

## ALPHA FLUX FCAW Welding Torches air cooled



### For Outdoor- Professionals.

ALPHA FLUX – the new generation of Flux-Cored Self Shielding Welding Torches – suitable for extreme applications in pipeline construction, cladding and rail joint welding as well as at repair work. Equipped with quick-change torch neck, fixable at all angles as well as with the heavy duty highly flexible coaxial cable BIKOX® R for applications up to  $-30^{\circ}\text{C}$ , the ALPHA FLUX offers optimal handling.

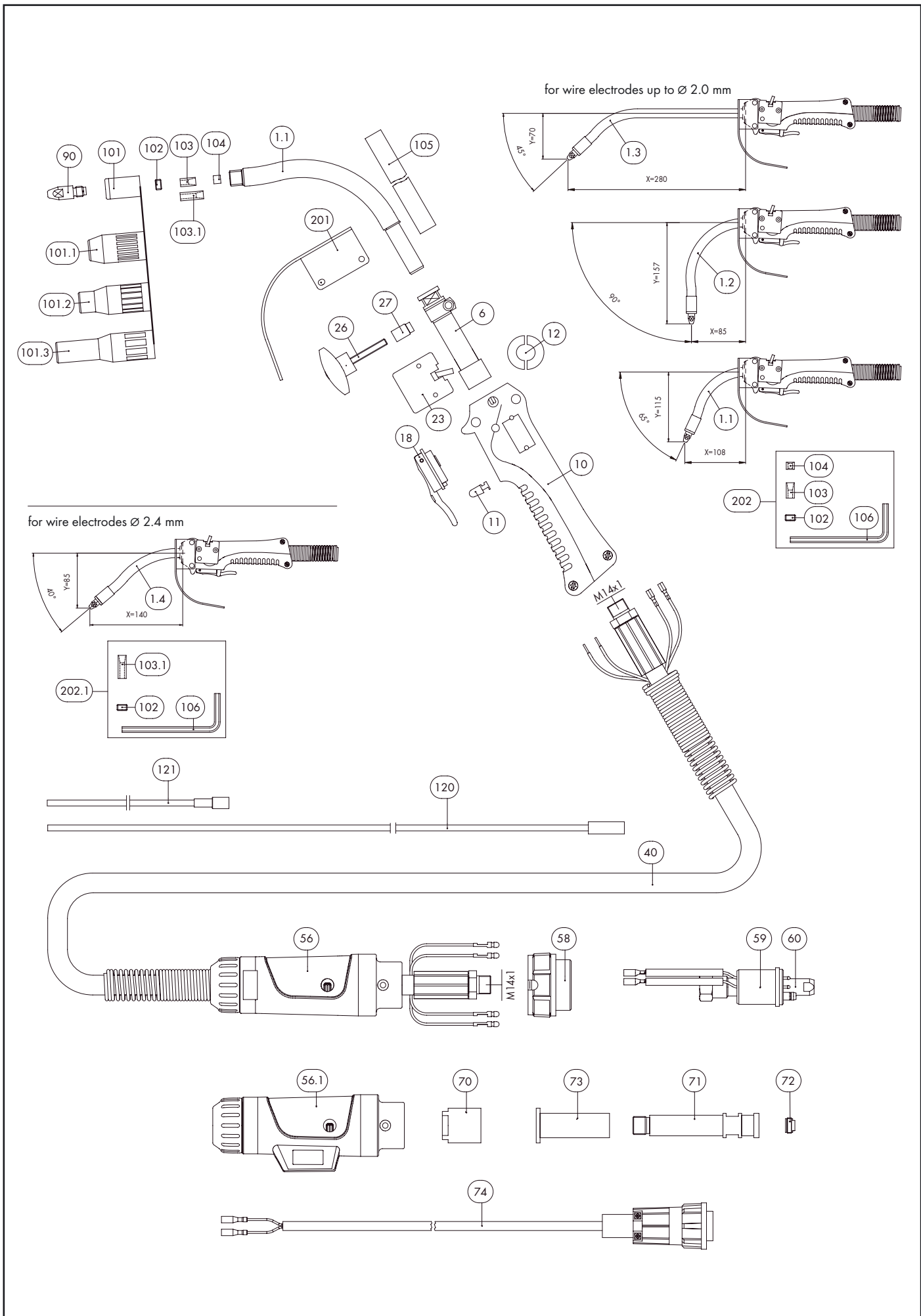
- Quick-change torch neck, fixable at all angles.
- Silver-plated contact tips – low spatter adhesion.
- Optional additional switch for adjustment of welding current.

- Highly flexible coaxial cable BIKOX® R for applications up to  $-30^{\circ}\text{C}$ .
- Changeable liner.
- Torch protection caps for different wire sizes.

#### Technical Data (IEC EN 60 974-7):

Rating:	330 A with self shielding Flux-Cored Wire 60% ED
Wire-Ø:	1.2 – 2.4





Build group	Pos.	Description	Specifications	Part no.
<b>Torch</b>		ALPHA FLUX 350 KZ-2	3.00 m Standard	013.D160
		ALPHA FLUX 350 KZ-2	4.50 m Standard	013.D161
		ALPHA FLUX 350 LN	3.00 m Standard <sup>1)</sup>	013.D152
		ALPHA FLUX 350 LN	4.50 m Standard <sup>1)</sup>	013.D153
		ALPHA FLUX 350 KZ-2	3.00 m with welding current switch <sup>2)</sup>	013.D158
		ALPHA FLUX 350 KZ-2	4.50 m with welding current switch <sup>2)</sup>	013.D159
		ALPHA FLUX 350 LN	3.00 m with welding current switch <sup>1) 2)</sup>	013.D164
		ALPHA FLUX 350 LN	4.50 m with welding current switch <sup>1) 2)</sup>	013.D165
<b>Swan neck</b>	1.1	Swan neck ALPHA FLUX 350	M8 65° X = 108 Y = 115 <sup>3)</sup>	013.D144 •
	w/o fig.	Swan neck ALPHA FLUX 350	5/16" 65° X = 108 Y = 115 <sup>3)</sup>	013.D162
	1.2	Swan neck ALPHA FLUX 350	M8 90° X = 85 Y = 157 <sup>3)</sup>	013.D136
	w/o fig.	Swan neck ALPHA FLUX 350	5/16" 90° X = 85 Y = 157 <sup>3)</sup>	013.D140
	1.3	Swan neck ALPHA FLUX 350	M8 45° X = 280 Y = 70 <sup>3)</sup>	013.D169
	1.4	Swan neck ALPHA FLUX 350	M8 40° X = 140 Y = 85	Wire Ø 2.4 <sup>4)</sup> 013.D210.1
	w/o fig.	Swan neck ALPHA FLUX 350	5/16" 40° X = 140 Y = 85	Wire Ø 2.4 <sup>4)</sup> 013.D212.1
	<b>Handle</b>	6	Torch body M14x1 FLUX	
10		Handle FLUX cpl.		180.D051
		Handle FLUX cpl. for welding current switch		180.D052
11		Trigger guard with stopper		400.D252
12		Cover disc Ø 16 mm, seperated	2 pcs.	013.D199
18		Trigger switch long		185.D065
w/o fig.		Trigger switch short		185.D074
23		Switch assembly (switch)		185.D085
26		Wing screw M5x31 mm cpl.		013.D166
27		Sleeve, insulated		013.D167
<b>Cable assembly KZ-2</b>	40	BIKOX® RF 35 4-wire 3.00 m		160.D806
		BIKOX® RF 35 4-wire 4.50 m		160.D808
	56	Connector housing, small		501.D508
	56.1	Connector housing, small for trigger wire for welding current switch		501.D507
	58	Connector nut M33x2		500.0213
	59	Central plug KZ-2 M14x1		501.D342
	60	Fixing bush M14x1 cap nut		501.0129
<b>Cable assembly LN</b>	40	BIKOX® RF 35 4-wire 3.00 m		160.D806
		BIKOX® RF 35 4-wire 4.50 m		160.D808
	56.1	Connector housing, small for trigger wire for welding current switch		501.D501
	70	Uni-Plug M14x1		501.D347
	71	Intermediate connector LN		501.9241
	72	Clamp screw LN		331.9002
	73	Insulating tube LN		501.9192
	74	Trigger wire LN cpl.		501.D556.1
		Other trigger wire adaptors on request		
<b>Wear parts</b>	90	Contact tip M8; Ø 1.2 (10x30) CuCrZr silver plated	10 pcs.	147.0445
		Contact tip M8; Ø 1.4 (10x30) CuCrZr silver plated	10 pcs.	147.0536
		Contact tip M8; Ø 1.6 (10x30) CuCrZr silver plated	10 pcs.	147.0590
		Contact tip M8; Ø 2.0 (10x30) CuCrZr silver plated	10 pcs.	147.0656 •
		Contact tip M8; Ø 2.4 (10x30) CuCrZr silver plated	10 pcs.	147.0679
	101	Insulator 1 ALPHA FLUX		013.D132
	101.1	Torch protection cap, gas nozzle recess 2 mm		145.D359
	101.2	Torch protection cap, gas nozzle recess 13 mm		145.D362
	101.3	Torch protection cap, gas nozzle recess 34 mm		145.D365

Build group	Pos.	Description	Specifications	Part no.
<b>Wear parts</b>	102	Threaded pin M8; 4 mm	5 pcs.	013.D139•
		Threaded pin 5/16", 4 mm	5 pcs.	013.D141
	103	Sleeve Ø 3.5 mm, L = 12 mm, for wire electrodes up to Ø 2.0	5 pcs.	013.D138
	103.1	Sleeve Ø 3.5 mm, L = 18 mm, for wire electrodes up to Ø 2.4	5 pcs.	013.D211.5
	104	Ceramic sleeve Ø 3.5 mm, for wire electrodes up to Ø 2.0	5 pcs.	013.D137
	105	Insulating tube 141 mm for 60° and for 40°		013.D146•
		Insulating tube 178 mm for 90°		013.D128
		Insulating tube 274 mm for 45°		013.D171
	120	Cable liner 2.8x6.3 for wire electrodes up to Ø 2.0 for 3.00 m		122.D106•
		Cable liner 2.8x6.3 for wire electrodes up to Ø 2.0 for 4.50 m		122.D107
		Cable liner 3.5x7.0 for wire electrodes Ø 2.4 for 3.00 m		122.D114
		Cable liner 3.5x7.0 for wire electrodes Ø 2.4 for 4.50 m		122.D115
	121	Neck liner 3.0 for Pos. 1.1 and 1.2 for wire electrodes up to Ø 2.0		122.D116
	Neck liner 3.0 for Pos. 1.3 for wire electrodes up to Ø 2.0		122.D112	
	Neck liner 3.4 for Pos. 1.4 for wire electrodes Ø 2.4		122.D111	
<b>Wear parts set:</b>	202	consisting of: Pos. 102 (1x), 103 (1x), 104 (5x), 106 - hexagon spanner SW4 (1x) for M8, wire electrodes up to Ø 2.0		013.D201
		for 5/16", wire electrodes up to Ø 2.0		013.D205
	202.1	consisting of: Pos. 102 (1x), 103.1 (1x), 106 - hexagon spanner SW4 (1x) for M8, wire electrodes Ø 2.4		013.D213.1
	for 5/16", wire electrodes Ø 2.4		013.D214.1	
<b>Miscellaneous</b>	201	Hand shield for ALPHA FLUX		400.D386.1

- standard equipment

<sup>1)</sup> LN = applicable for wire feeding devices LINCOLN®

<sup>2)</sup> Control lead without plug for additional switch

<sup>3)</sup> Contains Pos. 102, 103, 104 and 105

<sup>4)</sup> Contains Pos. 102, 103.1, and 105

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#### **On request:**

- Other rear connectors
- Other geometries of swannecks
- Trigger wire plugs for additional switches
- Wire conducting tip for welding in narrow gaps:
  - M8 or 5/16"
  - Length: 90 mm and 180 mm
  - Entire length insulated



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