

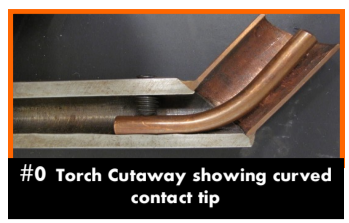
BOREWELDING TORCHES

Description	Bore ID		Part Number
	inch	mm	
#00	0.88 - 1.8	22.4 - 45.7	29063
#0	1.75 - 3	44.5 - 76.2	28448
#1	2.75 - 5.5	69.9 - 139.7	29064
#1A	3 - 5.5	76.2 - 139.7	39723
#2	4.5 - 7.5	114.3 - 190.5	29032
#3	6 - 9	152.4 - 228.6	29033
#4	8 - 11	203.2 - 279.4	29034
#5	10 - 13	254.0 - 330.2	29035
#6	12 - 15	304.8 - 381.0	30345
#7	14 - 17	355.6 - 431.8	31792
#8	16 - 19	406.4 - 482.6	30346
#9	18 - 21	457.2 - 533.4	30710
#10	20 - 23	508.0 - 584.2	30711
#11	22 - 25	558.8 - 635.0	30712
#12	24 - 27	609.6 - 685.8	30713
Bearing Clearance Torch	12 - 27	304.8 - 685.8	63916
#13/24 Extended Range	26 - 54	660.4 - 1371.6	34473
<i>13/24 Torch Requires 10 inch (254 mm) radial mount and slow rotation belt & pulley.</i>			
#000 Torch	0.5 - 1	12.7 - 25.4	39724
<i>Requires dedicated borewelder w/ fast rotation motor and push/pull feeder assembly. Use with 0.023 Wire & Weld approx. 75 amps.</i>			
OD Trammel Torch .88 to 14 inch dia.			27013
<i>Requires 2) 5 inch radial mounts & mounting rod extension (use with adjustable base only) Comes with Standard Torch adapter for extended reach</i>			
OD Trammel Torch, extended range 28"	28 max dia.	711.2 max dia.	38506
<i>Requires 1) 10 inch (254 mm) and 1) 5 inch radial mount & mounting rod extension (use with adjustable base only)</i>			
OD Trammel Torch, extended range 56"	56 max dia.	1422.4 max dia.	53004
<i>Requires 2) 10 inch (254 mm) and 1) 5 inch radial mount & mounting rod extension (includes standard torch adapter.)</i>			
Compact Face Torch 6 inch (152.4 mm) swing	2 - 19	50.8 - 482.6	48013
<i>NOTE: Compact face torch Needs a minimum 6 inches (152.4 mm) of axial and radial clearance to operate.</i>			
Standard Face Torch, .88"-20" Inch diameter capability (8 inch radius swing)			28186
Conical Torch			28020
<i>NOTE "A": Standard Diameter OD trammel, Face & Conical torches require radial mounts equal to the working radius of the job, and mounting rod extender. Trammel package includes standard torch adapter for extended reach. When in horizontal axis, order one counter-balance kit to eliminate rotation drive backlash. For use with Adjustable base only</i>			

USE COUNTERBALANCE WHEN IN HORIZONTAL AXIS



#00 and #0 Torch



#0 Torch Cutaway showing curved contact tip



#1 Torch



#1A Torch for Alloy Wires



Borewelding Torches #7 through #12



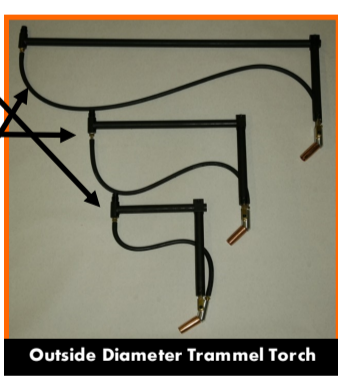
Bearing Clearance Torch



#13/24 "Extended Range" Torch



#000 Small Diameter Torch



Outside Diameter Trammel Torch



Standard Torch Adapter on Trammel Torch



Standard Torch Adapter, Trammel and Face Diameter Torch



Compact Face Torch



Standard Face Torch

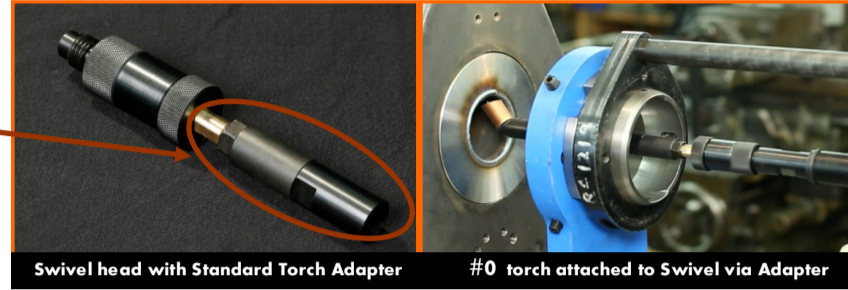


Conical Seat Torch

Swivel Torches - BW1000 Auto-BoreWelder			
Description	Bore ID		Part Number
	inch	mm	
#1 Swivel	2.75 - 8.2	69.9 - 208.3	39725
#2 Swivel	8 - 12	203.2 - 304.8	39726
Standard Torch adapter / SWIVEL	FOR Attaching standard BW3 torches to the BW1 and BW26 Swivel Type Torch (7/16-20 to 3/4-10 Union)		33804



#1 Head attached to Swivel, #2 head above



Swivel head with Standard Torch Adapter

#0 torch attached to Swivel via Adapter

Torch Extensions for BW 1000 2600 and 3000

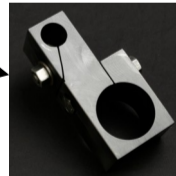
Description	Reach		Part Number
	inch	mm	
Torch extension	3	76.2	29038
Torch extension	6	152.4	29039
Torch extension	12	304.8	29040
Torch extension	18	457.2	29065



Torch Extensions

Mounting Hardware

Description	Part Number
Adjustable base	29037
Mounting rod	30773
Mounting rod extender	30831
Radial mount - 5 inch (127.0 mm)	28208
Radial mount - 10 inch (254.0 mm)	35006
Radial mount - BW1000 / BW2600 AutoBoreWelder	40958



Slow Rotation BW3000

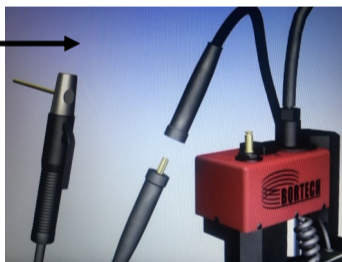
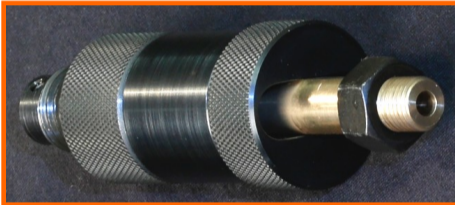
<u>Slow Rotation (1/2 stock speed) for welding over 27 inches (685.8 mm)</u> BW3000 ONLY Increases range to 54 inches	Part Number
Pulley	32574
V-belt, 11 inches (279.4 mm)	32575



Torch Accessories	Part Number
Adapter - Standard Torch to Face & Trammel (1/8 NPT to 3/4-10 Union with clamp)	36170
Adapter - Standard Torch to Swivel Head - model 106 & BW1000 (Dozer) (7/16/20 to 3/4-10 union)	33804
Counterbalance Used in horizontal axis only with bore torches above #6 and Face, Trammel and Conical Seat. (Eliminates rotation speed variation due to gravity and backlash in Rotation Drive)	30756
Mounting rod extender (6 inch) Used to extend the working distance between the borewelder and the part when using the Face Trammel Or Conical Seat torch. USE WITH ADJUSTABLE BASE ONLY (required for mounting OD trammel, facing & conical seat torches)	30831
Swivel Head Assembly - BW1000 (106 & Dozer)	35603
Torch Extension Support Arm with Offset Head- BW3000 (306-P)	33256
Torch Extension Support Arm - BW1000 (106 & Dozer)	40877
Stick Electrode Holder (BW3000 and BW5000) Connects to weld cable female quick- couple that attaches to borewelder. Use with Inverter type CC/CV weld power supply in order to stick weld, enabling immediate welding of bearing mounts, attachment bolts, or touch ups in buildup. This is a MUST HAVE in the field!!!	36169

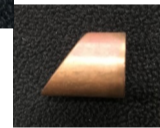


Standard Torch Adapter to Swivel head shown installed on Swivel head



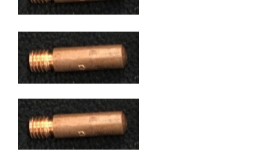
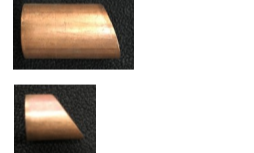
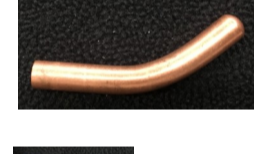
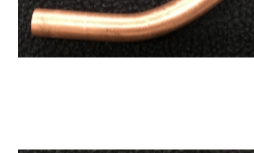
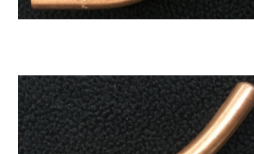
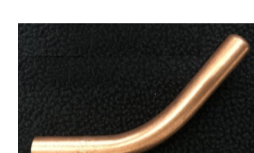
Consumables (Quick Ref)

Consumables (Quick Ref)			
Torch Tips	Wire Size		Part Number
	inch	mm	
Straight, screw in Contact Tip (for all torches <u>other than</u> #0, #00 and #000 torches)	0.030	0.8	70150
Straight, screw in Contact Tip (for all torches <u>other than</u> #0, #00 and #000 torches)	0.035	0.9	69865
Straight, screw in Contact Tip (for all torches <u>other than</u> #0, #00 and #000 torches)	0.045	1.2	70149
#0 Standard tip	0.035	0.9	69520
#0 EZ-FEED tip	0.045	1.2mm	69555
#00 Standard tip	0.035	0.9	69521
#00 EZ-FEED tip	0.045	1.2	69554
#000 tip	0.023	0.6	66888
#000 tip	0.030	0.8	67180
Nozzles	Detail		Part Number
Nozzle, Screw on Type -	Isolated screw on nozzle for all torches other than #0 #00		69866
#0 - Individual	Un-isolated Braze on nozzle for #00 ONLY		72974
#00 - Individual	Un-isolated Braze on nozzle for #0 ONLY		36531
Diffuser	Detail		Part Number
Diffuser for <u>all</u> torches except for #0 and #00	Screws into torch body and nozzle screws onto this		69778
Liner			
Liner supports the welding wire inside conduits, torches extensions and inside the borewelder it-	Wire Size		Part Number
	inch	mm	
Liner .144" O.D. for all BW3 BW26 and BW1 torches and extensions. Also for BW3 conduits.	0.023 / 0.045	0.6 / 1.2	62505 "per INCH" - 40424 16 feet
Liner .188" O.D. for all BW1 BW26 and BW3 Spindle Liner. Also for BW5 Conduit Liner	0.045 (.062 BW5)	1.2 / (1.8 BW5)	67162 "per INCH"
Liner .156" O.D. for all BW1 BW26 CONDUIT Liner. Has brass end crimped on it	0.045 (.062 BW5)	1.2 / (1.8 BW5)	48552



DETAILS OF CONTACT TIPS

TORCH #		DESCRIPTION of CONTACT TIP	CLX PN	BT PN
#0	CURVED	TIP WELDING STANDARD (COPPER) .035 / 0.9mm - 1.0mm (Used for mild steel welding, typical)	69520	10227
#0	CURVED	TIP WELDING STANDARD (CR/ZR) .035" / 0.9mm - 1.0mm CR/ZR* SEE BELOW (Good alternative for welding with alloy wires, longer tip life)	70204	10227 CR/ZR
#0	CURVED	TIP WELDING SP-EZ FEED (COPPER) .045 / 1.2mm. Standard radius bend with a large thru hole (.074" Hole diameter) Good Alternative when tough feeding with standard tip is experienced. Can increase wire flip	69555	10248
#0	CURVED	TIP WELDING SP-EZ FEED CR/ZR* .045 / 1.2mm Standard radius bend with a large thru hole (.074" Hole diameter) Good alternative for welding with alloy wires, but increased wire flip possibility	70599	10248 CR/ZR
#0	CURVED	TIP WELDING LARGE RADIUS (COPPER).035" / 0.9mm - 1.0mm The large radius tip can be used for welding with difficult to feed wires, as the contact tip is bent at a larger radius. (I prefer CR/ZR or EZ FEED)	67997	10228
#00	CURVED	TIP WELDING STANDARD .035 / 0.9mm - 1.0mm (used for mild steel welding, typical)	69521	10038
#00	CURVED	TIP WELDING STANDARD CR/ZR .035" / 0.9mm - 1.0mm CR/ZR* SEE BELOW (Good alternative for welding with alloy wires, longer tip life)	69891	10038 CR/ZR
#00	CURVED	TIP WELDING SP EZ-FEED .045 / 1.2mm (Standard radius bend with a .074" Hole diameter) Good Alternative when tough feeding with standard tip is experienced. Can increase wire flip	69554	10251
#00	CURVED	TIP WELDING SP EZ FEED CR/ZR .045 / 1.2mm CR/ZR* SEE BELOW (Standard radius bend with .074" Hole diameter) Good alternative for welding with alloy wires, but increased wire flip possibility due to large hole	70600	10251 CR/ZR
#0		NOZZLE BRAZE ON OR SILVER SOLDER	72974	10068-2
#00		NOZZLE BRAZE ON OR SILVER SOLDER	36531	10241-2
ALL OTHER TORCHES (with diffusers and insulated nozzles)				
	STRAIGHT	TIP, SCREW IN .035" / 0.9mm	69865	10081
	STRAIGHT	TIP, SCREW IN .035" / 0.9mm CR / ZR	62642	10081 CR/ZR
	STRAIGHT	TIP, SCREW IN .045" / 0.9mm	70149	10141
	STRAIGHT	TIP, SCREW IN .045" / 0.9mm CR / ZR	70205	10141 CR/ZR
		NOZZLE, INSULATED	69866	10092
		DIFFUSER,	69778	10040
HEAVY DUTY CONSUMABLES THESE HELP INCREASE RUNTIME WHEN WELDING AT HIGHER CURRENTS OR WITH DIFFICULT TO WELD WIRES. NOTE: ONLY AVAILABLE WITH DIFFUSER STYLE TORCHES, INCREASES TORCH RANGE BY 1.5" DIAMETER.				
	STRAIGHT	TIP HEAVY DUTY .035 (14-35)	67928	10108
	STRAIGHT	TIP HEAVY DUTY .045 (14-45)	67932	10109
		NOZZLE, LARGE, HEAVY WALL, INSULATED	68009	10238
		DIFFUSER HEAVY (52FN)	68002	10236
		SHIM (WASHER) FOR DIFFUSER BASE	68001	10235



- **Chrome Zirconum (CR/ZR) is alloyed with copper to increase mechanical wear properties at a high temperatures. Therefore it is advantageous when used for welding alloy wires.**
- **4 x increase in weld time with stainless steel when compared to standard copper contact tips.**