








SET-UP AND MAINTENANCE GUIDE

ARCT SERIES

INTELLIGENT
TORCH SOLUTIONS

 EN English Quick Guide
 ES Spanish Guía Consulta Rápida
 PL Polish Szybki przewodnik
 PT Portuguese Guia de consulta rápida

 RU Russia Краткое руководство
 SV Swedish Snabbguide
 CH Chinese 快速指南

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RATINGS AT A GLANCE

IEC/EN 60974-7



MAKE WORK
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Air-Cooled

Technical Data:		T1/T1FX	T2	T2FX	T3	T3FX
Cooling Method		Air-Cooled				
Rating:	DC	140A	190A	180A	240A	220A
	AC	100A	135A	125A	170A	155A
Duty Cycle		35%		35%		35%
Electrode Size		1.0-3.2mm / 0.04"-1/8"	1.0-4.0mm / 0.04"-5/32"		1.0-4.8mm / 0.04"-3/16"	
Operating Temperature		-20°C ...+40°C				

Liquid-Cooled

Technical Data:		T1WLT/T1WFXLT		T1W/T1WFX		T3W/T3WFX		T4W/T4WFX		T5W/T5WFX		T5WA Auto	
Cooling Method		Liquid-Cooled											
		12.5ft	25ft	12.5ft	25ft	12.5ft	25ft	12.5ft	25ft	12.5ft	25ft	12.5ft	25ft
Rating:	1200W DC	225A	225A	330A	330A	400A	400A	450A	400A	550A	500A	550A	450A
	AC	160A	160A	230A	230A	280A	280A	315A	280A	385A	350A	385A	315A
	1600W DC	-	-	-	-	-	-	450A	450A	550A	550A	550A	450A
	AC	-	-	-	-	-	-	315A	315A	385A	385A	385A	315A
Duty Cycle		100%	100%	100%	100%	100%	60%	100%	60%	100%	60%	100%	100%
Electrode Size		1.0-3.2mm / 0.04"-1/8"		1.0-4.0mm / 0.04"-5/32"		1.0-4.0mm / 0.04"-5/32"		1.6-4.8mm / 1/16"-3/16"		1.6-6.4mm / 1/16"-1/4"		1.6-6.4mm / 1/16"-1/4"	
Minimum Water Flow		1.0 l/min		1.5 l/min		1.5 l/min		1.5 l/min		1.5 l/min		1.5 l/min	
Minimum Water Inlet Pressure		2.5 Bar											
Maximum Water Inlet Pressure		5.0 Bar											
Maximum Water Inlet Temperature		50°C											
Operating Temperature		-20°C ...+40°C											

Technical Data

ES Datos Técnicos PL Tekniset tiedot PT Dados Técnicos
RU Краткое руководство SV Snabbguide CH 技术参数

Rating

ES Rango PL Obciążalność PT Capacidade
RU Параметры SV Strömstyrka CH 电流

Duty Cycle

ES Ciclo de Trabajo PL Cykl pracy PT Ciclo de Trabalho
RU ПВ SV Intermittens CH 暂载率

Electrode Size

ES Diámetro Electrodo PL Średnica elektrody
PT Diâmetro Eletrodo RU Диаметр электрода
SV Elektroddiameter CH 电极尺寸

Air-Cooled

ES Refrigerado Aire PL Chłodzenie gazowe
PT Refrigerado Água RU Воздушное охлаждение
SV Gaskylid CH 空冷

Liquid-Cooled

ES Refrigerado Agua PL Chłodzenie cieczą
PT Refrigerado Água RU Жидкостное охлаждение
SV Vattenkyld CH 水冷

Minimum Water Flow

ES Mínimo Flujo Agua PL Minimalny przepływ cieczy PT Fluxo Água Mínimo
RU Минимальная скорость подачи охлаждающей жидкости
SV Vattenflöde minimum CH 最低水流

Minimum Water Inlet Pressure

ES Presión Mínima Entrada Agua PL Minimalne ciśnienie wejściowe
PT Pressão Mínima Entrada Água RU Максимальное давление в входе
SV Vattentryck minimum CH 最低进水口压力

Maximum Water Inlet Pressure

ES Presión Máxima Entrada Agua PL Maksymalne ciśnienie wejściowe
PT Pressão Máxima Entrada Água RU Максимальное давление в входе
SV Vattentryck maximum CH 最高进水口压力

Maximum Water Inlet Temperature

ES Máxima Temperatura Entrada Agua PL Maksymalna temperatura cieczy
PT Máxima Temperatura Entrada Água RU Максимальная температура охлаждающей жидкости в входе
SV Maxtemperatur vatten CH 进水口最高温度

- ✓ IEC/EN 60974-7
- ✓ ISO9001:2015
- ✓ LVD 2014/35/EU
- ✓ REACH 1907/2006/EC
- ✓ RoHS2 2011/65/EU, amend 2015/863/EU

GETTING STARTED

Standard Set-Up

- 1 Ensure you have all the parts



- Asegúrese que tienes todas las piezas
- Upewnij się, że masz wszystkie części w zestawie
- Certifique-se de ter todas as peças
- Убедитесь, что у Вас есть все части горелки.
- Kontrollera att alla delar finns
- 准备好需要安装的备件

- 2 Push the gasket onto the head
Twist and push the gasket until in place



- Empuje el sello en la cabeza de la antorcha.
Nota: Hay una pequeña ranura en la parte superior de la cabeza de la antorcha.
- Załóż silikonową uszczelkę na główkę palnika
- Empurrar a vedação na cabeça da tocha.
Torcer e empurrar a vedação até posicionar.
- Наденьте резиновый уплотнитель на голову горелки.
Внимание: на голове горелки есть небольшой выступ. Необходимо повернуть и вставить уплотнитель до упора.
- Montera packningen på huvudet. Observera räfflan på huvudet. Vrid och tryck på packningen tills den är i rätt läge
- 按照图示方法, 将橡胶绝缘套装到枪头上

- 3 Assemble the heat isolator.
Tighten with the enclosed spanner



- Armar el aislador de calor. Apretar con llave de boca.
- Złożyć izolator ze stali nierdzewnej
- Montar o isolador de calor.
Apertar com chave de boca.
- Наденьте теплоизолятор. Закрепите с помощью прилагающегося ключа.
- Montera värmeisolatorn och spänn fast med det medföljande verktyget
- 按照图示方法, 将不锈钢隔热套旋到枪头螺纹上, 并使用专用扳手拧紧

- 4 Insert the collet and locate the collet slot on the pin at the back of the head









- Ubique la pinza en el pasador en la parte posterior del cabezal
- Umieścić tuleję zaciskową na sworzniu z tyłu palnika
- Localizar a pinça no pino atrás da cabeça da tocha.
- Вставьте цапгу с задней стороны головы горелки.
- Rikta in spännhylsan på huvudets baksida
- 按照图示方法, 将钨极夹装到枪头内孔, 装配时注意钨极夹上的轴向定位导槽对准枪头孔内的定位销

GETTING STARTED







5 Assemble the back cap to pinch the collet



-  Montar el capuchón largo para apretar la pinza
-  Przykręć korek w celu zaciśnięcia oprawy elektrody
-  Montar a capa do eletrodo para apertar a pinça
-  Закрепите колпачок, чтобы зажать цангу.
-  Montera spännhuvn för att spänna fast spännhylsan
-  按照图示方法，将后帽与钨极夹通过螺纹连接到一起







6 Insert the Tungsten



-  Insertar el tungsteno
-  Włóż elektrodę wolframową od przodu palnika
-  Inserir o Tungsténio
-  Вставьте вольфрамовый электрод.
-  Montera elektroden
-  按照图示方法，将钨极装到钨极夹的内孔中，顺时针旋转后帽夹紧钨极







7 Assemble the ceramic - push on



-  Ubicar la cerámica - encajar
-  Zamocuj dyszę ceramiczną
-  Posicionar o bocal de cerámica - encaixar
-  Закрепите керамическое сопло.
-  Tryck på gashylsan
-  按照图示方法，将陶瓷喷嘴装到不锈钢隔热套上，并推紧

8 Tighten the back cap. You're ready to go!









-  Armar el capuchón. Usted está listo!
-  Dokręć korek w celu zaciśnięcia elektrody wolframowej w palniku
-  Apertar a capa do tungsténio. Você está pronto!
-  Затяните колпачок. Горелка готова к работе!
-  Dra åt spännhuvn. Nu är det klart att svetsa!
-  按照图示方法，逆时针旋转后帽松开钨极，调整钨极位置，顺时针旋转后帽夹紧并固定钨极位置

GETTING STARTED

T5WA Auto Standard Set-Up







- 1 Ensure you have all the parts



-  Asegúrese que tienes todas las piezas
-  Upewnij się, że masz wszystkie części w zestawie
-  Certifique-se de ter todas as peças
-  Убедитесь, что у Вас есть все части горелки.
-  Kontrollera att alla delar finns
-  准备好需要安装的备件







- 2 Push the gasket onto the head
Twist and push the gasket until in place



-  Empuje el sello en la cabeza de la antorcha.
Nota: Hay una pequeña ranura en la parte superior de la cabeza de la antorcha.
-  Załóż silikonową uszczelkę na główkę palnika
-  Empurrar a vedação na cabeça da tocha.
Torcer e empurrar a vedação até posicionar.
-  Наденьте резиновый уплотнитель на голову горелки.
Внимание: на голове горелки есть небольшой выступ.
Необходимо повернуть и вставить уплотнитель до упора.
-  Montera packningen på huvudet. Observera räfflan på huvudet. Vrid och tryck på packningen tills den är i rätt läge
-  按照图示方法, 将橡胶绝缘套装到枪头上







- 3 Assemble the heat isolator.
Tighten with the enclosed spanner



-  Armar el aislador de calor . Apretar com llave de boca.
-  Złożyć izolator ze stali nierdzewnej
-  Montar o isolador de calor.
Apertar com chave de boca.
-  Наденьте теплоизолятор. Закрепите с помощью прилагающегося ключа.
-  Montera värmeisolatorn och spänn fast med det medföljande verktyget
-  按照图示方法, 将不锈钢隔热套旋到枪头螺纹上, 并使用专用扳手拧紧

- 4 Insert the collet and locate the collet slot on the pin at the back of the head



-  Ubique la pinza en el pasador en la parte posterior del cabezal
-  Umieść tuleję zaciskową na sworzniu z tyłu palnika
-  Localizar a pinça no pino atrás da cabeça da tocha.
-  Вставьте цангу с задней стороны головы горелки.
-  Rikta in spännhylsan på huvudets baksida
-  按照图示方法, 将钨极夹装到枪头内孔, 装配时注意钨极夹上的轴向定位导槽对正枪头孔内的定位销







GETTING STARTED



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5 Assemble the back cap to pinch the collet



-  Montar el capuchón largo para apretar la pinza
-  Przykręć korek w celu zaciśnięcia oprawy elektrody
-  Montar a capa do eletrodo para apertar da pinça
-  Закрепите колпачок, чтобы зажать цангу.
-  Montera spännhuven för att spänna fast spännhylsan
-  按照图示方法，将后帽与钨极夹通过螺纹连接到一起







6 Insert the Tungsten



-  Insertar el tungsteno
-  Włóż elektrodę wolframową od przodu palnika
-  Inserir o Tungstênio
-  Вставьте вольфрамовый электрод.
-  Montera elektroden
-  按照图示方法，将钨极装到钨极夹的内孔中，顺时针旋转后帽夹紧钨极







7 Assemble the ceramic - push on



-  Ubicar la cerámica - encajar
-  Zamocuj dyszę ceramiczną
-  Posicionar o bocal de cerâmica - encaixar
-  Закрепите керамическое сопло.
-  Tryck på gashylsan
-  按照图示方法，将陶瓷喷嘴装到不锈钢热套上，并推紧

8 Tighten the back cap. You're ready to go!



-  Armar el capuchón. Usted está listo!
-  Dokręć korek w celu zaciśnięcia elektrody wolframowej w palniku
-  Apertar a capa do tungstênio. Você está pronto!
-  Затяните колпачок. Горелка готова к работе!
-  Dra åt spännhuven. Nu är det klart att svetsa!
-  按照图示方法，逆时针旋转后帽松开钨极，调整钨极位置，顺时针旋转后帽夹紧并固定钨极位置

ARC TIG WEAR PARTS SET-UP OVERVIEW



MAKE WORK LIFE EASIER

T1/T1WLT/T1W

Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size						
						1.0	1.6	2.4	3.2	4.0	4.8	6.4
4	6mm 1/4"	6 l/min	8mm	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	8mm	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	10mm	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	8 l/min	10mm	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	8 l/min	10mm	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	13mm	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
Quartz cups can be used for Aluminium welding but only in short runs



Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Steel, Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size						
						1.0	1.6	2.4	3.2	4.0	4.8	6.4
4	6mm 1/4"	5 l/min	10mm	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	10mm	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	13mm	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	8 l/min	14mm	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	8 l/min	15mm	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	15mm	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
Quartz cups can be used for Aluminium welding but only in short runs



Short Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size						
						1.0	1.6	2.4	3.2	4.0	4.8	6.4
5	8mm 5/16"	6 l/min	8mm	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	8 l/min	8mm	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	10mm	●	●	●	●	●	●	●	●	●



Short Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Steel, Aluminium and Stainless Steel

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size						
						1.0	1.6	2.4	3.2	4.0	4.8	6.4
5	8mm 5/16"	6 l/min	8mm	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	8 l/min	8mm	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	10mm	●	●	●	●	●	●	●	●	●



ARC TIG WEAR PARTS SET-UP OVERVIEW



MAKE WORK LIFE EASIER

T1/T1WLT/T1W



Super Series Nozzle Super Series Gas Lens Collet Body Set-up

Recommended Set-up Parameters for Titanium,Stainless Steel,Steel,Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
12	20mm 3/4"	12 l/min	25mm	●	●	●	●	●	●	●	●	●	●
14	23mm 15/16"	12 l/min	25mm	●	●	●	●	●	●	●	●	●	●
18	28mm 1-1/10"	15 l/min	35mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
 The Tungsten stick out should be minimum 10mm for aluminium welding
 Quartz cups can be used for Aluminium welding but only in short runs
 150A DC max amps with 1/16"-1.6mm tungsten.
 200A DC max amps with 3/32"-2.4mm tungsten.
 240A DC max amps with 1/8"-3.2mm tungsten.
 Prevent arc starting from gauze.
 Start arc at low Amp.

T2/T3W/T4W



Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
4	6mm 1/4"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	11mm	●	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	7 l/min	12mm	●	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	10 l/min	13mm	●	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	12 l/min	15mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
 Quartz cups can be used for Aluminium welding but only in short runs

Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless steel , Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
4	6mm 1/4"	5 l/min	10mm	●	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	13mm	●	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	7 l/min	14mm	●	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	8 l/min	15mm	●	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	20mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.
 Quartz cups can be used for Aluminium welding but only in short runs

ARC TIG WEAR PARTS SET-UP OVERVIEW



MAKE WORK
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T2/T3W/T4W



Super Series Nozzle Super Series Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Titanium, Stainless steel, steel, Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
12	20mm 3/4"	12 l/min	25mm	●	●	●	●	●	●	●	●	●	●
14	23mm 15/16"	12 l/min	25mm	●	●	●	●	●	●	●	●	●	●
18	28mm 1-1/16"	15 l/min	35mm	●	●	●	●	●	●	●	●	●	●
24	38mm 1-1/2"	20 l/min	55mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

The Tungsten stick out should be minimum 10mm for Aluminium welding

Quartz cups can be used for Aluminium welding but only in short runs

150A DC max amps with 1/16"-1.6mm tungsten.

200A DC max amps with 3/32"-2.4mm tungsten.

240A DC max amps with 1/8"-3.2mm tungsten.

Prevent arc starting from gauze.

Start arc at low amp.

T3/T5W/T5WA



Standard Nozzle Collet Body Set-Up

Recommended Set-up Parameters for Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
4	6mm 1/4"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	11mm	●	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	7 l/min	12mm	●	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	10 l/min	13mm	●	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	12 l/min	15mm	●	●	●	●	●	●	●	●	●	●
12	19mm 3/4"	15 l/min	18mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

Quartz cups can be used for Aluminium welding but only in short runs

Standard Nozzle Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless Steel, Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic Nozzle	Quartz Option	Tungsten Size							
						1.0	1.6	2.4	3.2	4.0	4.8	6.4	
4	6mm 1/4"	5 l/min	10mm	●	●	●	●	●	●	●	●	●	●
5	8mm 5/16"	6 l/min	10mm	●	●	●	●	●	●	●	●	●	●
6	10mm 3/8"	7 l/min	13mm	●	●	●	●	●	●	●	●	●	●
7	11mm 7/16"	7 l/min	14mm	●	●	●	●	●	●	●	●	●	●
8	12mm 1/2"	8 l/min	15mm	●	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	20mm	●	●	●	●	●	●	●	●	●	●
12	19mm 3/4"	13 l/min	20mm	●	●	●	●	●	●	●	●	●	●

Note: Maximum recommended tungsten for Quartz option is 3.2mm.

Quartz cups can be used for Aluminium welding but only in short runs

ARC TIG WEAR PARTS SET-UP OVERVIEW



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T3/T5W/T5WA



Large Gas Lens Nozzle With Large Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Stainless Steel, Steel and Aluminium

Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic		Quartz		Tungsten Size						
				Nozzle	Option	1.0	1.6	2.4	3.2	4.0	4.8	6.4		
8	12mm 1/2"	8 l/min	15mm	●	●	●	●	●	●	●	●	●	●	●
10	15mm 5/8"	10 l/min	20mm	●	●	●	●	●	●	●	●	●	●	●
12	19mm 3/4"	13 l/min	20mm	●	●	●	●	●	●	●	●	●	●	●
14	24mm 15/16"	15 l/min	25mm	●	●	●	●	●	●	●	●	●	●	●

Note: Please refer to Page 58 for recommended Tungsten parameters.
The Tungsten stick out should be minimum 10mm for Aluminium welding

Super Series Nozzle With Super Series Gas Lens Collet Body Set-Up

Recommended Set-up Parameters for Titanium, Stainless steel, steel, Aluminium



Nozzle Size	Bore Size	Suggested Gas Flow Rate	Maximum Tungsten Stick-out	Ceramic		Quartz		Tungsten Size						
				Nozzle	Option	1.0	1.6	2.4	3.2	4.0	4.8	6.4		
14	23mm 15/16"	12 l/min	25mm	●	●	●	●	●	●	●	●	●	●	●
18	28mm 1-1/10"	15 l/min	35mm	●	●	●	●	●	●	●	●	●	●	●
24	38mm 1-1/2"	20 l/min	55mm	●	●	●	●	●	●	●	●	●	●	●

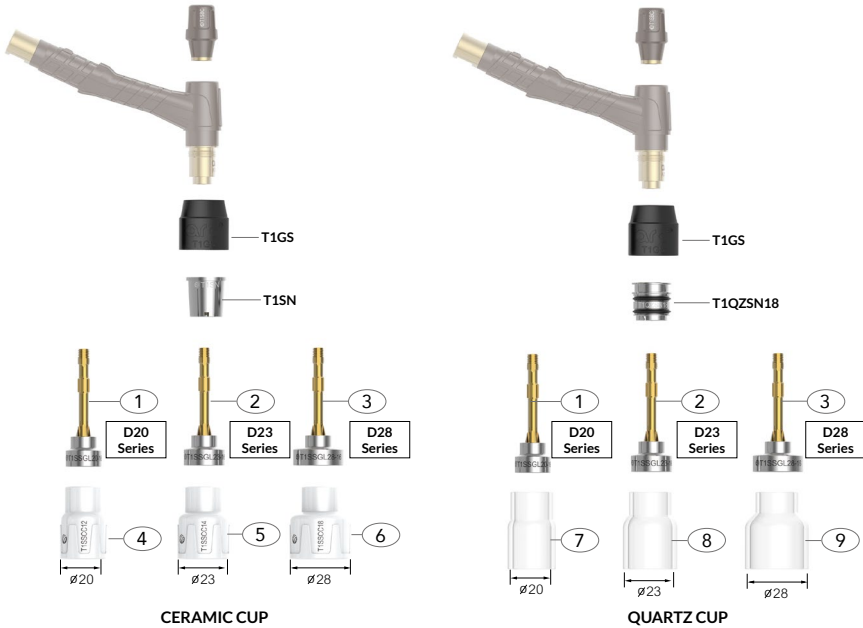
Note: Maximum recommended tungsten for Quartz option is 3.2mm.
The Tungsten stick out should be minimum 10mm for Aluminium welding
Quartz cups can be used for Aluminium welding but only in short runs
150A DC max amps with 1/16"-1.6mm tungsten.
200A DC max amps with 3/32"-2.4mm tungsten.
240A DC max amps with 1/8"-3.2mm tungsten.
Prevent arc starting from gauze.
Start arc at low amp.
Please refer to Page 58 for recommended Tungsten parameters.

ARC T SUPER SERIES SYSTEM SET-UP OVERVIEW



MAKE WORK
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T1 / T1FX / T1WLT / T1WFXLT / T1W / T1WFX



Part No.	Bore
1	T1SSGL20-16 1.6mm 1/16"
	T1SSGL20-20 2.0mm 5/64"
	T1SSGL20-24 2.4mm 3/32"
	T1SSGL20-32 3.2mm 1/8"
2	T1SSGL23-16 1.6mm 1/16"
	T1SSGL23-20 2.0mm 5/64"
	T1SSGL23-24 2.4mm 3/32"
	T1SSGL23-32 3.2mm 1/8"
3	T1SSGL28-16 1.6mm 1/16"
	T1SSGL28-20 2.0mm 5/64"
	T1SSGL28-24 2.4mm 3/32"
	T1SSGL28-32 3.2mm 1/8"

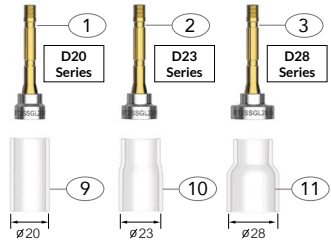
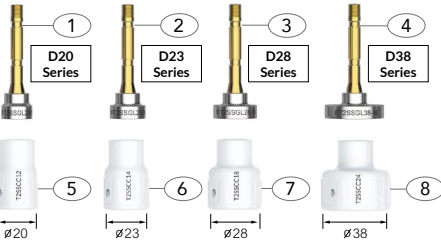
Part No.	Bore
4	T1SSCC12 20mm 3/4"
5	T1SSCC14 23mm 15/16"
6	T1SSCC18 28mm 1-1/10"
7	T1SSQZ12 20mm 3/4"
8	T1SSQZ14 23mm 15/16"
9	T1SSQZ18 28mm 1-1/10"

ARC T SUPER SERIES SYSTEM SET-UP OVERVIEW



MAKE WORK
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T2 / T2FX / T3W / T3WFX / T4W / T4WFX



CERAMIC CUP

QUARTZ CUP

Part No.	Bore
1	T2SSGL20-16 1.6mm 1/16"
	T2SSGL20-20 2.0mm 5/64"
	T2SSGL20-24 2.4mm 3/32"
	T2SSGL20-32 3.2mm 1/8"
2	T2SSGL23-16 1.6mm 1/16"
	T2SSGL23-20 2.0mm 5/64"
	T2SSGL23-24 2.4mm 3/32"
	T2SSGL23-32 3.2mm 1/8"
3	T2SSGL28-16 1.6mm 1/16"
	T2SSGL28-20 2.0mm 5/64"
	T2SSGL28-24 2.4mm 3/32"
	T2SSGL28-32 3.2mm 1/8"
4	T2SSGL38-16 1.6mm 1/16"
	T2SSGL38-20 2.0mm 5/64"
	T2SSGL38-24 2.4mm 3/32"
	T2SSGL38-32 3.2mm 1/8"

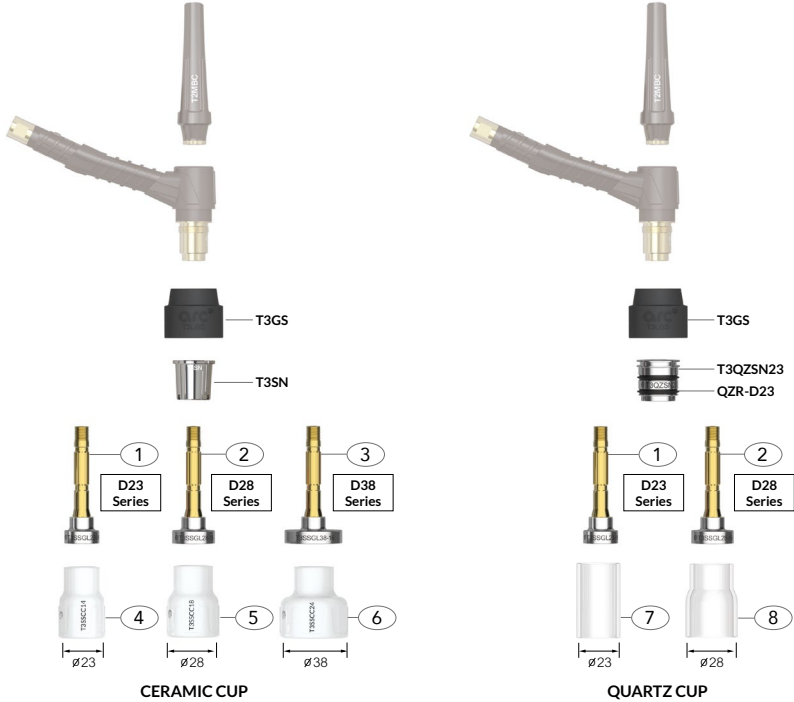
Part No.	Bore
5	T2SSCC12 20mm 3/4"
6	T2SSCC14 23mm 15/16"
7	T2SSCC18 28mm 1-1/10"
8	T2SSCC24 38mm 1-9/16"
9	T2SSQZ12 20mm 3/4"
10	T2SSQZ14 23mm 15/16"
11	T2SSQZ18 28mm 1-1/10"

ARC T SUPER SERIES SYSTEM SET-UP OVERVIEW



MAKE WORK
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T3 / T3FX / T5W / T5WFX



CERAMIC CUP

QUARTZ CUP

Part No.	Bore
1	T3SSGL23-16 1.6mm 1/16"
	T3SSGL23-20 2.0mm 5/64"
	T3SSGL23-24 2.4mm 3/32"
	T3SSGL23-32 3.2mm 1/8"
2	T3SSGL28-16 1.6mm 1/16"
	T3SSGL28-20 2.0mm 5/64"
	T3SSGL28-24 2.4mm 3/32"
	T3SSGL28-32 3.2mm 1/8"
3	T3SSGL38-16 1.6mm 1/16"
	T3SSGL38-20 2.0mm 5/64"
	T3SSGL38-24 2.4mm 3/32"
	T3SSGL38-32 3.2mm 1/8"

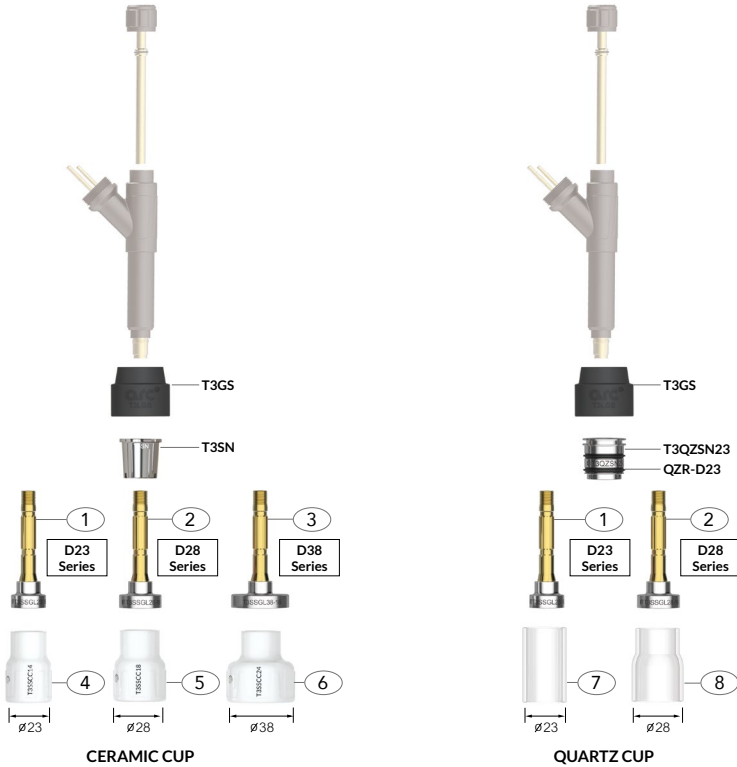
Part No.	Bore
4	T3SSCC14 23mm 15/16"
5	T2SSCC18 28mm 1-1/10"
6	T2SSCC24 38mm 1-9/16"
7	T3SSQZ14 23mm 15/16"
8	T3SSQZ18 28mm 1-1/10"

ARC T SUPER SERIES SYSTEM SET-UP OVERVIEW



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T5WA



CERAMIC CUP

QUARTZ CUP

Part No.	Bore		
1	T3SSGL23-16	1.6mm	1/16"
	T3SSGL23-20	2.0mm	5/64"
	T3SSGL23-24	2.4mm	3/32"
	T3SSGL23-32	3.2mm	1/8"
2	T3SSGL28-16	1.6mm	1/16"
	T3SSGL28-20	2.0mm	5/64"
	T3SSGL28-24	2.4mm	3/32"
	T3SSGL28-32	3.2mm	1/8"
3	T3SSGL38-16	1.6mm	1/16"
	T3SSGL38-20	2.0mm	5/64"
	T3SSGL38-24	2.4mm	3/32"
	T3SSGL38-32	3.2mm	1/8"

Part No.	Bore		
4	T3SSCC14	23mm	15/16"
5	T2SSCC18	28mm	1-1/10"
6	T2SSCC24	38mm	1-9/16"
7	T3SSQZ14	23mm	15/16"
8	T3SSQZ18	28mm	1-1/10"

ARC T HIGH PERFORMANCE SERIES

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2024.08



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