

forceTig - high-performance TIG joining process



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forceTig – high-performance TIG joining process

forceTig is a high-performance TIG welding process that can do more than traditional TIG solutions, combining the benefits of TIG welding (high quality weld seams) with increased efficiency. The forceTig process is perfect for automated and mechanised applications, with and without welding consumable, allowing users to take full advantage of high welding speeds. It can even be used to join extremely thick materials without the need for seam preparation, saving users time and money.

How does forceTig work?

Combining our high-performance power sources and effective welding torch and electrode cooling, users can use welding currents far beyond those available for standard TIG solutions. What's more, the effective electrode cooling means the arc is concentrated and more constricted, significantly increasing the arc's directional stability. The high-power range also allows high-alloy steels to be joined reliably with a single layer using keyhole technology.

Advantages:

- High currents possible for continuous operation – up to 1,000 A at 100% duty cycle
- Different torch constructions – perfectly equipped for all areas of use
- Sturdy, tried-and-tested welding torches
- Can be used to weld on material thicknesses up to 10 mm of high-alloy steels without seam preparation and in a single layer, no backing required
- Also suitable for non-ferrous metals such as copper, aluminium and titanium
- Usual TIG quality spatter-free, high weld seam quality and more reliable
- Keyhole effect for high-alloy steel in the high-power range to ensure secure root fusion
- Perfect for PA, PC and PG positions
- Increased welding speed and fewer parameter settings than with plasma welding processes
- Increased deposition rate possible thanks to hot wire, allows for cost-effective surfacing
- Welding torches can also be used with our automated standard TIG power sources using a media separation box

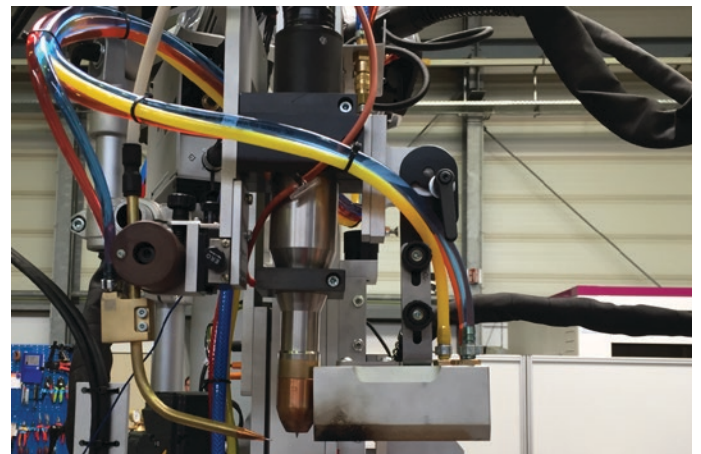
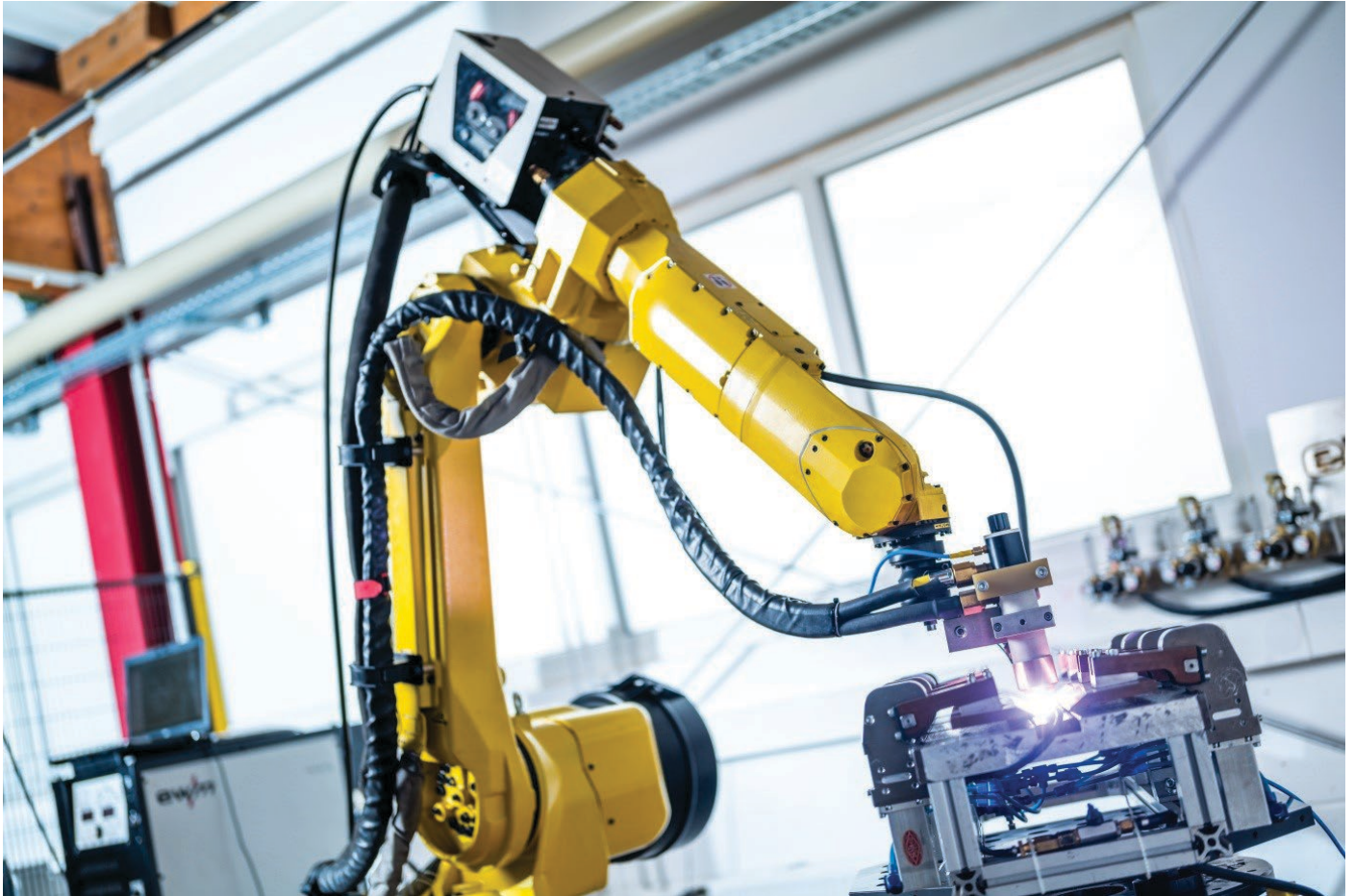
Fields of application:

- Perfect for high-alloy steel of various material thicknesses
- Container construction, e.g. in food industry
- High-alloy steel pipe construction, e.g. in chemical industry
- Endless production of pipes
- Heat exchangers
- Turbine construction



Sample applications

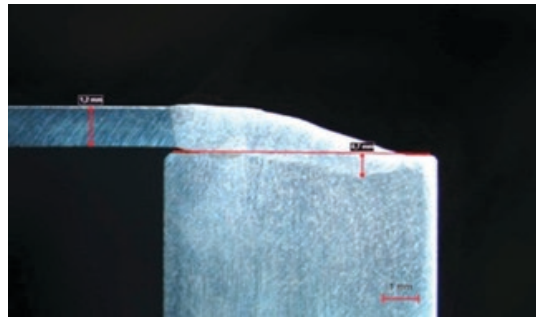
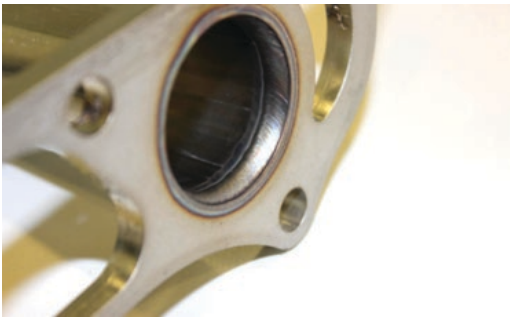
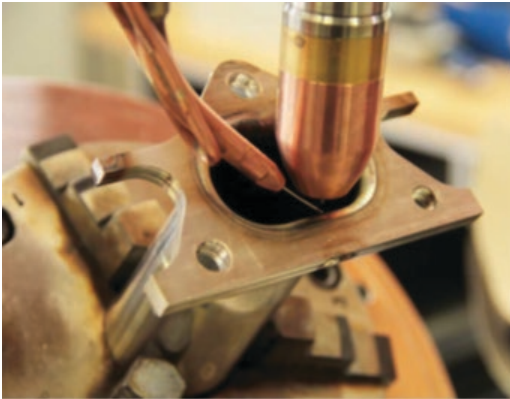
TIG joining processes can be used universally in the areas of thin and thick sheet metal processing, as part of automated or mechanised sequences, with and without filler wire.



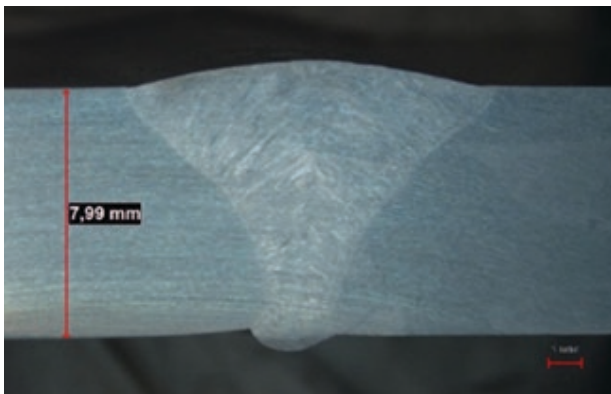
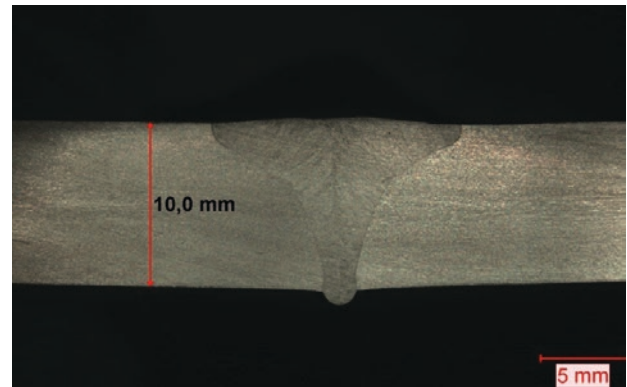
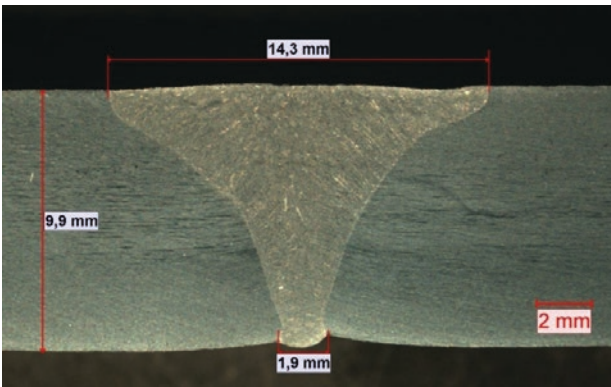


Sample applications

Automated robot applications for joining pipe-flange connections



Welding thick panels

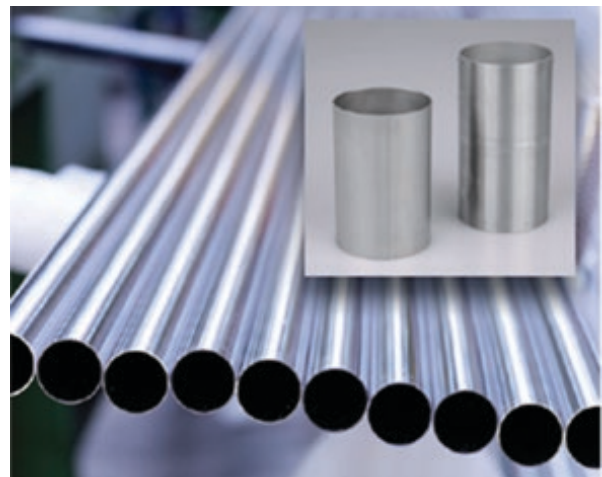




Hot wire surfacing

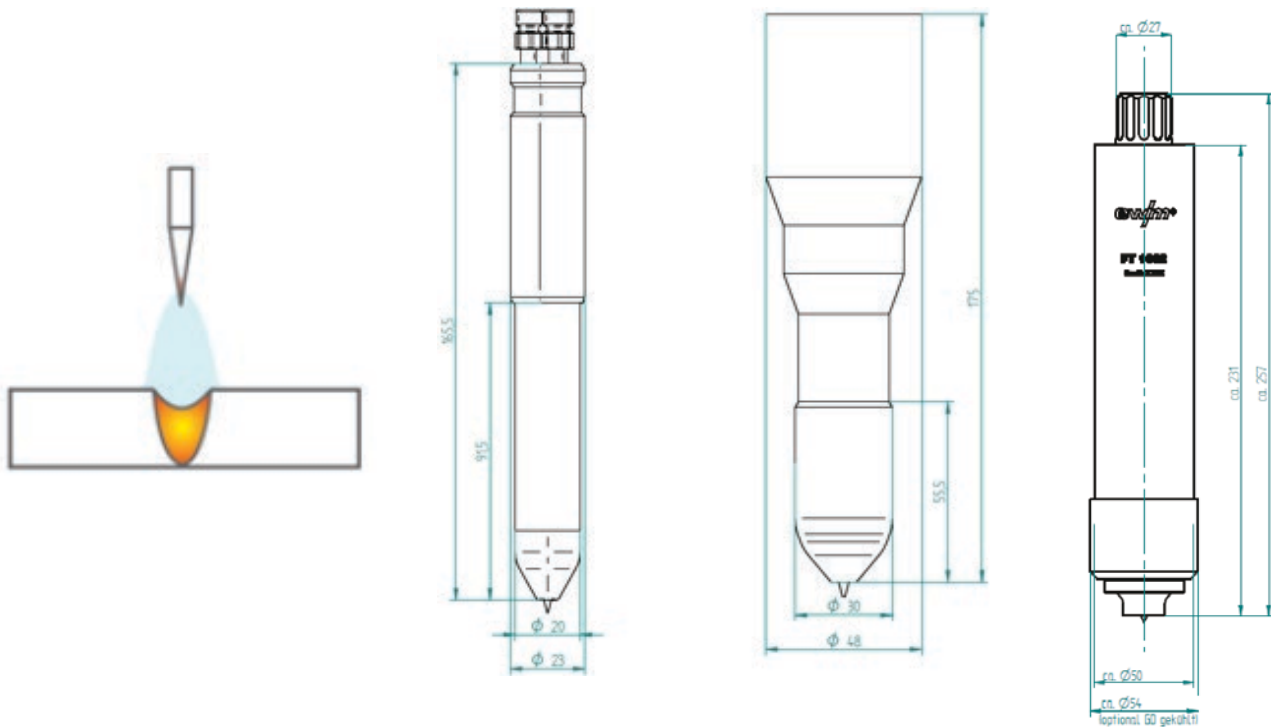


Welding thin panels and pipes without welding consumables





forceTig welding torches



FT500 and FT1000	FT1002
<ul style="list-style-type: none"> ■ FT500 with 500 A 100% duty cycle ■ FT1000 with 800 A 100% duty cycle ■ Compact design ■ Screwable electrode for ensuring reproducible TCP ■ Torch design with fewer consumables ■ 180° or 90° hose package routing ■ Optional slim and rigid wire feed 	<ul style="list-style-type: none"> ■ FT1002 with 1,000 A 100% duty cycle ■ Freely adjustable electrode length with collet ■ Electrodes with Ø 4, 6, 4, 8, 10, 12 mm available and can be resharpened ■ Electrodes can be changed without tools ■ Water-cooled gas nozzle – perfect for high currents in PA position ■ Optional flexible wire feed with 4-axis support



forceTig media separation box for connection to automated TIG-XX2 power sources

The forceTig media separation box is available in various different versions, for connection to power sources with up to 550 A and for power sources of 1,000 A. Connection to the power source is made using a corresponding connecting hose package. The media separation box is also equipped with a gas valve, gas test push-button and gas pressure sensor. The forceTig media separation box can be mounted on the side of the power source using an adapter plate or “externally” on a mounting console.



Front view



Rear view



Recommended power sources

	Tetrix 552	Tetrix 552 HW	Tetrix 1002
Welding current	5 A–550 A	5 A–550 A	10 A–1,000 A
Hot wire current	-	5 A–180 A	-
Duty cycle 40°	550 A/60%	550 A/60%	1,000 A/80%
	420 A/100%	420 A/100%	750 A/100%
Open circuit voltage	80 V	80 V	80 V
Variants/options			
DC	✓	✓	✓
AC/DC	✓	-	-
Filler wire	✓	✓	✓
tigSpeed	On request	✓	On request





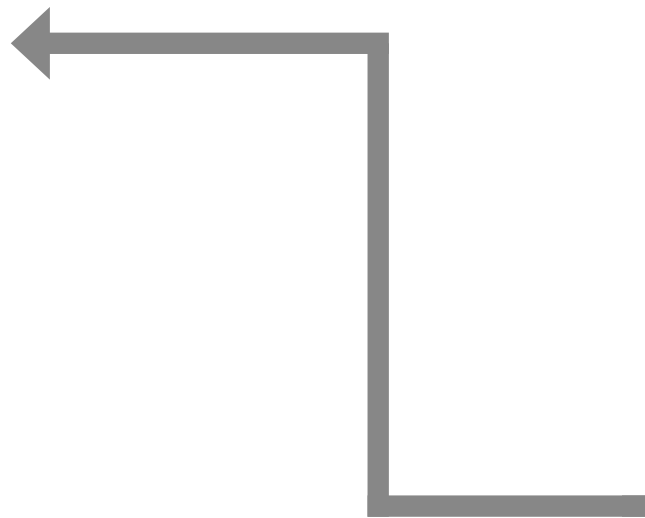
Overview of forceTig welding system – variant 1

Example configuration for easy integration into mechanised systems.

Control via 19-pole interface for automated welding.

Parameter setting via Synergic front control, RT50 remote control or PC300.

START/STOP and I>0 evaluation via 19-pole interface for automated welding



RK3.1 recooling unit required



Flow monitoring via external flow sensor

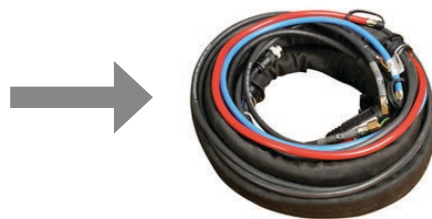




forceTig welding torch
FT500/FT1000/FT1000 AX/FT1002



The forceTig media separation box can be mounted "externally" or on the power source using adapter plate.



A corresponding 95 mm²/water/19-pol. connecting hose package (for 1,000 series: 2 x 95 mm² screw fittings) connects the power source and the media separation box. The maximum total length of the connecting hose package and the welding torch is 18 m.



Overview of forceTig welding system – variant 2

Example configuration for easy integration into mechanised systems
for use of additional wire

Control via special RINT X12 ATCASE interface with 28-pole connection.

Parameter setting via Synergic front control,
RT50, FR AW1 remote control or PC300.

TIG wire feeders
T drive 4 Rob 2/T drive 4 Rob 2



Cold wire regulation and cold wire ON
via FR AW1 remote control



START/STOP and
I>0 evaluation via
28-pole connection socket

RK3.1 recooling unit required

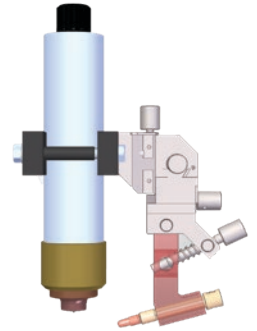
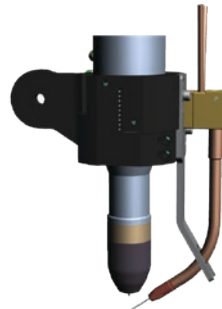
Flow monitoring via external flow
sensor





3/tigSpeed drive 4 Rob

forceTig welding torch
FT500/FT1000/FT1000 AX/FT1002



VSLP connecting hose package
for connecting wire feeders



Optional RT50 remote control



The forceTig media separation box
can be mounted "externally" or on the
power source using adapter plate.



A corresponding 95 mm²/water/19-pol. connecting hose package
(for 1,000 series: 2 x 95 mm² screw fittings) connects the power source and the media separation
box.

The maximum total length of the connecting hose package and the welding torch is 18 m.



Overview of forceTig welding system – variant 3

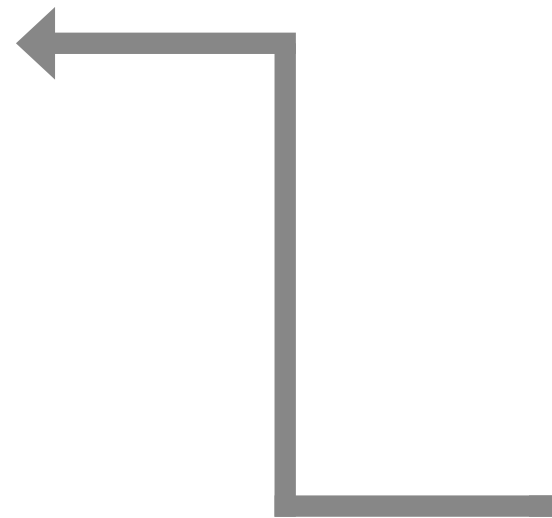
Example configuration for integration into fully automated systems with maximum scope of functions.

Control via RINT X12/BUSINT X11 interface.
Parameter setting via PC300 software in program mode or via higher-level control in control signal mode.

TIG wire feeders
T drive 4 Rob 2/T drive 4 Rob 2



Control via interface
RINT X12/BUSINT X11 in
program for control signal mode



RK3.1 recoling unit required

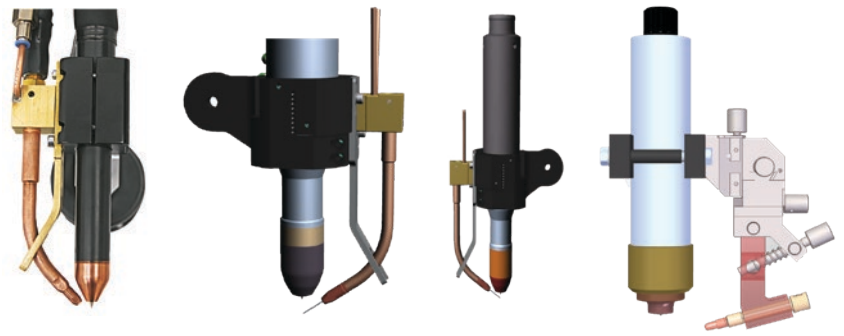
Flow monitoring via external flow
sensor





3/tigSpeed drive 4 Rob

forceTig welding torch
FT500/FT1000/FT1000 AX/FT1002



VSLP connecting hose package
for connecting wire feeders



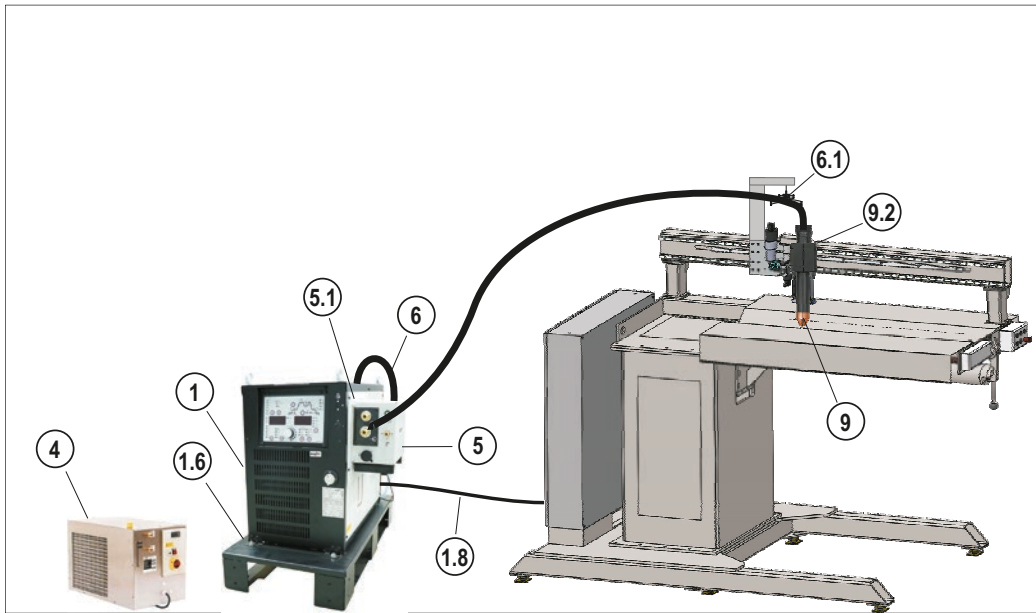
The forceTig media separation box
can be mounted "externally" or on the
power source using adapter plate.



A corresponding 95 mm²/water/19-pol. connecting hose package
(for 1,000 series: 2 x 95 mm² screw fittings) connects the power source and the media separation
box.
The maximum total length of the connecting hose package and the welding torch is 18 m.



■ forceTig, water cooled ■ forceTig welding system on longitudinal welding machine



Tetrix 552 Synergic

- With Synergic control
- FT500 forceTig media separation box
- Water cooled
- Example for easy integration into mechanised systems
- Control via 19-pole interface for automated welding
- Parameter setting via Synergic front control, RT50 remote control or PC300

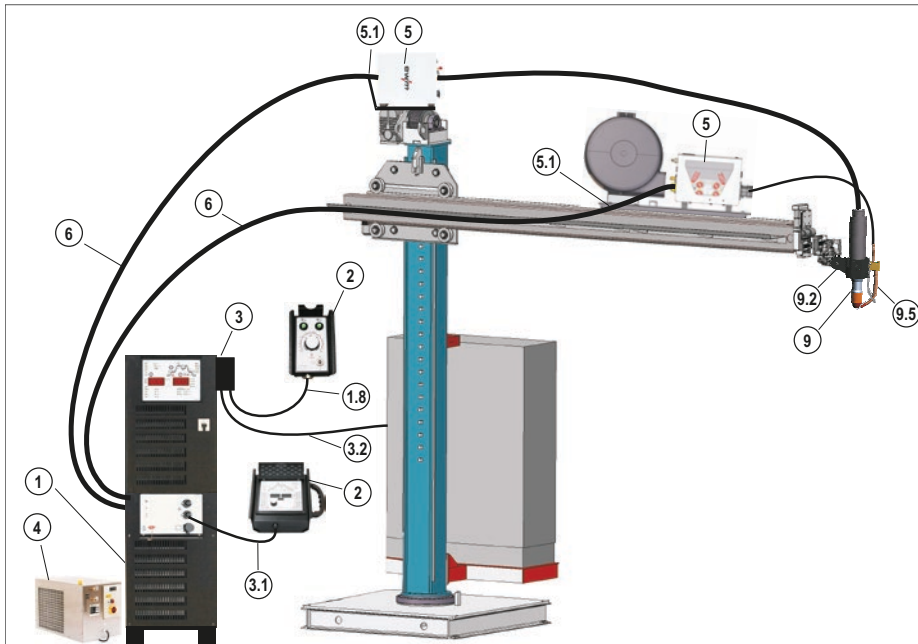


Item	Type	Designation	Item no.
1	Tetrix 552 Synergic	DC TIG welding machine with Synergic control	090-000154-00502
1.1	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000
1.2	WK95/CL 5m	Workpiece lead with cable lug	092-001990-00005
1.3	Optimator AR/MIX 200bar 20l G1/4"	Pressure regulator with flow meter	094-011839-00000
1.5	GH 2x1/4 XR 5m	G1/4 IG/AG gas hose, extension for XR robot intermediate hose package	092-003220-00001
1.6	PALETTE ROB XX2	Transport pallet for power source and add-on module	090-008275-00000
1.8	RA5 19POL 1x 5M	Connection cable, 19-pole, one-sided wire end ferrules	092-001569-00005
4	RK 3.1	Recooling unit with boosted pump 8 bar	094-002285-02000
4.1			094-000530-00005
4.1	KF 23E-5	Coolant up to -10 °C (14 °F), 5 l	094-000530-00005
4.1			094-000530-00005
4.1			094-000530-00005
4.2	HOSE BRIDGE	Hose bridge	092-007857-00000
4.2	WS 2x0,5M	Water hoses, two units	092-001953-00001
4.2	UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
4.3	ON DFW RK FT	Flow monitor connection, retrofit option	092-S08266-04168
5	forceTig TorchBox 550	forceTig media separation box	092-S01178-04057
5.1	ON HOLDER EXT CASE	Assembly PCB panel for external casing on XX2 power sources	092-S01758-04058
6	VSLP TB 95QMM WS 19 POL 1m	Robot intermediate hose package, water cooled, standard protective hose, 19-pole	092-007855-31101
9	FT 500W 5m	forceTig welding torch with hose package	094-020100-10000
9.2	BF FT500	Fixing flange	094-020874-00001
10.04	INS/DIF FT500	Insulator / Diffusor	094-020620-00000
10.08	CAT FT52 R0.25	Cathode, round	094-020618-00000
-	STS FT500	Torch key	094-021232-00000
-	Toolcraft	Copper paste	094-017723-00001
-	PC300 XQ Set	PC300 XQ welding parameter software set, including CMSTICK, cable and SECINT X10 USB interface	090-008777-00000

- ▶ Image for conceptual purposes. Not all listed items are shown.
- ▶ For more accessories, options and machine variants please refer to the individual chapters
- ▶ The example and system set-up are suitable for forceTig variant 1 description.



forceTig, water cooled ■ forceTig welding system on column and boom with cold wire manually



Tetrix 1002 Synergic CW

- With Synergic control
- FT1000 forceTig media separation box
- Water cooled
- T drive 4 Rob 3
- Example for easy integration into mechanised systems when using filler wire
- Only START/STOP and I>0 must be connected for minimal control
- Parameter setting via front control, RT 50 remote control or PC300 software
- Cold wire regulation and cold wire ON via FR AW1 remote control

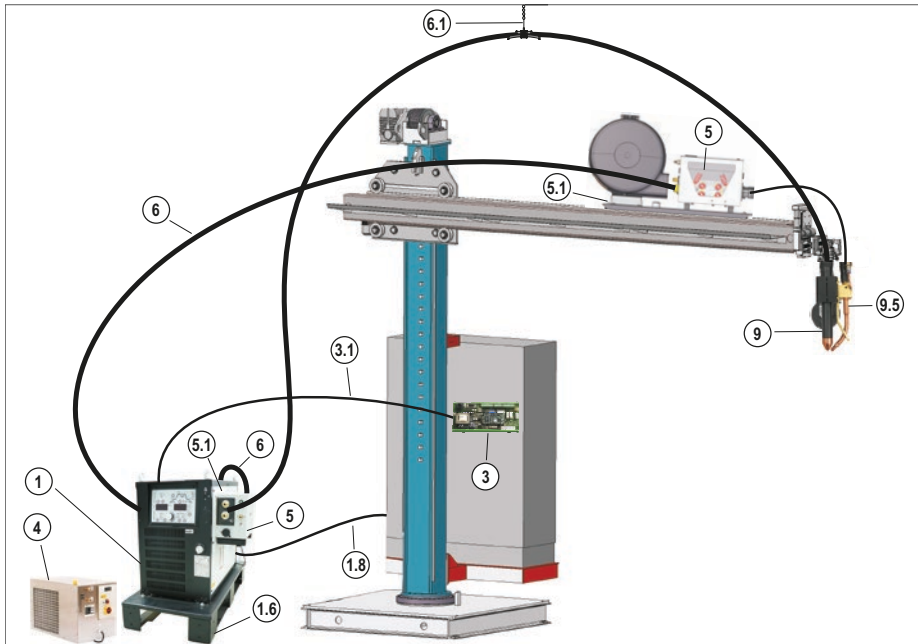


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1	Tetrix 1002 Synergic CW	DC TIG welding machine with Synergic control, incl. connection capability for additional wire	090-000197-00502
1.1	OW CEE 63A	Mains plug, assembled	092-008216-00000
1.2	WK95QMM 5m	Workpiece lead with cable lug, angled	092-003993-00005
1.2			092-003993-00005
1.3	Optimator AR/MIX 200bar 20l G1/4"	Pressure regulator with flow meter	094-011839-00000
1.5	GH 2x1/4 XR 5m	G1/4 IG/AG gas hose, extension for XR robot intermediate hose package	092-003220-00001
1.8	RA5 12/19POL 5m	Connection cable e.g for remote control	092-S01470-04056
2	FR AW1	Remote controls	090-S08765-03796
2	RT50 7POL	Remote control with complete range of functions	090-008793-00000
3	RINT X12 SCO ATCASE	SCO robot interface in casing	090-S08293-03795
3.1	FRV 7POL 5m	Digital 7-pole cable	092-000201-00003
3.2	RA5 28POL 5M	Connection cable, 28-pole, one-sided wire end ferrules	092-007728-00005
4	RK 3.1	Recooling unit with boosted pump 8 bar	094-002285-02000
4.1	KF 23E-5	Coolant up to -10 °C (14 °F), 5 l	094-000530-00005
4.1			094-000530-00005
4.1			094-000530-00005
4.1			094-000530-00005
4.2	HOSE BRIDGE	Hose bridge	092-007857-00000
4.2	SET 2 Y-PART	Water connection set, 2x Y-Part	092-S09218-04188
4.2	WS 2x0,5M	Water hoses, two units	092-001953-00001
4.2	UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
4.3	ON DFW RK FT	Flow monitor connection, retrofit option	092-S08266-04168
5	T Drive 4 Rob 3 LI IG3	Wire feeder for automated applications, opens on left, IG3 speedometer solution	090-008784-00502
5	forceTig TorchBox 1000	forceTig media separation box	092-S01178-04189
5.1	MONTAGE CONSOLE ROB 3 UNIVERSAL	Mounting console for wire feeder and media separation box	092-002440-00000
5.1	ON DV CAP ROB LI	Rob wire spool support, left	092-003217-00000
5.1	ON HOLDER EXT CASE	Assembly PCB panel for external casing on XX2 power sources	092-S01758-04058
5.2	ON COOL W ROB3	Retrofit option water cooling ROB 3	092-002384-00000
6	SLP WOS 7/12 POL 16M	Control cable assembly	092-007855-51016
6	2x95QMM WOS 19POL 16M	Robot intermediate hose package, water cooled, without protective hose, 19-pole	092-S07855-04190
7.4	AK300	Wire spool adapter B300	094-001803-00001
9	FT1000W AX 1,5M	forceTig welding torch with hose package	094-020390-10000
9.2	BH FT RSA	Torch holder for forceTig welding torch on RSA collision sensor	094-022315-00000
9.5	AWS FT1000 1,5m QCS	Wire support	090-008829-00015
9.8	IA TIG 2K/1	Ignition aid	092-003836-00000
10.01	GD NW=12mm 37mm	Gas nozzle, ceramic	094-016127-00001
10.04	INS/DIF FT1000	Gas diffuser and insulator	094-015306-00001
10.08	CAT FT02 R0.25	Cathode, round	094-021229-00000
-	TTC FT1000	Torch key	094-021231-00000
-	Toolcraft	Copper paste	094-017723-00001
-	PC300 XQ Set	PC300 XQ welding parameter software set, including CMSTICK, cable and SECINT X10 USB interface	090-008777-00000

- ▶ Image for conceptual purposes. Not all listed items are shown.
- ▶ For more accessories, options and machine variants please refer to the individual chapters
- ▶ The example and system set-up are suitable for forceTig variant 2 description.



■ forceTig, water cooled ■ forceTig welding system on column and boom with cold wire automated



Tetrix 552 Synergic CW

- With Synergic control
- FT500 forceTig media separation box
- Water cooled
- T drive 4 Rob 3
- Example for fully automated integration into mechanised systems
- Control via BUSINTX11 interface in program or control signal mode
- Parameter setting via PC300 software in program mode or via SPS in control signal mode

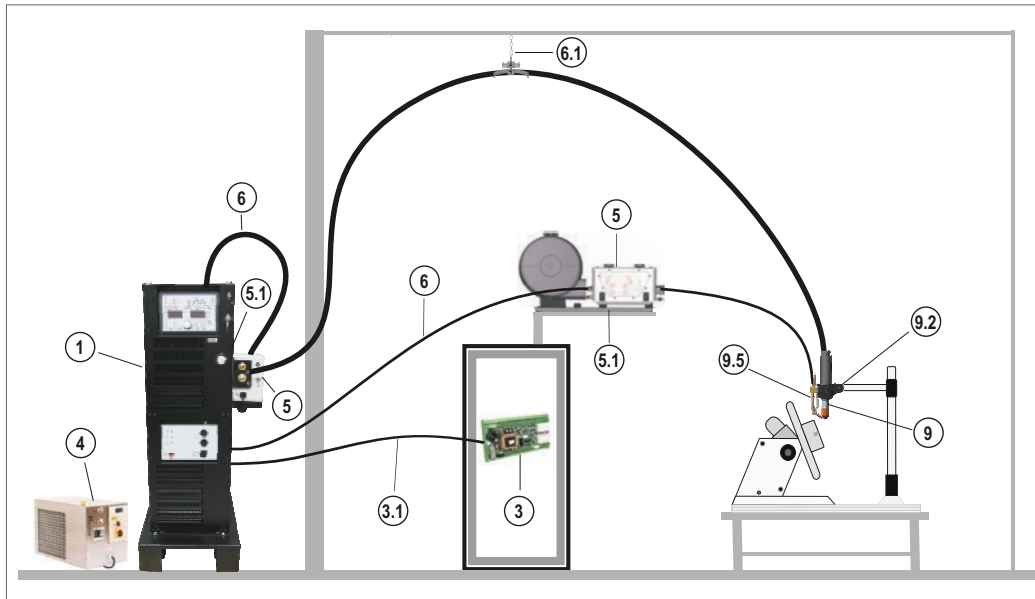


Item	Type	Designation	Item no.
1	Tetrix 552 Synergic CW	DC TIG welding machine with Synergic control, incl. connection capability for additional wire	090-S00154-04055
1.1	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000
1.2	WK95/CL 5m	Workpiece lead with cable lug	092-001990-00005
1.3	Optimator AR/MIX 200bar 20l G1/4"	Pressure regulator with flow meter	094-011839-00000
1.5	GH 2x1/4 XR 5m	G1/4 IG/AG gas hose, extension for XR robot intermediate hose package	092-003220-00001
1.6	PALETTE ROB XX2	Transport pallet for power source and add-on module	090-008275-00000
1.8	RA5 19POL 1x 5M	Connection cable, 19-pole, one-sided wire end ferrules	092-001569-00005
3	Tetrix BUSINT X11 PROFINET	Industrial bus interface, potential-free power supply, 24 V	090-908260-00008
3.1	FRV 7POL 5m	Digital 7-pole cable	092-000201-00003
4	RK 3.1	Recooling unit with boosted pump 8 bar	094-002285-02000
4.1			094-000530-00005
4.1	KF 23E-5	Coolant up to -10 °C (14 °F), 5 l	094-000530-00005
4.1			094-000530-00005
4.2	HOSE BRIDGE	Hose bridge	092-007857-00000
4.2	WS 2x0,5M	Water hoses, two units	092-001953-00001
4.2	UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
4.3	ON DFW RK FT	Flow monitor connection, retrofit option	092-S08266-04168
5	T Drive 4 Rob 3 LI IG3	Wire feeder for automated applications, opens on left, IG3 speedometer solution	090-008784-00502
5	forceTig TorchBox 550	forceTig media separation box	092-S01178-04057
5.1	ON DV CAP ROB LI	Rob wire spool support, left	092-003217-00000
5.1	ON HOLDER EXT CASE	Assembly PCB panel for external casing on XX2 power sources	092-S01758-04058
5.2	ON COOL W ROB3	Retrofit option water cooling ROB 3	092-002384-00000
6	SLP WS 7/12 POL 10M	Control cable, standard protective hose	092-007855-51110
6	VSLP TB 95QMM WS 19 POL 1m	Robot intermediate hose package, water cooled, standard protective hose, 19-pole	092-007855-31101
6.1	ON ZWIPA-CONNECTION	Retrofit option, third-party intermediate hose package, strain relief	094-007890-00000
7.4	AK300	Wire spool adapter B300	094-001803-00001
9	FT 500W 8m	forceTig welding torch with hose package	094-020100-10008
9.5	AWS FT500 1,5m	Wire support incl. BF FT500 torch holder	090-008799-00015
10.01	GN FT4505 Ø 5 mm	Gas nozzle, copper	094-020619-00000
10.04	INS/DIF FT500	Insulator / Diffusor	094-020620-00000
10.08	CAT FT52 R0.25	Cathode, round	094-020618-00000
-	STS FT500	Torch key	094-021232-00000
-	Toolcraft	Copper paste	094-017723-00001
-	Set PC300 XQ / ANALYZER	Set comprising PC300 XQ and Analyzer software	090-008779-00000

- ▶ Image for conceptual purposes. Not all listed items are shown.
- ▶ For more accessories, options and machine variants please refer to the individual chapters
- ▶ The example and system set-up are suitable for forceTig variant 3 description.



■ forceTig, water cooled ■ forceTig welding system, tigSpeed drive, mechanised use with hot wire



Tetrix 552 Synergic HW

- With Synergic control
- FT550 forceTig media separation box
- Water cooled
- tigSpeed drive 4 Rob
- Example for fully automated integration into mechanised systems
- Control via BUSINTX11 interface in program or control signal mode
- Parameter setting via PC300 software in program mode or via SPS in control signal mode

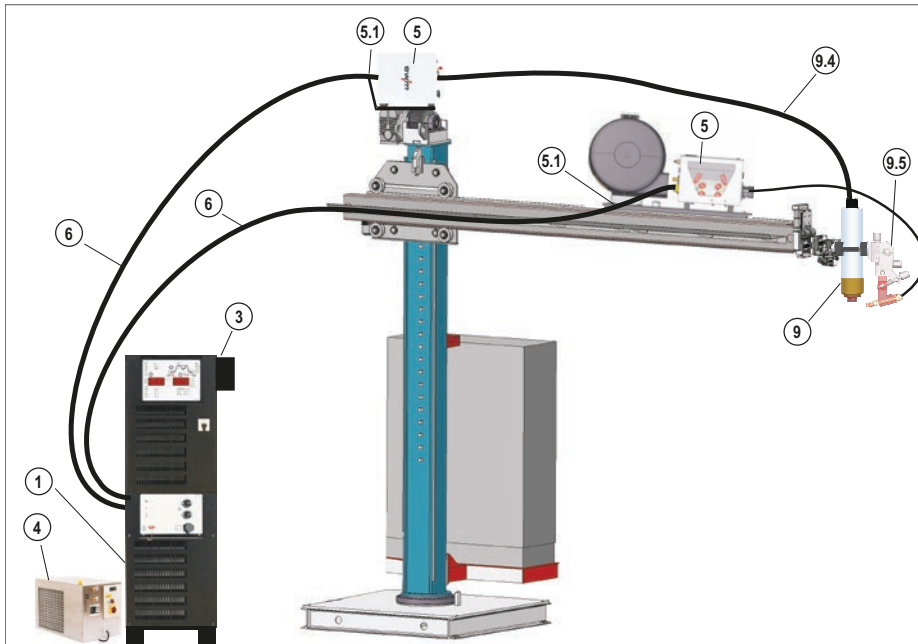


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1.1	OW CEE 32A	Mains plug, assembled (CEE 32 A)	092-008215-00000
1.2	WK95/CL 5m	Workpiece lead with cable lug	092-001990-00005
1.3	Optimator AR/MIX 200bar 20l G1/4"	Pressure regulator with flow meter	094-011839-00000
1.5	GH 2x1/4 XR 5m	G1/4 IG/AG gas hose, extension for XR robot intermediate hose package	092-003220-00001
1.8	RA5 19POL 1x 5M	Connection cable, 19-pole, one-sided wire end ferrules	092-001569-00005
3	Tetrix BUSINT X11 PROFINET	Industrial bus interface, potential-free power supply, 24 V	090-908260-00008
3.1	FRV 7POL 5m	Digital 7-pole cable	092-000201-00003
4	RK 3.1	Recooling unit with boosted pump 8 bar	094-002285-02000
4.1			094-000530-00005
4.1	KF 23E-5	Coolant up to -10 °C (14 °F), 5 l	094-000530-00005
4.1			094-000530-00005
4.2	HOSE BRIDGE	Hose bridge	092-007857-00000
4.2	WS 2x0,5M	Water hoses, two units	092-001953-00001
4.2	UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
4.3	ON DFW RK FT	Flow monitor connection, retrofit option	092-508266-04168
5	forceTig TorchBox 550	forceTig media separation box	092-501178-04057
5	tigSpeed drive 4 Rob	Wire feed unit for automated applications	090-005395-00502
5.1	ON DV CAP ROB LI	Rob wire spool support, left	092-003217-00000
5.1	ON HOLDER EXT CASE	Assembly PCB panel for external casing on XX2 power sources	092-501758-04058
6	VSLP 95QMM HW WR 7/12/19POL 5M	Intermediate hose package, robot, water cooled, ribbed hose	092-007855-81205
6	VSLP TB 95QMM WS 19 POL 1m	Robot intermediate hose package, water cooled, standard protective hose, 19-pole	092-007855-31101
6.1	ON ZWIPA-CONNECTION	Retrofit option, third-party intermediate hose package, strain relief	094-007890-00000
7.4	AK300	Wire spool adapter B300	094-001803-00001
9	FT1000W AX 5M	forceTig welding torch with hose package	094-020390-10005
9.2	BH FT RSA	Torch holder for forceTig welding torch on RSA collision sensor	094-022315-00000
9.5	AWS FT1000 1,5m DZA	Wire support	090-008831-00015
9.8	IA TIG 2K/1	Ignition aid	092-003836-00000
10.01	GD NW=12mm 37mm	Gas nozzle, ceramic	094-016127-00001
10.04	INS/DIF FT1000	Gas diffuser and insulator	094-015306-00001
10.08	CAT FT02 R0.25	Cathode, round	094-021229-00000
-	TTC FT1000	Torch key	094-021231-00000
-	Toolcraft	Copper paste	094-017723-00001
-	Set PC300 XQ / ANALYZER	Set comprising PC300 XQ and Analyzer software	090-008779-00000

- ▶ Image for conceptual purposes. Not all listed items are shown.
- ▶ For more accessories, options and machine variants please refer to the individual chapters
- ▶ The example and system set-up are suitable for forceTig variant 3 description.



■ forceTig, water cooled ■ forceTig welding system on column and boom with cold wire



Tetrix 1002 Synergic CW

- With Synergic control
- FT1000 forceTig media separation box
- Water cooled
- T drive 4 Rob 3
- Example for fully automated integration into mechanised systems
- Control via BUSINTX11 interface in program or control signal mode
- Parameter setting via PC300 software in program mode or via SPS in control signal mode



Item	Type	Designation	Item no.
1	Tetrix 1002 Synergic CW	DC TIG welding machine with Synergic control, incl. connection capability for additional wire	090-000197-00502
1.1	OW CEE 63A	Mains plug, assembled	092-008216-00000
1.2	WK95QMM 5m	Workpiece lead with cable lug, angled	092-003993-00005
1.2			092-003993-00005
1.3	Optimator AR/MIX 200bar 20l G1/4"	Pressure regulator with flow meter	094-011839-00000
1.5	GH 2x1/4 XR 5m	G1/4 IG/AG gas hose, extension for XR robot intermediate hose package	092-003220-00001
3	Tetrix BUSINT X11 PROFINET CU ATCASE	Industrial bus interface, potential-free power supply, 24 V	090-908590-00008
4	RK 3.1	Recooling unit with boosted pump 8 bar	094-002285-02000
4.1	KF 23E-5	Coolant up to -10 °C (14 °F), 5 l	094-000530-00005
4.1			094-000530-00005
4.1			094-000530-00005
4.1			094-000530-00005
4.2	HOSE BRIDGE	Hose bridge	092-007857-00000
4.2	SET 2 Y-PART	Water connection set, 2x Y-Part	092-S09218-04188
4.2	WS 2x0,5M	Water hoses, two units	092-001953-00001
4.2	UKV4SET 4M	Hose connection set to connect a cooling unit	092-000587-00000
4.3	ON DFW RK FT	Flow monitor connection, retrofit option	092-S08266-04168
5	T Drive 4 Rob 3 LI IG3	Wire feeder for automated applications, opens on left, IG3 speedometer solution	090-008784-00502
5	forceTig TorchBox 1000	forceTig media separation box	092-S01178-04162
5.1	MONTAGE CONSOLE ROB 3 UNIVERSAL	Mounting console for wire feeder and media separation box	092-002440-00000
5.1	ON DV CAP ROB LI	Rob wire spool support, left	092-003217-00000
5.1	ON HOLDER EXT CASE	Assembly PCB panel for external casing on XX2 power sources	092-S01758-04058
5.2	ON COOL W ROB3	Retrofit option water cooling ROB 3	092-002384-00000
6	SLP WOS 7/12 POL 10m	Control cable, without protective hose	092-007855-51010
6	VSLP TB 2X95QMM WOS 19 POL 10m	Robot intermediate hose package, water cooled, without protective hose, 19-pole	092-S07855-04371
7.4	AK300	Wire spool adapter B300	094-001803-00001
9	FT1002W	forceTig welding torch	094-026042-00000
9.4	SP W 3 M	Hose package	094-025118-00000
9.5	AWS HW 4-AXIS 3,0M QC-S CRNI	4 axes support, hot wire, insulated setup, for T drive 4 Rob.3	094-S20614-04222
9.8	IA TIG 2K/1	Ignition aid	092-003836-00000
10.01	SG D=24x31MM	Shielding gas nozzle	094-025117-00000
10.05	ZSZ D=6,4MM	Collet chuck	094-025105-00000
10.08	WE D=6,4x175MM	Tungsten electrode	094-025109-00000
10.13	GL D=6,4MM	Gas lens	094-025113-00000
11.02	SGDK	Shielding gas nozzle cooling	094-025122-00000
11.03	SGDE D=24MM	Shielding gas nozzle attachment	094-025123-00000
11.04	SET WG GD 4M	Hose set for water-cooled gas nozzles, 4 m	094-025212-00000
-	ELEC-ADJUST	Electrode setting gauge	094-025119-00000
-	SIL 100G	Silicon paste for o-ring	094-013826-00000
-	SWA G1/2	Power-water adapter	094-025135-00000
-	SWA M18x1,5		094-025134-00000
-	PC300 XQ Set	PC300 XQ welding parameter software set, including CMSTICK, cable and SECINT X10 USB interface	090-008777-00000

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- ▶ For more accessories, options and machine variants please refer to the individual chapters
- ▶ The example and system set-up are suitable for forceTig variant 3 description.



Further information on the individual items, such as power sources, as well as torches and accessories, can be found in our automation catalog 2021.

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