

WELD *The TIG Welder's Choice* **CRAFT**®

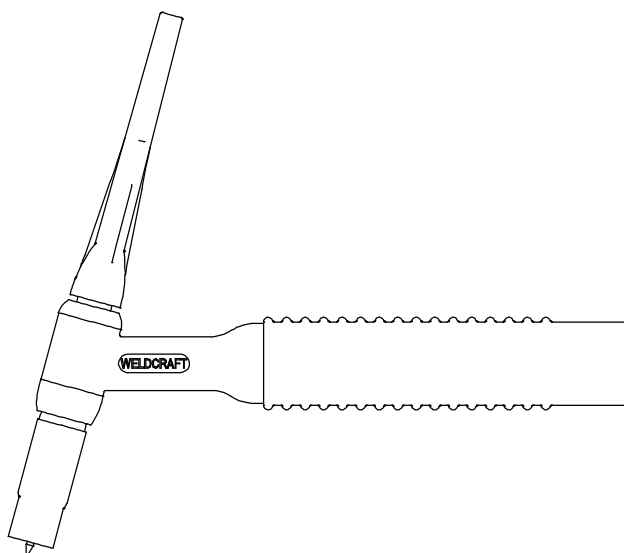
WP-26
WP-26V
WP-26P
WP-26FV
WP-26F



*Hand-Held Air-Cooled TIG
(GTAW) Torches*

*Torches manuelles TIG refroidies
par eau*

*Antorchas manuales enfriadas
por agua para TIG (GTAW)*



Owner's Manual
Manual del Operador
Manuel de L'utilisateur



Weldcraft.com

File: TIG (GTAW)



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SECTION 1 –SAFETY PRECAUTIONS FOR GTAW TORCHES – READ BEFORE USING

WC000038 – 2011-10

 **Protect yourself and others from injury — read, follow, and save these important safety precautions and operating instructions.**

1-1. Symbol Usage



DANGER! – Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.



Indicates a hazardous situation which, if not avoided, could result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.

NOTICE – Indicates statements not related to personal injury.

 Indicates special instructions.



This group of symbols means Warning! Watch Out! ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards



The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the welding power source Owner's Manual. Read and follow all Safety Standards.



Only qualified persons should install, operate, maintain, and repair this unit.



During operation, keep everybody, especially children, away.



ELECTRIC SHOCK can kill.

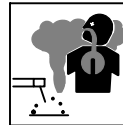
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrode or electrical parts.
- Before welding, verify torch head is firmly attached to the torch body.
- Do not wrap torch hoses and power cable together with tape or plastic wire ties. Wrapping restricts water flow which may cause power cable to overheat and torch hose to burst.
- Repair or replace worn, damaged, or cracked torch or cable insulation.
- Turn off welding power source before changing tungsten electrode or torch parts.
- Keep all covers and handle securely in place.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

- Wear an approved welding helmet fitted with a proper shade of filter lenses to protect your face and eyes from arc rays and sparks when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash, glare and sparks; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather, heavy cotton, or wool) and foot protection.



FUMES AND GASES can be hazardous.

- Keep your head out of the fumes.
- Ventilate area, or use breathing device.
- Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for material used.



BUILDUP OF GAS can injure or kill.

- Shut off compressed gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



WELDING can cause fire or explosion.

- Do not weld near flammable material.
- Do not weld on containers that have held combustibles, or on closed containers such as tanks, drums, or pipes unless they are properly prepared according to AWS F4.1 and AWS A6.0 (see Safety Standards).
- Watch for fire; keep extinguisher nearby.



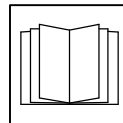
HOT PARTS can burn.

- Allow torch to cool before touching.
- Do not touch hot metal.
- Protect hot metal from contact by others.



NOISE can damage hearing.

- Check for noise level limits exceeding those specified by OSHA.
- Use approved ear plugs or ear muffs if noise level is high.
- Warn others nearby about noise hazard.



READ INSTRUCTIONS.

- Read and follow all labels and the Owner's Manual carefully before installing, operating, or servicing unit. Read the safety information at the beginning of the manual and in each section.
- Use only genuine replacement parts from the manufacturer.
- Perform maintenance and service according to the Owner's Manuals, industry standards, and national, state, and local codes.

1-3. Proposition 65 Warnings

 Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

 This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. *Wash hands after use.*

 This product contains or produces a chemical known to the State of California to cause cancer or birth defects (or other reproductive harm). (California Health & Safety Code Section 25249.5 et seq.)

1-4. Principal Safety Standards

Safety in Welding, Cutting, and Allied Processes, ANSI Standard Z49.1, is available as a free download from the American Welding Society at <http://www.aws.org> or purchased from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Safe Practices for the Preparation of Containers and Piping for Welding and Cutting, American Welding Society Standard AWS F4.1, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

Safe Practices for Welding and Cutting Containers that have Held Combustibles, American Welding Society Standard AWS A6.0, from Global Engineering Documents (phone: 1-877-413-5184, website: www.global.ihs.com).

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org and www.sparky.org).

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 14501 George Carter Way, Suite 103, Chantilly, VA 20151 (phone: 703-788-2700, website: www.cganet.com).

Safety in Welding, Cutting, and Allied Processes, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 5060 Spectrum Way, Suite 100, Ontario, Canada L4W 5N5 (phone: 800-463-6727, website: www.csa-international.org).

Safe Practice For Occupational And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 25 West 43rd Street, New York, NY 10036 (phone: 212-642-4900, website: www.ansi.org).

Standard for Fire Prevention During Welding, Cutting, and Other Hot Work, NFPA Standard 51B, from National Fire Protection Association, Quincy, MA 02269 (phone: 1-800-344-3555, website: www.nfpa.org).

OSHA, Occupational Safety and Health Standards for General Industry, Title 29, Code of Federal Regulations (CFR), Part 1910, Subpart Q, and Part 1926, Subpart J, from U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954 (phone: 1-866-512-1800) (there are 10 OSHA Regional Offices—phone for Region 5, Chicago, is 312-353-2220, website: www.osha.gov).

1-5. EMF Information

Electric current flowing through any conductor causes localized electric and magnetic fields (EMF). Welding current creates an EMF field around the welding circuit and welding equipment. EMF fields may interfere with some medical implants, e.g. pacemakers. Protective measures for persons wearing medical implants have to be taken. For example, restrict access for passers-by or conduct individual risk assessment for welders. All welders should use the following procedures in order to minimize exposure to EMF fields from the welding circuit:

1. Keep cables close together by twisting or taping them, or using a cable cover.
2. Do not place your body between welding cables. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.

4. Keep head and trunk as far away from the equipment in the welding circuit as possible.
5. Connect work clamp to workpiece as close to the weld as possible.
6. Do not work next to, sit or lean on the welding power source.
7. Do not weld whilst carrying the welding power source or wire feeder.

About Implanted Medical Devices:

Implanted Medical Device wearers should consult their doctor and the device manufacturer before performing or going near arc welding, spot welding, gouging, plasma arc cutting, or induction heating operations. If cleared by your doctor, then following the above procedures is recommended.

SECTION 2 – SPECIFICATIONS

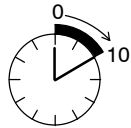
2-1. Specifications

Model			
	WP-26	WP-26V	WP-26P
Amperage Rating	200 Amps W/Argon Gas At 60% Duty Cycle DCEN; 150 Amps W/Argon Gas At 60%duty Cycle ACHF		
Cooling Method	Air		
Tungsten Size	.020 Thru 5/32 in. (0.5 Thru 4.0 mm)		
Cable Options	12.5 ft (3.8 m) or 25 ft (7.6 m) One-Piece Rubber 12.5 ft (3.8 m) or 25 ft (7.6 m) Two-Piece Rubber		
Dimensions	Length: 8 in. (203 mm); Handle Diameter: 1.13 in. (29 mm) Weight: 9.1 oz (258 g)	Length: 8.5 in. (216 mm); Handle Diameter: 1.13 in. (29 mm) Weight: 10.8 oz (306 g)	Length: 12.75 in. (324 mm); Handle Diameter: 1.37 in. (35 mm) Weight: 13.6 oz (386 g)

Model		
	WP-26F	WP-26FV
Amperage Rating	200 Amps W/Argon Gas At 60% Duty Cycle DCEN; 150 Amps W/Argon Gas At 60%duty Cycle ACHF	
Cooling Method	Air	
Tungsten Size	.020 Thru 5/32 in. (0.5 Thru 4.0 mm)	
Cable Options	12.5 ft (3.8 m) or 25 ft (7.6 m) One-Piece Rubber 12.5 ft (3.8 m) or 25 ft (7.6 m) Two-Piece Rubber	
Dimensions	Length: 8.5 in. (216 mm); Handle Diameter: 1.13 in. (29 mm) Weight: 11.05 oz (313 g)	Length: 9 in. (229 mm); Handle Diameter: 1.13 in. (29 mm) Weight: 12.95 oz (367 g)

2-2. Duty Cycle



Minutes

Definition

Duty Cycle is percentage of 10 minutes that torch can weld at rated load without overheating.

60% Duty Cycle At 200 Amperes Using Argon Gas w/DCEN



→



6 Minutes Welding

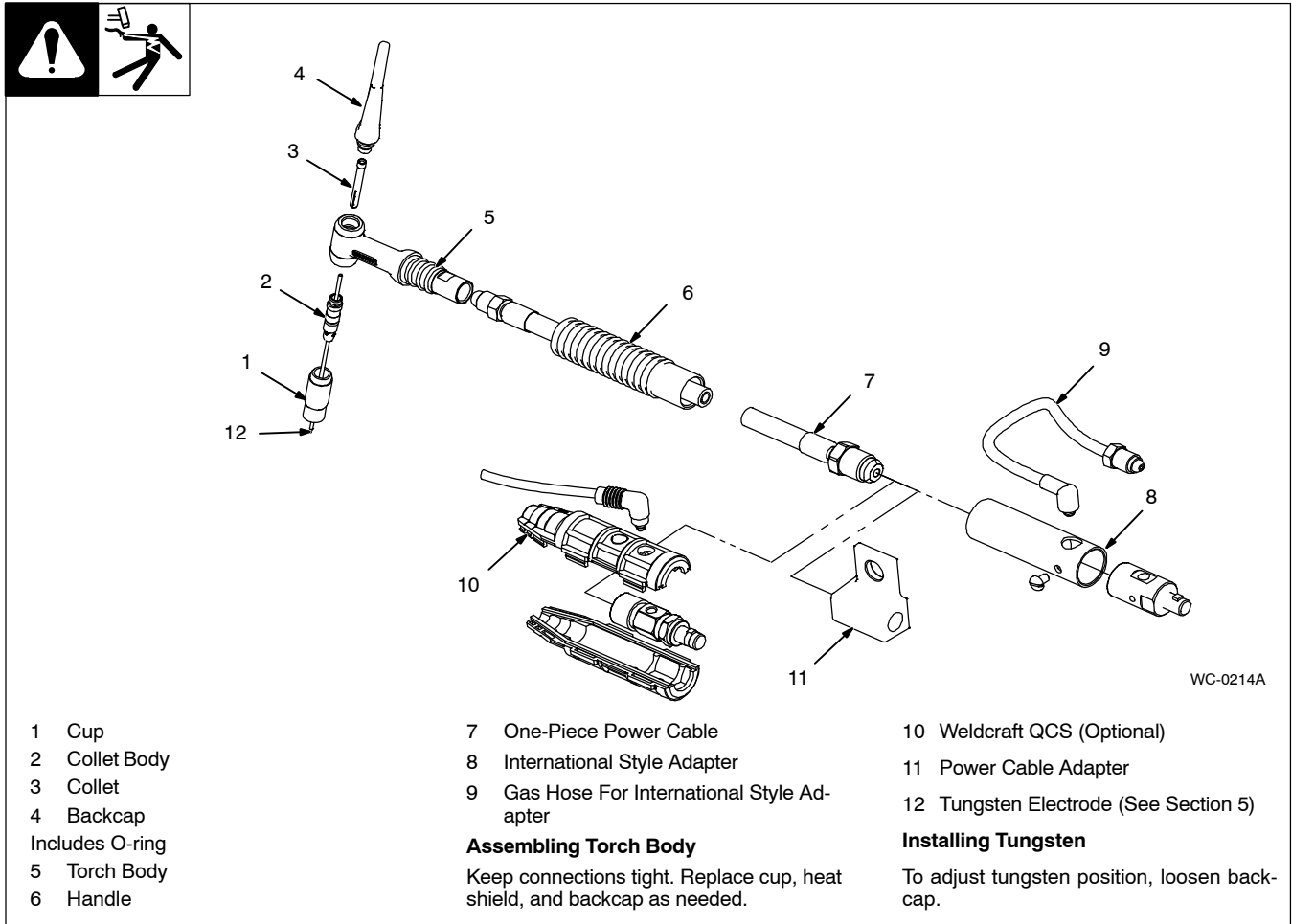
4 Minutes Resting

NOTICE – Exceeding rated amperage can damage torch and void warranty (see Section 2-1).

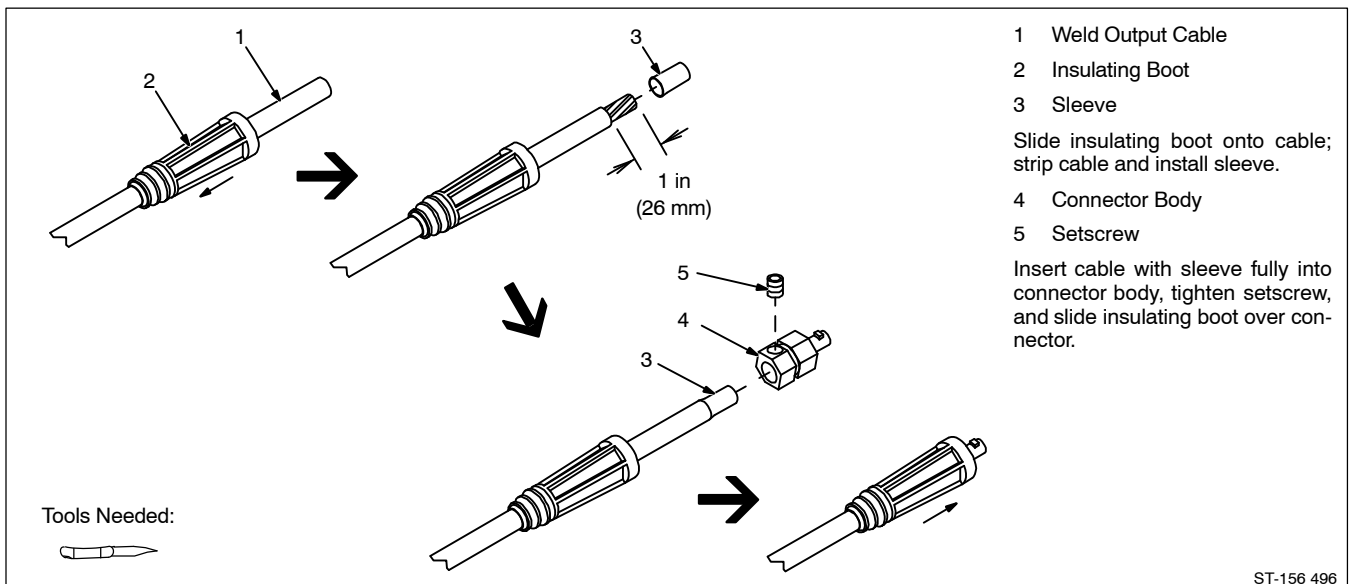
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SECTION 3 – INSTALLATION

3-1. Required Torch Parts And Torch Assembly



3-2. International Style Connector Assembly



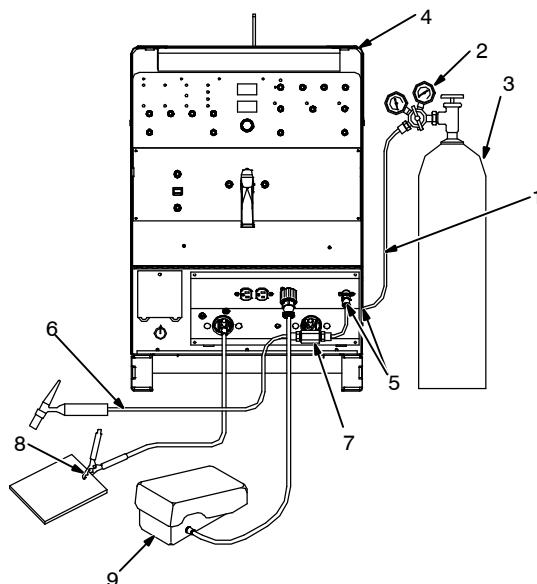
3-3. Connecting Torch

A. Connecting Torch With One-Piece Cable



If applicable, install high-frequency unit.

Torch Without Gas Valve



⚠ Turn Off welding power source power before installing torch.

Obtain the following hose:

- 1 Gas Hose With 5/8-18 Right-Hand Fittings

Connections:

- 2 Regulator/Flowmeter
- 3 Gas Cylinder
- 4 Welding Power Source
- 5 Gas Valve

Operating Torch Gas Valve:

Valve controls gas preflow and post-flow. Open valve on torch just before welding.

Preflow is used to purge the immediate weld area of atmosphere.

Postflow is required to cool tungsten and weld, and to prevent contamination of tungsten and weld. After welding, leave valve open about 1 second for every 10 amperes of weld current. Close valve on torch when postflow is finished.

- 6 One-Piece Torch Cable
- 7 Power Cable Adapter

Connect gas hose and power cable to adapter before connecting adapter to weld output terminal.

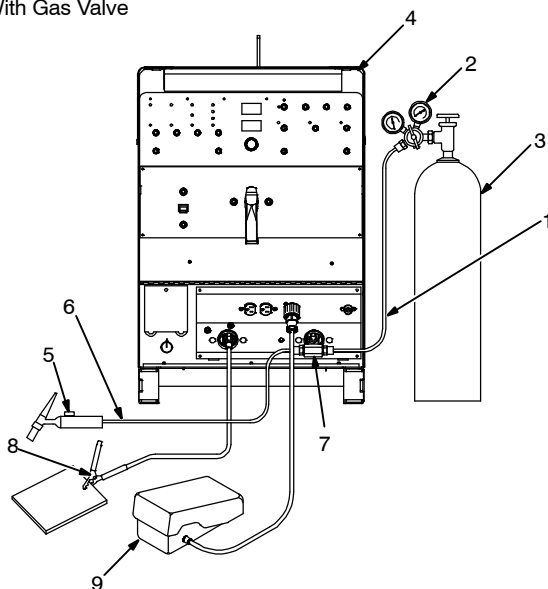
- 8 Work Clamp

Connect work clamp to clean, paint-free location on workpiece, close to weld.

Use wire brush or sandpaper to clean metal at weld joint area.

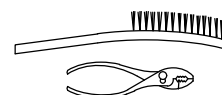
- 9 Foot Control

Torch With Gas Valve



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Tools Needed:



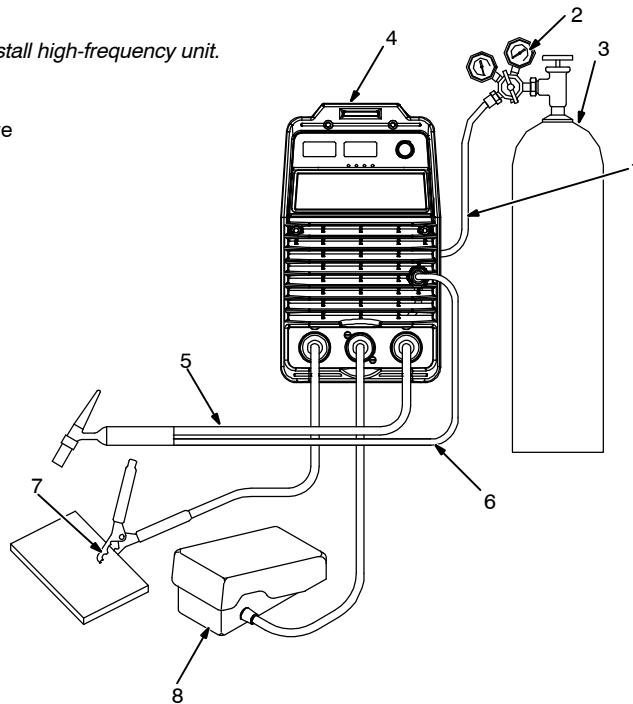
5/8, 7/8 in.

B. Connecting Torch With Two-Piece Cable



If applicable, install high-frequency unit.

Torch Without Gas Valve



⚠ Turn Off welding power source power before installing torch.

Obtain the following hose:

- 1 Gas Hose With 5/8-18 Right-Hand Fittings

Connections:

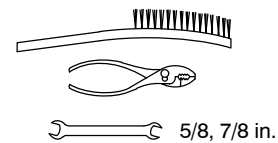
- 2 Regulator/Flowmeter
- 3 Gas Cylinder
- 4 Welding Power Source
- 5 Torch Power Cable
- 6 Torch Gas-In Hose
- 7 Work Clamp

Connect work clamp to clean, paint-free location on workpiece, close to weld.

Use wire brush or sandpaper to clean metal at weld joint area.

- 8 Foot Control

Tools Needed:



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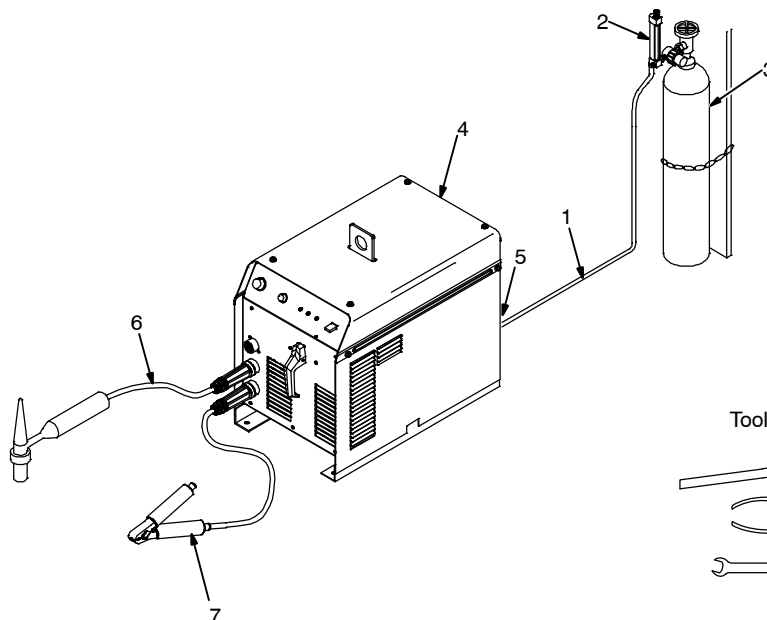
5/8, 7/8 in.

C. Connecting Torch With Flow-Through Type Connection



If applicable, install high-frequency unit.

Torch Without Gas Valve



⚠ Turn Off welding power source power before installing torch.

Obtain the following hose:

- 1 Gas Hose With 5/8-18 Right-Hand Fittings

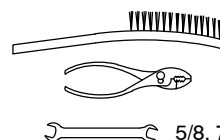
Connections:

- 2 Regulator/Flowmeter
- 3 Gas Cylinder
- 4 Welding Power Source
- 5 Gas Valve
- 6 One-Piece Torch Cable
- 7 Work Clamp

Connect work clamp to clean, paint-free location on workpiece, close to weld.

Use wire brush or sandpaper to clean metal at weld joint area.

Tools Needed:

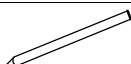
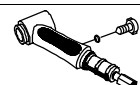
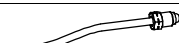
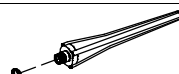
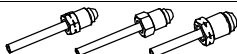
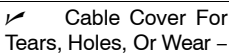


5/8, 7/8 in.

Ref. ST-802 540-A

SECTION 4 – MAINTENANCE & TROUBLESHOOTING

4-1. Routine Maintenance

																		 Disconnect torch before maintaining.							
		✓ = Check ◇ = Change ● = Clean ☆ = Replace * To be done by Factory Authorized Service Agent																							
Daily		 ✓ Nozzle For Cracks – ☆ If Necessary										 ✓ Check Tungsten Preparation (See Section 6)													
Weekly		 ✓ Collet For Wear – ☆ If Necessary					 ✓ Collet Body Threads – ☆ If Necessary					 ✓ Gas Lens Screen – ☆ If Necessary					 ✓ Gas Valve, If Applicable – ☆ If Necessary								
Monthly		 ✓ Power Cable For Cracks, Wear – ☆ If Necessary					 ✓ Gas Hose For Cracks, Leaks, Wear – ☆ If Necessary					 * ✓ Water Hose, If Applicable, For Cracks, Leaks, Wear – ☆ If Necessary					 ✓ Back Cap O-Ring – ☆ If Necessary								
		 ✓ Power, Gas, And Water Cable Connections To Ensure They Are Tight					 ✓ Cable Cover For Tears, Holes, Or Wear – ☆ If Necessary																		
* When using a water-cooled torch, maintain cooling equipment according to the manufactures recommendations.																									

4-2. Troubleshooting

Before using troubleshooting table, check selection and preparation of tungsten electrode according to Section 5.

Trouble	Remedy
Arc will not start. High frequency present and visible at the torch.	Check cable and work connections. Be sure weld circuit is complete (see Section 3-3).
	Check and be sure shielding gas is present.
Lack of high frequency; difficulty in establishing arc.	Select proper size and type of tungsten. Properly prepare tungsten according to Section 6.
	Check cables and torch for cracks or bad connections. Be sure that torch cables are not close to any grounded metal. Repair or replace necessary parts.
	Check torch consumables. Be sure collet and collet body are correctly installed and tightened (see Section 3-1).
	Check welding power source High Frequency control, and if necessary, check and adjust spark gaps.
Torch gas valve not working properly (if applicable).	Have Factory Authorized Service Station/Service Distributor check valve.
No shielding gas flow from torch.	Be sure valves on gas supply are open.
	Check cable for kinks or blockage.
	Check and tighten all gas supply fittings.
	Check cables and torch for cracked insulation or bad connections. Repair or replace (see Section 4-1).
	Make sure collect is installed correctly (see Section 3-1).
Tungsten electrode oxidizing and not remaining bright after conclusion of weld.	Shield weld zone from drafts.
	Increase postflow time.
	Increase gas flow rate. Check manufacture's recommendations.
	Check and tighten all gas fittings.
	Check gas valve and flow meter/regulator.
	Select proper size and type of tungsten. Properly prepare tungsten (see Section 6).

Trouble	Remedy
Excessive tungsten electrode consumption.	Select proper size and type of tungsten. Properly prepare tungsten according to Section 6.
	Check polarity setting on welding power source (see welding power source Owner's manual).
	Check for proper gas flow rate. Check manufacture's recommendations.
	If torch is water cooled, check torch and cables for water leaks. Repair or replace if necessary (see Section 4-1).
Wandering arc	Shield weld zone from drafts.
	Reduce gas flow rate.
	Select proper size and type of tungsten. Properly prepare tungsten according to Section 6.
	When using AC, check welding power source High Frequency control setting, and increase setting if necessary.
Yellow powder or smoke on cup.	Use proper type shielding gas.
	Check for proper gas flow rate. Check manufacture's recommendations.
	Increase postflow time.
	Check torch cup size. Match cup size to joint being welded.
Erratic arc	Make sure base material is clean and free of contaminates.
	When using DC, check polarity, and/or polarity of welding cables.
	Select proper size and type of tungsten. Properly prepare tungsten according to Section 6.
	Use proper arc length. Arc length may be too long or too short.
	When using AC, check welding power source High Frequency control setting, and be sure it is operating continuously.
	When using AC, slow travel speed can cause erratic arc. Adjust travel speed.
Porosity in weld.	Check for proper type gas and correct flow rate. Check manufacture's recommendations.
	Check and tighten gas fittings.
	Make sure base material and filler material is clean and free of contaminates.
	Check for impurities and moisture in gas lines. Purge if necessary.
	If torch is water cooled, check torch and cables for water leaks. Repair or replace if necessary (see Section 4-1).

SECTION 5 – SELECTING AND PREPARING A TUNGSTEN FOR DC OR AC WELDING WITH INVERTER MACHINES

gtaw_Inverter_2011-06



⚠ Whenever possible and practical, use DC weld output instead of AC weld output.

5-1. Selecting Tungsten Electrode (Wear Clean Gloves To Prevent Contamination Of Tungsten)

📖 Not all tungsten electrode manufacturers use the same colors to identify tungsten type. Contact the tungsten electrode manufacturer or reference the product packaging to identify the tungsten you are using.

Electrode Diameter	Amperage Range - Gas Type♦ - Polarity	
	(DCEN) – Argon Direct Current Electrode Negative (For Use With Mild Or Stainless Steel)	AC – Argon Balance Control @ 65% Electrode Negative (For Use With Aluminum)
2% Ceria, 1.5% Lanthanum, Or 2% Thorium Alloy Tungstens		
.010 in. (1 mm)	Up to 25	Up to 20
.020 in. (1 mm)	15-40	15-35
.040 in. (1 mm)	25-85	20-80
1/16 in. (1.6 mm)	50-160	50-150
3/32 in. (2.4 mm)	130-250	135-235
1/8 in. (3.2 mm)	250-400	225-360
5/32 in. (4.0 mm)	400-500	300-450
3/16 in. (4.8 mm)	500-750	400-500
1/4 in. (6.4 mm)	750-1000	600-800

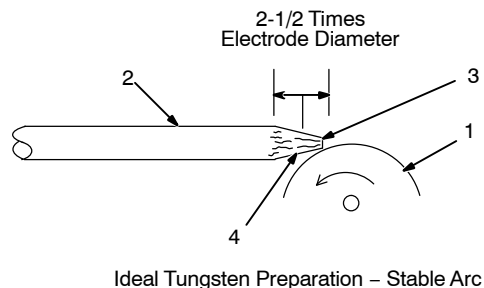
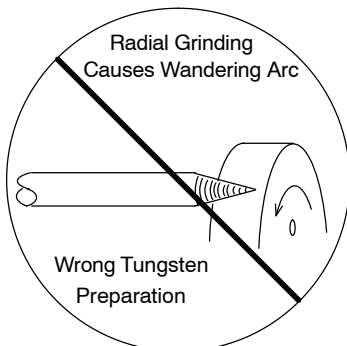
♦ Typical argon shielding gas flow rates are 11 to 35 CFH (cubic feet per hour).

Figures listed are a guide and are a composite of recommendations from American Welding Society (AWS) and electrode manufacturers.

5-2. Preparing Tungsten Electrode For DC Electrode Negative (DCEN) Welding Or AC Welding With Inverter Machines



⚠ Grinding the tungsten electrode produces dust and flying sparks which can cause injury and start fires. Use local exhaust (forced ventilation) at the grinder or wear an approved respirator. Read MSDS for safety information. Consider using tungsten containing ceria, lanthana, or yttria instead of thorium. Grinding dust from thoriated electrodes contains low-level radioactive material. Properly dispose of grinder dust in an environmentally safe way. Wear proper face, hand, and body protection. Keep flammables away.



1 Grinding Wheel

Grind end of tungsten on fine grit, hard abrasive wheel before welding. Do not use wheel for other jobs or tungsten can become contaminated causing lower weld quality.

2 Tungsten Electrode

A 2% ceriated tungsten is recommended.

3 Flat

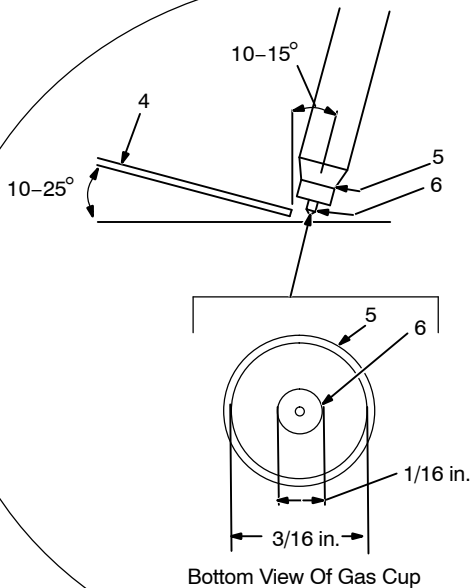
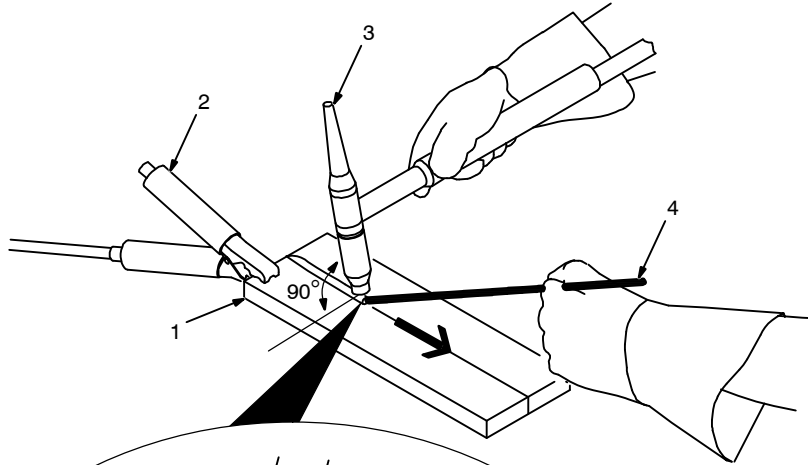
Diameter of this flat determines amperage capacity.

4 Straight Ground

Grind lengthwise, **not radial**.

SECTION 6 – GUIDELINES FOR TIG WELDING (GTAW)

6-1. Positioning The Torch



⚠ Grinding the tungsten electrode produces dust and flying sparks which can cause injury and start fires. Use local exhaust (forced ventilation) at the grinder or wear an approved respirator. Read MSDS for safety information. Consider using cerium or lanthanum based tungsten instead of thoriated. Thorium dust contains low-level radioactive material. Properly dispose of grinder dust in an environmentally safe way. Wear proper face, hand, and body protection. Keep flammables away.

1 Workpiece

Make sure workpiece is clean before welding.

2 Work Clamp

Place as close to the weld as possible.

3 Torch

4 Filler Rod (If Applicable)

5 Gas Cup

6 Tungsten Electrode

Select and prepare tungsten according to Section 5.

Guidelines:

The inside diameter of the gas cup should be at least three times the tungsten diameter to provide adequate shielding gas coverage. (For example, if tungsten is 1/16 in. diameter, gas cup should be a minimum of 3/16 in. diameter.

Tungsten extension is the distance the tungsten extends out gas cup of torch.

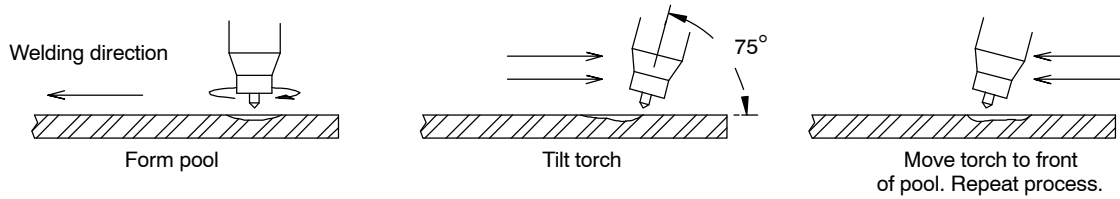
The tungsten extension should be no greater than the inside diameter of the gas cup.

Arc length is the distance from the tungsten to the workpiece.

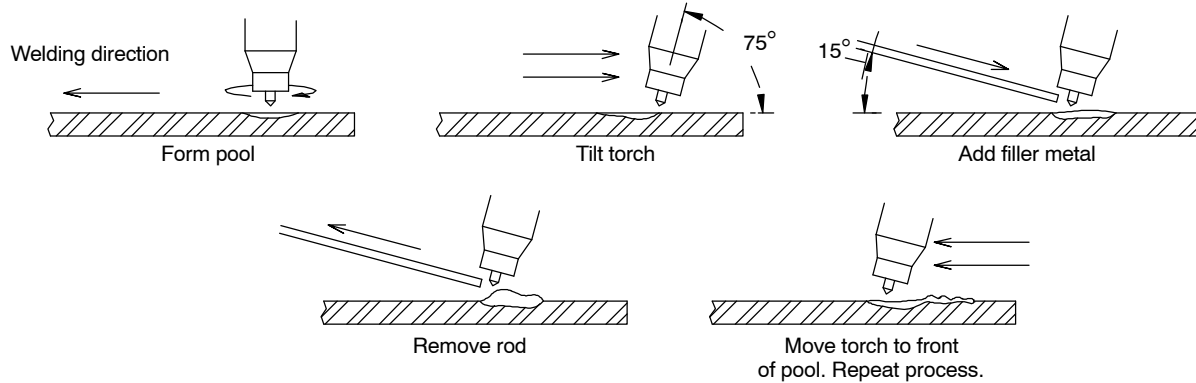
Ref. ST-161 892

6-2. Torch Movement During Welding

Tungsten Without Filler Rod



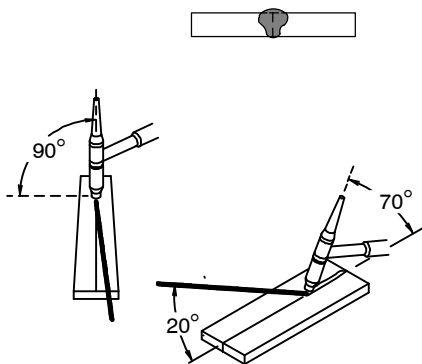
Tungsten With Filler Rod



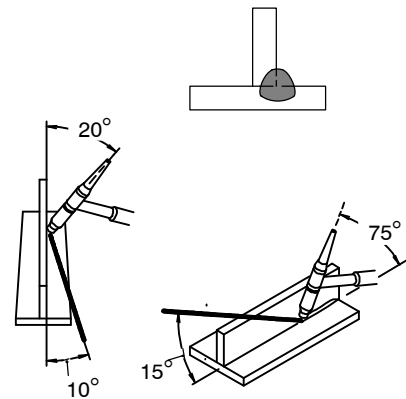
ST-162 002-B

6-3. Positioning Torch Tungsten For Various Weld Joints

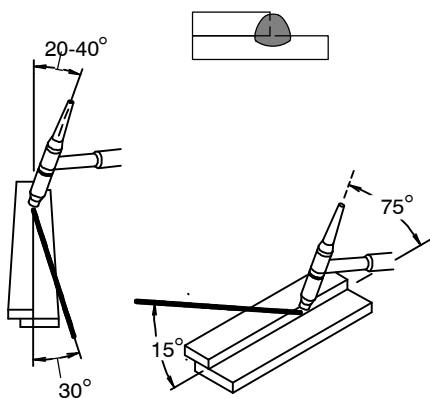
Butt Weld And Stringer Bead



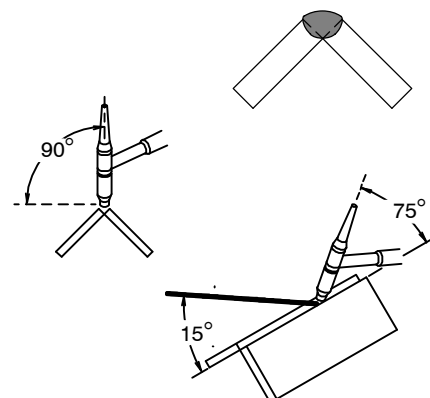
"T" Joint



Lap Joint

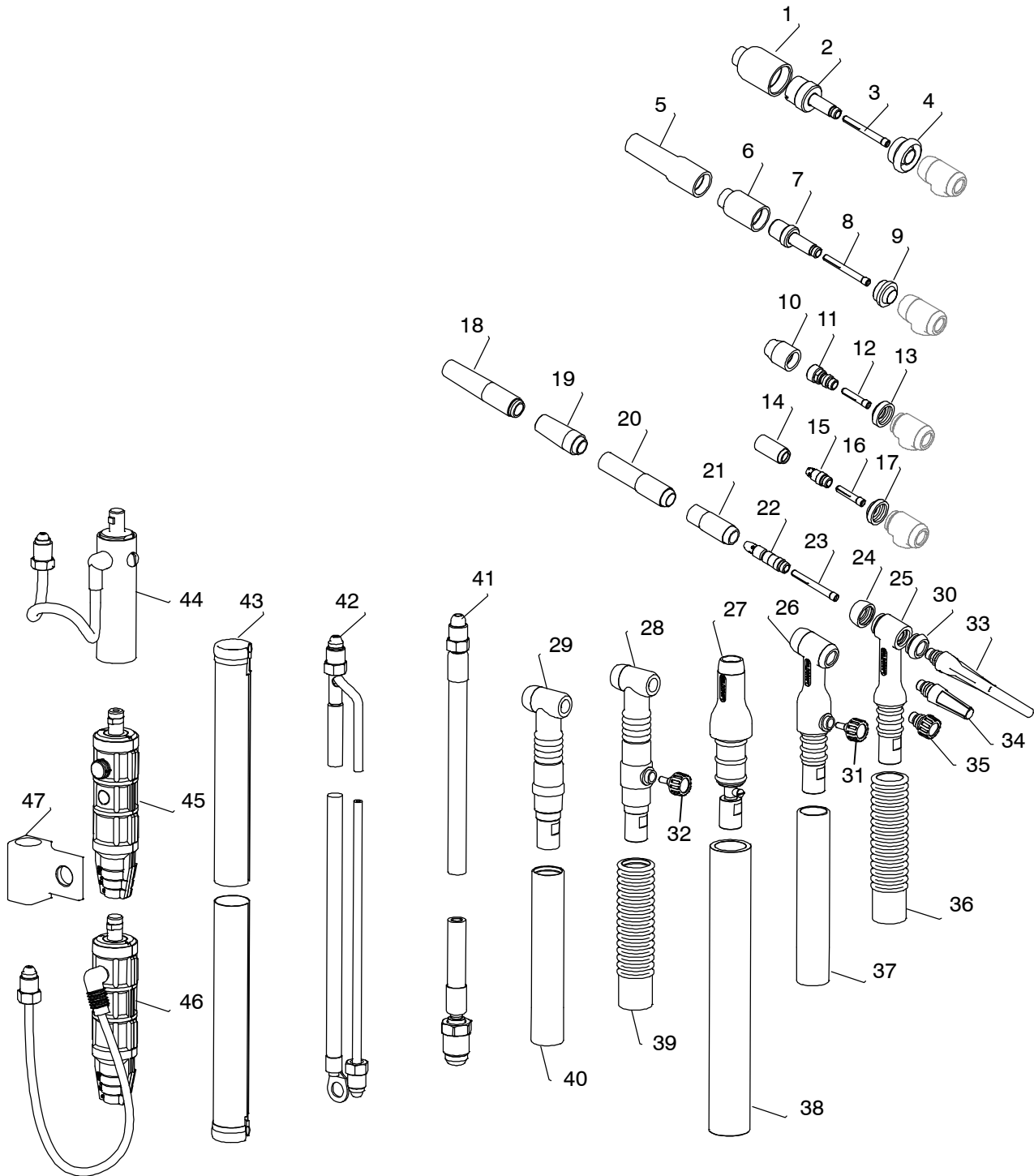


Corner Joint



ST-162 003 / S-0792

SECTION 7 – PARTS LIST



WC-0215A

Figure 7-1. Complete Torch Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity				
				WP Model				
				26	26V	26P	26FV	26F
Figure 7-1. Complete Torch Assembly								
1		◆57N75	Nozzle, Alumina GL LG #6 (3/8 in.)	1	1	1	1	1
1		◆57N74	Nozzle, Alumina GL LG #8 (1/2 in.)	1	1	1		
1		◆53N88	Nozzle, Alumina GL LG #10 (5/8 in.)	1	1	1		
1		◆53N87	Nozzle, Alumina GL LG #12 (3/4 in.)	1	1	1		
1		◆53N89	Nozzle, Alumina GL LG Short #15 (15/16 in.)	1	1	1	1	1
2		◆45V0204	Gas Lens, Large 0.020–0.040 in. (0.5–1.0 mm)	1	1	1	1	1
2		◆45V116	Gas Lens, Large 1/16 in. (1.6 mm)	1	1	1	1	1
2		◆45V64	Gas Lens, Large 3/32 in. (2.4 mm)	1	1	1	1	1
2		◆995795	Gas Lens, Large 1/8 in. (3.2 mm)	1	1	1	1	1
2		◆45V63	Gas Lens, Large 1/16 in. (1.6 mm)	1	1	1	1	1
3		◆10N21	Collet, 0.020 in. (0.5 mm)	1	1	1	1	1
3		◆10N22	Collet, 0.040 in. (1.0 mm)	1	1	1	1	1
3		◆10N23	Collet, 1/16 in. (1.6 mm)	1	1	1	1	1
3		10N24	Collet, 3/32 in. (2.4 mm)	1	1	1	1	1
3		◆10N25	Collet, 1/8 in. (3.2 mm)	1	1	1	1	1
3		◆54N20	Collet, 5/32 in. (4.0 mm)	1	1	1	1	1
4		◆54N63	Insulator, Gas lens LG	1	1	1	1	1
5		◆54N17L	Nozzle, Alumina GL Long #5 (5/16 in.)	1	1	1	1	1
5		◆54N16L	Nozzle, Alumina GL Long #6 (3/8 in.)	1	1	1	1	1
5		◆54N15L	Nozzle, Alumina GL Long #7 (7/16 in.)	1	1	1	1	1
6		◆54N18	Nozzle, Alumina GL #4 (1/4 in.)	1	1	1	1	1
6		◆54N17	Nozzle, Alumina GL #5 (5/16 in.)	1	1	1	1	1
6		◆54N16	Nozzle, Alumina GL #6 (3/8 in.)	1	1	1	1	1
6		◆54N15	Nozzle, Alumina GL #7 (7/16 in.)	1	1	1	1	1
6		◆54N14	Nozzle, Alumina GL #8 (1/2 in.)	1	1	1	1	1
6		◆54N19	Nozzle, Alumina GL Short #11 (11/16 in.)	1	1	1	1	1
7		◆45V29	Gas Lens 0.020 in. (0.5 mm)	1	1	1	1	1
7		◆45V24	Gas Lens 0.040 in. (1.0 mm)	1	1	1	1	1
7		◆45V25	Gas Lens 1/16 in. (1.6 mm)	1	1	1	1	1
7		◆45V26	Gas Lens 3/32 in. (2.4 mm)	1	1	1	1	1
7		◆45V27	Gas Lens 1/8 in. (3.2 mm)	1	1	1	1	1
7		◆45V28	Gas Lens 5/32 in. (4.0 mm)	1	1	1	1	1
8		◆10N21	Collet 0.020 in (0.5 mm)	1	1	1	1	1
8		◆10N22	Collet 0.040 in (1.0 mm)	1	1	1	1	1
8		◆10N23	Collet 1/16 in (1.6 mm)	1	1	1	1	1
8		◆10N24	Collet 3/32 in (2.4 mm)	1	1	1	1	1
8		◆10N25	Collet 1/8 in (3.2 mm)	1	1	1	1	1
8		◆54N20	Collet 5/32 in (4.0 mm)	1	1	1	1	1
9		◆54N01	Insulator, Gas Lens	1	1	1	1	1
10		◆53N58	Nozzle, Alumina GL #4 (1/4 in.)	1	1	1	1	1
10		◆53N59	Nozzle, Alumina GL #5 (5/16 in.)	1	1	1	1	1
10		◆53N60	Nozzle, Alumina GL #6 (3/8 in.)	1	1	1	1	1
10		◆53N61	Nozzle, Alumina GL #7 (7/16 in.)	1	1	1	1	1
10		◆53N61S	Nozzle, Alumina GL #8 (1/2 in.)	1	1	1	1	1
11		◆17GL040	Gas Lens, Stubby 0.040 in. (1.0 mm)	1	1	1	1	1
11		◆17GL116	Gas Lens, Stubby 1/16 in. (1.6 mm)	1	1	1	1	1
11		◆17GL332	Gas Lens, Stubby 3/32 in. (2.4 mm)	1	1	1	1	1
11		◆17GL18	Gas Lens, Stubby 1/8 in. (3.2 mm)	1	1	1	1	1
12		◆10N22S	Collet, Stubby 0.040 in. (1.0 mm)	1	1	1	1	1
12		◆10N23S	Collet, Stubby 1/16 in. (1.6 mm)	1	1	1	1	1
12		◆10N24S	Collet, Stubby 3/32 in. (2.4 mm)	1	1	1	1	1
12		◆10N25S	Collet, Stubby 1/8 in. (3.2 mm)	1	1	1	1	1
13		◆17GLG20	Insulator Gas Lens Stubby	1	1	1	1	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity				
				WP Model				
				26	26V	26P	26FV	26F

Figure 7-1. Complete Torch Assembly (continued)

14	◆13N08	Nozzle, Alumina #4 (1/4 in.)	1	1	1	1	1
14	◆13N09	Nozzle, Alumina #5 (5/16 in.)	1	1	1	1	1
14	◆13N10	Nozzle, Alumina #6 (3/8 in.)	1	1	1	1	1
14	◆13N11	Nozzle, Alumina #7 (7/16 in.)	1	1	1	1	1
14	◆13N12	Nozzle, Alumina #8 (1/2 in.)	1	1	1	1	1
14	◆13N13	Nozzle, Alumina #10 (5/8 in.)	1	1	1	1	1
15	◆17CB20	Collet Body, Stubby 0.040–1/8 in (1.0–3.3 mm)	1	1	1	1	1
16	◆10N22S	Collet, Stubby 0.040 in. (1.0 mm)	1	1	1	1	1
16	◆10N23S	Collet, Stubby 1/16 in. (1.6 mm)	1	1	1	1	1
16	◆10N24S	Collet, Stubby 3/32 in. (2.4 mm)	1	1	1	1	1
16	◆10N25S	Collet, Stubby 1/8 in. (3.2 mm)	1	1	1	1	1
17	◆18CG20	Insulator, Nozzle Stubby	1	1	1	1	1
18	◆12N03	Nozzle, Lava Long #4L (1/4 in.)	1	1	1	1	1
18	◆105Z60	Nozzle, Lava Long #5L (5/16 in.)	1	1	1	1	1
18	◆12N02	Nozzle, Lava Long #6L (3/8 in.)	1	1	1	1	1
18	◆105Z61	Nozzle, Lava Long #7L (7/16 in.)	1	1	1	1	1
19	◆105Z43	Nozzle, Lava #4 (1/4 in.)	1	1	1	1	1
19	◆105Z42	Nozzle, Lava #5 (5/16 in.)	1	1	1	1	1
19	◆105Z44	Nozzle, Lava #6 (3/8 in.)	1	1	1	1	1
19	◆105Z45	Nozzle, Lava #7 (7/16 in.)	1	1	1	1	1
19	◆08N78	Nozzle, Lava #8 (1/2 in.)	1	1	1	1	1
19	◆08N79	Nozzle, Lava #10 (5/8 in.)	1	1	1	1	1
19	◆08N80	Nozzle, Lava #12 (3/4 in.)	1	1	1	1	1
20	◆10N49L	Nozzle Alumina Long #5L (5/16 in.)	1	1	1	1	1
20	◆10N48L	Nozzle Alumina Long #6L (3/8 in.)	1	1	1	1	1
20	◆10N47L	Nozzle Alumina Long #7L (7/16 in.)	1	1	1	1	1
21	◆10N50	Nozzle, Alumina #4 (1/4 in.)	1	1	1	1	1
21	◆10N49	Nozzle, Alumina #5 (5/16 in.)	1	1	1	1	1
21	◆10N48	Nozzle, Alumina #6 (3/8 in.)	1	1	1	1	1
21	◆10N47	Nozzle, Alumina #7 (7/16 in.)	1	1	1	1	1
21	◆10N46	Nozzle, Alumina #8 (1/2 in.)	1	1	1	1	1
21	◆10N45	Nozzle, Alumina #10 (5/8 in.)	1	1	1	1	1
21	◆10N44	Nozzle, Alumina #12 (3/4 in.)	1	1	1	1	1
22	◆10N29	Collet Body, 0.020 in. (0.5 mm)	1	1	1	1	1
22	◆10N30	Collet Body, 0.040 in. (1.0 mm)	1	1	1	1	1
22	◆10N31	Collet Body, 1/16 in. (1.6 mm)	1	1	1	1	1
22	◆10N32	Collet Body, 3/32 in. (2.4 mm)	1	1	1	1	1
22	◆10N28	Collet Body, 1/8 in. (3.2 mm)	1	1	1	1	1
22	◆406488	Collet Body, 5/32 in. (4.0 mm)	1	1	1	1	1
23	◆10N21	Collet, 0.020 in. (0.5 mm)	1	1	1	1	1
23	◆10N22	Collet, 0.040 in. (1.0 mm)	1	1	1	1	1
23	◆10N23	Collet, 1/16 in. (1.6 mm)	1	1	1	1	1
23	◆10N24	Collet, 3/32 in. (2.4 mm)	1	1	1	1	1
23	◆10N25	Collet, 1/8 in. (3.2 mm)	1	1	1	1	1
23	◆54N20	Collet, 5/32 in. (4.0 mm)	1	1	1	1	1
24	◆18CG	Insulator, Nozzle	1	1	1	1	1
25	◆WP-26	Torch Body, 200A A/C	1				
26	◆WP-26V	Torch Body, 200A A/C VLV		1			
27	◆WP-26P	Torch Body, 200A A/C 180 Deg			1		
28	◆WP-26FV	Torch Body, 200A A/C FX VLV (Includes)				1	
	◆200VTB	Torch Body, 200VTB				1	
29	◆WP-26F	Torch Body, 200A A/C FX (Includes)					1
	◆200TB	Torch Body, 200TB					1
30	◆18-7	Insulator, Backcap	1	1		1	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity				
				WP Model				
				26	26V	26P	26FV	26F
Figure 7-1. Complete Torch Assembly (continued)								
... 31		◆VS-1	Knob, Valve	1				
... 32		◆VS-1	Knob, Valve				1	
... 33		◆57Y02	Backcap, Long	1	1		1	1
... 34		◆300M	Backcap Medium	1	1		1	1
... 35		◆57Y04	Backcap, Short	1	1		1	1
... 36		◆H-200R	Handle, Ribbed (WP-26, WP-26V)	1	1			
... 37		◆H-200	Handle, Knurled (WP-26, WP-26V)	1	1			
... 38		◆18PBWH	Barrel, 10 in. (254 mm) (WP-26P)			1		
... 39		◆10N15R	Handle, Ribbed Thrd (WP-26FV, WP-26F)				1	1
... 40		◆10N15	Handle, Knurled Thrd (WP-26FV, WP-26F)				1	1
... 41		◆46V28R	Cable, Power 12.5 Ft (3.8 m) Rubber	1	1	1	1	1
... 41		◆46V30R	Cable, Power 25 Ft (7.6 m)	1	1	1	1	1
... 42		◆46V28-2	Cable, Power 2 pc 12.5 Ft (3.8 m) (Includes)	1	1	1	1	1
... 42		◆40V75R	Hose, Gas 12.5 Ft (3.8 m) Rubber	1	1	1	1	1
... 42		◆46V30-2	Cable, Power 2 pc 25 Ft (7.6 m) Rubber (Includes)	1	1	1	1	1
... 43		◆41V30R	Hose, Gas 25 Ft (7.6 m) Braided	1	1	1	1	1
... 43		◆WC-3-10	Cover, Cable 10 Ft (3.0 m)	1	1	1	1	1
... 43		◆WC-3-22	Cover, Cable 22 Ft (6.7 m)	1	1	1	1	1
... 44		◆195379	Adapter, Torch-IntIn Style Gas (#26)	1	1	1	1	1
... 45		◆Q5GT200	Conn, Quick 200A 50mm Flow Thru	1	1	1	1	1
... 46		◆Q5G-200	Conn, Quick 200A 50mm w/Hose	1	1	1	1	1
... 47		◆45V62	Adapter, Power Cable	1	1	1	1	1
...		◆AK-3	Kit, Accessory Thoriated	1	1	1	1	1
...		◆AK-3C	Kit, Accessory Ceriated	1	1	1	1	1

◆OPTIONAL

BE SURE TO PROVIDE MODEL AND STYLE NUMBER WHEN ORDERING REPLACEMENT PARTS.

[illegible]

Notes



Owner's Record

Please complete and retain with your personal records.

Model Name

Serial/Style Number

Purchase Date

(Date which equipment was delivered to original customer.)

Distributor

Address

City

State

Zip



For Service

Contact a *DISTRIBUTOR* or *SERVICE AGENCY* near you.

Always provide Model Number.

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Welding Process Handbooks

Weldcraft

An Illinois Tool Works Company
2741 N. Roemer Rd
Appleton, WI 54911 USA

1-800-752-7620 Toll Free

1-920-882-6800 Phone

1-920-882-6844 FAX

www.Weldcraft.com

To locate a Distributor or Service Agency call 1-800-752-7620 or 920-882-6800

Contact the Delivering Carrier to:

File a claim for loss or damage during shipment.

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.