

Lasting Connections

## MIG/MAG TORCHES



# BÖHLER WELDING

## Lasting Connections

As a pioneer in innovative welding consumables, Böhler Welding offers a unique product portfolio for joint welding world-wide. More than 2000 products are adapted continuously to the current industry specifications and customer requirements, certified by well-respected institutes and thus approved for the most demanding welding applications. As a reliable partner for customers, "lasting connections" are the brand's philosophy in terms of both welding and people.

Our clients benefit from a partner with

- » the highest expertise in joining, rendering the best application support globally available
- » specialized and best in class product solutions for their local and global challenges
- » an absolute focus on customer needs and their success
- » a worldwide presence through factories, offices and distributors

**Due to our new torch portfolio, from now on, Böhler Welding offers the perfect combination of welding machines, torches and consumables to achieve the best welding solution out of one hand.**



# FULL POWER IN YOUR HAND

## Robust, long lifetime and excellent handling

MIG/MAG torches by Böhler Welding are durable products for premium performance and high quality welds. With their light weight and excellent balance, our air and liquid cooled torches are premium products to achieve excellent welding results.



Our four air cooled Böhler MT xxx G torches are convincing when the best possible welding results with torch neck geometry should be achieved. The slim, straight handles allow easy handling as well as different posture positions and flexibility within the torch neck alignment. These torches are very robust, durable and thanks to the double fixation of the torch neck especially well protected against mechanical deformation. The torch necks and gas nozzles are nickel-plated to prevent the formation of weld spatter. Additionally, the low weight of the cable and the torch allows comfortable welding.

Our two liquid cooled Böhler MT xxx W torches are superior due to higher load limits compared to conventional torches of the same size. Due to the cooling system, wear parts are well protected from overheating - even at high outputs. Integrated spatter protection within the gas nozzles make these torches particularly resistant and robust. In addition, torch necks and gas nozzles are nickel-plated to prevent the formation of weld spatter.

## Key Benefits for air and liquid cooled MIG/MAG torches by Böhler Welding

- » High quality and durability
- » Reliable solution offering premium performance, robustness, endurance and an increase of productivity
- » Robust wear parts ensuring minimum shielding gas loss and long-life cycle
- » Advanced ergonomic design ensures good comfort in all welding positions
- » Easy maintenance and replacement of wear parts

# AIR COOLED TORCHES

| Product                                      | Technical data (EN 60 974-7)  |
|--|---|
| Air cooled (available in 3 m & 4 m versions) |   |
| Böhler MT 150 G - Böhler MT 150 G U/D        | » Load: 170 A CO <sub>2</sub> , 170 A mixed gas *<br>» Duty cycle: 60 %<br>» Wire-Ø: 0,8–1,0 mm |
| Böhler MT 250 G - Böhler MT 250 G U/D        | » Load: 230 A CO <sub>2</sub> , 220 A mixed gas *<br>» Duty cycle: 60 %<br>» Wire-Ø: 0,8–1,2 mm |
| Böhler MT 300 G - Böhler MT 300 G U/D        | » Load: 280 A CO <sub>2</sub> , 260 A mixed gas *<br>» Duty cycle: 60 %<br>» Wire-Ø: 0,8–1,6 mm |
| Böhler MT 350 G - Böhler MT 350 G U/D        | » Load: 330 A CO <sub>2</sub> , 310 A mixed gas *<br>» Duty cycle: 60 %<br>» Wire-Ø: 0,8–1,6 mm |

\* [M21 (DIN EN ISO 14175)]

| Product features  | User benefits   | High quality spare parts   |
|---|---|--|
| » Light weight and very powerful<br>» Premium performance, high robustness and lifetime<br>» Excellent balance and ergonomic handle with ball joint<br>» Optimal handle grip with soft component<br>» Massive torch neck with double fixations in handle for the toughest operating conditions<br>» Solid fixed slip-on nozzle<br>» Premium nickel plated gas nozzle and thermally highly loadable insulation<br>» Contact tip holder including gas diffuser<br>» Insulated liners as standard to prevent gas loss at the machine side connection<br>» Highly flexible and durable coaxial cable<br>» Light coaxial cable (1/3 lighter than the standard on the market) | » Long lifetime of the torch reduces recurring investment costs<br>» Higher productivity due to high heat resistance<br>» Time saving thanks to easy maintenance and replacement of wear parts<br>» Weight saving considerably reduces the physical strain on welders, especially for longer seams or difficult accessibility<br>» High working comfort for all welding positions (even in positional welding)<br>» Time saving through quick change and proper fixation of slip-on nozzle during hot welding processes | » Precisely manufactured parts with very tight tolerances ensure stable processes<br>» Gas Nozzle: High quality nickel plating reduces spatter adherence by more than 30%, high temperature loadable<br>» Proper fixed nozzle seat due to snap ring clamping<br>» CuCrZr tips for long lasting and durable wire feeding, "high speed deep drilling" production process enables narrow tolerances and smoother surface for ideal current transfer<br>» Insulated Liner and connection: No gas losses and no disturbance of power sensing<br>» No additional gas diffuser made of synthetic material - less spare parts and cost, more reliable and robust<br>» Torch body: Double fixation protect the neck against mechanical damage |





# BÖHLER MIG/MAG TORCHES

## BÖHLER MT XXX G (AIR COOLED)

| Torch types - BÖHLER MT                |       | 150 G   |   | 250 G   |           | 300 G                                     |           | 350 G     |  |
|--|-------|---|---|---|-----------|---|-----------|-----------|--|
| Standard                               |       |                         |   |   |           |   |           |           |  |
|  |       | M6  | M6  | M7  | M8        | M7  | M8        | M7        |  |
|  | 3 m   | 56638   | 72767   | 56641   | 72781     | 56655                                     | 72795     | 56658     |  |
|  | 4 m   | 56639   | 72778   | 56652   | 72783     | 56657                                     | 72807     | 56702     |  |
| U/D                                    |       |                         |   |   |           |   |           |           |  |
|  |       | M6  | M6  | M7  | M8        | M7  | M8        | M7        |  |
|  | 3 m   | 81.05.001   | 81.05.033   | 81.05.003   | 81.05.035 | 81.05.005                                 | 81.05.037 | 81.05.007 |  |
|  | 4 m   | 81.05.002   | 81.05.034   | 81.05.004   | 81.05.036 | 81.05.006                                 | 81.05.038 | 81.05.008 |  |
| Wear and spare parts                   |       | for 150 G - 150 G U/D   |   | for 250 G - 250 G U/D   |           | for 300 G - 300 G U/D - 350 G - 350 G U/D |           |           |  |
| Gas nozzle (5 pcs.)                    |       | <br>NW12 / L = 53 / Ø 18 | <br>NW16 / L = 70 / Ø 22 | <br>NW16 / L = 72 / Ø 25 |           |   |           |           |  |
|  |       | 56739   | 56740   | 56752   |           |   |           |           |  |
| Contact tip (10 pcs.)                  |       | <br>Ø 6 / L = 25       | <br>Ø 8 / L = 28       | <br>Ø 10 / L = 30      |           |   |           |           |  |
|  |       | M6  | M6  | M7  | M8        |   | M7        |           |  |
| Contact tip ECu                        | Ø 0.8 | 56810   | 72939   | 60596   | 72936     |   | 56812     |           |  |
|  | Ø 1.0 | 56811   | 72940   | 60598   | 72937     |   | 56814     |           |  |
|  | Ø 1.2 |   | 72947   | 60605   | 72938     |   | 56817     |           |  |
| Contact tip CuCrZr                     | Ø 0.8 |   | 73098   | 63443   | 72948     |   | 56820     |           |  |
|  | Ø 1.0 |   | 73102   | 63444   | 72983     |   | 56824     |           |  |
|  | Ø 1.2 |   | 73107   | 63445   | 72989     |   | 56831     |           |  |
|  | Ø 1.6 |   |   |   | 73014     |   | 56839     |           |  |
| Contact tip ECu<br>for aluminium wire  | Ø 0.8 | 63433   | 73026   | 63435   | 73061     |   | 63438     |           |  |
|  | Ø 1.0 | 63434   | 73043   | 63436   | 73073     |   | 63439     |           |  |
|  | Ø 1.2 |   | 73055   | 63437   | 73086     |   | 63440     |           |  |
|  | Ø 1.6 |   |   |   | 73087     |   | 63442     |           |  |
| Contact tip holder /<br>brass (5 pcs.) |       | <br>M8x1 / L = 50      | <br>M10x1 / L = 52     | <br>M12x1 / L = 53     |           |   |           |           |  |
|  |       | M6  | M6  | M7  | M8        |   | M7        |           |  |
|  |       | 56772   | 72917   | 56775   | 72921     |   | 56783     |           |  |
| Nozzle spring<br>(100 pcs.)            |       |                        |   |   |           |   |           |           |  |
|  |       | 61431   |   |   |           |   |           |           |  |

SELECTION GUIDE

# FULL POWER IN YOUR HAND





# LIQUID COOLED TORCHES

| Product   | Technical data (EN 60 974-7)   |
|---|--|
| Liquid cooled (available in 3 m & 4 m versions) |  |
| Böhler MT 440 W - Böhler MT 440 W U/D           | » Load: 500 A CO <sub>2</sub> , 450 A mixed gas *<br>» Duty cycle: 100 %<br>» Wire-Ø: 0,8–1,6 mm |
| Böhler MT 540 W - Böhler MT 540 W U/D           | » Load: 600 A CO <sub>2</sub> , 550 A mixed gas *<br>» Duty cycle: 100 %<br>» Wire-Ø: 0,8–1,6 mm |

\* [M21 (DIN EN ISO 14175)]

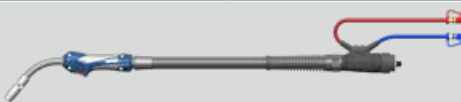





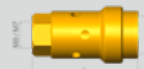
| Product features  | User benefits   | High quality spare parts  |
|---|---|---|
| » Premium performance, high robustness and lifetime<br>» Excellent balance and ergonomic handle with ball joint<br>» Optimal handle grip with soft component<br>» Massive torch neck with triple fixations in handle for the toughest operating conditions<br>» Premium nickel plated gas nozzle and thermally highly loadable insulation<br>» Long gas transport distance for excellent consistent gas coverage<br>» Contact tip holder including gas diffuser<br>» Insulated liners as standard to prevent gas loss at the machine side connection<br>» One flexible cable assembly for all liquid cooled torches without separate gas hose | » High load limits allow to use a high range of different wires for welding<br>» Higher productivity due to high heat resistance<br>» Long lifetime of the torch reduces recurring investment costs<br>» Time saving thanks to easy maintenance and replacement of wear parts<br>» High working comfort for all welding positions (even in positional welding)<br>» Reduction of storage and maintenance costs due to the use of the same hoses and cables for both liquid cooled torches | » Precisely manufactured parts with very tight tolerances ensure stable processes<br>» Gas Nozzle high quality nickel-plated nozzle reduces spatter adhesion by more than 30%.<br>» CuCrZr tips for long lasting and durable wire feeding, "high speed deep drilling" production process enables narrow tolerances and smoother surface for ideal current transfer<br>» Insulated Liner and connection: No gas losses and no disturbance of power sensing.<br>» No additional gas diffuser made of synthetic material - less spare parts and cost, more reliable and robust<br>» Torch body: Triple fixation protect the neck against mechanical damage<br>» Cable assembly: Solid and robust threaded connections. |



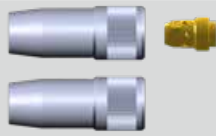


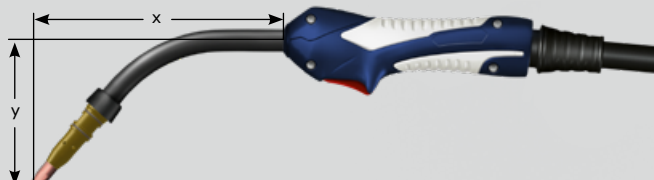
# BÖHLER MIG/MAG TORCHES

## BÖHLER MT XXX W (LIQUID COOLED)

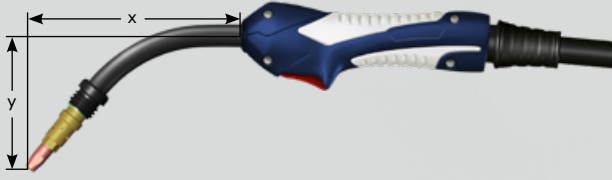
| Torch types - BÖHLER MT                |       | 440 W   |           | 540 W   |           |
|--|-------|---|-----------|---|-----------|
| Standard                               |       |                           |           |   |           |
|  |       | M8  | M7        | M8  | M7        |
|  | 3 m   | 72812   | 56716     | 72860   | 56729     |
|  | 4 m   | 72826   | 56728     | 72878   | 56730     |
| U/D                                    |       |                           |           |   |           |
|  |       | M8  | M7        | M8  | M7        |
|  | 3 m   | 81.05.039   | 81.05.009 | 81.05.041   | 81.05.011 |
|  | 4 m   | 81.05.040   | 81.05.010 | 81.05.042   | 81.05.012 |
| Wear and spare parts                   |       | for 440 W - 440 W U/D   |           | for 540 W - 540 W U/D   |           |
| Gas nozzle (5 pcs.)                    |       | <br>NW14.5 / L = 66 / Ø 22 |           | <br>NW16 / L = 66 / Ø 24 |           |
|  |       | 56753   |           | 56755   |           |
| Contact tip (10 pcs.)                  |       | <br>Ø10 / L = 30        |           |   |           |
|  |       | M8  |           | M7  |           |
| Contact tip ECu                        | Ø 0.8 | 72936   |           | 56812   |           |
|  | Ø 1.0 | 72937   |           | 56814   |           |
|  | Ø 1.2 | 72938   |           | 56817   |           |
| Contact tip CuCrZr                     | Ø 0.8 | 72948   |           | 56820   |           |
|  | Ø 1.0 | 72983   |           | 56824   |           |
|  | Ø 1.2 | 72989   |           | 56831   |           |
|  | Ø 1.6 | 73014   |           | 56839   |           |
| Contact tip ECu<br>for aluminium wire  | Ø 0.8 | 73061   |           | 63438   |           |
|  | Ø 1.0 | 73073   |           | 63439   |           |
|  | Ø 1.2 | 73086   |           | 63440   |           |
|  | Ø 1.6 | 73087   |           | 63442   |           |
| Contact tip holder /<br>brass (5 pcs.) |       | <br>M10x1 / L = 28       |           | <br>M10x1 / L = 28.5   |           |
|  |       | M8  | M7        | M8  | M7        |
|  |       | 72926   | 56786     | 72931   | 56797     |

# WEAR AND SPARE PARTS

| Heavy duty wear part sets   |  |  |       |
|---|--|--|-------|
| HD gas nozzle set<br>MT 540 W<br>(2 pcs. HD gas nozzle,<br>1 pc. contact tip<br>holder) |  |  |       |
|   |  | M8   | M7    |
|   |  | 72932  | 63430 |



| Torch neck MT xxx G                |            | 150 G - 150 G U/D  |       | 250 G - 250 G U/D |       | 300 G - 300 G U/D |       | 350 G - 350 G U/D |  |
|------------------------------------|------------|--|-------|-------------------|-------|-------------------|-------|-------------------|--|
| Torch neck +<br>Contact tip holder |            |  |       |                   |       |                   |       |                   |  |
|                                    | Geometry   | 45°  |       | 45°               |       | 45°               |       | 45°               |  |
|                                    | X x Y (mm) | 120 x 80   |       | 140 x 85          |       | 150 x 85          |       | 180 x 105         |  |
|                                    |            | M6   | M6    | M7                | M8    | M7                | M8    | M7                |  |
|                                    |            | 70962  | 72933 | 70979             | 72934 | 70980             | 72935 | 70981             |  |



| Torch neck spares                |  | for 150 G - 150 G U/D | for 250 G - 250 U/D | for 300 G - 300 G U/D - 350 G - 350 G U/D |
|----------------------------------|--|-----------------------|---------------------|---|
| Protection cap (10 pcs.)         |  | 70513                 | 70534               |   |
| Connection piece halves (1 pair) |  | 70255                 |                     | -   |
| Head insulation (5 pcs.)         |  | 70424                 | 70440               | 70441                                     |



| Torch neck MT xxx W                         |            | 440 W - 440 W U/D  | 540 W - 540 W U/D |
|---|------------|--|-------------------|
| Torch neck<br>(excl. Contact tip<br>holder) |            |  |                   |
|   | Geometry   | 50°  | 50°               |
|   | X x Y (mm) | 140 x 95   | 160 x 95          |
|   |            | 70991  | 70992             |

| Torch neck spares            |  | for 440 W - 440 W U/D - 540 W - 540 W U/D |
|------------------------------|--|---|
| Insulating disc<br>(10 pcs.) |  | 70466                                     |
| O-ring (red)<br>(20 pcs.)    |  | 70477                                     |



### Liner for air-cooled and liquid-cooled torches MT line

| Liner (1 pcs.) for<br>air-cooled and<br>liquid-cooled<br>torches MT Line |             |  |                                       |                                     |
|--|-------------|--|---------------------------------------|-------------------------------------|
|  |             | neutral  | PTFE<br>(for stainless steel wire)    | Carbon-PTFE<br>(for aluminium wire) |
| Liner 3 m  | Ø 0.8       | 56840  | 62197                                 | 62205                               |
|  | Ø 1.0 / 1.2 | 56849  | 62200                                 | 62207                               |
|  | Ø 1.6       | 56876  | 62202                                 | 62209                               |
| Liner 4 m  | Ø 0.8       | 56846  | 62198                                 | 62206                               |
|  | Ø 1.0 / 1.2 | 56875  | 62201                                 | 62208                               |
|  | Ø 1.6       | 56877  | 62204                                 | 62210                               |
| Liner (1 pcs.) for<br>air-cooled and<br>liquid-cooled<br>torches MT Line |             |  |                                       |                                     |
|  |             | Combi-Liner Al<br>(PTFE/Brass)   | Combi-Liner Al<br>(Carbon-PTFE/Brass) |                                     |
| Liner 3 m  | Ø 0.8       | 70229  | 70121                                 |                                     |
|  | Ø 1.0 / 1.2 | 70161  | 70176                                 |                                     |
|  | Ø 1.6       | 70155  | 73108                                 |                                     |
| Liner 4 m  | Ø 0.8       | 70230  | 70152                                 |                                     |
|  | Ø 1.0 / 1.2 | 70215  | 70224                                 |                                     |
|  | Ø 1.6       | 70159  | 73111                                 |                                     |







| Cable assembly          |     | Standard  |       | U/D   |       |
|-------------------------|-----|---|-------|---|-------|
| Cable assembly MT xxx G |     |  |       |  |       |
|                         |     | Light-weight - 2-pole   |       | Light-weight - 5-pole   |       |
|                         |     | 3 m   | 4 m   | 3 m   | 4 m   |
| Bikox MT 150 G          | R18 | 70007   | 70008 | 70017   | 70031 |
| Bikox MT 250 G          | R28 | 70032   | 70033 | 70035   | 70036 |
| Bikox MT 300 G          | R42 | 70039   | 70040 | 70041   | 70045 |
| Bikox MT 350 G          | R53 | 70047   | 70048 | 70049   | 70052 |
| Cable assembly MT xxx W |     |  |       |  |       |
|                         |     | 3 m   | 4 m   | 3 m   | 4 m   |
|                         |     | 70064   | 70071 | 70075   | 70078 |







| Connection housing / Central connector   |       | for MT xxx G   | for MT xxx G U/D  | for MT xxx W  | for MT xxx W U/D |
|--|-------|--|---|---|------------------|
| Connection housing incl. Bayonet (1 pc.) |       |   |  |  |                  |
|  |       | 63453  | 70234   | 63454   |                  |
| Central connector (1 pc.)                |       |   |   |  |                  |
|  |       | 70096  |   | 70100   |                  |
| Hexagon nut (10 pcs.)                    | M10x1 | 70468  |   | -   |                  |
| Connection nut                           | M33x2 | 70237  |   |   |                  |
| Nut (5 pcs.)                             | M10x1 | 70439  |   |   |                  |
| O-Ring (black) (20 pcs.)                 | 4x1   | 70474  |   |   |                  |
| SELCO plug - 7-pole                      |       |  |   |   |                  |
|  |       | 70622  |   |   |                  |
| Controle lead with SELCO plug - 7-pole   |       |  |   |   |                  |
|  |       | 70279  |   |   |                  |

| Cable assembly components - MT xxx G        |  |  |                          |                        |
|---|--|--|--------------------------|------------------------|
| Cable support (for connection housing side) |  |  |                          |                        |
|   |  | MT 150 G - 250 G<br>DN19   | MT 300 G - 350 G<br>DN21 | MT 350 G U/D<br>DN22.5 |
|   |  | 70308  | 70309                    | 70328                  |
| Cable support (for handle side)             |  |  |                          |                        |
|   |  | MT xxx G - DN17 - 22   |                          |                        |
|   |  | 70330  |                          |                        |

| Cable assembly components - MT xxx W |  |  |       |
|--------------------------------------|--|--|-------|
| Power cable PVC                      |  | 3 m  | 4 m   |
|                                      |  |  |       |
|                                      |  | 70497  | 70512 |
| Wire conduit with crimping sleeve    |  | 3 m  | 4 m   |
|                                      |  |  |       |
|                                      |  | 70641  | 70642 |



| Cable assembly components - MT xxx W         |        |  |   |
|--|--------|--|---|
| Control lead with connectors                 |        | 3 m  | 4 m   |
|  |        |  |   |
|  |        | 70266  | 70267   |
| Hose clip (20 pcs.)                          | D 9 mm | 70442  |   |
| Outer cover with cable support (handle side) |        | 3 m  | 4 m   |
|  |        |  |   |
|  |        | 70479  | 70480   |
| Cable support                                |        |   |  |
|  |        | spring   | sleeve (10 pcs.)  |
|  |        | 70062  | 70058   |
| Fastener cap (20 pcs.)                       |        |   |  |
|  |        | blue   | red   |
|  |        | 70384  | 70401   |
| Exchange support                             |        | for power water cable  | for wire conduit - gas hose   |
|  |        | 70342  | 70333   |

| Handle set, lever trigger, TPE-insert, controle module |  |   |  |
|--|--|---|--|
| Handle set   |  |      |   |
|  |  | Standard  | U/D  |
|  |  | handle, lever trigger (standard and long), ball-joint, screws, insert nuts and stickers | handle, Controle module U/D, TPE insert U/D, lever trigger (standard and long), ball-joint, screws, insert nuts and stickers |
| Lever trigger (2 pcs.)                                 |  |      |   |
|  |  | standard  | long   |
|  |  | 63431   | 63432  |
| Controle module U/D                                    |  |     |  |
|  |  | 70303   |  |
| TPE insert U/D - BIS-52 (2 pcs.)                       |  |     |  |
|  |  | 70639   |  |



# JOIN! voestalpine Böhler Welding

We are a leader in the welding industry with over 100 years of experience, more than 50 subsidiaries and more than 1,000 distribution partners around the world. Our extensive product portfolio and welding expertise combined with our global presence guarantees we are close when you need us. Having a profound understanding of your needs enables us to solve your demanding challenges with Full Welding Solutions - perfectly synchronized and as unique as your company.



**Lasting Connections** – Perfect alignment of welding machines, consumables and technologies combined with our renowned application and process know-how provide the best solution for your requirements: A true and proven connection between people, products and technologies. The result is what we promise: Full Welding Solutions for Lasting Connections.



**Tailor-Made Protectivity™** – The combination of our high-quality products and application expertise enables you to not only repair and protect metal surfaces and components. Our team of engineers, experienced in your specific applications, offer you customized solutions resulting in increased productivity for your demanding challenge. The result is what we promise: Tailor-Made Protectivity™.



**In-Depth Know-How** – As a manufacturer of soldering and brazing consumables, we offer proven solutions based on 60 years of industrial experience, tested processes and methods, made in Germany. This in-depth know-how makes us the internationally preferred partner to solve your soldering and brazing challenge through innovative solutions. The result is what we promise: Innovation based on in-depth know-how.

The Management System of voestalpine Böhler Welding Group GmbH, Peter-Mueller-Strasse 14-14a, 40469 Duesseldorf, Germany has been approved by Lloyd's Register Quality Assurance to: ISO 9001:2015, ISO 14001:2015, OHSAS 18001:2007, applicable to: Development, Manufacturing and Supply of Welding and Brazing Consumables. More information: [www.voestalpine.com/welding](http://www.voestalpine.com/welding)



