

# ***CITORCH T NG***

High quality manual TIG welding torches



# CITORCH T NG

The **CITORCH T NG** new range of welding torches from OERLIKON brings innovative solutions to perform the most demanding works in various sectors.



## CITORCH T NG

- High quality welding results on carbon and stainless steels and light alloys.



- For high demanding sectors of activity.

Boiler making



Petrochemicals



Offshore



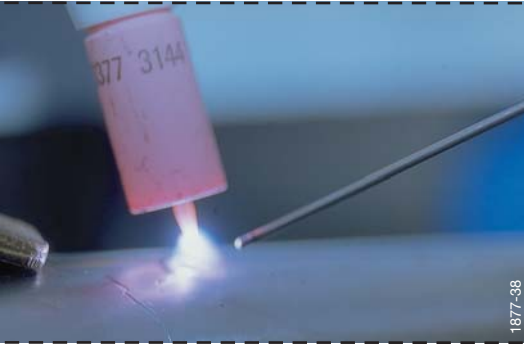
Shipbuilding



Piping



# A new range, a new design

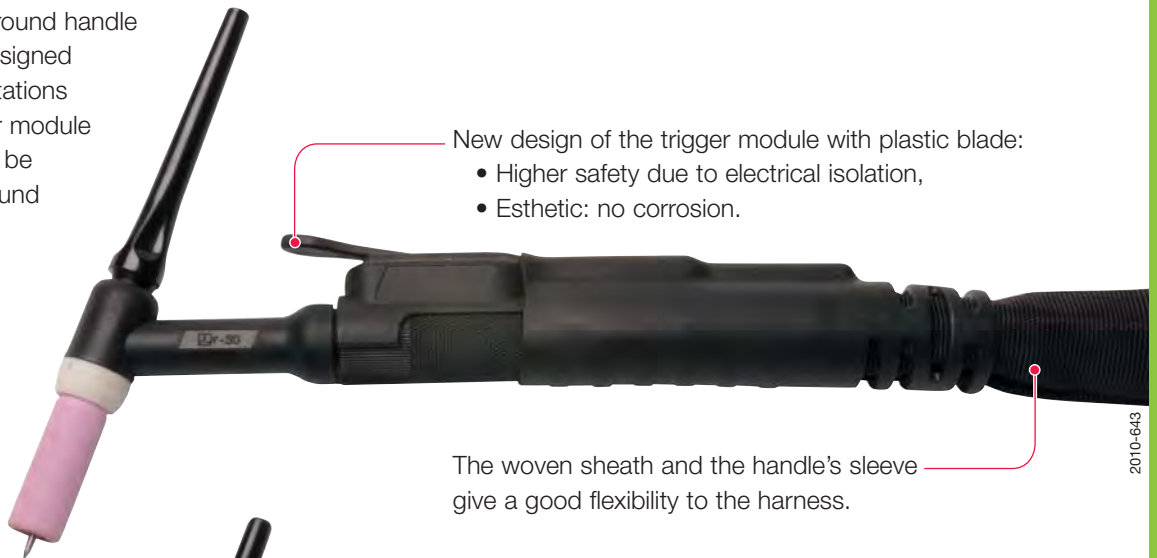


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**CITORCH T NG** range is presented in two models:

- Round handle serie (RL): easy to handle and easy to maintain,
- Ergonomic handle serie (EB): very comfortable to use and with various options in a modular system.

**RL serie** is the classic round handle TIG torches have been designed to meet all welding expectations in all positions. The trigger module is fully adjustable and can be moved in any position around the handle.



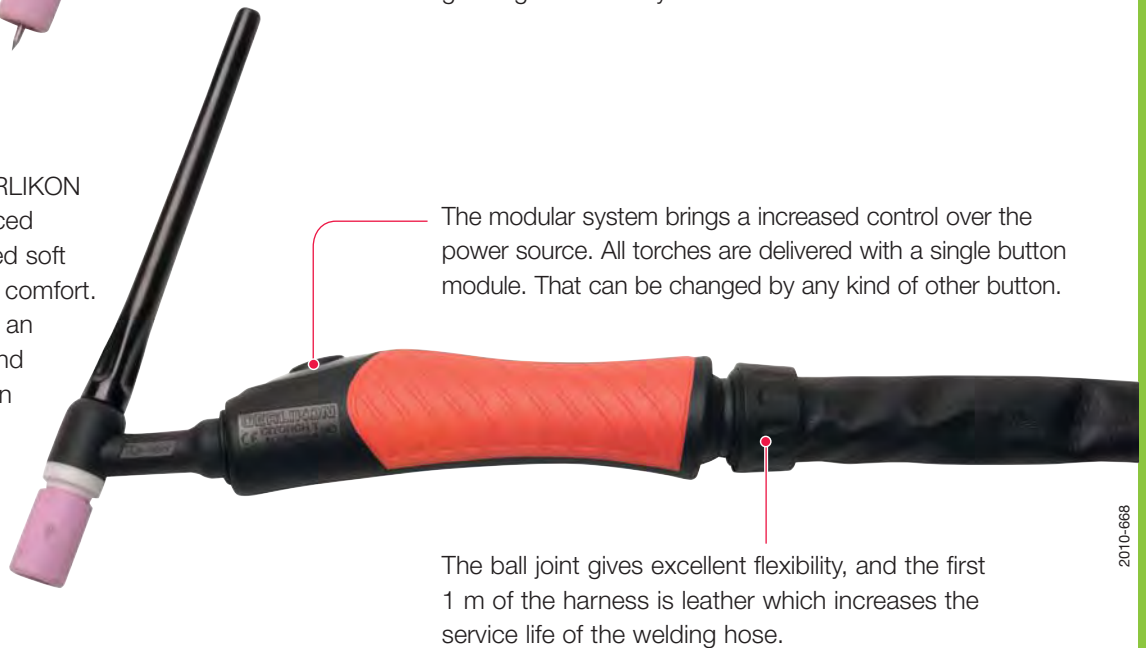
New design of the trigger module with plastic blade:

- Higher safety due to electrical isolation,
- Esthetic: no corrosion.

The woven sheath and the handle's sleeve give a good flexibility to the harness.

2010-643

**EB serie** is the best OERLIKON TIG torches with an advanced ergo-design, using a colored soft grip for a maximum welder comfort. These torches will give you an optimum welding quality, and increase the communication between the welder and the machine.



The modular system brings a increased control over the power source. All torches are delivered with a single button module. That can be changed by any kind of other button.

The ball joint gives excellent flexibility, and the first 1 m of the harness is leather which increases the service life of the welding hose.

2010-668



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2010-673



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The **CITORCH T NG** range includes 4 air cooled, and 3 water cooled types.

### Air cooled



		CITORCH T NG 10		CITORCH T NG 20		CITORCH T NG 30		CITORCH T NG 40			
Duty cycle 35%		125 A		150 A		200 A		250 A			
Duty cycle 60%		80 A		100 A		130 A		200 A			
Fitted as standard	back cap	long		long		long		long			
	nozzle	Ø 10 mm		Ø 10 mm		Ø 12 mm		Ø 12 mm			
	electrode	Ø 1.6 mm		Ø 2.0 mm		Ø 2.4 mm		Ø 2.4 mm			
To order											
Length		5 m	8 m	5 m	8 m	5 m	8 m	5 m	8 m		
Handle	RL	Connector	C5B	W000278984	W000278985	W000278986	W000278987	W000278988	W000278989	W000278990	W000278991
	EB	Connector	C5B	W000278380	W000278381	W000278382	W000278383	W000278384	W000278385	W000278386	W000278387

### Water cooled



		CITORCH T NG 10 W		CITORCH T NG 35 W		CITORCH T NG 40 W			
Duty cycle 100%		250 A		350 A		450 A			
Fitted as standard	back cap	long		long		long			
	nozzle	Ø 12 mm		Ø 15 mm		Ø 14 mm			
	electrode	Ø 2.4 mm		Ø 4.0 mm		Ø 4.8 mm			
To order									
Length		5 m	8 m	5 m	8 m	5 m	8 m		
Handle	RL	Connector	C5B	W000278992	W000278993	W000278994	W000278995	W000278996	W000278997
	EB	Connector	C5B	W000278388	W000278389	W000278390	W000278391	W000278392	W000278393

Single button delivery



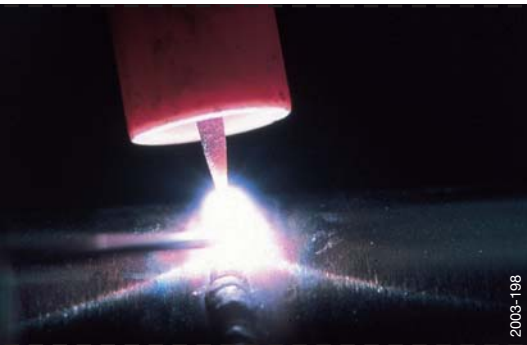
### Modular system

All torches are delivered with a single button module. If you want another control module, order it separately.

Refer to the instruction manual to see the different connections for the modules. For potmeter adapt the wiring to the welding machine.



- 1 Horizontal potmeter - W000279370
- 2 Vertical potmeter - W000279246
- 3 Double button - W000279242
- 4 Blade - W000279245

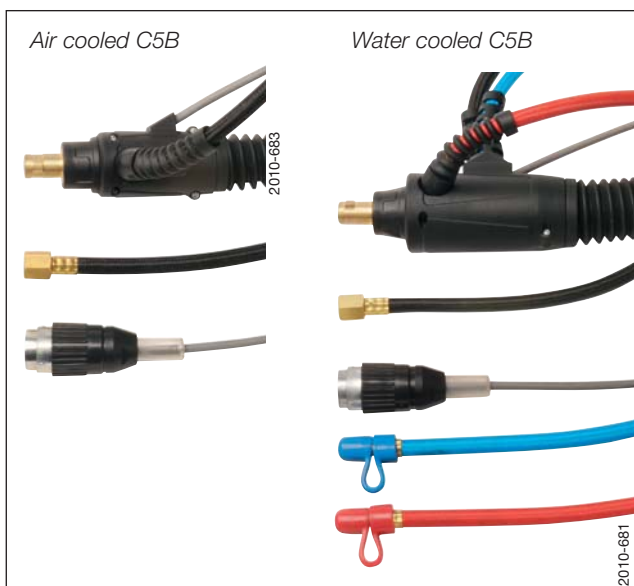


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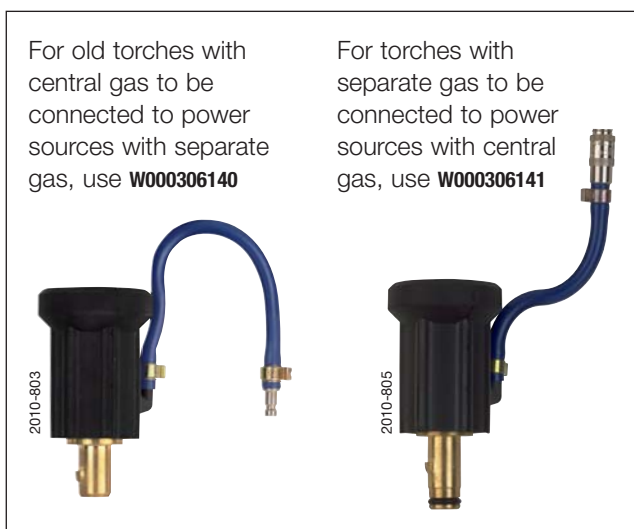
Connectors, adaptators, extensions and adjustable heads.

## Connectors

The connectors to the machine are in a new design, compact and fully protected delivering both strength and quality. All hoses are in rubber with a woven sheath for heavy duty work.



## Adaptators



## Extension

The extension harnesses are 15 m long and fitted with quick connectors and either S (banana) or 5 pins type trigger plugs. The connectors are protected by a leather cover with velcro fasteners.

- Air cooled version - **W000306135**
- Water cooled version - **W000306136**



## Adjustable heads

As an option, adjustable torch bodies are available. Welding in inaccessible locations becomes easier. You have the choice of 2 heads, small and large to be mounted on air cooled or water cooled bodies. Choose one body and one head to get a complete torch.

Air cooled body

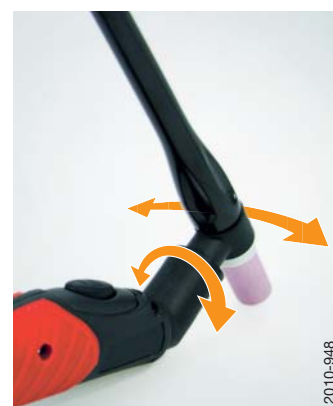
- **W000279381**

Water cooled body

- **W000279382**

Head CITORCH T  
NG 10 - **W000279383**

Head CITORCH T  
NG 20-30 - **W000279384**





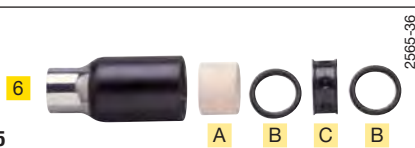
### Wear parts:

OERLIKON sets the standard for wear parts, ensuring maximum quality for both welding and the gas protection. Wear parts are common for RL or EB handles.



#### CITORCH T NG 40W

- A Insulating nut - W000306452
- B Nozzle seals - W000167673
- C Water distributor - W000271415



- The gas lens collet body **8** is supplied with a filter **9** and a sealing ring **7**.
- The ring **8** or the filter **9** are supplied on their own.

**Gas lens**, for welding where access is difficult.



**Nozzles 6 10:** choice of diameter

Welding current (A)	70	70	120	200	350
Diameter (mm)	6	8	10	12	15

All CITORCH T NG wear parts are compatible with the previous CITORCH T range.

		CITORCH T NG 10/10 W	CITORCH T NG 20	CITORCH T NG 30	CITORCH T NG 35 W / 40	CITORCH T NG 40 W
<b>1</b> Back cap	short	W000265603	W000265605	W000265605	W000265606	W000265607
	medium	W000265608	-	-	-	-
	long	W000265610	W000265611	W000265611	W000265612	W000265613
<b>2</b> Back cap o-ring		W000265616	W000265622	W000265622	W000265623	W000265624
<b>3</b> Sealing ring		W000265713	W000265630	W000265630	W000265631	-
<b>4</b> Electrode collet	Ø 1.0	W000265633	W000265634	W000265635	W000265636	-
	Ø 1.6	W000265638	W000265639	W000265640	W000265641	-
	Ø 2.0	W000265642	W000265643	W000265644	W000265645	-
	Ø 2.4	W000265654	W000265655	W000265656	W000265657	W000265658
	Ø 2.5	W000265659	W000265660	W000265661	-	-
	Ø 3.2	W000265662	W000265663	W000265664	W000265665	W000265666
	Ø 4.0	-	-	W000265667	W000265668	W000265669
Ø 4.8	-	-	-	W000265670	W000265671	
<b>5</b> Collet body all diameters		W000265672	W000265673	W000265674	W000265675	W000265677
<b>5*</b> Collet body heavy duty		-	-	-	W000306201*	-
<b>6</b> Nozzle	Ø 6.4	W000265695	W000265696	W000265697	W000265697	-
	Ø 8.0	W000265700	W000265701	W000265702	W000265702	-
	Ø 9.6	W000265704	W000265705	W000265706	W000265706	-
	Ø 11.0	-	-	-	-	W000265710
	Ø 12.8	W000265707	W000265708	W000265709	W000265709	-
<b>6L</b> Long Nozzle	Ø 14.0	-	-	-	-	W000265712
	Ø 15.7	-	-	W000265711	W000265711	-
	Ø 4.8	W000306456	-	-	-	-
	Ø 6.4	W000306457	-	W000306462	W000306462	-
	Ø 8.0	W000306458	-	W000306463	W000306463	-
<b>7</b> Gas lens sealing ring	Ø 9.6	W000306459	-	W000306464	W000306464	-
	Ø 11.2	-	-	W000306465	W000306465	-
	Ø 8.0	W000265713	W000265714	W000265714	W000265715	-
	Ø 9.6	W000265716	W000265717	W000265717	W000265718	-
	Ø 11.2	W000265719	W000265720	W000265720	W000265720	-
<b>8</b> Gas lens collet body	Ø 8.0	W000265721	W000265722	W000265722	W000265722	-
	Ø 9.6	W000265723	W000265724	W000265724	W000265724	-
	Ø 11.2	W000265725	-	-	-	-
	Ø 12.8	-	W000265726	W000265726	W000265726	-
	Ø 15.7	-	W000265727	W000265727	W000265727	-
<b>9</b> Gas lens filter	Ø 8.0	-	W000306467	W000306467	W000306467	-
	Ø 9.6	-	W000306468	W000306468	W000306468	-
	Ø 11.2	-	W000306469	W000306469	W000306469	-
	Ø 12.8	-	W000306470	W000306470	W000306470	-
	Ø 15.7	-	-	-	-	-
<b>10L</b> Long gas lens nozzle	Ø 8.0	-	-	-	-	-
	Ø 9.6	-	W000306468	W000306468	W000306468	-
	Ø 11.2	-	W000306469	W000306469	W000306469	-
Ø 12.8	-	W000306470	W000306470	W000306470	-	

\* For the collet body "heavy duty", use the gas lens nozzles



Wear parts are common for RL or EB handles.

### Maintenance kit

A complete kit for all your applications. The kit includes electrode collets, nozzles, back caps and collet body.

- CITORCH T NG 10/10W - W000306441
- CITORCH T NG 20 - W000306442
- CITORCH T NG 30 - W000306443
- CITORCH T NG 40/35W - W000306444
- CITORCH T NG 40W - W000306445



### Tungsten electrodes

A wide choice to meet all the welding requirements.

ISO 6848  
EN 26848

#### Choice criteria

Type	Metal	Arc stability	Striking	Lasting	Thermal resistance
Pur Tungsten	Light alloys	**	*	*	*
Tungsten with Thorium	Carbon and stainless steel	*	***	**	**
Tungsten with Cerium	Carbon and stainless steel	**	*	**	**
Tungsten with Lanthanum	All	**	***	***	***
Tungsten with rare Earths	All	**	***	***	***

\*\*\* Excellent \*\* Good \* Average

#### 11 Tungsten Electrodes WELDLINE - 150 mm long (except WS 20: 175 mm)

##### All purpose Tungsten Electrodes

Very high quality Tungsten electrodes (selected raw material and high-tech manufacturing process). Perfectly adapted to the most demanding applications.

Ø mm	WP Pure Tungsten	WT 20 Tungsten with Thorium 2%	WC 20 Tungsten with Cerium 2%	WL 20 Tungstenwith Lanthanum 2%	WS 20 Tungsten with rare Earths 2%
1.0	W000010009	W000010002	W000010022	W000010373	W000335166
1.6	W000010010	W000010003	W000010023	W000010016	W000335167
2.0	W000010011	W000010004	W000010024	W000010017	W000335168
2.4	W000010012	W000010005	W000010025	W000010018	W000335169
2.5	W000010013	W000010006	W000010026	W000010019	W000335170
3.2	W000010014	W000335156	W000335150	W000010020	W000335171
4.0	W000010015	W000010006	W000010028	W000010021	W000335172



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