welded.

**FUMES AND GASES - Can be dangerous to health**

- Keep your head out of the fumes.
- Use ventilation, extraction at the arc, or both, to take fumes and gases away from your breathing zone and the general area.

**ARC RAYS - Can injure eyes and burn skin**

- Protect your eyes and body. Use the correct welding screen and filter lens and wear protective clothing.
- Protect bystanders with suitable screens or curtains.

**NOISE - Excessive noise can damage hearing**

Protect your ears. Use earmuffs or other hearing protection.

**MOVING PARTS - Can cause injuries**



- Keep all doors, panels and covers closed and securely in place. Have only qualified people remove covers for maintenance and troubleshooting as necessary. Reinstall panels or covers and close doors when service is finished and before starting engine.



- Stop engine before installing or connecting unit.
- Keep hands, hair, loose clothing and tools away from moving parts.

**FIRE HAZARD**



- Sparks (spatter) can cause fire. Make sure that there are no inflammable materials nearby.
- Do not use on closed containers.

**HOT SURFACE - Parts can burn**



- Do not touch parts bare handed.
- Allow cooling period before working on equipment.
- To handle hot parts, use proper tools and/or insulated welding gloves to prevent burns.

**MALFUNCTION - Call for expert assistance in the event of malfunction.**

**PROTECT YOURSELF AND OTHERS!**



**CAUTION!**

This product is solely intended for arc welding.



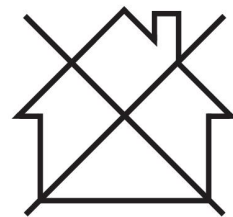
**WARNING!**

Do not use the power source for thawing frozen pipes.



**CAUTION!**

Class A equipment is not intended for use in residential locations where the electrical power is provided by the public low-voltage supply system. There may be potential difficulties in ensuring electromagnetic compatibility of class A equipment in those locations, due to conducted as well as radiated disturbances.





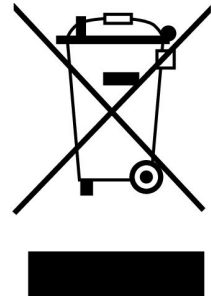
**NOTE!**

**Dispose of electronic equipment at the recycling facility!**

In observance of European Directive 2012/19/EC on Waste Electrical and Electronic Equipment and its implementation in accordance with national law, electrical and/or electronic equipment that has reached the end of its life must be disposed of at a recycling facility.

As the person responsible for the equipment, it is your responsibility to obtain information on approved collection stations.

For further information contact the nearest ESAB dealer.



**ESAB has an assortment of welding accessories and personal protection equipment for purchase. For ordering information contact your local ESAB dealer or visit us on our website.**

## 2 INTRODUCTION

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### 2.1 Overview

TIG torches **SR-B 9, SR-B 17, SR-B 26, SR-B 26-HD, SR-B 18, SR-B 20, SR-B 21, SR-B 400 and XCT-B 400W** are intended for manual TIG welding and available with water or air cooled versions.

Certain models are available with flex heads for unlimited movement in confined spaces.

**Accessories for the product can be found in the "ACCESSORIES" chapter of this manual.**

The TIG torch is supplied with:




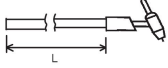



- wear parts (except electrodes):
  - Ø 1.6 mm (0.063 in.) SR-B 9
  - Ø 2.4 mm (0.094 in.) SR-B 17
  - Ø 2.4 mm (0.094 in.) SR-B 26
  - Ø 2.4 mm (0.094 in.) SR-B 26-HD
  - Ø 2.4 mm (0.094 in.) SR-B 20
  - Ø 2.4 mm (0.094 in.) SR-B 21
  - Ø 2.4 mm (0.094 in.) SR-B 400
  - Ø 2.4 mm (0.094 in.) XCT-B 400W
- instruction manual






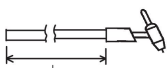



### 3 TECHNICAL DATA

Operating temperature range: -10 to +40 °C (+14 to +104 °F)

Transportation temperature range: -20 to +55 °C (+4 to +131 °F)

	<b>SR-B 9 9FX</b>	<b>SR-B 9V</b>	<b>SR-B 17 17FX</b>	<b>SR-B 17V</b>	<b>SR-B 26 26FX</b>	<b>SR-B 26V</b>
AC [A] / %	80/60		100/60		140/60	
DC [A] / %	110/60		140/60		200/60	
 Ømm	0.5–1.6 mm (0.02– 0.063 in.)		0.5–2.4 mm (0.02– 0.094 in.)		0.5–4.0 mm (0.02– 0.157 in.)	
	Ar Ar/He					
 L	4 & 8 m (13 & 26 ft)					
 0.5 A @ 42 V Max	X	-	X	-	X	-
 ⚡ max. kV	12 kV					
 Up max. V	113 V					

	<b>SR-B 26-HD 26FX-HD</b>	<b>SR-B 26V-HD</b>	<b>SR-B 18 18FX</b>	<b>SR-B 20 20FX</b>	<b>SR-B 21 21FX</b>	<b>SR-B 400</b>	<b>XCT-B 400W</b>
	-	-	X	X	X	X	X
 Max. °C	-		70 °C (158 °F)				
AC [A] / %	160/60		225/100	160/100	240/100	315/100	
DC [A] / %	230/60		320/100	220/100	340/100	450/100	
 Ømm	0.5–4.0 mm (0.02– 0.157 in.)			0.5–3.2 (0.02– 0.126 in.)		1.0–4.8 (0.039– 0.189 in.)	1.6–4.0 (0.063– 0.157 in.)
	Ar Ar/He						
 L	4 & 8 m (13 & 26 ft)						
 0.5 A @ 42 V Max	X	-	X	X	X	X	X

 max. kV	12 kV
 Up max. V	113 V

### Specification of the torch cooling circuit

(for water cooled torches only)

- min. water pressure: 2.5 bar
- max. water pressure: 4.0 bar

The necessary cooling power is dependent of the application, the welding parameters and the length of the torch. Sufficiency of available cooling power can be verified by measuring the return temperature of the cooling fluid. If the return temperature is above 60 °C (140 °F), the cooling power should be increased or the welding current should be reduced.

Recommended minimum values for cooling power and coolant flow rate			
Welding current / Torch length	Up to 300 A DC / 210 AAC	Up to 450 A DC / 315 AAC	Up to 500 A DC / 350 AAC
4 m	1.0 kW / 1.0 l/min	1.2 kW / 1.2 l/min	1.6 kW / 1.4 l/min
8 m	1.6 kW / 1.2 l/min	2.0 kW / 1.4 l/min	2.5 kW / 1.7 l/min

For other application parameters or longer cables, refer to additional documents that may have been included with your torch.



### CAUTION!

Return temperatures of more than 60 °C can cause damage or destruction of the torch. The cooler must always be filled with sufficient cooling liquid, refer the user manual of the cooling unit. In case of a high thermal load on the torch, use a cooler with sufficient capacity. Use only special cooling fluid containing corrosion inhibitors for welding torches. We recommend using ESAB CoolingFluid.

### Duty cycle

The duty cycle refers to the time as a percentage of a ten-minute period that you can weld or cut at a certain load without overloading. The duty cycle is valid for 40 °C (104 °F), or below.

Protection class	
The torches protection class machine side (EN 60 529)	IP3X

### Enclosure class

The **IP** code indicates the enclosure class, i.e. the degree of protection against penetration by solid objects of 2.5 mm Ø and greater. Omitting second characteristic numeral.

## 4 OPERATION

### 4.1 General

**General safety regulations for handling the equipment can be found in the "SAFETY" chapter of this manual. Read it through before you start using the equipment!**

Read the operating instructions for the welding components, e.g. power source and connect accordingly.

### 4.2 Connections

Tighten the connections for the torch carefully to avoid overheating the connection, connection interference, mechanical damage or leakage of liquid or gas.

Connect water connections to the torch so that the red terminal is always connected to the corresponding red terminal and the blue terminals are always connected to the corresponding blue terminals.

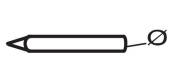

### 4.3 Choice of electrode

By alloying the tungsten electrode with 1% to 2% lanthanum or cerium the electron discharge is increased, which gives better striking and restriking and therefore increased arc stability.

Alloyed tungsten electrodes have a longer service life, tolerate higher currents and are less likely to leave tungsten residue in the weld.

<b>Pure tungsten electrode (AC)</b>	<b>Green</b>	<b>WP</b>	Used for welding light metal alloys.
<b>Cerium alloyed tungsten electrode (AC/DC)</b>	<b>Grey</b>	<b>WC20</b>	Used for welding light metals such as aluminium and magnesium. Electrode tip must be rounded when welding.
<b>Lanthanum alloyed tungsten electrode (DC)</b>	<b>Gold</b>	<b>WL15</b>	Usually used for welding stainless steel, steel, copper, titanium etc.
<b>Lanthanum alloyed tungsten electrode (AC/DC)</b>	<b>Black</b>	<b>WL10</b>	Used for welding light metal alloys, stainless steel, steel, copper, titanium etc.

#### Selection table

		A / AC			A / DC	
		W	CeO2	La2O3	CeO2	La2O3
1.0 mm (0.039 in.)	6.4/8.0 mm (0.252/0.315 in.)	10–60	-	15–100	70–80	20–100
1.6 mm (0.063 in.)	6.4/8.0/9.8 mm (0.252/0.315/0.386 in.)	50–100	60–90	70–160	80–140	80–160
2.4 mm (0.094 in.)	9.8/11.2/12.7 mm (0.386/0.441/0.500 in.)	100–160	90–130	110–200	150–210	120–230
3.2 mm (0.126 in.)	11.2/12.7 mm (0.441/0.500 in.)	130–180	140–190	150–205	220–320	200–305
4.0 mm (0.157 in.)	12.7 mm (0.500 in.)	180–230	200–250	180–270	330–420	250–420

## 4.4 Grinding

Grind tungsten electrodes according to the following table:



### NOTE!

Tungsten electrodes must be grounded lengthways. If they are incorrectly grounded, the arc may be unstable. When the welding current is increased, the angle must also be increased.

When welding with alternating current (AC), the electrode end must be gently rounded. Grinding the electrode is then unnecessary. Light grading of the edge is sufficient. The electrode forms itself if it is carefully overloaded. If the tip becomes ball shaped while welding using alternating current, this is a sign that the current is too high for the diameter of electrode being used.

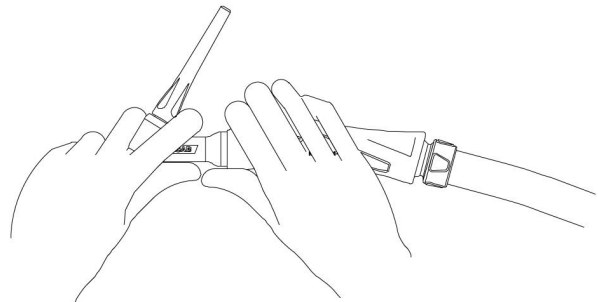
Welding current	Electrode angle	
20 A	30°	
20–100 A	30°–90°	
100–200 A	90°–120°	
over 200 A	120°	

## 4.5 Bending of the flexible torch

The life of the flexible torch is limited. The maximum bending angle should be 45 degrees.

The life of the torch head can be prolonged by proper technique.

Always make sure that the torch head is supported by the thumb when you bend. This prevents damages at sharp bendings.



## 4.6 Valve torches



### CAUTION!

Do not operate TIG torches with an integrated valve in the torch neck on welding systems equipped with an ignition and stabilization device.

## 5 MAINTENANCE

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**NOTE!**

Regular maintenance is important for safe and reliable operation.



**WARNING!**

The mains supply must be disconnected before cleaning.



**CAUTION!**

All warranty undertakings from the supplier cease to apply if the customer attempts any work to rectify any faults in the product during the warranty period.

### 5.1 Daily

- Check that all cables and hoses are undamaged and that there are no kinks in them.
- Check that the gas nozzle is free from defects and suitable for the work in question.
- Check that the shielding gas flows evenly and without restriction.
- Check that the electrode is undamaged and that the electrode has been ground to the correct angle.
- Check the water flow at the unit's return line.

## 6 TROUBLESHOOTING

Read the operating instructions for the welding components, e.g. power source.

If the measures described below are not successful, consult your dealer or the manufacturer.

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
The arc does not strike	<ul style="list-style-type: none"> <li>• Cable or contact is poor.</li> <li>• Torch electrode is badly oxidised.</li> <li>• There are impurities in the shielding gas (moisture, air).</li> <li>• The electrode used is too large or stubby at low current.</li> </ul>	<ul style="list-style-type: none"> <li>• Check the cable and contact.</li> <li>• Re grind along the length of the electrode.</li> <li>• Flush clean with gas.</li> <li>• Replace with a smaller electrode.</li> </ul>
No trigger function	<ul style="list-style-type: none"> <li>• Control cable interrupted/faulty.</li> </ul>	<ul style="list-style-type: none"> <li>• Check/repair.</li> </ul>
Gas shielding is poor	<ul style="list-style-type: none"> <li>• There are impurities in the shielding gas (moisture, air).</li> <li>• There are impurities in the base material (rust, lubricant).</li> <li>• Insufficient or total lack of shielding gas.</li> <li>• It is too draughty at the welding site.</li> <li>• Welding spray has fastened on the gas lens or the gas hood.</li> </ul>	<ul style="list-style-type: none"> <li>• Flush clean with gas.</li> <li>• Clean the base material.</li> <li>• Check contents of the gas bottle/hoses and the pressure setting.</li> <li>• Shield the welding area with protective screens.</li> <li>• Clean or replace.</li> </ul>

## 7 ORDERING SPARE PARTS

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### CAUTION!

Repair and electrical work should be performed by an authorised service technician. Use only original spare and wear parts.

**SR-B 9, SR-B 17, SR-B 26, SR-B 26-HD, SR-B 18, SR-B 20, SR-B 21, SR-B 400, XCT-B 400W** is designed and tested in accordance with the international and European standards **IEC-/ EN 60974-7**. On completion of service or repair work, it is the responsibility of the person(s) performing the work to ensure that the product still complies with the requirements of the above standard.

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see [esab.com](http://esab.com). When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.

## ORDERING NUMBERS

FX = flexible body, V = valve, HD = heavy duty, W = water cooled

Ordering no.	Type	Torch head			TSB 1025		TSB 3550				W
		Switch	Valve	F head	4 m 13 ft	8 m 26 ft	4 m 13 ft	8 m 26 ft	12 m 39 ft	16 m 52 ft	
0700025500	SR-B 9	X					X				
0700025501	SR-B 9	X						X			
0700025502	SR-B 9	X							X		
0700025503	SR-B 9	X								X	
0700025504	SR-B 9V		X		X						
0700025505	SR-B 9V		X			X					
0700025506	SR-B 9FX	X		X			X				
0700025507	SR-B 9FX	X		X				X			
0700025508	SR-B 17	X					X				
0700025509	SR-B 17	X						X			
0700025510	SR-B 17	X							X		
0700025511	SR-B 17	X								X	
0700025512	SR-B 17V		X		X						
0700025513	SR-B 17V		X			X					
0700025514	SR-B 17V		X				X				
0700025515	SR-B 17V		X					X			
0700025516	SR-B 17FX	X		X			X				
0700025517	SR-B 17FX	X		X				X			
0700025518	SR-B 26	X					X				
0700025519	SR-B 26	X						X			
0700025520	SR-B 26	X							X		
0700025521	SR-B 26	X								X	
0700025522	SR-B 26V		X				X				
0700025523	SR-B 26V		X					X			
0700025524	SR-B 26FX	X		X			X				
0700025525	SR-B 26FX	X		X				X			
0700025526	SR-B 26-HD	X					X				
0700025527	SR-B 26-HD	X						X			
0700025528	SR-B 26-HD	X							X		
0700025529	SR-B 26-HD	X								X	
0700025530	SR-B 26V-HD		X				X				
0700025531	SR-B 26V-HD		X					X			
0700025532	SR-B 26FX-HD	X		X			X				



ORDERING NUMBERS

0700025533	SR-B 26FX-HD	X		X				X			
0700025550	SR-B 18	X					X				X
0700025551	SR-B 18	X						X			X
0700025552	SR-B 18	X							X		X
0700025553	SR-B 18	X								X	X
0700025554	SR-B 18FX	X		X			X				X
0700025555	SR-B 18FX	X		X				X			X
0700025534	SR-B 20	X					X				X
0700025535	SR-B 20	X						X			X
0700025536	SR-B 20FX	X		X			X				X
0700025537	SR-B 20FX	X		X				X			X
0700025544	SR-B 21	X					X				X
0700025545	SR-B 21	X						X			X
0700025546	SR-B 21	X							X		X
0700025547	SR-B 21	X								X	X
0700025548	SR-B 21FX	X		X			X				X
0700025549	SR-B 21FX	X		X				X			X
0700025538	SR-B 400	X					X				X
0700025539	SR-B 400	X						X			X
0700025540	XCT-B 400W	X					X				X
0700025541	XCT-B 400W	X						X			X
0700025542	XCT-B 400W	X							X		X
0700025543	XCT-B 400W	X								X	X
0463698001	Spare parts list										

Spare parts and wear parts can be ordered through your nearest ESAB dealer, see [esab.com](http://esab.com). When ordering, please state product type, serial number, designation and spare part number in accordance with the spare parts list. This facilitates dispatch and ensures correct delivery.



**CAUTION!**

Repair and electrical work should be performed by an authorised ESAB service technician. Use only ESAB original spare and wear parts.

Technical documentation is available on the Internet at [www.esab.com](http://www.esab.com).

## WEAR PARTS

### Tungsten electrodes Eco

Ordering no. 150 mm	Ordering no. 175 mm	Tungsten electrodes Eco	Diameter	Colour	Code	Current
-	0151 574 009	Wolfram, pure	Ø 1.6	Green	WP	AC
0151 574 245	-	Wolfram, pure	Ø 2.0	Green	WP	AC
0151 574 210	0151 574 010	Wolfram, pure	Ø 2.4	Green	WP	AC
0151 574 211	0151 574 011	Wolfram, pure	Ø 3.2	Green	WP	AC
-	0151 574 012	Wolfram, pure	Ø 4.0	Green	WP	AC
0151 574 237	0151 574 037	Cerium 2%	Ø 1.6	Grey	WC20	AC/DC
0151 574 242	-	Cerium 2%	Ø 2.0	Grey	WC20	AC/DC
0151 574 238	0151 574 038	Cerium 2%	Ø 2.4	Grey	WC20	AC/DC
0151 574 239	0151 574 039	Cerium 2%	Ø 3.2	Grey	WC20	AC/DC
0151 574 240	0151 574 040	Cerium 2%	Ø 4.0	Grey	WC20	AC/DC
0151 574 230	0151 574 050	Lanthanum 1.5%	Ø 1.0	Gold	WL15	AC/DC
0151 574 231	0151 574 051	Lanthanum 1.5%	Ø 1.6	Gold	WL15	AC/DC
0151 574 243	0151 574 246	Lanthanum 1.5%	Ø 2.0	Gold	WL15	AC/DC
0151 574 232	0151 574 052	Lanthanum 1.5%	Ø 2.4	Gold	WL15	AC/DC
0151 574 233	0151 574 053	Lanthanum 1.5%	Ø 3.2	Gold	WL15	AC/DC
0151 574 234	0151 574 054	Lanthanum 1.5%	Ø 4.0	Gold	WL15	AC/DC
0151 574 235	0151 574 055	Lanthanum 1.5%	Ø 4.8	Gold	WL15	AC/DC

### SR-B 9, SR-B 20, SR-B 21

Nozzles, collets, collet bodies and gas lenses:

**Bold = standard delivery**

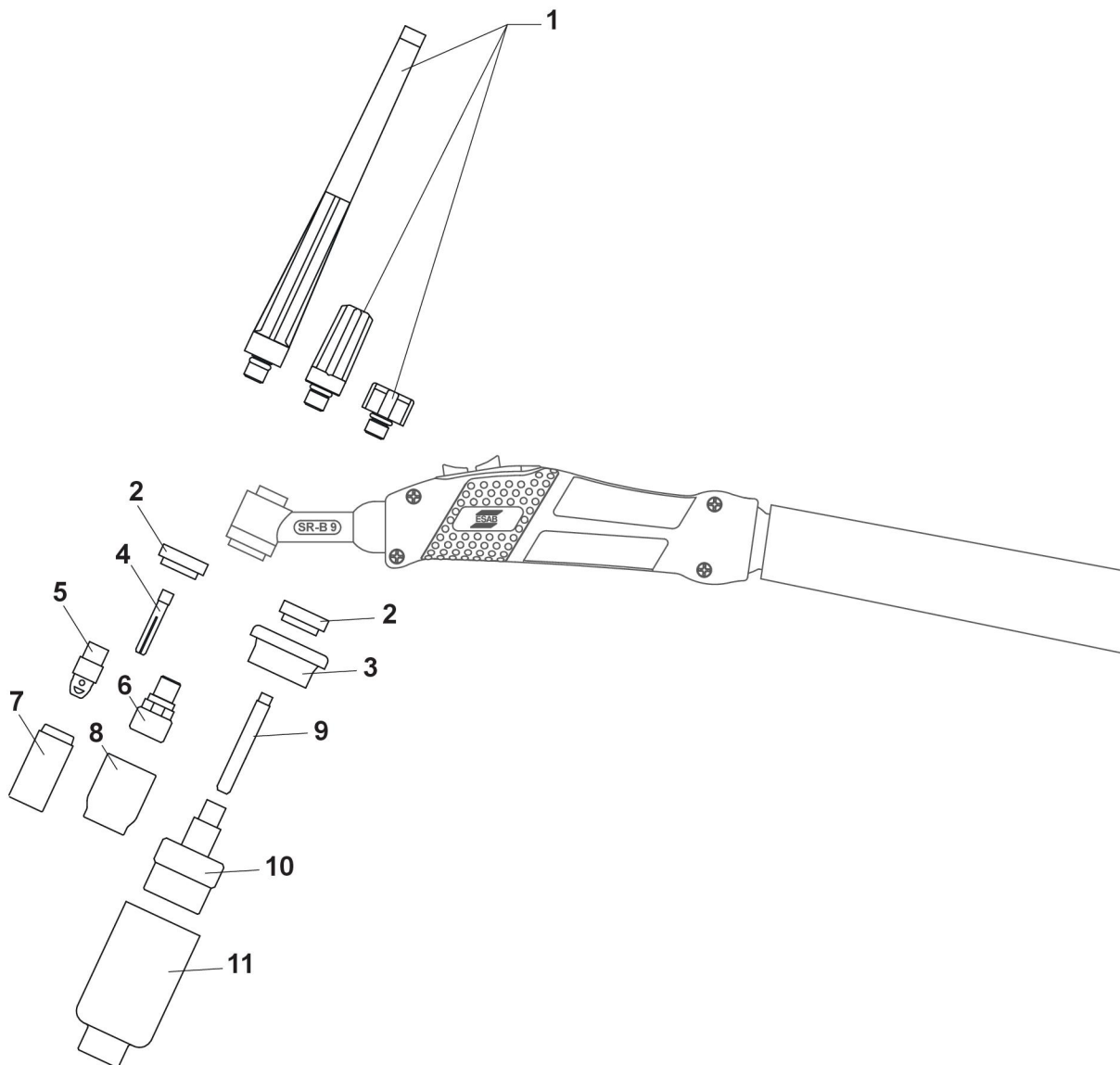
Item	Size	Description	Ordering no.
<b>1</b>	Long	Back cap	<b>0365 310 051</b>
	Medium		0365 310 050
	Short		0365 310 049
<b>2</b>		Heat shield	<b>0366 960 017</b>
<b>3</b>		Adaptor Jumbo gas lens	0157 123 026
<b>4</b>	Ø 0.5	Collet standard	0365 310 027
	Ø 1.0		0365 310 028
	Ø 1.6		<b>0365 310 029</b>
	Ø 2.0	Std. for SR-B 9	0700 025 662
	Ø 2.4		<b>0365 310 030</b>
	Ø 3.0		0700 025 663
	Ø 3.2		0365 310 091
	Std. for SR-B 20/21		

## WEAR PARTS

<b>5</b>	Ø 1.0	Collet body standard	0365 310 037
	Ø 1.6	Std. for SR-B 9	<b>0365 310 038</b>
	Ø 2.4	Std. for SR-B 20/21	<b>0365 310 039</b>
	Ø 3.2		0365 310 090
<b>6</b>	Ø 1.0	Collet body with gas lens	0157 121 016
	Ø 1.6		0157 121 017
	Ø 2.4		0157 121 018
	Ø 3.2		0157 121 041
<b>7</b>	Ø 6.4 (No. 4)	Gas nozzle standard	0365 310 044
	Ø 8.0 (No. 5)	L=30 mm	0365 310 045
	Ø 9.8 (No. 6)	Std. for SR-B 9	<b>0365 310 046</b>
	Ø 11.2 (No.7)	Std. for SR-B 20/21	<b>0365 310 047</b>
	Ø 12.7 (No. 8)		0365 310 048
	Ø 15.9 (No. 10)		0588 000 440
not illustrated	Ø 5.0 (No. 3)	Gas nozzle standard	0700 025 664
	Ø 6.4 (No. 4)	L=48 mm	0700 025 665
	Ø 8.0 (No. 5)		0700 025 666
	Ø 9.5 (No. 6)		0700 025 667
	Ø 6.5 (No. 4)	L=63 mm	0700 025 668
	Ø 8.0 (No. 5)		0700 025 669
	Ø 9.5 (No. 6)		0700 025 670
	Ø 6.5 (No. 4)	L=89 mm	0700 025 671
<b>8</b>	Ø 6.4 (No.4)	Gas nozzle for gas lens	0157 121 032
	Ø 8.0 (No.5)	L=25.5 mm	0157 121 033
	Ø 9.8 (No.6)		0157 121 034
	Ø 11.2 (No.7)		0157 121 039
	Ø 12.7 (No.8)		0157 121 040
	Ø 16.0 (No. 10)		0700 025 698
not illustrated	Ø 6.4 (No. 4)	Gas nozzle for gas lens	0700 025 658
	Ø 8.0 (No. 5)	L=35 mm	0700 025 659
	Ø 9.8 (No. 6)		0700 025 660
	Ø 11.2 (No.7)		0700 025 661
	Ø 16.0 (No. 10)		0700 025 699
<b>9</b>	Ø 1.0	Collet for Jumbo gas lens	0700 025 672
	Ø 1.6		0700 025 673
	Ø 2.4		0700 025 674
	Ø 3.2		0700 025 675

WEAR PARTS

<b>10</b>	Ø 1.0-1.6	Gas lens, Jumbo	0700 025 676
	Ø 2.4		0700 025 677
	Ø 3.2		0700 025 678
<b>11</b>	Ø 9.8 (No. 6)	Gas nozzle for Jumbo gas lens	0157 123 088
	Ø 12.7 (No. 8)		0157 123 089
	Ø 15.9 (No. 10)	L=48 mm	0588 000 438
	Ø 19.0 (No. 12)		0157 123 098
	Ø 24.0		0588 000 437
	Ø 24.0	L=34 mm	0700 025 679



**SR-B 17, SR-B 26, SR-B 18**

Nozzles, collets, collet bodies and gas lenses:

**Bold = standard delivery**

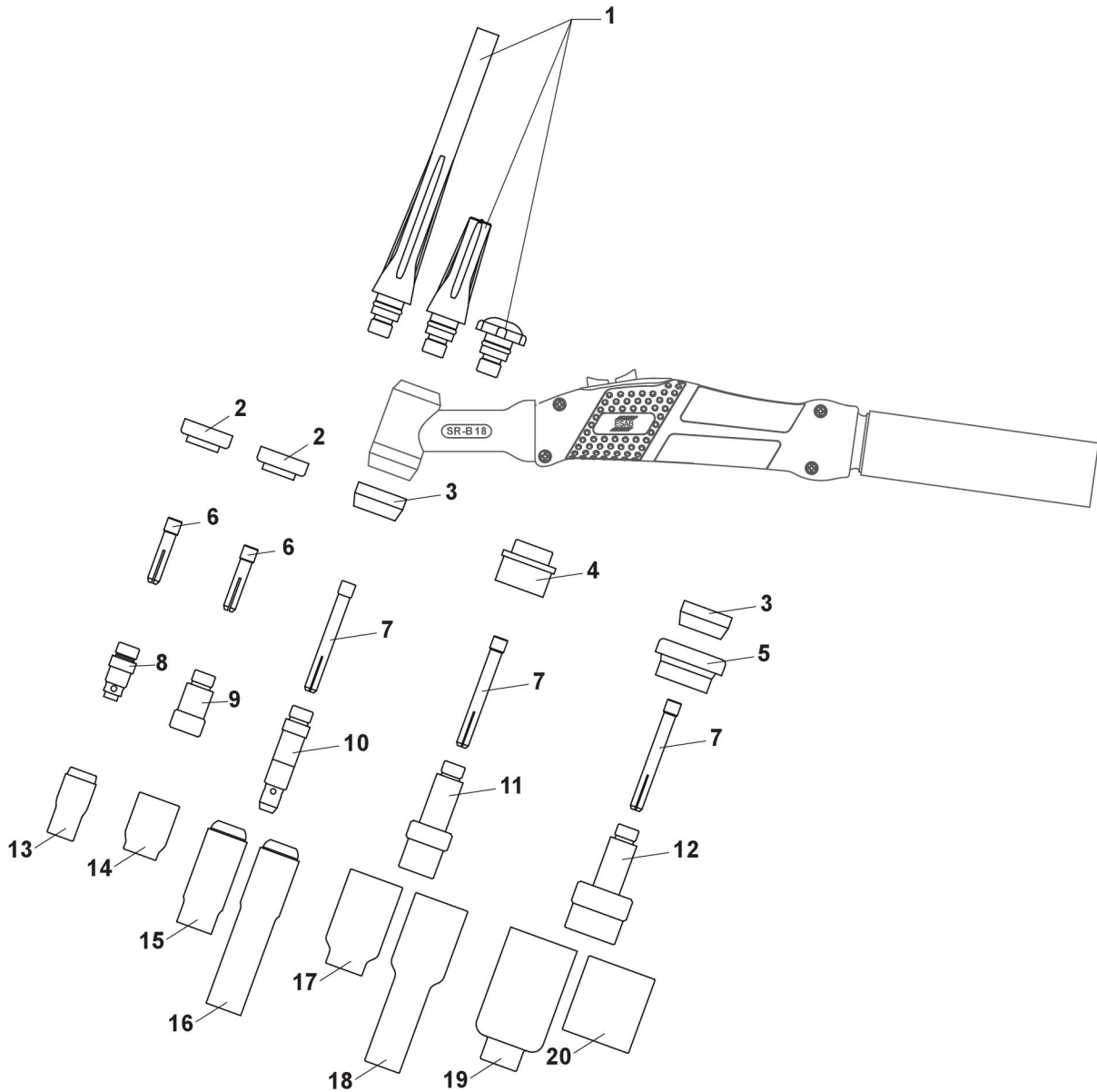
Item	Size	Description	Ordering no.
<b>1</b>	Long	Back cap	<b>0157 123 029</b>
	Medium		0588 000 591
	Short		0157 123 028
<b>2</b>		Heat shield small	0700 025 680
<b>3</b>		Heat shield	<b>0366 960 016</b>
<b>4</b>		Heat shield gas lens	0366 960 020
<b>5</b>		Heat shield large gas lens	0366 960 021
<b>6</b>	Ø 1.0	Collet standard and for gas lens, short	0349 501 216
	Ø 1.6		0349 501 217
	Ø 2.4		0349 501 218
	Ø 3.2		0349 501 219
<b>7</b>	Ø 0.5	Collet standard and for gas lens	0157 123 009
	Ø 1.0		0157 123 010
	Ø 1.6		0157 123 011
	Ø 2.0		0700 025 681
	Ø 2.4		<b>0157 123 012</b>
	Ø 3.0		0700 025 682
	Ø 3.2		0157 123 013
	Ø 4.0		0157 123 014
<b>8</b>	Ø 1.0-1.6	Collet body short	0700 025 683
	Ø 2.0-2.4		0700 025 684
	Ø 3.2		0700 025 685
<b>9</b>	Ø 1.0-1.6	Collet body with gas lens, short	0700 025 686
	Ø 2.4		0700 025 687
	Ø 3.2		0700 025 688
<b>10</b>	Ø 0.5-1.6	Collet body standard	0157 123 016
	Ø 2.0-2.4		<b>0157 123 017</b>
	Ø 3.0-3.2		0157 123 018
	Ø 4.0		0157 123 019
<b>11</b>	Ø 1.0	Collet body with gas lens, standard	0157 123 021
	Ø 1.6		0157 123 022
	Ø 2.0-2.4		0157 123 023
	Ø 3.0-3.2		0157 123 024
	Ø 4.0		0157 123 025

## WEAR PARTS

<b>12</b>	Ø 1.0	Collet body with extra large gas lens	0157 123 083
	Ø 1.6		0157 123 084
	Ø 2.0-2.4		0157 123 085
	Ø 3.0-3.2		0157 123 086
	Ø 4.0		0588 000 087
<b>13</b>	Ø 6.4 (No. 4)	Gas nozzle L=30 mm	0365 310 044
	Ø 8.0 (No. 5)		0365 310 045
	Ø 9.8 (No. 6)		0365 310 046
	Ø 11.2 (No. 7)		0365 310 047
	Ø 12.7 (No. 8)		0365 310 048
	Ø 15.9 (No. 10)		0588 000 440
<b>14</b>	Ø 6.4 (No. 4)	Gas nozzle for gas lens, short L=25.5 mm	0157 121 032
	Ø 8.0 (No. 5)		0157 121 033
	Ø 9.8 (No. 6)		0157 121 034
	Ø 11.2 (No. 7)		0157 121 039
	Ø 12.7 (No. 8)		0157 121 040
<b>15</b>	Ø 6.4 (No. 4)	Gas nozzle standard L=47 mm	0157 123 052
	Ø 8.0 (No. 5)		0157 123 053
	Ø 9.8 (No. 6)		<b>0157 123 054</b>
	Ø 11.2 (No. 7)		0157 123 055
	Ø 12.7 (No. 8)		0157 123 056
	Ø 15.9 (No. 10)		0588 000 442
	Ø 19 (No. 12)		0588 000 441
<b>16</b>	Ø 6.4 (No. 4)	Gas nozzle standard L=76 mm	0700 025 689
	Ø 8.0 (No. 5)		0700 025 690
	Ø 9.8 (No. 6)		0700 025 691
	Ø 11.2 (No. 7)		0700 025 692
<b>17</b>	Ø 6.4 (No. 4)	Gas nozzle for gas lens L=42 mm	0157 123 057
	Ø 8.0 (No. 5)		0157 123 058
	Ø 9.8 (No. 6)		0157 123 059
	Ø 11.2 (No. 7)		0157 123 060
	Ø 12.7 (No. 8)		0157 123 061
	Ø 17.5 (No. 11)		0588 000 439
<b>18</b>	Ø 6.4 (No. 4)	Gas nozzle for gas lens L=76 mm	0700 025 693
	Ø 8.0 (No. 5)		0700 025 694
	Ø 9.8 (No. 6)		0700 025 695
	Ø 11.2 (No. 7)		0700 025 696
	Ø 12.7 (No. 8)		0700 025 697

WEAR PARTS

<b>19</b>	Ø 9.8 (No. 6)	Gas nozzle for gas lens, large L=48 mm	0157 123 088
	Ø 12.5 (No. 8)		0157 123 089
	Ø 15.9 (No. 10)		0588 000 438
	Ø 19 (No. 12)		0157 123 098
	Ø 24		0588 000 437
<b>20</b>	Ø 24	Gas nozzle for gas lens, short L=34 mm	0700 025 679



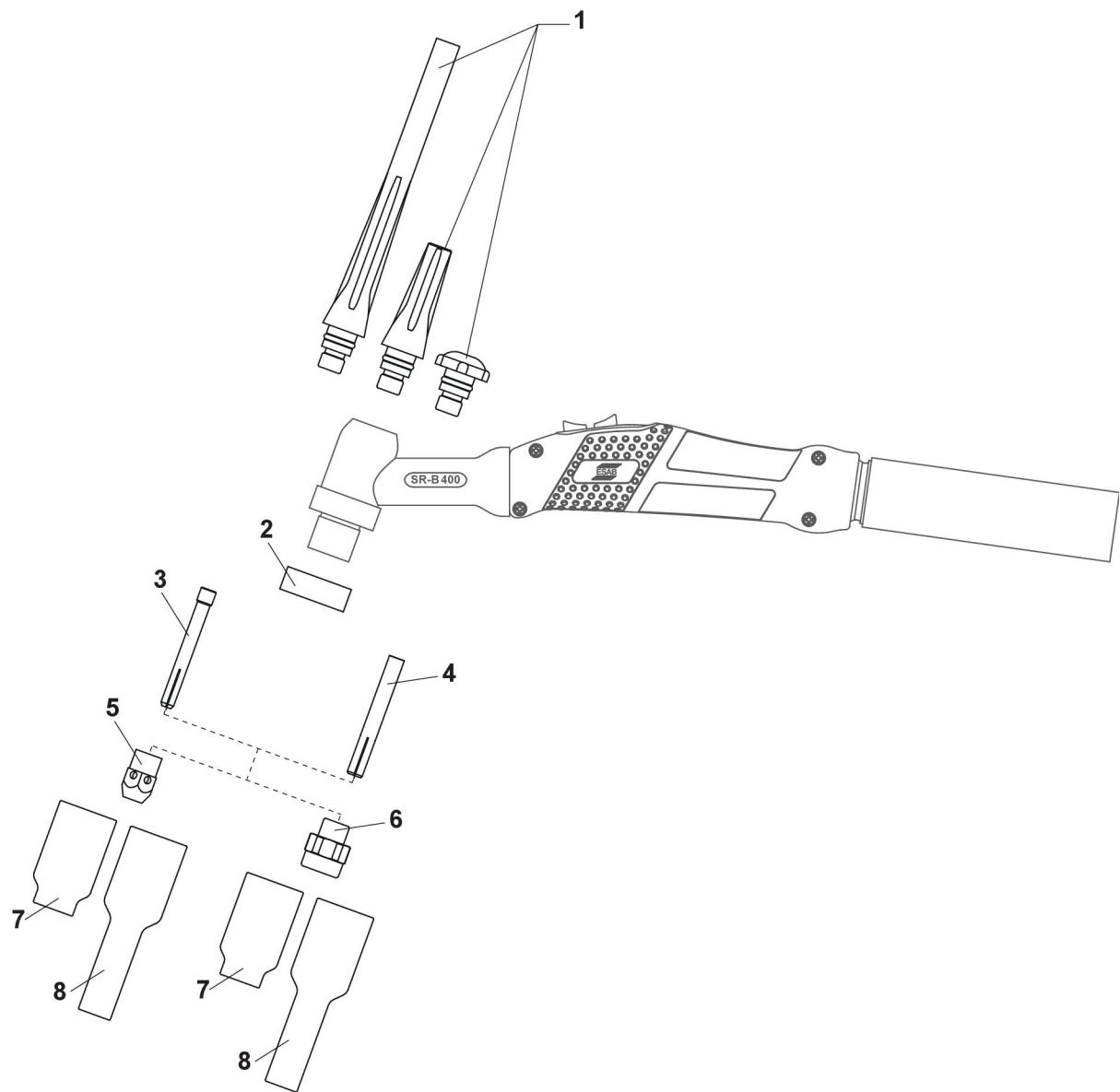
**SR-B 400**

Nozzles, collets, collet bodies and gas lenses:

**Bold = standard delivery**

Item	Size	Description	Ordering no.
<b>1</b>	Long	Back cap	<b>0157 123 029</b>
	Medium		0588 000 591
	Short		0157 123 028
<b>2</b>		Heat shield	<b>0366 960 018</b>
<b>3</b>	Ø 1.0	Collet standard and for gas lens	0157 123 010
	Ø 1.6		0157 123 011
	Ø 2.4		<b>0157 123 012</b>
	Ø 3.2		0157 123 013
	Ø 4.0		0157 123 014
<b>4</b>	Ø 2.4	Collet, heavy duty	0157 123 077
	Ø 3.2		0157 123 078
	Ø 4.0		0157 123 079
	Ø 4.8		0157 123 074
<b>5</b>	Ø 1.0-3.2	Collet body standard	<b>0157 123 081</b>
	Ø 3.2-4.8		0157 123 082
<b>6</b>	Ø 1.0	Collet body with gas lens	0157 123 091
	Ø 1.6		0157 123 092
	Ø 2.4		0157 123 093
	Ø 3.2		0157 123 094
	Ø 4.0		0157 123 095
	Ø 4.8		0157 123 075
<b>7</b>	Ø 6.4 (No. 4)	Gas nozzle standard and for gas lens L=42 mm	0157 123 057
	Ø 8.0 (No. 5)		0157 123 058
	Ø 9.8 (No. 6)		<b>0157 123 059</b>
	Ø 11.2 (No. 7)		0157 123 060
	Ø 12.7 (No. 8)		0157 123 061
	Ø 17.5		0588 000 439
<b>8</b>	Ø 6.4 (No. 4)	Gas nozzle standard and for gas lens L=76 mm	0700 025 693
	Ø 8.0 (No. 5)		0700 025 694
	Ø 9.8 (No. 6)		0700 025 695
	Ø 11.2 (No. 7)		0700 025 696
	Ø 12.7 (No. 8)		0700 025 697



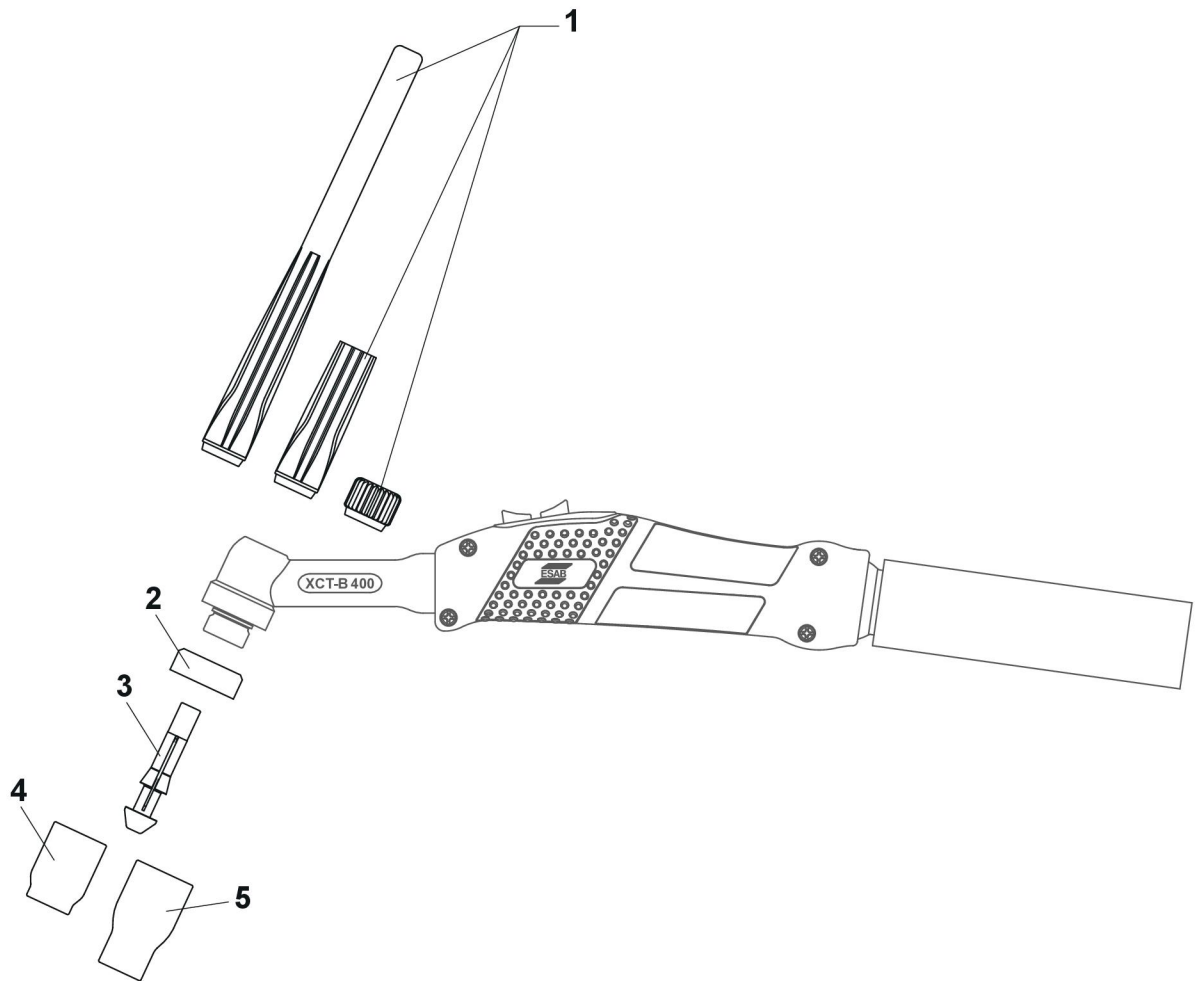


**XCT-B 400W**

Nozzles, collets, collet bodies and gas lenses:

**Bold = standard delivery**

Item	Size	Description	Ordering no.
<b>1</b>	Long	Back cap	<b>0700 025 650</b>
	Medium		0700 025 651
	Short		0700 025 652
<b>2</b>		Heat shield	<b>0700 025 653</b>
<b>3</b>	Ø 1.6	Collet standard	0700 025 654
	Ø 2.4		<b>0700 025 655</b>
	Ø 3.2		0700 025 656
	Ø 4.0		0700 025 657
<b>4</b>	Ø 6.4 (No. 4)	Gas nozzle standard L=25.5 mm	0157 121 032
	Ø 8.0 (No. 5)		0157 121 033
	Ø 9.8 (No. 6)		0157 121 034
	Ø 11.2 (No. 7)		0157 121 039
	Ø 12.7 (No. 8)		0157 121 040
	Ø 16.0 (No. 10)		0700 025 698
<b>5</b>	Ø 6.4 (No. 4)	Gas nozzle standard L=35.0 mm	0700 025 658
	Ø 8.0 (No. 5)		0700 025 659
	Ø 9.8 (No. 6)		0700 025 660
	Ø 11.2 (No. 7)		<b>0700 025 661</b>
	Ø 16.0 (No. 10)		0700 025 699





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