

TIG CATALOG 4.2



**TIG Welding Technology for all
Metalworking Industries.**

POLSAB
TECHNIKA SPAWALNICZA

**ABICOR
BINZEL®** 

www.binzel-abicor.com



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TIG Welding Torches "ABITIG® GRIP"

air and liquid cooled

ABITIG® GRIP – the complete solution in the field of TIG welding torches. This range represents a logical development of the ABITIG® torch range, which has distinguished itself by its consistent implementation of modular design and optimum ergonomics.

The torches in various ratings, both air and liquid cooled, are fitted with a uniform ergonomic handle with "GRIP" and optimised cable assembly management, into which numerous switch and control functions can be integrated. All consumables are compatible to the international "SR-Standard".

The flexible cable assemblies are available with modular and robust machine-side connections.

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
- Short ball joint for optimum movement radius and ideal handling
- Light and flexible cable assemblies with modular machine-side connections for most available TIG welding power sources
- Consumables compatible to the international standard

ABITIG® GRIP 9

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	110 A DC 80 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–1.6 mm

ABITIG® GRIP 20 / ABITIG® GRIP 20 SC

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	240 A DC / 320 A DC 170 A AC / 220 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 0.5–3.2 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.



Torch complete

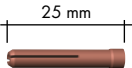
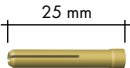
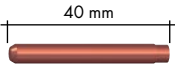
Type	Cooling	Part-No.	Torch body	Part-No.
ABITIG® GRIP 9	air cooled	see comment ²	Standard; 46.0 mm	712.5020
ABITIG® GRIP 9 F	air cooled	see comment ²	Flexible; 46.0 mm	712.5030
ABITIG® GRIP 20 / SC	liquid cooled	see comment ²	Standard; 46.0 mm	712.3020
ABITIG® GRIP 20 F	liquid cooled	see comment ²	Flexible; 46.0 mm	712.3030
ABITIG® GRIP 20 F	liquid cooled	see comment ²	Flexible; 75.0 mm	712.3040.1
ABITIG® GRIP 20 F	liquid cooled	see comment ²	Flexible; 110.0 mm	712.3050.1

² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binz-abicor.com.

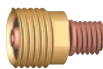
ABITIG® GRIP 9, ABITIG® GRIP 20, ABITIG® GRIP 20 SC

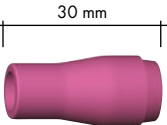
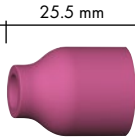
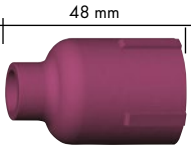
Wear parts

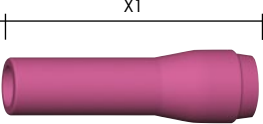
			
Back cap (10 pcs.)	Short	Medium	Long
	701.0240 / 41V33	701.0244 / 41V35	701.0247 / 41V24

			
	25 mm	25 mm	40 mm
Collet (10 pcs.)	Standard version	Brass version	Jumbo version
Ø 0.5 mm	701.0249 / 13N20	701.1060	701.1225 / 13N20L
Ø 1.0 mm	701.0250 / 13N21	701.1061	701.1226 / 13N21L
Ø 1.2 mm	701.0254 / -	-	-
Ø 1.6 mm	701.0251 / 13N22	701.1019	701.1227 / 13N22L
Ø 2.0 mm	701.0255 / -	-	-
Ø 2.4 mm	701.0252 / 13N23	701.1020	701.1228 / 13N23L
Ø 3.2 mm	701.0253 / 13N24	701.1063	701.1229 / 13N24L

		
Insulating ring / Adaptor	Insulating ring (10 pcs.)	Adaptor (5 pcs.)
	702.0055 / 598882	701.1234 / 54N63-20

			
Collet body (10 pcs.)	Standard version	Standard version with gas lens	Jumbo version with gas lens
Ø 0.5–1.0 mm	701.0275 / 13N26	701.0301 / 45V42	701.1230 / 45V0204S
Ø 1.2 mm	701.0279 / -	701.0313 / -	-
Ø 1.6 mm	701.0276 / 13N27	701.0307 / 45V43	701.1231 / 45V116S
Ø 2.0 mm	701.0280 / -	701.0315 / -	-
Ø 2.4 mm	701.0277 / 13N28	701.0309 / 45V44	701.1232 / 45V64S
Ø 3.2 mm	701.0278 / 13N29	701.0311 / 45V45	701.1233 / 995795S

			
	30 mm	25.5 mm	48 mm
Gas nozzle, ceramic (10 pcs.)	Standard version	Standard version for gas lens	Jumbo version for gas lens
No. 4 Ø 6.5 mm	701.0281 / 13N08	701.0317 / 53N58	-
No. 5 Ø 8.0 mm	701.0282 / 13N09	701.0318 / 53N59	-
No. 6 Ø 9.5 mm	701.0283 / 13N10	701.0319 / 53N60	701.1199 / 57N75
No. 7 Ø 11.0 mm	701.0284 / 13N11	701.0320 / 53N61	-
No. 8 Ø 12.5 mm	701.0285 / 13N12	701.0322 / 53N61S	701.1200 / 57N74
No. 10 Ø 16.0 mm	701.0286 / 13N13	-	701.1201 / 53N88
No. 12	-	-	701.1121 / 53N87

		
	X1	34 mm
Gas nozzle, ceramic (10 pcs.)	Standard version	Jumbo version for gas lens¹
No. 4 Ø 6.5 mm 48 mm	701.0289 / 796F71	701.1202 / 53N89
No. 5 Ø 8.0 mm 48 mm	701.0290 / 796F72	
No. 6 Ø 9.5 mm 48 mm	701.0291 / 796F73	
No. 4 Ø 6.5 mm 63 mm	701.0293 / 796F75	
No. 5 Ø 8.0 mm 63 mm	701.0294 / 796F76	
No. 4 Ø 6.5 mm 89 mm	701.0296 / 796F79	

¹ not suitable for high frequency

TIG Welding Torches "ABITIG® GRIP"

air and liquid cooled



ABITIG® GRIP handle system –
see page 44–45

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
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- Consumables compatible to the international standard

ABITIG® GRIP 17

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	140 A DC
	100 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–2.4 mm

ABITIG® GRIP 18

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	320 A DC
	230 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 0.5–4.0 mm

¹Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.9 l/min.

ABITIG® GRIP 26

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	180 A DC
	130 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–4.0 mm

Technical data based on cable assembly
lengths of up to 8.00 m.

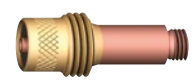
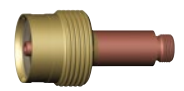
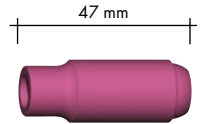
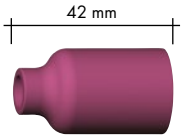
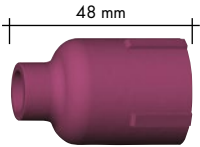
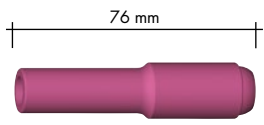
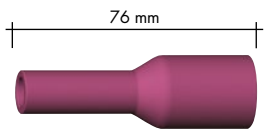
Torch complete

Type	Cooling	Part-No.	Torch body	Part-No.
ABITIG® GRIP 17	air cooled	see comment ²	Standard; 65.0 mm	712.1020
ABITIG® GRIP 17 F	air cooled	see comment ²	Flexible; 65.0 mm	712.1030
ABITIG® GRIP 18	liquid cooled	see comment ²	Standard; 69.0 mm	712.2020
ABITIG® GRIP 18 F	liquid cooled	see comment ²	Flexible; 69.0 mm	712.2030
ABITIG® GRIP 18 K	liquid cooled	see comment ²	Short; 59.0 mm	712.2230
ABITIG® GRIP 26	air cooled	see comment ²	Standard; 79.0 mm	712.4020
ABITIG® GRIP 26 F	air cooled	see comment ²	Flexible; 79.0 mm	712.4030
ABITIG® GRIP 26 K	air cooled	see comment ²	Short; 59.0 mm	712.4230

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ABITIG® GRIP 17, ABITIG® GRIP 18, ABITIG® GRIP 26

Wear parts

					
Back cap (10 pcs.)		Short		Long	
		712.1053		712.1051	
					
Collet (10 pcs.)		Version (50 mm)		Version (52 mm)	
Ø 0.5 mm		702.0005 / 10N21		701.0169 / 10N21D	
Ø 1.0 mm		702.0006 / 10N22		701.0171 / 10N22D	
Ø 1.2 mm		702.0007 / -		701.0170 / -	
Ø 1.6 mm		702.0008 / 10N23		701.0172 / 10N23D	
Ø 2.0 mm		702.0012 / -		701.0176 / -	
Ø 2.4 mm		702.0009 / 10N24		701.0173 / 10N24D	
Ø 3.2 mm		702.0010 / 10N25		701.0174 / 10N25D	
Ø 4.0 mm		702.0011 / 54N20		701.0175 / 54N20D	
					
Insulating ring / Adaptor		Insulating ring (10 pcs.)		Adaptor (10 pcs.)	
		703.0012 / 18CG		701.0130 / 54N01	
				Adaptor (5 pcs.)	
				701.1122 / 54N63	
					
Collet body		Standard version (10 pcs.)		Standard version with gas lens (10 pcs.)	
Ø 0.5–1.2 mm		701.0190 / 10N30		701.0201 / 45V24	
Ø 1.6 mm		701.0191 / 10N31		701.0203 / 45V25	
Ø 2.0 mm		701.0196 / 10N32		701.0207 / 45V26	
Ø 2.4 mm		701.0196 / 10N32		701.0207 / 45V26	
Ø 3.2 mm		701.0197 / 10N28		701.0209 / 45V27	
Ø 4.0 mm		701.0198 / 406488		701.0211 / 45V28	
					
				Jumbo version with gas lens (5 pcs.)	
Ø 0.5–1.2 mm		701.0190 / 10N30		701.0201 / 45V24	
Ø 1.6 mm		701.0191 / 10N31		701.0203 / 45V25	
Ø 2.0 mm		701.0196 / 10N32		701.0207 / 45V26	
Ø 2.4 mm		701.0196 / 10N32		701.0207 / 45V26	
Ø 3.2 mm		701.0197 / 10N28		701.0209 / 45V27	
Ø 4.0 mm		701.0198 / 406488		701.0211 / 45V28	
				701.1116 / 45V116	
				701.1117 / 45V64	
				701.1118 / 995795	
				701.1208 / 45V63	
					
Gas nozzle, ceramic (10 pcs.)		Standard version		Standard version for gas lens	
No. 4 Ø 6.5 mm		701.0107 / 10N50		701.0420 / 54N18	
No. 5 Ø 8.0 mm		701.0108 / 10N49		701.0421 / 54N17	
No. 6 Ø 9.5 mm		701.0109 / 10N48		701.0422 / 54N16	
No. 7 Ø 11.0 mm		701.0110 / 10N47		701.0423 / 54N15	
No. 8 Ø 12.5 mm		701.0111 / 10N46		701.0424 / 54N14	
No. 10 Ø 16.0 mm		701.0113 / 10N45		-	
No. 12 Ø 19.5 mm		701.0114 / 10N44 ¹		701.0426 / 54N19	
					
				Jumbo version for gas lens	
No. 4 Ø 6.5 mm		701.0107 / 10N50		701.0420 / 54N18	
No. 5 Ø 8.0 mm		701.0108 / 10N49		701.0421 / 54N17	
No. 6 Ø 9.5 mm		701.0109 / 10N48		701.0422 / 54N16	
No. 7 Ø 11.0 mm		701.0110 / 10N47		701.0423 / 54N15	
No. 8 Ø 12.5 mm		701.0111 / 10N46		701.0424 / 54N14	
No. 10 Ø 16.0 mm		701.0113 / 10N45		-	
No. 12 Ø 19.5 mm		701.0114 / 10N44 ¹		701.0426 / 54N19	
				701.1199 / 57N75	
				701.1200 / 57N74	
				701.1201 / 53N88	
				701.1121 / 53N87	
					
Gas nozzle, ceramic (10 pcs.)		Standard version		Standard version for gas lens	
No. 5 Ø 8.0 mm		701.0115 / 10N49L		701.0427 / 54N17L	
No. 6 Ø 9.5 mm		701.0116 / 10N48L		701.0428 / 54N16L	
No. 7 Ø 11.0 mm		701.0117 / 10N47L		701.0429 / 54N15L	
Ø 24.0 mm		-		-	
					
				Jumbo version for gas lens²	
No. 5 Ø 8.0 mm		701.0115 / 10N49L		701.0427 / 54N17L	
No. 6 Ø 9.5 mm		701.0116 / 10N48L		701.0428 / 54N16L	
No. 7 Ø 11.0 mm		701.0117 / 10N47L		701.0429 / 54N15L	
Ø 24.0 mm		-		-	
				701.1202 / 53N89	

¹ 50 mm long

² not suitable for high frequency

TIG Welding Torches "ABITIG® GRIP"

air and liquid cooled

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
- Short ball joint for optimum movement radius and ideal handling
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- Consumables compatible to the international standard



ABITIG® GRIP handle system –
see page 44–45

ABITIG® GRIP 24 G

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	110 A DC
	80 A AC
Duty cycle:	35 %
Tungsten electrodes:	Ø 0.5 – 1.6 mm

ABITIG® GRIP 24 W

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	140 A DC
	100 A AC
Duty cycle:	100 %
Tungsten electrodes:	Ø 0.5 – 2.4 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly
lengths of up to 8.00 m.

Torch complete

Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 24 G	air cooled	see comment ²	Standard; 55.0 mm	712.7020
ABITIG® GRIP 24 W	liquid cooled	see comment ²	Standard; 55.0 mm	712.7120

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ABITIG® GRIP 24 G, ABITIG® GRIP 24 W

Wear parts



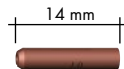
**Insulating sleeve /
Insulator** (10 pcs.)

Insulating sleeve



Insulator for gas lens

	701.0458 / 53N22	701.0459 / 53N66
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Collet (10 pcs.)

Standard version

Standard version for gas lens

Ø 0.5 mm	-	-
Ø 1.0 mm	701.0453 / 53N16	701.0462 / 53N63
Ø 1.2 mm	701.0455 / -	-
Ø 1.6 mm	701.0454 / 53N14	701.0463 / 54N64
Ø 2.0 mm	701.0456 / -	701.0466 / -
Ø 2.4 mm	701.0457 / 24C332	701.0465 / 24GLC332

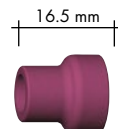


Collet body (10 pcs.)

Standard version

Standard version with gas lens

Ø 0.5 mm	701.0479 / 53N17	701.0301 / 45V41
Ø 1.0 mm	701.0480 / 53N18	701.0301 / 45V42
Ø 1.2 mm	701.0483 / -	701.0313 / -
Ø 1.6 mm	701.0481 / 53N19	701.0307 / 45V43
Ø 2.0 mm	701.0484 / -	701.0315 / -
Ø 2.4 mm	701.0482 / 24CB332	701.0309 / 45V44

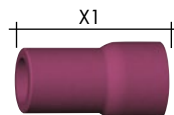


Gas nozzle, ceramic
(10 pcs.)

Standard version

Standard version for gas lens

No. 4 Ø 6.5 mm	701.0468 / 53N24	701.0317 / 53N58
No. 5 Ø 8.0 mm	701.0469 / 53N25	701.0318 / 53N59
No. 6 Ø 9.5 mm	701.0470 / 53N27	701.0319 / 53N60
No. 7 Ø 11.0 mm	-	701.0320 / 53N61



Gas nozzle, ceramic
(10 pcs.) **X1**

Standard version

No. 4L Ø 6.5 mm 29.0 mm	701.0471 / 53N28
No. 6L Ø 9.5 mm 29.0 mm	701.0472 / 53N26
No. 4L Ø 6.5 mm 62.5 mm	701.0473 / 53N24L
No. 5L Ø 8.0 mm 91.5 mm	701.0474 / 53N27L

TIG Welding Torches "ABITIG® GRIP"

liquid cooled

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- Consumables compatible to the international standard



ABITIG® GRIP 12-1

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	350 A DC 250 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.0 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.

Torch complete

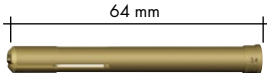
Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 12-1	liquid cooled	see comment ²	Standard; 70.0 mm	712.0020

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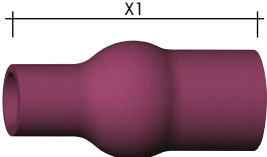
ABITIG® GRIP 12-1

Wear parts

		
Back cap (10 pcs.)	Short	Long
	712.0053	712.0051

	
Collet (10 pcs.)	Standard version
Ø 1.6 mm	712.0062
Ø 2.4 mm	712.0063
Ø 3.2 mm	712.0064
Ø 4.0 mm	712.0065

		
Collet body (10 pcs.)	Standard version	Standard version with gas lens
Ø 1.6 mm	712.0072	712.0101
Ø 2.4 mm	712.0073	712.0102
Ø 3.2 mm	712.0074	712.0103
Ø 4.0 mm	712.0075	712.0104

	
Gas nozzle, ceramic	Standard version
(10 pcs.) X1	
No. 4 Ø 6.5 mm 43 mm	704.0046 / 130.00
No. 5 Ø 8.0 mm 43 mm	704.0047 / 131.00
No. 6 Ø 9.5 mm 43 mm	704.0048 / 132.00
No. 7 Ø 11.0 mm 43 mm	704.0049 / 133.00
No. 8 Ø 12.5 mm 43 mm	704.0050 / 134.00
No. 9 Ø 14.5 mm 43 mm	704.0051 / 135.00
No. 10 Ø 16.0 mm 43 mm	704.0052 / 136.00
No. 11 Ø 17.5 mm 48 mm	704.0053 / 137.00

TIG Welding Torches "ABITIG® GRIP"

liquid cooled

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
- Short ball joint for optimum movement radius and ideal handling
- Light and flexible cable assemblies with modular machine-side connections for all available TIG welding power sources
- Consumables compatible to the international standard



ABITIG® GRIP 18 SC

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	400 A DC 280 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 0.5–4.8 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.9 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.

Torch complete

Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 18 SC	liquid cooled	see comment ²	Standard; 75.0 mm	712.6020

² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

ABITIG® GRIP 18 SC

Wear parts

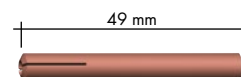
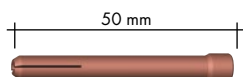


Back cap (10 pcs.)

Short

Long

	712.1053	712.1051
--	----------	----------



Collet (10 pcs.)

Standard version

HL version¹

Ø 0.5 mm	702.0005 / 10N21	-
Ø 1.0 mm	702.0006 / 10N22	-
Ø 1.6 mm	702.0008 / 10N23	-
Ø 2.4 mm	702.0009 / 10N24	-
Ø 3.2 mm	702.0010 / 10N25	712.6064 / 10N25HD
Ø 4.0 mm	-	712.6065 / 54N20HD
Ø 4.8 mm	-	712.6066 / 18C36



Insulating ring (5 pcs.)

Insulating ring

	712.6043 / 18NG
--	-----------------



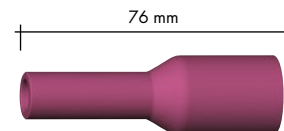
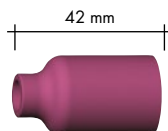
Collet body (10 pcs.)

Standard version

Standard version with gas lens

HL version¹

Ø 0.5 mm	-	712.6099 / 18GL02	-
Ø 1.0 mm	-	712.6100 / 18GL04	-
Ø 1.6 mm	-	712.6101 / 18GL16	-
Ø 2.4 mm	-	712.6102 / 18GL32	-
Ø 3.2 mm	-	712.6103 / 18GL18	-
Ø 4.0 mm	-	712.6104 / 18GL53	-
Ø 4.8 mm	-	712.6105 / 18GL36	-
Ø 0.5–3.2 mm	712.6074 / NCB-53	-	-
Ø 3.2–4.8 mm	-	-	712.6076 / NCB-36



Gas nozzle, ceramic (10 pcs.)

Standard version

Standard version

No. 4 Ø 6.5 mm	701.0420 / 54N18	-
No. 5 Ø 8.0 mm	701.0421 / 54N17	701.0427 / 54N17L
No. 6 Ø 9.5 mm	701.0422 / 54N16	701.0428 / 54N16L
No. 7 Ø 11.0 mm	701.0423 / 54N15	701.0429 / 54N15L
No. 8 Ø 12.5 mm	701.0424 / 54N14	-
No. 12 Ø 19.5 mm	701.0426 / 54N19	-

¹ Please note: HL = Heavy duty version

TIG Welding Torches "ABITIG®" with rotary valve

air cooled



- Rotary valve for regulating gas mounted directly on the torch body
- Light and flexible cable assemblies for all common TIG welding power sources
- Consumables compatible to the international standard

ABITIG® 9 V / FV¹

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	110 A DC
	80 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–1.6 mm

ABITIG® 17 V / FV¹

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	140 A DC
	100 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–2.4 mm

ABITIG® 26 V / FV¹

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	180 A DC
	130 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 0.5–4.0 mm

¹ FV = Torch body (with rotary valve)
Flexible

Torch complete		Part-No.		Torch body	
Type	Version ²	4 m	8 m	Type	Part-No.
ABITIG® 9 V	Rotary valve / Plug 10-25	706.5057	706.5058	Standard; 60.0 mm	705.0007
ABITIG® 9 FV	Rotary valve / Plug 10-25	on demand	on demand	Flexible; 78.0 mm	703.0311.1
ABITIG® 17 V	Rotary valve / Plug 10-25	706.1057	706.1058	Standard; 65.0 mm	705.0038
ABITIG® 17 V	Rotary valve / Plug 35-50	706.1037	706.1038	Standard; 65.0 mm	705.0038
ABITIG® 17 FV	Rotary valve / Plug 10-25	706.1157	706.1158	Flexible; 80.0 mm	703.0010
ABITIG® 17 FV	Rotary valve / Plug 35-50	706.1137	706.1138	Flexible; 80.0 mm	703.0010
ABITIG® 26 V	Rotary valve / Plug 35-50	706.4037	706.4038	Standard; 80.0 mm	705.0091
ABITIG® 26 FV	Rotary valve / Plug 35-50	706.4137	706.4138	Flexible; 80.0 mm	703.0290

² Power cable / gas hose separate, gas hose with G1/4" union nut. Other versions available on request.

Wear parts – back cap, collet, collet body, adaptor, insulating ring and gas nozzle – are identical with those of the same type for ABITIG® torches.

Notes

TIG Welding Torch "ABITIG® GRIP Little"

air and liquid cooled

After having been welcomed by TIG welders all over the world for many years, the ABITIG® GRIP Little product range provides perfect access and optimum handling and now has been extended by adding the ABITIG® GRIP Little 90 as well as the ABITIG® GRIP Little 180 W torches.

The new ABITIG® GRIP Little 90 and 180 W torches with their small, ergonomic handle are the ideal solution in cases of particularly restricted access or demanding quality requirements. Nobody has to do without the well-known benefits of this torch series:

- Ergonomic "GRIP" handles for a reliable grip and a perfect feel
- Modular switching and control functions in the handle – personalised and user-friendly
- Excellent HF security
- Lightweight and flexible cable-hose assemblies with modular connectors to most standard TIG welding equipment at the machine end
- Optimised service life due to a significantly larger current and process temperature transfer area
- Reduced stocking requirements – just three spare parts



ABITIG® GRIP Little 90

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	90 A DC 60 A AC
Duty cycle:	35 %
Tungsten electrodes:	Ø 1.0–1.6 mm

ABITIG® GRIP Little 180 W

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	180 A DC 130 A AC
Duty cycle:	100 %
Tungsten electrodes:	Ø 1.0–3.2 mm

¹Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.

Torch complete

Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP Little 90	air cooled	see comment ²	Standard; 60.0 mm	770.0040.1
ABITIG® GRIP Little 180 W	liquid cooled	see comment ²	Standard; 60.0 mm	772.0040.1

² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

ABITIG® GRIP Little 90, ABITIG® GRIP Little 180 W

Wear parts



Back cap (10 pcs.)

Short

Standard

771.0053

771.0051



Spring (10 pcs.)

771.0037



Electrode holder/ Gas diffuser (5 pcs.)

Electrode holder

Gas diffuser

Gas diffuser cylindrical

Ø 1.0 mm

771.0061

771.0111

-

Ø 1.6 mm

771.0062

771.0112

-

Ø 2.0 mm

771.0067

771.0117

-

Ø 2.4 mm

771.0063

771.0113

771.0123

Ø 3.2 mm

771.0064

771.0114

771.0124



Gas nozzle, ceramic

Standard

Standard

(10 pcs.)

Ø 6.0 mm (No. 1)

771.0081

-

Ø 8.0 mm (No. 2)

771.0082

-

Ø 10.5 mm (No. 3)

771.0083

771.0083



Gas nozzle, ceramic

Long

Long

(10 pcs.)

Ø 6.0 mm (No. 1)

771.2171

-

Ø 8.0 mm (No. 2)

771.2172

-

Ø 10.5 mm (No. 3)

771.2173

771.2173

TIG Welding Torches "ABITIG® GRIP"

air and liquid cooled

The ABITIG® GRIP line "ABICOR BINZEL-Style", air and liquid cooled, offer leading edge performance in a comfortable and light weight package. The cooling system guarantees long service life and enables the use of smaller tungsten electrodes through optimised heat dissipation.

The reduction in the quantity of consumables to only three components (back cap, electrode holder / gas diffuser and threaded gas nozzle) simplifies use and helps reduce stocking costs.

The innovative torch design prevents the heat from the gas nozzle reaching the torch body. This protects the torch, increases service life and further reduces operating costs.

The intelligent ABITIG® GRIP handle offers increased comfort due to the integration of numerous switching and control functions. Furthermore it is well protected against high frequency (HF) flashover.

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
- Short ball joint for optimum movement radius and ideal handling
- Light and flexible cable assemblies with modular machine-side connections for most available TIG welding power sources
- Reduced storage costs with only three consumable parts



ABITIG® GRIP 150 / ABITIG® GRIP 150 F

Technical data (EN 60 974-7): (with gas nozzle 36 mm):

Type of cooling:	air cooled
Rating:	150 A DC 105 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 1.0–2.4 mm

ABITIG® GRIP 260 W / ABITIG® GRIP 260 W SC

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	260 A DC / 340 A DC 185 A AC / 240 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.0–3.2 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

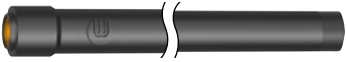
Technical data based on cable assembly
lengths of up to 8.00 m.

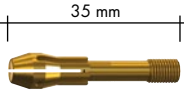
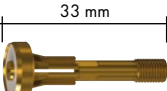
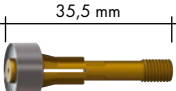
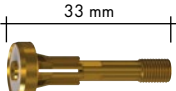
Torch complete			Torch body	
Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 150	air cooled	see comment ²	Standard; 60.0 mm	776.0010
ABITIG® GRIP 150 F	air cooled	see comment ²	Flexible; 60.0 mm	776.0130
ABITIG® GRIP 260 W / SC	liquid cooled	see comment ²	Standard; 60.0 mm	777.0010

² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

ABITIG® GRIP 150, ABITIG® GRIP 260 W, ABITIG® GRIP 260 W SC

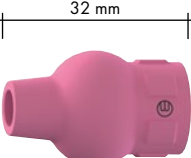
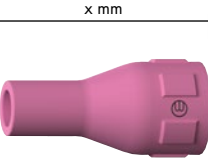
Wear parts

			
Back cap (10 pcs.)	Short	Medium	Long
	776.0053	771.0051	772.0051.10

				
Electrode holder / Gas diffuser (5 pcs.)	Electrode holder	Gas diffuser	Gas diffuser	Gas diffuser
Ø 1.0 mm	776.0061	776.0171	777.0171.5	776.0171
Ø 1.6 mm	776.0062	776.0172	777.0172.5	776.0172
Ø 2.0 mm	776.0067	776.0177	777.0177.5	776.0177
Ø 2.4 mm	776.0063	776.0173	777.0173.5	776.0173
Ø 3.2 mm	776.0064	776.0174	777.0174.5	776.0174

		
	Standard version	for gas diffuser
	(10 pcs.)	(1 pc.)
Insulator	776.1043	776.0443
Adaptor ring	-	776.0441

		
Gas diffuser 4 (1 pc.)	Standard	Multilayer
Ø 1.6 mm	775.0122	775.0127.1
Ø 2.4 mm	775.0123	775.0128.1
Ø 3.2 mm	775.0124	775.0129.1

				
Gas nozzle, ceramic	Standard version	Ball version	Standard version	For gas diffuser
(10 pcs.)			x = 36 mm x = 60 mm	
Ø 6.5 mm	777.0081	770.0081.10	777.2171 777.2175	-
Ø 8.0 mm	777.0082	770.0082.10	777.2172 777.2176	-
Ø 9.5 mm	777.0083	770.0083.10	777.2173 -	-
Ø 11.0 mm	777.0084	770.0084.10	777.2174 -	-
Ø 12.5 mm	-	-	- -	778.1183
Ø 16.0 mm	-	-	- -	778.1184
Ø 19.5 mm	-	-	- -	778.1188
Ø 24.3 mm	-	-	- -	778.1189 ³

³ Without figure: cylindrical form, length 34.0 mm; not suitable for high frequency.

TIG Welding Torches "ABITIG® GRIP"

air and liquid cooled



- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle – individually and ergonomically
- Short ball joint for optimum movement radius and ideal handling
- Light and flexible cable assemblies with modular machine-side connections for most available TIG welding power sources
- Reduced storage costs with only three consumable parts

ABITIG® GRIP 200 / ABITIG® GRIP 200 F

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	200 A DC 140 A AC
Duty cycle:	35 %
Tungsten electrodes:	Ø 1.6–3.2 mm

ABITIG® GRIP 450 W / WK / WKF

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	420 A DC / 400 A DC 300 A AC / 280 A AC
Duty cycle:	60 % / 100 %
Tungsten electrodes:	Ø 1.6–4.8 mm

ABITIG® GRIP 450 W SC

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	480 A DC / 450 A DC 340 A AC / 320 A AC
Duty cycle:	60 % / 100 %
Tungsten electrodes:	Ø 1.6–4.8 mm

¹ Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.

Torch complete			Torch body	
Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 200	air cooled	see comment ²	Standard; 80.0 mm	774.0010
ABITIG® GRIP 200 F	air cooled	see comment ²	Flexible; 80.0 mm	774.0130
ABITIG® GRIP 200 K	air cooled	see comment ²	Short; 60.0 mm	774.0230
ABITIG® GRIP 450 W	liquid cooled	see comment ²	Standard; 80.0 mm	775.0010
ABITIG® GRIP 450 WK	liquid cooled	see comment ²	Short; 60.0 mm	775.0230
ABITIG® GRIP 450 WF	liquid cooled	see comment ²	Flexible; 80.0 mm	775.0238.1
ABITIG® GRIP 450 WKF	liquid cooled	see comment ²	Short; flexible; 60.0 mm	775.0233.1

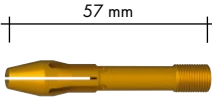
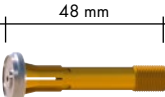
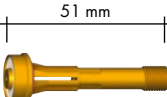
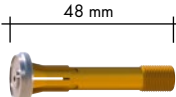
The torch bodies (standard and short) for ABITIG® 450 W SC are identical with those for ABITIG® 450 W. The complete torches differ only in terms of the layout of the cable assembly.

² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

ABITIG® GRIP 200, ABITIG® GRIP 450 W, ABITIG® GRIP 450 W SC

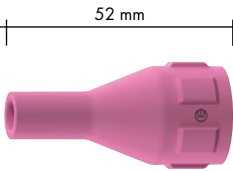
Wear parts

			
Back cap	Short (10 pcs.) 773.0053	Medium (1 pc.) 773.0055.1	Long (10 pcs.) 773.0051

				
Electrode holder / Gas diffuser (5 pcs.)	Electrode holder	Gas diffuser	Gas diffuser	Gas diffuser
Ø 1.6 mm	775.0062	773.0172	773.0112.5	773.0172
Ø 2.0 mm	775.0067	773.0177	-	773.0177
Ø 2.4 mm	775.0063	773.0173	773.0113	773.0173
Ø 3.2 mm	775.0064	773.0174	773.0114	773.0174
Ø 4.0 mm	775.0065	773.0175	-	773.0175
Ø 4.8 mm	775.0066	773.0176	-	773.0176

		
Insulator	Standard version (10 pcs.) 775.1043	For gas diffuser (1 pc.) 775.1143

		
Gas diffuser 4 (1 pc.)	Standard	Multilayer
Ø 1.6 mm	775.0122	775.0127.1
Ø 2.4 mm	775.0123	775.0128.1
Ø 3.2 mm	775.0124	775.0129.1
Ø 4.0 mm	775.0125	775.0130.1
Ø 4.8 mm	775.0126	-

			
Gas nozzle, ceramic (10 pcs.)	Standard version x = 26 mm x = 37 mm	Standard version	For gas diffuser
Ø 7.5 mm	- 775.0081	775.2171	-
Ø 10.0 mm	775.0152 ³ 775.0082	775.2172	-
Ø 12.5 mm	- -	-	778.1183
Ø 13.0 mm	775.0153 ³ 775.0083	775.2173	-
Ø 13.0 mm (boosted)	- 775.0183	-	-
Ø 15.0 mm	- 775.0084	775.2174	-
Ø 15.0 mm (boosted)	- 775.0184	-	-
Ø 16.0 mm	- -	-	778.1184
Ø 19.5 mm	- -	-	778.1188
Ø 24.3 mm	- -	-	778.1189 ⁴

³ Only in combination with gas diffuser 48 mm (773.0172-773.0177).

⁴ Without figure: cylindrical form, length 34.0 mm; not suitable for high frequency.

TIG Welding Torch "ABITIG® GRIP"

liquid cooled

In the upper performance level ABITIG® GRIP 500 W is the ideal solution and exceeds the product portfolio of the ABITIG® GRIP torch series in an optimal way. High performance welding for all thick sheet TIG welding applications.

This powerful torch offers all known advantages of the ABITIG® GRIP torch series:

- Best arc characteristics and reliable gas coverage up to 500 A
- Ergonomic "GRIP" handles for a reliable grip and a perfect feel
- Modular switching and control functions in the handle – personalised and user-friendly
- Short ball joint provides maximum mobility, flexibility and ideal handling
- Excellent HF security
- Lightweight and flexible cable-hose assemblies with modular connectors to all standard TIG welding equipment at the machine end
- Optimised service life due to a significantly larger current and process temperature transfer area
- Reduced stocking requirements – just three spare parts



ABITIG® GRIP 500 W

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled ¹
Rating:	500 A DC
	350 A AC
Duty cycle:	100 %
Tungsten electrodes:	Ø 1.6–6.4 mm

¹Torch input pressure:
Min. 2.5 bar (max. 3.5 bar);
Min. flow rate: 0.7 l/min.

Technical data based on cable assembly lengths of up to 8.00 m.

Torch complete

Type	Cooling	Part-No.	Version	Part-No.
ABITIG® GRIP 500 W	liquid cooled	see comment ²	Standard; 79.0 mm	775.0041.1

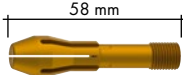
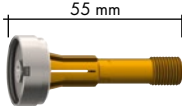
² Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

ABITIG® GRIP 500 W

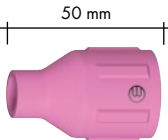
Wear parts

		
Back cap (1 pc.)	Short	Standard
	775.0053.1	775.0051.1

	
Insulator (1 pc.)	Insulator
	775.0058.1

		
Electrode holder/ Gas diffuser (1 pc.)	Electrode holder	Gas diffuser
Ø 1.6 mm	779.6044	779.6058
Ø 2.0 mm	779.6049	779.6063
Ø 2.4 mm	779.6045	779.6059
Ø 3.2 mm	779.6046	779.6060
Ø 4.0 mm	779.6047	779.6061
Ø 4.8 mm	779.6048	779.6062
Ø 6.4 mm	779.6050	779.6064

		
Gas nozzle, ceramic (10 pcs.)		Short³
Ø 24.0 mm	-	778.1189

	
Gas nozzle, ceramic (10 pcs.)	Standard
Ø 12.5 mm	778.1183
Ø 16.0 mm	778.1184
Ø 19.5 mm	778.1188

³ Not suitable for high frequency.

TIG Welding Torches “ABITIG® GRIP Little”

air and liquid cooled

The welding torch line ABITIG® GRIP Little – particularly suited to those everyday, less accessible welding jobs. Maximum flexibility with no compromises.

The torches of various ratings, both air and liquid cooled, are combined with a standardized ergonomic handle with “GRIP” and optimised cable

assembly management, into which standard switching and control functions can be integrated.

In addition the flexible cable assemblies are available with modular and robust machine-side connections.



Technical data (EN 60 974-7):

TIG Welding Torches “ABITIG® GRIP Little” (air cooled)

Type	Rating (A)		Duty cycle (%)	Tungsten electrodes (Ø in mm)
	DC	AC		
ABITIG® GRIP Little 9 / 9 F	110	80	35	0.5–1.6
ABITIG® GRIP Little 17 / 17 F	140	100	35	0.5–2.4
ABITIG® GRIP Little 24 G	110	80	35	0.5–1.6
ABITIG® GRIP Little 90	90	60	35	1.0–1.6
ABITIG® GRIP Little 150 / 150 F	140	100	35	1.0–2.4

TIG Welding Torches “ABITIG® GRIP Little” (liquid cooled)

Type	Rating (A)		Duty cycle (%)	Tungsten electrodes (Ø in mm)
	DC	AC		
ABITIG® GRIP Little 20 / 20 F	220	150	100	0.5–3.2
ABITIG® GRIP Little 24 W	140	100	100	0.5–2.4
ABITIG® GRIP Little 180 W	180	130	100	1.0–3.2
ABITIG® GRIP Little 260 W	240	170	100	1.0–3.2

Subject to change without notice.

- One ergonomic handle with "GRIP" for all ABITIG® GRIP torch types – offers high gripability and optimum feel
- Modular switching and control functions integrated into the handle
- Excellent protection against high frequency flashover

- Light and flexible cable assemblies (High-Flex-Leather) with modular machine-side connections for most available TIG welding power sources
- Consumables (Types 9 / 17 / 20 / 24) compatible to the international standard
- Air cooled up to 140 A – at 35% duty cycle
- Liquid cooled up to 240 A – at 100% duty cycle

ABITIG® GRIP Little
handle system –
even smaller, even lighter
(see page 44–45)



- 1 ABITIG® 9 / 9 F
- 2 ABITIG® 17 / 17 F
- 3 ABITIG® 20 / 20 F
- 4 ABITIG® 24 G
- 5 ABITIG® 24 W
- 6 ABITIG® 90
- 7 ABITIG® 150 / 150 F
- 8 ABITIG® 180 W
- 9 ABITIG® 260 W

Torch complete

Type	Handle	Part-No.	Torch body	
ABITIG® 9 ¹	ABITIG® GRIP Little	see comment ³	Standard; 46.0 mm	705.0001
ABITIG® 9 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 46.0 mm	703.0001
ABITIG® 17 ¹	ABITIG® GRIP Little	see comment ³	Standard; 65.0 mm	705.0033
ABITIG® 17 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 62.0 mm	703.0009
ABITIG® 20 ¹	ABITIG® GRIP Little	see comment ³	Standard; 46.0 mm	705.0058
ABITIG® 20 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 46.0 mm	703.0302
ABITIG® 20 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 75.0 mm	703.0305
ABITIG® 20 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 110.0 mm	703.0306
ABITIG® 24 G ¹	ABITIG® GRIP Little	see comment ³	Standard; 55.0 mm	705.0075
ABITIG® 24 W ¹	ABITIG® GRIP Little	see comment ³	Standard; 55.0 mm	705.0080
ABITIG® 90 ²	ABITIG® GRIP Little	see comment ³	Standard; 60.0 mm	770.0040.1
ABITIG® 150 ¹	ABITIG® GRIP Little	see comment ³	Standard; 46.0 mm	770.0010.1
ABITIG® 150 F ¹	ABITIG® GRIP Little	see comment ³	Flexible; 46.0 mm	770.0130.1
ABITIG® 180 W ²	ABITIG® GRIP Little	see comment ³	Standard; 60.0 mm	772.0040.1
ABITIG® 260 W ¹	ABITIG® GRIP Little	see comment ³	Standard; 46.0 mm	772.0010.1

¹ Wear parts see "ABITIG® GRIP" torches of similar design (Page 4–13 and 18–21).

² Wear parts see page 16 and 17.

³ Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. Please use the TIG torch overview for the order of complete torches – this you can find in the download area of our website www.binzel-abicor.com.

TIG Machine Torches “ABITIG® MT”

air and liquid cooled

The compact designed machine torches of the ABITIG®-MT series represent an effective solution for welding operations with simple geometries.

With a wide range of current options, the torches are available in both air and liquid cooled options, with side mounted cable assemblies.

- Compact in design
- Rugged cable assemblies suitable for all established welding machines
- Ideally suited for welding operations with simple geometries



ABITIG® 150 MT

Technical data (EN 60 974-7):

Type of cooling: air cooled
Rating: 150 A DC
110 A AC
Duty cycle: 60%
Tungsten electrodes: Ø 1.0–3.2 mm

ABITIG® 260 W MT

Technical data (EN 60 974-7):

Type of cooling: liquid cooled
Rating: 260 A DC
180 A AC
Duty cycle: 100%
Tungsten electrodes: Ø 1.0–3.2 mm

Torch complete			Torch body	
Type	Cooling	Part-No.	Type	Part-No.
ABITIG® 150 MT	air cooled	see comment ¹	Standard; 214.0 mm	778.1020
ABITIG® 260 W MT	liquid cooled	see comment ¹	Standard; 214.0 mm	779.1020

¹ Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. For the order of complete torches please indicate the cable assembly length and the machine side connection.

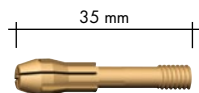
ABITIG® 150 MT, ABITIG® 260 W MT

Wear parts

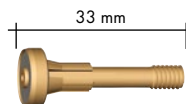
Guide tube (1 pc.)



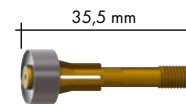
779.1030



Electrode holder



Gas diffuser



Gas diffuser

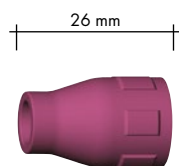
Electrode holder / Gas diffuser (5 pcs.)

	Electrode holder	Gas diffuser	Gas diffuser
Ø 1.0 mm	776.0061	776.0171	777.0171.5
Ø 1.6 mm	776.0062	776.0172	777.0172.5
Ø 2.0 mm	776.0067	776.0177	777.0177.5
Ø 2.4 mm	776.0063	776.0173	777.0173.5
Ø 3.2 mm	776.0064	776.0174	777.0174.5

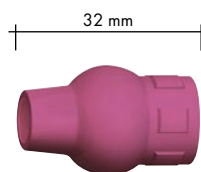
Insulator (1 pc.)



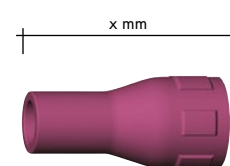
779.1043



Standard version



Ball version



Long version

Gas nozzle, ceramic (10 pcs.)

			x = 36 mm	x = 60 mm
Ø 6.5 mm	777.0081	770.0081.10	777.2171	777.2175
Ø 8.0 mm	777.0082	770.0082.10	777.2172	777.2176
Ø 9.5 mm	777.0083	770.0083.10	777.2173	-
Ø 11.0 mm	777.0084	770.0084.10	777.2174	-

TIG Machine Torches "ABITIG® MT"

air and liquid cooled



- Compact in design
- Rugged cable assemblies suitable for all established welding machines
- ABITIG® 200 MT / 300 W MT with adjustable tungsten electrode
- Ideally suited for welding operations with simple geometries

ABITIG® 200 MT

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	200 A DC
	140 A AC
Duty cycle:	60%
Tungsten electrodes:	Ø 1.6–4.0 mm

ABITIG® 300 W MT

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	300 A DC
	210 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.8 mm

Torch complete

Type	Cooling	Part-No.
ABITIG® 200 MT	air cooled	see comment ¹
ABITIG® 300 W MT	liquid cooled	see comment ¹

Torch body

Type	Part-No.
Standard; 249.0 mm	778.2020
Standard; 249.0 mm	779.2020

¹ Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. For the order of complete torches please indicate the cable assembly length and the machine side connection.

ABITIG® 200 MT, ABITIG® 300 W MT

Wear parts



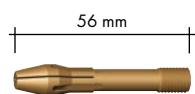
Guide tub (1 pc.)

778.1030

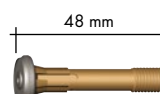


Collet (1 pc.)

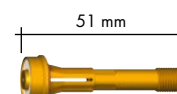
778.1140



Electrode holder



Gas diffuser



Gas diffuser

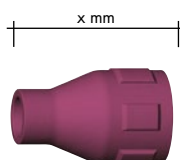
**Electrode holder /
Gas diffuser** (5 pcs.)

	Electrode holder	Gas diffuser	Gas diffuser
Ø 1.6 mm	775.0062	773.0172	773.0112.5
Ø 2.0 mm	775.0067	773.0177	-
Ø 2.4 mm	775.0063	773.0173	773.0113
Ø 3.2 mm	775.0064	773.0174	773.0114
Ø 4.0 mm	775.0065	773.0175	-
Ø 4.8 mm	775.0066	773.0176	-



Insulator (1 pc.)

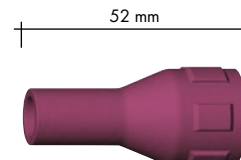
775.1043



Standard version

x = 26 mm

x = 37 mm



Long version

Gas nozzle, ceramic
(10 pcs.)

	x = 26 mm	x = 37 mm	
Ø 7.5 mm	-	775.0081	775.2171
Ø 10.0 mm	775.0152	775.0082	775.2172
Ø 12.5 mm	-	-	-
Ø 13.0 mm	775.0153	775.0083	775.2173
Ø 13.0 mm (boosted)	-	775.0183	-
Ø 15.0 mm	-	775.0084	775.2174
Ø 15.0 mm (boosted)	-	775.0184	-
Ø 16.0 mm	-	-	-
Ø 19.5 mm	-	-	-

Further options, e. g. the "Jumbo" version up to NS 24 or metal gas nozzles, please see chapter 10 of our spare parts list - this you can find in the download area of our website www.binzel-abicor.com.



Setting gauge (1 pc.)

778.1157

TIG Machine Torches "ABITIG® MT"

air and liquid cooled



- Compact in design
- Rugged cable assemblies suitable for all established welding machines
- Ideally suited for welding operations with simple geometries

ABITIG® 400 W MT

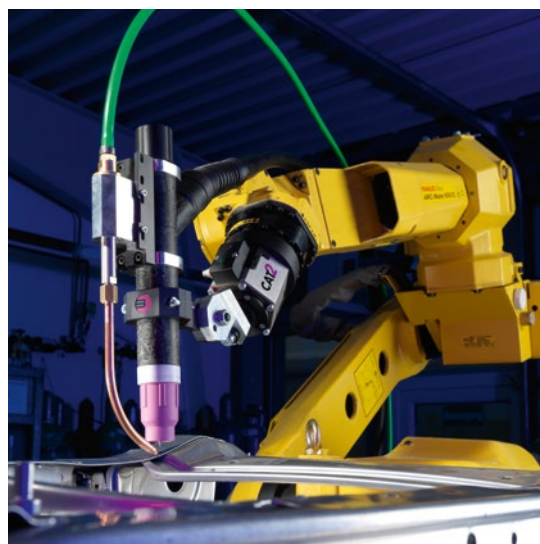
Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	400 A DC 280 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.8 mm

ABITIG® 500 W MT

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	500 A DC 350 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–6.4 mm



ABITIG® 500 W MT with cold wire feeding
(see page 38).

Torch complete

Type	Cooling	Part-No.	Torch body	Part-No.
ABITIG® 400 W MT	liquid cooled	see comment ¹	Standard; 228.0 mm	779.4020
ABITIG® 500 W MT	liquid cooled	see comment ¹	Standard; 265.0 mm	779.6020

¹ Due to the highly differing types of connections on the machine side we cannot list order numbers for complete torches. For the order of complete torches please indicate the cable assembly length and the machine side connection.

ABITIG® 400 W MT, ABITIG® 500 W MT

Wear parts

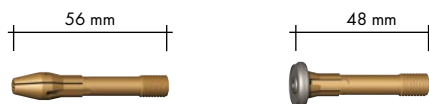
ABITIG® 400 W MT

ABITIG® 500 W MT

Guide tube (1 pc.)

779.4030

779.6026



Electrode holder / Gas diffuser

Electrode holder (5 pcs.)

Gas diffuser (5 pcs.)

Ø 1.6 mm	775.0062	773.0172
Ø 2.0 mm	775.0067	773.0177
Ø 2.4 mm	775.0063	773.0173
Ø 3.2 mm	775.0064	773.0174
Ø 4.0 mm	775.0065	773.0175
Ø 4.8 mm	775.0066	773.0176
Ø 6.4 mm	-	-

Electrode holder (1 pc.)

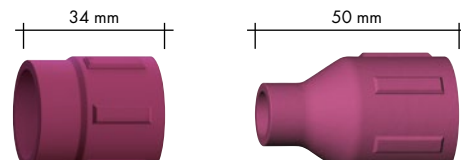
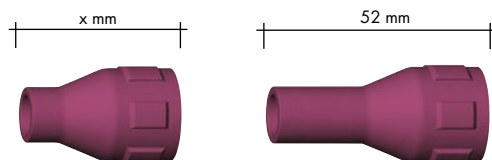
Gas diffuser (1 pc.)

779.6044	779.6058
779.6049	779.6063
779.6045	779.6059
779.6046	779.6060
779.6047	779.6061
779.6048	779.6062
779.6050	779.6064

Insulator (1 pc.)

779.4043

779.6033



Gas nozzle, ceramic (10 pcs.)

Standard version x = 26 mm x = 37 mm

Long version

Ø 7.5 mm	-	775.0081	775.2171
Ø 10.0 mm	775.0152	775.0082	775.2172
Ø 12.5 mm	-	-	-
Ø 13.0 mm	775.0153	775.0083	775.2173
Ø 13.0 mm (boosted)	-	775.0183	-
Ø 15.0 mm	-	775.0084	775.2174
Ø 15.0 mm (boosted)	-	775.0184	-
Ø 16.0 mm	-	-	-
Ø 19.5 mm	-	-	-
Ø 24.0 mm	-	-	-

Standard version

Long version

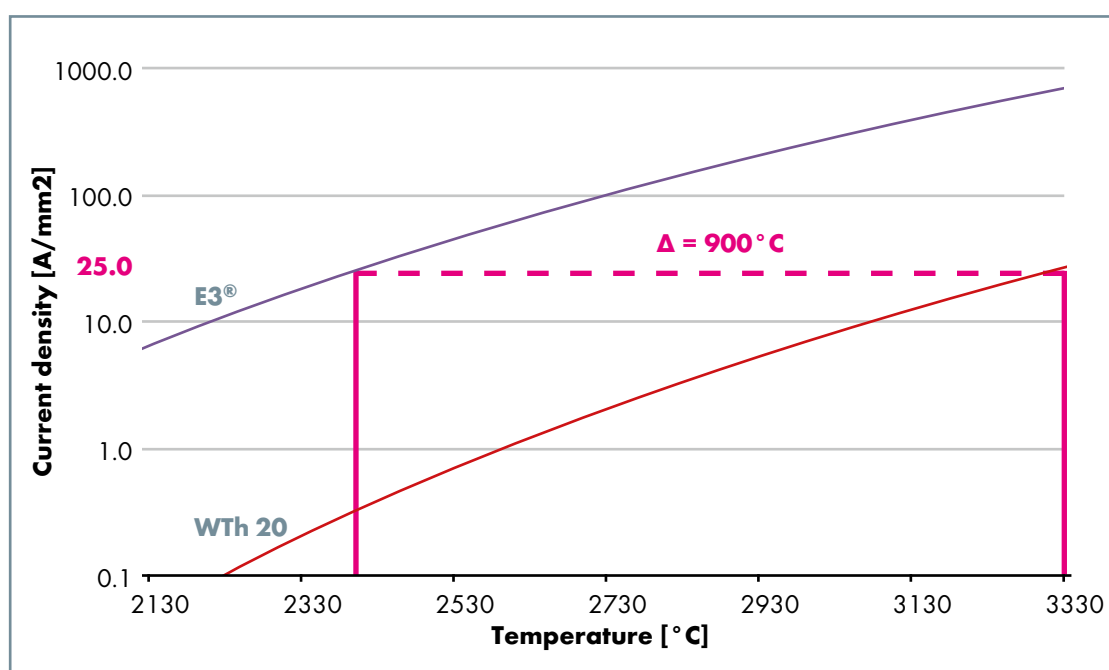
-	-
-	-
-	778.1183
-	-
-	-
-	-
-	-
-	778.1184
-	778.1188
778.1189	-

Further options please see chapter 10 of our spare parts list – this you can find in the download area of our website www.binzel-abicor.com.

Tungsten electrodes

- The welder is no longer exposed to radiation
- Reduced environmental impact. Remaining pieces and grinding dust are no longer treated as hazardous
- No special safeguards required for storage and transport
- Electrode tip remains "cooler" than thoriated types
- Superior repeatable ignition characteristics
- Increased arc stability
- Reduced burn off
- Higher current carrying capacity
- Lower degradation to the electrode tip
- Increased application flexibility

Higher electrical rating



At the same current density E3® electrodes operate at approx. 900°C less than the WTh electrodes and therefore have a higher current carrying capacity.

Durability by comparison

The heat-affected zone of the electrode tip is visually reduced with E3® electrodes. Accordingly, the burn off of the E3® electrode tips is reduced and the durability increased.



E3®



WTh 20

The visual appearance of the E3® electrodes after 150 ignitions show less erosion than the WTh 20 electrodes after 150 ignitions. E3® electrodes provide improved ignitions even after a longer period of use.



E3®



WTh 20

E3®²

Electrodes with rare earth (mixed oxides). In comparison to thoriated electrodes this electrode is less harmful to the environment and not radioactive. The electrodes offer excellent ignition characteristics and consistent welding properties. They are universal and suitable for all applications in the whole range of DC and AC welding for non-alloyed and high-alloyed steel, aluminium, titanium, nickel, copper and magnesium alloys. Because of their great ignition properties they are also suitable for automated welding. Due to the low electrode temperature, they offer an increased current carrying capacity and longer service life than thoriated electrodes.

Colour-coding: **E3® = purple**

WLa 10 / 15 / 20

Lanthanated electrodes are suitable for applications in DC and AC welding. Their main areas of application are the welding of non-alloyed and high-alloyed steel, aluminium, titanium, nickel, copper and magnesium alloys. These electrodes are also suitable for the use in micro-plasma welding. Ignition characteristics are enhanced with increased amounts of lanthanum oxide (La₂O₃). The overall service life and current carrying capacity is lower than the E3® electrodes.

Colour-coding: **WLa 10 = black / WLa 15 = gold / WLa 20 = blue**

WCe 20

By adding cerium oxide (CeO₂), these electrodes have an increased capacity compared to pure tungsten electrodes, however the WCe electrodes have a lower capacity than the E3® and WL electrodes. Main areas of application are in the DC and AC welding of non-alloyed and high-alloyed steel, aluminium, titanium, nickel, copper and magnesium alloys in the low and middle current range.

Colour-coding: **WCe 20 = grey**

WP

Undoped electrodes – consist of pure tungsten. The main area of application for this type of electrode is the AC welding of aluminium alloys with excellent arc stability. The WP-electrodes are not suitable for DC welding.

Colour-coding: **WP = green**

WZr 08

Tungsten electrodes with the addition of zirconium have a lower risk of contaminating the weld from deposits of tungsten. The main area of application for this electrode is AC welding. They are limited in their suitability for DC welding.

Colour-coding: **WZr 08 = white**

Tungsten electrodes per DIN EN ISO 6848 (10 pcs.)

Length: 175 mm¹ Electrodes-Ø	E3®² purple	WLa 10 black	WLa 15 gold	WLa 20 blue	WCe 20 grey	WP green	WZr 08 white
1.0 mm	700.0304.10	700.0157.10	700.1183.10	700.0219.10	700.0166.10	700.0003.10	700.0028.10
1.6 mm	700.0306.10	700.0158.10	700.1184.10	700.0220.10	700.0167.10	700.0007.10	700.0030.10
2.0 mm	700.0307.10	700.0159.10	700.1185.10	700.0221.10	700.0168.10	700.0009.10	700.0032.10
2.4 mm	700.0308.10	700.0160.10	700.1186.10	700.0222.10	700.0169.10	700.0012.10	700.0034.10
3.2 mm	700.0310.10	700.0162.10	700.1187.10	700.0223.10	700.0170.10	700.0016.10	700.0036.10
4.0 mm	700.0311.10	700.0163.10	700.0255.10	700.0242.10	700.0171.10	700.0018.10	700.0037.10

¹ Tungsten electrodes in 150 mm length on demand.

² According to DIN EN ISO 6848..



Wire Feeder System “ABIDRIVE V2”

ABIDRIVE V2 – precise wire feeding for professional welding seam results

The new wire feeding unit ABIDRIVE V2 of ABICOR BINZEL equipped with the special 4-roller drive offers a constantly precise wire feeding for manual and automated TIG welding. With the intuitive menu guidance, individual settings of wire feeding are simple. The detailed customization possibilities to each welding task lead to an optimal result.

Together with the air cooled manual TIG welding torches ABITIG® GRIP 200, the liquid cooled manual TIG torches ABITIG® GRIP 260 W / 450 W and the liquid cooled TIG machine welding torches ABITIG® 260 W / 400 W / 500 W MT, the wire feeding unit ABIDRIVE V2 forms the ideal system for welding long TIG seams in a time-saving, comfortable and process-safe manner.

The wire feeding system can be easily adapted to various TIG welding machines via customized intermediate cable assemblies.

The advantages of the compact and robust ABIDRIVE V2 at a glance:

- Wire speed adjustable from 0.2 to 8.0 m/min
- Fine adjustment of wire speed in steps of 0.02 m/min
- 2 driven wire feeding rolls for minimal slippage and maximum feed constancy
- Individually customizable wire retraction
- Finely adjustable interval function to define the seam shaping and optics
- Optional remote controllers (potentiometer or up/down) – for automated TIG welding
- Commercial standard connections / quick couplings



Technical data

ABIDRIVE V2 (230 V)

Technical data (IEC 60974)

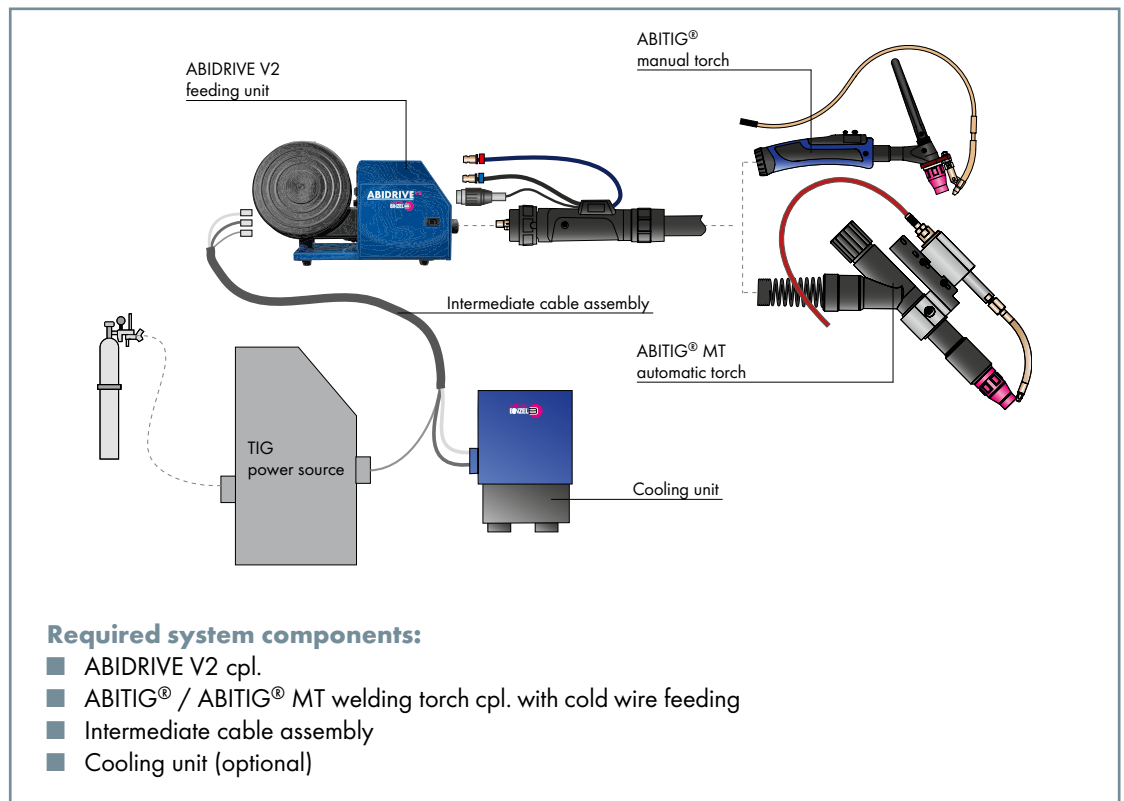
Inlet voltage:	230 V/50 Hz ± 10 %
Welding current:	300 A (100% duty cycle and direct connection)
Delay fuse:	2 AT
Wire speed:	0.2–8.0 m/min
Wire diameter:	0.8–1.6 mm
Protection class:	IP21s
Weight:	17 kg
Size in mm (L/W/H):	674x260x408

ABIDRIVE V2 (115 V)

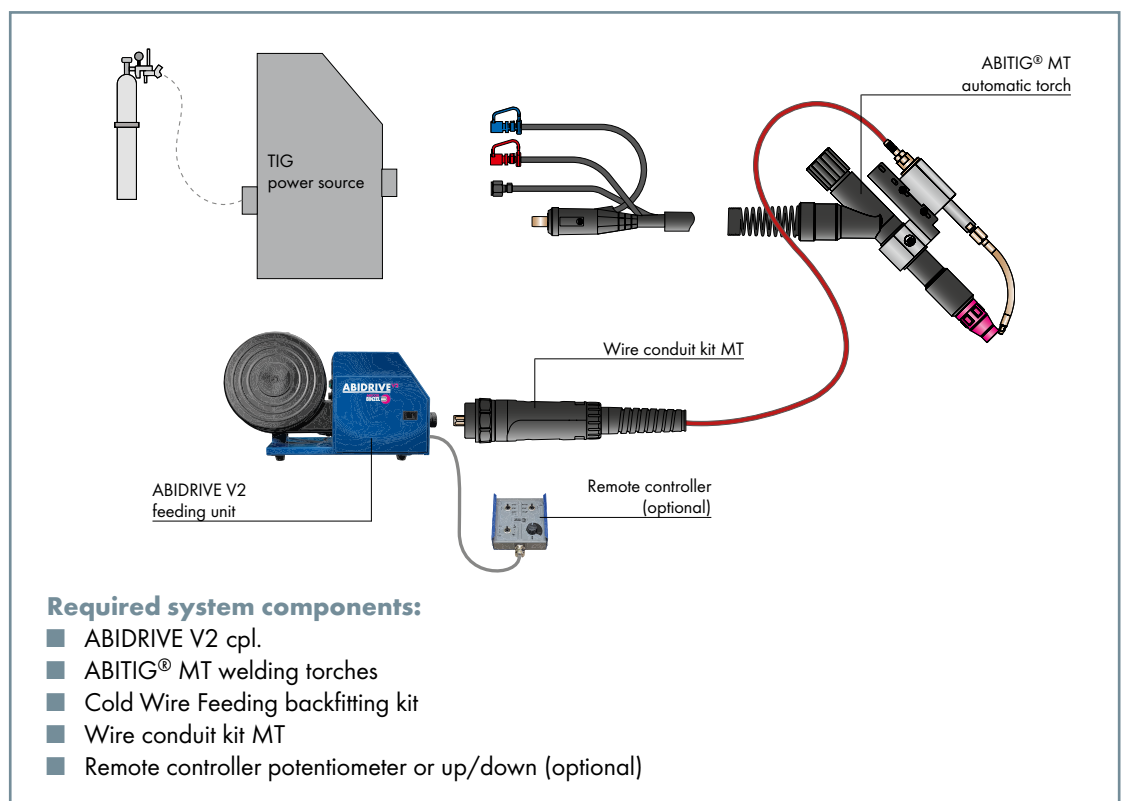
Technical data (IEC 60974)

Inlet voltage:	115 V/50 Hz ± 10 %
Welding current:	300 A (100% duty cycle and direct connection)
Delay fuse:	2 AT
Wire speed:	0.2–8.0 m/min
Wire diameter:	0.8–1.6 mm
Protection class:	IP21s
Weight:	17 kg
Size in mm (L/W/H):	674x260x408

System overview direct connection ABIDRIVE V2



System overview direct connection power source



Wire Feeder System “ABIDRIVE V2”

ABIDRIVE V2 cpl.



Wire Feeder System ABIDRIVE V2

Description	Details	Part-No.
Wire Feeder System ABIDRIVE V2 (without wire feed rolls)	230 V	525.2002.1
Wire Feeder System ABIDRIVE V2 (without wire feed rolls)	115 V	525.2003.1

Drive rolls

Drive rolls (1 pc.)

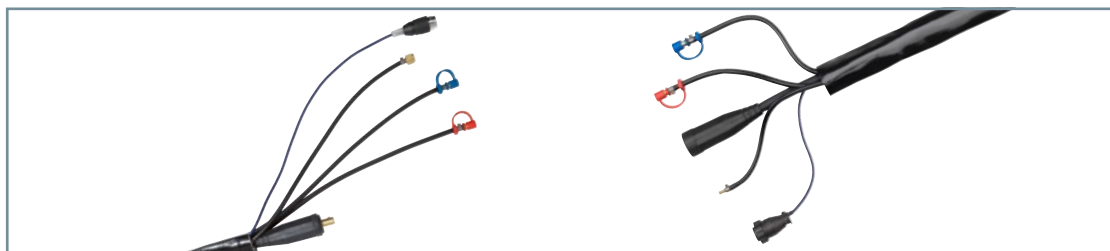
Description	Details	Part-No.
Wire feed roll 1.0 cpl.	4x U-groove driven	525.2053.1
Wire feed roll 1.2 cpl.	4x U-groove driven	525.2004.1
Wire feed roll 1.6 cpl.	4x U-groove driven	525.2005.1
Wire feed roll 0.8 cpl.	2x V-groove / 2x smooth	525.2008.1
Wire feed roll 1.0 cpl.	2x V-groove / 2x smooth	525.2009.1
Wire feed roll 1.2 cpl.	2x V-groove / 2x smooth	525.2010.1
Wire feed roll 1.6 cpl.	2x V-groove / 2x smooth	525.2011.1
Wire feed roll 0.8 cpl.	2x V-groove / 2x smooth driven	525.2012.1
Wire feed roll 1.0 cpl.	2x V-groove / 2x smooth driven	525.2013.1
Wire feed roll 1.2 cpl.	2x V-groove / 2x smooth driven	525.2014.1
Wire feed roll 1.6 cpl.	2x V-groove / 2x smooth driven	525.2015.1
Wire feed roll 0.8	2x V-groove w/o pressure roll	525.2049.1
Wire feed roll 1.0	2x V-groove w/o pressure roll	525.2050.1
Wire feed roll 1.2	2x V-groove w/o pressure roll	525.2051.1
Wire feed roll 1.6	2x V-groove w/o pressure roll	525.2052.1

Options / Spare parts

Options / Spare parts

Description	Details	Part-No.
Remote control V2	Up/Down	525.2042.1
Remote control V2	Potentiometer	525.2043.1
Drive gear	Plastics	525.2044.1

Intermediate cable assembly



TIG intermediate cable assembly (L=2.00 m), air cooled

Current	Control cable	Inert gas	Coolant		Details	Part-No.
			Inlet	Return		
BCS-11 BLS-46B BHC-00	Amphenol 7 pol.	G1/4" IG	-	-	Kemppi®	525.2022.1
BCS-06 BLS-15A BHC-00	Tuchel 9 pol.	G3/8" IG	-	-	Fronius®	525.2024.1
Plug 50-70 BLS-01B BHC-05	Tuchel 5 pol.	NW 2,7mm	-	-	Lorch®	525.2056.1

TIG intermediate cable assembly (L=2.00 m), liquid cooled

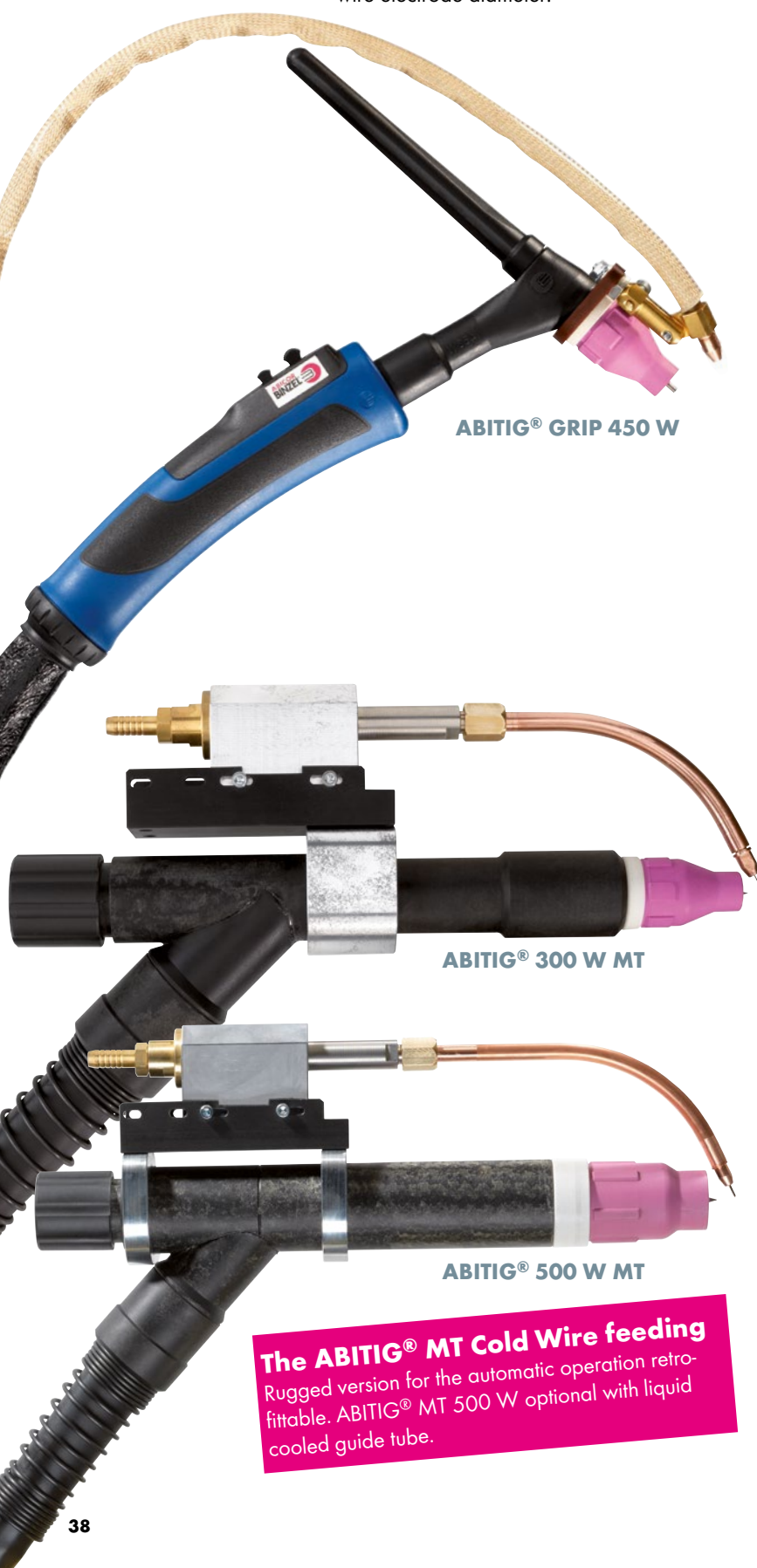
Current	Control cable	Inert gas	Coolant		Details	Part-No.
			Inlet	Return		
Plug 50-70 BLS-37 BHC-11	Burndy 8 pol.	G1/4" IG	ND 5 mm	ND 5 mm	EWM®	525.2017.1
Plug 50-70 BLS-01A BHC-11	Tuchel 5 pol.	G1/4" IG	ND 5 mm	ND 5 mm	EWM®	525.2018.1
Plug 50-70 BLS-01B BHC-16	Tuchel 5 pol.	ND 2.7 mm	ND 5 mm	ND 5 mm	Lorch®	525.2019.1
Plug 50-70 BLS-03A BHC-16	Rundsteckverb. 7 pol.	ND 2.7 mm	ND 5 mm	ND 5 mm	Rehm®	525.2020.1
BCS-11 BLS-46B BHC-12	Amphenol 7 pol.	G1/4" IG	ND 5 mm	ND 5 mm	Kemppi®	525.2021.1
BCS-03 BLS-01A BHC-12	Tuchel 5 pol.	WZ-0	ND 5 mm	ND 5 mm	Merkle®	525.2023.1
Plug 50-70 BLS-01B BHC-11	Tuchel 5 pol.	G1/4" IG	ND 5 mm	ND 5 mm	Jäckle®/ Lorch®	525.2025.1
BCS-36 BLS-15A BHC-12	Tuchel 9 pol.	central Fronius-ZA	ND 5 mm	ND 5 mm	Fronius®	525.2026.1
BCS-06 BLS-10A BHC-15	Amphenol 4 pol.	G1/4" IG	G3/8" IG	G3/8" IG	Kemppi®	525.2027.1
Plug 50-70 BLS-09A BHC-21	Amphenol 2 pol.	G1/8" IG	ND 5 mm	ND 5 mm	ESAB®	525.2028.1
BCS-19 BLS-04A BHC-00	Tuchel 5 pol.	central Oerlikon-ZA	central	central	Oerlikon®	525.2029.1
BCS-25 BLS-04A BHC-12	Tuchel 5 pol.	central Oerlikon BSB	ND 5 mm	ND 5 mm	Oerlikon®	525.2030.1
BCS-07 BLS-99A BHC-12		ZA 9 pol.	ND 5 mm	ND 5 mm	Esab®/ Selco®	525.2031.1
Plug 50-70 BLS-01B BHC-30	Tuchel 5 pol.	G1/4" IG	G3/8" IG	M12x1	ESS®	525.2032.1
BCS-37 BLS-01A BHC-12	Tuchel 5 pol.	Merkle TCG	ND 5 mm	ND 5 mm	Merkle®	525.2033.1
Plug 50-70 BLS-01B BHC-26	Tuchel 5 pol.	G3/8" IG	ND 5 mm	ND 5 mm	Cloos®	525.2036.1
Plug 50-70 BLS-64B BHC-20	Amphenol 6 pol.	ND 5 mm	ND 5 mm	ND 5 mm	CEA®	525.2057.1

All trademarks mentioned in this brochure are property of the respective companies.

TIG Welding Torches "ABITIG®" and "ABITIG® MT" with cold wire feed

- The ABITIG® Cold Wire Feeding can be perfectly adjusted to any application due to the three-dimensional positioning and the individually exchangeable feeding nozzles, adjusted to the wire electrode diameter.

- Precise, easy three-dimensional positioning of the cold wire feeding
- Light dead weight provides a fatigue-free working
- Highly flexible wire feeding hose inside the cable assembly – no restrictions during handling
- Higher welding speeds compared to the manual feeding of welding material
- Exact welding wire feeding



ABITIG® GRIP 450 W

ABITIG® 300 W MT

ABITIG® 500 W MT

The ABITIG® MT Cold Wire feeding
Rugged version for the automatic operation retro-fittable. ABITIG® MT 500 W optional with liquid cooled guide tube.

ABITIG® 200 MT / ABITIG® GRIP 200

Technical data (EN 60 974-7):

Type of cooling:	air cooled
Rating:	200 A DC 140 A AC
Duty cycle:	35%
Tungsten electrodes:	Ø 1.6–3.2 mm

ABITIG® 260 W MT / ABITIG® GRIP 260 W

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	260 A DC 180 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.0–3.2 mm

ABITIG® 300 W MT

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	300 A DC 210 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.8 mm

ABITIG® 400 W MT

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	400 A DC 280 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.8 mm

ABITIG® GRIP 450 W

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	400 A DC 280 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–4.8 mm

ABITIG® 500 W MT

Technical data (EN 60 974-7):

Type of cooling:	liquid cooled
Rating:	500 A DC 350 A AC
Duty cycle:	100%
Tungsten electrodes:	Ø 1.6–6.4 mm

"ABITIG®" and "ABITIG® MT" with cold wire feed

Torches cpl.

TIG Manual Welding Torches ABITIG® with cold wire feed

Type		Part-No.
ABITIG® GRIP 200	4 m BIS-75, GZ-0, with cold-wire ¹	525.2035.1
ABITIG® GRIP 200	4 m BIS-V2, GZ-0, KD wire U/D ¹	525.2039.1
ABITIG® GRIP 260 W	4 m BIS-75, WZ-0 BHC-12, with cold wire ¹	525.2034.1
ABITIG® GRIP 260 W	4 m BIS-V2, WZ-0 BHC-12, KD wire U/D ¹	525.2040.1
ABITIG® GRIP 450 W	4 m BIS-75, WZ-0 BHC-12, with cold wire ¹	525.2001.1
ABITIG® GRIP 450 W	4 m BIS-V2, WZ-0 BHC-12, KD wire U/D ¹	525.2041.1

¹ incl. cold wire feeding tip 1.0 mm

TIG Machine Welding Torches ABITIG® MT with cold wire feed

Type		Part-No.
ABITIG® 200 MT	4 m with cold wire feed ²	525.1015
ABITIG® 260 W MT	4 m with cold wire feed ²	525.1018
ABITIG® 300 W MT	4 m with cold wire feed ²	525.1023
ABITIG® 400 W MT	4 m with cold wire feed ²	525.1026
ABITIG® 500 W MT	4 m with cold wire feed ²	525.1042.1

² incl. cold wire feeding tip 1.0 mm

Wear parts

Cold wire feeding tip

(5 pcs.)

	ABITIG®	ABITIG® MT
Ø 0.8 mm	729.0071	967.0329
Ø 1.0 mm	729.0072	967.0330
Ø 1.2 mm	729.0073	967.0331
Ø 1.6 mm	-	967.0332

Cold wire feeding

ABITIG®	Cold wire guide liner 2.0x4.5 mm (L=0.45 m)	729.0080
	Double nipple	729.0057
ABITIG® MT	Cold wire feeding tube for ABITIG® MT 260 W / 300 W / 400 W	779.6513.1
	Cold wire feeding tube for ABITIG® MT 500 W	967.0326
	optional:	
	Cold wire feeding tube for ABITIG® MT 500 W - liquid cooled	779.6505

Wire guides

Carbon PTFE core liner 2.0/4.0; Wire-Ø 1.0-1.2; for 4.00 m	127.0007
Polyamid core liner 2.0/4.0; Wire-Ø 1.0-1.2; for 4.00 m	128.0015
Polyamid core liner 2.0x4.0; Wire-Ø 1.6; for 6.00 m	128.0017
Polyamid core liner 2.3x4.7; Wire-Ø 1.6; for 6.00 m	128.0037

Component kits

Backfitting kits

Cold wire feeding cpl. for ABITIG® 260 W (Gas nozzle L = 26 mm) ³	729.0084
Cold wire feeding cpl. for ABITIG® 450 W (Gas nozzle L = 37 mm) ³	729.0070
Cold wire feeding cpl. for ABITIG® MT 260 W / 300 W / 400 W ³	779.6514.1
Cold wire feeding cpl. for ABITIG® MT 500 W ³	779.6500

³ incl. cold wire feeding tip 1.0 mm

Wire conduit kit ABIDRIVE (L = 6.00 m) incl. fastening material applicable for all retrofit kits	525.1014
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Accessories

Torch mounts

MT-25 for ABITIG® MT 260 W / 400 W	780.0222
MT-30 for ABITIG® MT 300 W	780.0145
MT-35 for ABITIG® MT 500 W	780.0292

Component kits

I. Component kits ABITIG® 9 / 17 / 18 / 20 / 20 SC / 26

Type	Electrode-Ø 1.6	Electrode-Ø 2.4	Electrode-Ø 3.2
ABITIG® 9 (Collet body)	712.3151	-	-
ABITIG® 9 (Gas lens)	712.3191	-	-
ABITIG® 17 (Collet body)	712.2151	712.2152	-
ABITIG® 17 (Gas lens)	-	712.2192	-
ABITIG® 18 (Collet body)	-	712.2152	712.2153
ABITIG® 18 (Gas lens)	-	712.2192	-
ABITIG® 20 (Collet body)	-	712.3152	-
ABITIG® 20 (Gas lens)	-	712.3192	-
ABITIG® 20 SC (Collet body)	-	712.3152	-
ABITIG® 20 SC (Gas lens)	-	712.3192	-
ABITIG® 26 (Collet body)	-	712.2152	712.2153
ABITIG® 26 (Gas lens)	-	712.2192	-

Component kit "Collet body" consisting of: Back cap long, collet, collet body and gas nozzle ceramic.

Component kit "Gas lens" consisting of: Back cap long, collet, collet body with gas lens and gas nozzle ceramic.

II. Component kits ABITIG® 150 / 260 W / 260 W SC

Type	Electrode-Ø 1.6	Electrode-Ø 2.4	Electrode-Ø 3.2
ABITIG® 150 (Electrode holder)	777.0182	777.0183	-
ABITIG® 150 (Gas diffuser)	-	777.0193	-
ABITIG® 260 W (Electrode holder)	777.0182	777.0183	-
ABITIG® 260 W (Gas diffuser)	-	777.0193	-
ABITIG® 260 W SC (Electrode holder)	777.0182	777.0183	-
ABITIG® 260 W SC (Gas diffuser)	-	777.0193	-

Component kit "Electrode holder" consisting of: Back cap medium, electrode holder and gas nozzle ceramic.

Component kit "Gas diffuser" consisting of: Back cap medium, gas diffuser and gas nozzle ceramic.

III. Component kits ABITIG® 200 / 450 W / 450 W SC

Type	Electrode-Ø 2.4	Electrode-Ø 3.2	Electrode-Ø 4.8
ABITIG® 200 (Electrode holder)	774.0183	-	-
ABITIG® 200 (Gas diffuser)	774.0193	-	-
ABITIG® 450 W (Electrode holder)	774.0183	-	-
ABITIG® 450 W (Gas diffuser)	774.0193	-	-
ABITIG® 450 W SC (Electrode holder)	774.0183	-	-
ABITIG® 450 W SC (Gas diffuser)	774.0193	-	774.0196

Component kit "Electrode holder" consisting of: Back cap long, electrode holder and gas nozzle ceramic.

Component kit "Gas diffuser" consisting of: Back cap long, gas diffuser and gas nozzle ceramic.

Power cables, Control cables and Hoses

I. Power cables ABITIG® GRIP

Type	Power cable standard			Power cable High Flex		
	4 m	8 m	12 m	4 m	8 m	12 m
ABITIG® 9	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 20	150.0015	150.0016	150.0017	150.0062	150.0063	150.0064
ABITIG® 20 SC	-	-	-	150.0301.1	150.0302.1	150.0303.1
ABITIG® 17	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 18	150.0018	150.0019	150.0020	150.0068	150.0069	150.0070
ABITIG® 18 SC	150.0018	150.0019	150.0020	150.0068	150.0069	150.0070
ABITIG® 26	150.0087	150.0088	150.0089	150.0059	150.0060	150.0061
ABITIG® 24 G	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 24 W	150.0015	150.0016	150.0017	150.0062	150.0063	150.0064
ABITIG® 12-1	150.0074	150.0075	150.0076	150.0071	150.0072	150.0073
ABITIG® 150	150.0111	150.0112	150.0113	150.0040	150.0041	150.0190
ABITIG® 260 W	150.0099	150.0100	150.0101	150.0164	150.0165	150.0166
ABITIG® 260 W SC	-	-	-	150.0305.1	150.0306.1	150.0307.1
ABITIG® 200	150.0170	150.0171	150.0172	150.0036	150.0037	150.0114
ABITIG® 450 W	150.0054	150.0055	150.0083	150.0167	150.0168	150.0169
ABITIG® 450 W SC	-	-	-	150.0203	150.0194	150.0204
ABITIG® 500 W	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067

Power cable for TIG welding torches ABITIG® with rotary valve and TIG machine torches on request.

II. Power cables ABITIG® GRIP Little

Type	Power cable standard			Power cable High Flex		
	4 m	8 m	12 m	4 m	8 m	12 m
ABITIG® 9	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 20	150.0259.1	150.0260.1	150.0261.1	150.0255.1	150.0256.1	150.0257.1
ABITIG® 17	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 24 G	150.0084	150.0085	150.0086	150.0065	150.0066	150.0067
ABITIG® 24 W	150.0259.1	150.0260.1	150.0261.1	150.0255.1	150.0256.1	150.0257.1
ABITIG® 90	150.0111	150.0112	150.0113	150.0040	150.0041	150.0190
ABITIG® 150	150.0111	150.0112	150.0113	150.0040	150.0041	150.0190
ABITIG® 180 W	150.0267.1	150.0268.1	150.0269.1	150.0002 ¹	150.0003 ¹	150.0272.1
ABITIG® 260 W	150.0267.1	150.0268.1	150.0269.1	150.0002 ¹	150.0003 ¹	150.0272.1

¹ highly flexible PU version

III. Control cables

Type	Description	Details	Part-No.
all torches ²	Power cable 3 core	100 m	100.0100
all torches ²	Power cable 6 core	100 m	100.0112
all torches ²	Power cable 6 core (protected)	100 m	100.0028

² apart from TIG welding torches ABITIG® GRIP with rotary valve and TIG machine torches

Spare parts mentioned are suitable for use with all ABITIG®, ABITIG® GRIP and ABITIG® GRIP Little TIG welding torches – unless specifically marked.

Power cables, Control cables and Hoses

IV. Outer hoses

Type	Description	Details	Part-No.
ABITIG® 9 / 20	Outer hose 22x1.25	40 m	109.0020
ABITIG® 17 / 18 / 18 SC / 26			
ABITIG® 24 G / 24 W			
ABITIG® 12-1			
ABITIG® 90 / 180 W			
ABITIG® 150 / 260 W			
ABITIG® 200 / 450 W			
ABITIG® 500 W			
ABITIG® 9 V			
ABITIG® 17 V / 17 FV			
ABITIG® 20 SC	Outer hose 25x1.25	40 m	105.0019
ABITIG® 260 W SC			
ABITIG® 450 W SC			
ABITIG® 26 V / 26 FV			
ABITIG® 150 MT	Outer hose 22x1.25	40 m	109.0020
ABITIG® 200 MT			
ABITIG® 260 W MT			
ABITIG® 300 W MT			
ABITIG® 400 W MT			
ABITIG® 500 W MT			
ABITIG® MT with cold wire feed	Outer hose 25x1.25	40 m	105.0019

V. Leather hose and hose coupling

Type	Description	Part-No.
all torches ¹	Leather hose 0.8 m	108.0028
all torches ²	Hose coupling complete for connecting leather and outer hose	400.0391
ABITIG® 20 SC	Hose coupling complete for connecting leather and outer hose	400.0392
ABITIG® 260 W SC		
ABITIG® 450 W SC		
ABITIG® 500 W		

¹ apart from TIG welding torches ABITIG® GRIP with rotary valve and TIG machine torches

² apart from TIG welding torches ABITIG® GRIP with rotary valve, TIG machine torches and ABITIG® GRIP 20 SC / 260 W SC / 450 W SC / 500 W

VI. Gas hoses

Type	Description	Details	Part-No.
ABITIG® 20 / 20 SC	Gas hose 3x1.5	100 m	102.0124
ABITIG® 18 / 18 SC			
ABITIG® 24 W			
ABITIG® 12-1			
ABITIG® 180 W			
ABITIG® 260 W / 260 W SC			
ABITIG® 450 W / 450 W SC			
ABITIG® 500 W			
ABITIG® 9 V			
ABITIG® 17 V / 17 FV			
ABITIG® 26 V / 26 FV	Gas hose 4.9x1.5	100 m	109.0040
ABITIG® 260 W MT	Gas hose 3x1.5	100 m	102.0124
ABITIG® 300 W MT			
ABITIG® 400 W MT			
ABITIG® 500 W MT			

Spare parts mentioned are suitable for use with all ABITIG®, ABITIG® GRIP and ABITIG® GRIP Little TIG welding torches – unless specifically marked.

VII. Water hose

Type	Description	Version	
		PVC black per 100 m	BRH per 40 m
ABITIG® 20 / 20 SC	Water hose 3.9x1.5	109.0011	109.0059
ABITIG® 18 / 18 SC			
ABITIG® 24 W			
ABITIG® 12-1			
ABITIG® 500 W			
ABITIG® 260 W MT			
ABITIG® 300 W MT			
ABITIG® 400 W MT			
ABITIG® 500 W MT			

VIII. Hose clamps, marking washers and ceiling covers

Type	Part-No. (20 pcs.)	for hose			
		102.0124	109.0011	109.0040	109.0059
Hose clamp Ø=9.0 with ring (mark. 9.5)	173.0001			•	•
Hose clamp Ø=8.2 with ring (mark. 8.7)	173.0005		•		
Hose clamp Ø=7.5 with ring (mark. 8.0)	173.0007	•			
Marking washer red	501.2166		•		•
Marking washer blue	501.2167		•		•
Ceiling cover red	501.2423		•		•
Ceiling cover blue	501.2424		•		•

Handles and Modules

I. Handles ABITIG® GRIP and control modules

Type	Description	Details	Part-No.
all ABITIG® GRIP torches ¹	Handle ABITIG® GRIP, without control module		180.0130.1
all ABITIG® GRIP torches ¹	Control module single push-button	BIS-51	400.1275.1
	Control module single push-button with potentiometer 10 kΩ (3 pole)	BIS-59	400.1281.1
	Control module double push-button	BIS-52	400.1276.1
	Control module double push-button for high switching current (up to 2 A)	BIS-60	400.1280.1
	Control module double push-button with potentiometer 1 kΩ	BIS-64	400.1327.1
	Control module double push-button with potentiometer 2.2 kΩ	BIS-74	400.1328.1
	Control module double push-button with potentiometer 4.7 kΩ	BIS-84	400.1329.1
	Control module double push-button with potentiometer 10 kΩ	BIS-54	400.1278.1
	Control module double push-button with potentiometer 47 kΩ	BIS-94	400.1330.1
	Control module double push-button with compensator	BIS-67	400.1282.1
	Control module UP / DOWN (device-dependent)	BIS-65	400.1279.1
	Control module UP / DOWN (compatible with Stel® / CEA®)	BIS-85	400.1367.1
	Control module UP / DOWN (compatible with Lorch®)	BIS-95	400.1277.1
	Control module UP / DOWN (compatible with CEA®)	BIS-98	400.1368.1
	Control module single push-button with rubber calotte	BIS-R1	400.1378.1

¹ apart from TIG welding torches ABITIG® GRIP with rotary valve and TIG machine torches

II. Handles ABITIG® GRIP Little and control modules

Type	Description	Details	Part-No.
all ABITIG® GRIP Little torches ¹	Handle ABITIG® GRIP Little, without control module		180.0131.1
all ABITIG® GRIP Little torches ¹	Control module single push-button	BIS-51	400.1296.1
	Control module single push-button (lower release force than BIS-51)	BIS-S1	400.1647.1
	Control module double push-button	BIS-52	400.1292.1
	Control module UP / DOWN (device-dependent)	BIS-55	400.1388.1
	Control module UP / DOWN (device-dependent)	BIS-65	400.1318.1
	Control module UP / DOWN (compatible with Stel® / CEA®)	BIS-85	400.1375.1
	Control module UP / DOWN (compatible with Lorch®)	BIS-95	400.1354.1
	Lid (5 pcs.)	BIS-57	400.1402.5

¹ apart from TIG welding torches ABITIG® GRIP with rotary valve and TIG machine torches

III. Handles and rotary valves

Type	Description	Part-No.
ABITIG® 9 V / 17 V / 17 FV	Handle	705.1440
	Rotary valve	705.0046
ABITIG® 26 V / 26 FV	Handle	705.0096
	Rotary valve	705.0097

Handle ABITIG® GRIP Little



BIS-51 /
BIS-51 (lower release force)
ED = Single push-button



BIS-52
DD = Double push-button /
Button short (in Torch-Price-List
Standard, under DD)



BIS-55
UD = UP / DOWN
(device-dependend)



BIS-65
UD = UP / DOWN
(device-dependend)



BIS-85
UD = UP / DOWN
(compatible with Stel® / CEA®)



BIS-95
UD = UP / DOWN
(compatible with Lorch®)



BIS-57
Lid (5 pcs.)



appropriate handle
Part-No.: 180.0131.1

Abbreviations for switch functions:

ED	Single push-button
DD	Double push-button
UD	UP / DOWN (two switches)
EDP ¹	Single push-button with potentiometer 10 kΩ, other factors on request (e.g. 1.0 kΩ, 2.2 kΩ, 4.7 kΩ, 47 kΩ)
DDP ¹	Double push-button with potentiometer 10 kΩ, other factors on request (e.g. 1.0 kΩ, 2.2 kΩ, 4.7 kΩ, 47 kΩ)

¹In the case of potentiometer regulation in the handle,
an HF-filter is essential if the potentiometer cable runs
through the remote control connector and is started with
high voltage pulses. If there is no HF-filter, the HF pulses
may damage the control electronics.

Please order the HF-control cable filter DGF 3 by using
the Part-No. 184.0162.

Handle ABITIG® GRIP



BIS-51
ED = Single push-button



BIS-52
DD = Double push-button /
Button long



BIS-54 / -64 / -74 / -84 / -94
DDP = Double push-button /
Poti xx kΩ (see page 44)



BIS-59
EDP = Single push-button /
Poti 10 kΩ (compatible with
Migatronik®, 3 pole)



BIS-60
DD = Double push-button /
Button long for high switching
current up to 2 A



BIS-65
UD = UP / DOWN
(device-dependend)



BIS-67
DD = Double push-button /
Compensator



BIS-85
UD = UP / DOWN
(compatible with Stel® / CEA®)



BIS-95
UD = UP / DOWN
(compatible with Lorch®)



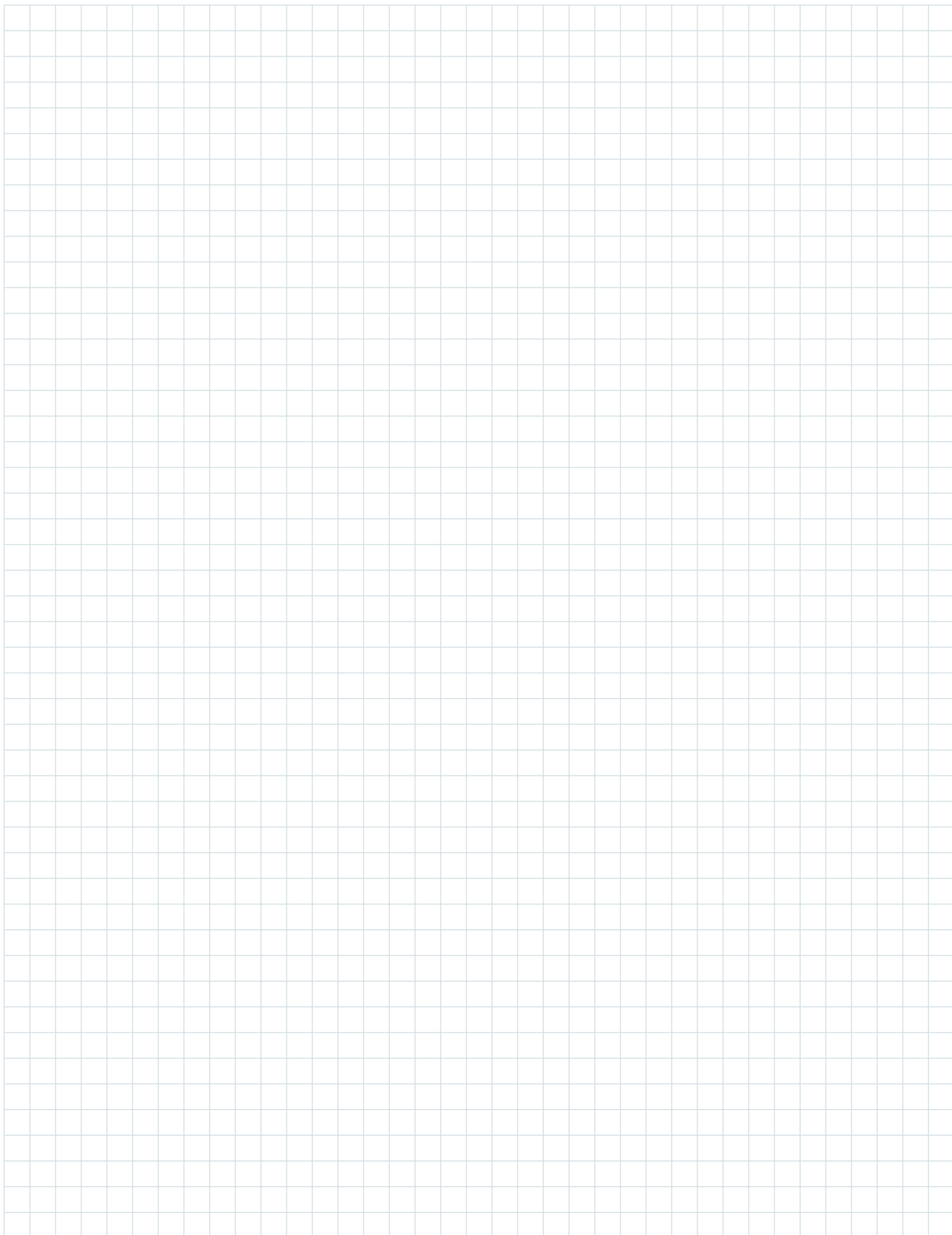
BIS-98
UD = UP / DOWN
(compatible with CEA®)



BIS-R1
ED = Single push-button
with rubber calotte



appropriate handle
Part-No.: 180.0130.1



Our product range:

■ MIG/MAG

- Welding Torches
- Machine and Special Torches
- Push-Pull Welding Torches
- Fume Extraction Torches
- Central Adaptor System

■ TIG

- Welding Torches
- Machine and Special Torches

■ PLASMA

- Cutting Torches
- Welding Torches
- Machine and Special Torches

■ ROBOTIC SYSTEMS

- Robot Torches MIG/TIG/PLASMA
- Electronic Welding Regulator
- Laser Heads
- Seam Tracking Sensors
- TCP Programming Aid
- Robot Mounts
- Wire Cutting Station
- Torch Cleaning Station
- Wire Feeding Systems

■ Welding Accessories

- Fumes Extraction Systems
- Coolers
- Welding Cable Plug and Socket
- Anti Spatter Spray and Paste
- and so on ...

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