

AS 18-TW

water-cooled



**Different modular switch
units available:**

- single push-button
- double push-button
- up/down (4 push-buttons)
- single push-button
with potentiometer

320 Amp./100% duty cycle (DC)
240 Amp./100% duty cycle (AC)

AS 18-TW

water-cooled

Equipment: **A** standard
B gas lens
D gas lens jumbo



A

B

D



Gas lens insulator
17089021



Gas lens insulator jumbo
17089031



Collet L52mm
17 □ 5202 for 1,0/1,6/2,4
18 □ 5202 for 3,2/4,0
□ Please fill in size



Collet L52mm
17 □ 5202 for 1,0/1,6/2,4
18 □ 5202 for 3,2/4,0
□ Please fill in size



Collet L52mm
17 □ 5202 for 1,0/1,6/2,4
18 □ 5202 for 3,2/4,0
□ Please fill in size



Collet body
1796 □ 02 for 1,0/1,6/2,4
1896 □ 02 for 3,2/4,0
□ Please fill in size



Gas lens
1796 □ 11 for 1,0/1,6/2,4
1896 □ 11 for 3,2/4,0
□ Please fill in size



Gas lens jumbo
1796 □ 21 for 1,0/1,6/2,4
1896 □ 21 for 3,2/4,0
□ Please fill in size



Ceramic nozzle L47mm
for standard casing
Please state size
Also available in
special length L76mm



Ceramic nozzle L42mm
for gas lens
Please state size
Also available in
special length L76mm



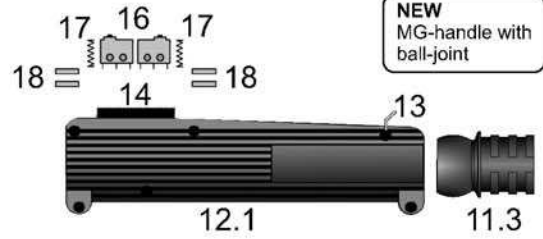
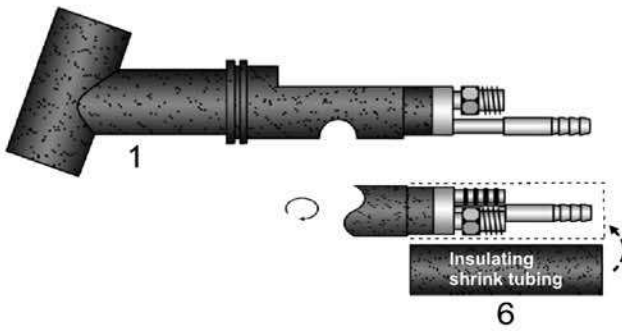
Ceramic nozzle L 48mm
for gas lens jumbo
Please state size

HSN 737

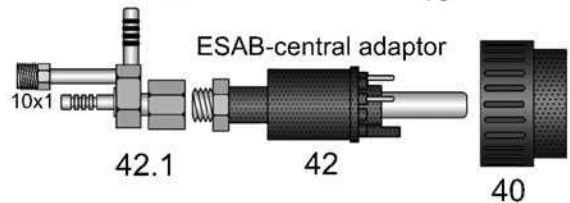
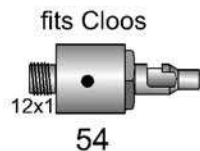
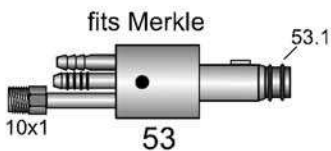
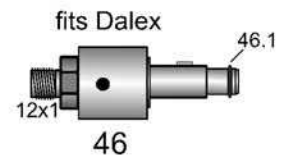
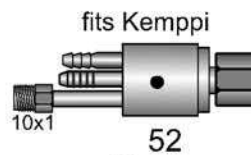
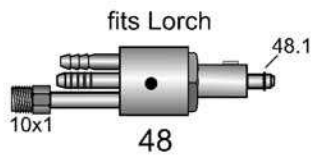
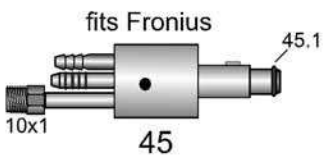
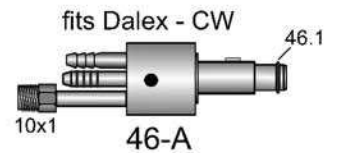
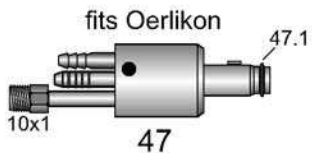
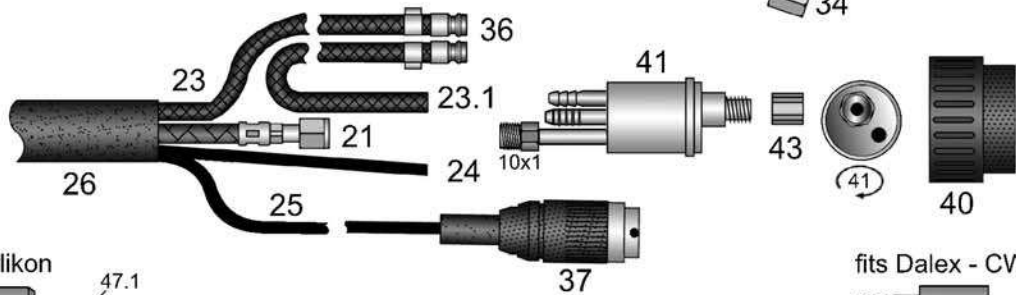
AS 18-TW water-cooled



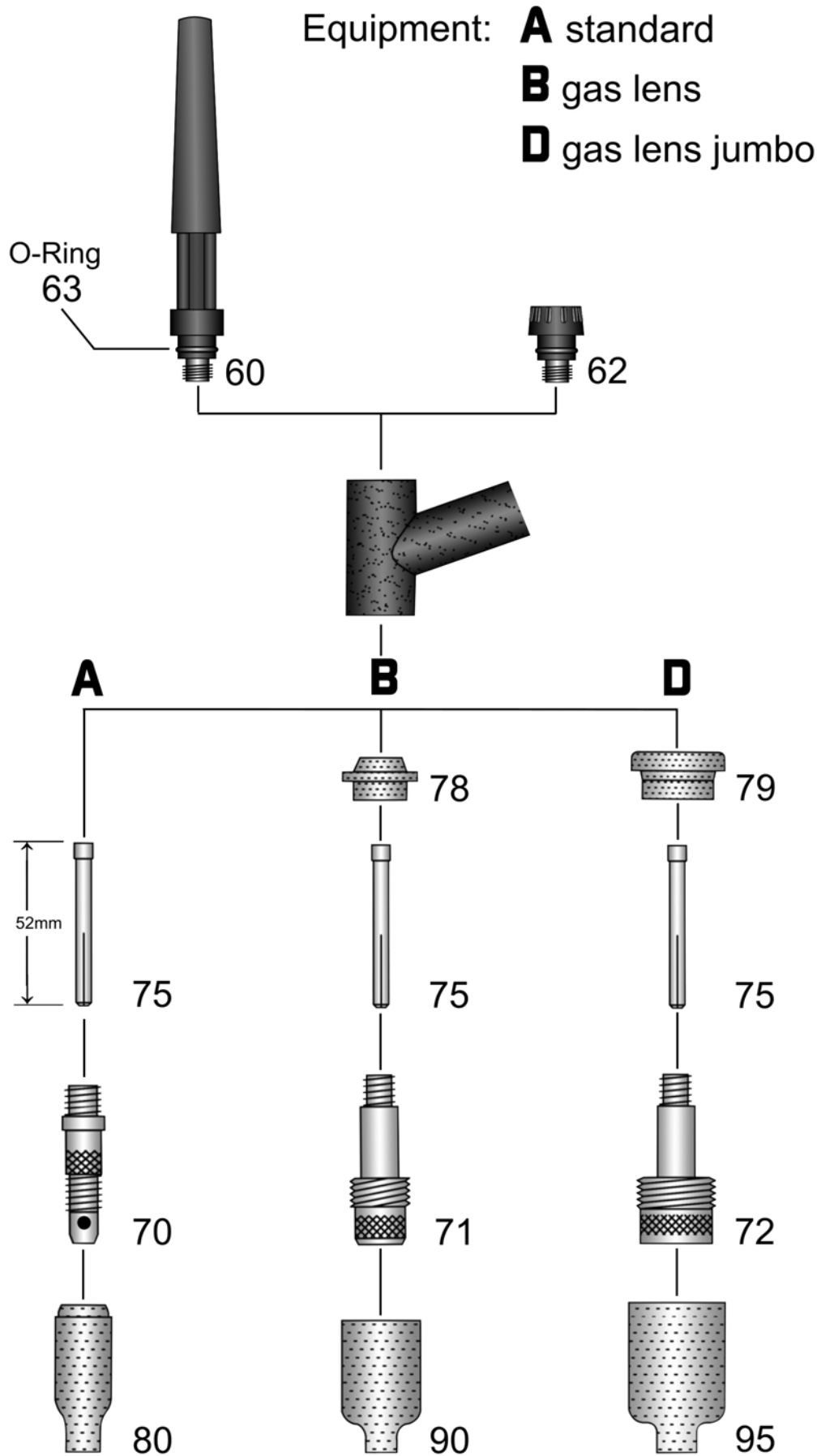
320 Ampere at 100% duty cycle (DC) - 240 Ampere at 100% duty cycle (AC)



Forma WIG-handle with ball joint and different modular switch units



HSN 525



AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

Art.-No.

Torches with first meter leather hose. Prices without leather on request. Machine side separate connections with Tichel plug.

In variation to the torches listed below, the torches can also be produced with other power/ water cables (e.g. HT 180 silicone superflexible). This can also be combined with hoses in a lot of different qualities. Torches and cable assemblies can be produced in excess lengths. Please find the different options and surcharges in the attachment "Custom made products" appendix C. We produce torches for more than 40 different brands of machines with different connection systems.

18600401 Torch AS 18-TW / 4m spare cable assembly ST 80 PVC-NIT

18600801 Torch AS 18-TW / 8m spare cable assembly ST 80 PVC-NIT

The following torches are equipped with very flexible and heat resistant HT110 rubber fabric hoses.

1860040P Torch AS 18-TW / 4m spare cable assembly HT 110

1860080P Torch AS 18-TW / 8m spare cable assembly HT 110

TIG-spare cable assemblies in different qualities, machine side with separate connections and Tichel plug, or, if ordered so, with the following connection systems:

wig92402 TIG-spare cable assembly water-cooled 4m - please state desired design!

wig92802 TIG-spare cable assembly water-cooled 8m - please state desired design!

The following surcharges for machine side connections are only to find prices quickly. Please use our catalogue "TIG machine side connections" to find a "T" number which identifies a machine side connection system completely.

29002102 Surcharge: machine side power/water plug SK35 bayonet connection AD13mm

29000201 Surcharge: machine side with EURO central adapter

29002109 Surcharge: machine side power/water plug fits Merkle with 2 O-rings

29002106 Surcharge: machine side power/water plug fits Fronius with 1 O-ring

29002101 Surcharge: machine side power/water plug fits Dalex with 1 O-ring

29002108 Surcharge: machine side power/water plug fits Oerlikon with 1 O-ring

29002104 Surcharge: machine side power/water plug fits Lorch SK35 + gas-nipple

29002105 Surcharge: machine side power/water plug fits Kemppi IT-G1/4"

29002110 Surcharge: machine side power/water plug fits Cloos

29000212 Surcharge: machine side fits ESAB central adapter, 4 pins installed at position 3,4,5,6

poti2901 Surcharge: 1 button with additional potentiometer

ud290001 Surcharge: 4 switches > up / down

Please note that there might be additional charges for special control line plugs. See appendix D.

1 18691001 Torch body AS 18-TW

6 18050002 Ignition insulating hose L75mm / ID39mm down to ID13mm

11.1 91914601 Forma TIG handle with screws, ball joint, without modular switch unit

11.2 91914602 Forma screw for handle

11.3 91914603 Forma hose bracket with ball joint ID21,5mm (also fits MG-handle)

11.4 91914611 Forma modular switch unit: 1 button with connecting adapter

11.5 91914621 Forma modular switch unit: 2 buttons with connecting adapter

11.6 91914631 Forma modular switch unit: 1 button + potentiometer (10k) with connecting adapter

11.7 91914641 Forma modular switch unit: 2 buttons + up/down (4 switches) with connecting adapter

11.8 91914651 Forma connecting adapter fits control line to modular switch unit

N.i. 91914661 Forma switch module safety nipple

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

Art.-No.

| | | |
|------|----------|--|
| 12.1 | 91914061 | MG-handle with ball joint, push-button, 2 return springs, 2 microswitches and 4 cylindrical pins |
| 13 | 91914421 | MG-tapping screw |
| 14 | 91915002 | MG-push button |
| 16 | 91914121 | MG-microswitch |
| 17 | 91914221 | MG-return spring |
| 18 | 91914321 | MG-cylindrical pin |

Please state the machine side connection for the following power/ water cables.

For 4m long torches:

| | | |
|----|----------|---|
| 20 | 12942401 | ST 80 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 4m |
| 20 | 12942404 | HT 105 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 4m |
| 20 | 12942403 | HT 110 rubber fabric hose power/water cable 10mm ² 12/18/20-TW / 4m |
| 20 | 12942405 | HT 130 TPE power/water cable 10mm ² 12/18/20-TW / 4m |
| 20 | 12942408 | HT 180 silicone super flexible power/water cable 10mm ² 12/18/20-TW / 4m |

For 8m long torches:

| | | |
|----|----------|---|
| 20 | 12942801 | ST 80 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 8m |
| 20 | 12942804 | HT 105 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 8m |
| 20 | 12942803 | HT 110 Rubber fabric hose power/water cable 10mm ² 12/18/20-TW / 8m |
| 20 | 12942805 | HT 130 TPE power/water cable 10mm ² 12/18/20-TW / 8m |
| 20 | 12942808 | HT 180 silicone super flexible power/water cable 10mm ² 12/18/20-TW / 8m |

The following power/ water cables are produced with M10x1 inner thread at the machine side for EURO central adapters. (fits to all Holch connection systems with outer thread M10x1).

For 4m long torches:

| | | |
|----|----------|---|
| 21 | 12942411 | ST 80 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 4m |
| 21 | 12942414 | HT 105 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 4m |
| 21 | 12942413 | HT 110 rubber fabric hose power/water cable 10mm ² 12/18/20-TW / 4m |
| 21 | 12942415 | HT 130 TPE power/water cable 10mm ² 12/18/20-TW / 4m |
| 21 | 12942418 | HT 180 silicone super flexible power/water cable 10mm ² 12/18/20-TW / 4m |

For 8m long torches:

| | | |
|----|----------|---|
| 21 | 12942811 | ST 80 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 8m |
| 21 | 12942814 | HT 105 PVC-NIT power/water cable 10mm ² 12/18/20-TW / 8m |
| 21 | 12942813 | HT 110 rubber fabric hose power/water cable 10mm ² 12/18/20-TW / 8m |
| 21 | 12942815 | HT 130 TPE power/water cable 10mm ² 12/18/20-TW / 8m |
| 21 | 12942818 | HT 180 silicone super flexible power/water cable 10mm ² 12/18/20-TW / 8m |

Reel goods:

Prices are per meter and only applicable for purchasing of complete rolls

| | | |
|------|----------|--|
| 23 | 50150001 | Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm blue for water (100m) |
| 23 | 51700002 | Meter HT 110 rubber fabric hose ID5,0-W1,7mm blue for water (100m) |
| 23.1 | 50151001 | Meter ST 80 PVC-NIT fabric hose ID5,0-W1,5mm red for water (100m) |
| 23.1 | 51700003 | Meter HT 110 rubber fabric hose ID5,0-W1,7mm red for water (100m) |
| 24 | 31000001 | Meter ST 70 PVC hose ID3,0-W1,0mm black for gas (100m) |
| 24 | 51700001 | Meter HT 110 rubber fabric hose ID5,0-W1,7mm black for gas (100m) |
| 24 | 31200001 | Meter HT 130 PUR hose ID3-W1,2mm black for gas (100m) |

N.i. 91902701 Meter control line 3x0,34mm² shielded black (100m)

N.i. 91902711 Meter control line 3x0,5mm² red (100m)

25 91902721 Meter control line 5x0,25mm² grey (100m)

26 22150002 Meter neoprene protective hose ID22mm black (40m)

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

| Art.-No. | | |
|---|----------|---|
| N.i. | 91915004 | Leather protective hose ID22mm / 1 meter long |
| N.i. | 91915007 | Leather protective hose ID22mm / 1 meter long with ball joint and hose connector |
| N.i. | 91915003 | Hose connector leather protective hose / protection hose ID19,5mm |
| 34 | 91901501 | Coupling nut IT-G1/4" |
| N.i. | 91901211 | Hose connector 4mm fits coupling nut R1/4" |
| 35 | 91901601 | Coupling nut IT-G3/8" |
| N.i. | 91901301 | Hose connector 5mm fits Coupling nut R3/8" |
| 36 | 91901001 | Cooling liquid plug nipples EURO |
| N.i. | 91901008 | Closing cap blue fits cooling liquid plug nipples EURO |
| N.i. | 91901009 | Closing cap red fits cooling liquid plug nipples EURO |
| 37 | 91904101 | Plug 3-poles Tuchel with bayonet-catch |
| 37 | 91904111 | Plug 5-poles Tuchel with bayonet-catch |
| More control line plugs see appendix D | | |
| 40 | 91900701 | Terminal nut insulated fits EURO central adapter |
| 41 | 91900211 | TIG central adapter EURO central adapter water cooled |
| 42 | 91900301 | TIG central adapter identical ESAB, 4 contact pins at position 3,4,5,6 |
| 42.1 | 91918571 | TIG power/cooling liquid junction fits ESAB central adapter |
| 42.3 | 91918312 | TIG central adapter SK-35 bayonet connection AD13mm |
| 43 | 91900901 | Coupling nut IT-M10x1 (rounded edges) fits EURO central adapter |
| 45 | 91918327 | Power/water plug fits Fronius with 1 O-ring (OT-M10x1 / like EURO central adapter) |
| 45.1 | 62190001 | O-ring ID6,2-W1,9mm fits Fronius |
| 46 | 9190417e | Power/water plug fits Dalex (1 O-ring) (OT-12x1) |
| 46-A | 9190418n | Power-/gasplug fits Dalex with waterdeviation to outside, CW-System with 1 O-ring |
| 46.1 | 63240001 | O-ring ID6,3-W2,4mm fits Dalex |
| 47 | 9190423n | Power/water plug fits Oerlikon with 1 O-ring (OT-M10x1 / like EURO central adapter) |
| 47.1 | 60717801 | O-ring ID6,07-W1,78mm fits Oerlikon |
| 48 | 9190420n | Power/water plug fits Lorch SK35 + gas-nipple (OT-10x1 / like EURO central adapter) |
| 48.1 | 91900801 | O-ring ID4-W1mm fits gas-nipple EURO central adapter |
| o.A | 91900552 | TIG cable support long (like MIG-MAG) with screws fits ESAB central adapter |
| N.i. | 91900554 | Attachment screw M4x8mm fits ESAB central adapter |
| 49 | 91900557 | TIG cable support short with screws (fits water-cooled) |
| N.i. | 91920702 | Screw M3x11,5mm for Ratio/Industry/RAUCH handle and cable support |
| N.i. | 91920703 | M3 mounting socket for Ratio/Industry/RAUCH handle and cable support |
| o.A. | 91900602 | Screw M4x6mm for TIG cable support short |
| 49.1 | 91901012 | Reduction-eyelet (rubber) from ID10,5mm to ID5mm fits TIG cable support short |
| N.i. | 91921701 | PUR hose ID8,5-W1,0mm 150mm long fits leading water hoses into cable support |
| 50 | 91912801 | Spring-socket EURO central adapter |
| 51 | 91912601 | Cable support spring fits EURO / ESAB central adapter |
| 52 | 9190419n | Power/water plug fits Kemppi IT-G1/4" (AG-M10x1 / like EURO central adapter) |
| 53 | 9190424n | Power/water plug fits Merkle with 2 O-rings (OT-M10x1 / like EURO central adapter) |
| 53.1 | 81600001 | O-ring ID8-W1,6mm fits Lorch/Merkle |
| 54 | 9190415n | Powerplug fits Cloos (special-plug) (OT-12x1) |
| 60 | 17091311 | Holch back cap long (german version with black O-ring) AS17-AS18-ABL220 57Y02-D |

AS 18-TW

Welding-torch TIG water-cooled

320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

| Art.-No. | | |
|---|----------|--|
| 62 | 17091301 | Holch back cap short (german version with black O-ring) AS17-AS18-ABL220 57Y04-D |
| 63 | 17089011 | O-ring black ID9-W2,5mm for back cap |
| 70 | 17961002 | Collet body 17-18-26-220 / 1,0 10N30 |
| 70 | 17961602 | Collet body 17-18-26-220 / 1,6 10N31 |
| 70 | 17962402 | Collet body 17-18-26-220 / 2,4 10N32 |
| 70 | 18963202 | Collet body 17-18-26-220 / 3,2 10N28 |
| 70 | 18964002 | Collet body 17-18-26-220 / 4,0 406488 |
| 71 | 17961011 | Gas lens 17-18-26-220 / 1,0 45V24 |
| 71 | 17961611 | Gas lens 17-18-26-220 / 1,6 45V25 |
| 71 | 17962411 | Gas lens 17-18-26-220 / 2,4 45V26 |
| 71 | 18963211 | Gas lens 17-18-26-220 / 3,2 45V27 |
| 71 | 18964011 | Gas lens 17-18-26-220 / 4,0 45V28 |
| 72 | 17961021 | Jumbo gas lens 17-18-26-220 / 1,0 45V0204 |
| 72 | 17961621 | Jumbo gas lens 17-18-26-220 / 1,6 45V116 |
| 72 | 17962421 | Jumbo gas lens 17-18-26-220 / 2,4 45V64 |
| 72 | 18963221 | Jumbo gas lens 17-18-26-220 / 3,2 995795 |
| 72 | 18964021 | Jumbo gas lens 17-18-26-220 / 4,0 45V63 |
| Brazen collets L-52mm | | |
| suitable equipment line (A) standard collet body | | |
| suitable equipment line (B) gas lens | | |
| suitable equipment line (D) gas lens jumbo | | |
| 75 | 17105202 | Collet L52mm AS17-AS18-ABL220 / 1,0 10N22-D |
| 75 | 17165202 | Collet L52mm AS17-AS18-ABL220 / 1,6 10N23-D |
| 75 | 17245202 | Collet L52mm AS17-AS18-ABL220 / 2,4 10N24-D |
| 75 | 18325202 | Collet L52mm AS17-AS18-ABL220 / 3,2 10N25-D |
| 75 | 18405202 | Collet L52mm AS17-AS18-ABL220 / 4,0 54N20-D |
| 78 | 17089021 | PTFE-Gas-lens insulator 17-18-26-220 54N01 |
| 79 | 17089031 | PTFE-Gas-lens insulator Jumbo 17-18-26-220 54N63 |
| Ceramic gas nozzles in different lengths | | |
| suitable equipment line (A) standard collet body | | |
| 80 | 17930401 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.4 10N50 (pu= 10pieces) |
| 80 | 17930501 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.5 10N49 (pu= 10pieces) |
| 80 | 17930601 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.6 10N48 (pu= 10pieces) |
| 80 | 17930701 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.7 10N47 (pu= 10pieces) |
| 80 | 17930801 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.8 10N46 (pu= 10pieces) |
| 80 | 17930101 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.10 10N45 (pu= 10pieces) |
| 80 | 17930121 | Ceramic gas nozzle L47mm 17-18-26-220 / Gr.12 10N44 (pu= 10pieces) |
| N.i. | 17930404 | Ceramic gas nozzle L76mm 17-18-26-220 / Gr.4 10N50L (pu= 10pieces) |
| N.i. | 17930504 | Ceramic gas nozzle L76mm 17-18-26-220 / Gr.5 10N49L (pu= 10pieces) |
| N.i. | 17930604 | Ceramic gas nozzle L76mm 17-18-26-220 / Gr.6 10N48L (pu= 10pieces) |
| N.i. | 17930704 | Ceramic gas nozzle L76mm 17-18-26-220 / Gr.7 10N47L (pu= 10pieces) |
| Ceramic gas nozzles in different lengths | | |
| suitable equipment line (B) gas lens | | |
| 90 | 22093041 | Gas nozzle for gas lens L42mm / Gr.4 54N18 (pu= 10pieces) |
| 90 | 22093051 | Gas nozzle for gas lens L42mm / Gr.5 54N17 (pu= 10pieces) |

AS 18-TW

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320A at 100% duty cycle (DC) - 240A at 100% duty cycle (AC)

| Art.-No. | | |
|-----------------|----------|---|
| 90 | 22093061 | Gas nozzle for gas lens L42mm / Gr.6 54N16 (pu= 10pieces) |
| 90 | 22093071 | Gas nozzle for gas lens L42mm / Gr.7 54N15 (pu= 10pieces) |
| 90 | 22093081 | Gas nozzle for gas lens L42mm / Gr.8 54N14 (pu= 10pieces) |
| 90 | 22093111 | Gas nozzle for gas lens L42mm / Gr.11 54N19-11 (pu= 10pieces) |
| 90 | 22093121 | Gas nozzle for gas lens L42mm / Gr.12 54N19 (pu= 10pieces) |
| | | |
| N.i. | 22093054 | Gas nozzle for gas lens L76mm / Gr.5 54N17L (pu= 10pieces) |
| N.i. | 22093064 | Gas nozzle for gas lens L76mm / Gr.6 54N16L (pu= 10pieces) |
| N.i. | 22093074 | Gas nozzle for gas lens L76mm / Gr.7 54N15L (pu= 10pieces) |
| N.i. | 22093084 | Gas nozzle for gas lens L76mm / Gr.8 54N14L (pu= 10pieces) |

Ceramic gas nozzles jumbo in different lengths suitable equipment line (D) gas lens jumbo

| | | |
|------|----------|--|
| 95 | 22093066 | Jumbo gas nozzle L48mm / Gr.6 57N75 (pu= 10pieces) |
| 95 | 22093086 | Jumbo gas nozzle L48mm / Gr.8 57N74 (pu= 10pieces) |
| 95 | 22093106 | Jumbo gas nozzle L48mm / Gr.10 53N88 (pu= 10pieces) |
| 95 | 22093126 | Jumbo gas nozzle L48mm / Gr.12 53N87 (pu= 10pieces) |
| | | |
| N.i. | 22093067 | Jumbo gas nozzle L73mm / Gr.6 57N75L (pu= 10pieces) |
| N.i. | 22093087 | Jumbo gas nozzle L73mm / Gr.8 57N74L (pu= 10pieces) |
| N.i. | 22093107 | Jumbo gas nozzle L73mm / Gr.10 53N88L (pu= 10pieces) |
| N.i. | 22093127 | Jumbo gas nozzle L73mm / Gr.12 53N87L (pu= 10pieces) |

Top quality tungsten electrodes in 9 different qualities, see appendix A.