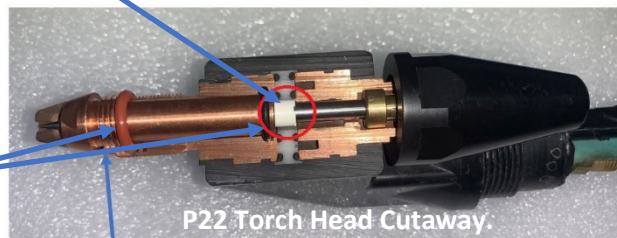


## Plasma Welding Torch assembly

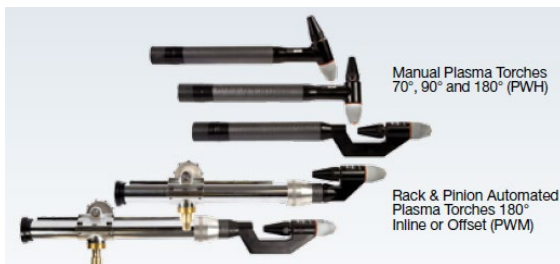
PWH/M P22 Torch Shown. P75. P15, P30 similar assembly.



1. Cup
2. Standard Tip (Keyhole Process)
3. Extended Tip (Melt-in Process)
4. Electrode
5. Liner (Red and Black O-Ring inside of Torch).
6. Gas Distributor
7. Collar
8. Shield Gas Diffuser
9. Cup Gasket
10. Torch Head
11. Collet
12. Back Cap



Stainless collar not shown.



Torch configurations:

- Phenolic Handle or Rack and Pinion.
- 70°, 90°, 180° inline or offset head.

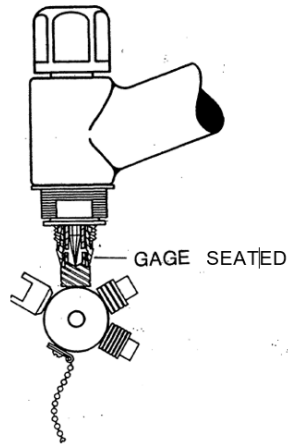
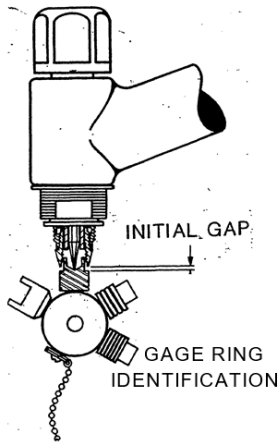
See Brochure for ordering information.

Note:

- Tip orifice designates current capability. The current rating on a tip is its maximum current capability.
- Electrode is 2% thoriated tungsten. The point is centered and machined at a specific angle. The use of TIG Tungsten can cause damage or failure to the torch. Hand grinding of the point will cause damage or failure of the torch.

- When in operation always:
  - Use two separate supplies of gas.
  - Purge before starting pilot.
  - Leave pilot on between welds and throughout the work shift.

### Electrode Setback



If a stiff columnated arc is desired, insert the electrode gage into the front of the torch and loosen the electrode cap slightly. Push back on the electrode with the gage until the shoulder of the gage seats against the front of the torch. Tighten the electrode cap while holding the gage in this position. Insert the proper

tip into the liner assembly and tighten moderately.

If a soft arc is desired, insert the proper tip into the liner assembly. Loosen the back cap slightly, allowing the electrode point to protrude through the orifice opening. Using a flat surface push the electrode back until it is flush with the tip face. Tighten the back cap.