

Other accessories orbital welding technology

ORBIPURGE forming set

Complete with Teflon gas hose and quick-release couplers. The ORBIPURGE forming set for inner diameter of the pipe 12 - 110 mm (0.472" - 4.331") includes all accessories for a quick and efficient internal forming during orbital welding.

Forming plugs for larger diameters are available separately.

- Suitable for all common materials
- Different forming plugs adapt precisely to the inner diameter of the pipe and thus ensure complete sealing.
- The complete set is delivered in a rugged plastic case
- The standard scope of delivery includes 2 forming plugs each per size, a Teflon gas hose as well as protective gas vents made of sinter metal with quick-release couplers.
- Is especially suitable for very high cleanliness requirements for the forming atmosphere and is the ideal supplement to the ORBmax residual oxygen meter (see from Page 83)
- The included, self-closing quick-release couplers allow a simple connecting and disconnecting of the gas hose

Replacement protective gas vents for ORBIPURGE forming plugs:
Fitting for all ORBIPURGE forming plugs.



ORBIPURGE forming set



Replacement protective gas vents



Ground cable



Hose package extensions

ITEM	CODE	KG
ORBIPURGE forming set	881 000 001	3.150
Replacement protective gas vents for ORBIPURGE 3/8"	881 020 014	0.030
Replacement protective gas vents for ORBIPURGE M5	881 020 015	0.005
Forming plugs pair ID 114 - 130 mm (4.488" - 5.118"), 3/8"	881 050 030	0.220
Forming plugs pair ID 121 - 142 mm (4.764" - 5.591"), 3/8"	881 050 031	0.230
Forming plugs pair ID 148 - 162 mm (5.827" - 6.378"), 3/8"	881 050 032	0.250

Ground cable

For utilization in combination with an Orbital welding power source of the ORBIMAT series.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	KG
Ground cables for ORBIMAT 165/180/300-power sources	5.0	16.4	811 050 005	2.400
Ground cables for ORBIMAT 300 CA AVC/OSC power sources	5.0	16.4	812 050 046	2.850

Hose package extensions

Fitting for all weld heads of Orbitalum, with exception of the AVC/OSC versions of the ORBIWELD TP series. The weld current connection adapter set may be required for usage with older Orbital welding power sources and heads with green Superior connections (see page 86). Newer machine models are already equipped with DINSE compatible connections.

Further lengths on request.

ITEM	LENGTH [M]	LENGTH [FT]	CODE	KG
Hose package extension 5 m (16 ft)	5	16	871 050 011	7.600
Hose package extension 10 m (32 ft)	10	32	871 050 012	14.600
Hose package extension 15 m (49 ft)	15	49	871 050 013	22.000
Hose package extension 20 m (64 ft)	20	64	871 050 016	28.700

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

Double pressure reducer

With 2 adjustable flow displays and possibility of connection of weld and forming gas.

TECHNICAL SPECIFICATIONS	ARGON/HYDROGEN	ARGON
Max. input pressure	200 bar	230 bar
Flow display	Up to 50 l/min.	Up to 30 l/min.
Bottle connection	W21.8x1/14" LH	W21.8x1/14"
Hose connection	G 3/8 LH	G 1/4

ITEM	VERSION	CODE	KG
Double pressure reducer	Argon	888 000 001	1.850
Double pressure reducer	Argon/hydrogen	888 000 002	1.870
Replacement seals for double pressure reducer		888 000 005	0.002



Double pressure reducer "Argon"

Bar pressure reducer "Argon"

For HX 16P, see Page 52.



Bar pressure reducer "Argon"

WS2 tungsten electrodes

WS electrodes are used for direct current and alternating current welding and are an adequate replacement for WT electrodes.

Advantages:

- High spark reliability
- Low combustion
- Long service life
- High arc quality

Contents: 10 pieces Length: 175 mm (6,890").
 Composition: WS2 = Rare earths (mixed oxides)
 Identification color: Turquoise

ITEM	ELECTRODE Ø [MM]	ELECTRODE Ø [INCH]	CODE	KG
WS2 tungsten electrodes	1.0	0.039	826 004 018	0.006
WS2 tungsten electrodes	1.6	0.063	826 004 019	0.010
WS2 tungsten electrodes	2.4	0.094	826 004 020	0.018



WS2 tungsten electrodes

Weld current connection adapter set

Simple, safe, robust and durable.

For usage with older Orbital welding power sources and heads with green Superior connections. Newer machine models are already equipped with DINSE compatible connections.

ITEM	CODE	KG
Welding current connection adapter set for socket & plug	850 030 004	0.326
Welding current connection adapter for plug	850 030 002	0.130
Welding current connection adapter for socket	850 030 003	0.195



Weld current connection adapter set

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY



TIG manual welding torch for ORBIMAT

TIG manual welding torch for ORBIMAT

High-performance TIG manual welding torch for ORBIMAT orbital welding power supplies for manual welding and tacking. The liquid-cooled manual welding torch offers optimum heat dissipation and high service life. Thanks to the handy design, the flexible hose package and the switching function integrated in the handle, the manual welding torch offers optimum user-friendliness.

Including lockable metal transport case as well as a wear parts set.

Characteristics:

- Liquid-cooled 250 A DC, 200 A AC
- Superflex hose package
- Flexible torch body
- Ergonomic handle

The scope of delivery includes:

- 1 TIG manual welding torch
- 1 transport case
- Torch wear parts set

The following accessories are mandatory for the use of the TIP manual welding torch and must be ordered separately:


- Ground cable, see Page 86

ITEM	HOSE PACKAGE [M]	HOSE PACKAGE [FT]	CODE	MACHINE WEIGHT KG	SHIPPING WEIGHT KG
TIG manual welding torch for ORBIMAT	4.0	13.0	890 013 010	2.425	6.405

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

Torch and cold wire accessories

ACCESSORIES	CLAMPING SLEEVE ELECTRODES		CLAMPING SLEEVE PRESSURE PIECE		TORCH ISOLATOR	
Image						
SUITABLE FOR:	CODE	KG	CODE	KG	CODE	KG
TP 250	811 020 018	0.001	812 005 002	0.003	811 013 001	0.001
TP 400 KD4-100	812 020 024	0.002			812 005 001	0.002
TP 400 KD3-62 (AVC/OSC)	812 020 024	0.002				
TP 600 (AVC/OSC)						
TP 1000 (AVC/OSC)						
P16	831 001 058	0.010	-	-	831 001 007	0.005
P16 AVC						
TIG manual welding torch	812 020 024	0.002	812 020 059	0.005	812 020 060	0.002
DRV turntables (standard)	890 020 039	0.005	890 020 046	0.009	890 020 041	0.002
DRV turntables (Jumbo)	-	-	-	-	812 020 065	0.012

ACCESSORIES	WIRE CORE							
Image								
Version	TP wire core 0.8 mm (0.031")		TP wire core 1.0 mm/1.2 mm (0.039"/0.047")		Front wire core (long) 0.8 mm (0.031")		Rear wire core (short) 0.8 mm (0.031")	
SUITABLE FOR:	CODE	KG	CODE	KG	CODE	KG	CODE	KG
TP 250	811 020 030	0.074	811 002 006		-	-	-	-
TP 400 KD4-100	812 020 041	0.009	811 002 005	0.009				
TP 400 KD3-62 (AVC/OSC)								
TP 600 (AVC/OSC)								
TP 1000 (AVC/OSC)								
P16					831 001 022	0.005	831 001 015	0.005
P16 AVC	-	-	-	-				
TIG manual welding								
DVR turntables	890 020 055	0.020	890 020 056	0.020				

ACCESSORIES	HF SPIRAL		TORCH SEAL		GAS NOZZLE		GAS LENS	
Image								
SUITABLE FOR:	CODE	KG	CODE	KG	CODE	KG	CODE	KG
TP 250 Clamping sleeve	831 001 027	0.003	811 005 020	0.003	811 020 017	0.004	811 020 016	0.004
TP 400 KD4-100	811 050 011	0.002	-	-	812 020 023	0.010	812 020 022	0.010
TP 400 KD3-62 (AVC/OSC)	831 001 027	0.003						
TP 600 (AVC/OSC)								
TP 1000 (AVC/OSC)								
P16					831 001 060	0.020	831 001 161	0.009
P16 AVC	811 050 011	0.002						
TIG manual welding	-	-			812 020 023	0.010	812 020 022	0.010
DRV turntables (standard)	-	-			812 020 023	0.010	812 020 022	0.010
DRV turntables (Jumbo)	-	-			812 020 064	0.039	812 020 063	0.048
Clamping sleeve JUMBO 2.4 mm MB 250 A	812 020 068	0.010						

OTHER ACCESSORIES FOR ORBITAL WELDING TECHNOLOGY

