



# CATALOGUE

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23







# Introduction














RYWAL-RHC is a private enterprise established in 1992 and acting as a distributor, wholesaler and manufacturer of welding consumables, electric and gas welding equipment, abrasive materials, cutting machines, ventilation systems, technical chemistry, safety products and additional items used in the pre-, during- and after-welding process.

The head office and main store are located in Toruń in central Poland. Thanks to the good location and attractive offer we are an interesting partner for foreign customers. International business is one of the most important and perspective activities in our organization. We are looking for long term partnerships, which will bring our Customers and us satisfaction and good financial results.

The biggest advantages of our company are the complex offer, professional and qualified multilingual staff and well developed and organized logistics which guarantee short delivery time.

To meet the highest quality of service and complexity of the offer, we created MOST and GOLD product ranges, which helps our partners to find "unique brand" and reliable goods as the option to international well-known manufacturers. Our products are presented in traditional Catalogue. We believe that Paper Catalogue is perfect tool and guide through the whole welding and cutting assortment. Additionally, we assure you access to all necessary information published in electronic versions.

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# 01





# WELDING EQUIPMENT AND STUD WELDING MACHINES

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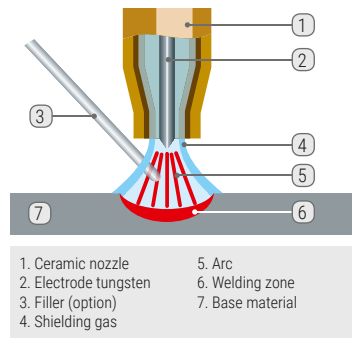
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# Introduction

Each method of arc welding has its own specificity resulting from the range of parameters, density and properties of the arc (chemical composition of the arc space, type of material of the electrodes, etc.) and the ways the metal passes through the arc. Thus, we would like to introduce you to some of the most popular welding methods and the devices selected for them in our new catalogue.

## TIG: Tungsten Inert Gas Welding

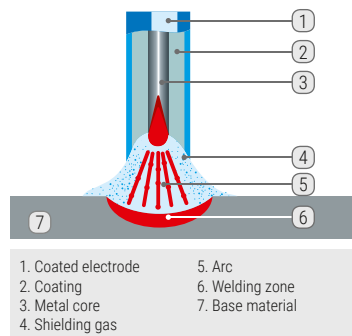
### Arc welding with tungsten electrode in inert gas shielding



Method 141 (TIG) is a method of arc welding in which heat is emitted during arc burning between the non-melting (tungsten) electrode and the welded material. The molten material forms a welding zone, which is protected against oxidation by shielding an inert gas such as argon and helium. Unlike the MIG method, the electrode is made of tungsten or its alloys, which have a very high melting point, which in turn prevents the non-melting electrode from forming a welded joint. If a filler metal is needed during welding, the filler metal is usually supplied by hand by the welder to the place to be welded - usually in the form of welding rods. There is also a way to automate filler wire feeding by means of cold wire feeders, which allow the material to be delivered to the welded area with a separate liner. TIG welding is dedicated to welding in all positions using DC current (non-alloy, alloyed steels) or AC current (aluminium).

## MMA: Manual Metal Arc Welding

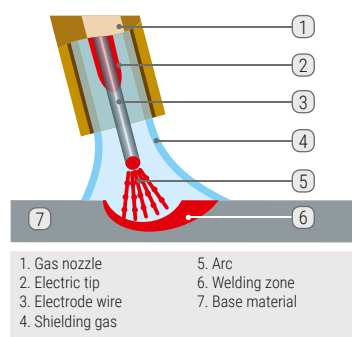
### SMAW: Shielded Metal Arc Welding



Shielded Metal Arc Welding (SMAW), method 111 (MMA), also known as Shielded Metal Arc Welding (SMAW), is a manual arc welding process, which is used to join metals by means of melting (coated) electrodes. The electric current is converted into heat and a welding arc is burned between the consumable electrode and the welded material to melt the electrode and the welded material and permanently connect them. The electrode, positioned at a proper angle to the joint, is moved manually by the welder. The welding arc can be powered by direct current (DC) with plus or minus polarity or alternating current (AC). The coating of the electrode is designed to produce a protective gas and slag during welding, which protects each drop of material passing into the welding zone from air, especially from the oxygen. Coated electrode welding is a welding method which dates back to 1885 and is still widely used around the world.

## MIG (Solid Wire Arc Welding inert gas shielding) and MAG (solid wire arc welding with active gas shielding)

### GMAW: Gas Metal Arc Welding - solid electrode wire arc welding



Welding method 131/135 (GMAW) in Poland is better known as MIG/MAG. The MIG method is an arc welding method in which the welded material and electrode wire are melted to form a so-called "welding zone", which is protected against oxidation with an inert shielding gas (usually argon). The MAG method, in contrast to the MIG method, uses active gases, usually argon- CO<sub>2</sub> mixtures, as shielding gas.

The welding wire is fed from the feeder through a system of rollers so that it is fed to the contact tip in the welding torch where the current is supplied. Welding of materials is usually carried out using direct current (DC) with plus polarity on the welding torch with a gas shielding. The gas forms plasma which transfers material from the electrode wire to the welding zone in the welding arc.

MIG/MAG welding can be semi-automatic, mechanized or automatic. These methods are currently used in the most industrial applications worldwide. Therefore, these methods are constantly being developed by the manufacturers of the devices that make up their variations. One of the best known varieties of the MIG/MAG method are TwinPulseXT, Pulse, SpeedPulseXT, SpeedUp, SpeedArc, SpeedRoot, SpeedCold.



**List of directives, standards and symbols used in the chapter "Welding equipment":****a/ Directives**

- Low Voltage Directive LVD 2014/35/EU.
- Electromagnetic Compatibility Directive EMC 2014/30/EU.
- Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment RoHS 2011/65/EU.
- Directive 2012/19/EU WEEE II (WEEE - Waste electrical and electronic equipment).

**Note:** Welding equipment is not subject to Machinery Directive 2006/42/EU!

**b/ Standards**

- EN 60974-1:2018 Arc welding equipment - Part 1: Welding power sources.
- EN 60974-10:2014 Arc welding equipment - Part 10: Electromagnetic compatibility (EMC) requirements.
- EN 60974-4: 2017 Arc welding equipment - Part 4: Periodic inspection and testing.
- EN ISO 13918: 2002 Welding - Studs and ceramic ferrules for arc stud welding.

**c/ Some symbols and terms**

**IP Rating (IP):** the degree of protection provided by the enclosure of the electrical device against access to hazardous internal parts or the penetration of solids (first digit of the code) and water (second digit of the code).

**Most common:**

- **IP21:** protection against access to hazardous parts with your finger, protection against foreign solids 12,5 mm in diameter and larger, and protection against falling water droplets. The device is for indoor use only.
- **IP23:** protection against access to hazardous parts with your finger, protection against foreign solids 12,5 mm in diameter and larger, and protection against water spraying at any angle up to 60° from the vertical on each side. The device is suitable for outdoor use.
- **IP34:** protection against access to hazardous parts with a tool, protection against foreign solid objects with a diameter of 2,5 mm and larger and protection against water splashes from any direction. The device is suitable for outdoor use.
- **S** (extension), e.g. IP21S: testing for harmful effects of water ingress when the moving parts of the device (e.g. rotor of the rotating machine) are stationary.

**Insulation class:** it is a letter designation of the insulation materials used, informing about the maximum operating temperature of the transformer, exceeding of which during continuous operation shortens the life and time of failure-free operation of the transformer.

**The most common are:**

- **F** - maximum permanently permissible temperature 155°C.
- **H** - maximum permanently permissible temperature 180°C.

**Welding current in the X (%)** duty cycle according to EN 60974-1: 2018 is measured at an ambient temperature of 40°C and for 10 minutes. For example, a welding current of 100 A at a 60% duty cycle means that the machine can weld continuously with 100 A for 6 minutes, followed by a 4-minute cooling period.

**d/ Mandatory device inspection**

According to the Labour Code provisions: "All responsibility for the safe use of machinery and equipment shall be borne by the owner". This results in the obligation to perform periodic and post-repair checks and inspections of equipment. Periodic tests are carried out at least once a year (legal basis EN ISO 17662 clause 4.2), and post-repair tests after each repair that restored welding functionality (legal basis: EN 60974-4 clause 4.6). All above services are performed by the technical support of **RYWAL-RHC**.

**ATTENTION:**

1. We reserve the right to change the technical parameters.
2. Posted product photos may show other versions.
3. Please contact our employees with any questions.
4. It is possible to order presentations of some devices from our offer.

## ▼ 1. MIG/MAG WELDING MACHINES



### FANMIG MOST 212 LCD - semi-automatic welding inverter machine

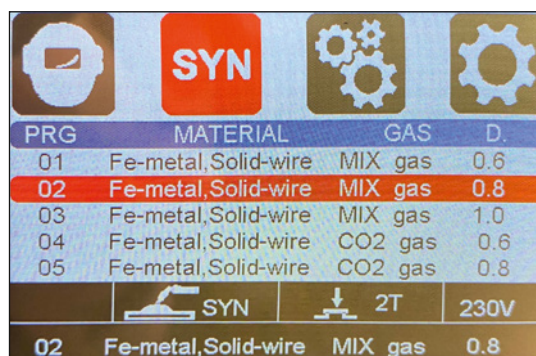


FANMIG 212 LCD is a modern semi-automatic welding inverter machine designed for MIG/MAG welding, TIG DC (scratch start) and MMA coated electrode welding. The device operates synergic or manual mode and includes a wide range of programmes for steel, stainless steel and aluminium. Programms for MIG brazing with CuSi3 0,8 mm and 1,0 mm wires are also available. FANMIG 212 LCD is a compact machine: power source and wire feeder are there in the same body. On the rear shelf there is a place for gas cylinder (max. 120 cms high). The device is powered from a single-phase 230 V. A PFC (Power Factor Correction) filter has been included in the device. The advantage of an inverter with PFC are: higher energetic effectiveness, lower load for electric network, greater tolerance to current fluctuations and less interference generated by the device. The 4-rolls wire feeder enables wire welding with 15 kg / K300 spools. Recommended steel wire diameters are 0,8 - 1,0 mm and 1,0 mm for aluminium. After change to the polarisation it is possible to apply self-shielding flux cored wire 0,8 or 0,9 mm.

#### Main applications:

- Light renovation works,
- Car body repairs,
- Crafting, production of light steel structures,
- Hobby.

Control panel equipped with display presents text messages. Parameter setting is executed with two knobs used both for choosing and confirming functions or values.



Model	FANMIG 212 LCD
<b>Electrical power supply</b>	1x230/ 50-60 V/ Hz
<b>Welding current range</b>	
▪ MIG/MAG	25-200 A
▪ TIG	10-200 A
▪ MMA	10-200 A
<b>Open circuit voltage (MMA) <math>U_0</math></b>	67 V
<b>Overload protection / Fuse</b>	16 C (slow)
<b>Current <math>I_{eff}</math></b>	16 A (MMA)
<b>Current <math>I_{1max}</math></b>	30,5 A
<b>Duty cycle X</b>	
▪ MIG/MAG	200 A/30%; 150 A/60%; 130 A/100%
▪ TIG	200 A/35%; 160 A/60%; 140 A/100%
▪ MMA	200 A/25%; 140 A/60%; 120 A/100%
<b>Wire feeding speed</b>	1,5-17,0 m/min
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 23S
<b>Rolls</b>	4 x 30/22
<b>Dimensions</b>	474 x 911 x 670 mm
<b>Weight</b>	44,5 kg
<b>Catalogue no.</b>	51 00 023700

The device is supplied with a ground cable and for coated electrode welding MMA, a gas hose and a manual booklet, standard rolls for 0,8-1,0 mm steel wire.

#### Additional welding torches and accessories (optional):

- Welding torch M24 SGRIP 3 m - 55 08 302430
- Welding torch M24 SGRIP 4 m - 55 08 302440
- Welding torch M24 SGRIP 5 m - 55 08 302450
- Welding torch M1 3 m - 55 08 305080
- Welding torch M1 4 m - 55 08 305081
- Welding torch M1 5 m - 55 08 305082
- Welding torch TIG 26 SGRIP 4 m - 56 01 082622
- Roll 0,8-1,0 30/22 - 51 13 007826
- Roll 0,6-0,8 30/22 - 51 13 007783

#### Accessories for aluminium welding and brazing (recommended wire diameter 1,0 mm):

- Roll 1,0AL-1,2AL - 51 13 007863
- Graphite-teflon liners for welding torch:  
55 13 013010 (3 m); 55 13 013020 (4 m); 55 13 013030 (5 m)
- Brass tube for EURO connection - 51 13 008011.





## FANMIG MOST 202 LCD - semi-automatic welding inverter machine

FANMIG 202 LCD is a modern semi-automatic welding inverter machine designed for MIG/MAG welding, TIG DC (scratch start) and MMA coated electrode welding. The device operates in synergic or manual mode and includes a wide range of programmes for steel, stainless steel and aluminium. A programme for MIG brazing with CuSi3 0,8 mm wire is also available.

The device is powered from a single-phase 230 V. A PFC (Power Factor Correction) filter has been included in the device. The advantage of an inverter with PFC are: higher energetic effectiveness, lower load for electric network, greater tolerance to current fluctuations and less interference generated by the device.

The wire feeder with 2-rolls enables wire welding with 5 kg / D200 spools.

Recommended steel wire diameters are 0,8 - 1,0 mm and 1,0 mm for aluminium. After change to the polarisation it is possible to apply self-shielding flux cored wire.

### Main applications:

- Light renovation works,
- Car body repairs,
- Crafting, production of light steel structures,
- Hobby.

Control panel equipped with display presents text messages. Parameter setting is executed with two knobs used both for choosing and confirming functions or values. The panel is secured against damage with transparent glass.

PRG	MATERIAL	GAS	D.
01	Fe-metal, Solid-wire	MIX gas	0.6
02	Fe-metal, Solid-wire	MIX gas	0.8
03	Fe-metal, Solid-wire	MIX gas	1.0
04	Fe-metal, Solid-wire	CO2 gas	0.6
05	Fe-metal, Solid-wire	CO2 gas	0.8

02	Fe-metal, Solid-wire	MIX gas	0.8
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The device is supplied with a ground cable and for coated electrode welding MMA, a gas hose and a manual booklet, standard rolls for 0,8-1,0 mm steel wire.

### Additional welding torches and accessories (optional):

- Welding torch M24 SGRIP 3 m - 55 08 302430
- Welding torch M24 SGRIP 4 m - 55 08 302440
- Welding torch M24 SGRIP 5 m - 55 08 302450
- Welding torch M1 3 m - 55 08 305080
- Welding torch M1 4 m - 55 08 305081
- Welding torch M1 5 m - 55 08 305082
- Welding torch TIG 26 SGRIP 4 m - 56 01 082622
- Roll 0,8-1,0 30/22 - 51 13 007826
- Roll 0,6-0,8 30/22 - 51 13 007783

### Accessories for aluminium welding and brazing (recommended wire diameter 1,0 mm):

- Roll 1,0AL-1,2AL - 51 13 007863
- Graphite-teflon liners for welding torch:
  - 55 13 013010 (3 m);
  - 55 13 013020 (4 m);
  - 55 13 013030 (5 m);
- Brass tube for EURO connection - 51 13 008011.

MIG/MAG welding of steel, stainless steel, aluminium or brazing do not require big investments!

**NEW**  
in offer



Model	FANMIG 202 LCD
<b>Electrical power supply</b>	1x230/ 50-60 V/ Hz
<b>Welding current range</b>	
■ MIG/MAG	20-200 A
■ TIG	10-200 A
■ MMA	10-200 A
<b>Open circuit voltage (MMA) <math>U_0</math></b>	67 V
<b>Overload protection / Fuse</b>	16 C (slow)
<b>Current <math>I_{eff}</math></b>	15,7 A
<b>Current <math>I_{Tmax}</math></b>	30,5 A
<b>Duty cycle X</b>	
■ MIG/MAG	200 A/30%; 150 A/60%; 130 A/100%
■ TIG	200 A/35%; 150 A/60%; 140 A/100%
■ MMA	200 A/25%; 140 A/60%; 120 A/100%
<b>Wire feeding speed</b>	1,5-17,0 m/min
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 23S
<b>Rolls</b>	2 x 30/22
<b>Dimensions</b>	215x540x410 mm
<b>Weight</b>	17,7 kg
<b>Catalogue No.</b>	51 00 023690



## FANMIG MOST J5 / J5 PULSE - semi-automatic pulse welding inverter machines

*Combination of simplicity of settings  
and high arc quality.*



FANMIG J5

HIT

FANMIG J5 PULSE

Model	FANMIG J5	FANMIG J5 PULSE
<b>Power and tolerance</b>	1x230/ 50-60 V/ Hz ±15%	
<b>Welding current range</b>		
▪ MIG/MAG	30-200 A	20-200 A
▪ MMA	10-160 A	20-180 A
▪ TIG	10-180	-
<b>Open circuit voltage (MMA) U<sub>0</sub></b>	60 V	69 V
<b>Overload protection / Fuse</b>	16 A (slow blow)	16 A (slow blow)
<b>Nominal power consumption S1 (X 100%)</b>		
▪ MIG/MAG	3,9 kVA	7,5 kVA (MIG/MAG Pulse)
▪ MMA	6,8 kVA	8,0 kVA
<b>Duty cycle X</b>		
▪ MIG/MAG	200 A/24 V/20% 90 A/18,5 V/100%	200 A/24 V/20% 89 A/18 V/100%
▪ MMA	160 A/26,4 V/20% 71,5 A/22,8 V/100%	180 A/27,2 V/20% 80 A/23,2 V/100%
<b>Wire feeding speed</b>	2-11,5 m/min	1-15 m/min
<b>IP Rating</b>	IP 21S	IP 21S
<b>Dimensions</b>	440x180x350 mm	490x210x410 mm
<b>Weight</b>	9,2 kg	13,3 kg
<b>Catalogue No.</b>	51 00 020190	51 00 020195

FANMIG J5 MOST is a modern semi-automatic inverter for MIG/MAG welding. The device is designed for steel and stainless steel welding in shielding gas environment.

FANMIG J5 Pulse offers synergic programs for pulse or double-pulse welding of different materials.

Both FANMIGs can be perfectly used in crafts, car body works, repairs or in hobby works etc.

### Advantages of FANMIG J5 MOST

- Higher welding current than in similar, traditional semi-automatic machines powered from 230 V mains supply.
- Very good welding properties in both MAG and MMA methods, synergic programs for welding 0,8 mm and 1,0 mm steel.
- Capable of TIG DC welding with arc ignited by scratching.
- Display for welding current data and parameter adjustments.
- Euro socket suitable for any MIG/MAG torches.
- Typical ground socket (35/50).
- Low mass due to the inverter power source.
- Silent cooling fan.

### Additionally for FANMIG J5 PULSE:

- Synergic MIG/MAG, pulse and double-pulse, MMA.
- Possibility of welding aluminium or brazing with special welding torch M24 AL SGRIP 2 m.
- Many auxiliary functions.
- Standby mode.

**FANMIG J5 and J5 PULSE:** The 2-roll wire feeder enables welding with 5 kg/D200 and 1 kg spools.

### Device assembly:

The device is supplied in a cardboard box with earth cable, a gas hose and user's manual.

Wire feeder is equipped with standard 0,8-1,0 mm rolls for steel wire (51 13 007833).

### Additional welding torches and accessories:

- Welding torch M15 SGRIP 3 m - 55 08 301530
- Welding torch M15 SGRIP 4 m - 55 08 301540
- Welding torch M15 SGRIP 5 m - 55 08 301550
- Welding torch TIG 26 V MOST 4 m - 56 01 062634 (FANMIG J5 only)
- Welding torch M24 ALSGRIP for aluminium 2 m - 55 08 302420 (FANMIG J5 PULSE only)
- Roll 0,8-1,0 - 51 13 007833 (supplied)
- Roll 0,6-0,8 - 51 13 007801 (optional)
- Roll 1,0-1,2 AL - 51 13 007829 (optional for FANMIG J5 PULSE)
- WUS HD welding cart -50 03 003942
- MOST welding pliers - 57 00 004707



## FANMIG MOST J23 - semi-automatic welding inverter machine

FANMIG MOST J23 is a modern semi-automatic welding inverter machine designed for MIG/MAG welding. The device is designed for steel and stainless steel welding with shielding gas for crafting, car body shops and DIY applications.

### Advantages of FANMIG J23:

- Higher welding current than in similar, traditional semi-automatic machines powered from 230 V mains supply.
- Very good welding properties. Setting the welding current potentiometer and the wire feed speed potentiometer in the same position guarantees a stable, quiet welding arc with minimal spatter.
- A solid trolley adapted to transport a small cylinder (gas cylinder max. 20 cm in diameter and height up to 120 cm), front swivel wheels with brake.
- Possibility of welding with 15 kg or 5 kg spools.
- Welding current display.
- Metal components of wire feed mechanism with typical roll size 22/30.
- Euro socket suitable for any MIG/MAG torches.
- Durable housing, powder-coated covers.
- Small weight - only 24 kg.
- Silent cooling fan.
- Proven brand MOST.

### Device assembly:

The device is supplied in a cardboard box with earth cable, a gas hose, an adapter for 5 kg spool and user's manual. Wire feeder is equipped with standard 0,8-1,0 mm rolls for steel wire (51 13 007826).

### Additional welding torches and accessories:

- Welding torch M15 SGRIP 3 m - 55 08 301530
- Welding torch M15 SGRIP 4 m - 55 08 301540
- Welding torch M15 SGRIP 5 m - 55 08 301550
- Welding torch M1 3 m - 55 08 305080
- Welding torch M1 4 m - 55 08 305081
- Welding torch M1 5 m - 55 08 305082
- Roll 0,6-0,8 mm - 51 13 007783



Scan the link or go to  
<https://www.rywal.eu/f01-4>

*Traditional housing - a modern interior!*



Model	FANMIG J23
<b>Power and tolerance</b>	1x230/ 50-60 V/ Hz ±15%
<b>Welding current range</b> ■ MIG/MAG	30-180 A
<b>Open circuit voltage <math>U_0</math></b>	52 V
<b>Overload protection / Fuse</b>	16 A (slow blow)
<b>Nominal power consumption</b>	7 kVA
<b>Current <math>I_{eff}</math></b>	16 A
<b>Current <math>I_{1max}</math></b>	35 A
<b>Duty cycle X</b> ■ MIG/MAG	180 A/23 V/20% 103 A/19,2 V/60% 80 A/18 V/100%
<b>Wire feeding speed</b>	1,5-14 m/min
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 21S
<b>Roll</b>	30/22 (Cooptim type)
<b>Dimensions</b>	890x453x668 mm
<b>Weight</b>	24 kg
<b>Catalogue No.</b>	51 00 020188*

\* Self assembly kit



## FANMIG MOST 2500i / 3200i / 3200i mobil semi-automatic welding inverter

*Inverter = low weight  
with lowered power consumption!*



Scan the link or go to  
<https://www.rywal.eu/f01-1>



### Advantages of i-FANMIG devices:

- Compact size.
- 4 rolls wire feeders.
- 15 kg or 5 kg spools available.
- MIG/MAG or MMA welding method.
- Synergy: 12 programs for steel, aluminium and stainless steel.
- Multifunction knob.
- Memory for six own programs.
- Welding current display.

HIT

Model	FANMIG 2500i	FANMIG 3200i	FANMIG 3200i mobil
<b>Electrical power supply</b>	3x400 V / 50-60 Hz	3x400 V / 50-60 Hz	3x400 V / 50-60 Hz
<b>Welding current range</b>			
▪ MIG/MAG	20-250 A	20-315 A	20-315 A
▪ MMA	30-250 A	30-300 A	30-300 A
<b>Open circuit voltage <math>U_0</math></b>	54,4 V	63,1 V	63,1 V
<b>Overload protection / Fuse</b>	16 A	16 A	16 A
<b>Duty cycle X</b>			
▪ MIG/MAG	250 A / 60% 210 A / 100%	315 A / 25% 250 A / 60% 210 A / 100%	315 A / 25% 250 A / 60% 210 A / 100%
▪ MMA	250 A / 50% 230 A / 60% 190 A / 100%	300 A / 20% 230 A / 60% 190 A / 100%	300 A / 20% 230 A / 60% 190 A / 100%
<b>Welding current setting</b>	Stepless	Stepless	Stepless
<b>Wire feeding speed</b>	1-17 m/min	1-17 m/min	1-15 m/min
<b>Welding torch cooling</b>	Gas	Gas	Gas
<b>Welding Torch (gas)</b>	M24 or M25 MOST	M24, M25 or M36 MOST	M24, M25 or M36 MOST
<b>Insulation class</b>	H	H	H
<b>IP Rating</b>	IP 23S	IP 23S	IP 23S
<b>Dimensions</b>	868x500x806 mm	868x500x806 mm	240x650x438 mm
<b>Weight</b>	47,6 kg	47,6 kg	26,6 kg
<b>Catalogue No.</b>	51 00 023705	51 00 023715	51 00 023720

### Device assembly:

Device is delivered in cardboard box with power plug included (CEE 16 A). Equipment with earth cable and gas hose, user's manual as well as a front panel bow guard for self-assembly. The wire feeder has rolls for 0,8-1,0 mm steel wire welding.





## FANMIG MOST 340i - semi-automatic welding inverter machine

The FANMIG 340i is a modern inverter semi-automatic welding machine for MIG/MAG or coated electrode MMA welding. FANMIG 340i is a natural successor to older compact semi-automatic machines with step control of welding current ("transformer"), such as FANMIG 320-4 MOST.

The device is used for welding steel, stainless steel or aluminum after adaptation of feeder and welding torch. The welding parameters (voltage and wire feed speed) are set in a stepless manner. The FANMIG 340i is a compact device, i.e. the power source and feeder are in one housing. The device is powered by a three-phase power supply of 3x400 V.

The 4-roll wire feeder allows welding with wire from 15 kg / K300 spools. Recommended diameters of steel wires are 0,8 mm; 1,0 mm or 1,2 mm, for aluminum 1,0 mm. After changing the polarity, you can also use flux self-shielding wires  $\varnothing$ 0,8-0,9 mm.



### Basic application:

- repair work,
- auto body repairs,
- craftsmanship, making light steel constructions,
- stationary welding.

The control panel is equipped with two displays of welding parameters. Parameter setting is done using two knobs, the arc can be adjusted by inductance. Switches are used to select the welding method MIG / MMA or the operation mode of the welding torch button 2T/4T.



HIT

Model	FANMIG 340i
Electrical power supply	3x400 V/ 50-60 V/ Hz
Welding current range	50-350 A
■ MIG/MAG	20-350 A
■ MMA	
Open circuit voltage $U_0$	61,5 V
Overload protection / Fuse	25 A
Current $I_{eff}$	14,5 A (MMA)
Current $I_{imax}$	23 A
Duty cycle X	350 A / 50%
■ MIG/MAG and MMA	285 A / 60%
	221 A / 100%
Wire feed speed	1 - 18 m/min
Insulation class	F
IP Rating	IP 21S
Roll	4 x 30/22
Dimensions	900 x 450 x 755 mm
Weight	52 kg
Catalogue No.	51 00 023730

### Completion:

The unit comes with a ground cable, gas hose and instruction manual, standard rollers for 1,0-1,2 mm steel wire.

### Optional welding torches and accessories:

- Welding torch M22 SGRIP 3 m - 55 08 305090
- Welding torch M22 SGRIP 4 m - 55 08 305091
- Welding torch M22 SGRIP 5 m - 55 08 305092
- Welding torch M22M (rotary swan neck) 3 m - 55 08 305095
- Welding torch M22M (rotary swan neck) 4 m - 55 08 305096
- Welding torch M22M (rotary swan neck) 5 m - 55 08 305097
- Welding torch M36 SGRIP 3 m - 55 08 303630
- Welding torch M36 SGRIP 4 m - 55 08 303640
- Welding torch M36 SGRIP 5 m - 55 08 303650
- Roll 0,8-1,0 30/22 - 51 13 007826
- Roll 0,6-0,8 30/22 - 51 13 007783

### Optional accessories for aluminium welding and brazing (Recommended wire diameter 1,0 mm, AlMg5 type):

- Roll 1,0AL-1,2AL - 51 13 007863 (x2)
- Teflon liner for welding torch:  
55 13 013010 (3 m); 55 13 013020 (4 m); 55 13 013030 (5 m)
- Brass tube for euro-socket - 51 13 008011.



## FANMIG MOST 322 Pulse semi-automatic inverter welding

"Pulse - the easiest way to avoid spatters".

**NEW**  
in offer



FANMIG 322 mobil Pulse

FANMIG 322 Pulse

FANMIG 322W Pulse

A FANMIG 322 Pulse family is a modern semi-automatic welding inverter machine designed for MIG/MAG welding and MMA coated electrode welding: consisting of FANMIG 322 Pulse, FANMIG 322W Pulse and FANMIG 322 mobil Pulse. Apart from the short arc welding, it enables users to weld with MIG/MAG pulse current. All FANMIG 322 Pulse are compact devices: the power source and wire feeder are placed inside one housing. Thanks to its simplicity in use it is recommended as a first semi-automatic "MIG pulse" welding device in your workshop.

### Properties:

- The device is operated synergistically and includes a wide range of programmes for steel, stainless steel and aluminium pulse and short welding current.
- All FANMIG 322 Pulse are also equipped with a program for brazing of galvanized sheets.
- The 4-roll feeder enables welding with 15 or 5 kg spools, the recommended diameter of steel wires is 0,8 mm and 1,0 mm, for aluminium 1,0 mm.
- Includes LED lighting inside the wire feeder chamber.
- FANMIG 322 Pulse - compact with welding torch gas cooling.
- FANMIG 322W Pulse - compact with welding torch water cooling.
- FANMIG 322 mobil Pulse - size reduced to the size of a large wire feeder.

### Main advantages of MIG/MAG pulse:

- Non or minimal spatters.
- Smooth face of the seam and seam high aesthetics.
- Essential for welding stainless steel and aluminium.
- Crater filling feature.

### Control panel:

- two multifunction knobs,
- displays show parameter and actual values during welding,
- LEDs indicate the parameter units on the display,
- memory for 6 custom programs.



HIT

Model	FANMIG 322 Pulse	FANMIG 322 mobil Pulse	FANMIG 322W Pulse
<b>Electrical power supply</b>	3x400 / 50-60 V/ Hz	3x400 / 50-60 V/ Hz	3x400 / 50-60 V/ Hz
<b>Welding current range</b>			
▪ MIG/MAG	20 A / 15,0 V 315 A / 29,8 V	20 A / 15,0 V 315 A / 29,8 V	20 A / 15,0 V 10 A / 20,4 V
▪ MMA	10 A / 20,4 V 300 A / 32,0 V	10 A / 20,4 V 300 A / 32,0 V	300 A / 32,0 V 315 A / 29,8 V
<b>Open circuit voltage U<sub>0</sub></b>	63 V	63 V	63 V
<b>Overload protection / Fuse</b>	16 A slow blow	16 A slow blow	16 A slow blow
<b>Duty cycle X</b>			
▪ MIG/MAG	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%	315 A / 29,8 V / 25% 250 A / 26,5 V / 60% 210 A / 24,5 V / 100%
▪ MMA	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%	300 A / 32,0 V / 20% 230 A / 29,2 V / 60% 190 A / 27,6 V / 100%
<b>Welding current setting</b>	Stepless	Stepless	Stepless
<b>Wire feeder</b>	4-roll	4-roll	4-roll
<b>Wire feeding speed</b>	1-20 m/min	1-16 m/min	1-20 m/min
<b>Welding torch cooling</b>	Gas	Gas	Liquid or gas
<b>Cooling power Q=1 l/min</b>	-	-	0,74 kW
<b>Tank capacity</b>	-	-	4 l
<b>Maximum pressure</b>	-	-	3,5 bar
<b>Maximum flow</b>	-	-	8 l/min
<b>Insulation class</b>	H	H	H
<b>IP Rating</b>	IP 23S	IP 23S	IP 23S
<b>Dimensions</b>	670x911x474 mm	438x650x240 mm	884x902x474 mm
<b>Weight</b>	47,6 kg	26,6 kg	72,5 kg
<b>Catalogue No.</b>	51 00 023910	51 00 023930	51 00 023920

**Device assembly:**

Device is delivered in cardboard box with power plug included (CEE 16 A). The equipment includes a ground cable, gas hose and user's manual. The wire feeder has rolls for 0,8-1,0 mm steel wire welding. The cooler is filled with coolant (FANMIG 322W Pulse).

Additional welding torches and accessories	FANMIG 322 Pulse	FANMIG 322 mobil Pulse	FANMIG 322W Pulse
	Catalogue No.	Catalogue No.	Catalogue No.
<b>M22 SGRIP Welding Torch</b>	3 m - 55 08 305090 4 m - 55 08 305091 5 m - 55 08 305092	3 m - 55 08 305090 4 m - 55 08 305091 5 m - 55 08 305092	-
<b>M38 SGRIP Welding Torch</b>	3 m - 55 08 303830 4 m - 55 08 303840 5 m - 55 08 303850	3 m - 55 08 303830 4 m - 55 08 303840 5 m - 55 08 303850	-
<b>M240 SGRIP Welding Torch (liquid cooled)</b>	-	-	3 m - 55 08 304243 4 m - 55 08 304244 5 m - 55 08 304245
<b>Welding torch Digimig 355 (LCD operated)</b>	3 m - 55 08 308003 4 m - 55 08 308004 5 m - 55 08 308005	3 m - 55 08 308003 4 m - 55 08 308004 5 m - 55 08 308005	-
<b>Welding torch Digimig 240W UD (LCD operated, fluid cooled)</b>	-	-	3 m - 55 08 308020 4 m - 55 08 308021 5 m - 55 08 308022
<b>0,6-0,8 Roll</b>	51 13 007793	-	51 13 007793
<b>0,8-1,0 Roll</b>	51 13 007808	51 13 007843	51 13 007808
<b>1,0-1,2 Roll</b>	51 13 007865	51 13 007893	51 13 007865
<b>0,8AL-1,0AL Roll</b>	51 13 007809	51 13 007844	51 13 007809
<b>1,0AL-1,2AL Roll</b>	51 13 007885	51 13 007894	51 13 007885

**Attention:**

While welding with pulse current welding torch heating increases (by approx. 30%). Please apply welding work cycles provided by manufacturer of welding torch. Solution to this issue is a purchase of FANMIG 322W Pulse or for other FANMIG 322, application of cooling for welding torch liquid eg. by connecting Fancool 601-WA as additional cooling unit (cat. no.: 50 03 003805).



## FANMIG MOST 5 semi-automatic inverter welding machines



Scan the link or go to  
<https://www.rywal.eu/f01-13>



FANMIG 5 WP

FANMIG 5 WK

FANMIG 5 GK

FANMIG 5 GP

The family of FANMIG 5 are new inverter semi-automatic MIG/MAG welding machines for industrial use.

### Four available models:

- FANMIG 5 WP/5 m - 500 A power source with a separate feeder (5 m intermediate cable) and a welding torch with liquid cooling.
- FANMIG 5 GP/5 m - 500 A power source with a separate feeder (5 m intermediate cable), welding torch gas cooling.
- FANMIG 5 WK - compact 500 A power source with welding torch liquid cooler.
- FANMIG 5 GK - compact 500 A power source, gas cooled welding torch.

### Basic advantages of FANMIG 5:

- MIG / MAG welding with synergic or manual settings and MMA electrode.
- High welding current of 500 A / duty cycle 60% and 420 A / 100% (MMA 400 A / 100%).
- Synergic programs for welding steel and stainless steel, aluminium or other wire diameters in manual mode.
- Easy-to-use control panel, the same for all models.
- Robust wire feed system, four rolls type 37/19, feed speed 1-25 (compact 26) m/min.
- Memory up to 99 programs.

The devices are delivered with a ground cable and a gas hose, rolls 1,0-1,2 mm. Standard length of intermediate cables 5 m, optionally 1,2 m, 10 m or 15 m. Welding torches – option. For high-performance MAG welding it is recommended to use M6W MOST liquid-cooled torch.

FANMIG 5 devices meet the requirements of the Ecodesign Directive 2009/125 (EU) and Regulation 2019/1784 (EU).

### Catalogue no.

51 00 023970 - FANMIG 5 WP / 5 m  
51 00 023960 - FANMIG 5 GP / 5 m  
51 00 023955 - FANMIG 5 WK  
51 00 023951 - FANMIG 5 GK

Model	FANMIG 5	
Welding method	MIG/MAG	MMA
Electrical power supply	3x400 V / 50/60 Hz	
Welding current range	40 A / 16,0 V 500 A / 39,0 V	10 A / 20,4 V 400 A / 36,0 V
Welding current at:	400 A / 36,0 V	
■ 100% duty cycle	420 A / 35,0 V	
■ 60% duty cycle	500 A / 39,0 V	
Welding current regulation	Stepless	
Wire feeding speed	1 - 25 (compact 26) m/min	-
Welding torch cooling	Liquid or gas	
Power source efficiency	90%	
Open circuit	20 W	
IP rating	IP23S	

Dimensions and weights of individual models are available in the operational manual.





## FANMIG MOST 5 PULSE WP / WK semi-automatic inverter welding machines

FANMIGs 5 PULSE are new inverter MIG/MAG semi-automatic welding machines for industrial work.

### Two models are available:

- FANMIG 5 PULSE WP/5 m - 500 A power source with separate feeder (5 m intermediate cable) and liquid-cooled welding torch.
- FANMIG 5 PULSE WK - compact 500 A current source with liquid-cooled welding chuck.

### The main advantages of FANMIG 5 PULSE equipment:

- Possibility of pulse, double pulse or short-circuit arc welding in MIG/MAG method.
- MIG/MAG welding with synergic or manual settings, electro gouging and MMA electrode welding.
- High welding current of 500 A/60% and 420 A/100% (MMA 400 A/100%).
- Synergic programs for welding steel, stainless steel or aluminium.
- Easy-to-use control panel the same for both models.
- Powerful wire feeding system, 37/19 type rolls, wire feeding speed 1-20 m/min.
- Memory for up to 99 programs.

Model	FANMIG 5 PULSE	
Welding method	MIG/MAG	MMA
Electrical power supply	3x400 V / 50/60 Hz	
Welding current range	20 A / 15,0 V 500 A / 39,0 V	10 A / 20,4 V 500 A / 40,0 V
Welding current at:		
▪ 100% duty cycle	420 A / 35,0 V	400 A / 36,0 V
▪ 60% duty cycle	500 A / 39,0 V	450 A / 38,0 V
▪ 55% duty cycle		500 A / 40,0 V
Welding current set point	Infinitely	
Wire feeding speed	1 - 20 m/min	-
Welding torch cooling	Liquid	
Power source efficiency	88%	
Open circuit power consumption in idle state	25 W	
IP rating	IP23S	

Dimensions and weights of individual models are available in the operational manual.

Units supplied with mass cable and gas hose, rolls 1,0-1,2 mm.  
Standard intermediate cable lengths 5 m, as an option 1,2 m; 10 m or 15 m.  
Welding torches - optional. For high efficient MAG welding, we recommend liquid-cooled welding torch M6W MOST (steel) or M6OSW (aluminium).  
Double pulse (DP) welding programs available as an option (TOKEN).

FANMIG 5 PULSE devices meet the requirements of the Ecodesign Directive 2009/125/U and Regulation 2019/1784 (EU).

**NEW**  
in offer



FANMIG 5 PULSE WP

FANMIG 5 PULSE WK

FANMIG 5 WP PULSE control panel



### Catalogue no.

51 00 023985 - FANMIG 5 PULSE WP / 5 m

51 00 023980 - FANMIG 5 PULSE WK



## FANCOOL 601-WA MOST universal cooling unit for welding torches

The FANCOOL 601-WA MOST cooling unit is used to cool MIG / MAG and TIG welding torches. In many welding devices, the lack of liquid cooling of the welding torch is a serious limitation in operation. After connecting the cooler, we can use liquid-cooled welding torches and this significantly increases the efficiency of the welding machine.

For transport reasons the FANCOOL cooler is not filled with liquid at the factory. We recommend MOST COOL 30 fluid.

Model	FANCOOL 601-WA MOST
Tank	max 3,0 l (factory empty)
Cooling power (Q=1 l/min)	0,55 kW
Maximum pressure	p= 0,35 MPa (3,5 bar)
Maximum flow	Q= 8 l/min
Electrical power supply	230 V/ 50/60 Hz
Power consumption I <sub>a</sub>	1,3 A
IP Rating	IP 23S
Weight	16,6 kg
Dimensions	244x525x290 mm
Standard	EN 60974-2
Current recognized in automatic mode	60 A (if welding is done at a lower current, switch to manual mode)
Catalogue No.	50 03 003805



To configure the welding machine and cooling unit, please contact our service center. Send an inquiry to [serwis@rywal.com.pl](mailto:serwis@rywal.com.pl)

## Cooling liquid for welding and plasma torches MOST COOL 30

High-quality coolant for all liquid-cooled welding and cutting torches.

- Frost resistant up to -30°C, non-conductive, colourless.
- Protects the torch, welding cables, coolers for welding and cutting equipment against electrolytic corrosion.
- Does not aggressively affect rubber components, including seals.

Package:

5 L - Catalogue No.: 84 23 903105

Attention:  
Welding work at temperatures below 5°C requires special approvals.



## MIG/MAG torches

Welding torches for MIG / MAG devices and spare parts - page 41

GAS COOLED TORCHES							
Model	Rating (A)		Duty cycle	Wire diameter	Length / Catalogue No.		
	CO <sub>2</sub>	M21			3 m	4 m	5 m
M15 SGRIP	180 A	150 A	60%	0,6-1,0 mm	55 08 301530	55 08 301540	55 08 301550
M24 SGRIP	250 A	220 A	60%	0,8-1,2 mm	55 08 302430	55 08 302440	55 08 302450
M25 SGRIP	230 A	220 A	60%	0,8-1,2 mm	55 08 302530	55 08 302540	55 08 302550
M36 SGRIP	300 A	270 A	60%	0,8-1,2 mm	55 08 303630	55 08 303640	55 08 303650
M38 SGRIP	350 A	320 A	60%	1,0-1,6 mm	55 08 303830	55 08 303840	55 08 303850
LIQUID COOLED TORCHES							
M240 SGRIP	300 A	270 A	100%	0,8-1,2 mm	55 08 304243	55 08 304244	55 08 304245
M401 SGRIP	400 A	350 A	100%	0,8-1,2 mm	55 08 304013	55 08 304014	55 08 304015
M501 SGRIP	500 A	450 A	100%	0,8-1,6 mm	55 08 305013	55 08 305014	55 08 305015
MIG M6W*	580 A	530 A	100%	0,8-2,0 mm	55 08 305113	55 08 305114	55 08 305115
MIG M6OSW**	580 A	530 A	100%	0,8-2,0 mm	55 08 305123	55 08 305124	-

\*dedicated to devices with Pulse / \*\* dedicated to welding Al / Al Pulse

**Rolls for wire feeders**

		Ø30/32	Ø30/14	Ø37/10	Ø37/19	Ø40/32
Typ						
Size	External diam. Internal diam. Width	30 mm 22 mm 10 mm	30 mm 14 mm 12 mm	37 mm 10 mm 15 (17) mm	37 mm 19 mm 12 mm	40 mm 32 mm 10 mm
Wire diameter [mm]	0,6 - 0,8	51 13 007783	51 13 007796	51 13 007797	51 13 007793	-
	0,8 Al	-	51 13 007805	-	-	-
	0,8 - 1,0	51 13 007826	51 13 007810	51 13 007802	51 13 007808	51 13 007819
	0,8 - 1,0 Al	51 13 007828	51 13 007813	51 13 007803	51 13 007809	51 13 007830
	1,0 Al	-	51 13 007811	-	-	-
	1,0 - 1,2	51 13 007862	51 13 007860	51 13 007883	51 13 007865	51 13 007880
	1,0 - 1,2 Al	51 13 007863	51 13 007861	51 13 007884	51 13 007885	51 13 007879
	1,0/1,2 R	-	51 13 007891	-	51 13 007856	-
	1,0 - 1,2 R	51 13 007895	-	-	-	51 13 007866
	1,2	-	51 13 007905	-	-	-
	1,2 Al	-	51 13 007925	-	51 13 007928	-
	1,2 - 1,4 R	51 13 007899	-	-	-	-
	1,2 - 1,6	51 13 007956	51 13 007930	-	51 13 007931	51 13 007971
	1,2 - 1,6 Al	51 13 007960	51 13 007934	-	51 13 007935	51 13 007960
	1,2-1,6 R	-	-	51 30 208966	51 13 007937	-
	1,2/1,4/1,6 R	-	51 13 007918	-	-	-
	1,6 Al	-	-	-	-	-
1,6 - 2,0	-	-	-	-	51 13 007999	
1,6 - 2,0 R	-	-	-	-	51 13 007997	
2,4 - 3,2 R	-	-	-	-	51 13 007991	
Application	MOST	FANMIG 2500i / 3200i / 400 / 600 / compact FANMIG 280/320/400/340i / J23 / 200-2 basic / 201 LCD / 202 LCD / 212 LCD	FANMIG I: 190 / 270 C2/C4 / 350 C4 / 350LWF / 450WWF	FANMIG II: 230 C-2 / 271 C-2	FANMIG II: 271 C-4 / 351 C-4 / 351LWF; FANMIG 451WWF / 322(W) Pulse; FANMIG 5 (4 models) and FANMIG 5 PULSE (2 models)	FANMIG 404 / 504 / 604 / 500i / 502i / 522 Pulse
	LINCOLN ELECTRIC BESTER	some Magster: 250 4x4 / 250T / 315T (Cooptim CWF 4010)	some Magster: 250 4x4 / 250T / 315 4x4 315T / 350C / 350W / 450C / 500 (Fortrans type)		Powertec: 1 roll: 200C / 250C / 300C; feeder LF 22; 2 rolls: 300C / 280Pro / 350Pro / 420Pro / PT 300 / 360 / 420 / 500 with separate feeder LF 24, 33	some Magster 350C, 450C, 500W; all Magster 351W / 400 Plus/W / 500PlusW / 501W (Cooptim CWF 5110 Type)
	LORCH		Saprom / C-dialog / P / Feed 1 and Feed 2	M-Pro / MicorMIG (up to 2018)* / TF-Pro 300		
	OZAS ESAB		Minimag 164 / 240 / 320 feeders ZP-10 / 11 / 12 / 15; feeders ZP-20 (older types) Minimag 281; feeders: LKB-260 / 320 / 400; feeders: MEK2/4 Origomig C340 / Feed 30 older types		Minimag-241 / 341 / Magomig with feeders ZP-22 / 30; feeder ZP-30 / 20 / OrigoMig / OrigoFeed 30	

Other roll sizes available on request.

**Types of rolls:**

- V-groove for steel wires (hard).
- Knurled groove for flux cored wires.
- U-groove for aluminium wires (soft).



Rolls dedicated to FANMIG devices		
	0,6-0,8 mm	51 13 007801
	0,8-1,0 mm	51 13 007833
	1,0-1,2 mm	51 13 007829
	0,6-0,8 mm	51 13 007776
	0,8-1,0 mm	51 13 007843
	0,8-1,0 mm Al	51 13 007844
	1,0-1,2 mm	51 13 007893
	1,0-1,2 mm Al	51 13 007894

## ▼ 2. TIG WELDING MACHINES



### MOST PONTIG 210 DC inverter device

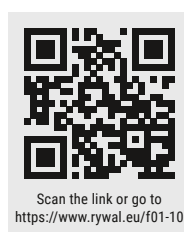
**NEW**  
in offer



PONTIG 210 DC MOST is a modern inverter rectifier for TIG DC welding of steel and stainless steel or MMA coated electrode welding. The device is powered by a 1x230 V power supply.

Main applications for this device include light and medium-intensive welding in:

- Food industry and stainless steel installation welding.
- Chemical industry and pipelines.
- Crafting, manufacturing items of lightweight steel or stainless steel.
- Yacht construction (rigging welding), etc.



Model	PONTIG 210 DC
<b>Power and tolerance</b>	1x230 V, 50-60 Hz ±15%
<b>Welding current range</b>	
▪ TIG	10-200 A
▪ MMA	10-180 A
<b>TIG / MMA welding current:</b>	
▪ In X 35% duty cycle	200 / 180 A
▪ In X 60% duty cycle	153 / 137 A
▪ In X 100% duty cycle	118 / 106 A
<b>Welding current regulation</b>	Stepless
<b>MMA electrode diameter</b>	2,0-4,0 mm
<b>Sockets for connection of welding cables</b>	35/50 (large)
<b>Overload protection / Fuse</b>	16 A delayed
<b>Dimensions</b>	432x167x312 mm
<b>Weight</b>	8,2 kg
<b>Standard</b>	EN60974-1
<b>IP Rating</b>	IP21S
<b>Insulation class</b>	F
<b>Catalogue No.</b>	52 00 005423

#### Control panel:

- User friendly to use control panel,
- The display shows the welding current and the functions being set,
- TIG DC constant or pulse current,
- Possess all the functions necessary for professional TIG welding.

**Device assembly:** Each device is supplied with a mass cable, a gas hose and a user's manual.

#### Additional welding torches and accessories (optional):

- Welding torch TIG T9 SGRIP 4 m 56 01 081920
- Welding torch TIG T9 SGRIP 8 m 56 01 081921
- Welding torch TIG T17 SGRIP 4 m 56 01 081707
- Welding torch TIG T17 SGRIP 8 m 56 01 081708
- Welding torch TIG 26 4 m 56 01 032622
- Welding torch TIG 26 8 m 56 01 032624
- Welding torch TIG T125 SGRIP 4 m (Rotating body) 56 01 084000
- Welding torch TIG T125 SGRIP 8 m (Rotating body) 56 01 084004
- WUS HD trolley 50 03 003942

Tungsten electrodes for TIG devices - see page 82

Welding torches and spare parts for TIG devices - see page 61





## MOST PONTIG 202 AC/DC inverter devices

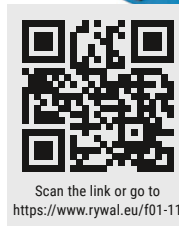
The PONTIG 202 AC/DC is an inverter welding rectifier for TIG welding of aluminium (TIG AC current) or steel and stainless steel (TIG DC current) or MMA (Stick) coated electrode.

**Main applications for this device include light and medium intensive welding in:**

- Aluminium structures, vehicles, adverts etc.
- Food industry and stainless steel installation welding.
- Chemical industry and pipelines.
- Crafting, manufacturing items of lightweight steel or stainless steel.
- Yacht construction (rigging welding), etc.
- Surfacing and regeneration jobs.

User friendly control panel equipped with display showing welding process functions.

PONTIG 202 AC/DC allows TIG welding with direct or alternative current up to 200 Hz. When welding with TIG AC, the adjustment frequency and balance are available to reach efficiency while maintaining high weld quality. The MMA method includes HotStart and ArcForce functions, PONTIG 202 AC/DC has all the additional functions needed for professional TIG welding (gas pre/post-flow, current rising, crater filling, etc.).



**HIT**



**Device assembly:**

PONTIG 202 AC/DC is delivered in a carton box containing user's manual, earth and MMA welding cables. TIG torch is optional.

**Optional accessories:**

- Welding torch TIG T9 SGRIP 4 m 56 01 081920
- Welding torch TIG T9 SGRIP 8 m 56 01 081921
- Welding torch TIG T17 SGRIP 4 m 56 01 081707
- Welding torch TIG T17 SGRIP 8 m 56 01 081708
- Welding torch TIG 26 4 m 56 01 032622
- Welding torch TIG 26 8 m 56 01 032624
- Welding torch TIG T125 SGRIP 4 m (Rotating body) 56 01 084000
- Welding torch TIG T125 SGRIP 8 m (Rotating body) 56 01 084004
- WUS HD trolley 50 03 003942

Model	PONTIG 202 AC/DC
<b>Power and tolerance</b>	1x230 V/50-60 Hz/ ±15%
<b>Welding current range</b>	
■ TIG	10-200 A
■ MMA	10-160 A
<b>Welding current regulation</b>	Stepless
<b>Overload protection / Fuse</b>	16 A (slow blow)
<b>X duty cycle TIG</b>	200 A / 25% 129 A / 60% 100 A / 100%
<b>X duty cycle MMA DC</b>	160 A / 30% 114 A / 60% 88 A / 100%
<b>MMA electrode diameter</b>	1,6-3,25 mm
<b>Sockets for connection of welding cables</b>	35/50 (large)
<b>Power factor cos φ</b>	0,7
<b>Power consumption</b>	8,2 (MMA) kW 6,0 (TIG) kW
<b>Efficiency</b>	85 %
<b>Plug</b>	Schuko 16 A
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 21S
<b>Standard</b>	EN 60974-1
<b>Dimensions</b>	502x218x382 mm
<b>Weight</b>	9,0 kg (17 kg carton of accessories)
<b>Catalogue No.</b>	52 00 005421



## MOST PONTIG 315 AC/DC inverter device

**NEW**  
in offer



PONTIG 315 AC/DC with cooler

Model	PONTIG 315 AC/DC
<b>Power and tolerance</b>	3x400 V 50-60 Hz -10%/+15%
<b>Welding current range</b>	10-350 A
<b>TIG / MMA welding current:</b>	
▪ In X 30% duty cycle	315 / 270 A
▪ In X 60% duty cycle	220 / 185 A
▪ In X 100% duty cycle	170 / 145 A
<b>Open circuit voltage (MMA) <math>U_0</math></b>	73 V
<b>Overload protection / Fuse</b>	32 A (delayed)
<b>Current <math>I_{eff}</math> (MMA)</b>	12,4 A
<b>Current <math>I_{1max}</math> (MMA)</b>	20 A
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 21S
<b>Dimensions (power source)</b>	566 x 223 x 405 mm
<b>Dimensions for power source + cooler + transport trolley</b>	
<b>Weight (power source)</b>	25,5 kg
<b>Weight for electrical power supply + cooler + transport trolley</b>	63,5 kg
<b>FANCOOL 300 cooler</b>	
<b>Electrical power supply (from PONTIG current source)</b>	1 x 230 V
<b>Power P</b>	1,2 kW l/min
<b>Maximum pressure</b>	3,0 bar
<b>Tank capacity</b>	5,5 l
<b>Dimensions</b>	660 x 275 x 335 mm
<b>Weight (empty)</b>	10 kg
<b>Catalogue No.</b>	52.00.005535

PONTIG 315 AC/DC MOST is modern inverter rectifier for TIG DC welding of steel, stainless steel, TIG AC aluminium welding and MMA coated electrode welding. It is an effective industrial equipment electrically powered by 3x400 V.

Main applications:

- Food industry and stainless steel installation welding.
- Structures made of aluminium, adverts, scaffolding.
- Chemical industry and pipelines.
- Crafting, manufacturing items of lightweight steel, stainless steel and copper alloys.
- Yacht construction, rigging welding, etc.
- Surfacing and regeneration of all metals.

TIG DC welding is performed with a direct or pulsating current of up to 200 Hz. Additional settings improving the weld quality or welding speed are available for TIG AC aluminium welding with alternative current e.g. different shapes of AC wave. MMA method offers VRD safety function for reducing open circuit voltage to 12 V.

PONTIG 315 AC/DC allows you to set all additional functions required for professional TIG welding (gas pre/post flow, current rising, crater filling, etc.).

PONTIG 315 AC/DC can work with different types of liquid-cooled or gas-cooled TIG welding torches after switching off the cooling unit or if liquid connections at the front of the cooling unit were bridged.

Control panel equipped with welding process functions. Parameter setting is executed with single knob used both for choosing and confirming functions or values.



**Scope of delivery:**

PONTIG 315 AC/DC is supplied with a mass cable, a gas hose and User's Manual. PONTIG 315 AC/DC is factory equipped with cooling unit and transport trolley. Cooler FANCOOL 300 is empty. Please fulfil it with 5 litres of colling liquid COOL 30 MOST (included in delivery).

**Additional welding TIG torches and accessories (optional):**

TIG torch 26 MOST 4 m (PONTIG 300/315) - 56 01 032644  
 TIG torch 26 MOST 8 m (PONTIG 300/315) - 56 01 032648  
 TIG torch 18 MOST 4 m (PONTIG 300/315) - 56 01 032654  
 TIG torch 18 MOST 8 m (PONTIG 300/315) - 56 01 032658

(TIG 26 - gas cooled; TIG 18 - water cooled. Other models or lengths of torches on request).



## MOST PONTIG 300 DC inverter device

PONTIG 300 DC MOST is modern inverter rectifiers for TIG DC welding of steel and stainless steel MMA coated electrode welding. PONTIG 300 DC is efficient industrial devices electrically powered by 3x400 V.

Main applications:

- Food industry and stainless steel installation welding.
- Chemical industry and pipelines.
- Crafting, manufacturing items of lightweight steel or stainless steel and copper alloys.
- Yacht construction, rigging welding, etc.

TIG welding is performed with a direct or alternating current of up to 200 Hz. In MMA method a VRD safety function is available for reducing open circuit voltage to 12 V.

PONTIG 300 DC allows to set all additional functions required for professional TIG welding (gas pre/post flow, current rising, crater filling, etc.).

The machine is designed to work with different types of liquid-cooled or gas-cooled TIG torches after switching off the cooler (settings of internal menu) also if liquid connections at the front of the radiator were bridged.

Control panel equipped with display presents welding process functions. Parameter setting is executed with single knob used both for choosing and confirming functions or values.

### Scope of delivery:

PONTIG 300 DC supplied with a mass cable, a gas hose and a User's Manual.  
An optional cooling unit and transport trolley is available for PONTIG 300 DC.

### Additional welding torches/holders and accessories (optional):

- TIG torch 26 MOST 4 m (PONTIG 300/315) - 56 01 032644
- TIG torch 26 MOST 8 m (PONTIG 300/315) - 56 01 032648
- TIG torch 18 MOST 4 m (PONTIG 300/315) - 56 01 032654
- TIG torch 18 MOST 8 m (PONTIG 300/315) - 56 01 032658
- FANCOOL 300 cooler - 52 00 005538
- Transport trolley - 52 00 005538

(TIG 26 - gas cooled; TIG 18 - water cooled. Other models or lengths of torches on request).



PONTIG 300 DC with cooler

Model	PONTIG 300 DC
<b>Power and tolerance</b>	3x400 V 50-60 Hz -10%/+15%
<b>Welding current range</b>	5-300 A
<b>TIG / MMA welding current:</b>	
▪ In X 20% duty cycle	300 / 210 A
▪ In X 60% duty cycle	173 / 160 A
▪ In X 100% duty cycle	134 / 124 A
<b>Open circuit voltage (MMA) U<sub>n</sub></b>	60 V
<b>Overload protection / Fuse</b>	25 A (slow blow)
<b>Current I<sub>off</sub></b>	8,3 A
<b>Current I<sub>max</sub></b>	16 A
<b>Insulation class</b>	F
<b>IP Rating</b>	IP 23
<b>Dimensions (power source)</b>	660 x 290 x 505 mm
<b>Weight (power source)</b>	19,4 kg
<b>Catalogue No. (power source)</b>	52 00 005530
<b>FANCOOL 300 cooler (option)</b>	
<b>Electrical power supply (from PONTIG power source)</b>	1 x 230 V
<b>Power P</b>	1,2 kW l/min
<b>Maximum pressure</b>	3,0 bar
<b>Tank capacity</b>	5,5 l
<b>Dimensions</b>	660 x 275 x 335 mm
<b>Weight (empty)</b>	10 kg

## TIG welding torches

GAS COOLED TORCHES							
Model	Rating (A)		Duty cycle	Wire diameter	Length / Catalogue No.		
	DC	AC			4 m	8 m	12 m
<b>T9 SGRIP</b>	125 A	90 A	35%	1,0-1,6 mm	56 01 060904	56 01 060908	ask
<b>T17 SGRIP</b>	150 A	105 A	35%	1,0-2,4 mm	56 01 061716	56 01 061717	ask
<b>T26 SGRIP</b>	180 A	125 A	35%	1,0-3,2 mm	56 01 062604	56 01 062608	56 01062612
<b>T125 SGRIP*</b>	150 A	105 A	35%	1,0-2,4 mm	56 01 061254	56 01 061258	ask
LIQUID COOLED TORCHES							
<b>T20 SGRIP</b>	225 A	160 A	100%	1,0-3,2 mm	56 01 062004	56 01 062008	56 01 062012
<b>T225F SGRIP*</b>	225 A	160 A	100%	1,0-3,2 mm	56 01 061304	56 01 061308	ask
<b>T250 SGRIP*</b>	250 A	175 A	100%	1,0-3,2 mm	56 01 061284	56 01 061288	ask
<b>T18 SGRIP</b>	380 A	270 A	100%	1,0-4,0 mm	56 01 061804	56 01 061808	56 01 061812
<b>T18SC SGRIP</b>	410 A	290 A	100%	1,0-4,0 mm	56 01 061814	56 01 061818	56 01 061822

\* Parameters dependent on the torch head, see page 66, 70, 71.

The handles can be equipped with flexible torch heads of various lengths.

The above TIG torches come without control and gas plugs. It is possible to order a handle configured for a specific device - catalogue numbers for individual welding machines.

### ▼ 3. LASER WELDING MACHINES



#### MOST XTW laser welding machine



The MOST XTW laser welding machine has been widely used in joining materials with thicknesses up to 6 mm. Various types of materials and shapes can be joined with a laser beam (also with the use of welding wire). The obtained joints are aesthetic and durable, and deformations are negligible. In most cases no mechanical treatment is required after the welding process is completed.

Currently in welding, laser technology is widely used in many branches of the industry such as automotive industry, astronautics, electronics, aviation, power industry, production of sanitary equipment, production and regeneration of matrices, food processing. Laser welding is one of the most modern welding methods, it becomes a competition for advanced welding processes, incl. electron welding. The welding process is very efficient and it can be used to combine various shapes in all welding positions, which increases the efficiency of production processes.

#### Advantages of laser welding:

- narrow welding seam,
- narrow heat-affected zone,
- high speed of the process,
- it does not require any additional material (welding wire can be used),
- high precision,
- high purity of the process,
- high power density,
- minimal deformation,
- the possibility of joining difficult-to-weld materials.

Laser welding is a highly efficient method in mass production, automated or robotic production, especially for connecting thin-walled elements, where the advantages are fully used in this method.

Model	MOST XTW-1500	MOST XTW-2000
Laser type	optical fiber, Nd-Yag, continuous mode	
Laser output power	max 1500 W	max 2000 W
Dot diameter	0,5-1,0 mm	
Laser head cable length	10 m (8 m outside the machine)	
Fiber core diameter	50 µm	
Power type	230 V ±20%	380 V ±20%
Cooling method	active cooler with forced liquid circulation	
Weight	220 kg	250 kg
Penetration depth	<4 mm	<5 mm
Dimensions DxHxW	970 x 780 x 585 mm	1100 x 800 x 640 mm
Laser head with wobbler	biaxle	
Oscillator	7 operating modes	
Catalog No.	3L 00 000001	3L 00 000002

#### Laser head and controls

The welding precision is determined by the head, which in case of the MOST welding machine is a biaxial head, which allows for setting several types of oscillation - operating modes.

The head has a display with the currently set parameters of the device, such as output power, type of oscillation, frequency and beam working area width.



MOST XTW laser welding machine is a set which includes:

- power source with the biaxial laser head and a built-in cooler,
- stabilizer,
- wire feeder.





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### MOST MAX laser welding machines

The new generation of handheld laser welding machines features compact size, light weight, flexibility of use and simplicity of operation. These devices allows welding of stainless steel, carbon steel, aluminium, galvanized sheet metal, copper and other metals.

Using advanced laser technology, the welder provides efficient welding at speeds higher than with TIG and MIG/MAG welding methods. Welds made with the laser welding machine are smooth and rounded. The welding process does not cause material deformation or burn-through, eliminating the need for subsequent grinding or polishing. As a result, general production efficiency is significantly improved, while the consumption of consumables and production costs for each component are reduced.



MOST MAX-T65



MOST MAX-T45

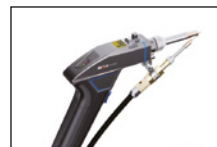


MOST MAX-T35

Model	MOST MAX-T65	MOST MAX-T45	MOST MAX-T35
<b>Mains voltage</b>	1~230 V ±10%, 50/60 Hz		
<b>Power</b>	1,5 kW	1,2 kW	800 W
<b>Power input max</b>	6 kW	4,5 kW	3 kW
<b>Welding power range</b>	10-100%		
<b>Maximum penetration depth:</b>			
▪ Stainless steel	6,5 mm	4,5 mm	3,5 mm
▪ Carbon steel	6,5 mm	4,5 mm	3,5 mm
▪ Aluminium	5,5 mm	4 mm	3 mm
▪ Galvanized sheets	6,5 mm	4,5 mm	3,5 mm
▪ Brass	4,5 mm	3,5 mm	2,5 mm
▪ Copper	3 mm	1,5 mm	-
<b>Covering gas</b>	Argon, Argon+CO <sub>2</sub> , Nitrogen		
<b>Emitted light wavelength</b>	1070-1090 nm		
<b>Fiber core diameter</b>	20 µm		
<b>Torch length</b>	5,6 m		
<b>Minimum torch bending radius</b>	175 mm		
<b>Welding torch cooling type</b>	Gas		
<b>Ambient temperature</b>	10 - 40°C		
<b>Ambient relative humidity</b>	10 - 85%		
<b>Storage temperature</b>	-10 ÷ 60°C		
<b>Modulation frequency</b>	10 kHz		
<b>Protection (circuit breaker, characteristic C)</b>	32 A/1F		
<b>Device dimensions d x w x h</b>	667 x 276 x 542 mm	667 x 276 x 542 mm	588 x 265 x 512 mm
<b>Weight</b>	39 kg	38 kg	29 kg
<b>Separate wire feeder</b>			
<b>Mains voltage</b>	=24 V		
<b>Wire diameter</b>	1,0/1,2/1,6 mm		
<b>Number of rolls</b>	4		
<b>Feeding speed</b>	0,1 - 18 m/min		
<b>Equipment dimensions d x w x h</b>	440 x 250 x 580 mm		

**Support wobble welding, optional in wire feeder**

Laser control system support wobbly frequency and width control, can achieve up to 4,0 mm weld width, weld at one time and high aesthetics, good consistency. Combine with wire feeder, help to improve to full fill the welding gap, make up the cutting defects from last process, normally support welding wire diameter 1,0/1,2/1,6 mm, suitable for carbon steel, stainless steel, aluminum, non-ferrous metal and alloy.



Laser Head with wire feeder



Laser Head



## ▼ 4. MMA WELDING MACHINES



### PONTE 201 MOST inverter for coated electrodes welding



#### Properties:

- weight - only 5.9 kg,
- LCD welding current display,
- durable metal housing with additional reinforcements in the corners,
- large 35/50 sockets,
- New - PONTE 201 PRO version with longer cables in a plastic case.

**HIT**

Model	PONTE 201 MOST
Power and tolerance	1x230 V, 50-60 Hz ±15%
Welding current range	10-200 A
Maximum current consumption $I_{Tmax}$	44 A
Welding current at X duty cycle	200 A /10% 82 A /60% 63 A /100%
Open circuit voltage	63 V
Power factor	0,65
Efficiency	85%
IP Rating	IP 21S
Overload protection / Fuse	16 A
Insulation class	F
Dimensions	
PONTE 201	375x140x290 mm
PONTE 201 PRO	570x220x420 mm
Welding sockets	35/50 (large)
Weight	
PONTE 201	5,9 kg
PONTE 201 PRO	9,5 kg (gross)
Catalogue No.	
PONTE 201	53 00 030684
PONTE 201 PRO	53 00 030685

#### Device assembly:

The PONTE 201 device is delivered in a cardboard box with welding cables (1,5 m earth and 2 m electrode cable) and user's manual.

PONTE 201 PRO is delivered in a plastic case with longer welding cables (3 m mass and electrode) and user's manual.

#### Accessories:

Thermos for storing dry electrodes MOST - page 88





## PONTE 402 MOST inverter for coated electrodes welding

PONTE 402 MOST - inverter rectifier for welding with a coated electrode and the TIG DC method (arc ignition by scratching the tip of the tungsten electrode).

The PONTE 402 rectifier is a professional welding unit for virtually all types of electrodes (including cellulose coating) and to a limited extent for TIG DC welding or electro-gouging.

In order to increase the welder's safety when working in places where there is a risk of electric shock, the device uses the VRD function, which reduces the open circuit voltage to approx. 9 V. In order to facilitate arc ignition when welding with the MMA electrode, the HotStart current value can be set. When welding pipes, the ArcForce function is also useful, thanks to which the current does not need to be adjusted when changing the welding position.

The device can optionally work with a remote control device. The control panel is clear and friendly to the welder. PONTE 402 meets the requirements of the Ecodesign Directive 2009/125/EU (power source efficiency 89%, idle power consumption 27 W).



Model	PONTE 402 MOST
<b>Power supply and tolerance</b>	3x400 V, 50-60 Hz $\pm 15\%$
<b>Welding current range</b>	30 - 400 A
<b>Maximum current consumption</b>	25,3 A
<b>Duty cycle</b>	400 A / 60% 310 A / 100%
<b>Open circuit voltage</b>	79 V
<b>Efficiency of the power source</b>	89%
<b>IP Rating</b>	IP 21S
<b>Insulation class</b>	F
<b>Dimensions</b>	680 x 340 x 528 mm
<b>Welding sockets</b>	35/50 (large)
<b>Weight</b>	23 kg
<b>Catalogue No.</b>	53 00 040400

### Device assembly:

The device is delivered in a cardboard box, power cord with a 32 PEE plug, without welding cables (see accessories).

### Accessories:

Thermos for storing dry electrodes MOST	50 00 004400
Ground cable 3 m and electrode cable 5 m/50 mm <sup>2</sup>	53 99 990115
Remote control PONTE 402 P110B007 15 m	53 13 000010
TIG torch 26V 35/50 MOST 4 m	56 01 062634
FANDRY 20 electrode dryer	50 00 003002
Thermos for FANTERM 5T electrodes	50 00 004300

## ▼ 5. INDUCTION HEATERS



### FANHEAT DHI-1012F HD MOST induction heater



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in offer

#### Equipment:

- Clear display with visualization of the parameters.
- Water cooled inductors.
- Continuous output control 10-100%.
- Mode - Timer and Mode – factory setting.
- USB connection for software update.
- Constant power mode CP and constant magnetic field CF mode.
- LED inductor lighting.
- Removable trolley.
- Remote control and temperature sensor terminal (option).

#### The kit includes:

- DHI-1012F HD MOST.
- Round focus coil 32 mm.
- Coolant liquid (in the device).

#### Catalogue numbers:

FANHEAT DHI-1012F HD MOST, burner 4 m 59 K12 40000



Scan the link or go to  
<https://www.rywal.eu/f01-14>

FANHEAT DHI-1012F HD MOST is mobile, water-cooled induction heater equipped with a 4 and potentially 6, 8 or 10 meter induction burner with the possibility of replaceable induction adapters. The device is intended for heating of ferromagnetic and conductive materials. Thanks to the compact design high performance, versatile use with smooth output adjustment, it is suitable for various applications especially in welding industry, heavy industry, production facilities, welding workshops, car repair shops, truck and agricultural machinery repair shops etc.

#### Ideal tools for every workshop:

- Heating prior to hardening, straightening, forging, bending of structural steel profiles and suitable for annealing.
- Low operating costs, training of operators is not necessary like for methods working with autogenous and propane-butane burners.
- Simplicity and ease of use - simple operation, fast heating process.
- Safety and ecology - absence of flame.
- Use in the automotive, railway, aerospace, marine and industry.
- In general, metal-working, maintenance.

#### Advantages:

- Mobility – weight 68 kg including water cooling.
- Replacement of autogenous working methods (flame heating).
- Very silent operation.
- Power 10 kW / 12 kVA, high loading factor.
- Ease of use – 4 m long burner (HD version option: 6, 8 or 10 m).
- Flexibility and ease of use.
- Robust and big wheels on the removable chassis.
- The HD version features an improved cooling system to achieve a higher duty cycle.

Model	DHI-1012F HD
Power supply	3x400 V
Power protection	3x16 A
Power	10 kW / 12 kVA
Frequency	18-45 kHz
Fan	Yes
IP Rating	IP21
Dimensions	400x760x700 mm
Weight	68 kg
Length of supply cable	5 m
Length of induction burner	4, 6, 8, 10 m

Accessories		
Coil	Diameter	Catalogue No.
Round focus coil	32 mm	59 K0 090000
Round front focus coil 90°	32 mm	59 K0 090012
„U” profile coil	14 mm	59 K0 090011
Single-turn round coil	22 mm	59 K0 090001
	28 mm	59 K0 090002
	34 mm	59 K0 090003
	40 mm	59 K0 090004
	47 mm	59 K0 090005
Double-turn round coil	57 mm	59 K0 090006
	22 mm	59 K0 090008
Spare focus core 32 mm	-	59 K0 090014
Foot remote control	-	59 K0 090016
Coolant liquid 10 l	-	59 K0 090015





## FANHEAT DHI-1012C1 HD MOST induction heater

FANHEAT DHI-1012C1 HD MOST is mobile, water-cooled induction heater equipped with a 4 and potentially 6, 8 or 10 meter induction burner with the possibility of replaceable induction adapters. The device is intended for heating of ferromagnetic and conductive materials. Thanks to the compact design high performance, versatile use with smooth output adjustment, it is suitable for various applications especially in welding industry, heavy industry, production facilities, welding workshops, car repair shops, truck and agricultural machinery repair shops etc.

### Ideal tools for every workshop:

- Heating prior to hardening, straightening, forging, bending of structural steel profiles and suitable for annealing.
- Low operating costs, training of operators is not necessary like for methods working with autogenous and propane-butane burners.
- Simplicity and ease of use - simple operation, fast heating process.
- Safety and ecology - absence of flame.
- Use in the automotive, railway, aerospace, marine and industry.
- In general, metal working, maintenance.
- For brazing.

### Advantages:

- Mobility – weight 68 kg including water cooling.
- Replacement of autogenous working methods (flame heating).
- Very silent operation.
- Power 10 kW / 12 kVA, high loading factor.
- Ease of use – 4 m long burner (HD version option: 6, 8 or 10 m).
- Flexibility and ease of use.
- Robust and big wheels on the removable chassis.
- The HD version features an improved cooling system to achieve a higher duty cycle.

Model	DHI-1012C1 HD
Power supply	3x400 V
Power protection	3x16 A
Power	10 kW / 12 kVA
Frequency	18-45 kHz
Fan	Yes
IP Rating	IP21
Dimensions	400x760x700 mm
Weight	68 kg
Length of supply cable	5 m
Length of induction burner	4, 6, 8, 10 m

Accessories		
Coil	Diameter	Catalogue No.
Round focus coil	32 mm	59 K0 090000
Round front focus coil 90°	32 mm	59 K0 090012
„U“ profile coil	14 mm	59 K0 090011
	17 mm	59 K0 090018
Single-turn round coil	22 mm	59 K0 090001
	28 mm	59 K0 090002
	34 mm	59 K0 090003
	40 mm	59 K0 090004
	47 mm	59 K0 090005
	57 mm	59 K0 090006
	67 mm	59 K0 090007
Double-turn round coil	82 mm	59 K0 090019
	22 mm	59 K0 090008
	28 mm	59 K0 090009
	34 mm	59 K0 090010
Spare focus core 32 mm	-	59 K0 090014
Foot remote control	-	59 K0 090016
Coolant liquid 10 l	-	59 K0 090015



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### Equipment:

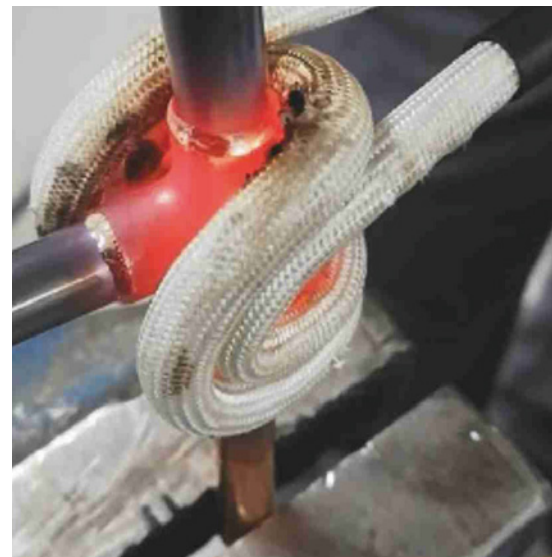
- Clear display with visualization of the parameters.
- Water cooled inductors.
- Continuous output control 10-100%.
- Mode - Timer and Mode – factory setting.
- USB connection for software update.
- Constant power mode CP and constant magnetic field CF mode.
- LED inductor lighting.
- Removable trolley.
- Remote control and temperature sensor terminal (option).

### The kit includes:

- DHI-1012C1 HD MOST.
- Round focus coil 32 mm.
- Coolant liquid (in the device).

### Catalogue numbers:

FANHEAT DHI-1012C1 HD MOST, burner 4 m 59 K1 210000



## ▼ 6. STUD WELDING EQUIPMENT



### Elotop stud welding equipment

Köco stud welding machines are high-performance production equipment that can significantly reduce the cost of joining components when compared to other methods. Threadless and threaded pins, studs with head, anchors etc. with a diameter of 3 to 25 mm can be quickly and high quality welded to sheet metal, pipes, profiles. This eliminates many additional preparatory operations such as drilling, threading, manual welding or tightening.

#### Properties:

- For arc welding (with ceramic ferrule) or short-cycle welding (SC).
- For welding in a gas shield (optional) or without.
- For work in a hall or on a construction site (IP23).
- A wide selection of guns depending on the diameter of the stud and the application.
- Stepless regulation of welding current and time.

HIT

Model	510	810	1010	1710	2010	3010
Welding range with a ceramic ferrule - stud diameter	Ø3-8 mm	Ø3-12 mm	Ø3-14 mm	Ø3-20 mm	Ø3-22 mm	Ø6-25 mm
Short-cycle welding range - stud diameter	Ø3-6 mm	Ø3-8 mm	Ø3-10 mm	Ø3-12 mm	Ø3-12 mm	Ø6-12 mm
The range of welding in gas shield -stud diameter	Ø3-8 mm	Ø3-10 mm	Ø3-12 mm	Ø3-16 mm	Ø3-16 mm	Ø6-16 mm
Maximum current	450 A	800 A	1100 A	1800 A	2300 A	3500 A
Current setting range	-	50-750 A	150-1000 A	150-1600 A	300-2000 A	300-2600 A
Time setting range	20-460 ms	20-600 ms	20-1000 ms	20-1500 ms	20-1500 ms	20-2000 ms
Program memory	-	20	20	20	20	20
Number of welded studs (pcs / min) for a given diameter (mm)	15/3 4/8	32/3 3/12	49/3 4/14	50/3 2/20	52/3 4/22	50/6 6/25
Self-diagnosis:						
▪ overheating	●	●	●	●	●	●
▪ short circuit	-	●	●	●	●	●
▪ no power supply	●	●	●	●	●	●
▪ pilot current error	-	●	●	●	●	●
Stepless current regulation	-	●	●	●	●	●
Securing cycle repeatability	●	●	●	●	●	●
Electrical power supply	400 V	230/400 V	230/400 V	230/400 V	230/400 V	230/400 V
400 V power plug	32 A	32 A	32 A	63 A	63/125 A	125 A
400 V power cord	5/2.5 m/mm <sup>2</sup>	5/4 m/mm <sup>2</sup>	5/4 m/mm <sup>2</sup>	5/10 m/mm <sup>2</sup>	5/16 m/mm <sup>2</sup>	5/16 m/mm <sup>2</sup>
Network protection at 230/400 V	16 A	25 A	35 A	63 A	63/80 A	125 A
Power supply fluctuation tolerance	-15/+6 %	-15/+6 %	-15/+6 %	-15/+6 %	-15/+6 %	-15/+6 %
IP Rating	IP 23	IP 23	IP 23	IP 23	IP 23	IP 23
Dimensions	375x220x360 mm	555x308x535 mm	555x308x535 mm	700x415x660 mm	805x430x730 mm	950x605x860 mm
Weight	25 kg	65 kg	85 kg	160 kg	190 kg	350 kg
Shielding gas equipment	●	●	●	○	○	○
Weld counter	-	●	●	●	●	●
Ad hoc	●	●	●	●	●	-
Total	-	○	○	○	○	○
Welding gun:						
SK 14	●	●	○	○	○	○
K 22	○	○	●	○	○	○
K 22-D	-	-	○	●	○	○
K 24	-	-	-	-	●	○
K 26	-	-	-	-	-	●
Catalogue No.	50 01 303520	50 01 303021	50 01 303034	50 01 303202	50 01 303403	50 01 303303

● standard / ○ option / - not available



Spare parts for  
K Classic guns  
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Catalogue Köco 2019 (PL)

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## Inverter stud welding machines

### Inverter 805i-8 / 805i-10 / 905i / 1305i / 1805i / 2305i

**NEW**  
in offer



- Inverter devices - much lower weight than the corresponding Elotop devices.
- For arc welding (with ceramic ferrule) or short-cycle welding (SC).
- For welding in a gas shield (optional) or without.
- For work in a hall or on a construction site (IP23).
- A wide selection of guns depending on the diameter of the pin and the application.
- Stepless regulation of welding current and time.

Model	805i-8 / 805i-10	905i	1305i	1805i	2305i
Welding range with a ceramic ring - stud diameter	Ø2 mm	Ø2-12 mm	Ø3-16 mm	Ø2-19 mm	Ø2-25 mm
Short-cycle welding - welding range	Ø2-8 mm	Ø2-8 mm	Ø3-8 mm	Ø2-10 mm	Ø12 mm
Gas shielded welding - welding range	Ø2-8 / Ø10 mm	Ø2-10 mm	Ø2-16 mm	Ø3-12 (16) mm	Ø2-12 (16) mm
Current setting range - stepless	100-800 A*	100-800 A	1300 A	200-1600 A	200-2300 A
Time setting range - stepless	1-300 ms	1-800 ms	1-1000 ms	1-1000 ms	1-1500 ms
Parameter memory (set: welding current, welding time and gas pre-flow)	-	20	20	20	20
Maximum number of studs/min, with... Ø	40 / Ø3 mm 9 / Ø8 mm	4 / Ø12 mm 9 / Ø10 mm	2 / Ø16 mm 5 / Ø12 mm	2 / Ø19 mm 6 / Ø16 mm	5 / Ø22 mm 3 / Ø25 mm
Self-diagnosis	Overheating No phase Short circuit Pilot current error				
50/60 Hz power supply	1x230 V	3x400 V	3x400 V	3x400 V	3x400 V
Time-delay power protection	16 A	20 A	35 A	50 A	63 / 80 A
Power consumption at...% PJ	maks. 8 kVA	3% / 45 kVA 7,5% / 28 kVA 100% / 7,5 kVA	2% / 69 kVA 4,5% / 45 kVA 100% / 9,5 kVA	3% / 90 kVA 6% / 65 kVA 100% / 15,5 kVA	8% / 117 kVA 11% / 90 kVA 100% / 17 kVA
Maximum welding cable length with welding current and cross section	-	600 A/25 m at 70 mm <sup>2</sup>	1300 A/10 m at 70 mm <sup>2</sup>	1600 A/10 m at 70 mm <sup>2</sup>	2000 A/10 m at 95 mm <sup>2</sup>
Power supply fluctuation tolerance	-15/+6 %	-15/+6 %	-15/+6 %	-15/+6 %	-15/+6 %
IP Rating	IP23	IP23	IP23	IP23	IP23
Gas shielded welding	option	option	option	option	option
Gas pre-flow	10-2000 ms	1-2000 ms	100-2000 ms	10-2000 ms	100-2000 ms
Case dimensions	550x225x470 mm	410x220x250 mm	550x175x395 mm	600x270x410 mm	800x310x535 mm
Weight	23 / 27 kg	18 kg	24 kg	36 kg	63 kg
Catalogue No.	50 01 303805 / 50 01 303806	50 01 303905	50 01 303135	50 01 303185	50 01 303195
Type of welding gun	SK14 (option K22)	SK14	K22	K22D	K22D; (option K24 / K26)

\*) 4 ranges



Spare parts for  
K Classic guns  
- download the  
Catalogue Köco 2019 (PL)

Scan the link or go to  
<https://www.rywal.eu/i01-1>



## Types of studs according to EN ISO 13918

**Köco SD**  
EN ISO 13918/ETA-03/0039  
Shear connectors.

- For steel structures conforming to European Technical Approval.
- ETA-03/0039 (except 6 and 12 mm).
- Other materials on request, available in many sizes.
- SD studs are available in diameters of 6 mm; 10 mm; 13 mm; 16 mm; 19 mm; 22 mm and 25 mm.

**Köco PD**  
EN ISO 13918  
Drawn arc weld studs with partial thread.

- Basic version made of 4.8 steel without coating. Other materials or coatings - table on page 31.
- Available PD studs diameters: M6; M8; M10; M12; M16; M20.

**Köco RD**  
EN ISO 13918  
Drawn arc studs with reduced thread.

- Basic version made of 4.8 steel without coating. Other materials or coatings - table on page 31.
- Available RD studs diameters: M6; M8; M10; M12; M16; M20.

**Köco FD**  
EN ISO 13918  
Drawn arc weld stud with full thread.

- Basic version made of 4.8 steel without coating. Other materials or coatings - table on page 31.
- Available FD studs diameters: M6; M8; M10; M12; M16; M20.

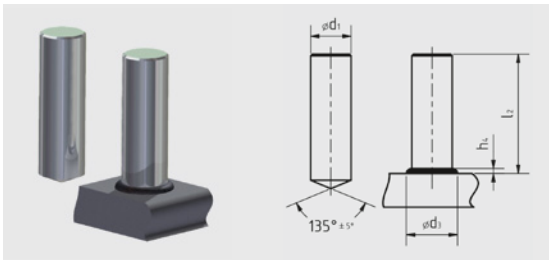
**Köco PS**  
EN ISO 13918  
Short-cycle drawn arc threaded stud with flange.

- Basic version made of copper-plated 4.8 steel. Other materials or coatings - table on page 31.
- Available PS studs diameters: M3; M4; M5; M6; M8; M10.

**Köco ID**  
EN ISO 13918  
Drawn arc weld stud with internal thread.

- Basic version made of 4.8 steel without coating. Other materials or coatings - table on page 31.
- ID studs are available with M6; M8; M10; M12 holes.



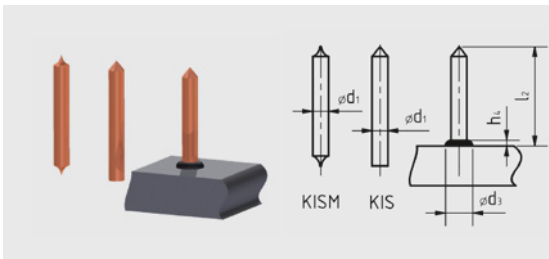


### Köco UD

EN ISO 13918

Drawn arc weld stud without thread.

- Basic version made of 4.8 steel without coating. Other materials or coatings - table below.
- UD studs are available in diameters of 6 mm; 8 mm; 10 mm; 12 mm; 14,6 mm; 22 mm and 16 mm.



### Köco KIS+KISM

Drawn arc insulation pin.

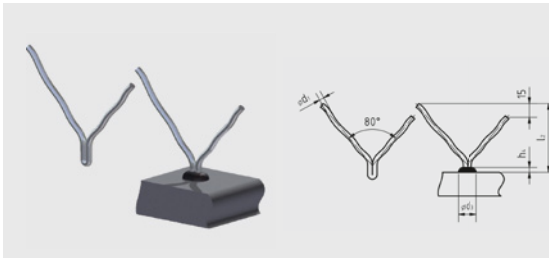
- Clips for pins, e.g. D = 38 mm on request.
- Insulation pins are available in 2 mm; 3 mm; 4 mm and 5 mm diameters with lengths from 30 to 250 mm. Other lengths available on request.



### Köco KKS

Arc weld boiler studs.

- Basic version made of Sicromal 10 steel without coating. Other materials or coatings - table below.
- KKS studs are available in 8 mm and 10 mm diameters.



### Köco KWA

Refractory Y anchor.

- Note: up to  $i_2 = 45$  mm, both bars have the same lengths.
- Basic version made of 1.4841 steel without coating. Other materials or coatings - table below.
- KWA anchors are available in diameters of 6 mm and 8 mm.

## Material and stud coating codes:

001	non-alloyed structural steel, without coating
002	stainless steel 1.4301/03
005	A4-50
008	1.4713 (Sicromal 8)
009	1.4742 (Sicromal 10)
011	1.4828
012	1.4841
053	1.4845
018	16Mo3
013	2.4851 (Inconel 601)
054	19MnB4, hardened
062	K 800
057	2.4856 (Inconel 625)
101	4.8, A2L zinc-plated and yellow chrome-plated
100	4.8, A2K (galvanized) without Cr VI
103	4.8, C2E (copper-plated)
102	4.8, G2E (nickel-plated copper)
112	4.8, flZnnc-600h without Cr VI zinc flake coating

The type of material and surface coating are indicated by the last three digits of the stud's catalogue number, according to the table beside.



More technical data for welding studs and pins - download the Köco 2019 Catalogue (PL)

Scan the link or go to <https://www.rywal.eu/i01-1>



## KST 108 and KST 110 stud welding equipment with capacitor discharge for CD studs

### Description:

- Suitable for welding studs made of steel, alloy steel, aluminium and brass.
- It welds studs with a diameter of 3 to 10 mm (insulation pins from 2 mm).
- Stepless charging voltage setting.
- Digital charging voltage display.
- Only 9.9 kg (KST 108 - 8.9 kg).
- Intelligent self-diagnosis system.

### Advantages of welding using capacitor discharge:

- Very fast welding of studs and pins to thin sheets over 0.5 mm thick.
- Fastening of the stud without scribing, drilling, threading or riveting.
- Full connection between the stud and base material.
- No damage or minimal discoloration on the opposite side of the base material, no leaks in tanks.
- No thermal deformation after welding.
- Low power consumption, no 3-phase power supply required.
- No additional materials are needed (wire, solder, flux, etc.).
- A wide range of possible connections.



HIT

Capacitor stud welding machines	KST 110	KST 108
Range of welded studs	2-10 mm	2-8 mm
Welding efficiency	M 10/8, M 6/15 pcs/min	M 8/10, M 6/15 pcs/min
Capacitance	99000 µF	66000 µF
Electrical power supply	115/230 V	115/230 V
Charging voltage	50-200 V	50-200 V
Main fuse, time-lag	6,3 A	6,3 A
Power supply frequency	50/60 Hz	50/60 Hz
Power consumption	700 W	700 W
Dimensions (without handle and feet)	330x190x280 mm	330x190x280 mm
Weight	9,9 kg	8,9 kg
IP protection class	IP23	IP23
Working temperature range	0-45°C	0-45°C
Catalogue No.	50 01 303014	50 01 303012

Guns for CD welding of studs	ESP 1 S	ESP 1 K
Type of work	with a gap	contact
Length of welding and control cables	4 m	4 m
Gun length (without pin holder)	165 mm	165 mm
The diameter of the gun	40 mm	40 mm
Gun height (including handle)	130 mm	130 mm
Weight (without cables)	0,730 kg	0,625 kg
Application	aluminium	steel, stainless steel, brass

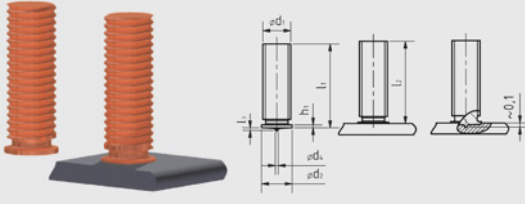


Spare parts for  
ESP guns  
- download the  
Köco 2019 Catalogue (PL)

Scan the link or go to  
<https://www.rywal.eu/i01-1>

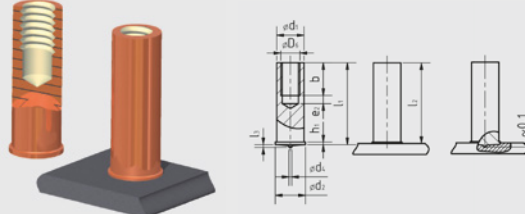


## Types of welding studs (CD) according to EN ISO 13918



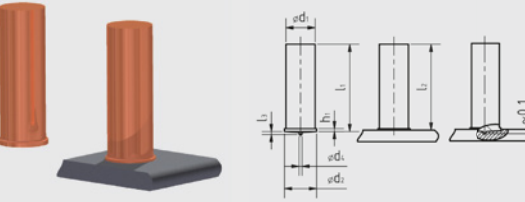
**Köco PT**  
EN ISO 13918  
Threaded stud with flange and ignition tip.

- Basic version made of copper-plated 4.8 steel. Other materials or coatings - table on page 31.
- Available PT studs diameters: M3; M4; M5; M6 and M8.



**Köco IT**  
EN ISO 13918  
Flanged stud with internal thread and ignition tip.

- Basic version made of copper-plated 4.8 steel. Other materials or coatings - table on page 31.
- Available IT stud holes: M3; M4; M5.



**Köco UT**  
EN ISO 13918  
Flanged stud without thread and with ignition tip.

- Basic version made of copper-plated 4.8 steel. Other materials or coatings - table on page 31.
- PT studs are available in diameters of 3 mm; 4 mm; 5 mm; 6 mm; 7,1 mm.



**ISO insulation pins**

- Available in 2.2 mm and 2.7 mm diameters with lengths from 2 to 250 mm.
- Basic version made of copper-plated 4.8 steel. Other materials or coatings - table on page 31.
- Clips for the above pins are also available.



More technical data for  
welding studs  
- download the  
Köco 2019 Catalogue (PL)

Scan the link or go to  
<https://www.rywal.eu/i01-1>

## ▼ 7. WELDING WITH ARGON PURGING

### ▼ 7.1. Welding accessories for argon purging



Scan the link or go to  
<https://www.rywal.eu/v01-2>

Obtaining high quality welds when connecting pipe elements requires the presence of an inert gas (also inside the pipe), which prevents oxidation and the formation of defects in the weld. To reduce the purging time of the argon pipeline and the amount of gas needed to protect a weld root, a number of methods described in this chapter can be used.

Dependent on the character of welding, several products can be used at the same time and an purge monitor can be properly connected.

### PurgeEye™ 100 IP65 Purge Monitor



PurgeEye™ 100 IP65 measures and shows the oxygen content in a space filled with argon or other shielding gas. If it is low enough, you can be sure that the weld will be of good quality.

The PurgeEye™ 100 IP65 monitor allows you to measure the percentage of oxygen up to the lower limit of 0.01% or 100 ppm. It is assumed that the presence of oxygen below 0.1% in the area of the weld does not have a negative impact on the quality and purity of the weld (except for some metals, e.g. titanium, zirconium).

HIT

Model	PurgeEye™ 100 IP65
Measurement range	from 0,01% (100 ppm) do 20,94% oxygen
Accuracy	for oxygen level 20% ± 0,2% for oxygen level 2% ± 0,02%
Dimensions (max width x height x max depth)	94x199x63 mm
Electrical power supply	2 x AA 1.5 V batteries
Display	LCD 24 mm
IP Rating	IP65
Weight	0,21 kg
Catalogue No.	50 72 030006



Possibility of placing the monitor on a pipe

#### The main advantages of the PurgeEye™ 100 IP65 monitor:

- CAL auto calibration button,
- large LCD display,
- sensor wear indicator,
- low battery indicator,
- automatic transition to StandBy mode after 1 hour from the last measurement,
- increased measuring range when compared to the MKV version,
- possibility of connecting to a shielding gas outlet or gas sampling with a rubber bulb,
- socket for mounting on a tripod or on a gripper on a pipe,
- rubber cover (option),
- supplied in a convenient plastic transport case.





## The PurgEye® family of purge monitors necessary for welding of titanium, nickel, duplex steel or zirconium

### 1. PurgEye® 200 - Cat. no. 50 72 030036

Hand held oxygen meter with a 10-1000 ppm range, rough measurements from 1 ppm. Powered with a battery with a lifetime of up to 10 hours. With built-in pump and permanent sensor. OLED display oxygen reading in ppm or %.

### 2. PurgEye® Nano - Cat. no. 50 72 030032

The first such simple and cheap meter measuring oxygen in the range from 10 ppm. Durable, maintenance-free sensor, no calibration required. Large display.

#### The basic advantages of the PurgEye® purge monitors:

- small dimensions and weight,
- large LCD display,
- automatic alarm indicating set limits being exceeded,
- specially designed for welding titanium, nickel alloys or highest purity stainless steel,
- for orbital welding or in argon chambers, tents, etc.,
- possibility of connecting to a shielding gas outlet (300) or gas sampling via a built-in pump,
- for cooperation with external devices such as a welding machines, alarm devices, etc.,
- supplied in a convenient plastic transport case.



PurgEye® 200



PurgEye® Nano

## Water-soluble Argweld® film

The water-soluble ARGWELDR film is used to create impermeable barriers that limit the space filled with shielding gas when welding pipes.

#### Properties:

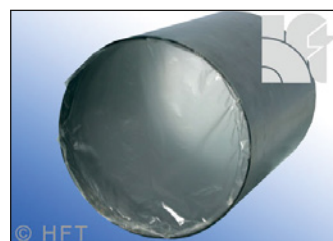
- for use with steels of all grades,
- the foil dissolves "like sugar" during a water test,
- without the risk of contamination of pumps, filters, etc.,
- biodegradable,
- indispensable in unit or short series welding.

The film is delivered in a cardboard package containing:

- water-soluble film, 20 m long and 1 m wide (folded in half and wound on a cardboard spool),
- two glue containers,
- knife,
- manual.

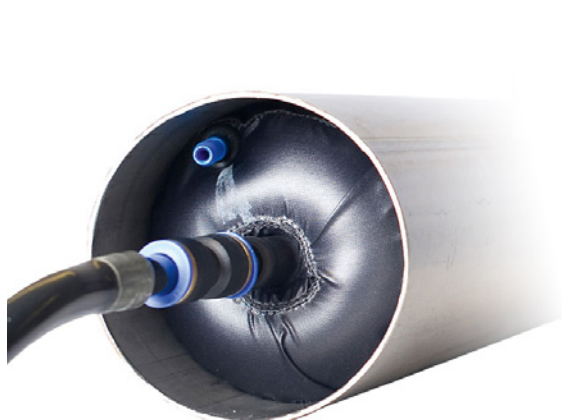
The packaging makes long-term storage of the set possible.

Catalogue No.: 50 72 001000





## PurgElite® Weld Purge Systems



### Properties:

- range from 1" to 24" (25 mm to 622 mm),
- simple, maintenance-free valve that does not require calibration,
- the PurgElite® system is powered by one argon hose, both for filling bladders and for creating an argon protection of the root weld,
- a special connector with a valve withstands material contact up to 700°C,
- the set does not scratch pipes polished from the inside,
- for pipes made of any type of steel,
- materials with low porosity were used for construction,
- for passing through the elbows, open ball valves, etc.,
- easy and quick to place in the pipe,
- it is not possible to tear the bladders due to excessive pressure,
- purging time is a fraction of the time needed for traditional cleaning methods,
- low cost compared to other blocking systems,
- return on investment in a short time.

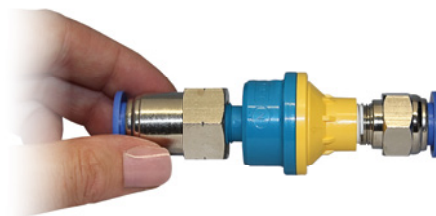
Range of application [mm]	Nominal pipe size [inch / mm]	Catalogue No. / Manufacturer's code
32-45	1,5"/25	50 72 100300 / PL0001,5
38-64	2"/50	50 72 100302 / PL0002
64-89	3"/75	50 72 100303 / PL0003
89-114	4"/100	50 72 100304 / PL0004
114-140	5"/125	50 72 100305 / PL0005
140-165	6"/150	50 72 100306 / PL0006
165-191	7"/175	50 72 100307 / PL0007
191-216	8"/200	50 72 100308 / PL0008
241-267	10"/250	50 72 100310 / PL0010
292-318	12"/300	50 72 100312 / PL0012
343-368	14"/350	50 72 100314 / PL0014
394-419	16"/400	50 72 100316 / PL0016
445-470	18"/450	50 72 100318 / PL0018
495-521	20"/500	50 72 100320 / PL0020
521-546	21"/525	50 72 100322 / PL0021
546-572	22"/550	50 72 100324 / PL0022
572-597	23"/575	50 72 100326 / PL0023
597-622	24"/600	50 72 100328 / PL0024

### Advantages of PurgElite® systems in comparison to older versions:

- without metal parts that can scratch the pipe,
- no more wasting time on valve calibration,
- no possibility of bursting bladders due to incorrect valve setting or excessive gas flow,
- reflective centering tape to facilitate proper positioning of the set relative to the connector,
- heat shields for PurgElite® sets in sizes 1-12" are also available.

**Valve PurgGate®** - protects the bladders from rupture due to excessive argon pressure. Terminated with quick connectors for the PurgElite® set and the argon hose.

Catalogue No. / Manufacturer's code: 50 72 100000 / APGV001





Scan the link or go to <https://www.rywal.eu/f01-6>

## Argweld Quick Purge® III Weld Purge System

### Properties:

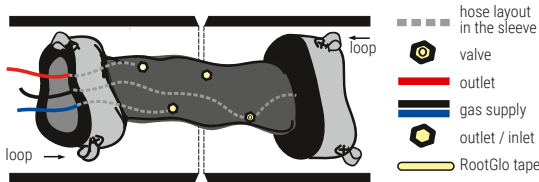
- more advanced solution than the PurgElite® systems,
- recommended for larger pipe diameters,
- the built-in IntaCal regulator allows for safe filling and draining of gas from bubbles,
- balloons connected by a sealed sleeve.



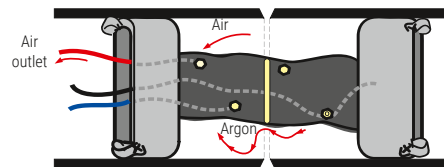
### How to use the Argweld® Weld Purge Systems in a pipe.

(drawings suitable for PurgElite® and Quick Purge® III sets)

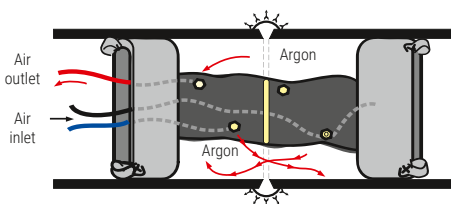
1. Place the ARGWELD® bladders in the pipeline as shown below. The bladders must be placed symmetrically in relation to the joint. The relief valve should be located at the bottom (heavier argon displaces air), diffusers in the highest position. RootGlo tape can be used to find the center of the set.



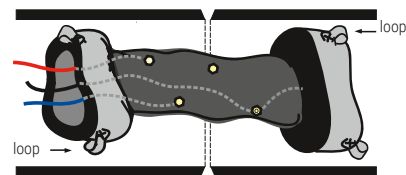
2. Open the argon flow. The bladders will fill up, excess gas gets into the space between the balloons. At the outlet of gas from the system (a mixture of air and blown out argon) an oxygen purge monitor must be placed, for example PurgeEye® 100 IP65.



3. After achieving an adequate purity of the gas surrounding the weld confirmed by the purge monitor measurements, welding can be started. It is possible to accelerate air removal by supplying argon using an additional hose connected to the set. The PurgeEye® Purge Monitor needle can be used to determine the oxygen content in the shielding gas. In order to limit the outflow of argon through the joint, the edges should be covered with a special aluminium foil (50 50 000030).



4. Removal of bladders from the pipe. At the end of welding and after the time necessary for the argon shield of the cooling weld, gas is released from the bubbles and removed from the pipe. You can proceed to the next seam.



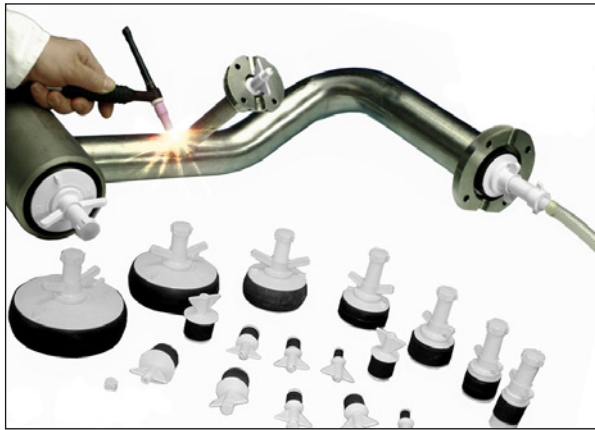
Range of application [mm]	Nominal pipe size [inch / mm]	Catalogue No. / Manufacturer's code
140-165	6"/150	50 72 100082 / APSQ006
165-191	7"/175	50 72 100084 / APSQ007
191-216	8"/200	50 72 100085 / APSQ008
216-241	9"/225	50 72 100100 / APSQ009
241-267	10"/250	50 72 100105 / APSQ010
267-292	11"/275	50 72 100107 / APSQ011
292-318	12"/300	50 72 100125 / APSQ012
318-343	13"/325	50 72 100130 / APSQ013
343-368	14"/350	50 72 100145 / APSQ014
368-394	15"/375	50 72 100155 / APSQ015
394-419	16"/400	50 72 100165 / APSQ016
419-445	17"/425	50 72 100170 / APSQ017
445-470	18"/450	50 72 100185 / APSQ018

Range of application [mm]	Nominal pipe size [inch / mm]	Catalogue No. / Manufacturer's code
470-495	19"/475	50 72 100195 / APSQ019
495-521	20"/500	50 72 100205 / APSQ020
521-546	21"/525	50 72 100210 / APSQ021
546-572	22"/550	50 72 100225 / APSQ022
572-597	23"/575	50 72 100230 / APSQ023
597-622	24"/600	50 72 100245 / APSQ024
622-648	25"/625	50 72 100250 / APSQ025
648-673	26"/650	50 72 100265 / APSQ026
673-699	27"/675	50 72 100270 / APSQ027
699-724	28"/700	50 72 100285 / APSQ028
724-749	29"/725	50 72 100295 / APSQ029
749-775	30"/750	5072 100297 / APSQ030
Bigger diameters we offer on request(max 96"/2400 mm)		

Some Purge Systems are available in HotPurge® heat-resistant versions (from 6" to 88") and are able to withstand temperatures up to 300°C for 24h. Used for P91 and similar steels welding.



## Pipe Plugs and Stoppers



Sealing plugs are suitable for a wide range of applications in industry, maintenance, craft services, etc. They are most often used for sealing pipes with argon shielding inside the pipe, low pressure water tests, heating pipes and fibre optics.

### Advantages of pipe plugs:

- range up to 900 mm (36"),
- high quality materials: nylon (up to 150 mm - 6") and aluminium castings (up to 900 mm - 36"),
- the ability to effectively seal pipes with uneven or cracked walls,
- easy cleaning: concrete, mortar, etc.; they do not stick to the plug, the plugs do not corrode,
- easy expansion and minimum tightening force is provided by a special copolymer washer located between the wing nut and the plug wall,
- larger plug sizes have additional stiffening ribs.

Solid plugs for pipes			
Size	Scope of application	Manufacturer no.	Catalogue No.
13 mm plug	14-19 mm	PSP1013	50 72 008050
19 mm plug	18-25 mm	PSP1019	50 72 008075
25 mm plug	24-36 mm	PSP1025	50 72 008100
32 mm plug	30-44 mm	PSP1032	50 72 008125
38 mm plug	37-54 mm	PSP1038	50 72 008150

Hollow shaft small bore plugs a 10 mm connection			
Size	Scope of application	Manufacturer no.	Catalogue No.
13x10 mm plug	13-19 mm	PSP113H	50 72 008055
19x10 mm plug	18-25 mm	PSP119H	50 72 008080
25x10 mm plug	23-36 mm	PSP125H	50 72 008105
32x10 mm plug	30-43 mm	PSP132H	50 72 008127
38x10 mm plug	36-50 mm	PSP138H	50 72 008160

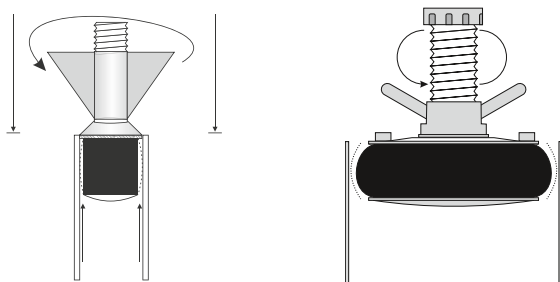
Hollow shaft small bore plugs a 13 mm connection			
Size	Scope of application	Manufacturer no.	Catalogue No.
38x13 mm/1½" plug	36-53 mm	PSP2038	50 72 009015
50x13 mm/2" plug	49-64 mm	PSP2050	50 72 009020
63x13 mm/2½" plug	63-76 mm	PSP2063	50 72 009022
75x13 mm/3" plug	73-88 mm	PSP2075	50 72 009025
100x13 mm/4" plug	92-100 mm	PSP2100	50 72 009040
125x13 mm/5" plug	119-142 mm	PSP2125	50 72 009050
150x13 mm/6" plug	145-164 mm	PSP2150	50 72 009060



Aluminium plugs for pipes with a 13 mm connection			
Size	Scope of application	Manufacturer no.	Catalogue No.
Al. plug 40x13 mm/1½"	38-50 mm	PSP3040	50 72 009340
Al. plug 50x13 mm/2"	49-62 mm	PSP3050	50 72 009350
Al. plug 60x13 mm/2½"	62-77 mm	PSP3060	50 72 009360
Al. plug 75x13 mm/3"	73-89 mm	PSP3075	50 72 009375
Al. plug 85x13 mm/3½"	84-103 mm	PSP3085	50 72 009385
Al. plug 100x13 mm/4"	94-110 mm	PSP3100	50 72 009388
Al. plug 115x13 mm/4½"	112-130 mm	PSP3115	50 72 009390
Al. plug 125x13 mm/5"	125-142 mm	PSP3125	50 72 009393
Al. plug 150x13 mm/6"	146-168 mm	PSP3150	50 72 009395

Aluminium plugs for pipes with a 25 mm connection			
Size	Scope of application	Manufacturer no.	Catalogue No.
Al. plug 175x25 mm/7"	175-200 mm	PSP4175	50 72 009417
Al. plug 200x25 mm/8"	193-220 mm	PSP4200	50 72 009420
Al. plug 225x25 mm/9"	220-240 mm	PSP4225	50 72 009422
Al. plug 250x25 mm/10"	245-279 mm	PSP4250	50 72 009425
Al. plug 300x25 mm/12"	295-325 mm	PSP4300	50 72 009430
Al. plug 350x25 mm/14"	350-385 mm	PSP4350	50 72 009435
Al. plug 400x25 mm/16"	390-435 mm	PSP4400	50 72 009440







## ARGWELD® flexible welding enclosures



ARGWELD® flexible welding enclosures have been designed for use wherever economic reasons do not justify the use of permanent welding chambers.

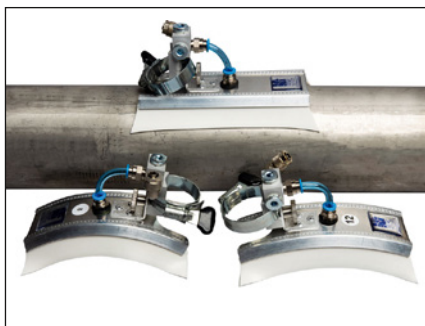
### Typical applications of ARGWELD® flexible welding enclosures:

- "occasional" welding of titanium components (mainly for the needs of the aviation industry),
- welding acid-resistant steel (mainly for the needs of the medical and automotive equipment industry) to eliminate costly purging of the discoloured weld area.

Enclosure diameter	Catalogue No.	Manufacturer No.
36"-914 mm	50 72 001090	AFE0900
48"-1219 mm	50 72 001120	AFE0120
60"-1524 mm	50 72 001150	AFE0150
70"-1778 mm	50 72 001180	AFE0180

In addition to the models presented above, it is possible to supply chambers according to requirements of the customer.

## ARGWELD® Weld Trailing Shields



It is used to provide better argon shielding for the cooling weld, for example when welding stainless steel or titanium. They are mounted on the TIG torch nozzle and connected with an independent argon hose. During welding, the shield slides over the weld for longer to isolate it from air. Argon is fed to a cooling weld through a special sieve.

### Trailing Shields are available in three models:

- for flat welds in manual welding,
- for manual welding inside pipes and vessels,
- for manual welding outside pipes and vessels,
- when ordering please declare model, diameter and type of TIG torch.

## Aluminium tape

Welding aluminium adhesive tape is used to seal pipe joints before TIG welding if the pipeline is filled with forming gas. During welding, the welder gradually peels off the tape, thus avoiding gas losses from the inside of the pipe. The applied adhesive and aluminium foil withstand the conditions arising during welding and guarantee the cleanliness of the obtained welds. The tape is glued with paper, and is available in 50 mm x 45 m size.

Catalogue No.: 50 50 000030



## Argweld® Weld Backing Tape

Argweld® Weld Backing Tapes are used for the correct performance of root weld in place of, e.g. ceramic backings. They consist of a fiberglass tape glued onto self-adhesive aluminium tape. The molten metal is deposited directly onto the fibre without undesirable slag. They are mainly used for welding tanks using the TIG method. Depending on the maximum welding current, 80 A, 160 A, 240 A and 600 A tapes can be distinguished.



### Advantages of Weld Backing Tapes:

- suitable for sheet metal, pipes and tanks,
- make it possible to avoid additional welding and machining,
- eliminate gouging and grinding,
- welding without welding defects,
- for all welding positions.

Type	Manufacturer no.	Catalogue No.
80 A Weld Backing Tape (25 m roll)	ABT0004	50 72 010098
160 A Weld Backing Tape (12,5 m roll)	ABT0005	50 72 020000
240 A Weld Backing Tape (12,5 m roll)	ABT0006	50 72 020002
600 A Weld Backing Tape (12,5 m roll)	ABT0007	50 72 020004

## ▼ 7.2. Ridge forming powder



### SOLAR FLUX TYPE B

#### Properties:

- flux applied as an aid in welding high alloy steels (nickel content above 25%),
- for welding of medium and low-alloy steels to obtain a joint with high durability and usage quality with difficult or impossible access from the ridge side,
- it eliminates the need for pads forming the weld ridge, as well as the gas shield used on the ridge side to protect liquid metal from oxidation.



Package: 450 g  
 Catalogue No.: 84 40 000010  
 (export label): 84 40 000011

## ▼ 7.3. Ceramic backing tapes



### MOST ceramic backing tapes



Scan the link or go to  
<https://www.rywal.eu/f01-7>

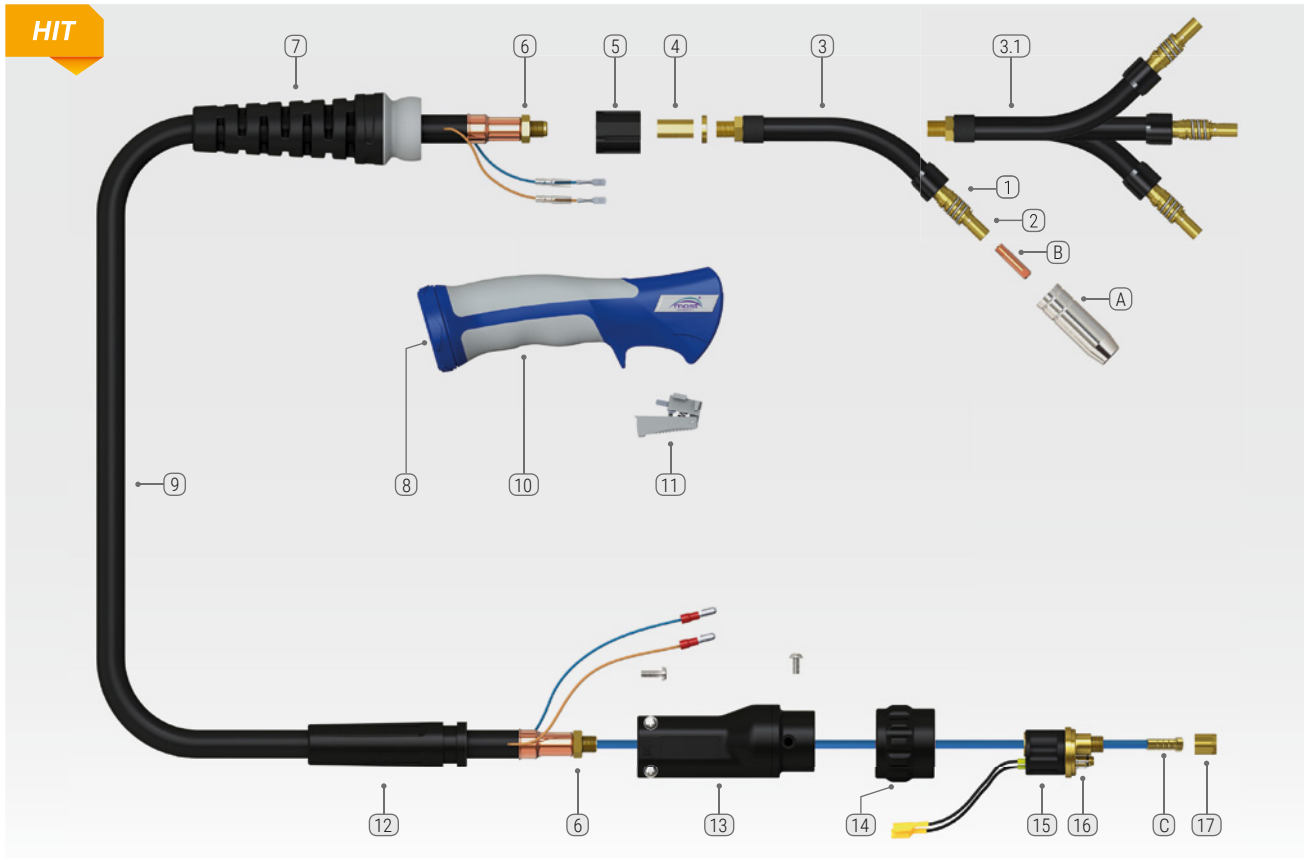
No.	Type - dimensions [mm]	Length	Remark
1	<p>MOST LT05 TIA</p>	<p>600 mm            24 seg x 25 mm</p>	<p>The 25 mm segment of the pad are fixed on 85 mm wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs.            Catalogue No.: 50 49 500550</p> <p><b>For welding with solid wire or metallic powder.</b></p>
2	<p>MOST LT05-6 TIA</p>	<p>600 mm            24 seg x 25 mm</p>	<p>The 25 mm segment of the pad are fixed on 85 mm wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs.            Catalogue No.: 50 49 500560</p> <p><b>For welding with solid wire or metallic powder.</b></p>
3	<p>MOST LT 05TT TIA</p>	<p>600 mm            24 seg x 25 mm</p>	<p>The 25 mm segment of the pad are fixed on 85 mm wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs.            Catalogue No.: 50 49 500500</p> <p><b>For welding with powder wire or coated electrode.</b></p>
4	<p>MOST LT 06 TIA</p>	<p>600 mm            24 seg x 25 mm</p>	<p>The 25 mm segment of the pad are fixed on 85 mm wide self-adhesive aluminium tape.</p> <p><b>Packaging / Catalogue No.:</b>            Ø6,0 mm - 250 pcs. - 50 49 500060            Ø8,0 mm - 160 pcs. - 50 49 500080            Ø10,0 mm - 120 pcs. - 50 49 500100            Ø12,0 mm - 100 pcs. - 50 49 500120            Ø15,0 mm - 75 pcs. - 50 49 500150</p>

▼ 8. WELDING TORCHES AND ACCESSORIES

▼ 8.1. MIG/MAG torches



M15 SGRIP



Model	M15 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	180 A - CO <sub>2</sub> 150 A - mix M21
▪ Wire diameter	0,6-1,0 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 301530 (4,0 m) 55 08 301540 (5,0 m) 55 08 301550

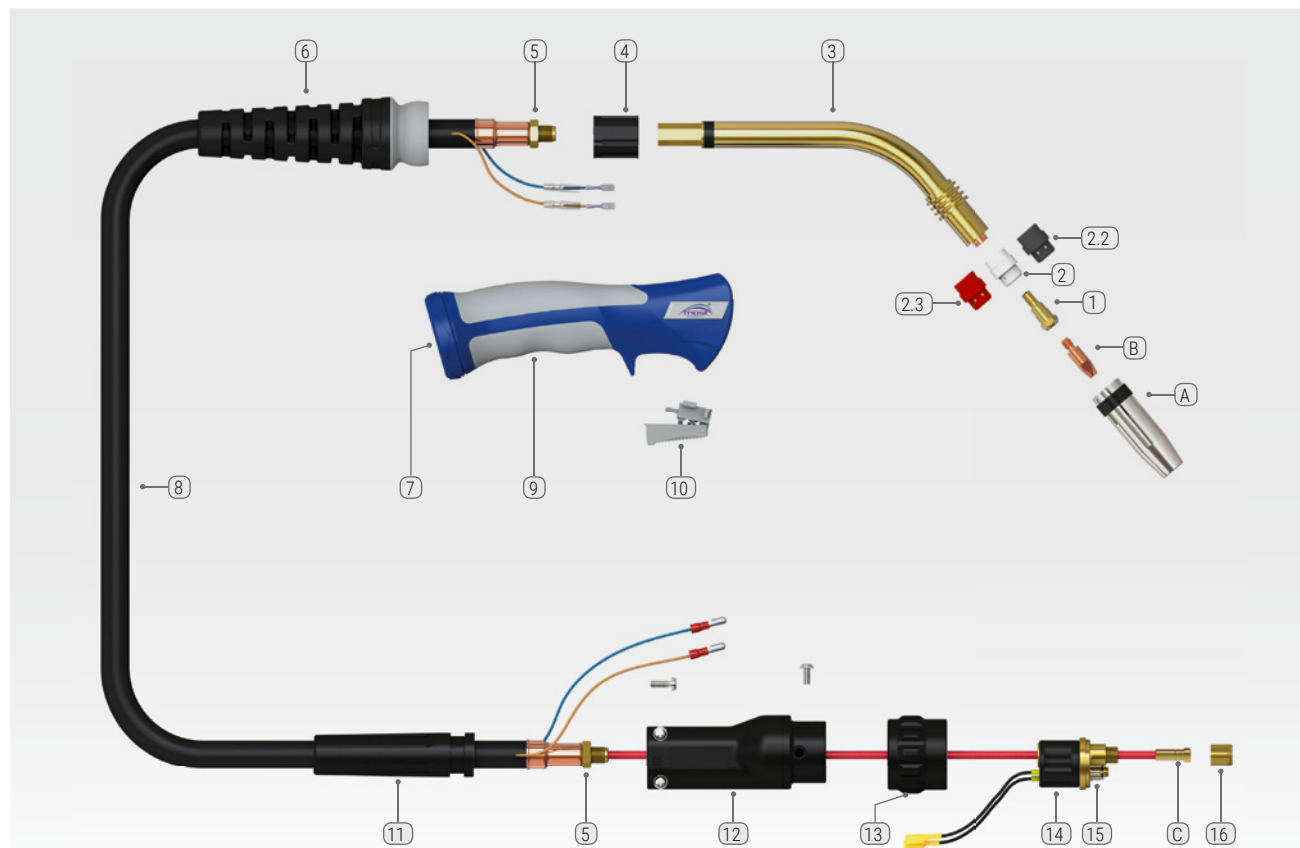
No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle Ø16	55 12 300885
	Conical gas nozzle Ø12*	55 12 300890
	Conical gas nozzle Ø9,5	55 12 300880
	Spot welding gas nozzle	55 12 300882
1	Spring*	55 13 008340
2	Contact tip holder with spring	55 13 003751
3	M-15 without nozzle and tip*	55 13 014060
3.1	M-15 flexible swan neck without nozzle and tip	55 13 01406F

No.	Replaceable elements	Catalogue No.
4	Intermediate adapter, brass	55 13 003760
5	Connector body	55 13 013258
6	M10x1 low nut	55 13 004309
7	MOST torch stiffener M15/25 UG8015	55 13 006834
8	MOST torch nut UG8008	55 13 006837
9	Welding cable combined 3 m	55 13 016090
9.1	Welding cable combined 4 m	55 13 016091
9.2	Welding cable combined 5 m	55 13 016092
10	MOST torch grip M GRIP UG2514/K/J/B	55 13 006515
11	MOST trigger M15/501 UG2516	55 13 006517
12	MOST stiffener for euro plug UC2841 M15 / 25	55 13 006835
13	MOST euro plug connector M15/36 UC1518	55 13 006518
14	MOST euro plug nut M15/501 UC1519	55 13 006519
15	Integrated connector UC1528	55 13 006569
16	O-ring 4x1	55 13 013962
17	Special insert nut	55 13 004300
B	M6x25 contact tip	(table p. 54)
C	Liners	(table p. 54)

\* standard version



## M24 SGRIP



Model	M24 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	250 A - CO <sub>2</sub> 220 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 302430 (4,0 m) 55 08 302440 (5,0 m) 55 08 302450

No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 17x63,5 Conical gas nozzle 12,5x63,5* Conical gas nozzle 10x63,5	55 12 300897 55 12 300895 55 12 300896
1	M6* contact tip holder	55 13 003800
2	M-24 gas diffuser ceramic white*	55 13 009460
2.1	M-24 gas diffuser, white	55 13 009465
2.2	M-24 gas diffuser, black	55 13 009464
2.3	M-24 silicone gas diffuser	55 13 009467

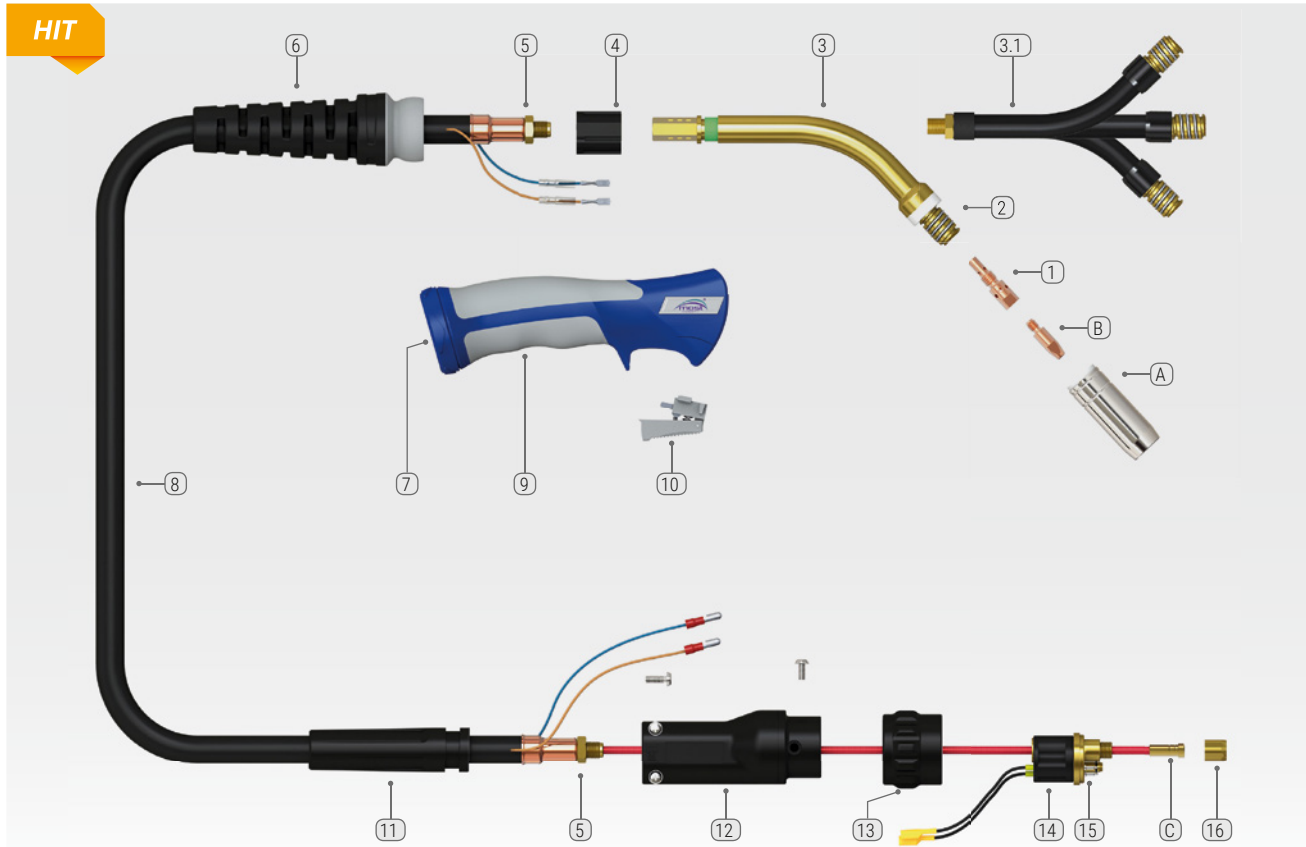
No.	Replaceable elements	Catalogue No.
3	M24 swan neck	55 13 014063
4	Connector body	55 13 013258
5	M10x1 low nut	55 13 004309
6	MOST torch stiffener M24/M36 UG8016	55 13 006832
7	MOST torch nut UG8008	55 13 006837
8	MOST welding cable M24 3 m	55 13 016093
8.1	MOST welding cable M24 4 m	55 13 016094
8.2	MOST welding cable M24 5 m	55 13 016095
9	MOST torch grip M GRIP UG2514/KJ/B	55 13 006515
10	MOST trigger M15/501 UG2516	55 13 006517
11	MOST stiffener for euro plug M15/25 UC2841	55 13 006835
12	MOST euro plug connector M24/36 UC3641	55 13 006833
13	MOST euro plug nut M15/25 UC1519	55 13 006519
14	Integrated connector UC1528	55 13 006569
15	O-ring 4x1	55 13 013962
16	Special insert nut	55 13 004300
B	M6x28 contact tip	(table p. 54)
C	Liners	(table p. 54)

\* standard version





M25 SGRIP



Model	M25 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	230 A - CO <sub>2</sub> 200 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 302530 (4,0 m) 55 08 302540 (5,0 m) 55 08 302550

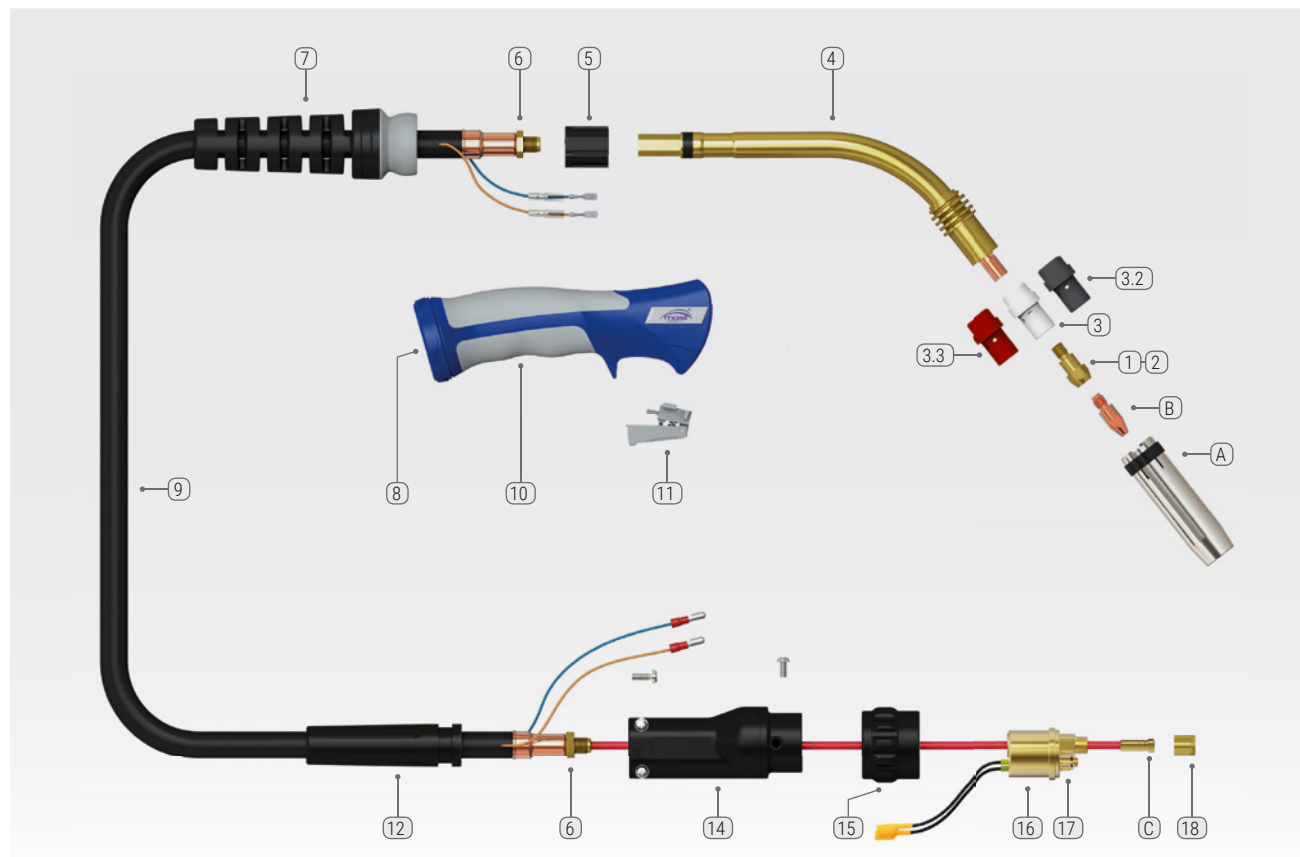
No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 18x57	55 12 300901
	Conical gas nozzle 15x57*	55 12 300900
	Conical gas nozzle 11,5x57	55 12 300904
	Spot welding gas nozzle	55 12 300903
1	M25* contact tip holder	55 13 003804
2	M25* spring	55 13 008360
3	M-25 without nozzle and tip*	55 13 014072
3.1	M-25 flexible swan neck without nozzle and tip	55 13 01407F

No.	Replaceable elements	Catalogue No.
4	Connector body	55 13 013258
5	M10x1 low nut	55 13 004309
6	MOST torch stiffener M15/25 UG8015	55 13 006834
7	MOST torch nut UG8008	55 13 006837
8	Welding cable M-25 3 m	55 13 016093
8.1	Welding cable M-25 4 m	55 13 016094
8.2	Welding cable M-25 5 m	55 13 016095
9	MOST torch grip MSGRIP UG 2514/KJ/B	55 13 006515
10	MOST trigger M15/501 UG2516	55 13 006517
11	MOST stiffener for euro plug M15/25 UC2841	55 13 006835
12	MOST euro plug connector M15/36 UC1518	55 13 006518
13	MOST euro plug nut M15/501 UC1519	55 13 006519
14	Integrated connector	55 13006569
15	O-ring 4x1	55 13 013962
16	Special insert nut	55 13 004300
B	M6x28 contact tip	(table p. 54)
C	Liners	(table p. 54)

\* standard version



## M36 SGRIP



Model	M36 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	320 A - CO <sub>2</sub> 290 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 303630 (4,0 m) 55 08 303640 (5,0 m) 55 08 303650

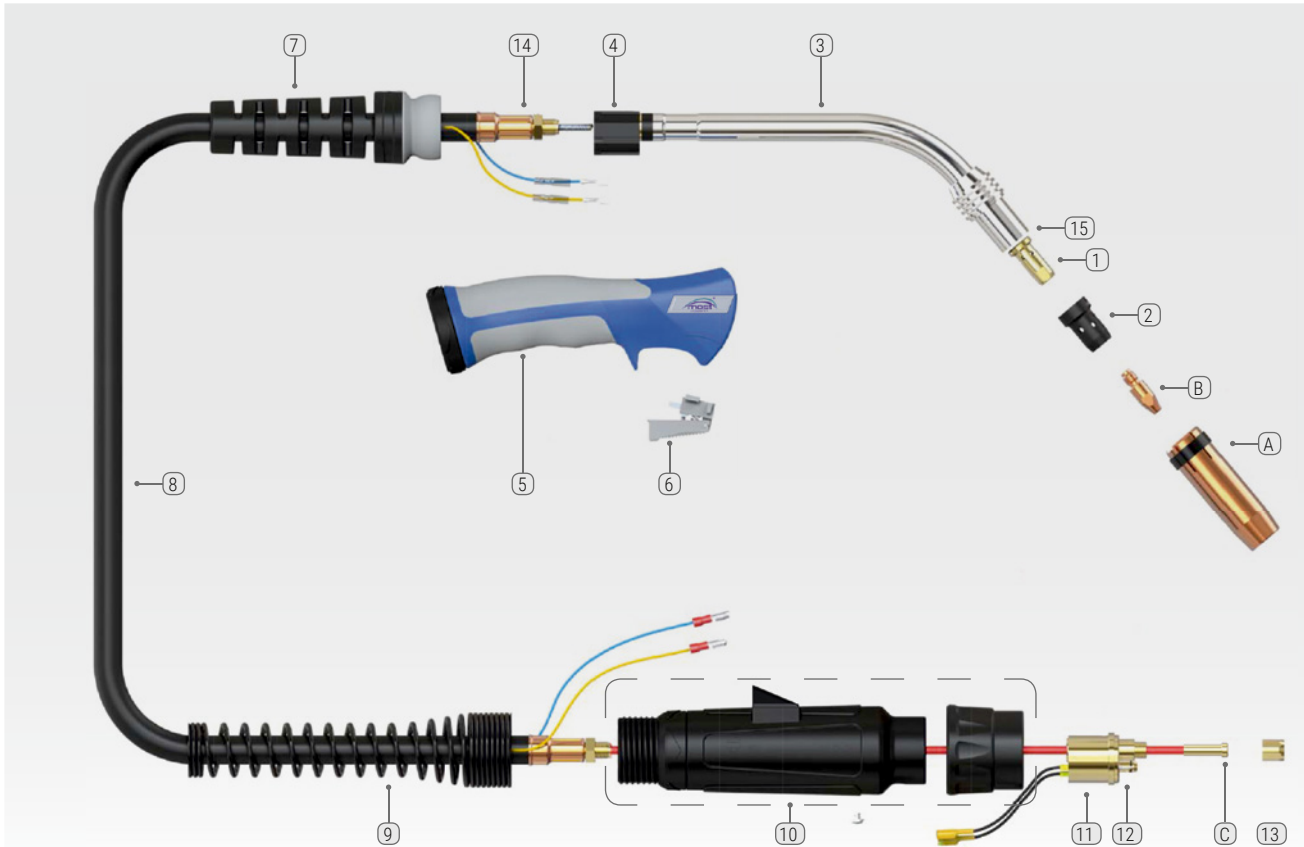
No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 19x84 Conical gas nozzle 16x84* Conical gas nozzle 12x84 Spot welding gas nozzle	55 12 300915 55 12 300910 55 12 300914 55 12 300917
1	M6x28* contact tip holder	55 13 003806
2	M8x28 contact tip holder	55 13 003816
3	M-36 gas diffuser ceramic white*	55 13 009486
3.1	M-36 gas diffuser, white	55 13 009485
3.2	M-36 gas diffuser, black	55 13 009484
3.3	M-36 silicone gas diffuser	55 13 00948S

No.	Replaceable elements	Catalogue No.
4	M36 swan neck	55 13 014080
5	Connector body	55 13 013258
6	M10x1 low nut	55 13 004309
7	MOST torch stiffener M36 UG8016	55 13 006832
8	MOST torch nut UG8008	55 13 006837
9	Welding cable M36 3 m	55 13 016096
9.1	Welding cable M36 4 m	55 13 016097
9.2	Welding cable M36 5 m	55 13 016098
10	MOST torch grip MSGRIP UG2514/KJ/B	55 13 006515
11	MOST trigger M15/501 UG2516	55 13 006517
12	MOST stiffener for euro plug M36 UC3641	55 13 006833
14	MOST euro plug connector M15/36 UC1518	55 13 006518
15	MOST euro plug nut M15/501 UC1519	55 13 006519
16	Integrated connector	55 13 006569
17	O-ring 4x1	55 13 013962
18	Special insert nut	55 13 004300
B	M6x28 contact tip	(table p. 54)
C	Liners	(table p. 54)

\* standard version



**M38 SGRIP**



Model	M38 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	350 A - CO <sub>2</sub> 320 A - mix M21
▪ Wire diameter	1,0-1,6 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 303830 (4,0 m) 55 08 303840 (5,0 m) 55 08 303850

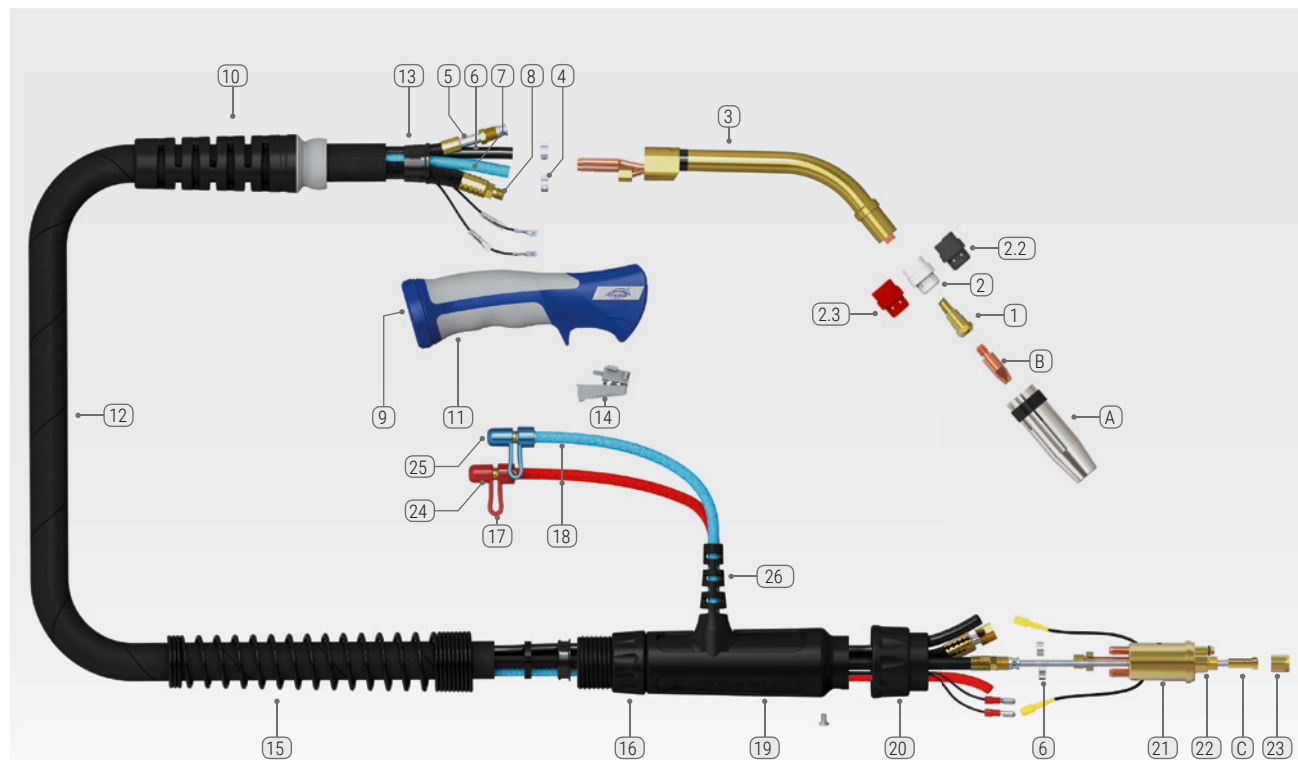
No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 20x76	55 13 000610
	Conical gas nozzle 16x76* heavy duty	55 13 000617
	Conical gas nozzle 16x76	55 13 000600
	Conical gas nozzle 14x76	55 13 000615
	Spot welding gas nozzle	55 13 000613
1	M8 M38 UB3812* contact tip holder	55 13 003820
2	M38 gas diffuser, black UB5005H*	55 13 009483
2.1	401/501 gas diffuser, white	55 13 009491

No.	Replaceable elements	Catalogue No.
3	M38 UG3801* swan neck	55 13 014079
4	Connector body	55 13 013258
5	MOST torch grip MSGRIP RYG2514	55 13 006515
6	MOST trigger M15/501 UG2516	55 13 006517
7	MOST torch stiffener UG8016	55 13 006832
8	Welding cable M38 3 m	55 13 016099
8.1	Welding cable M38 4 m	55 13 016100
8.2	Welding cable M36 5 m	55 13 016101
9	MOST stiffener for euro plug M38 UC8026	55 13 006841
10	MOST euro plug connector with UPA38030EB nut	55 13 006523
11	Integrated connector	55 13 006569
12	O-ring 4x1	55 13 013962
13	Special insert nut	55 13 004300
14	Low nut M10x1	55 13 004309
15	Insulated washer 401/501	55 13 013966
B	M8x30 contact tip	(table p. 54)
C	Liners coated	(table p. 54)

\* standard version



## M240 SGRIP



Model	M240 SGRIP
<b>Cooling</b>	Liquid
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 100% duty cycle	300 A - CO <sub>2</sub> 270 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 304243 (4,0 m) 55 08 304244 (5,0 m) 55 08 304245

No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 17x63,5 Conical gas nozzle 12,5x63,5* Conical gas nozzle 10x63,5	(3 m) 55 12 300897 (4 m) 55 12 300895 (5 m) 55 12 300896
1	M6* contact tip holder	55 13 003800
2	M-24 gas diffuser ceramic white*	55 13 009460
2.1	M-24 gas diffuser, white	55 13 009465
2.2	M-24 gas diffuser, black	55 13 009464
2.3	M-24 silicone gas diffuser	55 13 009467
3	M240 swan neck	55 13 014082
4	GER 9,5 clamp	50 15 000095
5	Insert-on cable	(3 m) 55 13 006503 (4 m) 55 13 006504 (5 m) 55 13 006505
6	Black gas pipe	55 13 015370 (m)
7	Blue hose 5x1,5	51 13 007120 (m)

No.	Replaceable elements	Catalogue No.
8	Power-water cable	(3 m) 55 13 015968 (4 m) 55 13 015969 (5 m) 55 13 015970
9	MOST torch nut UG8008	55 13 006837
10	MOST torch stiffener 401/501 UG 3208	55 13 006831
11	MOST torch grip MSGRIP UG2514/KJ/B	55 13 006515
12	External cable cover set	(3 m) 55 13 015530 (4 m) 55 13 015531 (5 m) 55 13 015532
12.1	External cable cover	51 13 007201 (m)
13	MOST rim 401/501 UG 8010	55 13 006839
14	MOST trigger M15/501 UG2516	55 13 006517
15	MOST M401/501 euro plug spring	55 13 006827
16	MOST euro plug spring nut M36/501	55 13 006828
17	Quick coupling plug ø6	50 14 182003
18	Red hose 5x15	51 13 007115
18.1	Blue hose 5x1,5	51 13 007120
19	MOST euro plug cover M401/501	55 13 006522
20	MOST euro plug nut M15/501 B1519	55 13 006519
21	Integrated water connector UB5098	55 13 006570
22	O-ring 4x1	55 13 013962
23	Special insert nut	55 13 004300
24	UBD 80310 red plug	55 13 006838
25	UBD 80320 blue plug	55 13 006840
26	Cable stiffener	55 13 006524
B	Contact tip M6x28	(table p. 54)
C	Liners	(table p. 54)

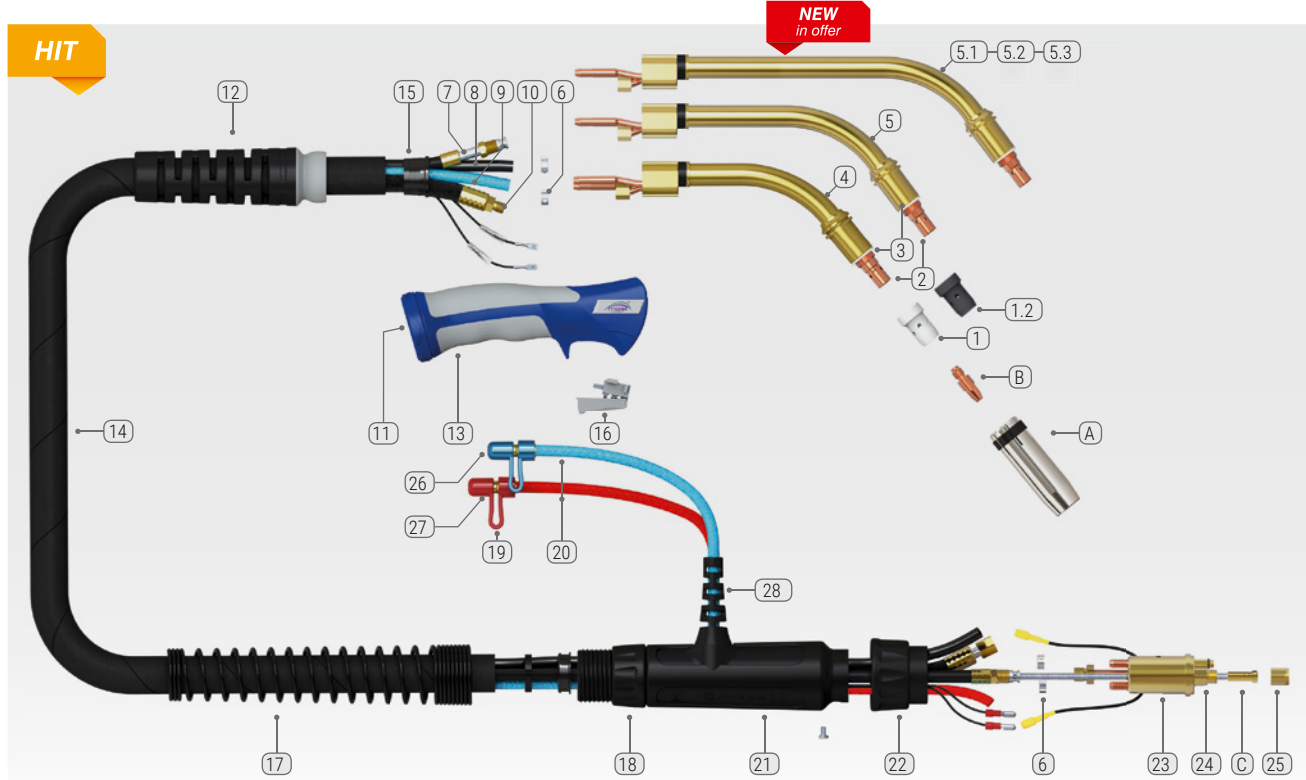
We recommend using special coolants as on page 16.

\* standard version





M401 SGRIP / M501 SGRIP



Model	M401 SGRIP	M 501 SGRIP
<b>Cooling</b>	Liquid	Liquid
<b>Technical data according to EN 60 974-7:</b>		
▪ Rating 100% duty cycle	400 A - CO <sub>2</sub> 350 A - mix M21	500 A - CO <sub>2</sub> 450 A - mix M21
▪ Wire diameter	0,8-1,6 mm	0,8-1,6 mm
<b>Length / Catalogue No.</b>	3,0 m/55 08 304013 4,0 m/55 08 304014 5,0 m/55 08 304015	3,0 m/55 08 305013 4,0 m/55 08 305014 5,0 m/55 08 305015

No.	Replaceable elements	Catalogue No.
7	<b>Insert-on cable</b>	(3 m) 55 13 006503 (4 m) 55 13 006504 (5 m) 55 13 006505
8	<b>Black gas pipe</b>	55 13 015370 (m)
9	<b>Blue hose 5x1,5</b>	51 13 007120 (m)
10	<b>Power water cable</b>	(3 m) 55 13 015968 (4 m) 55 13 015969 (5 m) 55 13 015970
11	<b>MOST torch nut UG8008</b>	55 13 006837
12	<b>MOST torch stiffener 401/501 UG 3208</b>	55 13 006831
13	<b>MOST torch grip MSGRIP UG2514/KJ/B</b>	55 13 006515
14	<b>External cable cover set</b>	(3 m) 55 13 015530 (4 m) 55 13 015531 (5 m) 55 13 015532
14.1	<b>External cable cover</b>	51 13 007201 (m)
15	<b>MOST Rim 401/501 UG 8010</b>	55 13 006830
16	<b>MOST trigger M15/501 UG2516</b>	55 13 006517
17	<b>MOST euro plug spring M401/501</b>	55 13 006827
18	<b>MOST euro plug spring nut M36/501</b>	55 13 006828
19	<b>Quick coupling plug for hose Ø6</b>	50 14 182003
20	<b>Red hose 5x15</b>	51 13 007115
20.1	<b>Blue hose 5x1,5</b>	51 13 007120
21	<b>MOST euro plug connector M401/501</b>	55 13 006522
22	<b>MOST euro plug nut M15/501 B1519</b>	55 13 006519
23	<b>Integrated water connector UB5098</b>	55 13 006570
24	<b>O-ring 4x1</b>	55 13 013962
25	<b>Special insert nut</b>	55 13 004300
26	<b>UBD 80310 red plug</b>	55 13 006838
27	<b>UBD 80320 blue plug</b>	55 13 006840
28	<b>Cable stiffener</b>	55 13 006524
B	<b>M8x30 contact tip</b>	(table p. 54)
C	<b>Liners</b>	(table p. 54)

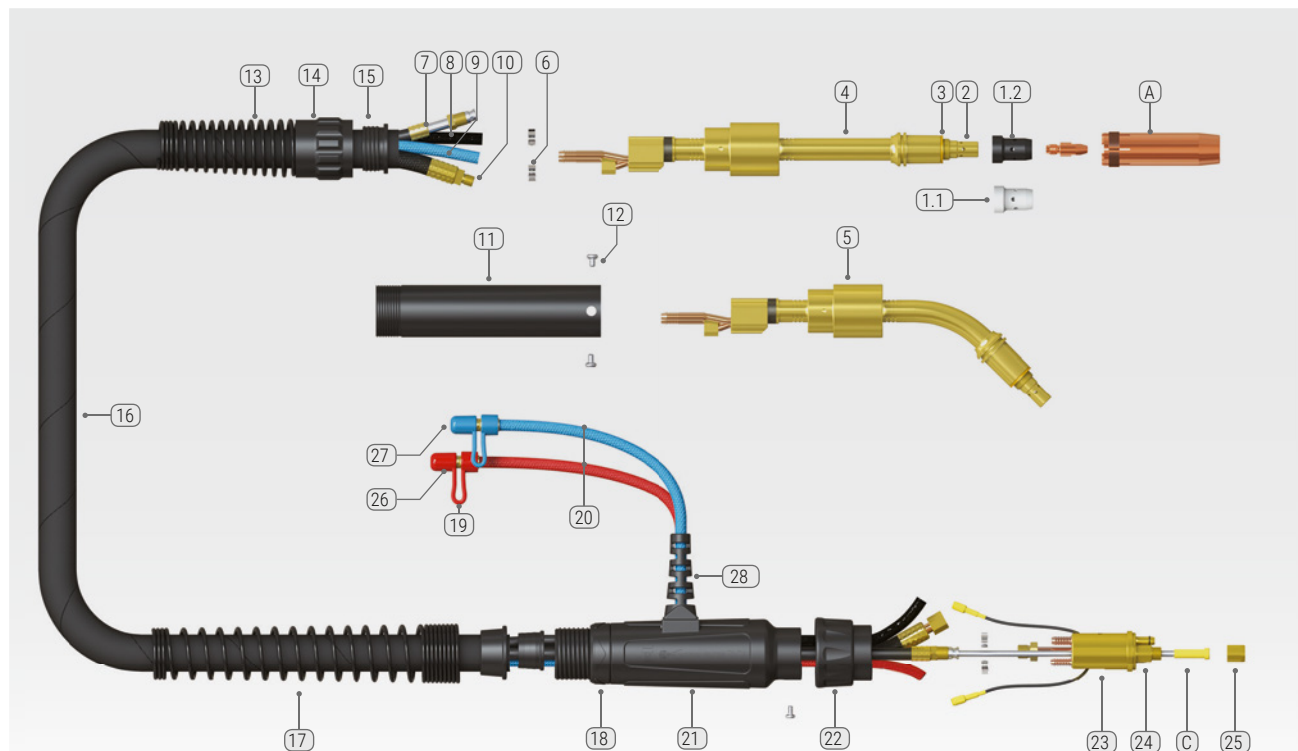
No.	Replaceable elements	Catalogue No.
A	<b>Straight gas nozzle 20x76</b> <b>Conical gas nozzle 16x76*</b> <b>Conical gas nozzle 14x76</b> <b>Reinforced conical gas nozzle 16x76 HD</b>	55 13 000610 55 13 000600 55 13 000615 55 13 000617
1	<b>401/501 gas diffuser ceramic white*</b>	55 13 009493
1.1	<b>401/501 gas diffuser white</b>	55 13 009491
1.2	<b>401/501 gas diffuser black</b>	55 13 009498
2	<b>M401/501 M6x25 contact tip holder</b>	55 13 003991
2.1	<b>M401/501 M6x29 contact tip holder</b>	55 13 003993
2.2	<b>M401/501 M8x25* contact tip holder</b>	55 13 003990
2.3	<b>M401/501 M8x29 contact tip holder</b>	55 13 003992
3	<b>Insulating washer M401/501</b>	55 13 013966
4	<b>M401 SGRIP* swan neck</b>	55 13 014086
5	<b>M501 SGRIP* swan neck</b>	55 13 014096
5.1	<b>M501L swan neck L=300 mm</b>	55 13 01409A
5.2	<b>M501XL swan neck L=400 mm</b>	55 13 01409B
5.3	<b>M501XXL swan neck L=500 mm</b>	55 13 01409C
6	<b>GER 9,5 clamp</b>	50 15 000095

We recommend using special coolants as on page 16.

\* standard version



## AT501



Model	AT501
<b>Cooling</b>	Liquid
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 100% duty cycle	500 A - CO <sub>2</sub> 450 A - mix M21
▪ Wire diameter	0,8-1,6 mm
<b>Length / Catalogue No.</b>	straight - (3,0 m) 55 08 305030 45° - (3,0 m) 55 08 305035 straight - (4,0 m) 55 08 305040 45° - (4,0 m) 55 08 305045 straight - (5,0 m) 55 08 305050 45° - (4,0 m) 55 08 305055

No.	Replaceable elements	Catalogue No.
A	Straight gas nozzle 20x76 Conical gas nozzle 16x76* Conical gas nozzle 14x76 Reinforced conical gas nozzle 16x76 HD	55 13 000610 55 13 000600 55 13 000615 55 13 000617
1	401/501 gas diffuser ceramic white*	55 13 009493
1.1	401/501 gas diffuser white	55 13 009491
1.2	401/501 gas diffuser black	55 13 009498
2	M401/501 M6x25 contact tip holder	55 13 003991
2.2	M401/501 M8x25* contact tip holder	55 13 003990
3	Insulating washer M401/501	55 13 013966
4	Swan neck AT501 straight	55 13 006854
5	Swan neck AT501 45°	55 13 006855
6	GER 9,5 clamp	50 15 000095
7	Insert-on cable	(3 m) 55 13 006503 (4 m) 55 13 006504 (5 m) 55 13 006505
8	Black gas pipe	55 13 015370 (m)

No.	Replaceable elements	Catalogue No.
9	Blue hose 5x1,5	51 13 007120 (m)
10	Power-water cable	(3 m) 55 13 015968 (4 m) 55 13 015969 (5 m) 55 13 015970
11	AT501 UB3630 handle grip	55 13 006850
12	AT501 UB3629 handle screw	55 13 006851
13	AT501 UB8017A handle spring	55 13 006853
14	AT501 UB8030A power nut spring	55 13 006852
15	AT501 PB8110A spring nut	55 13 006849
16	External cable cover set	(3 m) 55 13 015530 (4 m) 55 13 015531 (5 m) 55 13 015532
16.1	External cable cover	55 13 007201 (m)
17	MOST M401/501 euro plug spring	55 13 006827
18	MOST euro plug spring nut M36/501	55 13 006828
19	Quick coupling plug Ø6	50 14 182003
20	Red hose 5x1,5	51 13 007115
20.1	Blue hose 5x1,5	51 13 007120
21	MOST euro plug connector M401/501	55 13 006522
22	MOST euro plug nut M15/501 B1519	55 13 006519
23	Integrated water connector UB5098	55 13 006570
24	O-ring 4x1	55 13 013962
25	Special insert nut	55 13 004300
26	UBD 80310 red plug	55 13 006838
27	UBD 80320 blue plug	55 13 006840
28	Cable stiffener	55 13 006524
B	Contact tip M8x30	(table p. 54)
C	Liners	(table p. 54)

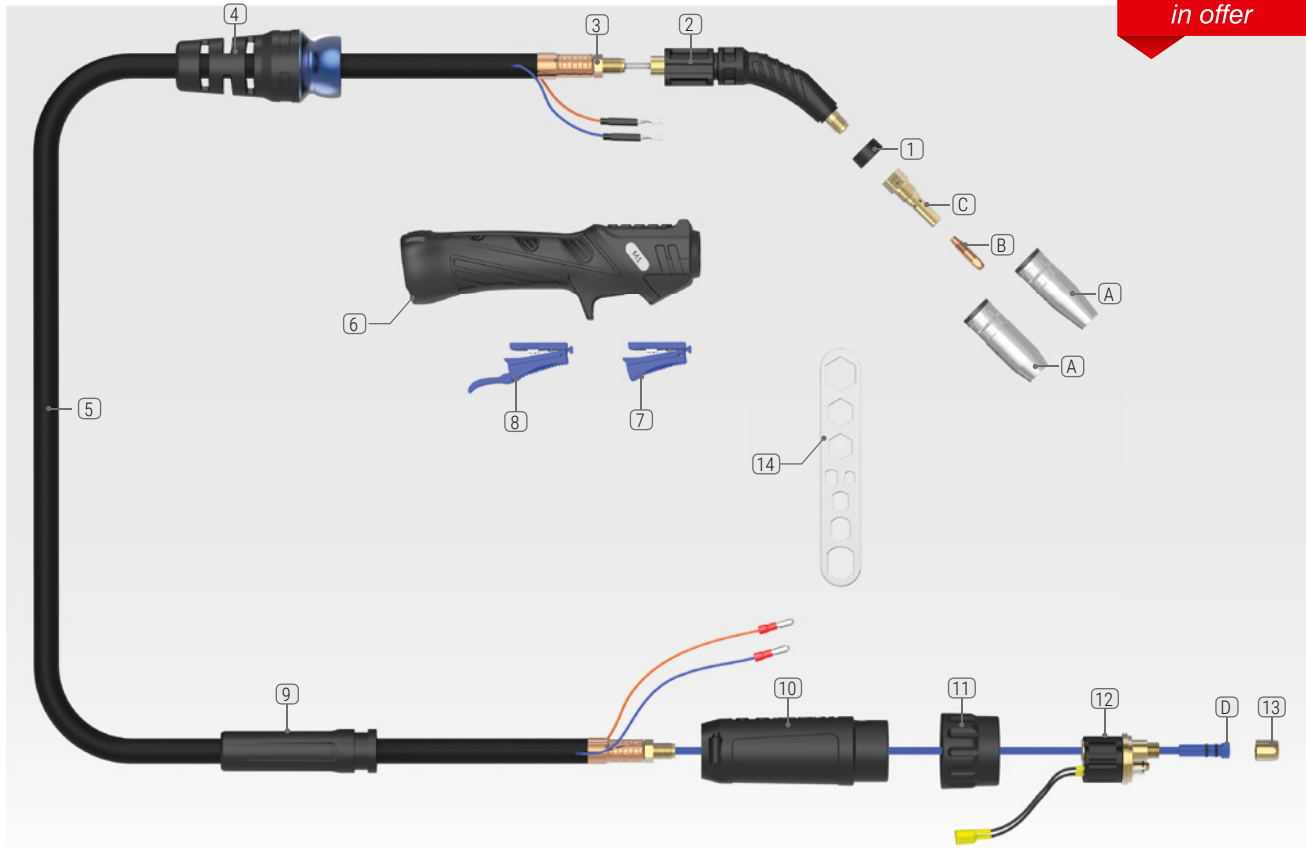
We recommend using special coolants as on page 16.

\* standard version



**M1 MOST MIG/MAG**  
Modern, lightweight

**NEW**  
in offer



Model	M1
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	180 A - CO <sub>2</sub> 150 A - mix M21
▪ Wire diameter	0,6-1,0 mm
<b>Length / Catalogue No.</b>	(3,0 m) 55 08 305080 (4,0 m) 55 08 305081 (5,0 m) 55 08 305082

Contact tips M1 M6	
Wire diameter	Catalogue No.
<b>M1 M6 0,6 mm</b>	55 13 003280
<b>M1 M6 0,8 mm</b>	55 13 003281
<b>M1 M6 1,0 mm</b>	55 13 003282
<b>M1 M6 1,2 mm</b>	55 13 003283
<b>M1 M6 1,0 mm AL</b>	55 13 003285
<b>M1 M6 1,2 mm AL</b>	55 13 003286
<b>Applicable of the torch type</b>	M1

No.	Replaceable elements	Catalogue No.
A	<b>Conical nozzle M1 Ø12</b> <b>Conical nozzle M1 Ø10,5</b>	55 13 000730 55 13 000731
B	<b>Contact tip M1 M6</b>	see table 1
C	<b>Contact tip holder M1</b>	55 13 003873
D	<b>Wire liner</b>	see table 2
1	<b>Insulator M1</b>	55 13 003870
2	<b>Swanneck M1</b>	55 13 014570
3	<b>Lock nut</b>	55 13 004309
4	<b>Cable support</b>	55 13 006872
5	<b>Outer liner assembly M1 3 m</b> <b>Outer liner assembly M1 4 m</b> <b>Outer liner assembly M1 5 m</b>	55 13 016102 55 13 016103 55 13 016104
6	<b>Handle</b>	55 13 006661
7	<b>Microswitch standard trigger assembly</b>	55 13 006675
8	<b>Microswitch extended trigger assembly</b>	55 13 006676
9	<b>Cable support</b>	55 13 006835
10	<b>Housing assembly</b>	55 13 006689
11	<b>Gun plug nut</b>	55 13 006519
12	<b>Euro plug 2</b>	55 13 006696
13	<b>Liner retaining nut</b>	55 13 006695
14	<b>Wear parts spanner</b>	55 13 006685

Table 1. Contact tip for M1 MOST torch

Wire liners	Catalogue No.
<b>Steel liner 0,6-0,9 mm M1/M22 blue 3 m AM1535-30</b>	55 13 012770
<b>Steel liner 0,6-0,9 mm M1/M22 blue 4 m AM1535-40</b>	55 13 012771
<b>Steel liner 0,6-0,9 mm M1/M22 blue 5 m AM1535-50</b>	55 13 012772
<b>Steel liner 1,0-1,2 mm M1/M22 red 3 m AM2524-30</b>	55 13 012783
<b>Steel liner 1,0-1,2 mm M1/M22 red 4 m AM2524-40</b>	55 13 012784
<b>Steel liner 1,0-1,2 mm M1/M22 red 5 m AM2524-50</b>	55 13 012785
<b>Graphite 1,0-1,2 mm M1/M22 3 m AM1564-30</b>	55 13 012786
<b>Graphite 1,0-1,2 mm M1/M22 4 m AM1564-40</b>	55 13 012787
<b>Graphite 1,0-1,2 mm M1/M22 5 m AM1564-50</b>	55 13 012788

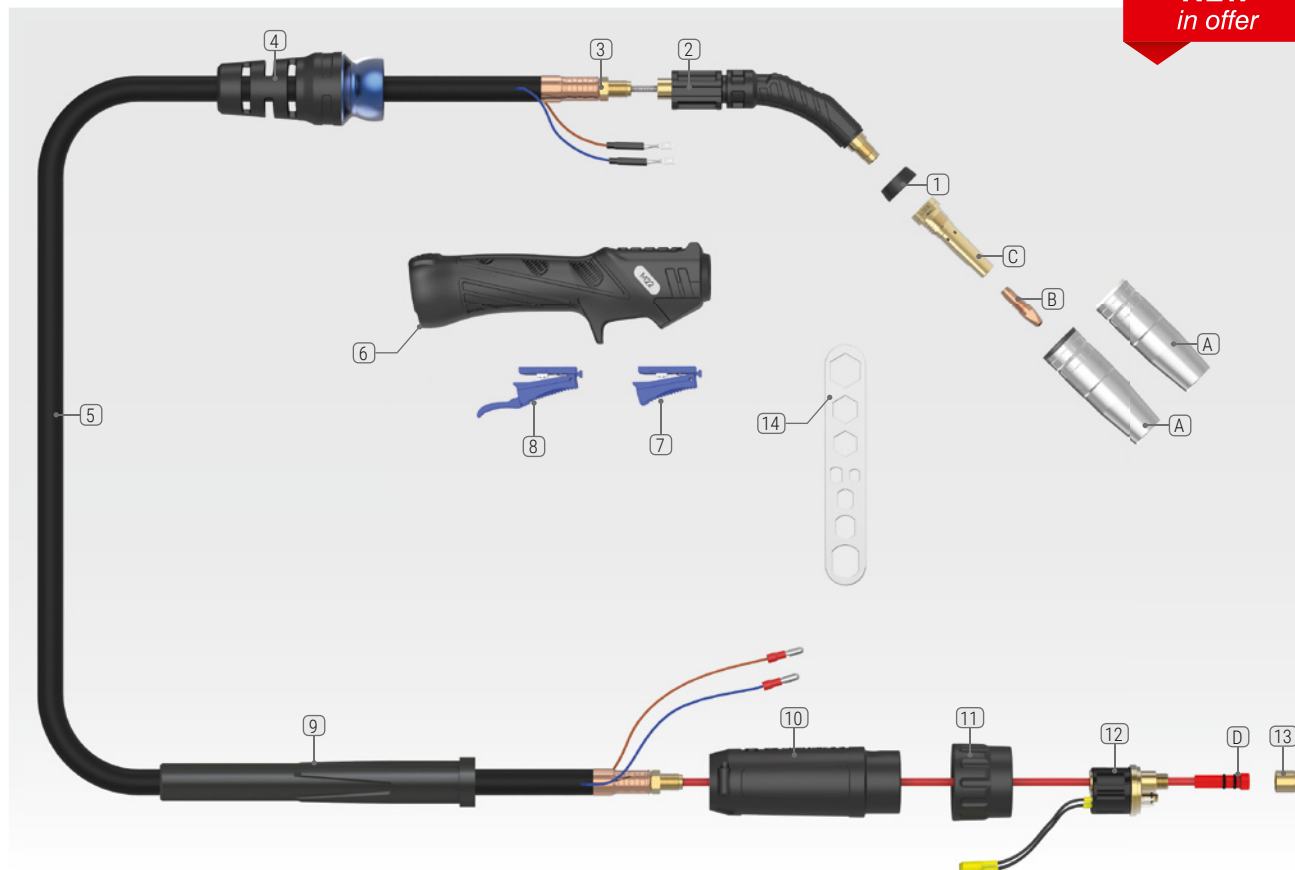
Table 2. Wire liners for M1, M22 and M22M MOST torch



## M22 MOST MIG/MAG

Modern, lightweight

**NEW**  
in offer



Model	M22
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	250 A - CO <sub>2</sub> 220 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3 m) 55 08 305090 (4 m) 55 08 305091 (5 m) 55 08 305092

Contact tips M2 M8	
Wire diameter	Catalogue No.
M2 M8 0,8 mm	55 13 003288
M2 M8 1,0 mm	55 13 003289
M2 M8 1,2 mm	55 13 003290
M2 M8 1,0 mm AL	55 13 003291
M2 M8 1,2 mm AL	55 13 003292
<b>Applicable of the torch type</b>	M22 M22M

Table 1. Contact tip for M22 and M22M MOST torch

Wire liners	Catalogue No.
Steel liner 0,6-0,9 mm M1/M22 blue 3 m AM1535-30	55 13 012770
Steel liner 0,6-0,9 mm M1/M22 blue 4 m AM1535-40	55 13 012771
Steel liner 0,6-0,9 mm M1/M22 blue 5 m AM1535-50	55 13 012772
Steel liner 1,0-1,2 mm M1/M22 red 3 m AM2524-30	55 13 012783
Steel liner 1,0-1,2 mm M1/M22 red 4 m AM2524-40	55 13 012784
Steel liner 1,0-1,2 mm M1/M22 red 5 m AM2524-50	55 13 012785
Graphite 1,0-1,2 mm M1/M22 3 m AM1564-30	55 13 012786
Graphite 1,0-1,2 mm M1/M22 4 m AM1564-40	55 13 012787
Graphite 1,0-1,2 mm M1/M22 5 m AM1564-50	55 13 012788

Table 2. Wire liners for M1, M22 and M22M MOST torch

No.	Replaceable elements	Catalogue No.
A	Conical nozzle M22 Ø16 Conical nozzle M22 Ø14	55 13 000734 55 13 000735
B	Contact tip	see table 1
C	Contact tip holder M22	55 13 003875
D	Wire liner	see table 2
1	Insulator M22	55 13 003871
2	Swanneck M2	55 13 014572
3	Lock nut	55 13 004309
4	Cable support	55 13 006872
5	Power cable assembly M22 3 m Power cable assembly M22 4 m Power cable assembly M22 5 m	55 13 016108 55 13 016109 55 13 016110
6	Handle M1/M22	55 13 006661
7	Microswitch standard trigger assembly	55 13 006675
8	Microswitch extended trigger assembly	55 13 006676
9	Cable support	55 13 006836
10	Housing assembly	55 13 006689
11	Gun plug nut	55 13 006519
12	Euro plug	55 13 006696
13	Liner retaining nut	55 13 006695
14	Wear parts spanner	55 13 006685

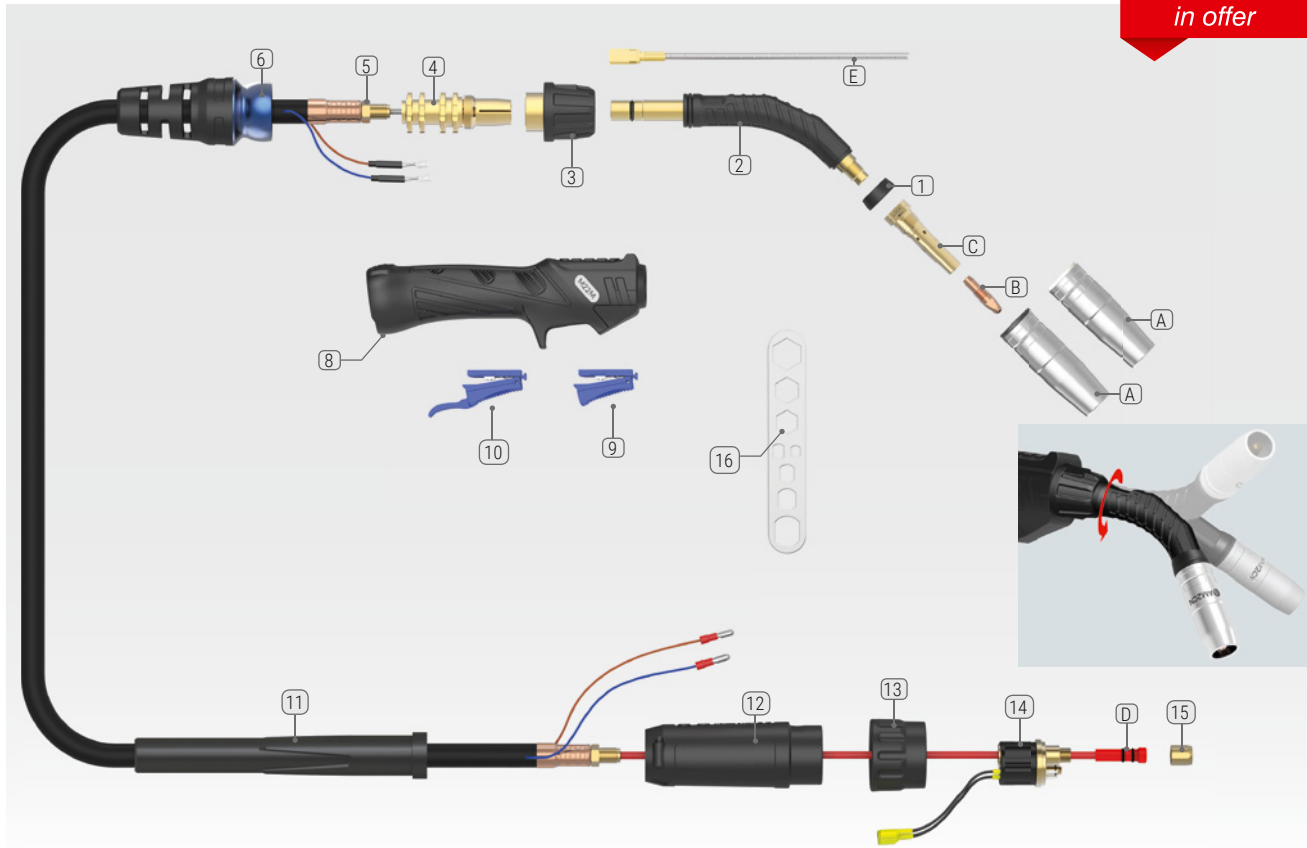




### M22M MOST MIG/MAG

Modern, lightweight, rotary swan neck

**NEW**  
in offer



Model	M22M
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 60% duty cycle	250 A - CO <sub>2</sub> 220 A - mix M21
▪ Wire diameter	0,8-1,2 mm
<b>Length / Catalogue No.</b>	(3 m) 55 08 305095 (4 m) 55 08 305096 (5 m) 55 08 305097

Neck jump liner	Catalogue No.
<b>M22M 0,8-1,2 Neck jump liner standard AM22MJL</b>	55 13 012789
<b>M22M 0,8-1,2 Neck jump liner brass AM22MJL-B</b>	55 13 012790

Table 3. Neck jump liner for M22M MOST

Contact tips M2 M8	
Wire diameter	Catalogue No.
<b>M2 M8 0,8 mm</b>	55 13 003288
<b>M2 M8 1,0 mm</b>	55 13 003289
<b>M2 M8 1,2 mm</b>	55 13 003290
<b>M2 M8 1,0 mm AL</b>	55 13 003291
<b>M2 M8 1,2 mm AL</b>	55 13 003292
<b>Applicable of the torch type</b>	M22 M22M

Table 1. Contact tip for M22 and M22M MOST torch

No.	Replaceable elements	Catalogue No.
A	<b>Conical nozzle M22 Ø16</b> <b>Conical nozzle M22 Ø14</b>	55 13 000734 55 13 000735
B	<b>Contact tip</b>	see table 1
C	<b>Contact tip holder M22</b>	55 13 003875
D	<b>Wire liner</b>	see table 2
E	<b>Liner</b>	see table 3
1	<b>Insulator M22</b>	55 13 003871
2	<b>Swanneck M22M</b>	55 13 014573
3	<b>Neck nut M22M</b>	55 13 014574
4	<b>Socket connection part M22M</b>	55 13 014575
5	<b>Lock nut</b>	55 13 004309
6	<b>Cable support</b>	55 13 006872
7	<b>Power cable assembly M22 3 m</b> <b>Power cable assembly M22 4 m</b> <b>Power cable assembly M22 5 m</b>	55 13 016108 55 13 016109 55 13 016110
8	<b>Handle</b>	55 13 006661
9	<b>Microswitch standard trigger assembly</b>	55 13 006675
10	<b>Microswitch extended trigger assembly</b>	55 13 006676
11	<b>Cable support</b>	55 13 006836
12	<b>Housing assembly</b>	55 13 006689
13	<b>Gun plug nut</b>	55 13 006519
14	<b>Euro plug 2</b>	55 13 006696
15	<b>Liner retaining nut</b>	55 13 006695
16	<b>Wear parts spanner</b>	55 13 006685

Wire liners	Catalogue No.
<b>Steel liner 0,6-0,9 mm M1/M22 blue 3 m AM1535-30</b>	55 13 012770
<b>Steel liner 0,6-0,9 mm M1/M22 blue 4 m AM1535-40</b>	55 13 012771
<b>Steel liner 0,6-0,9 mm M1/M22 blue 5 m AM1535-50</b>	55 13 012772
<b>Steel liner 1,0-1,2 mm M1/M22 red 3 m AM2524-30</b>	55 13 012783
<b>Steel liner 1,0-1,2 mm M1/M22 red 4 m AM2524-40</b>	55 13 012784
<b>Steel liner 1,0-1,2 mm M1/M22 red 5 m AM2524-50</b>	55 13 012785
<b>Graphite 1,0-1,2 mm M1/M22 3 m AM1564-30</b>	55 13 012786
<b>Graphite 1,0-1,2 mm M1/M22 4 m AM1564-40</b>	55 13 012787
<b>Graphite 1,0-1,2 mm M1/M22 5 m AM1564-50</b>	55 13 012788

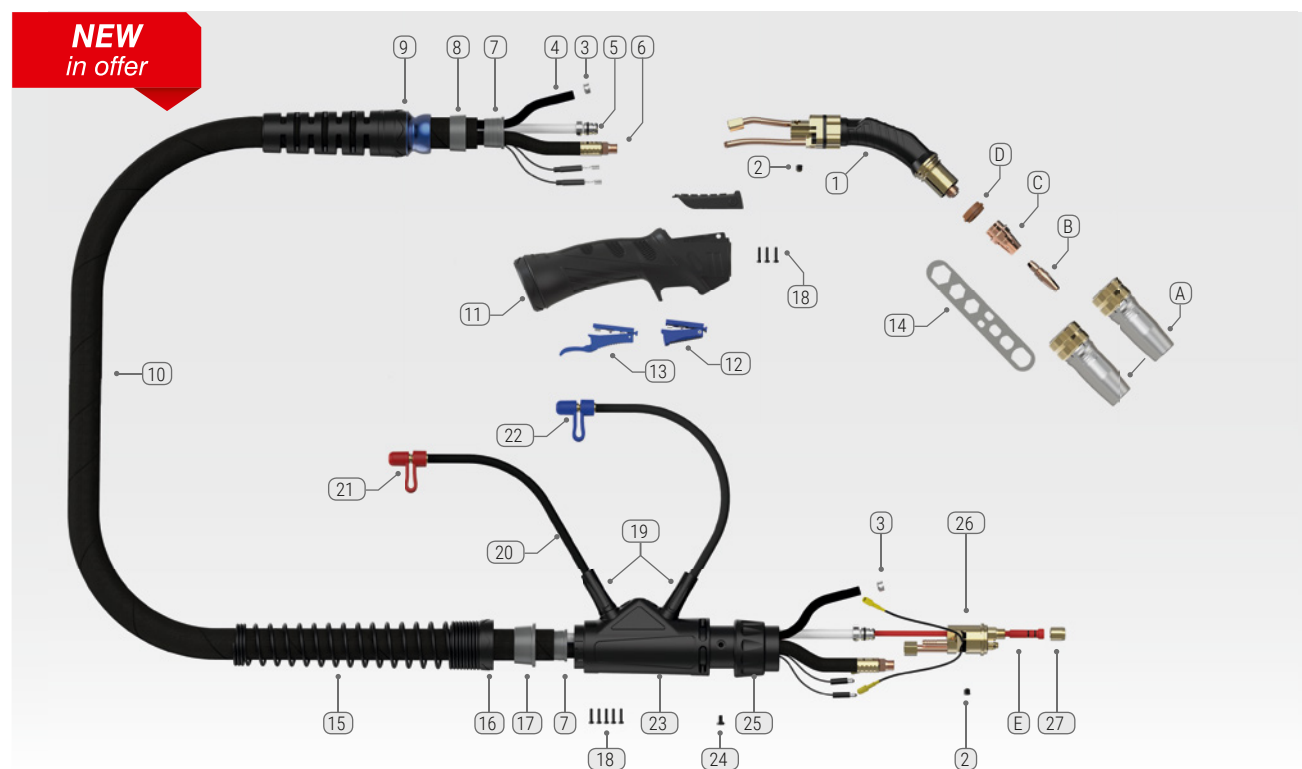
Table 2. Wire liners for M1, M22 and M22M MOST torch



Scan the link or go to  
<https://www.rywal.eu/f01-15>

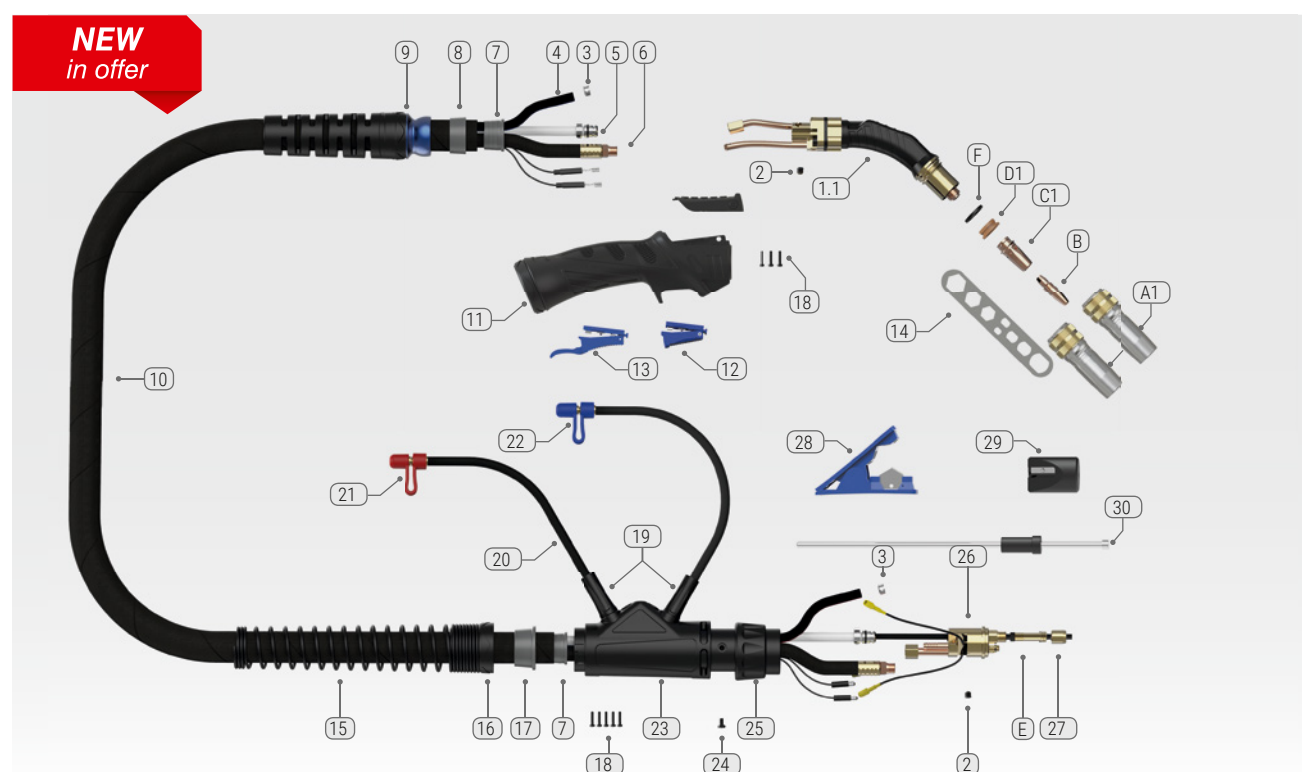
## M6W

Modern MIG/MAG welding torch for high-performance welding, especially using with pulse current



## M60SW

Modern MIG/MAG welding torch for aluminium and CuSi wires



M6W / M6OSW

Model		M6W		M6OSW	
Cooling		Liquid		Liquid	
Rating		Max. A	Pulse	Max. A	Pulse
CO <sub>2</sub>	at 1.6 kW cooler	580 A	380 A	580 A	380 A
	at 1.2 kW cooler	530 A	350 A	530 A	350 A
MIX	at 1.6 kW cooler	530 A	380 A	530 A	380 A
	at 1.2 kW cooler	480 A	350 A	480 A	350 A
Min. coolant inlet pressure		3,0 bar		3,0 bar	
Minimum liquid flow		1,5 l/min		1,5 l/min	
Duty cycle		100%		100%	
Wire diameter		0,8-2,0 mm		0,8-2,0 mm	
Gas flow		8-20 l/min		8-20 l/min	
Length / Catalogue No.		(3 m) 55 08 305113 (4 m) 55 08 305114 (5 m) 55 08 305115		(3 m) 55 08 305123 (4 m) 55 08 305124	

No.	Replaceable elements	Catalogue No.
A	M6W conical gas nozzle Ø16*	55 13 000740
	M6W conical gas nozzle Ø14	55 13 000741
A1	M6OSW conical gas nozzle Ø15*	55 13 000750
	M6OSW conical gas nozzle Ø13	55 13 000751
B	M10x35,5 contact tip	(see the table below)
C	M6W 28,5 mm* contact tip holder	55 13 003984
C1	M6OSW 32,5 mm contact tip holder	55 13 003987
D	M6W insulator	55 13 003980
D1	M6OSW insulator	55 13 003981
E	Liner	(see the table below)
F	O-ring	55 13 003982
1	M6W 45° swan neck	55 13 014550
1.1	M6OSW 45° swan neck	55 13 014560
2	M6x6 screw set	55 13 006884
3	GER 8,7 clamp	50 15 000087
4	Blue hose 5x1,5	51 13 007120
5	Cable for M6W insert 3 m	55 13 006403
	Cable for M6W insert 4 m	55 13 006404
	Cable for M6W insert 5 m	55 13 006405
6	Power-water cable M6W 3 m	55 13 006413
	Power-water cable M6W 4 m	55 13 006414
	Power-water cable M6W 5 m	55 13 006415
7	Hoop	55 13 006830
8	Sheath block	55 13 006848
9	M6W torch stiffener	55 13 006831

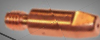
No.	Replaceable elements	Catalogue No.
10	M6W cable cover set 3 m	55 13 006423
	M6W cable cover set 4 m	55 13 006424
	M6W cable cover set 5 m	55 13 006425
	External cable cover (m)	55 13 007201
11	M6W handle	55 13 006660
12	M6W standard trigger	55 13 006675
13	M6W long trigger	55 13 006676
14	M6W key	55 13 006685
15	M6W euro plug spring	55 13 006827
16	Euro plug spring nut	55 13 006680
17	Euro plug inner ring	55 13 006681
18	Screw set	55 13 006684
19	Exit to a hose	55 13 006686
20	Red hose 5x1,5	51 13 007115
21	Red hose plug	55 13 006838
22	Blue hose plug	55 13 006840
23	M6W euro plug housing	55 13 006688
24	M4x0,7 screw	55 13 006683
25	M6W euro plug nut	55 13 006519
26	Euro plug	55 13 006687
27	Special insert nut	55 13 006695
28	Insert cutter	55 13 006690
29	Cartridge sharpener	55 13 006691
30	Cartridge positioner	55 13 006692

M10x35,5 contact tip		Catalogue No.
Wire diameter		
0,8 mm M10x35,5 CuCrZr		55 13 003260
1,0 mm M10x35,5 CuCrZr		55 13 003262
1,2 mm M10x35,5 CuCrZr		55 13 003263
1,4 mm M10x35,5 CuCrZr		55 13 003264
1,6 mm M10x35,5 CuCrZr		55 13 003265
0,8 mm Al M10x35,5 CuCrZr		55 13 003270
1,0 mm Al M10x35,5 CuCrZr		55 13 003271
1,2 mm Al M10x35,5 CuCrZr		55 13 003272
1,6 mm Al M10x35,5 CuCrZr		55 13 003274
Applicable to welding torch	■ M6W ■ M6OSW	

Wire guides (Liners)	Catalogue No.
Steel 1,0-1,2 red / 3 m	55 13 012800
Steel 1,0-1,2 red / 4 m	55 13 012801
Steel 1,0-1,2 red / 5 m	55 13 012802
Steel 1,6 yellow / 3 m	55 13 012810
Steel 1,6 yellow / 4 m	55 13 012811
Steel 1,6 yellow / 5 m	55 13 012812
Graphite 1,0-1,2 / 3 m	55 13 012820
Graphite 1,0-1,2 / 4 m	55 13 012821
Graphite 1,0-1,2 / 5 m	55 13 012822
For aluminium wire 1,0-1,2 / 3 m	55 13 012823
For aluminium wire 1,0-1,2 / 4 m	55 13 012824
For aluminium wire 1,6 / 3 m	55 13 012825
For aluminium wire 1,6 / 4 m	55 13 012826



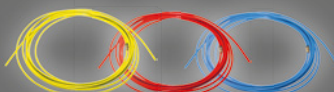
## ▼ 8.2. Contact tips for MIG/MAG welding torches



Tip size  Wire diameter	M6x25 (M6 narrow)	M6x28 (M6 thick)	M8x30	M6x25 (M6 narrow)	M6x28 (M6 thick)	M8x30
	Catalogue No.			Catalogue No. Abicor Binzel		
0,6 mm	55 13 002150	-	-	140.0008	140.0005	-
0,8 mm	55 13 002170	55 13 002180	55 13 002250	140.0059	140.0051	140.0114
1,0 mm	55 13 002320	55 13 002330	55 13 002340	140.0253	140.0242	140.0313
1,2 mm	55 13 002470	55 13 002480	55 13 002490	140.0387	140.0379	140.0442
1,4 mm	-	55 13 002610	55 13 002600	-	140.0516	140.0533
1,6 mm	55 13 002720	55 13 002730	55 13 002800	-	140.0555	140.0587
0,6 mm CuCrZr	-	-	-	140.0855	140.0998	-
0,8 mm CuCrZr	55 13 002171	55 13 002190	55 13 002251	140.0062	140.0054	140.0117
1,0 mm CuCrZr	55 13 002321	55 13 002331	55 13 002341	140.0256	140.0245	140.0316
1,2 mm CuCrZr	55 13 002473	55 13 002482	55 13 002491	140.0390	140.0382	140.0445
1,4 mm CuCrZr	-	-	55 13 002602	-	140.0519	140.0536
1,6 mm CuCrZr	-	55 13 002731	55 13 002801	-	140.0558	140.0590
0,8 mm Al	55 13 002172	55 13 002210	55 13 002253	141.0002	141.0001	141.0003
1,0 mm Al	55 13 002324	55 13 002335	55 13 002365	141.0007	141.0006	141.0008
1,2 mm Al	55 13 002475	55 13 002484	55 13 002493	141.0011	141.0010	141.0015
1,6 mm Al	55 13 002726	55 13 002732	55 13 002808	-	141.0020	141.0022
Applicable to welding torch	<ul style="list-style-type: none"> <li>▪ MOST M15</li> <li>▪ MB-15</li> <li>▪ Abimig 155</li> </ul>	<ul style="list-style-type: none"> <li>▪ MOST M24/M25</li> <li>▪ MOST M36/M240</li> <li>▪ MB-24/MB-25</li> <li>▪ MB-36/MB-240D</li> <li>▪ Abimig 255</li> </ul>	<ul style="list-style-type: none"> <li>▪ MOST M401/M501</li> <li>▪ MOST M38</li> <li>▪ MB-401D/MB-501D</li> <li>▪ Abimig 305/355/405</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 155</li> <li>▪ MB 15</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 255</li> <li>▪ MB-24/MB-25</li> <li>▪ MB-36/MB-240D</li> </ul>	<ul style="list-style-type: none"> <li>▪ Abimig 305/355/405</li> <li>▪ MB-401D</li> <li>▪ MB-501D</li> </ul>

## ▼ 8.3. Liners for MIG/MAG welding torches



Insert Size	3,0 m	4,0 m	5,0 m	3,0 m	4,0 m	5,0 m
Spiral for steel wires	coated			uncoated		
0,8 mm	55 13 012390*	55 13 012400*	55 13 012402*	55 13 012390	55 13 012400	55 13 012402
1,0 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,2 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,6 mm	55 13 012510***	55 13 012530***	55 13 012541***	55 13 012570	55 13 012573	55 13 012575
Teflon for aluminium wires or stainless steel						
0,8 mm	55 13 012120*	55 13 012170*	55 13 012175*	55 13 012120*	55 13 012170*	55 13 012175*
1,0 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,2 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,6 mm	55 13 012210***	55 13 012212***	55 13 012214***	55 13 012210***	55 13 012212***	55 13 012214***
1,0-1,2 mm graphite-teflon with brass spiral	55 13 013010	55 13 013020	55 13 013030	55 13 013010	55 13 013020	55 13 013030
Applicable torch type	<ul style="list-style-type: none"> <li>▪ MOST M15/M24/M25/M36/M38</li> <li>▪ MB-15AK/MB-24KD/MB-25AK/MB-36KD/GRIP ALW</li> </ul>			<ul style="list-style-type: none"> <li>▪ MOST M401/M501</li> <li>▪ MB-240D/MB-401D/MB-501D</li> </ul>		

\* blue / \*\* red / \*\*\* yellow



▼ 8.4. Replacement parts for MIG/MAG KEMPPI torches

Parts compatible with KEMPPI welding torches:

PMT/MMT 25; KMG 17/20/25; MT 18/25; MMG 18/20/22; FE 20/25

No.	Replaceable elements	Cat. no.	Ref. no.
1	45° swan neck	55 42 000700	4153040
2	Nozzle spring	55 42 000599	4275240
3	Insulating ring	55 42 000561	9591079
4	M6 contact tip holder	55 42 000500	9580173
5	Insulating sleeve	55 42 000560	9591010
6	M8x28 contact tip	table below	
7	Gas nozzle Ø14 L=60,5 mm	55 42 000400	9580101
8	Gas nozzle Ø14 L=60,5 mm thickened wall	55 42 000401	9580101E

Parts compatible with KEMPPI welding torches:

PMT 27/32; MMT 27/32; FE 27/32; PMT 30W; MMT 30W; WS 30W

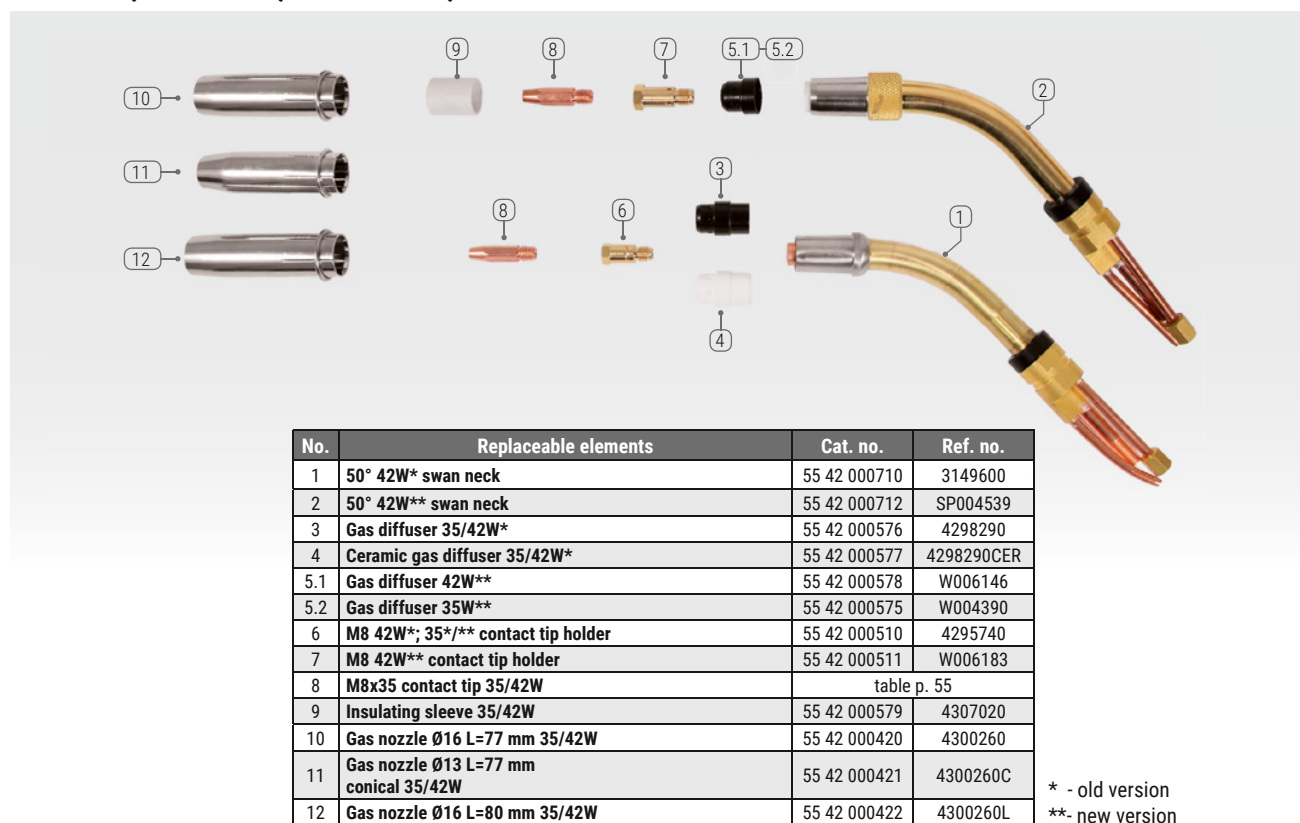
No.	Replaceable elements	Cat. no.	Ref. no.
1	50° swan neck 27/32	55 42 000704	3146780
2	Gas diffuser 27/32/30W	55 42 000570	4294880
3	Ceramic gas diffuser 27/32/30W	55 42 000571	4294880CER
4	M6 27/32/30W contact tip holder	55 42 000505	4294890
5	M8 27/32/30W contact tip holder	55 42 000510	4295740
6	Contact tip M6x28 27/32/30W	table below	
7	Contact tip M8x35 27/32/30W	table below	
8	Gas nozzle Ø14 L=70 mm M6 27/32/30W	55 42 000413	4294970
9	Gas nozzle Ø14 L=76 mm 27/32/30W	55 42 000410	4295760
10	Gas nozzle Ø12 L=76 mm conical 27/32/30W	55 42 000412	4295760C
11	Gas nozzle Ø14 L=79 mm 27/32/30W	55 42 000411	4295760L

Liners	3 m		4,5 m	
	Cat. no.	Ref. no.	Cat. no.	Ref. no.
Spiral white Ø0,6-0,8 mm	55 42 000606	4188571	55 42 000607	4188572
Spiral red Ø0,9-1,2 mm	55 42 000600	4188581	55 42 000601	4188582
Spiral yellow Ø1,6 mm	55 42 000604	4188591	55 42 000605	4188592
Teflon blue	55 42 000608		55 42 000609	
Teflon red Ø0,9-1,2 mm	55 42 000610		55 42 000611	

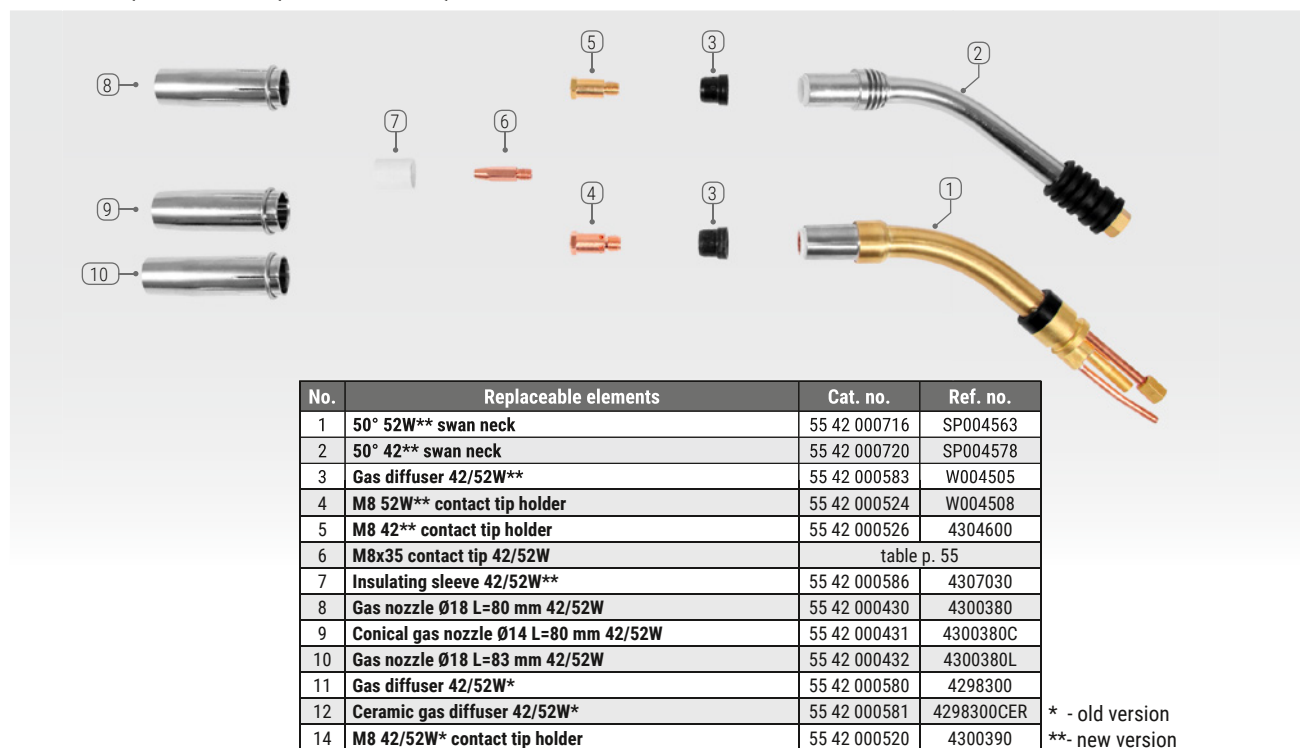
Wire diameter	M6x28		M8x35	
	Cat. no.	Ref. no.	Cat. no.	Ref. no.
0,8 mm	55 13 002180	9876635	55 42 000100	9580122
1,0 mm	55 13 002330	9876636	55 42 000101	9580123
1,2 mm	55 13 002480	9876637	55 42 000102	9580124
1,6 mm	55 13 002730	9876639	55 42 000104	9580126
0,8 mm CuCrZr	55 13 002710		55 42 000300	9580122ZR
1,0 mm CuCrZr	55 13 002331		55 42 000301	9580123ZR
1,2 mm CuCrZr	55 13 002482		55 42 000302	9580124ZR
1,6 mm CuCrZr	55 13 002731		55 42 000304	9580126ZR
0,8 mm Al			55 42 000200	9580122A
1,0 mm Al			55 42 000201	9580123A
1,2 mm Al			55 42 000202	9580124A
1,6 mm Al			55 42 000204	9580126A

The pictures above show replacement products manufactured for RYWAL-RHC. Presented alternatives to parts of KEMPPI torches are not the original parts. Names and reference numbers of KEMPPI torches and spare parts were provided to inform about the intended application of the offered replacement parts.

### Parts compatible with KEMPPPI welding torches: PMT 35; MMT 35; PMT 42W; MMT 42W



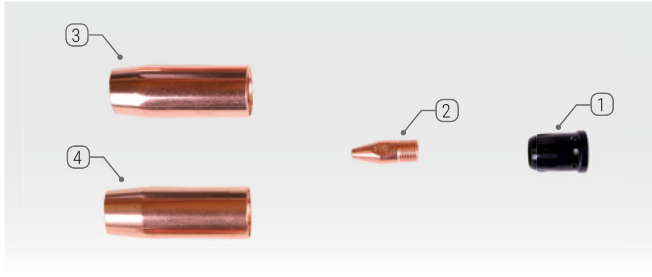
### Parts compatible with KEMPPPI welding torches: PMT 42, MMT 42, PMT 52W, MMT 52W



The pictures above show replacement products manufactured for RYWAL-RHC. Presented alternatives to parts of KEMPPPI torches are not the original parts. Names and reference numbers of KEMPPPI torches and spare parts were provided to inform about the intended application of the offered replacement parts.

**Parts compatible with KEMPPI welding torches:**

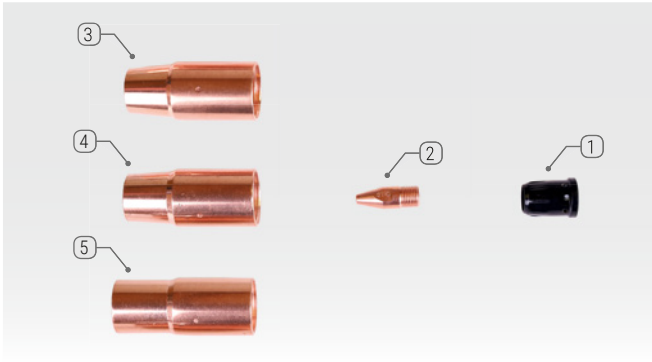
**GX203G35, GX203G5, GX303W35, GX303W5, GX205G35, GX205G5, GX305W35, GX305W5, GX305WS6**



No.	Replaceable elements	Cat. no.	Ref. no.
1	Contact tip adapter M10 insulated	55 42 000890	W013203
2	Contact tip M10	table below 1	
3	Gas nozzle Ø 14 L=57/22	55 42 000850	W014452
4	Gas nozzle Ø 15 L=60/22	55 42 000851	W015858

**Parts compatible with KEMPPI welding torches:**

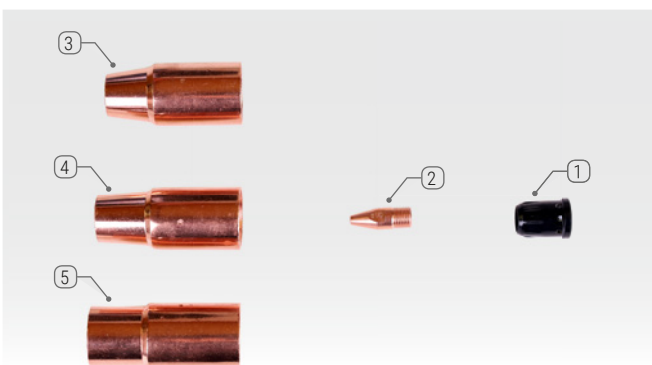
**GX303G35, GX303G5, GX403W35, GX428W5, GX403W5, GX305G35, GX305G5, GX305GS6, GX305GS8, GX405W35, GX405W5, GX405WS6, GX405WS8, GX305GMN35, GX305GMN5, GX208GMN35, GX208GMN5, GX308GMN35, GX308GMN5, GX428W35**



No.	Replaceable elements	Cat. no.	Ref. no.
1	Contact tip adapter M10 insulated	55 42 000890	W013203
2	Contact tip M10	table below 1	
3	Gas nozzle Ø 15 L=57/25	55 42 000860	W011478
4	Gas nozzle Ø 16 L=61/25	55 42 000861	W013930
5	Gas nozzle Ø 19 L=61/25	55 42 000862	W012143

**Parts compatible with KEMPPI welding torches:**

**GX403G35, GX403G5, GX503W35, GX503W5, GX405G35, GX405G5, GX505W35, GX505W5, GX408GMN35, GX408GMN5, GX528W35, GX528W5**



No.	Replaceable elements	Cat. no.	Ref. no.
1	Contact tip adapter M10 insulated	55 42 000890	W013203
2	Contact tip M10	table below 1	
3	Gas nozzle Ø 15 L=60/28	55 42 000870	W011472
4	Gas nozzle Ø 17 L=64/28	55 42 000871	W013931
5	Gas nozzle Ø 21 L=64/28	55 42 000872	W012146

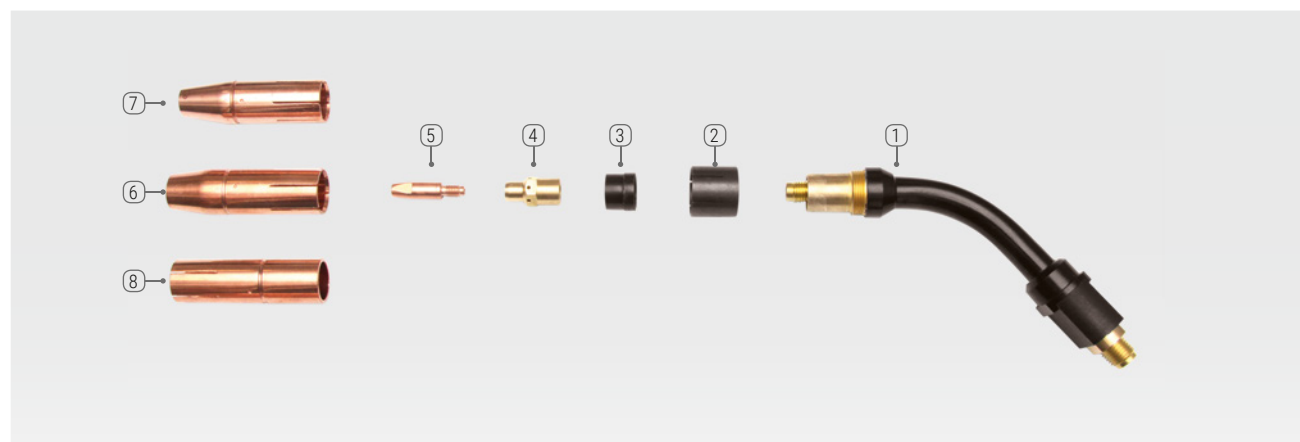
Contact tip Wire diameter	M10x28		M10x28 CuCrZr	
	Cat. no.	Ref. no.	Cat. no.	Ref. no.
0,8 mm	55 42 000800	CT08C1SD001	55 42 000820	CT08C1CZ001
1,0 mm	55 42 000801	CT10C1SD001	55 42 000821	CT10C1CZ001
1,2 mm	55 42 000802	CT12C1SD001	55 42 000822	CT12C1CZ001
1,4 mm	55 42 000803	CT14C1SD001	55 42 000823	CT14C1CZ001
1,6 mm	55 42 000804	CT14C1SD001	55 42 000824	CT14C1CZ001

Table 1: Contact tip

The pictures above show replacement products manufactured for RYWAL-RHC. Presented alternatives to parts of KEMPPI torches are not the original parts. Names and reference numbers of KEMPPI torches and spare parts were provided to inform about the intended application of the offered replacement parts.

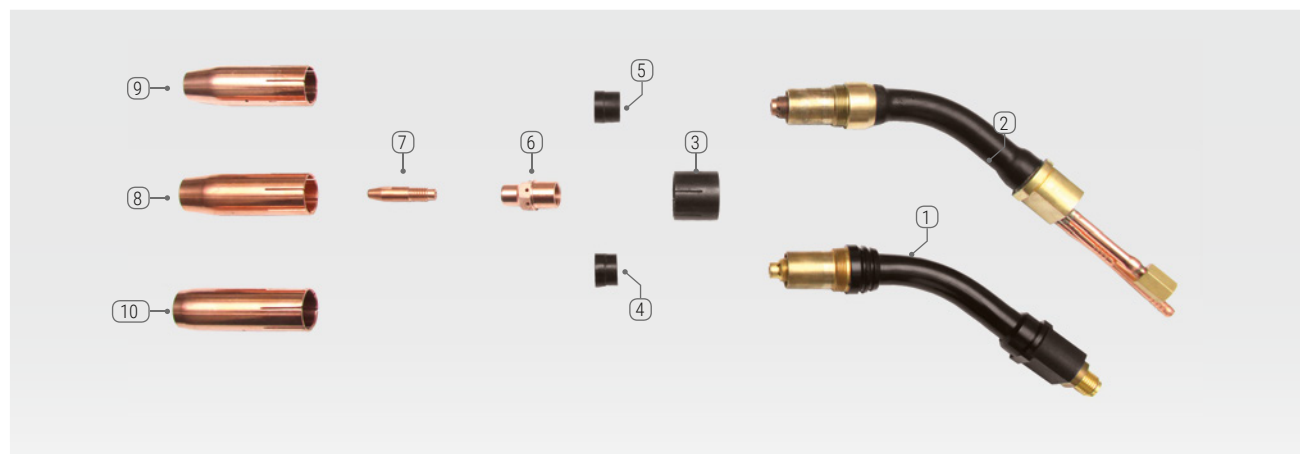
## ▼ 8.5. Replacement parts for MIG/MAG FRONIUS torches

### Parts compatible with FRONIUS welding torches: AL 2300 / AW 2500



No.	Replaceable elements	Cat. no.	Ref. no.
1	45° 2300 swan neck	55 33 000380	34.0350.1875
2	2300/2500 Locking nut	55 33 000235	42.0001.5171
3	2300/2500 insulator	55 33 000220	42.0100.0225
4	M6 2300/2500 contact tip holder	55 33 000185	42.0001.1718
5	Contact tip M6x33 2300/2500	table p. 59	
6	Gas nozzle Ø12 L=66 mm 2300/2500	55 33 000100	42.0001.5173
7	Gas nozzle Ø10 L=66 mm 2300/2500	55 33 000101	42.0001.5174
8	Gas nozzle Ø17 L=66 mm 2300/2500	55 33 000102	42.0001.5172

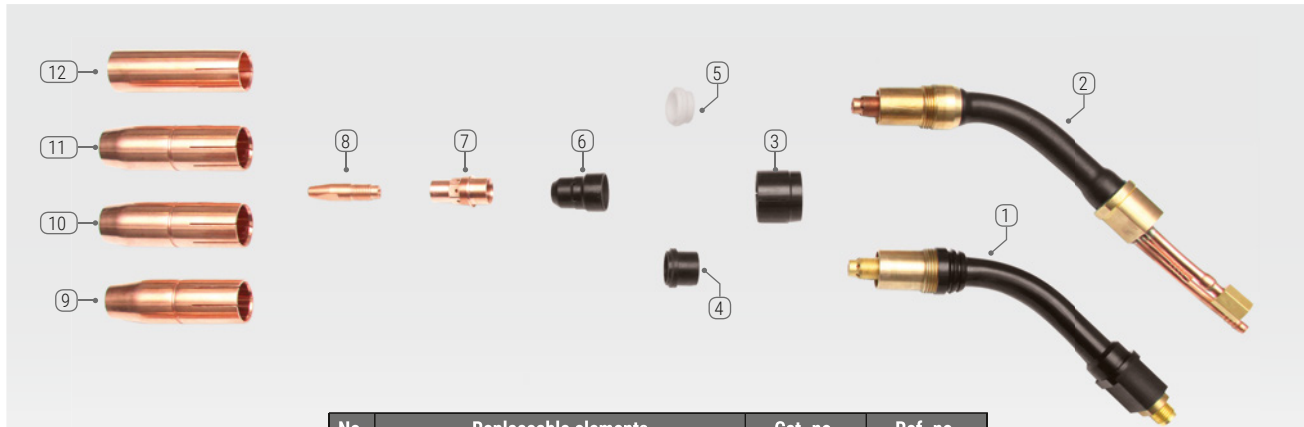
### Parts compatible with FRONIUS welding torches: AL 3000 / AW 4000



No.	Replaceable elements	Cat. no.	Ref. no.
1	45° 3000 swan neck	55 33 000385	34.0350.1771
2	45° 4000 swan neck	55 33 000388	34.0350.1812
3	Locking nut 3000/4000	55 33 000236	42.0001.2930
4	Isolator 3000	55 33 000225	42.0100.1014
5	Isolator 4000	55 33 000223	42.0100.1010
6	M8 3000/4000 contact tip holder	55 33 000190	42.0001.5084
7	M8x35 3000/4000 contact tip	table p. 59	
8	Gas nozzle Ø13 L=67 mm 3000/4000	55 33 000120	42.0001.5096
9	Gas nozzle Ø11 L=67 mm 3000/4000	55 33 000121	42.0001.5151
10	Gas nozzle Ø15 L=67 mm 3000/4000	55 33 000122	42.0001.5269

The pictures above show replacement products manufactured for RYWAL-RHC. Presented alternatives to parts of FRONIUS torches are not the original parts. Names and reference numbers of FRONIUS torches and spare parts were provided to inform about the intended application of the offered replacement parts.

**Parts compatible with FRONIUS welding torches:  
AL 4000 / AW 5000**



No.	Replaceable elements	Cat. no.	Ref. no.
1	45° 4000 swan neck	55 33 000391	34.0350.1822
2	45° 5000 swan neck	55 33 000394	34.0350.1820
3	Locking nut 4000/5000	55 33 000237	42.0001.2970
4	Isolator 4000	55 33 000227	42.0100.1018
5	Isolator 5000	55 33 000229	42.0100.1016
6	4000/5000 gas diffuser	55 33 000240	42.0100.1007
7	M10 4000/5000 contact tip holder	55 33 000195	42.0001.5122
8	M10x40 4000/5000 contact tip	table below	
9	Gas nozzle Ø17 L=79 mm 4000/5000	55 33 000130	42.0001.5128
10	Gas nozzle Ø15 L=79 mm 4000/5000	55 33 000131	42.0001.5129
11	Gas nozzle Ø20 L=79 mm 4000/5000	55 33 000132	42.0001.5127
12	Gas nozzle Ø17 L=79 mm thick 4000/5000	55 33 000133	42.0001.5130

Contact tip Wire diameter	M6x33		M8x35		M10x40	
	Cat. no.	Ref. no.	Cat. no.	Ref. no.	Cat. no.	Ref. no.
0,8 mm	55 33 000020	42.0001.3283				
1,0 mm	55 33 000022	42.0001.3282				
1,2 mm	55 33 000023	42.0001.3281				
0,8 mm CuCrZr	55 33 000040	42.0001.0053	55 33 000070	42.0001.2911	55 33 000080	42.0001.1576
1,0 mm CuCrZr	55 33 000042	42.0001.0054	55 33 000072	42.0001.2912	55 33 000082	42.0001.1577
1,2 mm CuCrZr	55 33 000043	42.0001.0055	55 33 000073	42.0001.2913	55 33 000083	42.0001.1578
1,6 mm CuCrZr	55 33 000045	42.0001.0056			55 33 000085	42.0001.1579
0,8 mm Al			55 33 000060	42.0001.5082		
1,0 mm Al			55 33 000061	42.0001.5051		
1,2 mm Al			55 33 000062	42.0001.5052		

**Parts compatible with welding torches MTW 400i/500i**



No.	Replaceable elements	Ref. no.	Cat. no.
1	Gas nozzle Ø15 L=63 400i/500i	42.0001.4051.5	55 33 000489
	Gas nozzle Ø17 L=63 400i/500i	42.0001.4050.5	55 33 000490
2	Contact tip M8x1,5x32 0,8 CuCrZr	42.0001.6464.10	55 33 000418
	Contact tip M8x1,5x32 1,0 CuCrZr	42.0001.6466.10	55 33 000419
	Contact tip M8x1,5x32 1,2 CuCrZr	42.0001.6467.10	55 33 000420
3	Gas diffuser 20,8x24 mm 400i/500i	42.0405.0854.5	55 33 000600
4	Contact tip adapter M8x1,5 400i/500i	42.0001.4037.5	55 33 000640
5	Insulator 20,8x14x7,3 mm 400i/500i	42.0100.1329.5	55 33 000610

The pictures above show replacement products manufactured for RYWAL-RHC. Presented alternatives to parts of FRONIUS torches are not the original parts. Names and reference numbers of FRONIUS torches and spare parts are advised only to inform about the application of offered replacement parts.



## ▼ 8.6. Special accessories for MIG/MAG torches



### Special swan necks M501

- Longer versions of the M501 MOST torch.
- It allows you to adapt the welding torch to work in hard to reach spaces.

Model	Length	Catalogue No.
M501L MOST swan neck	L=300 mm	55 13 01409A
M501XL MOST swan neck	L=400 mm	55 13 01409B
M501XXL MOST swan neck	L=500 mm	55 13 01409C

Swan neck is supplied without nozzle.

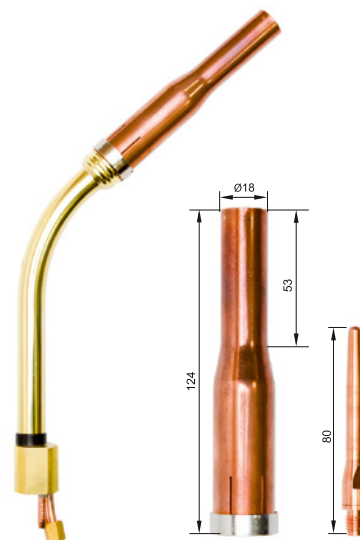
For special torches, the longer liner must be replaced. Leading input, set  $\varnothing 2,0 / 6$  m, catalogue no.: 55 13 012506.



### Narrow gap welding nozzle for M401 / M501 torches

Model	Catalogue No.
Gas nozzle M401/501 long 13x124 mm	55 13 000618
1,0 M8x80 mm CuCrZr long contact tip	55 13 002642
1,2 M8x80 mm CuCrZr long contact tip	55 13 002643

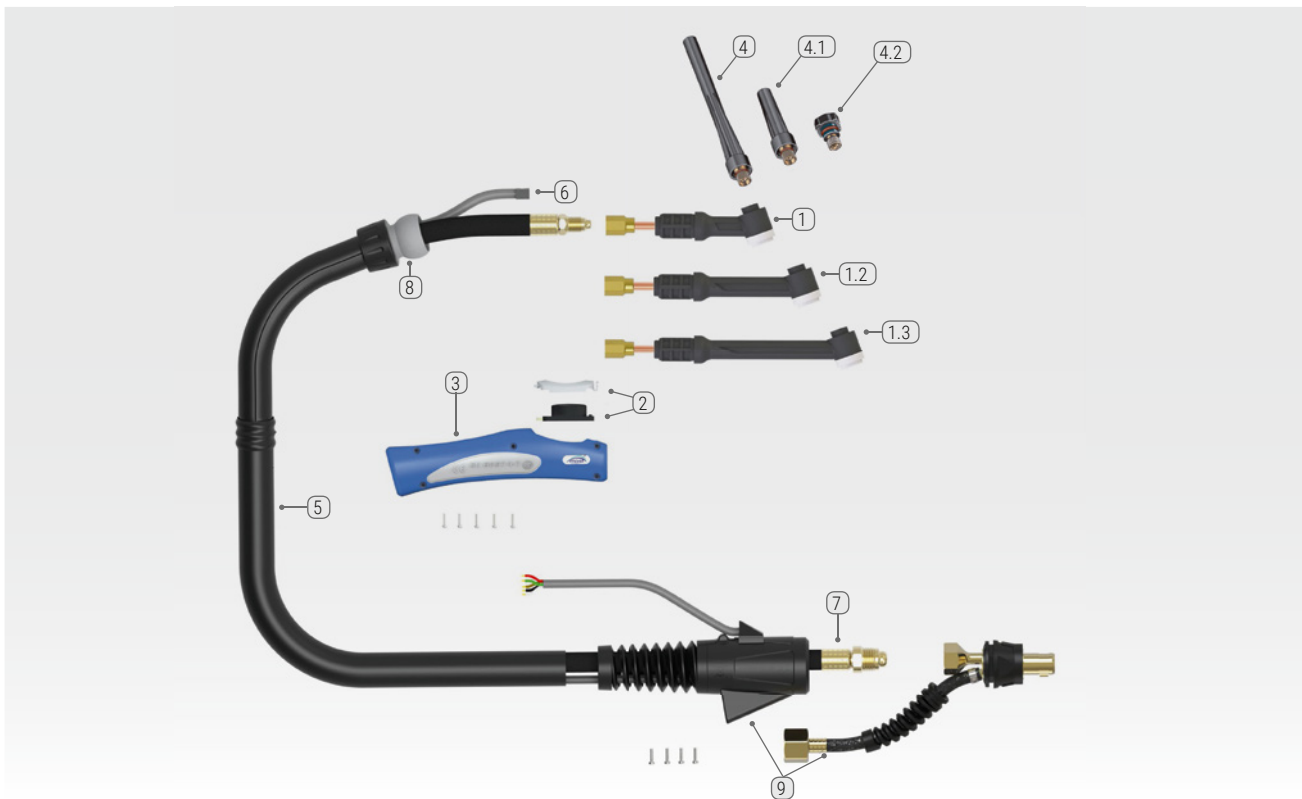
\* Other parts, i.e. gas diffuser and standard contact tip holder 401 / 501 - page 47.



▼ 8.7. TIG welding torches



T9 SGRIP



Model	T9 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 35% duty cycle	90 A AC / 125 A DC
▪ Tungsten electrode diameter	1,0-1,6 mm
▪ Gas flow	5-12 l/min
▪ Weight	0,75 kg
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 060904 (8,0 m) 56 01 060908

T9F SGRIP version with flexible torch, technical data as for T9 SGRIP.

Torches supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

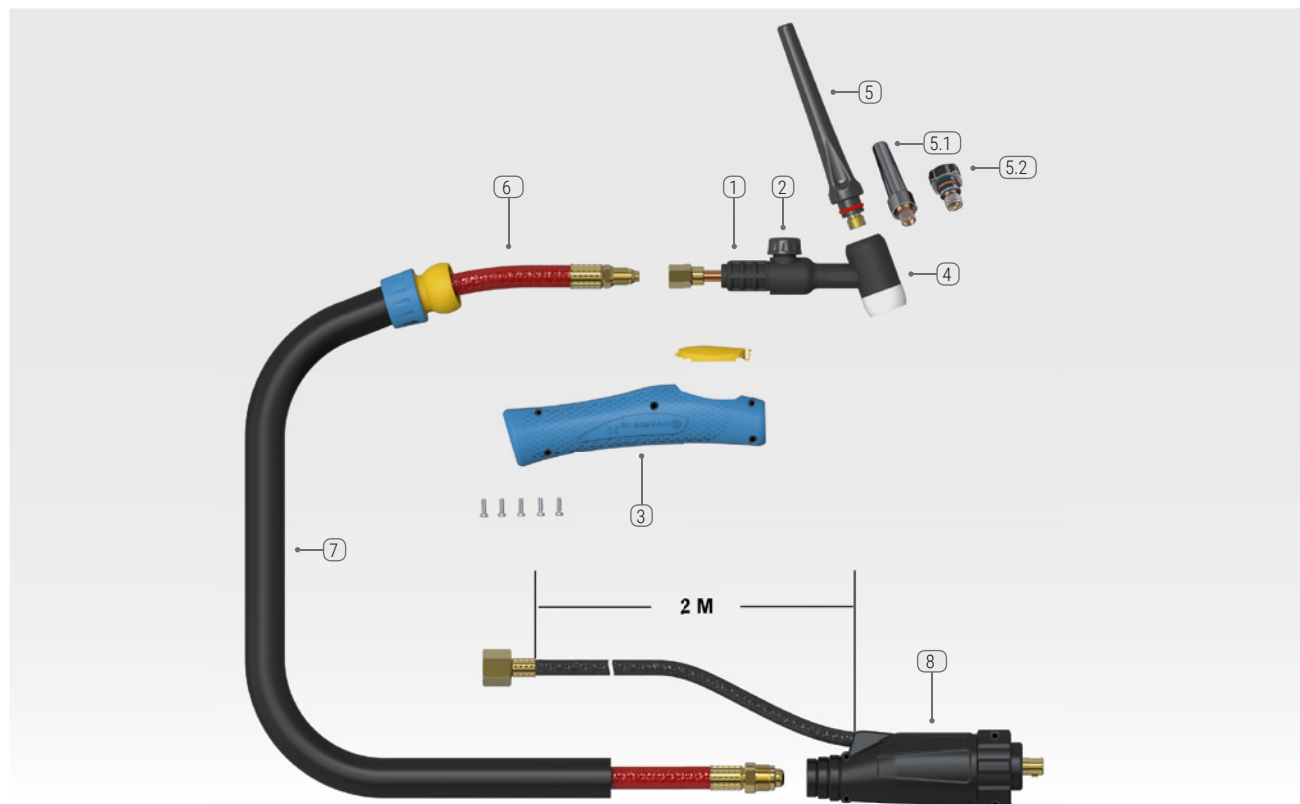
No.	Replaceable elements	Catalogue No.	Alternative designation
1	T9 MOST* torch body	56 13 003350	-
1.1	T9F MOST torch body	56 13 003351	-
1.2	T9FXL torch body L=75 mm MOST	56 13 00335L	-
1.3	T9FXL torch body L=100 mm MOST	56 13 00335X	-
2	Set button ON/OFF	56 13 200100	UER1MS
3	Small handle TSGRIP	56 13 200221	RY-ERH100
4	Long back cup T-9/20	56 13 003170	41V24
4.1	Medium back cup T-9/20	56 13 003250	42V35
4.2	Short back cup T-9/20	56 13 003280	41V33
5	Cable cover (m)	51 13 015288	-
5.1	Cable cover 4 m	56 13 200197	USLERC0100-40
5.2	Cable cover 8 m	56 13 200198	USLERC0100-80
6	4 m control cable	56 13 200217	UERSWL4
6.1	8 m control cable	56 13 200218	UERSWL8
7	T9 power gas cable 4 m	56 13 200200	USLHD57Y01AOB
7.1	T9 power gas cable 8 m	56 13 200201	USLHD57Y03AOB
8	TIG joint	56 13 200266	UERKJ100
9	T9 plug assembly	56 13 200274	UNSL3550-917-G-S5

\* standard version

- Parts for TIG torches - pages 73-81.
- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.



## T17V SGRIP



Model	T17V SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 35% duty cycle	95 A AC / 135 A DC
▪ Tungsten electrode diameter	1,0- 2,4 mm
▪ Gas flow	5-12 l/min
▪ Weight	0,75 kg
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 061704

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

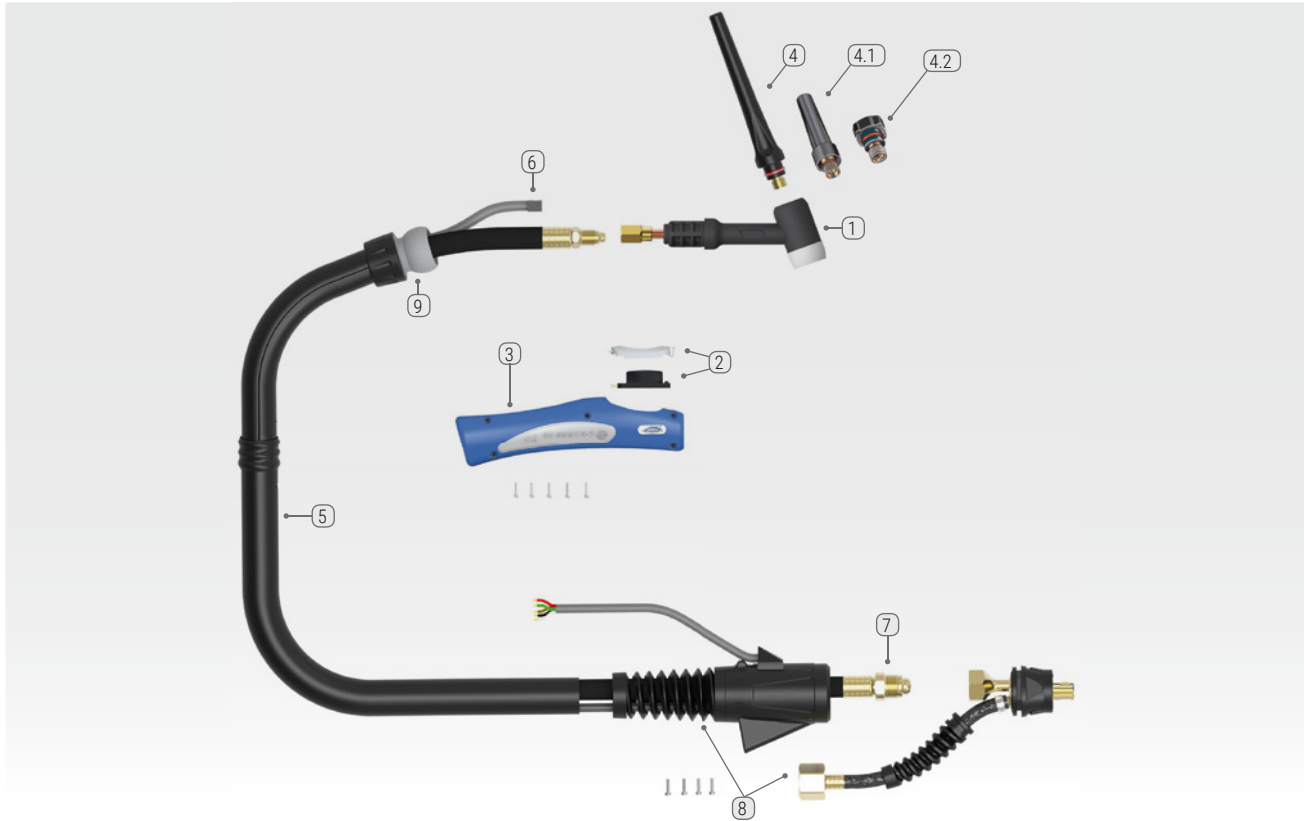
AC - alternating current.

No.	Replaceable elements	Catalogue No.	Alternative designation
1	T-17V MOST torch body	56 13 003417	UWP17V
2	T-17V valve	56 13 003135	-
3	TIG17V handle	56 13 007512	UCH100
4	T-17/18/26 insulator	56 13 014810	18CG
5	Long back cup T-17/18/26	56 13 003181	57Y02
5.1	Medium back cup T-17/18/26	56 13 003251	-
5.2	Short back cup T-17/18/26	56 13 003270	57Y04
6	Power gas cable TIG17V 4 m	56 13 016160	USL57Y01A
7	Cable cover (m)	51 13 015288	-
8	TIG17V 10/25 plug assembly	56 13 016412	UML1025-916-M-G5

- Parts for TIG torches - pages 73-81.
- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.



**T17 SGRIP**



Model	T17 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 35% duty cycle	105 A AC / 150 A DC
▪ Tungsten electrode diameter	1,0-2,4 mm
▪ Gas flow	5-12 l/min
▪ Weight	0,75 kg
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 061716 (8,0 m) 56 01 061717

T17F SGRIP version with flexible torch, technical data as for T17 SGRIP.

Torches are supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

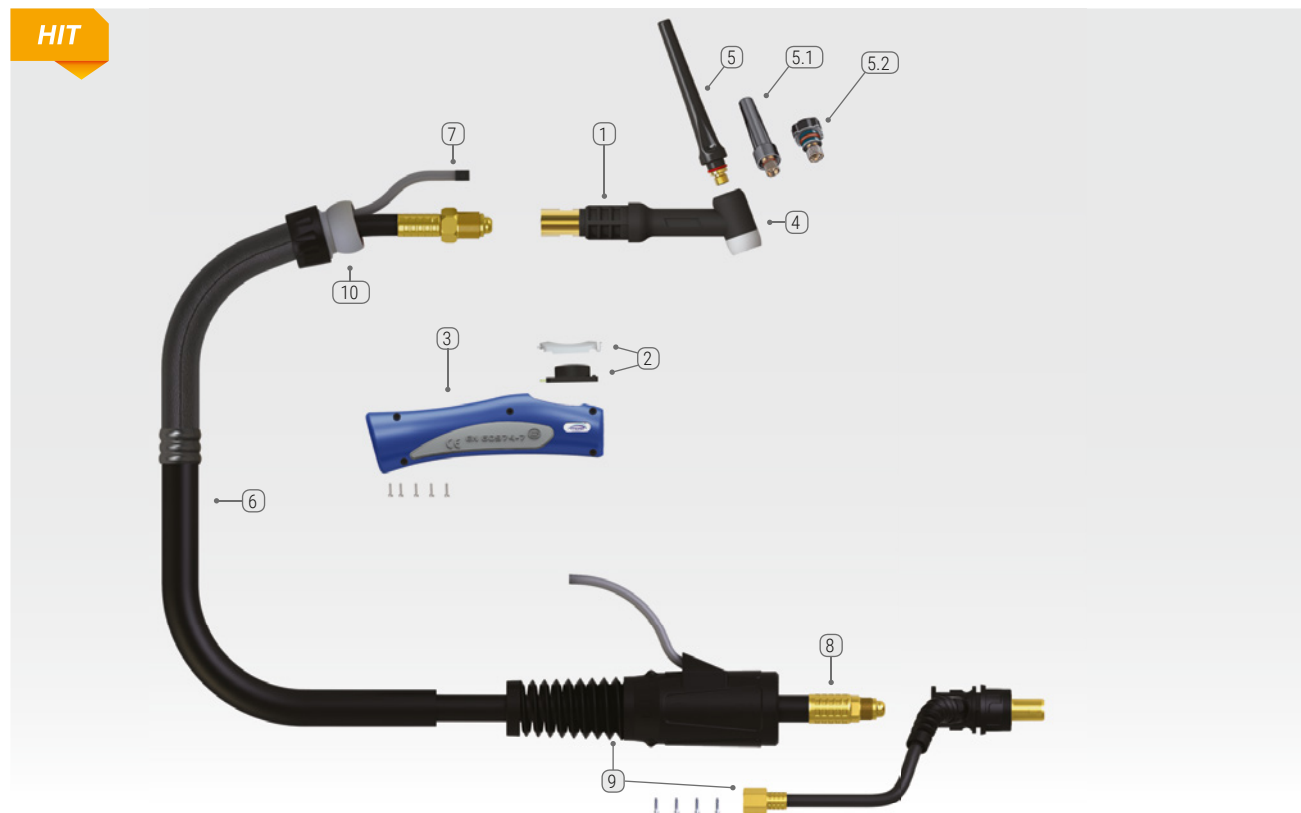
No.	Replaceable elements	Catalogue No.	Alternative designation
1	<b>T-17 MOST* torch body</b>	56 13 003367	-
1.1	<b>T17F MOST torch body</b>	56 13 003382	-
2	<b>Set button ON/OFF</b>	56 13 200100	UER1MS
3	<b>Small handle TSGRIP</b>	56 13 200221	RY-ERH100-A
4	<b>Long back cup T-17/18/26</b>	56 13 003181	57Y02
4.1	<b>Medium back cup T-17/18/26</b>	56 13 003251	-
4.2	<b>Short back cup T-17/18/26</b>	56 13 003270	57Y04
5	<b>Cable cover (m)</b>	51 13 015288	-
5.1	<b>Cable cover 4 m</b>	56 13 200200	USLHD57Y01A0B
5.2	<b>Cable cover 8 m</b>	56 13 200201	USLHD57Y03A0B
6	<b>Control cable 4 m</b>	56 13 200217	UERSWL4
6.1	<b>Control cable 8 m</b>	56 13 200218	UERSWL8
7	<b>TIG17 power gas cable 4 m</b>	56 13 200217	UERSWL4
7.1	<b>TIG17 power gas cable 8 m</b>	56 13 200218	UERSWL8
8	<b>T17 plug assembly</b>	56 13 200275	UNSL1625-917-GS5
9	<b>TIG joint</b>	56 13 200266	UERKJ100

\* standard version

- Parts for TIG torches - pages 73-81.
- We provide custom made TIG welding torches adapted to all common welding equipment - send email to export@rywal.com.pl
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.



## T26 SGRIP



Model	T26 SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 35% duty cycle	125 A AC / 180 A DC
▪ Tungsten electrode diameter	1,0-3,2 mm
▪ Gas flow	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 062604 (8,0 m) 56 01 062608 (12,0 m) 56 01 062612

T26F SGRIP version with a flexible torch, technical data as for T26 SGRIP.

Torches are supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

No.	Replaceable elements	Catalogue No.	Alternative designation
1	T-26 MOST* torch body	56 13 003398	-
1.1	T-26F MOST torch body	56 13 003397	-
2	Set button ON/OFF	56 13 200100	UERBS
3	TIG SGRIP large handle	56 13 200220	RY-ERH200
4	T-17/18/26 insulator	56 13 014810	18CG
5	Long back cup T-17/18/26	56 13 003181	57Y02
5.1	Medium back cup T-17/18/26	56 13 003251	-
5.2	Short back cup T-17/18/26	56 13 003270	57Y04
6	Cable cover (m)	51 13 015289	-
6.1	Cable cover 4 m	56 13 200250	USLERC200-40
6.2	Cable cover 8 m	56 13 200251	USLERC200-80
6.3	Cable cover 12 m	56 13 200252	USLERC200-120
7	Control cable with 4 m plug Control cable with 8 m plug Control cable with 12 m plug	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
8	Power gas cable T-26 MOST 4 m Power gas cable T-26 MOST 8 m Power gas cable T-26 MOST 12 m	56 13 200212 56 13 200213 56 13 200214	USL46V28A0B USL46V30A0B USL46V37A0B
9	TIG26 plug assembly	56 13 200272	UNSL 35-50-26-GS5
10	TIG joint	56 13 200264	UERKJ200

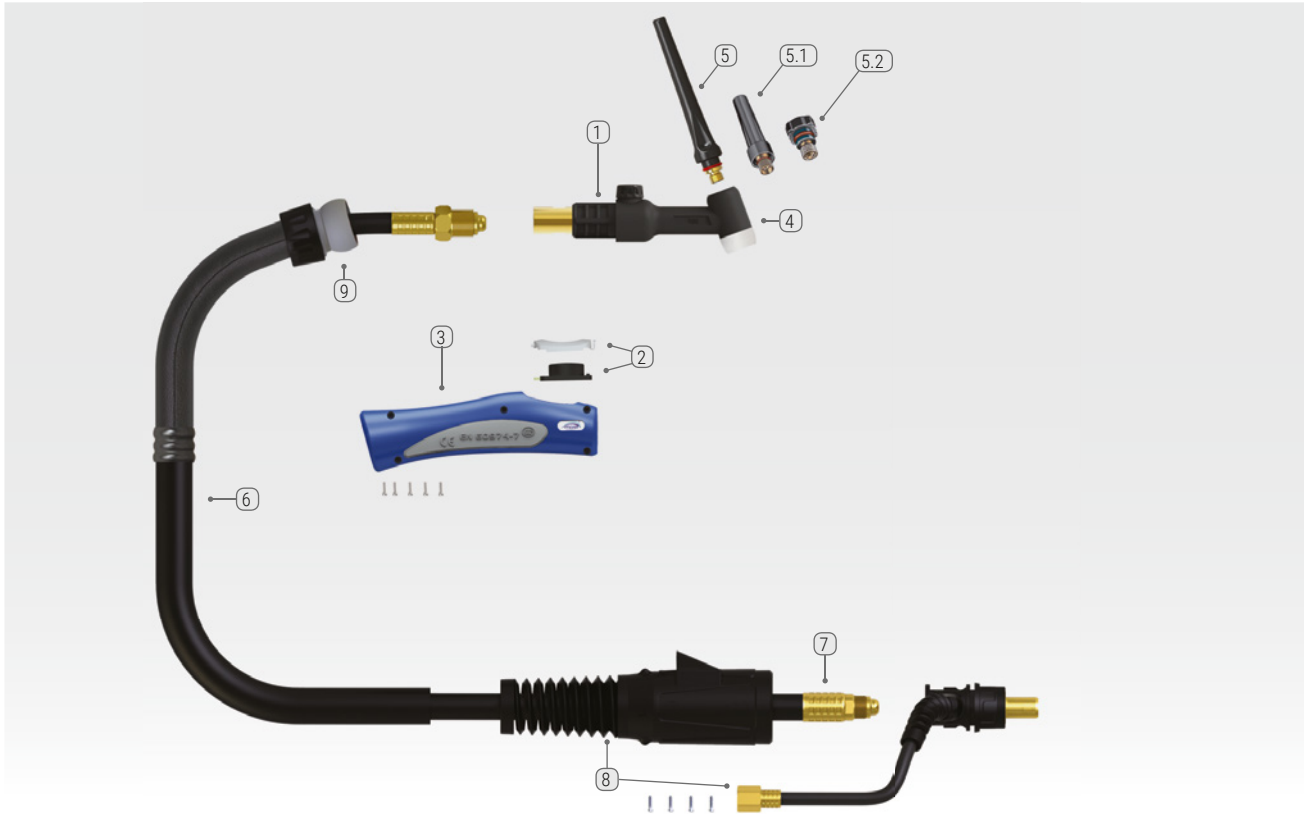
\* standard version

- Parts for TIG torches - pages 73-81.
- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.





**T26V SGRIP**



Model	T26V SGRIP
<b>Cooling</b>	Gas
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 35% duty cycle	125 A AC / 180 A DC
▪ Tungsten electrode diameter	1,0-3,2 mm
▪ Gas flow	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 062634 (8,0 m) 56 01 062638

No.	Replaceable elements	Catalogue No.	Alternative designation
1	T-26V MOST* torch body	56 13 003363	UWP26V
1.1	T-26VF MOST torch body	56 13 003370	UWP26VFX
2	TIG button cover	56 13 200105	UERBS
3	TIG SGRIP large torch	56 13 200220	RY-ERH200
4	T-17/18/26 insulator	56 13 014810	18CG
5	Long back cup T-17/18/26	56 13 003181	57Y02
5.1	Medium back cup T-17/18/26	56 13 003251	-
5.2	Short back cup T-17/18/26	56 13 003270	57Y04
6	Cable cover (m)	51 13 015289	-
6.1	Cable cover 4 m	56 13 200250	USLERC200-40
6.2	Cable cover 8 m	56 13 200251	USLERC200-80
7	Power gas cable T-26 MOST 4 m Power gas cable T-26 MOST 8 m	56 13 200212 56 13 200213	USL46V28AOB USL46V30AOB
8	TIG26 plug assembly	56 13 200272	UNSL 35-50-26-GS5
9	TIG joint	56 13 200264	UERKJ200

T26VF SGRIP version with a flexible torch, technical data as for T26 SGRIP.

Torches are supplied with a gas cap.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

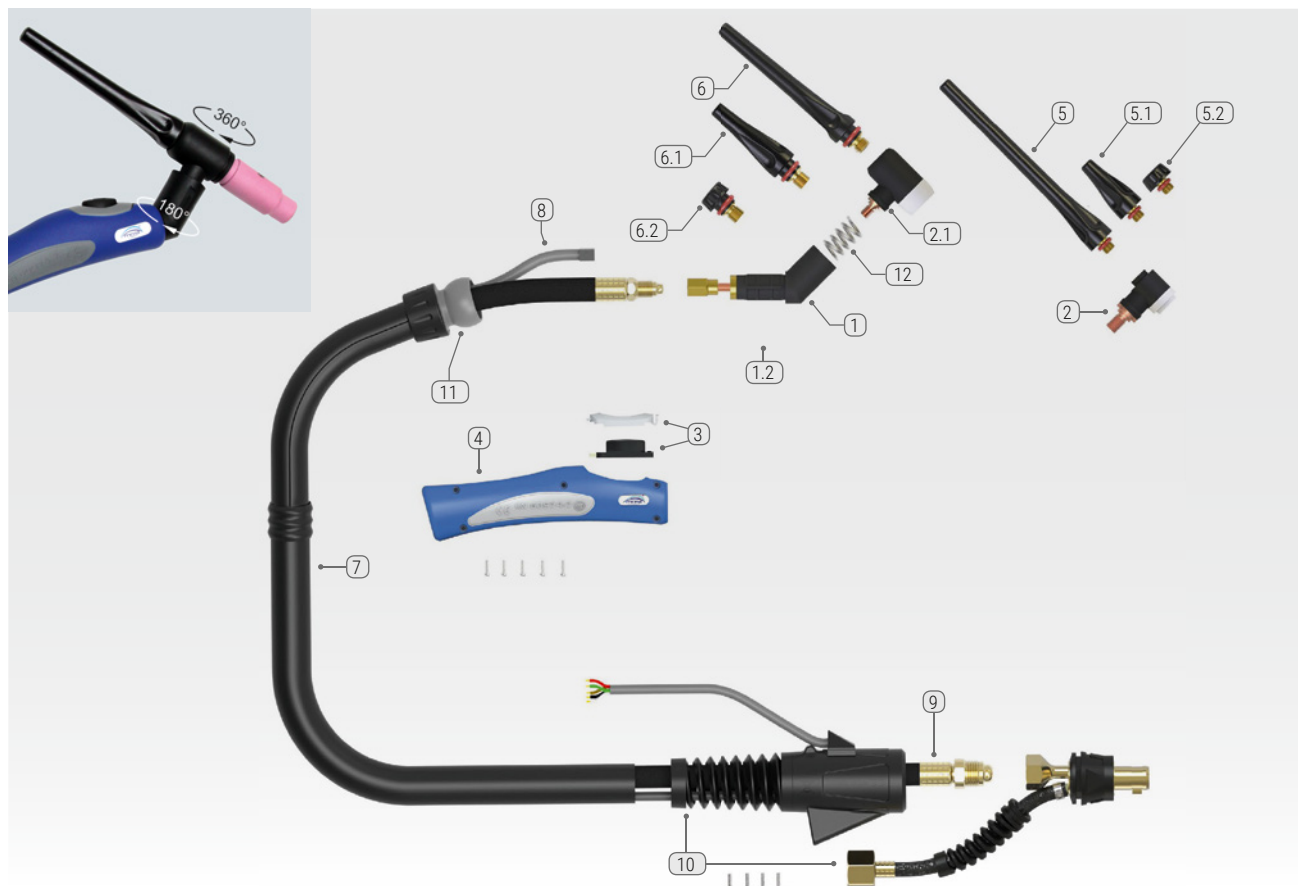
\* standard version

- Parts for TIG torches - pages 73-81.
- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.



## T125 SGRIP

Welding torch with rotating body and torch head



Model	T125 SGRIP	
<b>Cooling</b>	Gas	
<b>Technical data according to EN 60 974-7:</b> ■ Rating 35% duty cycle ■ Tungsten electrode diameter ■ Gas flow	For the UM9-90 head	For the UM17-90* head
	65 A AC / 95 A DC 1,0-1,6 mm 5-12 l/min	105 A AC / 150 A DC 1,0-3,2 mm 5-12 l/min
	<b>Length / Catalogue No.</b>	
	(4,0 m) 56 01 061254	(8,0 m) 56 01 061258

The possibility of using spare parts of the 9/20 and 18/26 standard thanks to the exchangeable burner head.

Torches are supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

\* standard version

No.	Replaceable elements	Catalogue No.	Alternative designation
1	Torch body T125 MOST	56 13 003510	U125M
2	Torch head T125/250 small	56 13 003525	UM9-90
2.1	Torch head T125/250 large	56 13 003526	UM17-90
3	Set button ON/OFF	56 13 200100	UER1MS
4	Small handle TIG SGRIP	56 13 200221	RY-ERH100
5	Long back cup T-9/20	56 13 003170	41V24
5.1	Medium back cup T-9/20	56 13 003250	41V35
5.2	Short back cup T-9/20	56 13 003280	41V33
6	Long back cup T-17/18/26	56 13 003181	57Y02
6.1	Medium back cup T-17/18/26	56 13 003251	-
6.2	Short back cup T-17/18/26	56 13 003270	57Y04
7	Cable cover (m)	51 13 015288	-
7.1	Cable cover 4 m	56 13 200197	USLRCO100-40
7.2	Cable cover 8 m	56 13 200198	USLRCO100-80
8	Control cable T-9/18/26	56 13 200217	UERSWL4
8.1	Control cable T-9/18/26	56 13 200218	UERSWL8
9	Power gas cable T125 4 m	56 13 200200	USLHD57Y01A0B
9.1	Power gas cable T125 8 m	56 13 200201	USLHD57Y03A0B
10	T125 plug assembly	56 13 200274	UNSL3550-917-GS5
11	TIG joint	56 13 200266	UERKJ100
12	Spring T125/250	56 13 003517	4276270

■ Parts for TIG torches - pages 73-81.

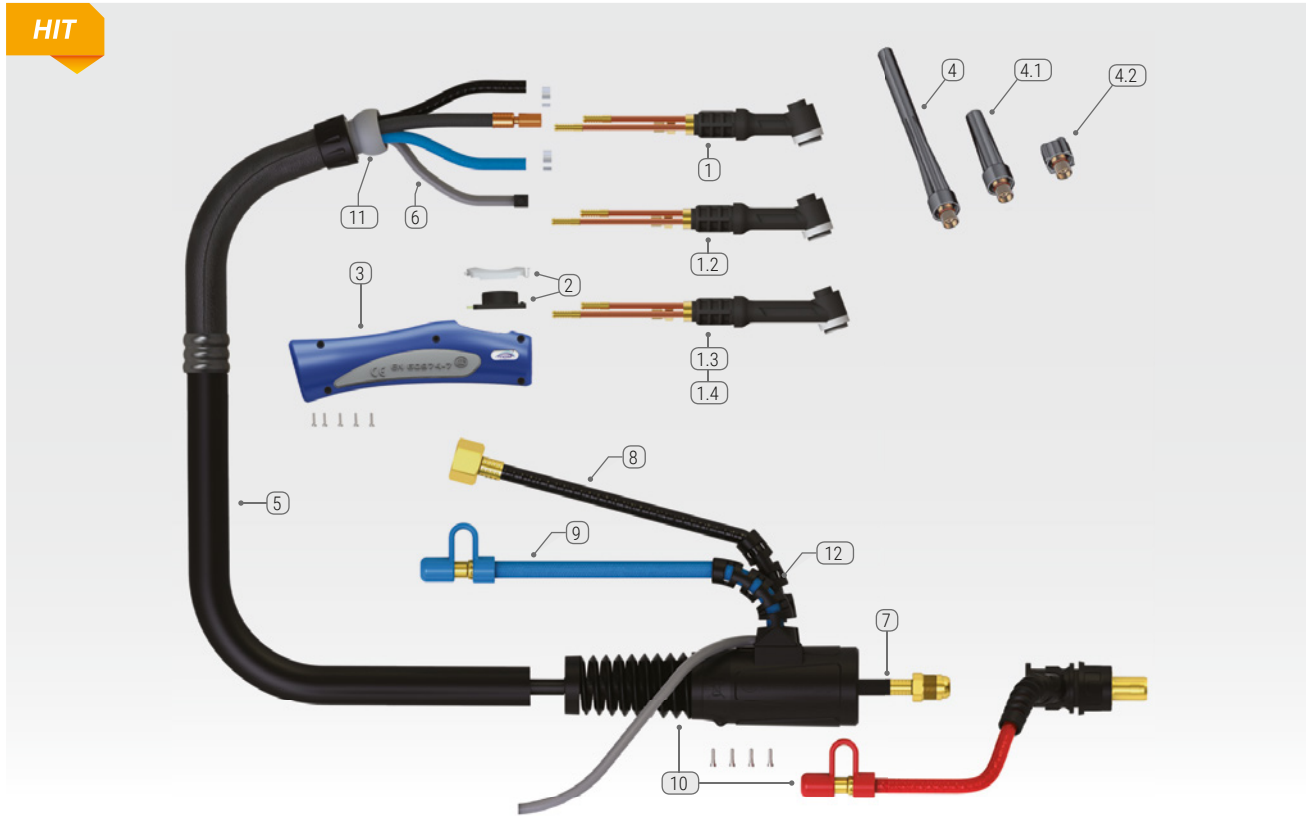
■ We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)

■ TIG welding rods - chapter 10.

■ Tungsten electrodes and tungsten electrode sharpeners - pages 82-83.



T20 SGRIP



Model	T20 SGRIP
<b>Cooling</b>	Liquid
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 100% duty cycle	160 A AC / 225 A DC
▪ Tungsten electrode diameter	1,0-3,2 mm
▪ Gas flow	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 062004 (8,0 m) 56 01 062008 (12,0 m) 56 01 062012

T20F SGRIP version with a flexible torch, technical data as for T26 SGRIP.  
Torches are supplied without control plugs.

V - torch with gas valve, without button.  
F - flexible torch.  
DC - direct current.  
AC - alternating current.

No.	Replaceable elements	Catalogue No.	Alternative designation
3	Small handle TSGRIP	56 13 200221	RY-ERH100
4	Long back cup T-9/20	56 13 003170	41V24
4.1	Medium back cup T-9/20	56 13 003250	41V35
4.2	Short back cup T-9/20	56 13 003280	41V33
5	Cable cover (m)	51 12 015289	-
5.1	Cable cover 4 m	56 13 200197	USLERCO100-40
5.2	Cable cover 8 m	56 13 200198	USLERCO100-80
5.3	Cable cover 12 m	56 13 200199	USLERCO100-120
6	Control cable 4 m Control cable 8 m Control cable 12 m	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
7	20W SGRIP 4 m power water cable 20W SGRIP 8 m power water cable 20W SGRIP 12 m power water cable	56 13 200208 56 13 200209 56 13 200210	USL45V03A0B USL45V04A0B USL45V37A0B
8	Gas line, set 4 m Gas line, set 8 m Gas line, set 12 m	56 13 200187 56 13 200188 56 13 200189	U45V09-GS5 U45V10-GS5 U45V09-37-GS5
9	Blue water hose 4 m Blue water hose 8 m Blue water hose 12 m	56 13 200190 56 13 200191 56 13 200192	UN45V070B-WF1 UN45V080B-WF1 UN45V07-370B-WF1
10	TIG 18/20 plug assembly	56 13 200273	UNSL 35-50-1820-WR1
11	TIG joint	56 13 200266	UERKJ100
12	Cable stiffener	56 13 200265	USLH-1820S

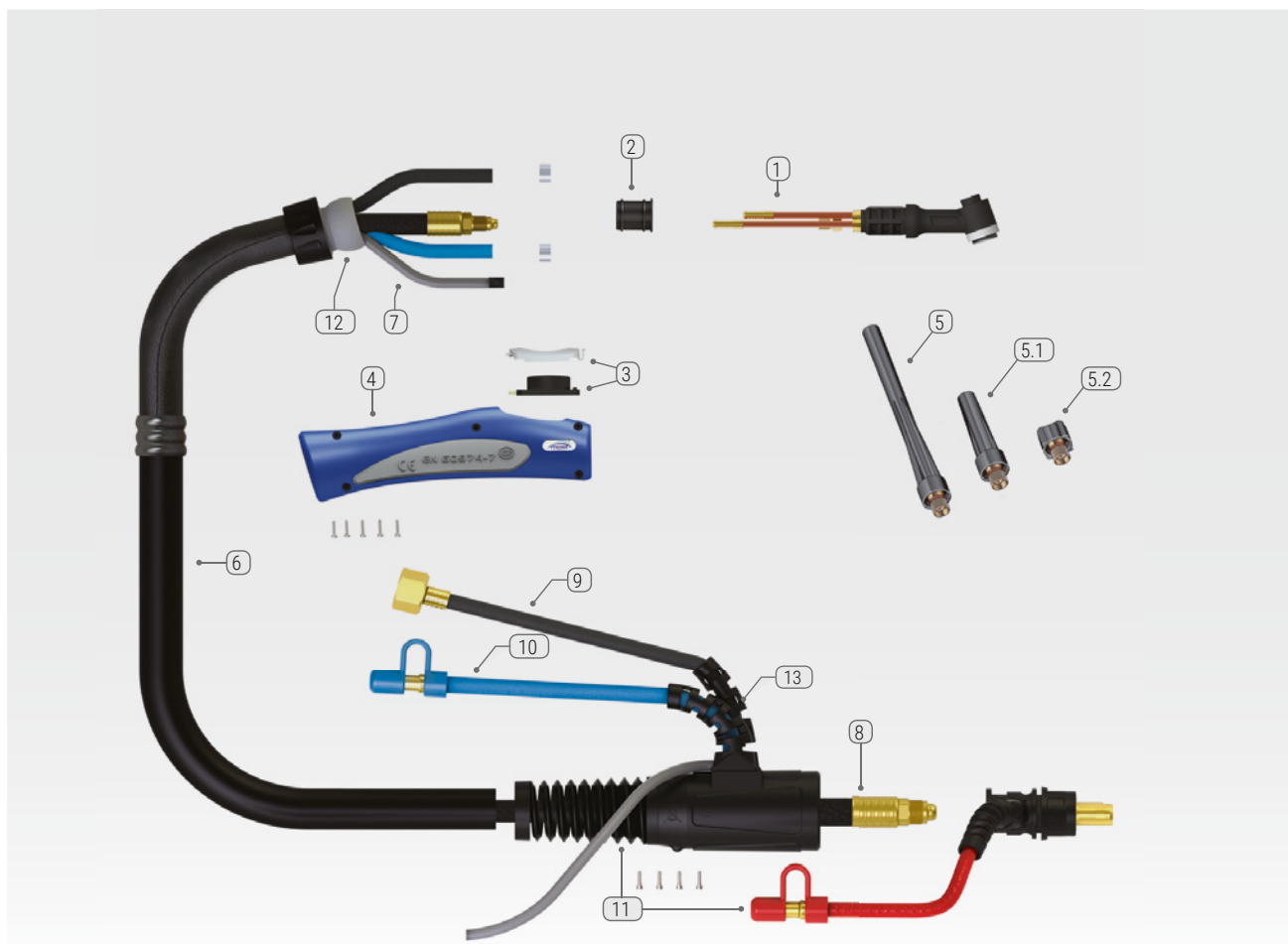
\* standard version

No.	Replaceable elements	Catalogue No.	Alternative designation
1	SR-20W MOST* torch body	56 13 003375	-
1.1	SR-20F MOST torch body	56 13 200008	-
1.2	T-20F torch body L=75 mm	56 13 003466	-
1.3	T-20F torch body L=100 mm	56 13 003467	-
1.4	T-20F torch body L=125 mm	56 13 003468	-
2	Set button ON/OFF	56 13 200100	UER1MS

- Parts for TIG torches - pages 73-81.
- We recommend using special coolants as on page 16.
- TIG welding rods - chapter 10.
- Tungsten electrodes and electrode sharpeners - pages 82-83.



## T20S SGRIP



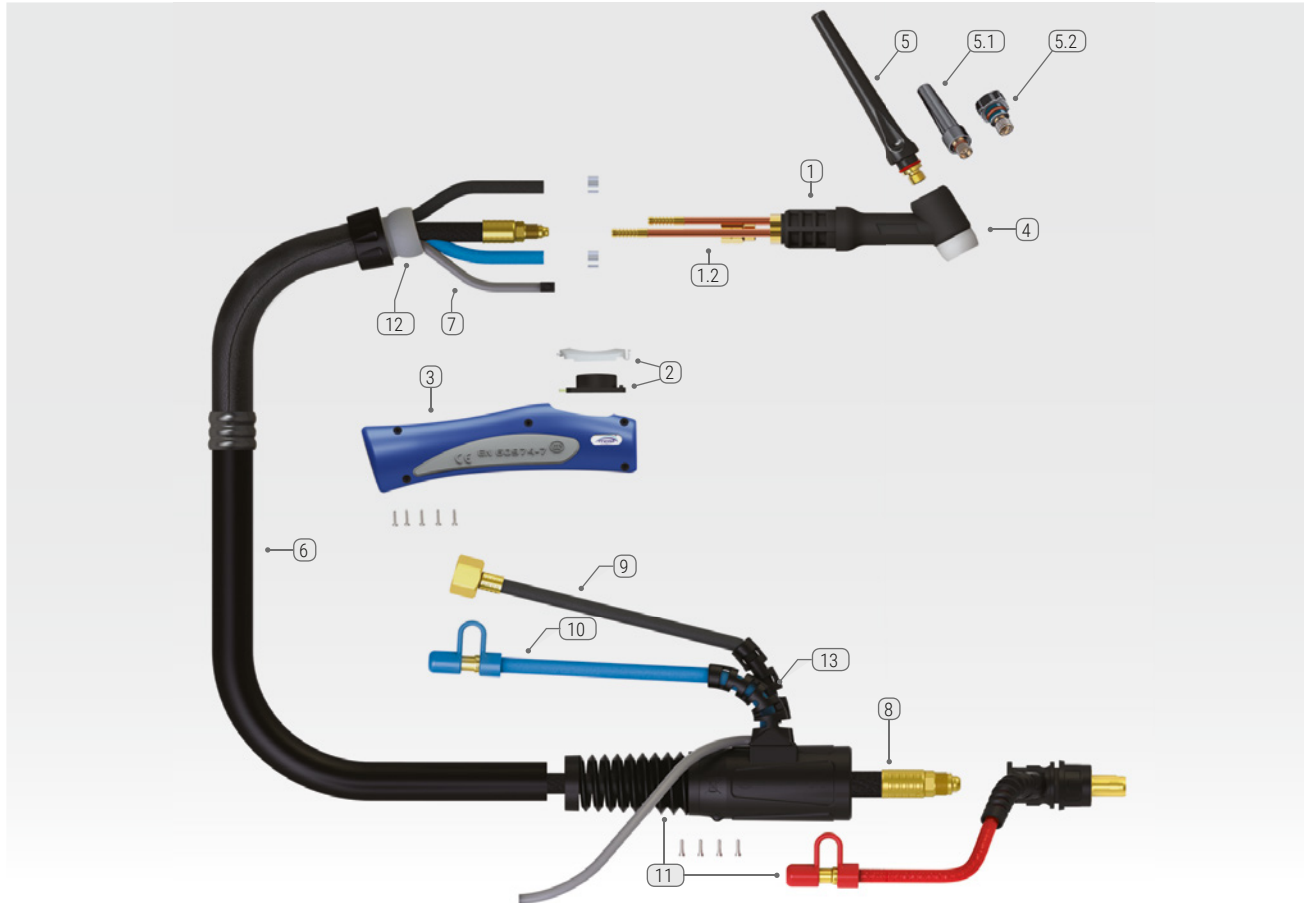
Model	T20S SGRIP
<b>Cooling</b>	Liquid
<b>Technical data according to EN 60 974-7:</b>	
▪ Rating 100% duty cycle	240 A AC / 340 A DC
▪ Tungsten electrode diameter	1,0-3,2 mm
▪ Gas flow	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 062016 (8,0 m) 56 01 062018

No.	Replaceable elements	Catalogue No.	Alternative designation
1	<b>T20S Torch body MOST</b>	56 13 200007	
2	<b>Adapter T20 torch head/large handle</b>	56 13 200290	
3	<b>Set button ON/OFF</b>	56 13 200100	UER1MS
4	<b>TIG SGRIP large handle</b>	56 13 200220	RY-ERH200
5	<b>Long back cup T-9/20</b>	56 13 003170	41V24
5.1	<b>Medium back cup T-9/20</b>	56 13 003250	42V35
5.2	<b>Short back cup T-9/20</b>	56 13 003280	41V33
6	<b>Cable cover</b>	51 13 015289	
6.1	<b>Cable cover 4 m</b>	56 13 200250	USLERCO200-40
6.2	<b>Cable cover 8 m</b>	56 13 200251	USLERCO200-80
7	<b>Control cable 4 m</b> <b>Control cable 8 m</b>	56 13 200217 56 13 200218	UERSWL4 UERSWL8
8	<b>18W SGRIP 4 m power water cable</b> <b>18W SGRIP 8 m power water cable</b>	56 13 200204 56 13 200205	USL40V64A0B USL41V29A0B
9	<b>Gas line, set 4 m</b> <b>Gas line, set 8 m</b>	56 13 200184 56 13 200185	U45V090B-GS5 U45V100B-GS5
10	<b>Blue water hose 4 m</b> <b>Blue water hose 8 m</b>	56 13 200190 56 13 200191	U45V070B-WF1 U45V080B-WF1
11	<b>TIG18/20 plug assembly</b>	56 13 200273	UNSL 35-50-1820-WR1
12	<b>TIG joint</b>	56 13 200264	UERKJ200
13	<b>Cable stiffener</b>	56 13 200265	USLH-1820S

- Parts for TIG torches - pages 73-81.
- We recommend using special coolants as on page 16.
- TIG welding rods - chapter 10.
- Tungsten electrodes and electrode sharpeners - pages 82-83.



T18 SGRIP / T18SC SGRIP



Model	T18 SGRIP	T18SC SGRIP
<b>Cooling</b>	Liquid	Liquid
<b>Technical data according to EN 60 974-7:</b>		
▪ Rating 35% duty cycle	270 A AC / 380 A DC	290 A AC / 410 A DC
▪ Tungsten electrode diameter	1,0-4,0 mm	1,0-4,0 mm
▪ Gas flow	5-12 l/min	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 061804 (8,0 m) 56 01 061808 (12,0 m) 56 01 061812	(4,0 m) 56 01 061814 (8,0 m) 56 01 061818 (12,0 m) 56 01 061822

T18F SGRIP version with a flexible torch, technical data as for T18 SGRIP. Torches are supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

No.	Replaceable elements	Catalogue No.	Alternative designation
5.1	Medium back cup T-17/18/26	56 13 003251	-
5.2	Short back cup T-17/18/26	56 13 003270	57Y04
6	Cable cover (m)	51 13 015289	-
6.1	Cable cover 4 m	56 13 200250	USLERCO200-40
6.2	Cable cover 8 m	56 13 200251	USLERCO200-80
6.3	Cable cover 12 m	56 13 200252	USLERCO200-120
7	Control cable 4 m Control cable 8 m Control cable 12 m	56 13 200217 56 13 200218 56 13 200219	UERSWL4 UERSWL8 UERSWL12
8	18W SGRIP 4 m power water cable 18W SGRIP 8 m power water cable 18W SGRIP 12 m power water cable	56 13 200204 56 13 200205 56 13 200206	USL40V64A0B USL41V29A0B USL41V37A0B
9	Gas line, set 4 m Gas line, set 8 m Gas line, set 12 m	56 13 200184 56 13 200185 56 13 200186	U45V090B-GS5 U45V100B-GS5 U45V09-370-GS5
10	Blue water hose 4 m Blue water hose 8 m Blue water hose 12 m	56 13 200190 56 13 200191 56 13 200193	U45V070B-WF1 U45V080B-WF1 U4507-370B-WF1
11	TIG18/20 plug assembly	56 13 200273	UNSL 35-50-1820-WR1
12	TIG joint	56 13 200264	UERKJ200
13	Cable stiffener	56 13 200265	USLH-1820S

\* standard version

No.	Replaceable elements	Catalogue No.	Alternative designation
1	T-18W MOST* torch body	56 13 003372	-
1.1	T-18F MOST torch body (flexible)	56 13 200010	UWP18FX
1.2	T-18SC MOST torch body (reinforced)	56 13 200012	UWP18SC
2	Set button ON/OFF	56 13 200100	UER1MS
3	TIG SGRIP large handle	56 13 200220	RY-ERH200
4	T-17/18/26 insulator	56 13 014810	18CG
5	Long back cup T-17/18/26	56 13 003181	57Y02

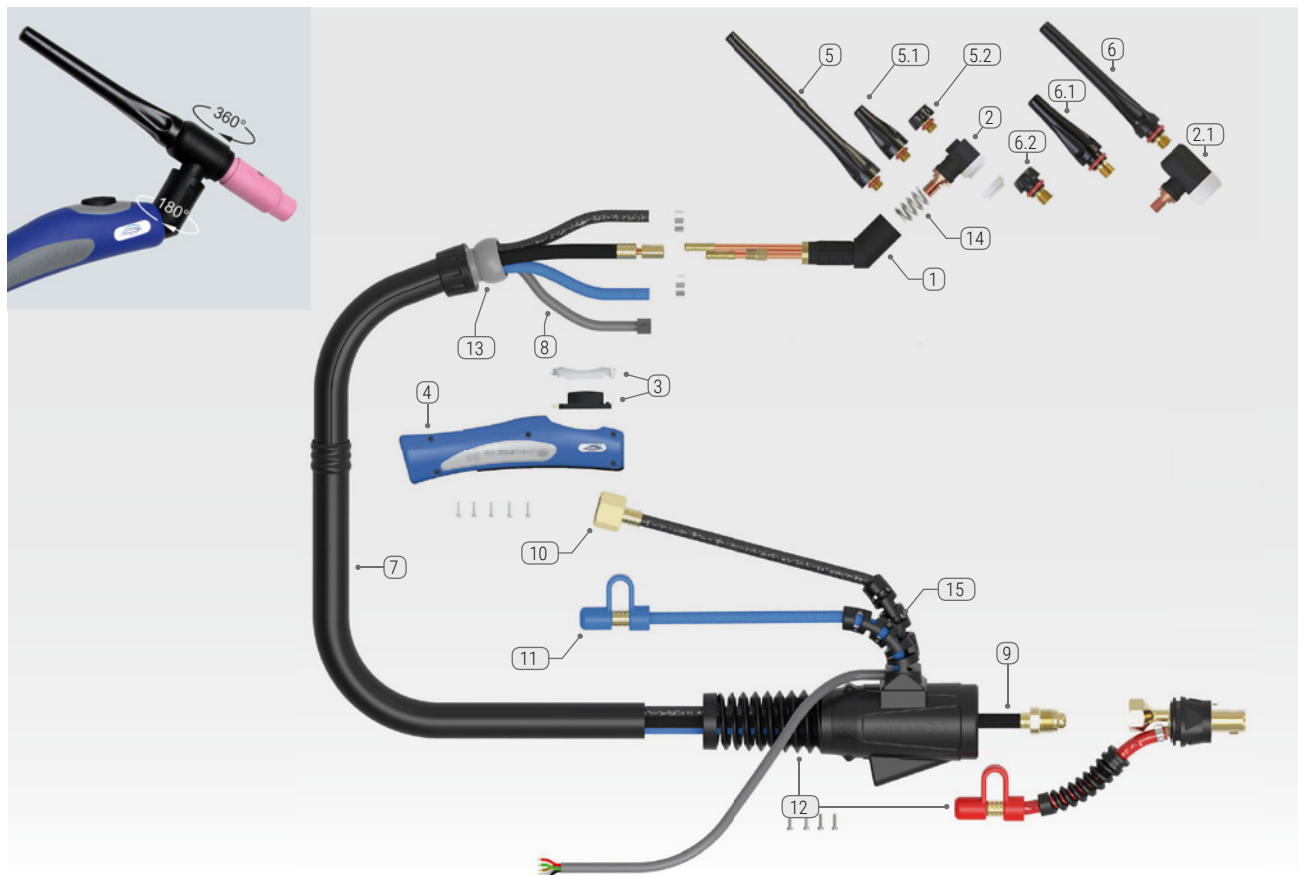
- Parts for TIG torches - pages 73-81.
- We recommend using special coolants as on page 16.
- TIG welding rods - chapter 10.
- Tungsten electrodes and electrode sharpeners - pages 82-83.





## T250 SGRIP

Welding torch with rotating body and torch head



Model	T250 SGRIP	
<b>Cooling</b>	Liquid	
<b>Technical data according to EN 60 974-7:</b>	For the UM9-90* head	For the UM17-90 head
▪ Rating 100% duty cycle	160 A AC / 225 A DC	175 A AC / 250 A DC
▪ Tungsten electrode diameter	1,0-3,2 mm	1,0-4,0 mm
▪ Gas flow	5-12 l/min	5-12 l/min
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 061284	(8,0 m) 56 01 061288

Torches are supplied without control plugs.

V - torch with gas valve, without button.

F - flexible torch.

DC - direct current.

AC - alternating current.

\* standard version

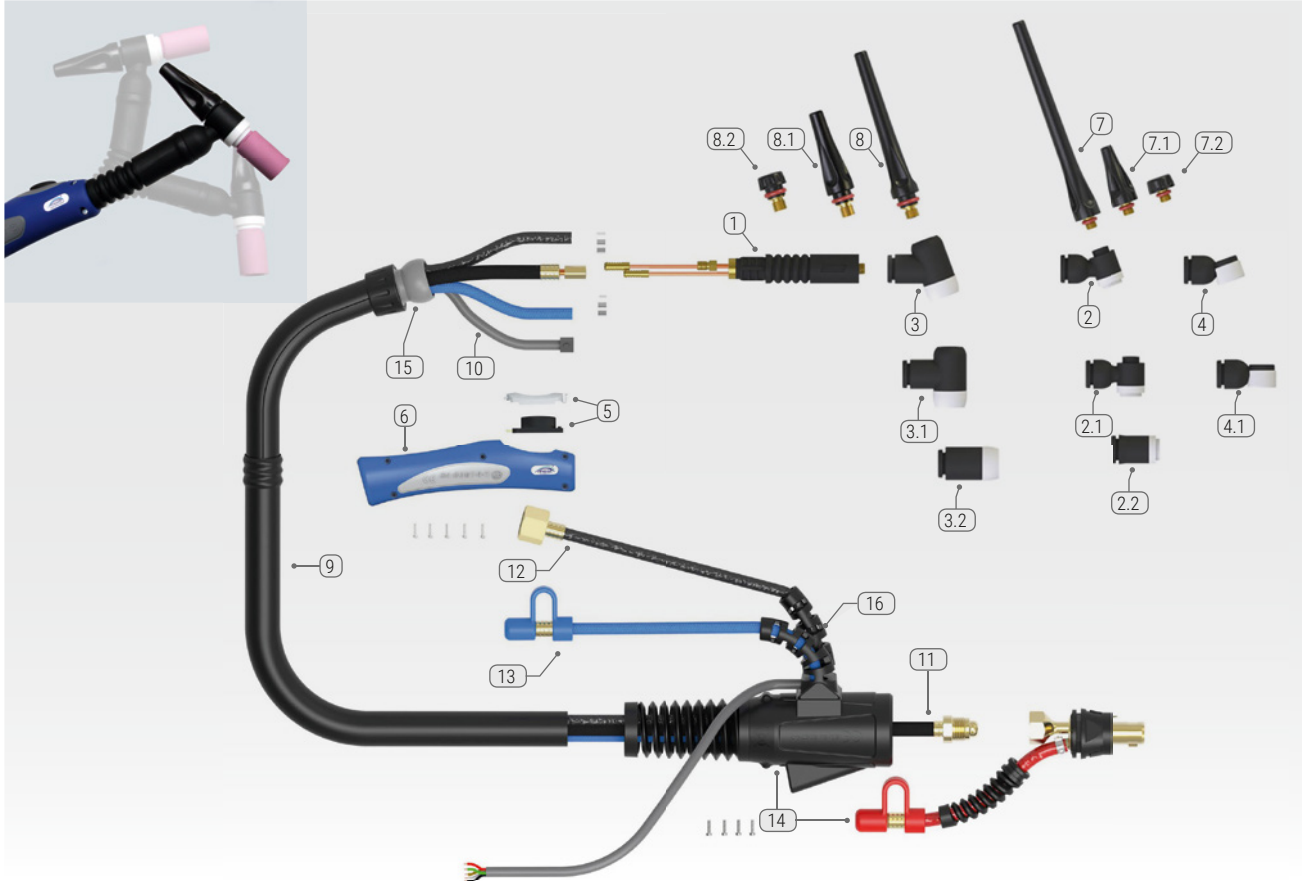
No.	Replaceable elements	Catalogue No.	Alternative designation
1	<b>Torch body T250 MOST</b>	56 13 003515	U250M
2	<b>Torch head T125/250 small</b>	56 13 003525	UM9-90
2.1	<b>Torch head T125/250 large</b>	56 13 003526	UM17-90
3	<b>Set button ON/OFF</b>	56 13 200100	UER1MS
4	<b>Small handle TSGRIP</b>	56 13 200221	RY-ERH100
5	<b>Long back cup SR-9/20</b>	56 13 003170	41V24
5.1	<b>Medium back cup SR-9/20</b>	56 13 003250	41V35
5.2	<b>Short back cup SR-9/20</b>	56 13 003280	41V33
6	<b>Long back cup T-17/18/26</b>	56 13 003181	57Y02
6.1	<b>Medium back cup T-17/18/26</b>	56 13 003251	-
6.2	<b>Short back cup T-17/18/26</b>	56 13 003270	57Y04
7	<b>Cable cover (m)</b>	51 13 015289	-
7.1	<b>Cable cover 4 m</b>	56 13 200197	USLERC0100-40
7.2	<b>Cable cover 8 m</b>	56 13 200198	USLERC0100-80
8	<b>Control cable T-9/18/26 4 m</b>	56 13 200217	UERSWL4
8.1	<b>Control cable T-9/18/26 8 m</b>	56 13 200218	UERSWL8
9	<b>T250 4 m power-water cable</b>	56 13 200208	USL45V03AOB
9.1	<b>T250 8 m power-water cable</b>	56 13 200209	USL45V04AOB
10	<b>Gas line, set 4 m</b>	56 13 200187	U45V09-GS5
	<b>Gas line, set 8 m</b>	56 13 200188	U45V10-GS5
	<b>Gas line, set 12 m</b>	56 13 200189	U45V09-37-GS5
11	<b>Blue water hose 4 m</b>	56 13 200190	UN45V070B-WF1
	<b>Blue water hose 8 m</b>	56 13 200191	UN45V080B-WF1
	<b>Blue water hose 12 m</b>	56 13 200192	UN45V07-370B-WF1
12	<b>T250 plug assembly</b>	56 13 200273	UNSL3550-1820-WR1
13	<b>TIG joint</b>	56 13 200266	UERKJ100
14	<b>Spring T125/250</b>	56 13 003517	4276270
15	<b>Cable stiffener</b>	56 13 200265	USLH-1820S

- Parts for TIG torches - pages 73-81.
- We recommend using special coolants as on page 16.
- TIG welding rods - chapter 10.
- Tungsten electrodes and electrode sharpeners - pages 82-83.



### T225F SGRIP

Torch with flexible torch body and interchangeable torch heads



Model	T225F SGRIP	
<b>Cooling</b>	Liquid	
<b>Technical data according to EN 60 974-7:</b>	For the UM9-20* head 140 A AC / 200 A DC 1,0-2,4 mm 5-12 l/min	For the UM18-26 head 160 A AC / 225 A DC 1,0-3,2 mm 5-12 l/min
<ul style="list-style-type: none"> <li>▪ Rating 100% duty cycle</li> <li>▪ Tungsten electrode diameter</li> <li>▪ Gas flow</li> </ul>		
<b>Length / Catalogue No.</b>	(4,0 m) 56 01 061304 (8,0 m) 56 01 061308	

Torches are supplied without control plugs.

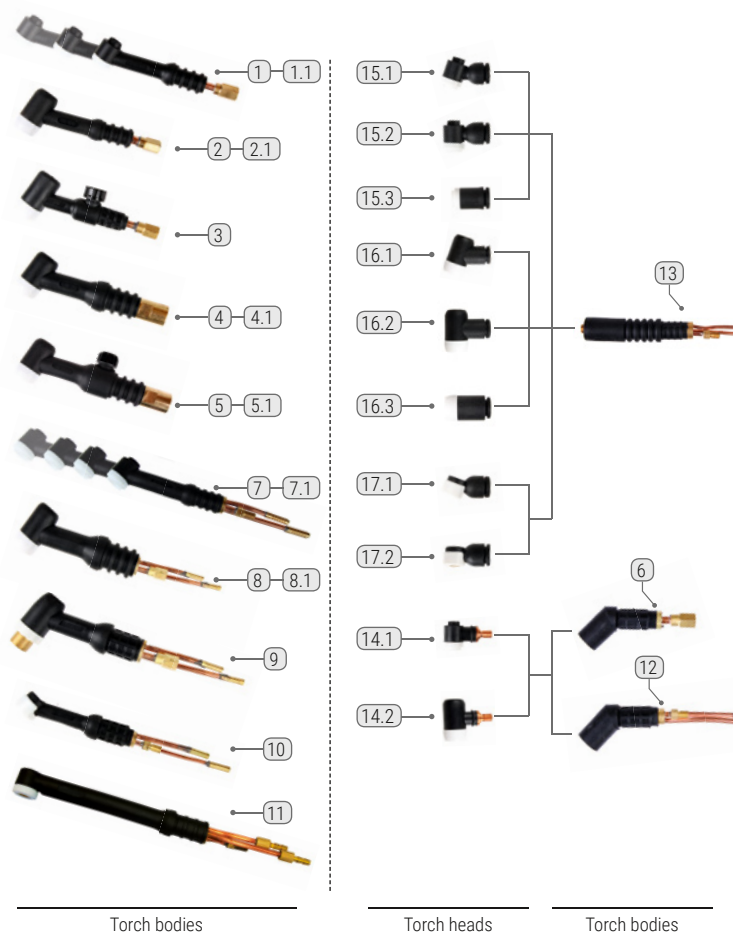
F- flexible torch.  
\* standard version

No.	Replaceable elements	Catalogue No.	Alternative designation
1	T225F MOST torch body	56 13 003520	U225F
2	T225F 9/20 70° UM20-70 MOST* torch head	56 13 003530	UM20-70
2.1	T225F 9/20 90° UM20-90 MOST torch head	56 13 003531	UM20-90
2.2	T225F 9/20 180° UM20-180 MOST torch head	56 13 003532	UM20-180
3	T225F 18/26 70° UM18-70 MOST torch head	56 13 003540	UM18-70
3.1	T225F 18/26 90° UM18-90 MOST torch head	56 13 003541	UM18-90
3.2	T225F 18/26 180° UM18-180 MOST torch head	56 13 003542	UM18-180

- Parts for TIG torches - see pages 73-81.
- We recommend using special coolants as on page 16.

No.	Replaceable elements	Catalogue No.	Alternative designation
4	T225F 24 70° UM24-70 MOST torch head	56 13 003550	UM24-70
4.1	T225F 24 90° UM24-90 MOST torch head	56 13 003551	UM24-90
5	Set button ON/OFF	56 13 200100	UERBS
6	Small handle TIG SGRIP	56 13 200221	RY-ERH100
7	Long back cup T-9/20	56 13 003170	41V24
7.1	Medium back cup T-9/20	56 13 003250	41V35
7.2	Short back cup T-9/20	56 13 003280	41V33
8	Long back cup T-17/18/26	56 13 003181	57Y02
8.1	Medium back cup T-17/18/26	56 13 003251	-
8.2	Short back cup T-17/18/26	56 13 003270	57Y04
9	Cable cover (m)	51 13 015289	-
9.1	Cable cover 4 m	56 13 200197	USLERCO100-40
9.2	Cable cover 8 m	56 13 200198	USLERCO100-80
10	Control cable T-9/18/26 4 m	56 13 200217	UERSWL4
10.1	Control cable T-9/18/26 8 m	56 13 200218	UERSWL8
11	T225F 4 m water cable	56 13 200208	USL45V03AOB
11.1	T225F 8 m water cable	56 13 200209	USL45V04AOB
12	Gas line, set 4 m	56 13 200187	U45V09-GS5
12.1	Gas line, set 8 m	56 13 200188	U45V10-GS5
13	Blue water hose 4 m	56 13 200190	UN45V070B-WF1
13.1	Blue water hose 8 m	56 13 200191	UN45V080B-WF1
14	T225F plug assembly	56 13 200273	UNSL3550-1820-WR1
15	TIG joint	56 13 200266	UERKJ100
16	Cable stiffener	56 13 200265	USLH-1820S

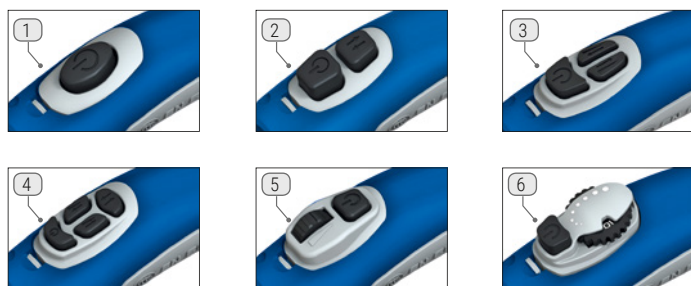
TIG torch bodies and heads



No.	Replaceable elements	Catalogue No.
gas cooled	1 Torch body T9 MOST	56 13 003350
	1.1 Torch body T9F (flexible) MOST	56 13 003351
	Torch body T9FXL L=75 mm (flexible) MOST	56 13 00335L
	Torch body T9FXL L=100 mm (flexible) MOST	56 13 00335X
	2 Torch body T17 MOST	56 13 003367
	2.1 Torch body T17F (flexible) MOST	56 13 003382
	3 Torch body T17V MOST	56 13 003417
	4 Torch body T26 MOST	56 13 003398
	4.1 Torch body T26F (flexible) MOST	56 13 003397
	5 Torch body T26V MOST	56 13 003369
	5.1 Torch body T26VF (flexible) MOST	56 13 003370
	6 Torch body T125 MOST (rotating*)	56 13 003510
	liquide cooled	7 Torch body T20 MOST
7.1 Torch body T20F (flexible) MOST		56 13 200008
Torch body T20FXL L=75 mm (flexible) MOST		56 13 003466
Torch body T20FXL L=100 mm (flexible) MOST		56 13 003467
Torch body T20FXL L=125 mm (flexible) MOST		56 13 003468
8 Torch body T18 MOST		56 13 003372
8.1 Torch body T18F (flexible) MOST		56 13 200010
9 Torch body T18SC MOST		56 13 200012
10 Torch body T24W MOST		56 13 200014
11 Torch body T24W FXL L=120 mm (flexible) MOST		56 13 200016
12 Torch body T250 MOST (rotating*)		56 13 003515
13 Torch body T225F (flexible) MOST		56 13 003520
torch heads		14.1 Torch head T125/250 mała 9/20 MOST
	14.2 Torch head T125/250 duża 17/18/26 MOST	56 13 003526
	15.1 Torch head T225F 9/20 70° MOST	56 13 003530
	15.2 Torch head T225F 9/20 90° MOST	56 13 003531
	15.3 Torch head T225F 9/20 180° MOST	56 13 003532
	16.1 Torch head T225F 17/18/26 70° MOST	56 13 003540
	16.2 Torch head T225F 17/18/26 90° MOST	56 13 003541
	16.3 Torch head T225F 17/18/26 180° MOST	56 13 003542
17.1 Torch head T225F 24W 70° MOST	56 13 003550	
17.2 Torch head T225F 24W 90° MOST	56 13 003551	

F - flexible V - with gas valve XL/XXL - extended

TIG SGRIP switches MOST



No.	Replaceable elements	Catalogue No.
1	ON/OFF momentary kit	56 13 200100
2	Button momentary kit	56 13 200107
3	Button momentary kit	56 13 200108
4	Button momentary kit	56 13 200104
5	Button maintained kit+10K vertical potentiometer	56 13 200112
6	Button maintained kit+10K horizontal potentiometer	56 13 200116

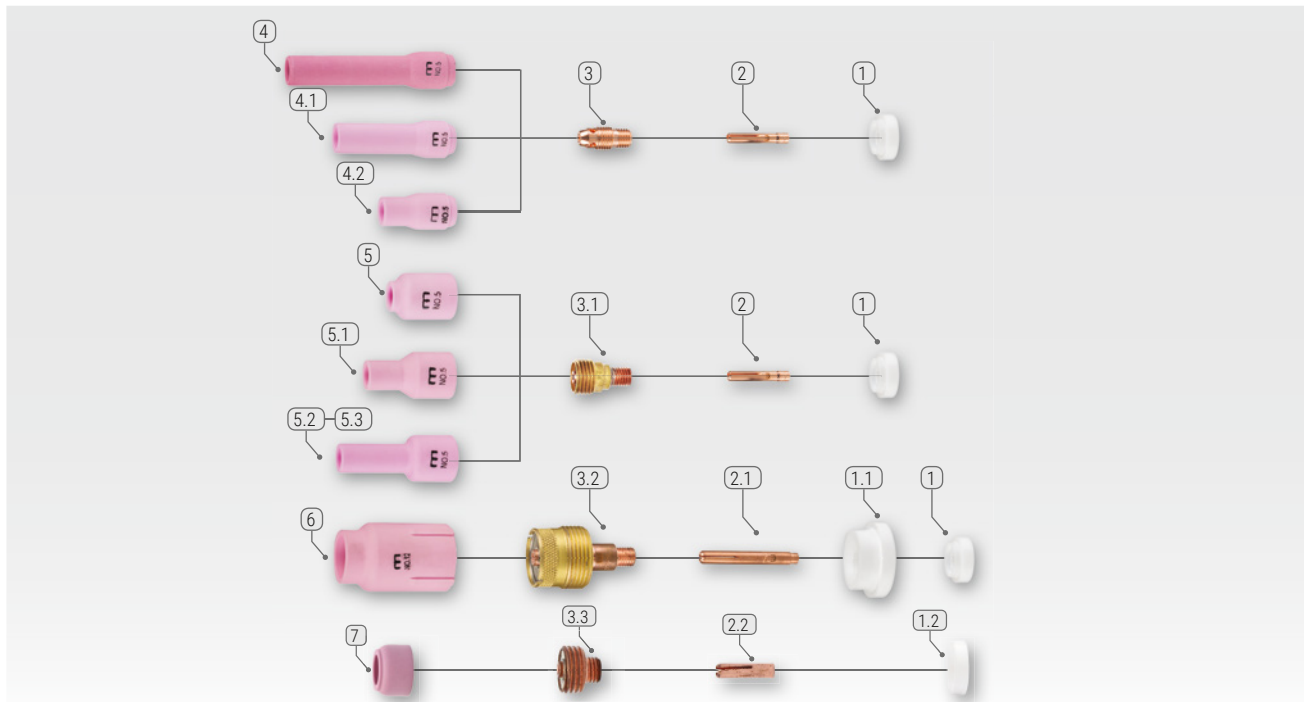
"Plug & Play" Switches can be replaced in 5 seconds without the use of tools



▼ 8.8. Spare parts for TIG welding torches



Parts compatible with 9, 20 and T20S TIG welding torches  
 T125/T250 for the UM9-90 torch head  
 T225F for UM20-70, UM20-90, UM20-180 torch heads



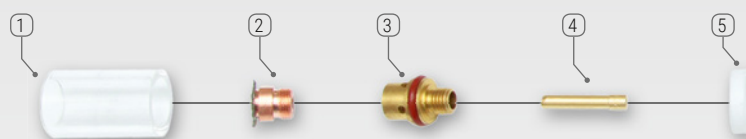
No.	Replaceable elements	Catalogue No.	Altern. ident.
1	9/20 insulator	56 13 014806	598882
1.1	Jumbo 9/20 lens isolator	56 13 014813	56N63-20
1.2	Nozzle insulator 14x32,5 9/20	56 13 013125	
2	Collet 1,0 9/20	56 13 009920	13N21
	Collet 1,6 9/20	56 13 009922	13N22
	Collet 2,0 9/20	56 13 009923	
	Collet 2,4 9/20	56 13 009924	13N23
	Collet 3,2 9/20	56 13 009927	13N24
2.1	Collet sleeve for Jumbo 1,6 9/20 lens	56 13 009983	13N22L
	Collet sleeve for Jumbo lens 2,4 9/20	56 13 009984	13N23L
	Collet sleeve for Jumbo 3,2 9/20 lens	56 13 009985	13N24L
2.2	Collet XS 4x20 2,4 9/20	56 13 010008	
3	TIG collet body 1,0 9/20	56 13 003840	13N26
	TIG collet body 1,6 9/20	56 13 003881	13N27
	TIG collet body 2,0 9/20	56 13 003912	
	TIG collet body 2,4 9/20	56 13 003920	13N28
	TIG collet body 3,2 9/20	56 13 003950	13N29
3.1	Gas lens 1,0 9/20/24	56 13 008230	45V42
	Gas lens 1,6 9/20/24	56 13 008250	45V43
	Gas lens 2,4 9/20/24	56 13 008271	45V44
	Gas lens 3,2 9/20/24	56 13 008300	45V45
3.2	Jumbo gas lens 1,6 9/20	56 13 008313	45V116S
	Jumbo gas lens 2,4 9/20	56 13 008314	45V64S
	Jumbo gas lens 3,2 9/20	56 13 008315	995795S
3.3	Gas lens XS 2,4	56 13 008353	

No.	Replaceable elements	Catalogue No.	Altern. ident.
4	Ceramic nozzle 6,5x63 #4	56 13 000914	796F75
	Ceramic nozzle 8,0x63 #5	56 13 000915	796F76
4.1	Ceramic nozzle 6,5x48 #4	56 13 000947	796F71
	Ceramic nozzle 8,0x48 #5	56 13 000946	796F72
	Ceramic nozzle 9,5x48 #6	56 13 000945	796F73
4.2	Ceramic nozzle 6,5x30 #4	56 13 000384	13N08
	Ceramic nozzle 8,0x30 #5	56 13 000386	13N09
	Ceramic nozzle 9,5x30 #6	56 13 000390	13N10
	Ceramic nozzle 11,0x30 #7	56 13 000394	13N11
	Ceramic nozzle 12,5x30 #8	56 13 000396	13N12
5	Ceramic nozzle 16,0x30 #9	56 13 000398	13N13
	Ceramic nozzle for lens 6,5x25,5 #4	56 13 000908	53N58
	Ceramic nozzle for lens 8,0x25,5 #5	56 13 000910	53N59
	Ceramic nozzle for lens 9,5x25,5 #6	56 13 000911	53N60
5.1	Ceramic nozzle for lens 11,0x25,5 #7	56 13 000912	53N61
	Ceramic nozzle for lens 6,5x35 #4	56 13 000426	53N58L
	Ceramic nozzle for lens 8,0x35 #5	56 13 000427	53N59L
5.2	Ceramic nozzle for lens 9,5x35 #6	56 13 000428	53N60L
	Ceramic nozzle for lens 6,5x48 #4	56 13 000430	53N58XL
	Ceramic nozzle for lens 8,0x48 #5	56 13 000431	53N59XL
5.3	Ceramic nozzle for lens 9,5x48 #6	56 13 000432	53N60XL
	Ceramic nozzle for lens 6,5x63 #4	56 13 000444	53N58XXL
	Ceramic nozzle for lens 8,0x63 #5	56 13 000445	53N59XXL
6	Ceramic nozzle for lens 9,5x63 #6	56 13 000446	53N60XXL
	Ceramic nozzle for lens Jumbo 9,5x48 #8	56 13 001115	57N75
	Ceramic nozzle for lens Jumbo 12,5x48 #8	56 13 001120	57N74
	Ceramic nozzle for lens Jumbo 16,0x48 #10	56 13 001136	53N88
7	Ceramic nozzle for lens Jumbo 19,5x48 #12	56 13 001119	53N87
	Nozzle XS 11x12	56 13 000521	

### System for a 14x32,5 transparent nozzle

Improves weld pool visibility.

**NEW**  
in offer



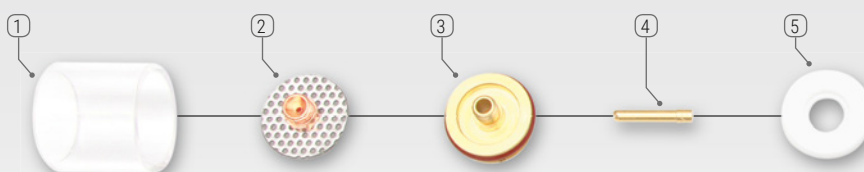
No.	Replaceable elements	Catalogue No.
1	14x32,5 transparent nozzle	56 13 013015
2	Gas lens 1,6 small 14 mm	56 13 013041
	Gas lens 2,4 small 14 mm	56 13 013043
	Gas lens 3,2 small 14 mm	56 13 013044
3	Adapter for 14x32,5 9/20 system	56 13 013141
4	Collet 1,0 25,5 mm	56 13 013080
	Collet 1,6 25,5 mm	56 13 013081
	Collet 2,4 25,5 mm	56 13 013083
	Collet 3,2 25,5 mm	56 13 013084
5	Nozzle insulator 14x32,5 9/20	56 13 013125

### System for 29x32 transparent nozzle

Improves weld pool visibility.

Very good laminar gas shield.

**NEW**  
in offer

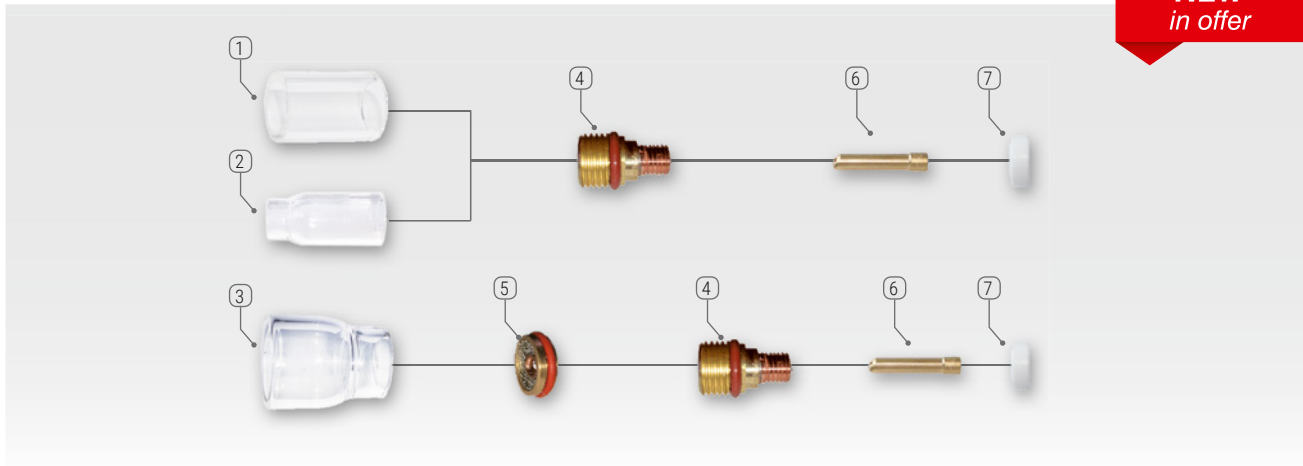


No.	Replaceable elements	Catalogue No.
1	Transparent nozzle 29x32	56 13 013005
2	Gas lens 1,0 large 29 mm	56 13 013030
	Gas lens 1,6 large 29 mm	56 13 013031
	Gas lens 2,4 large 29 mm	56 13 013033
	Gas lens 3,2 large 29 mm	56 13 013034
3	Adapter for 29x32 system	56 13 013136
4	Collet 1,6 25,5 mm	56 13 013081
	Collet 2,4 25,5 mm	56 13 013083
	Collet 3,2 25,5 mm	56 13 013084
5	Nozzle insulator 29x32	56 13 013121



System for a transparent nozzle with a gas lens

**NEW**  
in offer



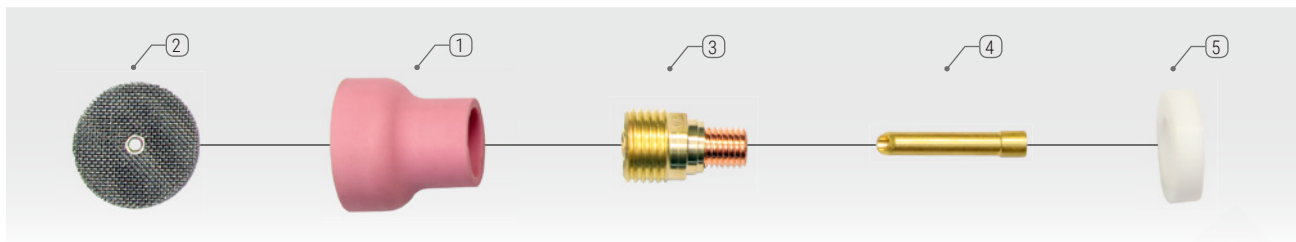
No.	Replaceable elements	Catalogue No.
1	14x32,5 transparent nozzle	56 13 013015
2	Transparent nozzle 9,5x32,5 Transparent nozzle 11x32,5	56 13 013022 56 13 013023
3	Transparent nozzle 25x19,5x28	56 13 013020
4	Gas lens 1,6 45V43 9/20 with an O-ring Gas lens 2,4 45V44 9/20 with an O-ring Gas lens 3,2 45V45 9/20 with an O-ring	56 13 013047 56 13 013048 56 13 013049
5	Adapter for 25x19,5x28 1,6 system Adapter for 25x19,5x28 2,4 system Adapter for 25x19,5x28 3,2 system	56 13 013144 56 13 013145 56 13 013146
6	Collet 1,6 25,5 mm Collet 2,4 25,5 mm Collet 3,2 25,5 mm	56 13 013081 56 13 013083 56 13 013084
7	Nozzle insulator 14x32,5 9/20	56 13 013125



- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - see pages 82-83.

## XL Cup system

Superior gas coverage, allows for longer electrode stick outs, perfect for welding in tight spaces.



No.	Replaceable elements	Catalogue No.	Remarks
1	Ceramic cup XL 19x26 #12	56 13 000980	
	Ceramic cup XL 23x26 #14	56 13 000981	
	Ceramic cup XL 26x29 #16	56 13 000982	
2	Strainer XL 19x26 1.6	56 13 008370	for the cup #12 19x26
	Strainer XL 19x26 2.4	56 13 008371	
	Strainer XL 19x26 3.2	56 13 008372	
	Strainer XL 23x26 1.6	56 13 008375	for the cup #14 23x26
	Strainer XL 23x26 2.4	56 13 008376	
	Strainer XL 23x26 3.2	56 13 008377	
3	Strainer XL 26x29 1.6	56 13 008378	for the cup #16 26x29
	Strainer XL 26x29 2.4	56 13 008379	
	Strainer XL 26x29 3.2	56 13 008380	
3	Gas lens 9/20 1.6 45V43 MOST	56 13 008250	
	Gas lens 9/20 2.4 45V44 MOST	56 13 008271	
	Gas lens 9/20 3.2 45V45 MOST	56 13 008300	
4	Collet 1.6 25,5 mm	56 13 013081	
	Collet 2.4 25,5 mm	56 13 013083	
	Collet 3.2 25,5 mm	56 13 013084	
5	Cup insulator 14x32,5 9/20	56 13 013125	

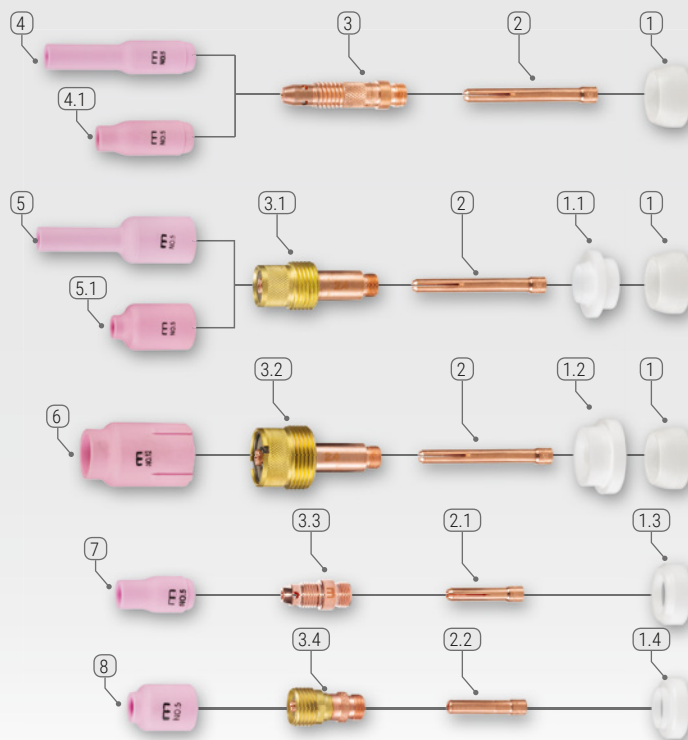


## XL Cup kits for the TIG torches T9 SGRIP and T20 SGRIP MOST

Name	Catalogue No.
XL Cup kit XL #12 2.4	56 13 001501
XL Cup kit XL #14 2.4	56 13 001505
XL Cup kit XL #16 2.4	56 13 001509



**Parts compatible with 17, 18 and 26 TIG welding torches  
T125/T250 for the UM17-90 torch head  
T225F for UM18-70, UM18-90, UM18-180 torch heads**



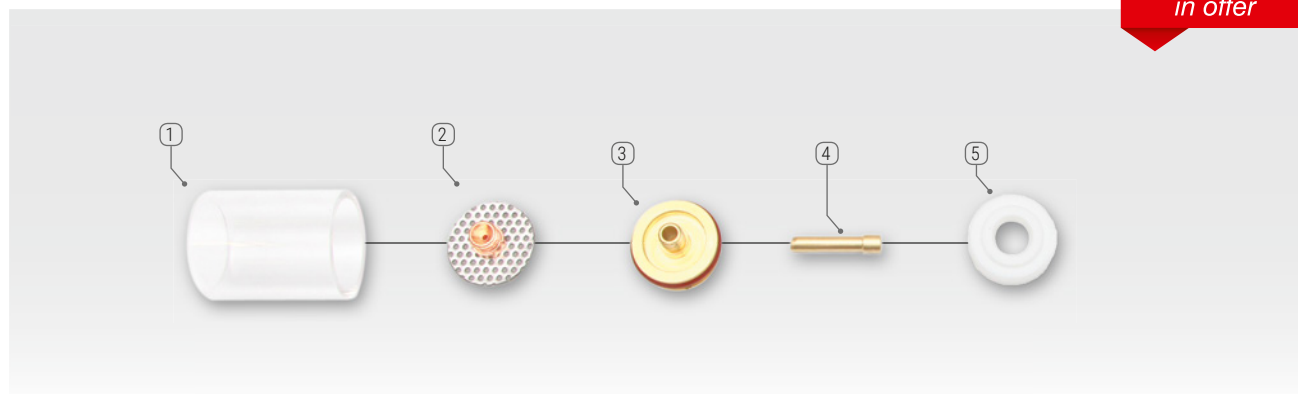
No.	Replaceable elements	Catalogue No.	Altern. ident.
1	18/26 insulator	56 13 014810	18CG
1.1	Lens insulator 18/26	56 13 014812	54N01
1.2	Jumbo 18/26 lens insulator	56 13 017813	54N63
1.3	Insulator short version 18/26	56 13 014826	18CG20
1.4	Lens insulator 18/26, short version	56 13 014822	18CGG
2	Collet 1,0 18/26	56 13 009930	10N22
	Collet 1,6 18/26	56 13 009932	10N23
	Collet 2,0 18/26	56 13 009934	10N24
	Collet 2,4 18/26	56 13 009936	10N24
	Collet 3,2 18/26	56 13 009940	10N25
Collet 4,0 18/26	56 13 009942	54N20	
2.1	Collet short version 1,0 18/26	56 13 009990	10N22S
	Collet short version 1,6 18/26	56 13 009991	10N23S
	Collet short version 2,4 18/26	56 13 009992	10N24S
	Collet short version 3,2 18/26	56 13 009993	10N25S
2.2	Collet for a short lens 1,6 18/26	56 13 009986	13N22GL
	Collet for a short lens 2,4 18/26	56 13 009987	13N23GL
	Collet for a short lens 3,2 18/26	56 13 009988	13N24GL
3	TIG collet body 1,0 18/26	56 13 003830	10N30
	TIG collet body 1,6 18/26	56 13 003883	10N31
	TIG collet body 2,0 18/26	56 13 003914	10N32
	TIG collet body 2,4 18/26	56 13 003921	10N32
	TIG collet body 3,2 18/26	56 13 003952	10N28
	TIG collet body 4,0 18/26	56 13 003960	406488
3.1	Gas lens 1,0 18/26	56 13 008235	45V24
	Gas lens 1,6 18/26	56 13 008252	45V25
	Gas lens 2,4 18/26	56 13 008272	45V26
	Gas lens 3,2 18/26	56 13 008301	45V27
	Gas lens 4,0 18/26	56 13 008310	45V28
3.2	Gas lens Jumbo 2,4	56 13 008276	45V64
	Gas lens Jumbo 3,2	56 13 008280	99795
3.3	TIG collet body 1,0-3,2 18/26, short version	56 13 003930	17CB20
3.4	Gas lens short version 1,6 18/26	56 13 008320	45V43L
	Gas lens short version 2,4 18/26	56 13 008321	45V44L
	Gas lens short version 3,2 18/26	56 13 008322	45V45L

No.	Replaceable elements	Catalogue No.	Altern. ident.
4	Ceramic nozzle 8,0x76 #5	56 13 001006	10N49L
	Ceramic nozzle 9,5x76 #6	56 13 001008	10N48L
	Ceramic nozzle 11,0x76 #7	56 13 001010	10N47L
4.1	Ceramic nozzle 6,5x47 #4	56 13 000768	10N50
	Ceramic nozzle 8,0x47 #5	56 13 000770	10N49
	Ceramic nozzle 9,5x47 #6	56 13 000780	10N48
	Ceramic nozzle 11,0x47 #7	56 13 000783	10N47
	Ceramic nozzle 12,5x47 #8	56 13 000784	10N46
	Ceramic nozzle 16,0x47 #10	56 13 000786	10N45
Ceramic nozzle 19,5x47 #12	56 13 000788	10N44	
5	Ceramic nozzle for lens 6,5x76 #4	56 13 000950	54N18L
	Ceramic nozzle for lens 8,0x76 #5	56 13 000951	54N17L
	Ceramic nozzle for lens 9,5x76 #6	56 13 000952	54N16L
	Ceramic nozzle for lens 11,0x76 #7	56 13 000953	54N15L
Ceramic nozzle for lens 12,8x76 #8	56 13 000954	54N14L	
5.1	Ceramic nozzle for lens 6,5x42 #4	56 13 000902	54N18
	Ceramic nozzle for lens 8,0x42 #5	56 13 000900	54N17
	Ceramic nozzle for lens 9,5x42 #6	56 13 000888	54N16
	Ceramic nozzle for lens 11,0x42 #7	56 13 000886	54N15
	Ceramic nozzle for lens 12,5x42 #8	56 13 000884	54N14
Ceramic nozzle for lens 19,5x42 #12	56 13 000882	54N19	
6	Ceramic nozzle for lens Jumbo 9,5x48 #6	56 13 001115	57N75
	Ceramic nozzle for lens Jumbo 12,5x48 #8	56 13 001120	57N74
	Ceramic nozzle for lens Jumbo 16,0x48 #10	56 13 001136	53N88
	Ceramic nozzle for lens Jumbo 19,5x48 #12	56 13 001119	53N87
7	Ceramic nozzle 6,5x30 #4	56 13 000384	13N08
	Ceramic nozzle 8,0x30 #5	56 13 000386	13N09
	Ceramic nozzle 9,5x30 #6	56 13 000390	13N10
	Ceramic nozzle 11,0x30 #7	56 13 000394	13N11
	Ceramic nozzle 12,5x30 #8	56 13 000396	13N12
Ceramic nozzle 16,0x30 #9	56 13 000398	13N13	
8	Ceramic nozzle for lens 6,5x25,5 #4	56 13 000908	53N58
	Ceramic nozzle for lens 8,0x25,5 #5	56 13 000910	53N59
	Ceramic nozzle for lens 9,5x25,5 #6	56 13 000911	53N60
	Ceramic nozzle for lens 11,0x25,5 #7	56 13 000912	53N61

## System for 29x47 transparent nozzles

Very good laminar gas shield.

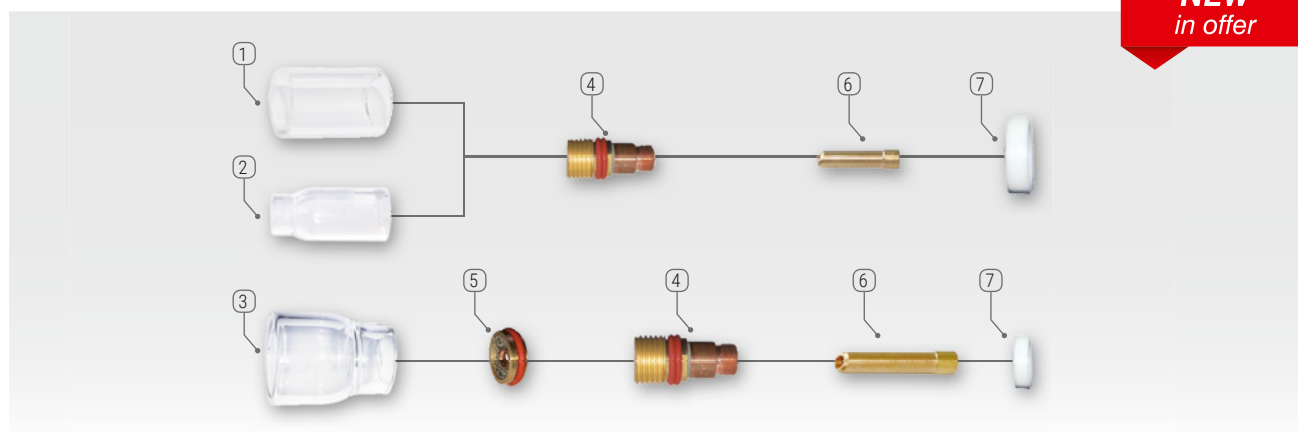
**NEW**  
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No.	Replaceable elements	Catalogue No.
1	Transparent nozzle 29x47	56 13 013000
2	Gas lens 1,0 large 29 mm	56 13 013030
	Gas lens 1,6 large 29 mm	56 13 013031
	Gas lens 2,4 large 29 mm	56 13 013033
	Gas lens 3,2 large 29 mm	56 13 013034
3	Adapter for 29x47 system	56 13 013135
4	Collet 1,0 33 mm	56 13 013070
	Collet 1,6 33 mm	56 13 013071
	Collet 2,4 33 mm	56 13 013073
	Collet 3,2 33 mm	56 13 013074
5	Nozzle insulator 29x47	56 13 013120

## System for a transparent nozzle with a gas lens

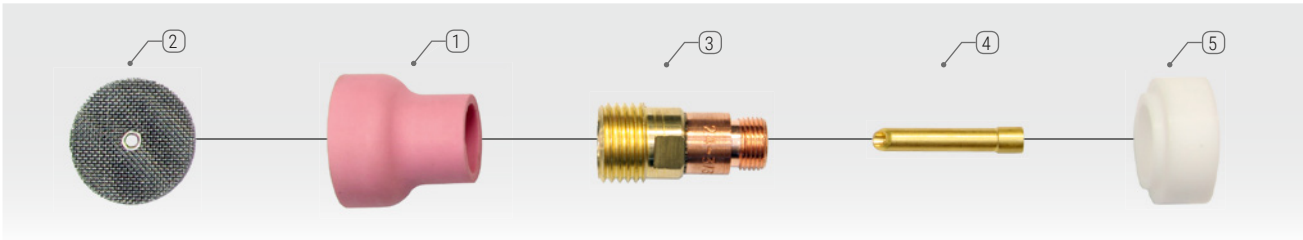
**NEW**  
in offer



No.	Replaceable elements	Catalogue No.
1	Transparent nozzle 14x32,5	56 13 013015
2	Transparent nozzle 9,5x32,5	56 13 013022
	Transparent nozzle 11x32,5	56 13 013023
3	Transparent nozzle 25x19,5x28	56 13 013020
4	Gas lens, short 1,6 18/26 with an O-ring	56 13 013050
	Gas lens, short 2,4 18/26 with an O-ring	56 13 013051
	Gas lens, short 3,2 18/26 with an O-ring	56 13 013052
5	Adapter for 25x19,5x28 1,6 system	56 13 013144
	Adapter for 25x19,5x28 2,4 system	56 13 013145
	Adapter for 25x19,5x28 3,2 system	56 13 013146
6	Collet 1,6 33 mm	56 13 013071
	Collet 2,4 33 mm	56 13 013073
	Collet 3,2 33 mm	56 13 013074
7	Insulator for short version 17/18/26 18CG20	56 13 014826

### XL Cup system

Superior gas coverage, allows for longer electrode stick outs, perfect for welding in tight spaces.



No.	Replaceable elements	Catalogue No.	Remarks
1	Ceramic cup XL 19x26 #12	56 13 000980	
	Ceramic cup XL 23x26 #14	56 13 000981	
	Ceramic cup XL 26x29 #16	56 13 000982	
2	Strainer XL 19x26 1.6	56 13 008370	for the cup #12 19x26
	Strainer XL 19x26 2.4	56 13 008371	
	Strainer XL 19x26 3.2	56 13 008372	
2	Strainer XL 23x26 1.6	56 13 008375	for the cup #4 23x26
	Strainer XL 23x26 2.4	56 13 008376	
	Strainer XL 23x26 3.2	56 13 008377	
2	Strainer XL 26x29 1.6	56 13 008378	for the cup #6 26x29
	Strainer XL 26x29 2.4	56 13 008379	
	Strainer XL 26x29 3.2	56 13 008380	
3	Gas lens stubby 17/26/18 1.6 45V43L MOST	56 13 008320	
	Gas lens stubby 17/26/18 2.4 45V44L MOST	56 13 008321	
	Gas lens stubby 17/26/18 3.2 45V45L MOST	56 13 008322	
4	Collet 1.6 33 mm	56 13 013071	
	Collet 2.4 33 mm	56 13 013073	
	Collet 3.2 33 mm	56 13 013074	
5	Cup insulator 17/26/18 18CGG MOST	56 13 014822	



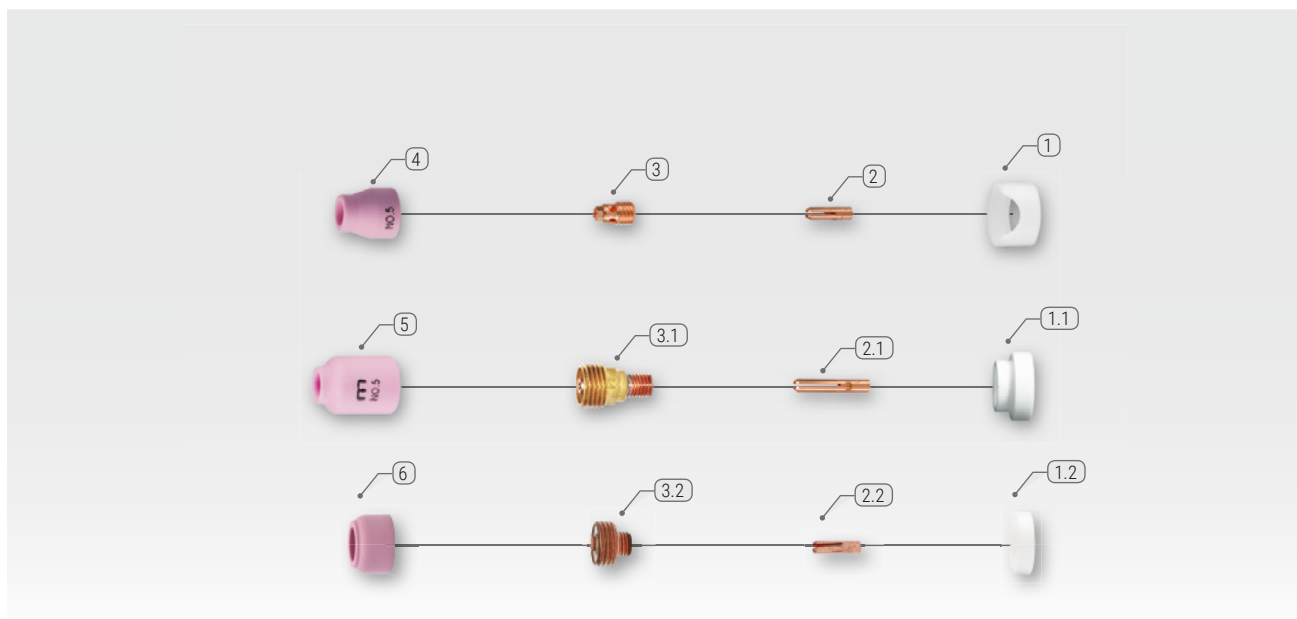
### XL Cup kits for the TIG torches T18 SGRIP and T26 SGRIP MOST

Name	Catalogue No.
Cup kit XL #12 2.4	56 13 001521
Cup kit XL #14 2.4	56 13 001525
Cup kit XL #16 2.4	56 13 001529





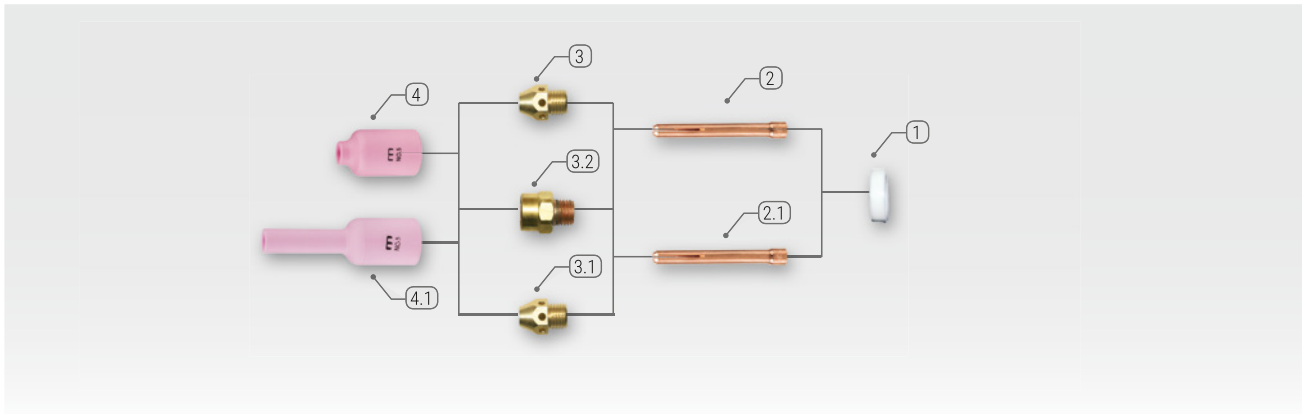
## Parts compatible with 24G and 24W TIG welding torches T225F UM24-70 and UM24-90 torch heads



No.	Replaceable elements	Catalogue No.	Alternative designation
1	Insulator 24	56 13 014823	53N22
1.1	Lens insulator 24	56 13 014825	53N66
1.2	Lens insulator XS 24	56 13 014827	
2	Collet 1,6 24 Collet 2,4 24	56 13 009996 56 13 009997	53N14 24C332
2.1	Collet for gas lens 1,6 24 Collet for gas lens 1,6 24	56 13 010001 56 13 010002	53N54 24GLC332
2.2	Collet XS 2.4 4*15,5	56 13 009999	
3	TIG collet body 1,6 24 TIG collet body 2,4 24	56 13 003972 56 13 003973	53N19 24CB332
3.1	Gas lens 1,6 9/20/24 Gas lens 2,4 9/20/24	56 13 008250 56 13 008271	45V43 45V44
3.2	Gas lens XS 2,4	56 13 008353	
4	Ceramic nozzle 6,5x16,5 #4 Ceramic nozzle 8,0x16,5 #5 Ceramic nozzle 9,5x16,5 #6	56 13 000512 56 13 000513 56 13 000514	53N24 53N25 53N26
5	Ceramic nozzle for gas lens 6,5x25,5 #4 Ceramic nozzle for gas lens 8,0x25,5 #5 Ceramic nozzle for gas lens 9,5x25,5 #6 Ceramic nozzle for gas lens 11,0x25,5 #7	56 13 000908 56 13 000910 56 13 000911 56 13 000912	53N58 53N59 53N60 53N61
6	Ceramic nozzle XS 11x12	56 13 000521	

- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - see pages 82-83.

## Parts compatible with TIG torch 18SC



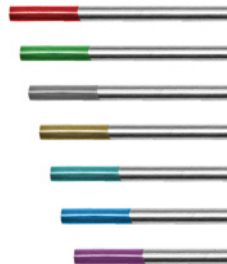
No.	Replaceable elements	Catalogue No.
1	Insulator SRT-18SC 712.6043	56 13 014818
2	Collet 17/18/26 1.0 10N22 MOST	56 13 009930
	Collet 17/18/26 1.6 10N23 MOST	56 13 009932
	Collet 17/18/26 2.0 MOST	56 13 009934
	Collet 17/18/26 2.4 10N24 MOST	56 13 009936
	Collet 17/18/26 3.2 10N25 MOST	56 13 009940
2.1	Collet 18SC HL 4.0 712. 6065	56 13 010040
	Collet 18SC HL 4.8 712. 6066	56 13 010041
3	TIG collet body 0,5-3,2 mm 18SC 712.6074	56 13 003820
3.1	TIG collet body	56 13 003945
3.2	Gas lens 18SC 2,4 mm 712.6102	56 13 008273
	Gas lens 18SC 3,2 mm 712.6103	56 13 008302
	Gas lens 18SC 4,0 mm 712.6104	56 13 008303
	Gas lens 18SC 4,8 mm 712.6105	56 13 008312
4	Ceramic nozzle 17/26/18/SC LAM. 54N18 6.5X42 MOST	56 13 000902
	Ceramic nozzle 17/26/18/SC LAM. 54N17 8.0X42 MOST	56 13 000900
	Ceramic nozzle 17/26/18/SC LAM. 54N16 9.5X42 MOST	56 13 000888
	Ceramic nozzle 17/26/18/SC LAM. 54N15 11.0X42 MOST	56 13 000886
	Ceramic nozzle 17/26/18/SC LAM. 54N14 12.5X42 MOST	56 13 000884
	Ceramic nozzle 17/26/18/SC LAM. 54N19 19.5X42 MOST	56 13 000882
4.1	Ceramic nozzle 17/18/26 LAM. 54N18L 6.5x76 MOST	56 13 000950
	Ceramic nozzle 17/26/18 LAM. 54N17L 8.0X76 MOST	56 13 000951
	Ceramic nozzle 17/26/18 LAM. 54N16L 9.5X76 MOST	56 13 000952
	Ceramic nozzle 17/26/18 LAM. 54N15L 11.0X76 MOST	56 13 000953
	Ceramic nozzle 17/18/26 LAM. 54N14L 12,5x76 MOST	56 13 000954

- We provide custom made TIG welding torches adapted to all common welding equipment - send email to [export@rywal.com.pl](mailto:export@rywal.com.pl)
- TIG welding rods - chapter 10.
- Tungsten electrodes and tungsten electrode sharpeners - see pages 82-83.

## ▼ 8.9. Tungsten electrodes and electrode grinders



### MOST tungsten electrodes for TIG welding



Electrode sharpening angle (according to Lorch instructions)	
Welding current (DC)	The angle of the electrode
20 A	30°
20-100 A	60°-90°
100-200 A	90°-120°
>200 A	120°

Recommended current (according to Lorch instructions)		
Electrode diam.	DC	AC
1,0 mm	3-40 A	5-30 A**
1,6 mm	15-130 A	20-90 A**
2,0 mm	45-180 A	45-135 A**
2,4 mm	70-240 A	70-180 A**
3,2 mm	140-320 A	130-250 A**
4,0 mm	220-450 A	200-320 A**

\*\*) Depending on the type of electrode and AC balance parameter settings

Name and symbol	A distinctive color	Type of work	Diameters at length L=175 mm	Catalogue No.	Remarks
Thorium 2% WT20	red	DC	Ø1,0 mm	50 19 921017	Slightly radioactive
			Ø1,6 mm	50 19 921617	
			Ø2,0 mm	50 19 922017	
			Ø2,4 mm	50 19 922417	
			Ø3,0 mm	50 19 923017	
			Ø3,2 mm	50 19 923217	
From pure tungsten WP	green	AC	Ø1,0 mm	50 19 931017	Welding of aluminium and its alloys
			Ø1,6 mm	50 19 931617	
			Ø2,0 mm	50 19 932017	
			Ø2,4 mm	50 19 932417	
			Ø3,0 mm	50 19 933017	
			Ø3,2 mm	50 19 933217	
Cerium WC20	grey	AC/DC	Ø1,0 mm	50 19 971017	Universal, long service life and load capacity
			Ø1,6 mm	50 19 971617	
			Ø2,0 mm	50 19 972017	
			Ø2,4 mm	50 19 972417	
			Ø3,0 mm	50 19 973017	
			Ø3,2 mm	50 19 973217	
WL15 lanthanum	gold	AC/DC	Ø1,0 mm	50 19 941017	Universal, very good arc ignition properties
			Ø1,6 mm	50 19 941617	
			Ø2,0 mm	50 19 942017	
			Ø2,4 mm	50 19 942417	
			Ø3,0 mm	50 19 943017	
			Ø3,2 mm	50 19 943217	
With the addition of Multi-Strike rare earths	turquoise	AC/DC	Ø1,0 mm	50 19 951017	The best properties when welding steel and aluminium
			Ø1,6 mm	50 19 951617	
			Ø2,4 mm	50 19 952417	
			Ø3,2 mm	50 19 953217	
			Ø4,0 mm	50 19 954017	
			With the addition of WS20 rare earths	blue	
Ø1,6 mm	50 19 975016				
Ø2,0 mm	50 19 975020				
Ø2,4 mm	50 19 975024				
Ø3,0 mm	50 19 975030				
Ø3,2 mm	50 19 975032				
With the addition of WE3 rare earths	violet	AC/DC	Ø1,6 mm	50 19 976016	Universal, long life WT20 replacement suggested
			Ø2,0 mm	50 19 976020	
			Ø2,4 mm	50 19 976024	
			Ø3,2 mm	50 19 976032	

AC-alternating current / aluminium welding

DC-direct current / welding of carbon and stainless steels



## WAG 40 MOST tungsten electrode grinder

This device is only used to sharpen tungsten electrodes used for TIG welding.

When welding with a tungsten electrode, its precise sharpening allows for an ideal ignition of the arc and increases the life of the electrode.

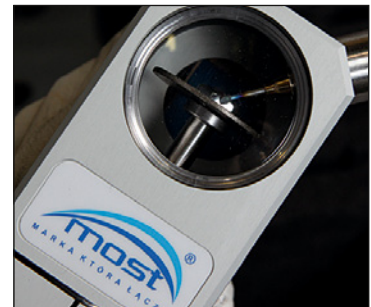
The WAG 40 MOST sharpener is necessary for TIG orbital welding, plasma welding and professional TIG manual welding.

The device is delivered in a case, with a tungsten electrode holder and 1,6 - diameter clamps; 2,4 and 3,2 mm, and a set of keys needed for maintenance of the grinder.

Model	WAG 40 MOST
Power P1	850 W
Electrical power supply	230 V / 50-60 Hz
Rotations	from 8.000 to 22.000 rpm
Noise level	88,8 dB (A)
Vibration level	5 m/s
Weight	2,8 kg
Filter cartridge	disposable filter
Diamond shield	Ø40 mm (Cat. no. 59 30 000201)
Catalogue No.	59 30 000110

### Features of the WAG 40 MOST sharpener:

- sharpening electrodes from 1,0 to 4,0 mm,
- setting the sharpening angle from 15 to 180°,
- depth setting hole for minimal electrode wear when sharpening,
- sharpening electrodes with a length of 15 mm,
- for the sharpening of short electrodes, longer collets marked L with accessories are used,
- for using on a table or as a hand-held device,
- built-in replaceable dust filter (Cat. no.: 59 30 000200),
- optional table stand (Cat. no.: 59 30 000335) or a wall mount.



## Neutrix WAG 90MAX tungsten electrode grinder

### Features of the Neutrix WAG 90MAX sharpener:

- sharpening electrodes from 1,0 to 8,0 mm,
- setting the sharpening angle from 16 to 180°,
- sharpening electrodes from 15 to 175 mm,
- depth setting hole for minimal electrode wear when sharpening,
- stationary device,
- built-in replaceable dust filter,
- high performance industrial device.

Model	Neutrix WAG 90MAX
Power P1	120 W
Electrical power supply	230 V / 50-60 Hz
Rotations	2.950 rpm
Noise level	62 dB (A)
Vibration level	2,8 m/s
Weight	12,1 kg
Filter cartridge	disposable filter
Diamond shield	Ø90 mm
Catalogue No.	59 30 000105



## ▼ 9. ACCESSORIES



### MMA electrode holders

Comfort 200 A MOST	Cat. no. 57 00 000200
Comfort 400 A MOST	Cat. no. 57 00 000400
Comfort 600 A MOST	Cat. no. 57 00 000600
200 A MOST rotatable	Cat. no. 57 00 001002
400 A MOST rotatable	Cat. no. 57 00 001004
160 A/20 MOST*	Cat. no. 57 00 001160
300 A/60 MOST*	Cat. no. 57 00 001300

\*) The welding cable is attached to the ring terminal.



### H01N2D welding cables (OS)



OS-16	Cat. no. 54 60 000016
OS-25	Cat. no. 54 60 000025
OS-35	Cat. no. 54 60 000035
OS-50	Cat. no. 54 60 000050
OS-70	Cat. no. 54 60 000070
OS-95	Cat. no. 54 60 000095

### Welding hammers



MOST 300 g spring	Cat. no. 50 00 001610
300 g euro MOST	Cat. no. 50 00 001620

### K300 spool adapters



One-piece	Cat. no. 50 00 001103
Two-piece	Cat. no. 50 00 001099

### Welding cable connectors

In accordance with EN 60974-12



#### Cable plug:

10/25 MOST	Cat. no. 57 00 007025
35/50 MOST	Cat. no. 57 00 007050
50/70 MOST	Cat. no. 57 00 007070
70/95 MOST	Cat. no. 57 00 007095

#### Cable socket

10/25 MOST	Cat. no. 57 00 007125
35/50 MOST	Cat. no. 57 00 007150
50/70 MOST	Cat. no. 57 00 007170
70/95 MOST	Cat. no. 57 00 007195



#### Panel plug

50/70 MOST	Cat. no. 57 00 007370
------------	-----------------------

#### Panel socket

10/25 MOST	Cat. no. 57 00 007225
35/50 MOST	Cat. no. 57 00 007250
50/70 MOST	Cat. no. 57 00 007270



#### Plug-socket adapter

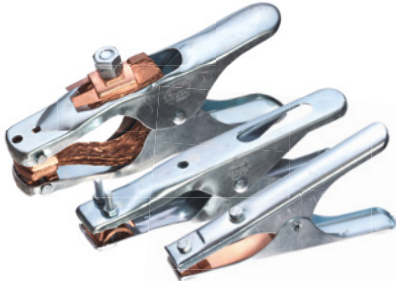
10/25 - 35/50 MOST	Cat. no. 57 00 007011
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### Earth clamps

In accordance with EN 60974-13 standard



**Clamps:**

150 A MOST	Cat. no. 57 00 003009
200 A MOST	Cat. no. 57 00 003010
300 A MOST	Cat. no. 57 00 003011
HIPPO 350 A MOST	Cat. no. 57 00 003021
HIPPO 500 A MOST	Cat. no. 57 00 003022
HIPPO 600 A MOST	Cat. no. 57 00 003023
ZBK-35 160 A	Cat. no. 57 00 003110
ZBK-70 315 A	Cat. no. 57 00 003120
ZBK-95 520 A	Cat. no. 57 00 003130



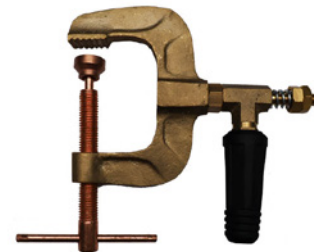
**Brass clamps:**

Croco 300 MOST	Cat. no. 57 00 003014
Croco 400 MOST	Cat. no. 57 00 003015
Croco 600 MOST	Cat. no. 57 00 003016



**Screw clamps:**

600 A MOST	Cat. no. 57 00 004660
ZBS-50 300 A	Cat. no. 57 00 003410
ZBS-70 400 A	Cat. no. 57 00 003420
ZBS-95 500 A	Cat. no. 57 00 003430



Rotary earth clamp 800 A  
Cat. no. 57 00 004680

### Tip wrench



Cat. no. 55 13 000018

### MOST Welding pliers

MOST welding pliers are used to perform necessary auxiliary operations during MIG / MAG welding. This specialized tool allows for the cutting of the end of the wire, cleaning the inside and edges of the gas nozzle from spatter, tightening the contact tip, nozzle, connector, etc.



**Pliers come in two sizes:**

- 7" (recommended for MOST 15/24/25 holders) Cat. no. 57 00 004707
- 8" (recommended for MOST 36/401/501 holders) Cat. no. 57 00 004708

### Magnetic torch holder



**Bracket for welding torch**

- MIG MOST Cat. no. 57 00 004880
- TIG MOST Cat. no. 57 00 004890

### Protective covers for welding cables

Rubber cover 22x23 - 20 m	Cat. no. 51 13 015288
Rubber cover 25x26 - 20 m	Cat. no. 51 13 015289
Cable cover 21x23 - 20 m	Cat. no. 51 13 007204
Cable cover 26x28 - 20 m	Cat. no. 51 13 007205
Cable cover 30x33 - 20 m	Cat. no. 51 13 007206
Cable cover 40x43 - 20 m	Cat. no. 51 13 007207
Cable cover 45x48 - 20 m	Cat. no. 51 13 007208
Leather cover Ø28 - 1 m	Cat. no. 51 13 007246
Leather cover Ø28 - 4 m	Cat. no. 51 13 007247
Leather cover Ø28 - 8 m	Cat. no. 51 13 007248





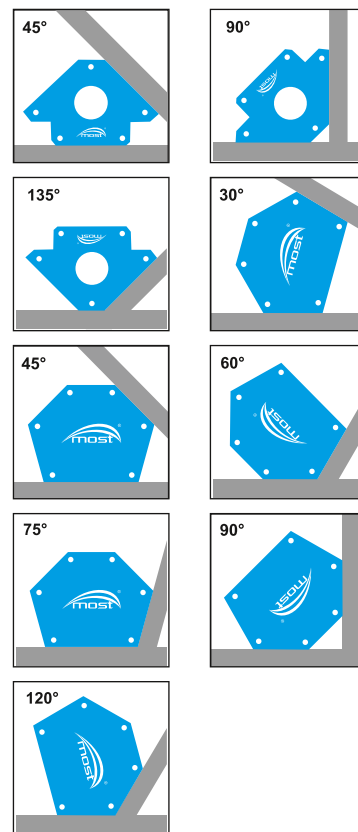
## Magnetic welding holders

### Application:

- Welding.
- Soldering.
- Assembly.
- Demagnetization.



Model	Dimensions (HxLxT)	Material setting angles	Capacity - max. support	Catalogue No.
Magnetic triangle S	83x119x14 mm	45°/90°/135°/180°	11,5 kg	57 00 004800
Magnetic triangle M	102x155x16 mm	45°/90°/135°/180°	22,5 kg	57 00 004850
Magnetic triangle L	122x187x25 mm	45°/90°/135°/180°	34 kg	57 00 004855
Magnetic polygon S	70x102x14 mm	30°/45°/60°/75°/90°/120°	11,5 kg	57 00 004860
Magnetic polygon M	90x118x16 mm	30°/45°/60°/75°/90°/120°	22,5 kg	57 00 004865
Magnetic polygon L	110x145x25 mm	30°/45°/60°/75°/90°/120°	34 kg	57 00 004870
Magnetic triangles set XS	43x72x12 mm	45°/90°/135°/180°	4x4 kg	57 00 004875



## GER hose clamps (for welding and plasma torches)



Type of cable tie	Hose diameter	Catalogue No.
GER 6,1	4,7 / 5,7 mm	50 15 000061
GER 6,6	5,2 / 6,2 mm	50 15 000066
GER 7,0	5,6 / 6,5 mm	50 15 000070
GER 7,5	5,9 / 7,0 mm	50 15 000075
GER 8,0	6,3 / 7,5 mm	50 15 000080
GER 8,3	6,6 / 7,8 mm	50 15 000083
GER 8,7	7,0 / 8,2 mm	50 15 000087
GER 9,0	7,0 / 8,5 mm	50 15 000090
GER 9,5	7,5 / 9,0 mm	50 15 000095
GER 10,0	8,0 / 9,5 mm	50 15 000100

Type of cable tie	Hose diameter	Catalogue No.
GER 10,5	8,5 / 10,0 mm	50 15 000105
GER 11,0	8,8 / 10,5 mm	50 15 000110
GER 11,3	9,1 / 10,8 mm	50 15 000113
GER 12,0	9,5 / 11,5 mm	50 15 000120
GER 12,3	9,8 / 11,8 mm	50 15 000123
GER 12,8	10,3 / 12,3 mm	50 15 000128
GER 13,3	10,6 / 12,6 mm	50 15 000133
GER 14,0	11,3 / 13,3 mm	50 15 000140
GER 14,5	11,8 / 13,8 mm	50 15 000145
GER 15,0	12,3 / 14,3 mm	50 15 000150
GER 15,5	12,8 / 14,8 mm	50 15 000155
GER 16,0	13,1 / 15,3 mm	50 15 000160
GER 16,5	13,2 / 15,8 mm	50 15 000165
GER 17,5	14,6 / 16,8 mm	50 15 000175
GER 18,5	15,6 / 17,8 mm	50 15 000185
GER 19,5	16,5 / 18,8 mm	50 15 000195
GER 20,7	17,1 / 20,0 mm	50 15 000207



### Quick connectors

Model	Catalogue No.	Image
<b>Quick-release couplings</b>		
Quick coupling with external thread 1/8"	50 14 102001	
Quick coupling with external thread 1/8" red	50 14 102025	
Quick coupling with external thread 1/8" blue	50 14 102026	
Quick coupling for Ø6 mm hose	50 14 102002	
Quick coupling for Ø9 mm hose	50 14 102003	
Quick coupling for hose partition Ø6 mm red	50 14 102020	
Quick coupling for the hose partition Ø6 mm blue	50 14 102021	
Quick coupling for Ø9 mm hose partition	50 14 102022	

Model	Catalogue No.	Image
<b>Connectors</b>		
Quick connector with Ø6 mm hose	50 14 182001	
Quick connector with Ø9 mm hose	50 14 182002	
<b>Hose plugs</b>		
2,7 gas plug	50 14 182006	
Plug for Ø6 mm hose	50 14 182003	
Ø9 mm hose plug	50 14 182004	

### Welding trolleys

MOST welding trolleys are designed for placing and transporting appropriate welding equipment, plasma cutters, and coolers on them. They are equipped with a shelf for a gas cylinder and hangers for hoses and welding holders. The set includes two straps for securing the device and a cylinder chain.

Model	WUS HD	WUS-100
Trolley dimensions	1120x440x670 mm	680x960x440 mm
Shelf dimensions	405x304 mm (regulated)	550x290 mm (top) 400x290 mm (middle) 450x290 mm (bottom)
Loading capacity	max 150 kg	max 80 kg
Max. height of the device or the height of kit with cooler	750 mm	-
Max gas bottle dimensions	-	120x20 mm
Catalogue No.	50 03 003942	50 03 003910





## FANDRY electrode dryers



FANDRY 20 and 50 MOST are used for drying electrodes before welding. The electrode manufacturer specifies the temperature and drying time. Most often it is required that the electrodes be dried for 2-3 hours at a temperature of about 350°C.

Model	FANDRY 20 dryer	FANDRY 50 dryer
Electrical power supply	230 V	230 V
Power	1200 W	1600 W
Capacity	20 kg of electrodes in 4 trays	50 kg of electrodes in 4 trays
Temperature control	100-350°C	100-350°C
Weight	14 kg	26 kg
Dimensions (HxWxL)	690x215x215 mm	800x310x310 mm
Catalogue No.	50 00 003002	50 00 003028

## FANTERM electrode thermoses



The electrodes prepared for operation should be stored in a thermos intended for this purpose at a temperature of about 100°C. We recommend our FANTERM 5T and FANTERM 10T thermoses for storage.

Model	FANTERM 5T thermos	FANTERM 10T thermos
Electrical power supply	230 V	230 V
Power	285 W	285 W
Capacity	5 kg of electrodes in 1 tray	10 kg of electrodes in 1 tray
Temperature control	50-200°C	50-200°C
Weight	3,5 kg	4,5 kg
Dimensions Diam x H	78x450 mm	110x450 mm
Catalogue No.	50 00 004300	50 00 004320

## MOST electrode container

The MOST container enables passive protection of previously dried electrodes and their periodic storage.

### Description:

- the seal effectively protects against water and moisture,
- durable and rigid housing made of PE-LD,
- only a quarter of a turn needed to close the thermos,
- sticker enabling description of the thermos content for easier identification,
- effectively replaces unstable cardboard packaging for electrodes,
- capacity - up to 6,8 kg of 450 mm long electrodes,
- maximum electrode temperature 121°C.



Catalogue No.: 50 00 004400



## MOST welding gauges

### MS 1 weld gauges

For Accurate Calibration of Butt Fillet Type Welds

**Application:** measuring the head height (0-12 mm), measuring the side length of the fillet welds, measuring the thickness of fillet welds (0-15 mm), measuring the size of the offset, measuring the size of the undercut (0-5 mm), measuring the angle of the metal bevel (150°), gap measurement (0,5-5 mm).

**Catalogue No.:** EM 12 110010



### MS 2 weld gauges

For Accurate Calibration of Butt Fillet Type Welds

**Application:** measuring the head height (0-15 mm), measuring the side length of the fillet welds, measuring the thickness of fillet welds (0-15 mm), measuring the size of the offset, measuring the size of the undercut, measuring the angle of the metal bevel (80°-160°), gap measurement (0,5-6 mm).

**Catalogue No.:** EM 12 110020



### MS 3 weld gauges

For Accurate Calibration of Butt Fillet Type Welds

**Application:** undercut depth up to 25 mm, headroom height up to 25 mm, length of fillet weld up to 25 mm, lowering of fillet weld, bevel angle from 0° to 60°, offset of welded sheets.

**Catalogue No.:** EM 12 110030



### MS 4 weld gauges

For quickly measuring the offset of the inner edges of pipes.

**Application:** measurement of internal displacement before and after alignment of pipes, measurement of internal displacement after joining pipes with a positional weld, measurement of distance between scratches after welding, measurement of head height and other parameters when welding pipes.

The device is available in inch and metric versions with scale divisions of 1/16 and 1 mm of plate angle, gap measurement.

**Catalogue No.:** EM 12 110040



### MS 5 weld gauges

For accurate measurement of fillet and butt welds.

**Application:** measuring of the length of the sides of the fillet welds, measuring of the allowable protrusion and lowering of the fillet welds, measuring the permissible head height.

**Catalogue No.:** EM 12 110050



### MS 6 weld gauges

For quickly measurement of the most popular fillet welds.

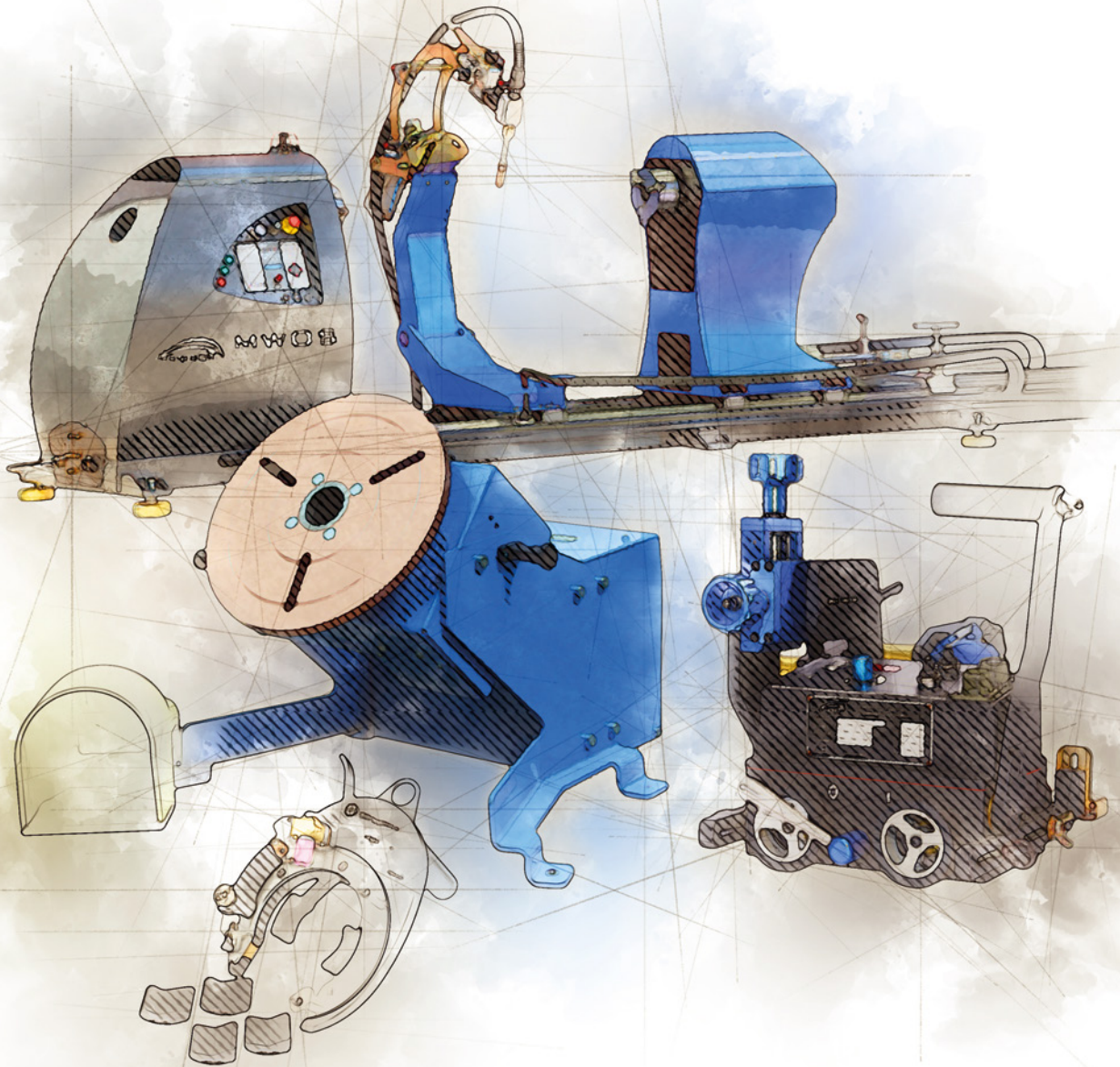
**Application:** The weldmeter allows the measurement of welds between 1/8"-1" (3,2-25,4 mm). The device is available in inch and metric versions.

**Catalogue No.:** EM 12 110060





# 02



# AUTOMATIZATION OF PRODUCTION PROCESSES

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## ▼ 1. CIRCUMFERENTIAL WELDING SYSTEM



The MOST advanced circumferential welding system solutions are a combination of an universal device capable of individual configuration of the work station designed for customer requirements. Welding systems allow to increase welding- efficiency while improving the quality of welded joints. The automation of production processes simplifies and allows for a wide spectrum of applications in customer production.

### Description:

- Repeatability of the process.
- Faster production cycle, the device can be operated by one operator.
- Minimization of the risk of welding defects.
- A wide range of working lengths and diameters.
- Adjustment of system configuration to the client's needs.
- Intuitive use.
- Wide options of configuration system.
- X and Z axis numerically operated.
- Circumferential welding, oscillation, cladding and screw welding.
- Longitudinal welding function\*.
- Multilayer welding\*.
- Welding head axis driven by servomotors.
- Workpiece rotation driven by step motor.
- MOST MCS-X digital control system.
- Digital connection between LORCH RTR power sources using the CAN protocol.
- Huge spectrum of final system configuration options enables adjustment to the customer's application requirements.
- A digital driver with the possibility to save and compile programs into production cycles.
- Intuitive control panel with a text display.



\*Available based on the system configuration



System is digitally operated and the drive is powered by a servomotor and step motors.

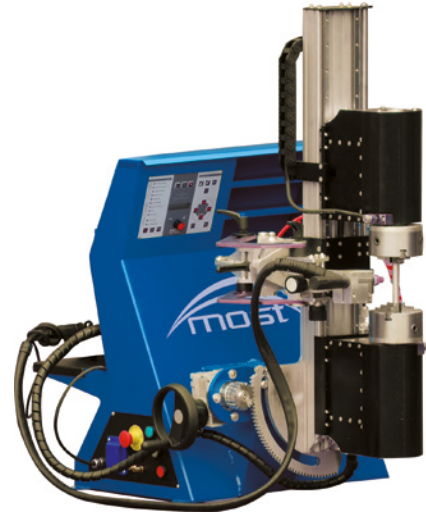




## MOST MPWOS 500/800 – circumferential welding system

- Universal machines designed for precise welding of small parts.
- Precise positioning of the torch.
- Adjusting the working section tilting allows to set the optimal welding position.
- The hollow spindle makes it possible to supply the shielding gas or to weld very long parts.

Model	MOST MPWOS-500	MOST MPWOS-800
Maximum static load capacity	25 kg	25 kg
Maximum rotation torque v01	33,7 Nm	33,7 Nm
Maximum rotation torque v02	98,1 Nm	98,1 Nm
Maximum rotation torque v03	193,1 Nm	193,1 Nm
Speed range v01	0,05-25 rpm	0,05-25,0 rpm
Speed range v02	0,02-8,3 rpm	0,02-8,3 rpm
Speed range v03	0,01-4,2 rpm	0,01-4,2 rpm
Working section arm tilt adjustment	0°-90°	0°-90°
Maximum workpiece diameter	340 mm	340 mm
Working range (size between flanges)	500 mm	800 mm
Catalogue No.	A9 17 000250	A9 17 000280



## MOST MPWOS-1000/1500 – circumferential welding system

- Numerical control of the torch X axis enables welding with oscillation, cladding and screw welding and also longitudinal welding as an option.
- Pneumatic or electric (servomotor) positioning of the torch in the Z axis makes it possible to achieve high precision and creation of multi layered welds as well as layered surfacing (optional).
- The X and Z axis of the torch driven by servomotors.
- The drive synchronization of the support sections makes it possible to weld elements which are not pre tacked (optional).



Model	MOST MPWOS-1000	MOST MPWOS-1500
Maximum static load capacity	270 kg	270 kg
Maximum rotation torque v01	181,1 Nm	181,1 Nm
Maximum rotation torque v02	362,4 Nm	362,4 Nm
Maximum rotation torque v03	604 Nm	604 Nm
Tilt range	0°-90°	0°-90°
Speed range v01	0,02-11,1 rpm	0,02-11,1 rpm
Speed range v02	0,01-5,6 rpm	0,01-5,6 rpm
Speed range v03	0,00-3,3 rpm	0,00-3,3 rpm
Maximum workpiece diameter	650 mm	650 mm
Working range (size between flanges)	1050 mm	1450 mm
Working section arm tilt adjustment	0°-90° – smooth manual, mechanized (option)	0°-90° – smooth manual, mechanized (option)
Catalogue No.	A9 17 000020	A9 17 000054

System is digitally operated and the drive is powered by a servomotor and step motors.



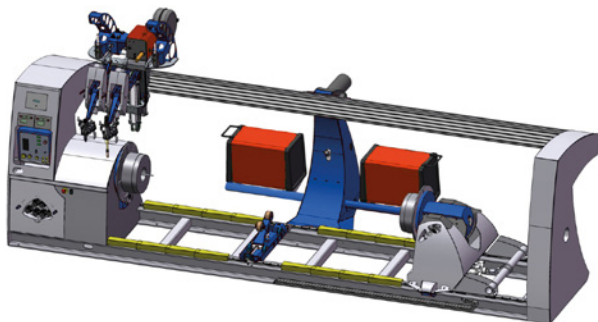
### MOST MWOS-E – circumferential welding system



- A system for the creation of circumferential welds.
- Pneumatic or electric (servomotors, optional) positioning of the torch enables efficient production and creation of multi-layer welds.
- The ability to use and operate two welding heads increases production efficiency.
- Large workspace between the rotation axis and the base makes it possible to weld tanks and products with an eccentric offset, like pipe-knee.
- Integrated through-drive transmission shaft enables the supply of shielding gas or welding of very long objects.

Model	MOST MWOS-E2	MOST MWOS-E6
Maximum static load capacity	370 kg	620 kg
Maximum rotation torque v01	135 Nm	181 Nm
Maximum rotation torque v02	271 Nm	362 Nm
Maximum rotation torque v03	453 Nm	604 Nm
Speed range v01	0,02-11,1 rpm	0,02-11,1 rpm
Speed range v02	0,01-5,6 rpm	0,01-5,6 rpm
Speed range v03	0,00-3,3 rpm	0,00-3,3 rpm
Working range (size between flanges)	1500-6500 mm	1500-12500 mm
Maximum workpiece diameter	1000 mm	1000 mm
Hollow spindle diam.	78 mm	108 mm
Catalogue No.	A9 17 000056	A9 17 000057

### MOST MWOS-A – circumferential welding system



- Numerical control of the torch X axis enables welding with oscillation, cladding and screw welding and also longitudinal welding as option.
- Pneumatic positioning of the torch enables serial production.
- Electric (servomotor) positioning of the torch in the Z axis makes it possible to achieve high precision and to create multi layered welds as well as layered surfacing (optional).
- The X and Z axis of the torch driven by servomotors.
- The ability to use two independent welding heads and double heads (for example with two welding methods).
- The drive synchronization of the support sections makes it possible to weld elements which are not pre-joined (optional).

Model	MOST MWOS-A2.2	MOST MWOS-A5.2
Maximum static load capacity	2200 kg	5200 kg
Maximum workpiece diameter	1250 mm	1750 mm
Maximum rotation torque v01	1066 Nm	1918 Nm
Maximum rotation torque v02	1776 Nm	3197 Nm
Maximum rotation torque v03	1487 Nm	4477 Nm
Speed range for version v01	0,01-5,6 rpm	0,01-5,6 rpm
Speed range for version v02	0,01-3,3 rpm	0,01-3,3 rpm
Speed range for version v03	0,00-2,4 rpm	0,00-2,4 rpm
Idler section tilt	0-90° / max. 1250 mm	0-90° / max. 1500 mm
Tailstock section tilt adjustment	Smooth manual, mechanized (option)	Smooth manual, mechanized (option)
Working range (size between flanges)	2500-16500 mm	2500-16500 mm
Catalogue No.	A9 17 000041	A9 17 000055

System is digitally operated and the drive is realized by a servomotor and step motors.



## ▼ 2. LONGITUDINAL WELDING SYSTEM



The MOST MLS and MALW systems are modern welding devices designed for the longitudinal welding with excellent ergonomics and useful parameters. They have been created to meet the quality demands related to weld connections, especially in applications where the demand for precise devices is constantly on the rise. These kinds of devices can be used for serial production pipe, chimney insert and ventilation system welding, as well as for the welding of simple sheets, tanks or reactor constructions. Everywhere where high precision and repeatability of the process are necessary.



### Description:

- Repeatability of the process.
- Faster production cycle, the device can be operated by one operator.
- Minimization of the risk of welding defects.
- A wide range of working lengths and diameters.
- Adjustment of system configuration to the client's needs.
- Intuitive use.



System is digitally operated and the drive is powered by a servomotor and step motors.



## MOST MLS – longitudinal welding system



Model	MLS-1050	MLS-1550	MLS-2050	MLS-3050
Working range (length of weld)	50-1050 mm	50-1550 mm	50-2050 mm	50-3050 mm
Workpiece diameter range	80-800 mm	100-800 mm	130-800 mm	180-800 mm
	Possibility to increase working diameter on request.			
Maximum diameter with hydraulic base (option)	2000 mm	2000 mm	2000 mm	2000 mm
Workpiece diameter range for the INT/EX (Internal/External) version	130-1300 mm-external welding (weld ridge inside the tank) above 1350 mm-internal welding (weld ridge on the outside of the tank)			
Welding speed range	0,1-2 m/min	0,1-2 m/min	0,1-2 m/min	0,1-2 m/min
Welding method	MIG/MAG/TIG/PLASMA/SAW			

- Welding device designed for the creation of longitudinal weld with perfect usage parameters.
- Liquid cooled copper washer.
- System for blowing gas to the ridge shield.
- NC control system MOST 02 digital process driver.
- AVC system for the automatic torch height adjustment (optional).
- Torch oscillation system (optional).
- A vision inspected system for the open welding arch (optional).
- Pneumatic centering system.
- Trolley for cargo loading (optional).

Model	MLS-2050 HD	MLS-3050 HD	MLS-4050 HD	MLS-5050 HD	MLS-6050 HD
Working range (length of weld)	50-2050 mm	50-3050 mm	50-4050 mm	50-5050 mm	50-6050 mm
	Other working ranges available on request				
Minimum workpiece diameter-internal welding (root outside the tank)	1350 mm	1350 mm	1350 mm	1350 mm	1500 mm
Welding speed range	0,1-2 m/min	0,1-2 m/min	0,1-2 m/min	0,1-2 m/min	0,1-2 m/min
Welding method	MIG/MAG/TIG/PLASMA/SAW				

## MOST MALW – longitudinal welding system



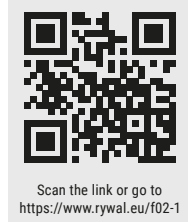
- Universal welding machine for longitudinal welding.
- Unique cascade root layer gas cover system Cascade GAS.
- Cooled spindle bar made out of high quality CuCrZr alloy.
- Welding head movement driven by a servomotor.
- Positioning with 0.2 mm precision.
- MOST MCS-L (CANopen) digital process driver.

Model	MALW-T 1000	MALW-T 1500	MALW-T 2000	MALW-M 1000	MALW-M 2000	MALW-M 3000
Working range (length of weld)	50-1100 mm	50-1550 mm	50-2050 mm	50-1100 mm	50-2050 mm	50-3050 mm
Workpiece diameter range	70-1000 mm	100-1000 mm	120-1000 mm	120-1000 mm	150-1000 mm	180-1000 mm
Maximum diameter with hydraulic base (option)	1500 mm	1500 mm	1500 mm	1500 mm	1500 mm	1500 mm
Maximum diameter when using a rail lifting system (option)	5000 mm	5000 mm	5000 mm	5000 mm	5000 mm	5000 mm
Welded material thickness range	0,3-4 mm	0,3-4 mm	0,3-4 mm	0,8-10 mm	0,8-10 mm	0,8-10 mm
Welding speed range	0,1-3 m/min	0,1-3 m/min	0,1-3 m/min	0,1-3 m/min	0,1-3 m/min	0,1-3 m/min
Welding method	TIG/PLASMA			MIG/MAG/TIG/PLASMA		

System is digitally operated and the drive is realized by a servomotor and step motors.



### ▼ 3. WELDING COLUMN & BOOM



#### MOST MCBM – Welding column-boom

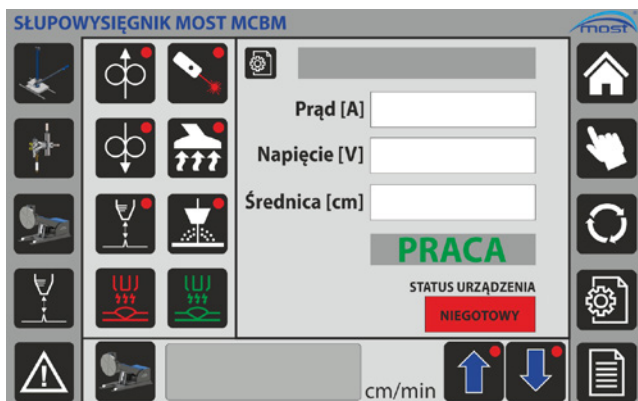
MOST MCBM welding column-booms are designed to extend production performance and to provide quality standards. Welding column-booms in connection to standard welding modules and accessories create right solutions in the field of welding automation. They can be easily integrated with roller rotators or MOST positioners to create a complete automated station. MOST MCBM welding column-booms have a modular design and offer working ranges up to 6x6 m. Different working ranges are available on request. MOST column and boom may be equipped with a stationary or mobile base including a drive. The final system configuration is always adapted on specific request and requirements of customer application.

**Welding column-booms are equipped with:**

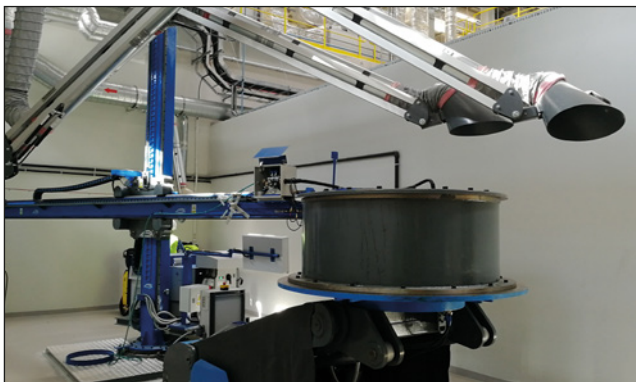
- Adjustable horizontal linear boom speed.
- Intuitive digital PLC control with operator's touch panel.
- Remote control.
- Vertical arm displacement system with counter weight.
- Safety limit switches.
- Motors including brake and forced cooling.

**Options:**

- Movable base, powered rail trolley.
- Column automatic rotation (engine incl.).
- System of monitoring welding area, vision system.
- Seam tracking system.
- Synchronization with other MOST products, i.e. roller rotators or positioners.



MOST MCS HMI operator touch panel

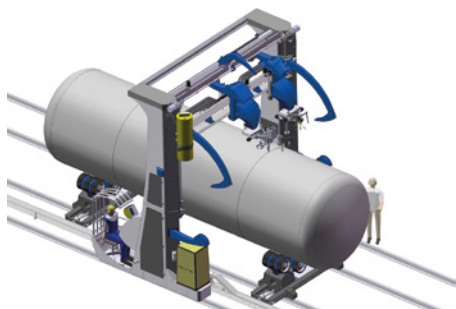


Model	Working range	Max boom load (horizontal boom)	Boom speed (welding) min/max	Column rotation	Automatic column rotation	Catalogue No.
MCBM-3x3	3x3 m	200 kg	200-1850 mm/min	manual	option	A9 15 000801
MCBM-4x4	4x4 m	200 kg	200-1850 mm/min	manual	option	A9 15 000802
MCBM-5x5	5x5 m	150 kg	200-1850 mm/min	manual	option	A9 15 000803
MCBM-6x6	6x6 m	150 kg	200-1850 mm/min	manual	option	A9 15 000804

▼ 4. GANTRY SYSTEM



**MOST MGWS – gantry system**



- Advanced gantry system for circumferential and longitudinal welds.
- Welding heads numerically operated and positioned on the X and Y axis driven by servomotors.
- Step motors responsible for the gantry drive and height adjustment.
- Welding methods: TIG, TIG with cold wire, MIG/MAG, PLASMA, SAW.
- Oscillation for the MIG/MAG method.
- Two independent welding methods can be used in one system.

Model	MGWS 33	MGWS 44	MGWS 55
Working range	3000x3000 mm	4000x4000 mm	5000x5000 mm
Welding head movement range in the X and Y axis	150-150 mm	150-150 mm	150-150 mm
Moving axis of the welding head R	90°	90°	90°
Gantry speed range	0,5-450 cm/min	0,5-450 cm/min	0,5-450 cm/min
Welding head speed range in the X and Y axis	0,01-150 cm/min	0,01-150 cm/min	0,01-150 cm/min
Welding method	TIG, TIG with cold wire, MIG/MAG, PLASMA, SAW		

**Tank positioning and assembly system:**

- 6 000 and 12 000 kg capacity (other capacities available on request).
- Automatic adjustment of the welded element diameter.
- Automatic positioning of the tank section.



System is digitally operated and the drive is powered by a servomotor and step motors.



## ▼ 5. PRECISION POSITIONERS



### Automation of circumferential welding.

Positioners are the basic systems to increase efficiency and quality of welding. In addition to automated welding circumferential welds, it can be also used as a positioning device for manual welding of structural elements. The MOST MP and MPH Series positioners offer a wide series of models regarding the workpiece weight and workstation final configuration options.

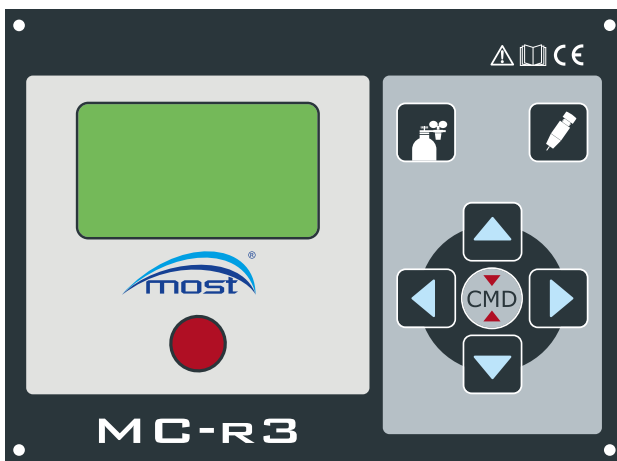
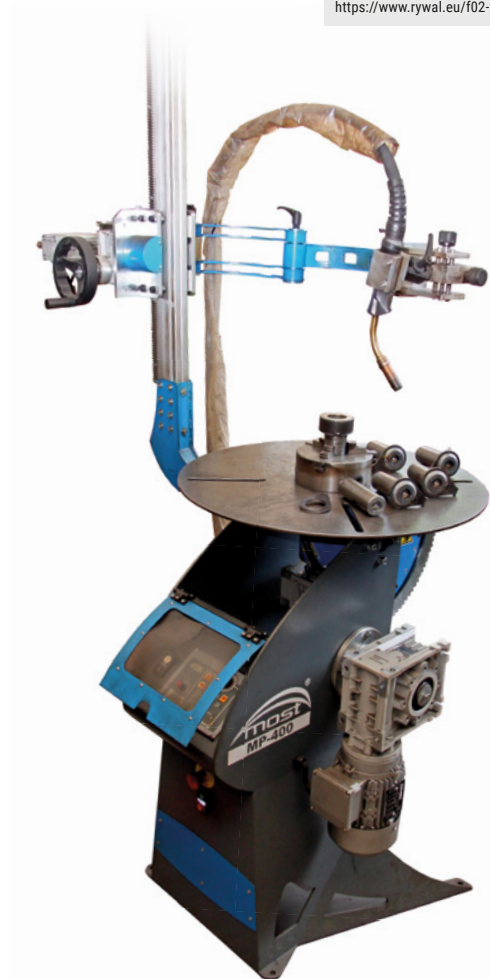
### Description:

- Powerful stepper motors ensuring continuous rotation speed and repeatable weld – quality.
- Large speed range of stepper motors enables the production of parts with- diameters.
- Pneumatic torch positioning (optional) enables extension to a simple automation solution.
- Integrated intuitive MOST MC controller with a line speed function and programmable tab function ensures simple and quick setting selection- both in manual and automatic mode.



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02



MOST MCr3 driver



System is digitally operated and the drive is powered by a servomotor and step motors.





### MOST MP positioners



**MOST MP-50 i MP-100:**

- Manual and automatic circumferential welding process.
- Manipulation of small and light-weight elements.
- Table version.
- Manual tilt adjustment in a 0°-110° range.

**MOST MP-400 i MP-600:**

- Manual and automatic circumferential welding process in production industrial.
- For the manipulation of spatial elements.
- Free-standing version.
- Automatic tilt adjustment in a 0°-90° range.

**MOST MP-2000 i MP-4000:**

- Reinforced range of MOST MP positioners dedicated to particularly large and heavy objects.
- Automatic tilt adjustment in a 0°-90° range.

Model	MOST MP-50	MOST MP-100	MOST MP-400	MOST MP-500	MOST MP-2000	MOST MP-4000
Maximum static load capacity	50 kg	90 kg	370 kg	520 kg	1700 kg	3700 kg
Maximum rotation torque v01	18 Nm	18 Nm	42 Nm	126 Nm	1814 Nm	3780 Nm
Maximum rotation torque v02	38 Nm	38 Nm	84 Nm	252 Nm	2585 Nm	4620 Nm
Maximum rotation torque v03	79 Nm	79 Nm	171 Nm	504 Nm	3326 Nm	5460 Nm
Tilt range	0-110°	0-110°	0-90°	0-90°	0-90°	0-90°
Tilt adjustment	Step, manual	Smooth, manual	Smooth, automatic	Smooth, automatic	Smooth, automatic	Smooth, automatic
Speed range v01	0,07-16,0 rpm	0,07-16,0 rpm	0,07-16,0 rpm	0,07-16,0 rpm	0,01-4,2 rpm	0,01-2,8 rpm
Speed range v02	0,03-8,0 rpm	0,03-8,0 rpm	0,03-8,0 rpm	0,03-8,0 rpm	0,01-2,8 rpm	0,00-2,1 rpm
Speed range v03	0,02-4,0 rpm	0,02-4,0 rpm	0,02-4,0 rpm	0,02-4,0 rpm	0,01-2,1 rpm	0,01-1,7 rpm
Catalogue No.	A9 17 100012	A9 17 100009	A9 17 100014	A9 17 100016	A9 17 100017	A9 17 100018

### MOST MPH positioners



**MOST MPH-50 i MPH-100:**

- Manual and automatic circumferential welding process.
- Hollow spindle.
- Possibility of feeding shielding gas to protect the ridge.
- Precise positioning for long items.
- Manual tilt adjustment in a 0°-110° range.

**MOST MPH-400 i MPH-600:**

- Manual and automatic circumferential welding process in production industrial.
- Hollow spindle.
- Possibility of feeding shielding gas to protect weld root.
- Precise positioning for long items.
- Automatic tilt adjustment in a 0°-110° range.

Model	MOST MPH-50	MOST MPH-100	MOST MPH-400	MOST MPH-600
Maximum static load capacity	50 kg	90 kg	370 kg	620 kg
Maximum rotation torque v01	49 Nm	49 Nm	87 Nm	154 Nm
Maximum rotation torque v02	120 Nm	120 Nm	181 Nm	319 Nm
Maximum rotation torque v03	241 Nm	241 Nm	362 Nm	639 Nm
Tilt range	0-110°	0-110°	0-110°	0-100°
Tilt adjustment	Smooth, manual	Smooth, manual	Smooth, automatic	Smooth, automatic
Hollow spindle	Ø48 mm	Ø78 mm	Ø108 mm	Ø144 mm
Speed range v01	0,08-20,0 rpm	0,08-20,0 rpm	0,05-11,4 rpm	0,05-11,4 rpm
Speed range v02	0,03-8,0 rpm	0,03-8,0 rpm	0,02-5,3 rpm	0,02-5,3 rpm
Speed range v03	0,02-4,0 rpm	0,02-4,0 rpm	0,01-2,8 rpm	0,01-2,7 rpm
Catalogue No.	A9 17 100013	A9 17 100020	A9 17 100021	A9 17 100022

## ▼ 6. WELDING POSITIONERS



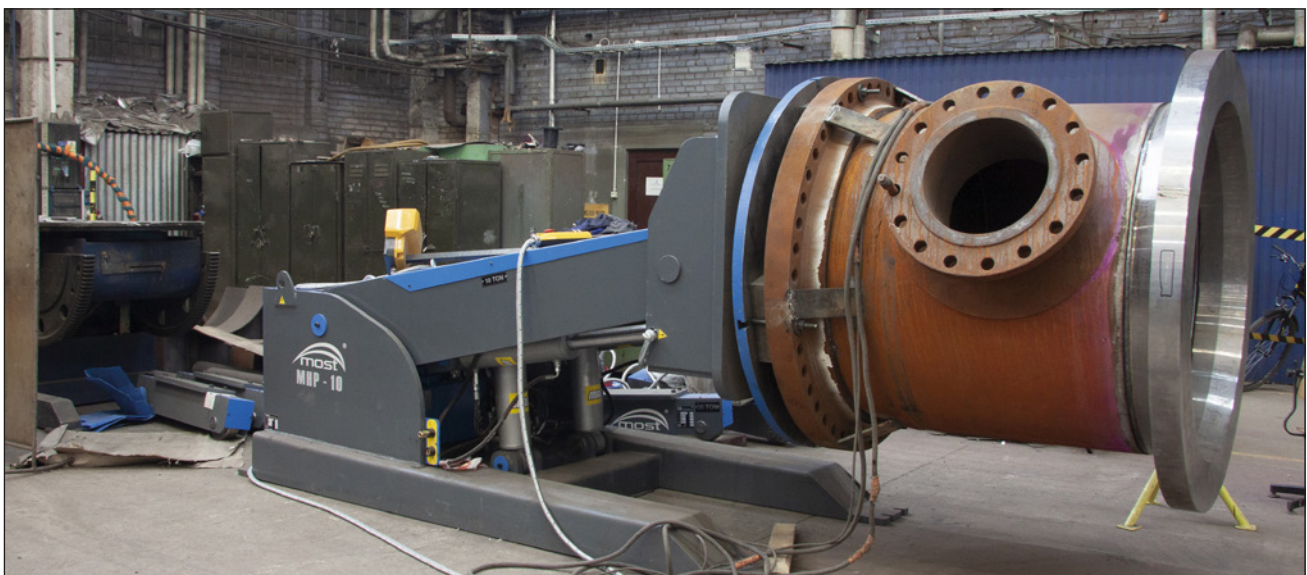
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02

MOST positioners are the best solution for lifting, rotating and tilting heavy work-pieces with a complex geometry. Use of positioners greatly increases productivity and significantly improves the quality of welding. The use of positioners increases flexibility, safety and comfort of work. With the use of positioner, welded element can always be placed in a convenient position, which secures performing a weld in a down-hand positions.

### Using MOST positioners ensures:

- Fast welding in the down hand position.
- Optimal welding parameters.
- Minimization of the risk of welding defects.
- Increased quality – less machining and less repairs.
- Work accuracy, safety and ergonomics.





### MOST MHP – 3 axis hydraulic welding positioners

**HIT**



- 3 working axis (lifting, rotating and tilting).
- The height, angle and rotation speed of the workpiece are fully adjustable.
- Stepless adjustment of height by means of hydraulic units.
- Ideal for welding heavy elements with complexes geometry.
- Maximum workpiece weight up to 10 000 kg (other capacities available on request).

Model	MHP-05	MHP-075	MHP-1	MHP-1,5	MHP-2	MHP-3,5	MHP-5	MHP-8	MHP-10
<b>Capacity</b>	500 kg	750 kg	1 000 kg	1 500 kg	2 000 kg	3 500 kg	5 000 kg	8 000 kg	10 000 kg
<b>Rotation speed</b>	0,15-1,5 rpm	0,15-1,5 rpm	0,15-1,4 rpm	0,15-1,3 rpm	0,15-1 rpm	0,15-1 rpm	0,15-0,76 rpm	0,10-0,66 rpm	0,10-0,5 rpm
<b>Maximum rotation torque</b>	750 Nm	1 150 Nm	1 570 Nm	2 290 Nm	3 050 Nm	5 300 Nm	7 500 Nm	12 050 Nm	15 050 Nm
<b>Max. tilt torque</b>	2 200 Nm	2 200 Nm	3 300 Nm	4 500 Nm	5 600 Nm	11 050 Nm	17 300 Nm	28 680 Nm	37 050 Nm
<b>Working plate diameter</b>	700 mm	700 mm	850 mm	850 mm	900 mm	1 000 mm	1 150 mm	1 250 mm	1 350 mm
<b>Catalogue No.</b>	A9 15 000100	A9 15 000104	A9 15 000101	A9 15 000106	A9 15 000102	A9 15 000107	A9 15 000105	A9 15 000108	A9 15 000109

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

### MOST MCP – conventional positioners



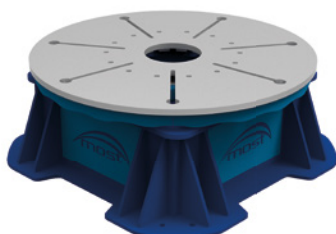
- Adjustable angle and rotation speed of the welded element.
- Stepless tilting adjustment.
- Maximum workpiece weight up to 10 000 kg (other capacities available on request).

Model	MCP-020	MCP-025	MCP-05	MCP-1	MCP-2	MCP-3	MCP-5	MCP-8	MCP-10
<b>Capacity</b>	200 kg	250 kg	500 kg	1 000 kg	2 000 kg	3 000 kg	5 000 kg	8 000 kg	10 000 kg
<b>Rotation speed</b>	0,22-2,2 rpm	0,15-1,5 rpm	0,15-1,5 rpm	0,15-1,4 rpm	0,1-0,7 rpm	0,1-0,7 rpm	0,15-0,76 rpm	0,13-0,67 rpm	0,1-0,5 rpm
<b>Maximum rotation torque</b>	300 Nm	500 Nm	780 Nm	1 600 Nm	3 150 Nm	4 500 Nm	7 500 Nm	12 000 Nm	15 100 Nm
<b>Max. tilt torque</b>	685 Nm	650 Nm	1 360 Nm	2 720 Nm	5 130 Nm	8 500 Nm	15 500 Nm	25 520 Nm	31 580 Nm
<b>Working plate diameter</b>	600 mm	600 mm	700 mm	850 mm	900 mm	1 000 mm	1 250 mm	1 500 mm	1 650 mm
<b>Catalogue No.</b>	A9 15 000132	A9 15 000133	A9 15 000120	A9 15 000121	A9 15 000122	A9 15 000123	A9 15 000125	A9 15 000128	A9 15 000131

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

### MOST MTT – turn tables

- Designed for the processing of elements in the vertical position.
- For high weight or thin wall elements.
- Maximum workpiece weight up to 50 000 kg (other capacities available on request).



Model	MTT-1	MTT-2	MTT-5	MTT-10	MTT-25	MTT-50
<b>Capacity</b>	1000 kg	2000 kg	5000 kg	10000 kg	25000 kg	50000 kg
<b>Rotation speed</b>	0,15-1,4 rpm	0,1-0,7 rpm	0,2-0,9 rpm	0,05-0,3 rpm	0,05-0,25 rpm	0,05-0,25 rpm
<b>Working plate diameter</b>	850 mm	900 mm	1250 mm	1500 mm	1800 mm	2000 mm
<b>Catalogue No.</b>	A9 15 000303	A9 15 000304	A9 15 000305	A9 15 000310	A9 15 000325	A9 15 000350

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.





### MOST MLPL-3AX – 3 axis “L” type welding positioners

- Ideal for the manipulation of large and most complex-geometry products.
- Stepless adjustment of speed, tilt and height.
- Manipulating large working elements with a complicated geometry in any position.
- Maximum workpiece weight up to 3 000 kg (other capacities available on request).

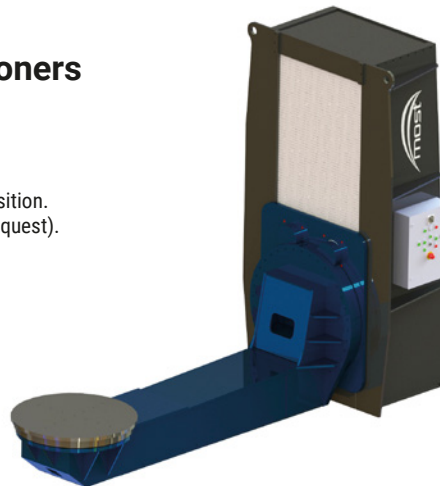


Model	MLPL0,75-3AX	MLPL1,5-3AX	MLPL3-3AX
Capacity	750 kg	1 500 kg	3 000 kg
Maximum working radius	1 000 mm	1 200 mm	1 600 mm
Max. rotation torque	1 130 Nm	2 260 Nm	4 550 Nm
Rotation speed	0,2-1,5 rpm	0,2-1,4 rpm	0,2-1 rpm
Max. tilt torque	1 380 Nm	3 340 Nm	6 900 Nm
Working plate diameter	700 mm	850 mm	1 000 mm
Catalogue No.	A9 15 000951	A9 15 000952	A9 15 000953

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

### MOST MLP – 3 axis “L” type welding positioners

- Ideal for the manipulation of large and most complex-geometry products.
- Stepless adjustment of speed, tilt and height.
- Adjustment of height by means of hydraulic elements.
- Manipulating large working elements with a complicated geometry in any position.
- Maximum workpiece weight up to 10 000 kg (other capacities available on request).



Model	MLP-1,5	MLP-3	MLP-5	MLP-7,5	MLP-10
Capacity	1 500 kg	3 000 kg	5 000 kg	7 500 kg	10 000 kg
Maximum working radius	1 300 mm	1 600 mm	1 700 mm	1 850 mm	2 000 mm
Max. rotation torque	2 260 Nm	4 550 Nm	7 500 Nm	12 050 Nm	15 000 Nm
Rotation speed	0,2-1,4 rpm	0,2-1 rpm	0,15-0,78 rpm	0,1-0,66 rpm	0,1-0,5 rpm
Max. tilt torque	3 340 Nm	6 900 Nm	14 750 Nm	19 300 Nm	24 700 Nm
Working plate diameter	850 mm	1 100 mm	1 100 mm	1 100 mm	1 300 mm
Catalogue No.	A9 15 000145	A9 15 000146	A9 15 000147	A9 15 000148	A9 15 000149

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.



### MOST MHTP – Headstock Tailstock Positioner

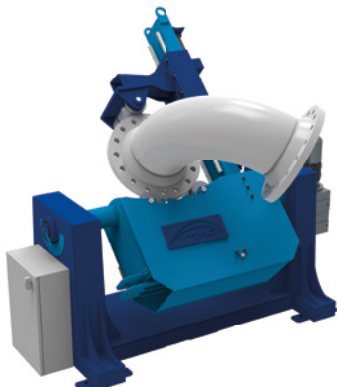


- Specially designed for manipulation of long, revolving work pieces.
- Ideal for circumferential welding and assembly of complicated and long work pieces. Trailer frames, containers parts, tanks, pipes or beams are ideal for this type of positioners.
- Mechanized rotation.
- Stepless height adjustment.
- Idler section may be equipped with rail carriages for welding work pieces of variable length.
- Maximum workpiece weight up to 12 000 kg (other capacities available on request).

Model	MHTP-1,5	MHTP-3	MHTP-5	MHTP-6	MHTP-8	MHTP-12
Capacity	1 500 kg	3 000 kg	5 000 kg	6 000 kg	8 000 kg	12 000 kg
Rotation speed	0,2-0,9 rpm	0,2-0,9 rpm	0,2-0,9 rpm	0,2-0,9 rpm	0,1-0,68 rpm	0,1-0,67 rpm
Max. rotation torque	5 000 Nm	10 150 Nm	17 800 Nm	20 550 Nm	24 000 Nm	36 000 Nm
Max. lifting torque	200 Nm	326 Nm	446 Nm	490 Nm	862 Nm	950 Nm
Adjustment range of vertical axis min-max	550-1550 mm	550-1550 mm	550-1800 mm	550-1800 mm	550-1800 mm	550-2300 mm
Working plate diameter	575 mm	650 mm	750 mm	750 mm	750 mm	1 000 mm
Max working diameter	2 800 mm	2 800 mm	3 600 mm	3 600 mm	3 600 mm	4 000 mm
Catalogue No.	A9 15 000410	A9 15 000420	A9 15 000430	A9 15 000440	A9 15 000460	A9 15 000450

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

### MOST MPP – pipe positioners



- For the mounting, rotating and tilting of processed elements with a round section.
- Ideal for pipes, elbow pipes, pipes with flanges.
- Smooth rotational speed adjustment.
- Quick, precise centering and clamping.
- Wide range of diameters and capacities.
- Centering of same diameter pipes.
- Mechanized rotation and tilting may be done at the same time.

Model	MPP-03	MPP-05	MPP-1	MPP-1,5	MPP-3
Capacity	300 kg	500 kg	750 kg	1 500 kg	3 000 kg
Rotation speed	200-1350 mm/min	200-1350 mm/min	200-1360 mm/min	200-1430 mm/min	200-1350 mm/min
Maximum rotation torque	260 Nm	300 Nm	610 Nm	1090 Nm	1230 Nm
Max. tilt torque	1680 Nm	2130 Nm	3590 Nm	6020 Nm	11870 Nm
Min-max pipe diameter	20-300 mm	20-400 mm	80-610 mm	80-610 mm	80-610 mm
Roller material	steel	steel	steel	steel	steel
Catalogue No.	A9 15 000164	A9 15 000167	A9 15 000161	A9 15 000162	A9 15 000163

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.



## ▼ 7. WELDING ROLLERBEDS



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02

Rollerbeds are devices dedicated to cylindrical workpiece manipulation. Devices of this type are necessary to manipulate and increase the production efficiency of the tanks, pipes and other rotating work pieces during welding process. MOST rotators can also be used for other processes, e.g. painting, sanding or assembly. Workpiece using rollerbeds may be placed in the most convenient work position. It significantly reduces time needed to prepare and manipulate the workpiece. Available variety of MOST rollerbeds includes a wide range of roller rotators models capable of manipulation of rotating elements of different masses, diameters and shapes.

### Standard equipment:

- adjustable diameter of the processed detail,
- adjustable rotational speed,
- remote control,
- digital rotation speed indicator,
- polyurethane wheels for absorbing shocks and vibration,
- motors including brake and forced cooling.

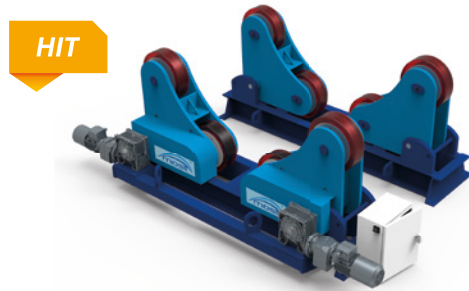
### Optional equipment:

- Buggy system moving of rollerbeds on the rail (manual or motorized).
- FIT-UP system, hydraulic leveling and positioning of workpiece.
- Special isolation for the most demanding working conditions.
- Custom roller designs for applications that require, for example high temperatures.





### MOST MSR – self-align rotators

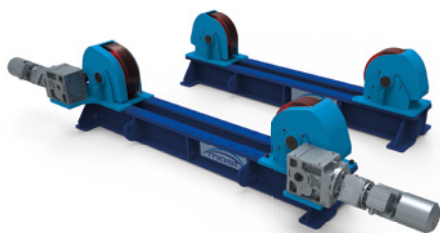


- Automatic adjustment of the welded element diameter.
- Ideal for the manipulation of heavy or thick-walled elements.
- Ensure a balanced load distribution.
- Buggy manual/motorized system moving rollerbeds on the rails.
- Maximum workpiece weight up to 100 000 kg (other capacities and diameter ranges available on request).

Model	MSR-3	MSR-5	MSR-10	MSR-15	MSR-20	MSR-30	MSR-40	MSR-50	MSR-60	MSR-80	MSR-120
Capacity	3 t	5 t	10 t	15 t	20 t	30 t	40 t	50 t	60 t	80 t	100 t
Capacity (drive section)	1,5 t	2,5 t	5 t	7,5 t	10 t	15 t	20 t	25 t	30 t	40 t	50 t
Capacity (idler section)	1,5 t	2,5 t	5 t	7,5 t	10 t	15 t	20 t	25 t	30 t	40 t	50 t
4 drive rollers	option	option	option	option	option	standard	standard	standard	standard	standard	standard
Rotation speed range	200-1200 mm/min	150-1220 mm/min	150-1220 mm/min	150-1300 mm/min	150-1470 mm/min	150-1300 mm/min	150-1200 mm/min	150-1230 mm/min	150-1350 mm/min	150-1500 mm/min	150-1400 mm/min
Diameter range min-max	250-2000 mm	250-3000 mm	450-3000 mm	450-3300 mm	450-4600 mm	500-4600 mm	500-4600 mm	500-4600 mm	550-5200 mm	550-5500 mm	600-5500 mm
Roller material	PU	PU	PU	PU	PU	PU	PU	PU	PU	PU	PU
Catalogue No.	A9 15 000203	A9 15 000205	A9 15 000210	A9 15 000209	A9 15 000212	A9 15 000213	A9 15 000214	A9 15 000215	A9 15 000216	A9 15 000218	A9 15 000220

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

### MOST MCR – conventional rollerbeds



- Manual adjustment of the welded element diameter.
- Compact size.
- Easy rolls spacing adjustment.
- Buggy manual/motorized system moving rollerbeds on the rails.
- Maximum workpiece weight up to 100 000 kg (other capacities and diameter ranges available on request).

Model	MCR-3	MCR-5	MCR-10	MCR-15	MCR-20	MCR-30	MCR-40	MCR-50	MCR-60	MCR-80	MCR-100
Capacity	3 t	5 t	10 t	15 t	20 t	30 t	40 t	50 t	60 t	80 t	100 t
Capacity (drive section)	1,5 t	2,5 t	5 t	7,5 t	10 t	15 t	20 t	25 t	30 t	40 t	50 t
Capacity (idler section)	1,5 t	2,5 t	5 t	7,5 t	10 t	15 t	20 t	25 t	30 t	40 t	50 t
2 drive rollers	option	option	option	standard	standard	standard	standard	standard	standard	standard	standard
Rotation speed range	200-1250 mm/min	200-1150 mm/min	200-1150 mm/min	200-1200 mm/min	200-1150 mm/min	200-1200 mm/min	200-1200 mm/min	200-1200 mm/min	200-1250 mm/min	200-1200 mm/min	200-1250 mm/min
Diameter range min-max	200-2000 mm	250-3000 mm	250-3000 mm	400-3300 mm	450-4600 mm	450-4600 mm	450-4600 mm	450-4600 mm	550-5200 mm	550-5200 mm	600-5500 mm
Catalogue No.	A9 15 000223	A9 15 000225	A9 15 000231	A9 15 000237	A9 15 000232	A9 15 000233	A9 15 000234	A9 15 000235	A9 15 000236	A9 15 000238	A9 15 000239

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

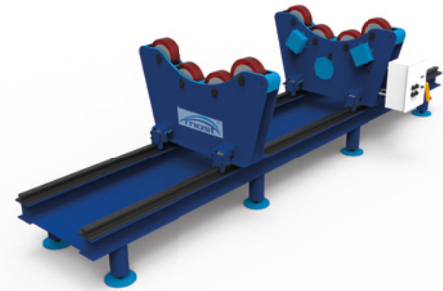


## MOST MPR and MPRA – pipe rotators

- Manual adjustment of the welded element diameter.
- Compact size.
- Easy roller spacing adjustment.
- Buggy manual/motorized system moving rollerbeds on the rails.
- Maximum workpiece weight up to 8 000 kg (other capacities and diameter ranges available on request).

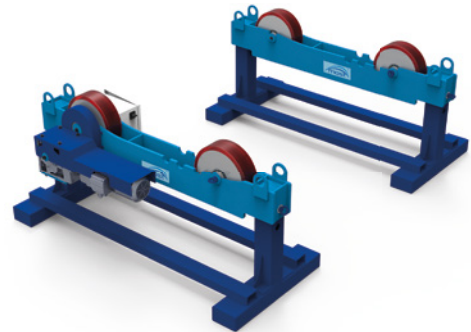
Model	MPR-3	MPR-6
Capacity	3 t	6 t
Capacity (drive section)	1,5 t	3 t
Capacity (idler section)	1,5 t	3 t
4 powered rolls	standard	standard
Rotation speed range	200-1100 mm/min	200-1000 mm/min
Diameter range min-max	80-1420 mm	110-1420 mm
Catalogue No.	A9 51 000995	A9 51 000994

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.



Model	MPRA-3	MPRA-6	MPRA-8
Capacity	3 t	6 t	8 t
Capacity (drive section)	1,5 t	3 t	4 t
Capacity (idler section)	1,5 t	3 t	4 t
Rotation speed range	200-1280 mm/min	200-1280 mm/min	200-1300 mm/min
Diameter range min-max	110-1200 mm	110-1200 mm	110-1420 mm
Catalogue No.	A9 15 000993	A9 15 000992	A9 15 001000

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.



## MOST MCHR – chain rotator

- Lifting and rotating of long workpiece like i-beams, profiles and other sections.
- Rotator is resistant to sharp edges of the workpieces.
- Eliminates the need to use cranes.
- Maximum workpiece weight up to 12 000 kg (other capacities and working ranges available on request).



Model	MCHR-6/600	MCHR-6/1000	MCHR-6/1500	MCHR-6/2000	MCHR-6/2500	MCHR-6/3000
Capacity	6 000 kg	6 000 kg	6 000 kg	6 000 kg	6 000 kg	6 000 kg
Capacity (drive section)	3 000 kg	3 000 kg	3 000 kg	3 000 kg	3 000 kg	3 000 kg
Capacity (idler section)	3 000 kg	3 000 kg	3 000 kg	3 000 kg	3 000 kg	3 000 kg
Rotation speed	5 rpm	5 rpm	5 rpm	5 rpm	5 rpm	5 rpm
Max. working diameter	600 mm	1 000 mm	1 500 mm	2 000 mm	2 500 mm	3 000 mm
Model	MCHR-12/1000	MCHR-12/1500	MCHR-12/2000	MCHR-12/2500	MCHR-12/3000	
Capacity	12 000 kg	12 000 kg	12 000 kg	12 000 kg	12 000 kg	
Capacity (drive section)	6 000 kg	6 000 kg	6 000 kg	6 000 kg	6 000 kg	
Capacity (idler section)	6 000 kg	6 000 kg	6 000 kg	6 000 kg	6 000 kg	
Rotation speed	5 rpm	5 rpm	5 rpm	5 rpm	5 rpm	
Max. working diameter	1 000 mm	1 500 mm	2 000 mm	2 500 mm	3 000 mm	

The technical parameter values for standard products may be changed without prior notice. If a special device model was ordered, the values may differ from the ones provided. Other load capacities and working ranges available on request.

## 8. WORKSHOP POSITIONERS AND ROTATORS



The use of positioners and rotators greatly increases productivity and significantly improves the quality of welding. Positioners and rotators are used in order to achieve optimal working conditions, ergonomics and to increase the safety of workers as well as to raise the efficiency and quality of the welds.

**Description:**

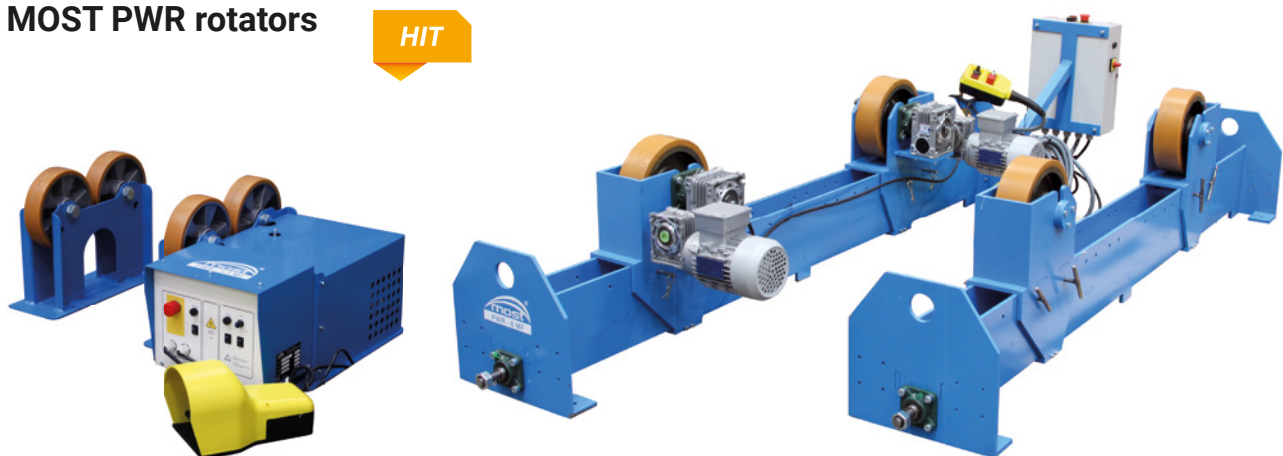
- Fast welding in the down-hand positions.
- Optimal welding parameters.
- Increased quality – less weld machining and less repairs.
- Accuracy, safety and ergonomics.

### MOST PWR positioners



Model	PWR-100	PWR-100HC	PWR-150	PWR-300	PWR-500
Capacity	100 kg	100 kg	150 kg	300 kg	500 kg
Vertical capacity	100 kg	100 kg	150 kg	300 kg	500 kg
Rotation speed	0,6-6 rpm	0,6-6 rpm	0,6-6 rpm	0,6-6 rpm	0,6-6 rpm
Working plate diameter	300 mm	300 mm / through spindle Ø50 mm	400 mm	600 mm	600 mm
Catalogue No.	A9 17 000076	A9 17 000078	A9 17 000150	A9 17 000300	A9 17 000499

### MOST PWR rotators



Model	PWR-1,5MF	PWR-3MF	PWR-6MF	PWR-12MF
Capacity	1500 kg	3000 kg	6000 kg	12000 kg
Capacity per section	750 kg	1500 kg	3000 kg	6000 kg
Rotation speed	120-1400 mm/min	120-1400 mm/min	120-1400 mm/min	120-1400 mm/min
Diameter range	20-800 mm	30-2500 mm	300-3500 mm	300-4000 mm
Catalogue No.	A9 17 000090	A9 17 000093	A9 17 000096	A9 17 000099



▼ 9. WELDING CARRIAGES



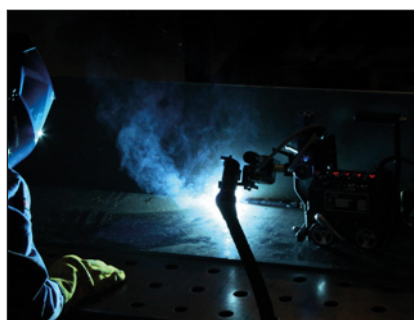
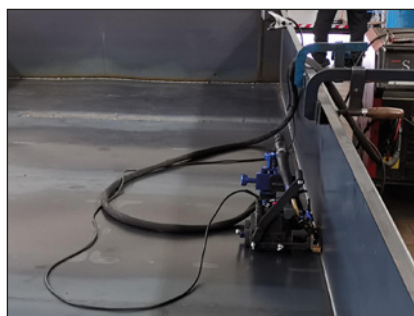
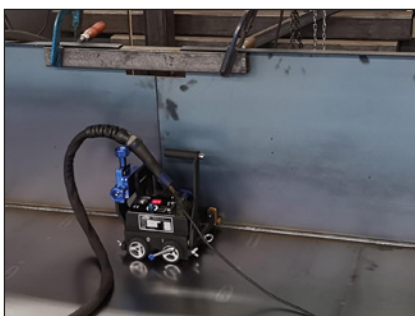
**MOST COBRA and COBRA OSC – welding carriage**

- Highly efficient longitudinal welding in different working positions.
- Compact, lightweight design.
- Durable housing.
- 4-wheel drive.
- Magnetic base.
- Precise torch position adjustment for all applications.
- LED speed display.
- Automatic arc on / off system (control of the welding device).
- Torch oscillator (COBRA OSC version).

**HIT**



Model	COBRA	COBRA OSC
Welding speed	0-800 mm/min	
Oscillation unit	-	Yes
Drive system	4WD	
Magnetic base	Yes	
Guide arms	Roller guides -2 pcs.	
Welding positions:	PA / 1F / 1GPB / 2FPC / 2GPD / 4FPE / 4G	
Battery powered	Option	
Catalogue No.	A9 15 000021	A9 15 000022

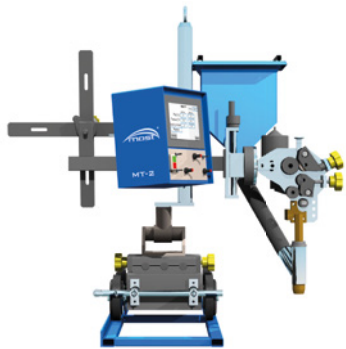




▼ 10. SUBMERGED ARC WELDING



**MOST MT-2 (SAW) tractor for submerged arc welding**



- SAW welding process optimization.
- Increased efficiency and quality.
- Four wheel drive.
- Engine with a tachometer rotation counter.
- All welding parameters adjusted and monitored by means of a PLC digital controller.
- Digital, microprocessor – driven system with 2% voltage stabilization.
- Vacuum flux recovery system (optional).
- Equipment for external arch guidance (optional).

Wide range of regulation enables creating butt and fillets welds:

- Butt welding of flat sheets.
- Fillet welding of stiffeners and profiles.
- Beam welding.
- Shipbuilding industry.
- Internal welding of wind turbines and tanks.

Model	MOST MT-2
Wire diameter range	2,0-5,0 mm
Welding speed	20-140 cm/min
Welding current in a 60% work cycle	1000 A
Welding current in a 100% work cycle	800 A
Welding voltage	18-44 V
Longitudinal support adjustment range	80 mm
Catalogue No.	A9 15 000019

**MOST PONTE 800c/1000c/1200c/1600c power sources**



- Highly efficient automated submerged arc welding.
- MIG/MAG, MMA welding and arc gouging.
- Dedicated for working in harsh, industrial conditions.
- Three-phase, air or liquid cooled direct current sources.
- Stable arc both with high and low welding voltages.
- Good ignition and re-ignition properties.
- 2% parameter stabilization.

Model	PONTE 800c	PONTE 1000c	PONTE 1200c	PONTE 1600c
Welding current range	0-800 A	0-1000 A	0-1200 A	0-1600 A
Welding current 60% in work cycle	650 A/40 V	850 A/40 V	1000 A/40 V	1450 A/40 V
Welding current 100% in work cycle	550 A/40 V	700 A/40 V	850 A/40 V	1350 A/40 V
Parameter stabilization	2%	2%	2%	2%
Welding method	SAW, MMA, MIG/MAG, arc gouging			
Frequency	10,5 Hz	10,5 Hz	10,5 Hz	10,5 Hz
Cooling	Air	Air / liquid (option)	Liquid	Liquid

**MOST FD-70L flux dryer**



- High efficiency and effectiveness of flux drying.
- Excellent thermal insulation.
- Unique design and high power of heating elements.
- Chromed and galvanized external layers with a higher resistance to chemical factors.
- Temperature adjustment controller with a display.
- Analogue or digital (option) programmer.

Model	MOST FD-70L
Capacity	70 l / (100 kg)
Heating element power	3600 W
Working temperature range	0-400°C
Catalogue No.	A9 15 000033

▼ 11. ORBITAL WELDING SYSTEM



**MOST orbital welding system**

- Compact system for orbital welding.
- Intuitive programming – guided program creation (automatic program calculation) after the diameter of the pipe and thickness of the wall are entered.
- Possibility of manual correction of the parameters during welding (in the fly).
- Monitoring of weld parameters (automatic process parameters documentation).
- Compatible with residual oxygen sensors.
- AVC system (optional).
- Oscillation (optional).

Model	MOST OS 80	MOST OS 115
<b>Orbital head type</b>	OWH 76 LB	OWH 114 LB
<b>Range of supported pipe diameters</b>	10-80 mm	20-115 mm
<b>Welding current range TIG DC</b>	3-220 A	
<b>Welding current in work cycle (40°C) according to EN60974-1, TIG method:</b>		
Current in 100% cycle	165 A	
Current in 60% cycle	190 A	
<b>Orbital welding programs</b>	99	
<b>Manual welding programs</b>	64	
<b>Liquid cooling</b>	option	
<b>Cold wire feeder</b>	option	
<b>Catalogue No.</b>	A9 15 000080	A9 15 000115



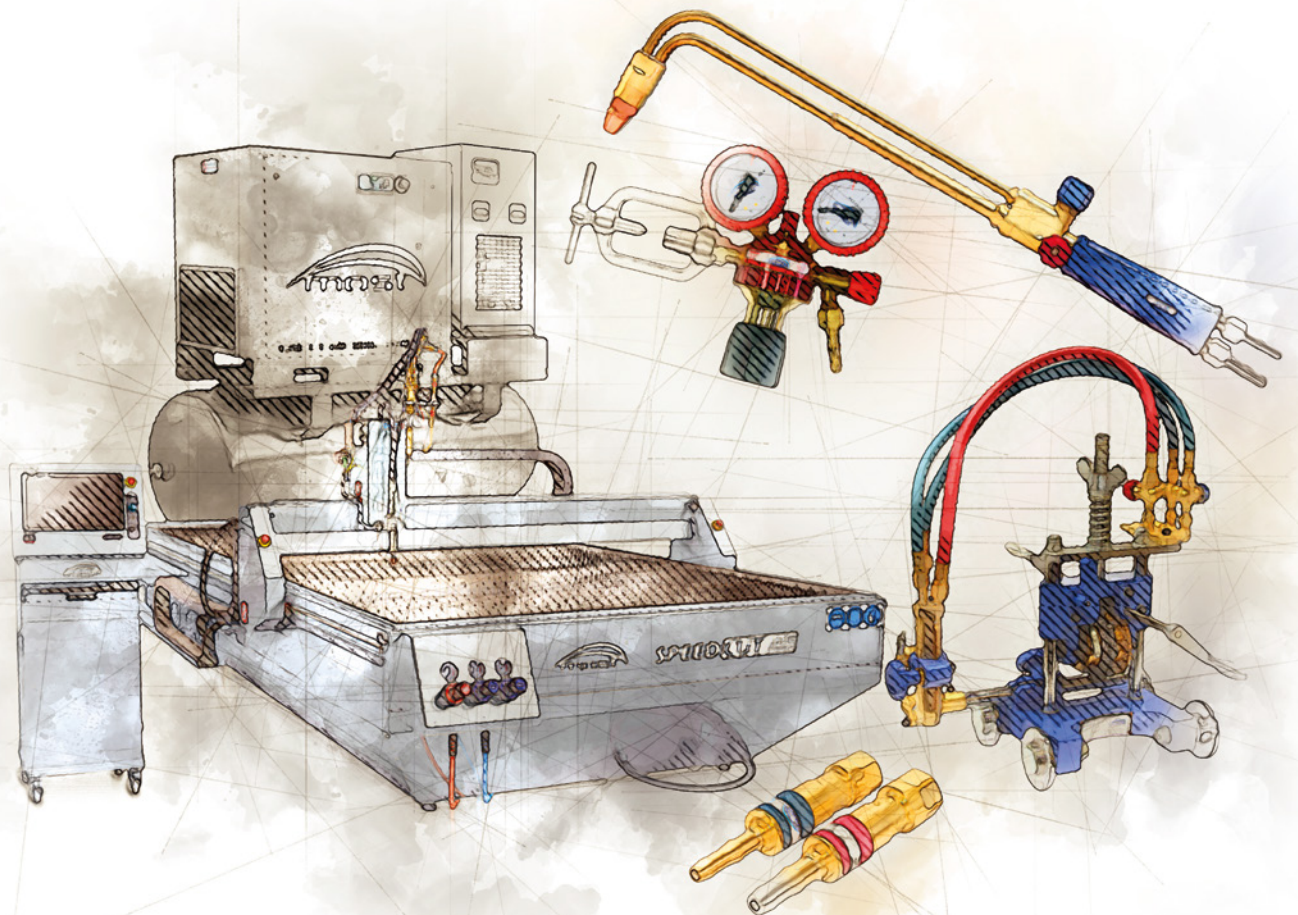
OWH 76 head



OWH 114 head



# 03



# CNC MACHINES AND GAS ACCESSORIES

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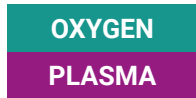
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## ▼ 1. CNC MACHINES FOR CUTTING WITH OXYGEN, PLASMA AND WATER



### Onyx CNC machine

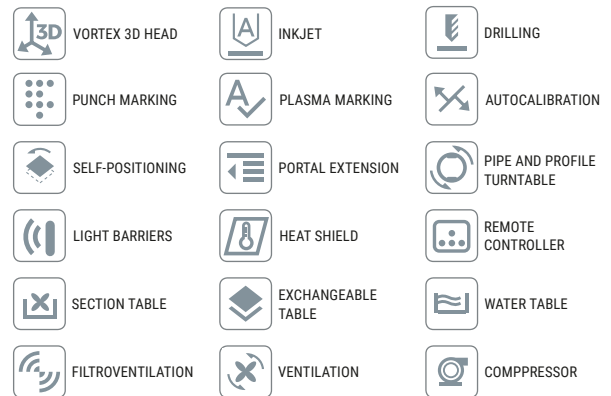


Type of CNC	ONYX
Drives	Servo AC
Cutting width (with two slides) [mm]	2000-7000
Basic working length [mm]	Any length from 1500
Positioning speed [mm/min]	25000
Cutting thickness [mm]	up to 300
Cutting quality	EN ISO 9013
Positioning accuracy	EN 28206
Safety standard	EN 13850
3-shift operation possibility	Yes

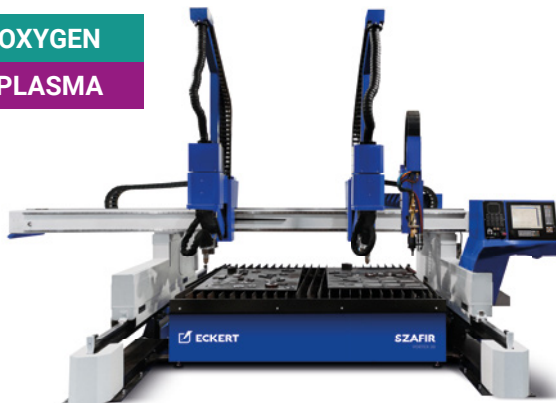
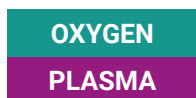
#### Main features:

- Vortex 3D FL plasma head provides the highest precision in automated 3D cutting of metal sheets, pipes and profiles.
- Increased portal stiffness allows for dynamic cutting of sheets with thicknesses from 1 to 300 mm.
- Modern i-Vision controller installed on a moving arm, provides exceptional ergonomics and comfort.
- Power LED lighting and light curtains guarantee safe operation.
- Excellent results thanks to an extensive database of predefined parameters for oxygen and plasma cutting.
- The machine is certified by Hypertherm® True Hole™ and Kjellberg® Contour Cut™ technology.
- Remote machine load management.
- Machine maintenance schedule assistant.

#### Accessories:



### Szafir CNC machine

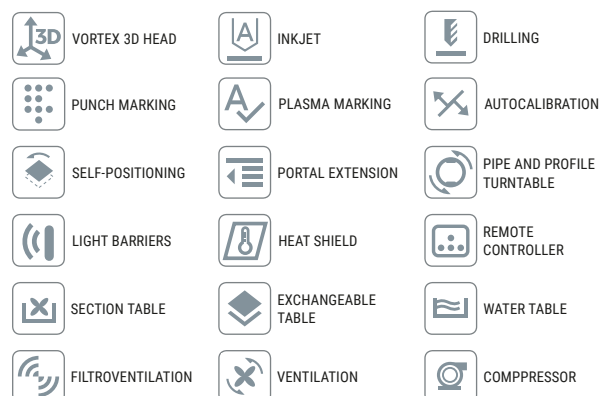


Type of CNC	SZAFIR
Drives	Servo AC
Cutting width (with two slides) [mm]	1500-7000
Basic working length [mm]	Any length from 1500
Positioning speed [mm/min]	25000
Cutting thickness [mm]	up to 200
Cutting quality	EN ISO 9013
Positioning accuracy	EN 28206
Safety standard	EN 13850
3-shift operation possibility	Yes

#### Main features:

- High dynamics and precision of automated 3D cutting of metal sheets, pipes and profiles.
- Cutting metal sheets up to 200 mm thickness.
- Extensive database of predefined cutting parameters.
- Unlimited possibility of increasing length of the working area.
- The machine is certified by Hypertherm® True Hole™ and Kjellberg® Contour Cut™ technology.
- Remote machine load management.
- Machine maintenance schedule assistant.

#### Accessories:







## Chrom CNC machine

OXYGEN

PLASMA

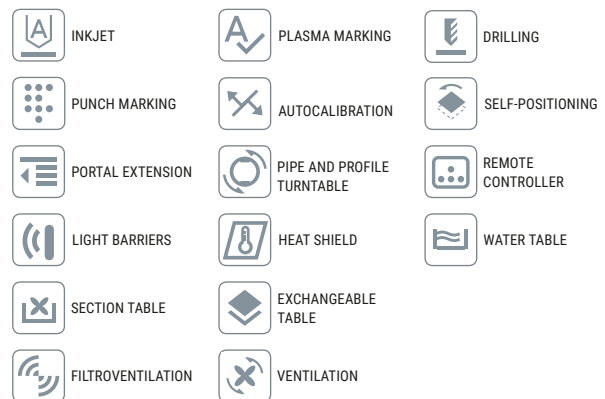


Type of CNC	CHROM
Drives	Servo AC
Cutting width (with two slides) [mm]	1000-3000
Basic working length [mm]	over 3000
Positioning speed [mm/min]	25000
Cutting thickness [mm]	up to 150
Cutting quality	EN ISO 9013
Positioning accuracy	EN 28206
Acceleration [m/s]	up to 1
Safety standard	EN 13850
3-shift operation possibility	Yes

### Main features:

- Unique precision in cutting complex shapes.
- Cutting steel from 1 to 150 mm thick.
- EtherCAT® technology solution for reliable connection of all machine components.
- Acceleration up to 1 m/s.
- Different security packages can be selected.
- A modern i-Vision controller, installed on a movable arm for exceptional ergonomics and comfort.
- A plug & play solution that allows you to expand and upgrade your machine at any time.
- Power LED lighting for greater operational safety.
- Integration of modules inside the machine, which increases resistance to harmful factors during the cutting process.
- Adapted to work in Industry 4.0.
- Machine maintenance schedule assistant.

### Accessories:



## Jantar CNC machine

OXYGEN

PLASMA

HIT

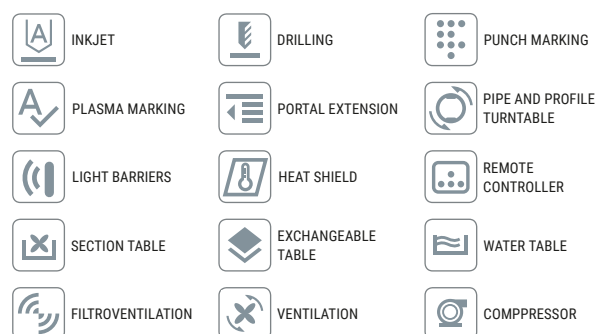


Type of CNC	JANTAR
Drives	Servo AC
Cutting width [mm]	1500, 2000, 2500, 3000
Basic working length [mm]	Any length from 1500
Positioning speed [mm/min]	25000
Cutting thickness [mm]	up to 100
Cutting quality	EN ISO 9013
Positioning accuracy	EN 28206
Safety standard	EN 13850
3-shift operation possibility	Yes

### Main features:

- High dynamics and precision of 2D cutting of metal sheets, pipes and profiles.
- Cutting materials from 0,5 mm to 100 mm thickness.
- Extensive database of predefined cutting parameters.
- Unlimited possibility of increasing length of the working area.
- The machine is certified by Hypertherm® True Hole™ and Kjellberg® Contour Cut™ technology.
- Remote machine load management.
- Machine maintenance schedule assistant.

### Accessories:





## Rubin HD CNC machine



OXYGEN

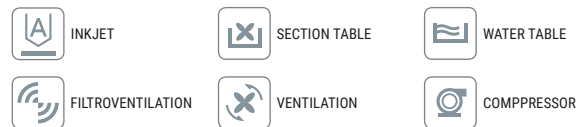
PLASMA



### Main features:

- Attractive price of a fully equipped basic version.
- Cutting capacity of steel from 1 mm to 100 mm thick.
- High durability thanks to independent construction of the portal and work table design.
- Robust construction based on steel profiles.
- Unprecedented ease of use.
- Excellent cutting results thanks to plasma power sources of a renowned brand.

### Accessories:



Type of CNC	RUBIN HD
Drives	Servo AC
Cutting width (with two slides) [mm]	1500, 2000
Basic working length [mm]	3000, 6000
Positioning speed [mm/min]	15000
Cutting thickness [mm]	up to 100
Cutting quality	EN ISO 9013
Positioning accuracy	EN 28206
Safety standard	EN 13850
3-shift operation possibility	Yes

## Rubin ECO CNC machine

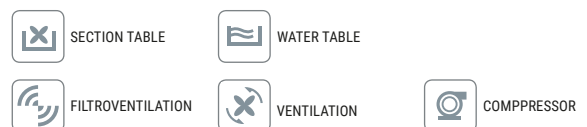
PLASMA



### Main features:

- Attractive price of a fully equipped basic version.
- Use of ecological water table to reduce noise and pollution.
- Cutting capacity of steel up to 30 mm thickness.
- High durability thanks to independent construction of the portal and work table design.
- Robust construction based on steel profiles.
- Unprecedented ease of use.

### Accessories:



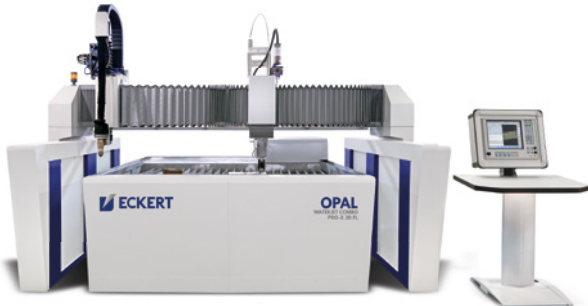
Type of CNC	RUBIN ECO
Drives	Servo AC
Cutting width (with two slides) [mm]	1500, 2000
Basic working length [mm]	3000, 6000
Positioning speed [mm/min]	15000
Cutting thickness [mm]	up to 30
Positioning accuracy	EN 28206
Safety standard	EN 13850
3-shift operation possibility	Yes



## Opal Waterjet Combo CNC machine

03

**WATER**  
**PLASMA**



Type of CNC	OPAL WATERJET COMBO
Drives	Servo AC
Cutting width [mm]	1000 - 6000
Basic working length [mm]	1000 - 12000
Water cutting thickness 2D [mm]	0,5 - 250
Water cutting thickness 3D [mm]	0,5 - 150
Plasma cutting thickness	depending on the plasma power source
Positioning speed [mm/min]	25000
Safety standard	EN 13850

### Main features:

- An innovative, patent protected combination of water and plasma technology.
- Fully automated cutting process with two different cutting technologies.
- Reduction of production costs even by 70% with comparison to standard waterjet machines.
- Universal cutting tool for any kind of material.
- Possibility of installing PRO-X 3D head.
- Ability to apply any required technology during edge cutting of a single element (plasma, water).
- Robust and reliable construction.
- Abrasive or pure water cutting.

### Accessories:

- PRO-X3D HEAD
- PLASMA MARKING
- DRILLING
- PUNCH MARKING
- ABRASIVE CUTTING
- PIPE AND PROFILE TURNTABLE
- WATER TABLE
- DYNAMIC CHANGE OF THE WATER LEVEL
- SCRATCH CONVEYOR
- WATER SOFTENING SYSTEM
- CASCADE FILTER
- FILTER WITH FILTER CARTRIDGE
- LIGHT BARRIERS

## Opal Waterjet CNC machine

**WATER**



Type of CNC	OPAL WATERJET
Drives	Servo AC
Cutting width [mm]	1000 - 6000
Basic working length [mm]	1000 - 12000
Water cutting thickness 2D [mm]	0,5 - 250
Water cutting thickness 3D [mm]	0,5 - 150
Passage speed [mm/min]	25000
Safety standard	EN 13850

### Main features:

- Versatile application.
- No dust formation during the cutting process.
- Possibility of water and abrasive cutting.
- Assembly up to 4 water heads at a time.
- Renowned high-pressure components.
- Free choice of cutting quality (5 levels).
- Robust and reliable construction.

### Accessories:

- PRO-X3D HEAD
- LIGHT BARRIERS
- PLASMA MARKING
- ABRASIVE CUTTING
- DYNAMIC CHANGE OF WATER LEVEL
- DRILLING
- WATER TABLE
- STAINLESS STEEL WATER TABLE
- BRICKS BASE
- WATER SOFTENING SYSTEM
- CASCADE FILTER
- FILTER WITH FILTER CARTRIDGE



## Plasma power sources

We cooperate with leading manufacturers of plasma power sources: Hypertherm and Kjellberg. Technologies applied by our partners allow us to achieve the best plasma cutting performance. The range of possibilities of modern plasma sources ensures high precision and perpendicularity of the cutting edge with minimum or no outflow from under the cutting edge.

### **Hypertherm™ True Hole™**

#### HyPerformance Plasma Systems



HyPerformance Plasma systems deliver Hy-Definition cutting quality with excellent performance, productivity and profitability due to increased consumables lifetime. Additionally, they deliver superior quality and consistency, eliminating the cost of secondary operations.

Power source	Max. cutting thickness with piercing [mm]	Max. cutting capacity from the edge [mm]
XPR 170	40	60
XPR 300	50	80
HPR 400 XD	50	80
HPR 800 XD	50	160

The data depends on type of material and its structure.



## Powermax Plasma Systems

Powermax Plasma Systems have a high cutting capacity and are used for all automatic steel machining operations.



Power source	Max. cutting thickness with piercing [mm]	Max. cutting range from the edge [mm]
Powermax 45	12	25
Powermax 65	16	32
Powermax 85	20	38
Powermax 105	22	50
Powermax 125	25	57
Max Pro 200	35	75

The data depends on the type of material and its structure.



## Q-series power sources

Q series units are a completely new solution in terms of construction and modern design. The greatest progress has been made in the field of remote control of the unit and in preparing the device for cooperation on Industry 4.0 platforms.

Power source	Max. cutting thickness with piercing [mm]	Max. cutting range from edge [mm]
Q1500	30	60
Q3000	40	80

The data depends on the type of material and its structure.



## HiFocus power sources

The HiFocus power sources line is recommended for cutting all types of low-alloy and high-alloy steels. Thanks to its exceptional parameters, it is particularly suitable for cutting stainless steel and aluminum.

Power source	Max. cutting thickness with piercing [mm]	Max. cutting range from the edge [mm]
HiFocus 80i NEO	12	25
HiFocus 130 NEO	25	40
HiFocus 161i NEO	30	50
HiFocus 280i NEO	35	70
HiFocus 360i NEO	40	80
HiFocus 440i NEO	50	120
HiFocus 600i NEO	80	160

The data depends on the type of material and its structure.



## SmartFocus power sources

The SmartFocus series are excellent alternative to the HiFocus. With comparable technical parameters, the user benefits from significantly lower investment cost in the purchase of the unit.

Power source	Max. cutting thickness with piercing [mm]	Max. cutting range from the edge [mm]
SmartFocus 130	25	40
SmartFocus 200	30	60
SmartFocus 300	40	80
SmartFocus 400	50	100

The data depends on the type of material and its structure.







### SpeedCut MOST CNC machine

PLASMA

HIT



Type of CNC	SpeedCut
Type of table	water
Cutting width [mm]	1500
Cutting length [mm]	3000
Positioning speed [mm/min.]	25 000
Cutting tool	plasma torch
Cutting thickness [mm]	up to 25
Cutting quality	EN ISO 9013

**Main features:**

- Adjustment of the distance between cutting torch and metal sheet - THC system.
- Working range in Z axis = 110 to 270 mm.
- Table load capacity supported by anti-vibration feet.
- Autonomous CNC PLC controller of Polish production.
- CAD/CAM software in Polish as standard version (other languages optional).
- Ground guides and tooth gears.
- Automatic lubrication system for the X axis linear guide.
- Ergonomic control panel adjustable in two levels.
- Computer screen protected by tempered glass.
- Ball conveyors for easy material positioning.
- Carrier ports for easy transport of the machine.
- Table equipped with a water grate - low operating costs.

**Accessories:**

- Plasma power source.
- Screw compressor.
- CAD/CAM program with automatic nesting.

### SpeedCut Compact MOST CNC machine

OXYGEN  
PLASMA

HIT



Type of CNC	SpeedCut Compact
Type of table	water
Available models ( width/length) [mm]	1500/3000 or 2000/4000 or 2000/6000
Positioning speed [mm/min.]	18 000 - 28 000
Cutting tool	plasma / oxygen cutting torch
Cutting thickness - plasma torch [mm]	up to 25
Cutting thickness - oxygen torch [mm]	up to 100 (up to 50 in production)
Cutting quality	EN ISO 9013

**Main features:**

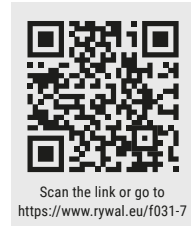
- Adjustment of the distance between cutting torch and metal sheet - THC system.
- Plasma and oxygen cutting torches.
- Distance to the gate up to 180 mm.
- Table load capacity supported by anti-vibration feet.
- Double-sided drive on a toothed slat.
- Autonomous CNC computer PLC of Polish production.
- CAD/CAM software in Polish in standard version.
- Slats and gear wheels grinded and hardened.
- Automatic lubrication system for the X and Y axis linear guide.
- Ergonomic control panel adjustable in two levels.
- The monitor screen is protected with tempered glass.
- Transport holes for easy movement of the machine.
- Table equipped with a water grate - low operating costs.

**Accessories:**

- Plasma power source.
- Screw compressor.
- CAD/CAM program with automatic nesting.



## SpeedCut MOST CNC machine



03



- 1. Control system
- 2. Integrated ergonomic keyboard
- 3. Stainless steel water table
- 4. Ball points for easy loading of metal sheet
- 5. High table load capacity 4000 kg
- 6. Transport holes for the forklift truck
- 7. Automatic lubrication system
- 8. Torch base system
- 9. Central rail truck drive
- 10. Z-axis with a large working range
- 11. Deeper stainless steel bathtub
- 12. Table load capacity 5000 kg
- 13. Double-sided rail truck drive
- 14. Simple and quick torch replacement
- 15. High-precision toothed gears
- 16. Top quality linear guides
- 17. Automatic lubrication system for all axes

Type of CNC	SpeedCut 15/30 MOST Silver	SpeedCut 15/30 MOST Compact Silver	SpeedCut 20/60 MOST Compact Silver
Type of table	water	water	water
Table load capacity [kg]	4000	5000	15 000
Net weight of the machine [kg]	700	820	1600
Water quantity [l]	500	800	2400
Travers speed [mm/min]	25 000	18 000	28 000
Gas cutting	-	●	●
Coating	galvanized	galvanized	galvanized
Machine dimensions [mm]	3700x2040x1280	3880x2190x1450	6880x2490x1450
Outdoor extension (1000 mm)	option	-	-
Nominal working area [mm]	1500x3000	1500x3000	2000x6000
Desktop type	freestanding 24"	freestanding 24"	freestanding 24"
USB interface	2	2	2
Keyboard	metal, dust and oil-resistant	metal, dust and oil-resistant	metal, dust and oil-resistant
Ball manipulator	●	●	●
Height adjuster	●	●	●
CAD/CAM software	●	●	●
Cutting software	●	●	●
Ball points for easy loading of metal	-	-	-
Holes for forklift	●	●	●
Adjustable support legs	6	8	12
Bathtub	stainless steel	stainless steel	stainless steel
Automatic lubrication system	-	●	●
Central rail truck drive	●	-	-
Double-sided rail truck on toothed gears	-	●	●
LSCG - Leveling System Chamfering Gates - equalizing the rail truck position system	●	●	●
DR - Dynamic Referencing system of dynamic point "0,0" indication	●	●	●
QS - quick start	●	●	●
RBE - Rotary Basing Edge - Innovative Basis system	●	●	●
TSC - Torch Sensor Control - dual roofing system	●	●	●
Stop & Go - simulation cutting system	●	●	●
Catalogue No.	60 75 001532	60 75 001533	60 75 002062

## 2. PROFESSIONAL COMPRESSED AIR SYSTEMS



### KZB COMBO MOST series screw compressors

Tank-mounted screw compressors equipped with a dryer, pre-filter and fine filter.



Type	Pressure [bar]	Capacity [l/min]	Power [kW]	Volume [dB (A)]	Tank [l]	Weight [kg]	Dimensions [mm]	Catalogue No.
KZB 5,5 COMBO	8/10/13	850/700/550	5,5	68	500	342	1940x650x1460	60 84 000500/60 84 000501/60 84 000502
KZB 7,5 COMBO	8/10/13	1150/1000/850	7,5	70	500	381	1940x650x1460	60 84 000510/60 84 000511/60 84 000512
KZB 11 COMBO	8/10/13	1650/1500/1200	11	70	500	533	1940x720x1650	60 84 000520/60 84 000521/60 84 000522
KZB 15 COMBO	8/10/13	2250/2150/1600	15	70	500	563	1940x720x1650	60 84 000530/60 84 000531/60 84 000532

### KZB MOST series screw compressors

Screw compressors installed on the tank, without dryer, pre-filter and fine filter.



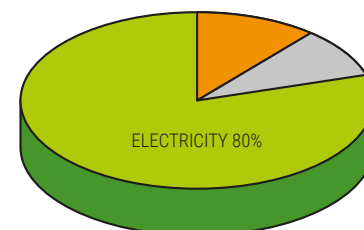
Type	Pressure [bar]	Capacity [l/min]	Power [kW]	Volume [dB (A)]	Tank [l]	Weight [kg]	Dimensions [mm]	Catalogue No.
KZB 5,5	8/10/13	850/700/550	5,5	68	500	310	1940x650x1460	60 84 000403/60 84 000404/60 84 000405
KZB 7,5	8/10/13	1150/1000/850	7,5	70	500	330	1940x650x1460	60 84 000410/60 84 000411/60 84 000412
KZB 11	8/10/13	1650/1500/1200	11	71	500	480	1940x720x1650	60 84 000420/60 84 000421/60 84 000422
KZB 15	8/10/13	2250/2150/1600	15	73	500	510	1940x720x1650	60 84 000430/60 84 000431/60 84 000432

### How much does compressed air cost?

The data refers to a screw compressor at 40 000 hours operating time.

Energy saving in screw compressors consists in:

- efficient heat recovery,
- implementing energy-saving solutions (superior control).



- Investment costs 11%
- Maintenance 9%
- Electricity costs 80%



## K series screw compressors MOST

Free-standing screw compressors, without tank, dryer, pre-filter and fine filter.



Type	Pressure [bar]	Capacity [l/min]	Power [kW]	Volume [dB (A)]	Tank [l]	Weight [kg]	Dimensions [mm]	Catalogue No.
K 5,5	8/10/13	850/700/550	5,5	68	500	180	970x650x860	60 84 000300/60 84 000301/60 84 000302
K 7,5	8/10/13	1150/1000/850	7,5	70	500	200	970x650x860	60 84 000310/60 84 000311/60 84 000312
K11	8/10/13	1650/1500/1200	11	71	500	250	970x720x1003	60 84 000320/60 84 000321/60 84 000322
K 15	8/10/13	2250/2150/1600	15	73	500	250	970x720x1003	60 84 000330/60 84 000331/60 84 000332

## MOST compressors - additional options

### Frequency inverter

SF P variable speed compressors use a frequency converter to adapt compressor performance to air consumption, saving up to 35% energy. The SF P compressors are highly efficient and flexible thanks to their high-quality components and clever design.



### Cyclone separator

In order to improve the efficiency of the air processing system, the SP cyclone separator is installed at the compressor outlet. As a result of air turbulence, heavy particles of steam and dirt are ejected into the separator wall. The amount of condensate removed in this way represents approximately 72% of all water contained in the compressed air.



### WED condensate drain

The removal of condensate from the buffer tank is an important activity that has a significant impact on its durability. Practice shows that many users forget about it, so we suggest to equip the compressor with an automatic WED condensate drain. This will not only help to relieve the customer of their daily routine, but will also extend the life of the tank and protect the compressed air system from being flooded with water and oil condensate.



### ▼ 3. PORTABLE GAS CUTTING MACHINES



#### Handy Cut MOST

**HIT**



Processing possibilities								
Straight cutting	Mould cutting	Hole cutting	Curvilinear-cutting	H-form cutting	Various profiles cutting	Pipes	Square pipes cutting	All positions

**Characteristics:**

- Semi-automatic torch for cutting of steel up to 50 mm thickness.
- High quality cutting of metal sheets, pipes, profiles and irregularly shaped elements.
- Variable adjustment of the torch cutting speed and direction of cut.
- Semi-automatic ignition system.
- Edge beveling in the range of angles 0-45°.
- Circle cutting in the diameter range of 30-200 mm and 150-500 mm.

Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of cutting circles	Weight	Characteristics
60 70 000100	Handy Cut	5-50 mm	150-530 mm/min	30-500 mm	2,8 kg	Electric cutting torch. Equipped with semi-automatic ignition

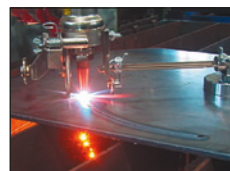
**Standard Equipment:**



Small cutting circle (Ø30-200 mm)



Beveling device



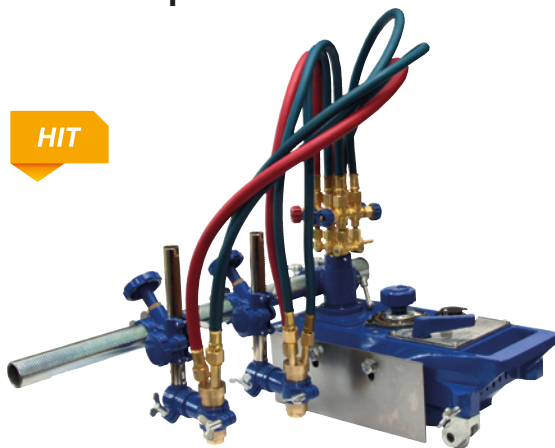
The large circle cutting attachment (Ø125-500 mm) (Additional Equipment)



Driving Gear for curved cutting

#### M-12 Wasp MOST

**HIT**



**Characteristics:**

- Semi-automatic double torch cutting machine for cutting and beveling of steel up to 150 mm thickness.
- Aluminium alloy body heat-resistant.
- Induction motor insensitive to voltage spikes.
- Stepless mechanical gearbox.
- Stepless regulation of the cutting speed.
- Beveling of edges within an unlimited angle range (reduction, sheet metal thinning).
- Possibility of circles cutting using a circle or circumferential rail.

Processing possibilities			
Straight cutting	Mould cutting	Hole cutting	Curvilinear-cutting

Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of cutting circles	Weight	Characteristics
60 70 000400	M-12 Wasp	5-150 mm	80-800 mm/min	40-2500 mm	11 kg	Sheet metal cutting and beveling machine



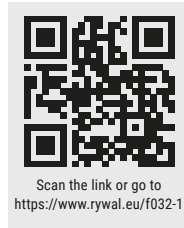
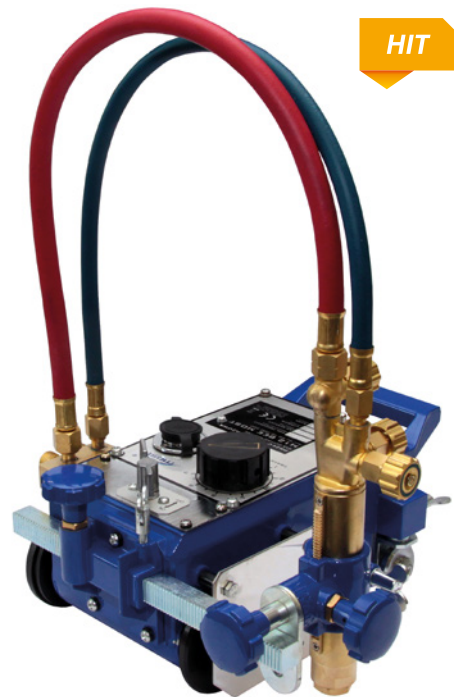


## M-12 Bee MOST

**Characteristics:**

- Semi-automatic single-torch cutting machine for cutting and bevelling steel up to 150 mm thickness.
- Aluminum alloy body heat-resistant.
- Stepless mechanical gearbox.
- Smooth regulation of the cutting speed.
- Beveling of edges in the range of 0-45°.
- Circle cutting from 80 to 1500 mm.

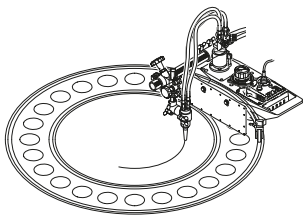
HIT



Processing possibilities		
straight cutting	mould cutting	hole cutting

Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of cutting circles	Weight	Characteristics
60 70 000300	M-12 Bee	5-150 mm	80-800 mm/min	80-1500 mm	10 kg	Sheet metal cutting and bevelling machine

### Optional equipment for M-12 Wasp and M-12 Bee cutting units:



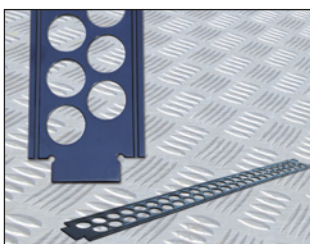
**Wasp circular rail**

The rail is designed to work with the M-12 Wasp. It is used for cutting or bevelling of circles in diameters of 40-360 mm and 770-1150 mm.



**Bee Circle cutting devices**

Enables to cut different diameters of holes. The minimum diameter depends on the dimensions of the device on which the circle cutting device is mounted.

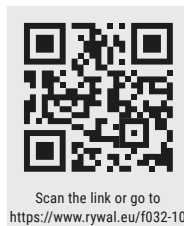


**Standard rail, Wasp & Bee**

Aluminum alloy rail designed to work with M-12 Wasp and M-12 Bee devices. Length of 1800 mm. The rails can be connected to each other and stabilized with magnetic support.

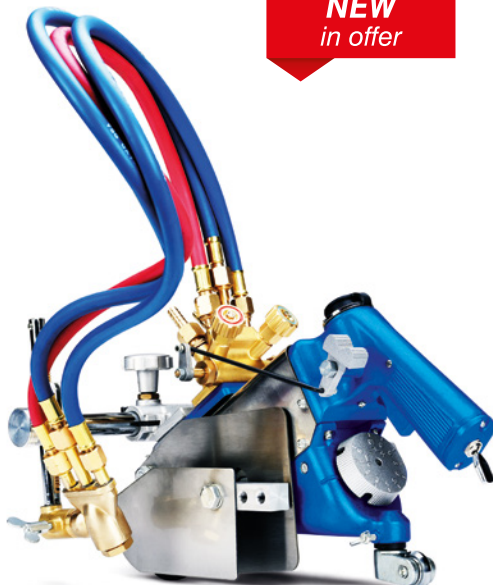


TrackCut MOST



03

**NEW**  
in offer



The semi-automatic TrackCut MOST cutter is a device for oxygen-cutting of sheets up to 100 mm thick. It has the option of bevelling the edges in the range of 0-45° and 50-80° with an inverted torch (for reductions and undercutting of sheets). Unprecedented smoothness of operation and mobility. The device can be guided by hand (e.g. curved bevells). All control elements (cutting oxygen flow, clutch, speed control) are located in the handle, which facilitates one-handed operation.

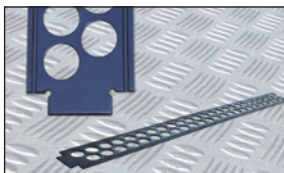
**Standard equipment:**



**Compass**

It enables cutting out circles of various diameters. The minimum diameter depends on the dimensions of the device on which the compass is mounted.

**Optional equipment:**



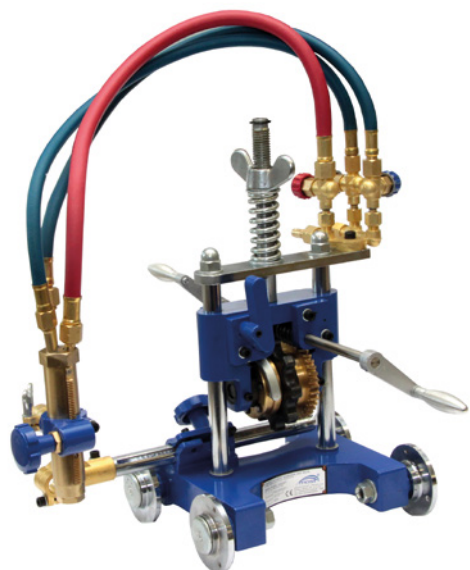
**Rail**

Aluminum alloy rail designed to work with TrackCut MOST devices. Length 1800 mm (other lengths available on request). The rails can be joined together and stabilized with magnetic rollers.

Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of the cut holes	Weight	Characteristics
60 70 000600	TrackCut	5-100 mm	50-1000 mm/min	50-550 mm	10 kg	Sheet metal cutting and bevelling machine

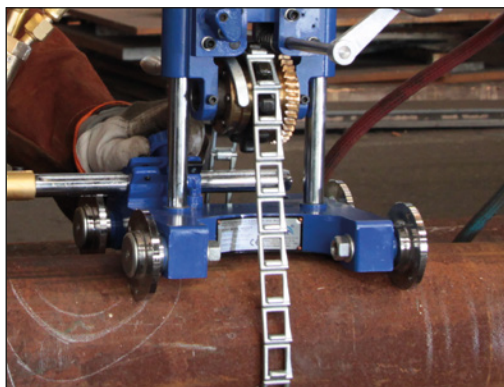
Processing possibilities			
Straight cutting	Mould cutting	Hole cutting	Curvilinear-cutting

OxyPipe MOST



**Characteristics:**

- Single-torch hand cutting machine for cutting and bevelling pipes up to 50 mm thickness.
- Smooth regulation of the cutting speed thanks to worm gearbox.
- Possibility of bevelling of edges in the range of 0-45°.
- Cutting of pipes with a minimum diameter from 115 mm (including pre-insulated and coated pipes).



Additional chain 1000 mm

Processing possibilities
Pipes

Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of cutting pipes	Weight	Characteristics
60 70 000200	Oxy Pipe	5-50 mm	80-800 mm/min	from 115 mm upwards	11,5 kg	Pipe cutting and bevelling machine



## Magnetic Pipe MOST

### Characteristics:

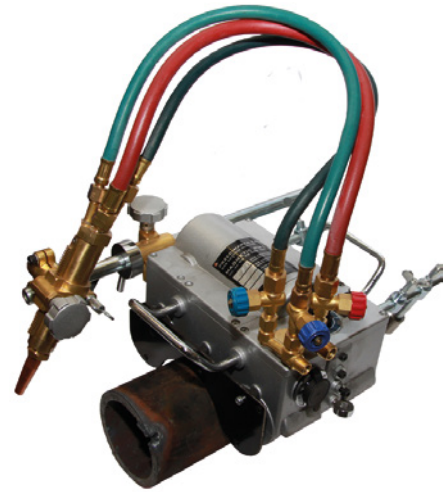
- Electrically driven magnetic cutting machine for cutting and bevelling of sheets and pipes in any position.
- Possibility of device assembly to the material with 4 magnetic wheels.
- No need for chains.
- Holds the element perfectly in every position.
- Two types of torch can be chosen, allowing bevelling at any angle.



Scan the link or go to <https://www.rywal.eu/f032-9>

### Processing possibilities

Pipes	Sheets



Catalogue No.	Name	Cutting thickness	Cutting speed	Diameter of cutting pipes	Weight	Characteristics
60 70 000500	Magnetic Pipe (short torch)	5-100 mm	50-750 mm/min	from 115 mm upwards	15 kg	Cutting & bevelling machine for pipes and plates
60 70 000501	Magnetic Pipe (long torch)					

## MOST nozzles for portable cutting machines

Cutting thickness range (nozzle type)					
Type of gas	3-5 mm	5-10 mm	10-15 mm	15-30 mm	30-40 mm
Acetylene	102-00	102-0	102-1	102-2	102-3
	102D7-00	102D7-0	102D7-1	102D7-2	102D7-3
Propane	106-00	106-0	106-1	106-2	106-3
	106D7-00	106D7-0	106D7-1	106D7-2	106D7-3
Natural gas	107-00	107-0	107-1	107-2	107-3
	107D7-00	107D7-0	107D7-1	107D7-2	107D7-3
Apachi	103-00	103-0	103-1	103-2	103-3
	103D7-00	103D7-0	103D7-1	103D7-2	103D7-3



Acetylene

Propane

Cutting thickness range (nozzle type)					
Type of gas	40-50 mm	50-100 mm	100-150 mm	150-250 mm	250-300 mm
Acetylene	102-4	102-5	102-6	102-7	102-8
	102D7-4	102D7-5	102D7-6	102D7-7	102D7-8
Propane	106-4	106-5	106-6	106-7	106-8
	106D7-4	106D7-5	106D7-6	106D7-7	106D7-8
Natural gas	107-4	107-5	107-6	107-7	107-8
	107D7-4	107D7-5	107D7-6	107D7-7	107D7-8
Apachi	103-4	103-5	103-6	103-7	103-8
	103D7-4	103D7-5	103D7-6	103D7-7	103D7-8



Natural gas

Apachi

### WARNING:

Nozzles marked 102D7, 106D7, 107D7, 103D7 due to their special design with higher cutting pressure allow to achieve up to 30% higher cutting speed, while maintaining the same oxygen consumption.

## ▼ 4. PLASMA CUTTING MACHINES



### Plasma cutting machine FANCUT 42 MOST

FANCUT 42 MOST is a plasma cutting machine with a current range up to 40 A and single-phase 230 V power supply.

The cutter is equipped with a PFC (Power Factor Correction) module.

The advantage of inverters equipped with PFC module is higher efficiency, lower electric power consumption load (a weaker fuse is required), greater tolerance to supply current fluctuations and less interference generated by the cutter. The device has a lower weight than older units of similar power and is equipped with a factory-mounted pressure regulator.



Scan the link or go to <https://www.rywal.eu/f032-11>



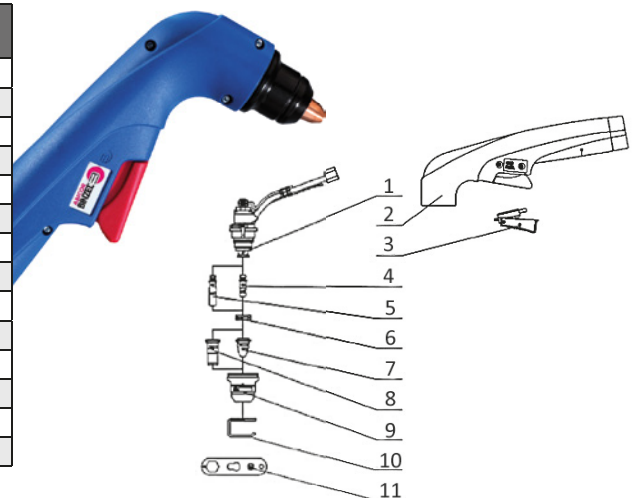
Universal air filter for plasma cutters	Catalogue No.
Air filter AT-1000 with mounting adapter	59 00 240036
Paper insert for AT-1000 5303	59 00 240037
Filter adapter ATA-1000 5304 (inlet/outlet accessories)	59 00 240038
Compass 742.D121.1	59 00 250103

Model	FANCUT 42
Main voltage	1x230 V/50-60 Hz
Network protection	16T A
Max current $I_n$	21,8 A
Max effective current $I_{eff}$	15,4 A
Power factor cos	0,98
Cutting current range	20/88,0 - 40/96,0 A/V
Idle Voltage $U_0$	320 V
Cutting current (X=100%) I <sub>2</sub> /U <sub>2</sub>	28/91,2 A/V
Cutting current (X=60%) I <sub>2</sub> /U <sub>2</sub>	33/93,2 A/V
Cutting current (X=50%) I <sub>2</sub> /U <sub>2</sub>	40/96 A/V
Max. thickness of quality carbon steel cutting	10 mm
Duty air pressure	5,0 bar
Min./Max. air pressure	4,5/8,5 bar
Air consumption	119 l/min
Arc ignition	pneumatic-contact
Power regulation	stepless
Insulation class	F
IP Rating	IP 23S
Dimensions (W x L x H)	148x490x295 mm
Weight	8,4 kg
Catalogue No.	59 00 250060

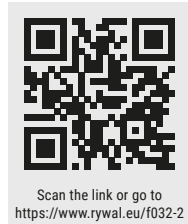


### Spare parts for plasma torch ABICUT 45 to FANCUT 40/41/42 MOST

No.	Spare parts	Manufacturer's code	Catalogue No.
1.	ABICUT 25K/45 body	748.0020.1	59 13 748020
2.	ABICUT handle	748.0053.1	59 13 748053
3.	Trigger	185.0005	55 13 007360
4.	Short electrode (equipped)	748.0032.10	59 13 748032
5.	Long electrode	748.0048.10	59 13 748048
6.	Diffuser	748.0033.2	59 13 748033
7.	Standard nozzle 0.8 mm	748.0035.10	59 13 748035
7.1.	Nozzle 0.65	748.0034.10	59 13 748034
8.	Long nozzle 0.9 mm (contact)	748.0049.10	59 13 748049
9.	Shield cup body ABICUT 45 (equipped)	748.0043.2	59 13 748043
9.1.	Cup 35A	748.0052.2	59 13 748052
10.	ABICUT 25K/45 Guide	748.0050.5	59 13 748050
11.	ABICUT key 25K/45/75 (cutting buggy)	748.0059.1	59 13 748059
12.	ABICUT 45/6 m plasma holder	-	59 03 030146







## Inverter plasma cutting machines 71/101 FANCUT MOST

FANCUT 71 and FANCUT 101 are modern, lightweight devices for cutting metal by air plasma.

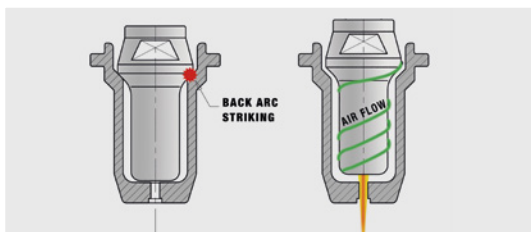
- Small size and weight.
- PT-80/100 series plasma torches 6 meters long.
- BACK STRIKING plasma arc ignition, which significantly extends the service life of spare parts, especially in comparison to the high frequency HF ignition.
- Easy to use and modern panel.
- Grid cutting mode: the plasma arc is also maintained when passing through gaps in the material.
- Electro-gauging with suitable parts - available for FANCUT 101.
- Contact cutting (touching the metal with cutting nozzle) or space cutting.
- The air pressure regulator is located at the front of the machine.



### Accessories available:

- Caliper PT-80 Compass Z0134AA - 59 25 000102.
- Caliper PT-100 Compass Z0143ZA - 59 25 000104.
- Bevel Tool 51880 for PT 80 - 59 25 000106.
- Bevel Tool 51887 for PT 100 - 59 25 000107.
- AT-1000 - 59 00 240036 air filter.
- Exchangeable paper insert for AT-1000 - 59 00 240037.
- Filter adapter AT-1000 (inlet/outlet accessories) - 59 00 240038.

The device is supplied with PT Plasma Torch 80/PT100 - 6 m long with double-pointed spacer, earth cable, user's manual and starter kit for cutting.



BACK STRIKING plasma arc scheme.

Model	FANCUT 71	FANCUT 101
<b>Main voltage: -10% / + 15%</b>	3x400 V / 50-60 Hz	3x400 V / 50-60 Hz
<b>Network protection</b>	16 A	20 A
<b>Max current I<sub>1</sub></b>	16 A	21,5 A
<b>Max effective current I<sub>1eff</sub></b>	12 A	15 A
<b>Power consumption (X=60%)</b>	11 kVA	16 kVA
<b>Cutting current range</b>	20-70 A	8-100 A
<b>Idle Voltage U<sub>0</sub></b>	280 V	310 V
<b>Cutting current (X=100%) I<sub>2</sub></b>	55 A	75 A
<b>Cutting current (X=60%) I<sub>2</sub></b>	70 A	100 A
<b>Max. thickness of qualitative carbon steel cutting</b>	25 mm	30 mm
<b>Recommended thickness of qualitative carbon steel cutting</b>	18 mm	22 mm
<b>Separating cutting</b>	35 mm	40 mm
<b>Duty air pressure (for torch in length 6 m)</b>	5,5-6,0 bar	5,5-6,0 bar
<b>Plasma-generating gas</b>	Compressed air	Compressed air
<b>Max. air pressure</b>	10 bar	10 bar
<b>Air consumption</b>	160 l/min	200 l/min
<b>Arc ignition</b>	Contact BACK STRIKING	Contact BACK STRIKING
<b>Power regulation</b>	Stepless	Stepless
<b>Insulation class</b>	F	F
<b>IP Rating</b>	IP 23	IP 23
<b>Dimensions (W x L x H)</b>	360x350x630 mm	610x340x680 mm
<b>Weight</b>	25 kg	39 kg
<b>Catalogue No.</b>	59 00 300071	59 00 300101

Recommended cutting thickness - current - cutting speed for FANCUT 101 (torch PT-100)

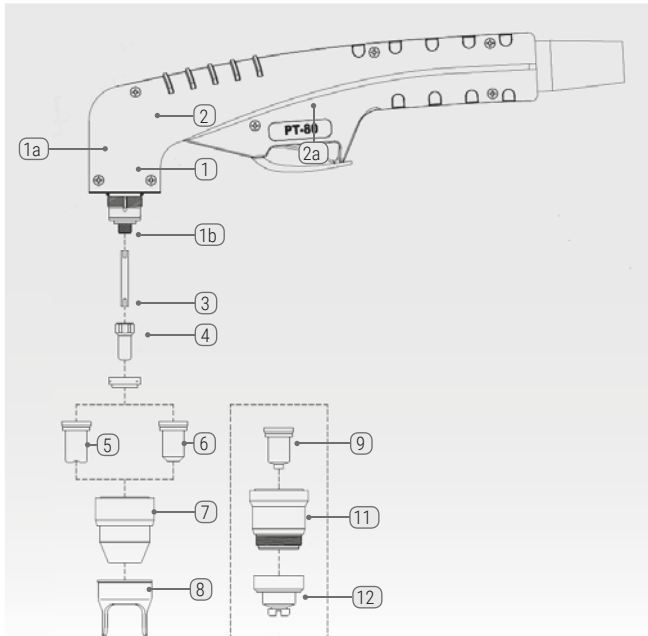
Mild steel			Stainless steel			Aluminium		
Thickness [mm]	Cutting current [A]	Cutting speed [mm/min]	Thickness [mm]	Cutting current [A]	Cutting speed [mm/min]	Thickness [mm]	Cutting current [A]	Cutting speed [mm/min]
4	40	2500	4	40	2300	4	40	3000
6	60	1700	6	60	1500	6	60	2000
10	60	1000	10	60	800	10	60	1100
12	80	900	12	80	800	12	80	900
15	80	600	15	80	550	15	80	650
20	100	600	20	100	550	20	100	650
25	100	400	25	100	300			
30	100	300						

The recommendations apply for an air pressure of 5,5 - 6,0 bar and a flow rate of 210 l/min.



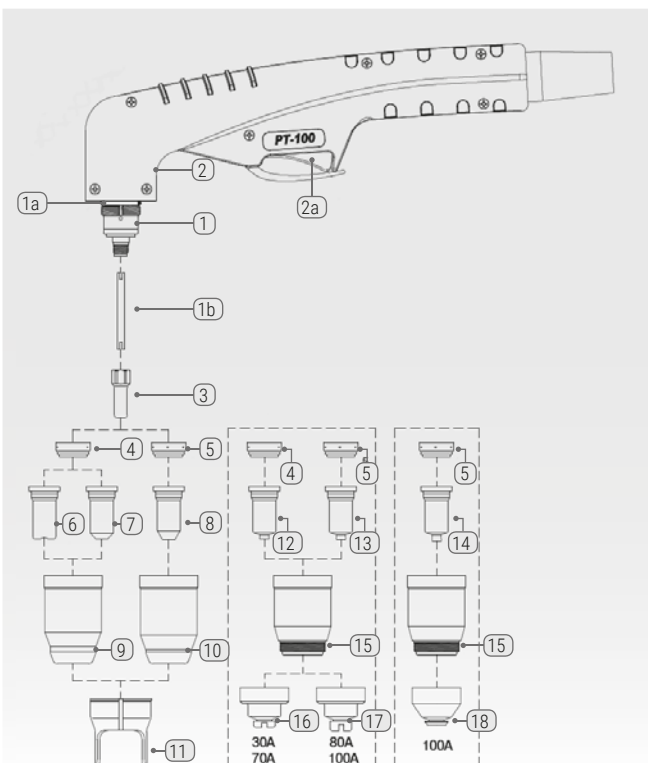


**Plasma Torch PT-80  
(FANCUT 70/71 MOST)**



No.	Spare parts	Catalogue No.
	Plasma torch PT-80 6 m Z0133AA	59 25 000010
1.	Torch Tip PT-80 Z0043AA	59 25 000015
1a	O-ring 15x1.5 PT-80 Z0044AA	59 25 000016
1b	Cooling tube PT-80 Z0045AA	59 25 000017
2.	Handle PT-80/100 Z0046AA	59 25 000018
2a	Trigger PT-80/100 Z0222AA	59 25 000019
3.	Electrode PT-80 Z0048AA	59 25 000020
4.	Swirl ring (Diffuser) PT-80 Z0049AA	59 25 000021
5.	PT-80 contact cutting nozzle 0,9 (30-40 A) Z0050AA	59 25 000022
6.	Nozzle PT-80 1.0 (40-50 A) Z0051A Nozzle PT-80 1.2 (60-70 A) Z0053AA	59 25 000023 59 25 000024
7.	Shield PT-80 Z0055AA	59 25 000025
8.	Double pointed spacer PT-80 Z0056AA	59 25 000026
9.	Nozzle PT-80 contact 1,0 (40-50 A) Z0145AA Nozzle PT-80 contact 1,2 (60-70 A) Z0147AA	59 25 000027 59 25 000028
11.	PT-80 contact cover Z0089AA	59 25 000029
12.	Contact Tip (Guide) PT-80/100 (40-70 A) Z0140AA Circular PT-80 Compass Z0134AA	59 25 000030 59 25 000102

**Plasma Torch PT-100  
(FANCUT 100/101 MOST)**



No.	Spare parts	Catalogue No.
	Plasma torch PT-100 6 m Z0042AA	59 25 000070
1.	Torch Tip PT-100 Z0057AA	59 25 000075
1a	O-ring 18x1.5 PT-100 Z0058AA	59 25 000076
1b	Cooling tube PT-100 Z0059AA	59 25 000077
2.	Handle PT-80/100 Z0046AA	59 25 000018
2a.	Trigger PT-80/100 Z0222AA	59 25 000019
3.	Electrode PT-100 Z0060AA	59 25 000078
4.	Swirl ring (Diffuser)PT-100 (30-70 A) Z0061AA	59 25 000079
5.	Swirl ring (Diffuser) PT-100 (80-120 A) Z0062AA	59 25 000080
6.	PT-100 contact cutting nozzle 0,9 (30-40 A) Z0063AA	59 25 000081
7.	Nozzle PT-100 1,0 (40-50 A) Z0064AA Nozzle PT-100 1,2 (60-70 A) Z0066AA	59 25 000082 59 25 000083
8.	Nozzle PT-100 1.5 (100-110 A) Z0068AA	59 25 000093
9.	Shield cap PT-100 (30-70 A) Z0070AA	59 25 000085
10.	Shield cap PT-100 (80-120 A) Z0071AA	59 25 000086
11.	Double pointed spacer PT-100 Z0072AA	59 25 000087
12.	Nozzle PT-100 contact 1,0 (40-50 A) Z0093AA	59 25 000088
12.1	Nozzle PT-100 contact 1,2 (60-70 A) Z0094AA	59 25 000095
13.	PT-100 contact nozzle 1,5 (100-110 A) Z0095AA	59 25 000089
14.	Nozzle for gouging PT-100 2,2 (100-120 A) ZZ0092AA	59 25 000090
15.	Shield cup body PT-100 Z0096AA	59 25 000091
16.	Contact tip PT-80/100 (30-70 A) Z0140AA	59 25 000030
17.	PT-100 contact Tip -Guide (80-120 A) ZZ0097AA	59 25 000092
18.	Shield cap T-100 for PT-80-100 (40-70 A) ZZ0090AA	59 25 000032
	Circular PT-100 Compass Z0143AA	59 25 000104

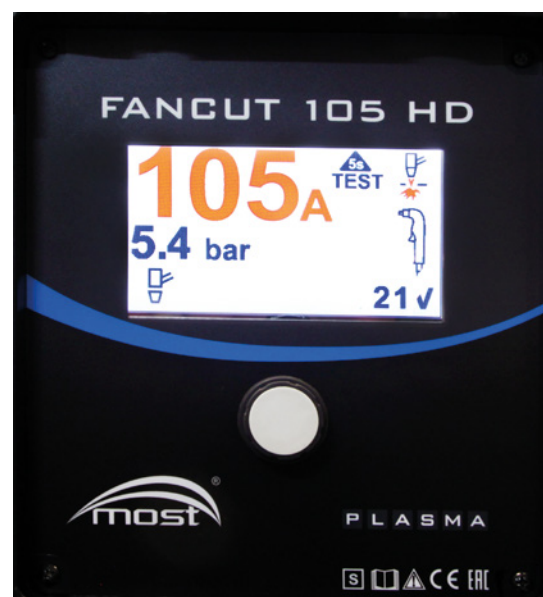


## Plasma cutting machine FANCUT 105 HD MOST

The FANCUT 105 HD is designed for quality cutting of metals with a thickness up to 45 mm using air plasma. Control of the process is performed from a modern panel with liquid crystal display. Apart from regulation of the current the cutting mode (continuous cutting, net cutting or gouging) and the working air pressure can be set. It is also possible to adjust the brightness of the display, select the pressure unit and provide information on the current operating status of the device. The operating pressure is regulated by a built-in proportional valve, which minimizes the impact of input pressure fluctuations. The „fan on demand” function runs the fan only when needed, which saves electricity and reduces dust contamination inside the cutting machine. In standby mode, the FANCUT 105 HD consumes only 25 watts.

**NEW**  
in offer

Model	FANCUT 105 HD
Power supply	3x400 / 50-60 V/Hz
Network fuse	32 (40) A*
Max. current $I_1$	36,7 A
Max. effective current $I_{1eff}$	31,9 (36,7) A*
Cos factor	0,76
Cutting current range	20 A/88 V - 105 A/160 V
Idle voltage $U_0$	320 V
Idle power consumption	25 W
Efficiency	87%
Cutting current (duty cycle 100%) $I_2$	95 A (105) / 150 V (160)*
Cutting current (duty cycle 60%) $I_2$	105 A / 160 V
Maximum cutting thickness of carbon steel	50 mm
Qualitative maximum cutting thickness	Carbon steel - 45 mm Stainless steel - 40 mm Aluminium - 30 mm Copper - 25 mm
Inlet air pressure	6,5 - 8,5 bar
Max. air pressure	8,5 bar
Air consumption	240 l/min
Operating pressure (shown on the display)	5,0 - 5,5 (recommended 5,4) bar
Arc striking	Pneumatic-contact
Noise emission	80-85 dB (A)
Current adjustment	Stepless
Insulation class	F
Protection class	IP 23S
EMC interference level according to EN 60974-10	Class A
Dimensions (w x l x h) without circular base	377x802x621 mm
Current source weight	46,7 kg

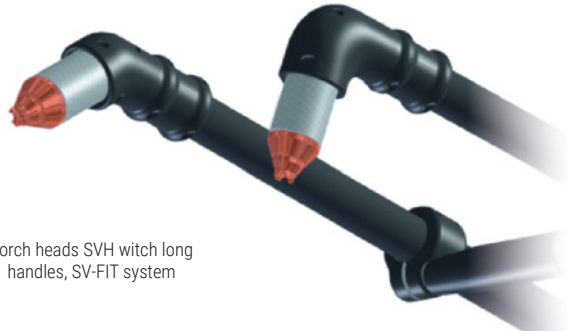


\*Values in brackets refer to 40 A circuit protection. Basic values for 32 A protection. The machine is supplied with a 32 A CEE plug. To obtain a cutting current of 105 A in a 100% duty cycle, it is recommended to connect the device to a 40 A protected power supply via a 63 A plug. The plug should only be replaced by an authorized person.



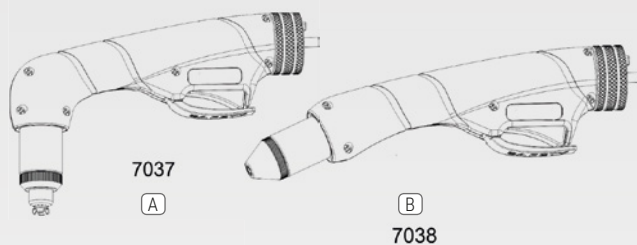
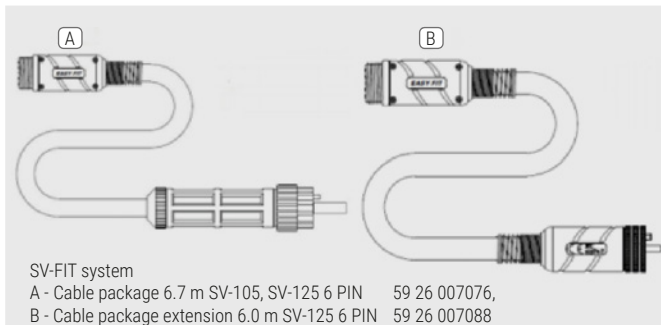
## Plasma Torch SVH-105 (FANCUT 105 HD MOST)

The FANCUT 105 HD is equipped with a plasma cutting torch SVH-105, which is a modern plasma cutting torch with pneumatic-contact ignition (without HF). The cable of the torch is completed on both sides with connectors, which allow for a quick change of torch or attaching an extension cable. Cutting is done exclusively by guiding the nozzle tip along the material, there is no need for spacers.

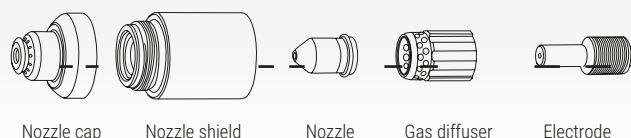


Torch heads SVH with long handles, SV-FIT system

The SV-FIT system allows an easy change of torch - see table opposite for available versions. With the extension cable (59 26 007088), the handle length can be extended from the standard 6,7 m to 12,7 m (extension cables longer than 16 m available on request) - see table.



A - Plasma torch head manual SVH-105 75° 59 26 007037  
 B - Plasma torch head manual SVH-105 15° 59 26 007038



Nozzle cap Nozzle shield Nozzle Gas diffuser Electrode



### Available accessories:

Name	Catalogue No.
Extension cable 6.0 m SV-105, SV-125 6 PIN	59 26 007088
WSF-2 silicone lubricant, gross 6 g	59 26 007101
Torch head SVH-105 15° angle	59 26 007038
Torch head SVH-105 length 80 cm angle 90°	59 26 007094
Torch head SVH-105 length 130 cm angle 90°	59 26 007095
Torch head SVH-105 80 cm long 15° angle	59 26 007096
Torch head SVH-105 length 130 cm angle 15°	59 26 007097
Bevel Tolls set PT 40, 60, SCP 60, TH-70,125	59 26 005872
Bevel circular set SVH-105,125	59 26 007175
Filter set AT 1000	59 00 240036
Paper cartridge AT-100	59 00 240037
Filter adapter AT-1000 (inlet/outlet fittings)	59 00 240038

### Torch parts:

Spare parts	Manufacturer's code	Catalogue No.
Plasma torch manual SVH-105 75°	7037	59 26 007037
Plasma torch manual SVH-105 15°	7038	59 26 007038
Cable package 6.7 m SV-105, SV-125 6 PIN	7076	59 26 007076
Cable package 9.0 m SV-105, SV-125 6 PIN	7103	59 26 007103
Cable package extension 6.0 m SV-125 6 PIN	7088	59 26 007088
Starter parts kit for SVH-105	7112	59 26 007112
O-Ring (pack of 2)	5790	59 26 005790
Electrode 20-105 A (pack of 10)	5830	59 26 005830
Gas diffuser 20-70 A (2 pack) eco	5936	59 26 005936
Gas diffuser 85-105 A (2 pack) eco	6998	59 26 006998
Nozzle 20-50 A (pack of 10)	5832	59 26 005832
Nozzle 60-70 A (pack of 10)	5937	59 26 005937
Nozzle 80-90 A (pack of 10)	7000	59 26 007000
Nozzle 95-105 A (pack of 10)	7001	59 26 007001
Nozzle shield 20-70 A eco	7070	59 26 007070
Nozzle shield 80-105 A eco	7071	59 26 007071
Nozzle cap 20-70 A	7073	59 26 007073
Nozzle cap 85-105 A	7072	59 26 007072
Gouging nozzle 45 A (pack of 10)	7074	59 26 007074
Gouging nozzle 70 A (pack of 10)	7075	59 26 007075
Gouging nozzle 105 A (pack of 10)	7153	59 26 007153
Gouging nozzle cap. 20-105 A	7154	59 26 007154
Extended electrode 20-105 A (pack of 10)	7155	59 26 007155
Extended nozzle 20-50 A (pack of 10)	7156	59 26 007156
Extended nozzle 70 A (pack of 10)	7157	59 26 007157
Extended nozzle 85 A (pack of 10)	7158	59 26 007158
Extended nozzle 105 A (pack of 10)	7159	59 26 007159
Extended nozzle 20-70 A	7107	59 26 007107
Extended nozzle cap 85-105 A	7108	59 26 007108
Bevel Tolls set	5872	59 26 005872
Circular set SVH-105, 12	7175	59 26 007175

## ▼ 5. GAS PRESSURE REGULATORS



03

Pressure regulators from the Brass and Aluminium MOST lines are used to reduce the pressure of the gas contained in the gas cylinder to the working pressure used in cutting, welding, soldering or heating station.

### MOST pressure regulators BRASS Line.

HIT

2 YEARS  
warranty

#### Characteristics:

- Possibility to work with inlet pressure of 200 bar (20 MPa).
- Compliance with EN ISO 2503.
- Cut-off valve as standard.
- Body made of brass.
- High quality pressure manometers.
- Easy and precise adjustment of working pressure.
- 2 years warranty.



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<https://www.rywal.eu/f032-3>

BRASS MOST  
OxygenBRASS MOST  
Ar/CO<sub>2</sub>BRASS MOST  
PropaneBRASS MOST  
Acetylene

Catalogue No.	Type of regulator	Type of gas	Max. inlet pressure	Working pressure range	Max flow	Nut thread at inlet	Nut thread at outlet	Hose connector	Characteristics
62 30 750100	Brass MOST	Oxygen	200 bar	0-10 bar	30 m <sup>3</sup> /h	G 3/4	G 1/4	6,3 mm	single-stage
62 30 750200	Brass MOST	Acetylene	25 bar	0-1,5 bar	5 m <sup>3</sup> /h	Yoke	G 3/8LH	8 mm	single-stage
62 30 750400	Brass MOST	Ar/CO <sub>2</sub>	200 bar	0,5-6 bar	0-32 l/min	W 21,8 x 1/14"	G 1/4	6,3 mm	single-stage with a manometric gas flow indicator
62 30 750500	Brass MOST	Propane	15 bar	0-1,5 bar	4 m <sup>3</sup> /h	W 21,8x1/14"	G 3/8LH	8 mm	single-stage



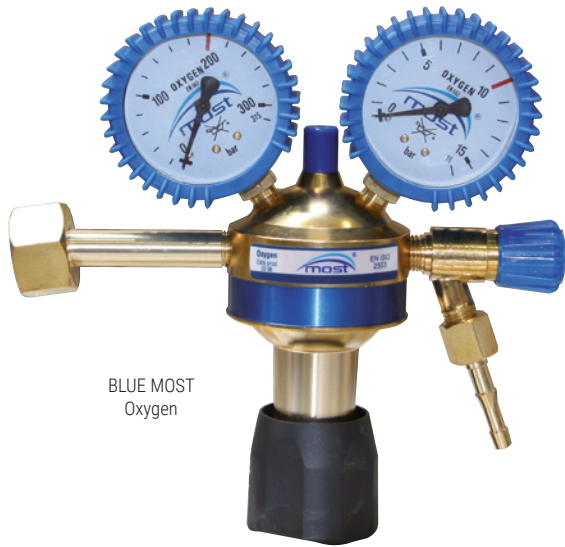


**MOST pressure regulators ALUMINIUM Line**

03

**2 YEARS**  
warranty

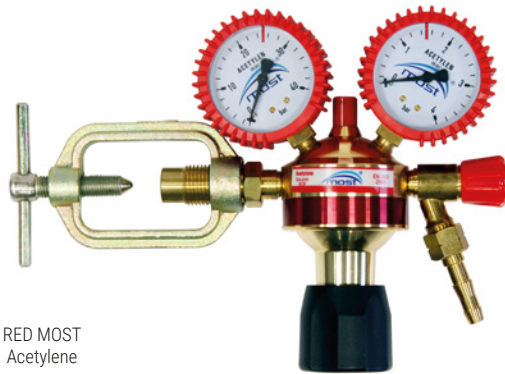
**HIT**



BLUE MOST  
Oxygen

**Characteristics:**

- Possibility to work with inlet pressure of 200 bar (20 MPa).
- Compliance with EN ISO 2503.
- Cut-off valve as standard.
- Body made of aluminium alloys.
- High quality pressure manometers equipped with covers.
- Easy and precise adjustment of working pressure.
- 2 years warranty.



RED MOST  
Acetylene



BLACK MOST  
Ar/CO<sub>2</sub>

Catalogue No.	Type of regulator	Type of gas	Max. inlet pressure	Working pressure range	Max flow	Nut thread at inlet	Nut thread at outlet	Hose connector	Characteristics
62 35 000050	Blue MOST	Oxygen	200 bar	0-10 bar	30 m <sup>3</sup> /h	G 3/4	G 1/4	6,3 mm	single-stage
62 35 000100	Red MOST	Acetylene	25 bar	0-1,5 bar	5 m <sup>3</sup> /h	Yoke	G 3/8LH	8 mm	single-stage
62 35 000150	Black MOST	Ar/CO <sub>2</sub>	200 bar	0,5-6 bar	0-32 l/min	W 21,8 x 1/14"	G 1/4	6,3 mm	single-stage with a manometric gas flow indicator

Always use flashback arrestors with pressure regulators - see page 137.



▼ 6. GAS TORCHES

▼ 6.1. Universal cutting and welding torch



Scan the link or go to <https://www.rywal.eu/f032-4>



Universal torch (for cutting and welding) CutWeld MOST

HIT

03



Characteristics:

- Manual oxygen-acetylene torch with injector gas mixing system.
- Universal set for cutting and gas welding.
- Compact design and lightweight makes it irreplaceable in all manual welding work.
- Welding attachments are equipped with grooved nozzles and cutting oxygen valve with a knob.

Catalogue No.	Torch type	Welding thickness	Cutting thickness	Equipment	Characteristics
60 20 000005	CutWeld - A	0,5-14 mm	3-100 mm	Torch handle 216; 6 welding torch fittings with suitable outlets; cutting nozzles set; cutting attachment; key; set nozzle cleaners; gasket set, cutting trolley; circle cutting attachment	Acetylene- oxygen torch with grooved nozzles

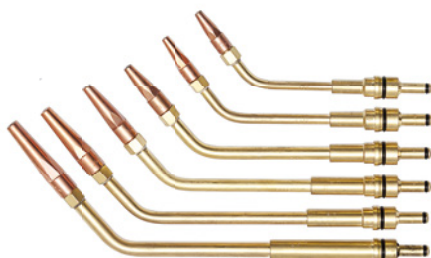
CutWeld MOST torch accessories



CutWeld cutting attachment		
Catalogue No.	Type	Characteristics
61 40 000030	CutWeld	Cutting attachment CutWeld-A



CutWeld universal handle		
Catalogue No.	Type	Characteristics
61 40 000025	CutWeld	Handle for CutWeld Torch



Welding torch fittings with CutWeld torch outlet				
Catalogue No.	Type	Nozzle no.	Cutting range	Characteristics
61 40 000041	Cut-A	1A	0,5-1 mm	for CutWeld Torch
61 40 000042	Cut-A	2A	1-2 mm	
61 40 000043	Cut-A	3A	2-4 mm	
61 40 000044	Cut-A	4A	4-6 mm	
61 40 000045	Cut-A	5A	6-9 mm	
61 40 000046	Cut-A	6A	9-14 mm	



Cut-A heating nozzles				
Catalogue No.	Nozzle type	Nozzle no.	Cutting range	Characteristics
61 40 000009	Cut-A	1A	3-100 mm	for CutWeld torch

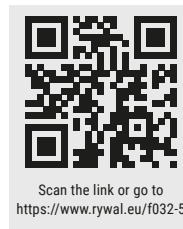


Cut-A cutting nozzles				
Catalogue No.	Nozzle type	Nozzle no.	Cutting range	Characteristics
61 40 000001	Cut-A	1A	3 - 8 mm	for CutWeld torch
61 40 000002	Cut-A	2A	5 - 15 mm	
61 40 000003	Cut-A	3A	15 - 30 mm	
61 40 000004	Cut-A	4A	30 - 60 mm	
61 40 000005	Cut-A	5A	60 - 100 mm	

▼ 6.2. Cutting torches



Cutting torch CUT A/P MOST bended



**Characteristics:**

- Manual oxygen-acetylene (CUT-A) or oxygen-propane (CUT-P) cutting torch with injector gas mixing system.
- Torch equipped with grooved nozzles, allows to increase cutting speed with quality improvement at the same time.
- Advantage of the torch is low consumption of technical gases.

Catalogue No.	Name	Cutting range	Weight
60 20 000011	Torch CUT A MOST – Acetylene	3-300 mm	1,2 kg
60 20 000021	Torch CUT P MOST – Propane	3-300 mm	1,2 kg
<b>Equipment:</b> set of nozzles up to 100 mm, set of tips. Cardboard packaging.			



Cutting nozzles



Heating nozzles

Type of gas	Cutting thickness range								
	Cutting nozzles							Heating nozzles	
	3-8 mm	5-15 mm	15-30 mm	30-60 mm	60-100 mm	100-200 mm	200-300 mm	3-100 mm	100-300 mm
Acetylene (Cut-A)	61 40 00001	61 40 00002	61 40 00003	61 40 00004	61 40 00005	61 40 00006	61 40 00007	61 40 00009	61 40 00010
Propane (Cut-P)	61 40 00011	61 40 00012	61 40 00013	61 40 00014	61 40 00015	61 40 00016	61 40 00017	61 40 00019	61 40 00020

Always use flashback arrestors with cutting torches - see page 137.

## ▼ 7. FLASHBACK ARRESTORS AND COUPLINGS



### Gas flashback arrestors MOST

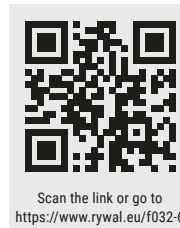
Catalogue No.	Type	Connection	Characteristics
<b>MOST flashback arrestors for torches</b>			Gas flashback arrestors with 3 security levels (gas back, flame back and hose fire)
63 94 001128	MOST - oxygen	G 1/4	
63 94 001118	MOST - fuel gas	G 3/8 LH	
<b>MOST flashback arrestors for regulators</b>			
63 94 001030	MOST - oxygen	G 1/4	
63 94 001130	MOST - fuel gas	G 3/8 LH	

**HIT**



for torch

Flow table MOST flashback arrestors		
Pressure inlet	Acetylene	Oxygen
0,4 bar	2 m <sup>3</sup> /h	-
0,8 bar	7 m <sup>3</sup> /h	-
1,0 bar	8 m <sup>3</sup> /h	-
2,5 bar	-	18 m <sup>3</sup> /h
5 bar	-	27 m <sup>3</sup> /h
7,5 bar	-	32 m <sup>3</sup> /h
10 bar	-	39 m <sup>3</sup> /h



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for regulator

### Gas couplings MOST

Catalogue No.	Type
63 80 000010	Oxygen coupling for torch
63 80 000020	Fuel gas coupling for torch
63 80 000030	Oxygen coupling for regulator
63 80 000040	Fuel gas coupling for regulator

**HIT**



for torch

**NEW**  
in offer

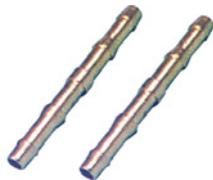


for regulator

▼ 8. ACCESSORIES



Hose nipple



Catalogue No.	Hose inside diameter	Length connector
61 15 803001	4 mm	71 mm
61 15 803002	6,3 mm	
61 15 803003	8 mm	
61 15 803004	10 mm	
61 15 803005	12,5 mm	75 mm
61 15 803006	16 mm	

Gas-tight element under 30 bar pressure

Gas hose - double nipple



Catalogue No.	End of	Nut
61 15 803090	6,3 G 1/4	G 1/4
61 15 803091	6,3 G 1/4	G 1/4 LH
61 15 803092	8 G 3/8	G 3/8
61 15 803093	8 G 3/8	G 3/8 LH
61 15 803094	10 G 1/2	G 1/2
61 15 803095	10 G 1/2	G 1/2 LH
61 15 803096	16 G 3/4	G 3/4
61 15 803097	16 G 3/4	G 3/4 LH

Gas-tight connections and parts under 30 bar pressure

Three connectors



Catalogue No.	Hose inside diameter	Dimensions of the connector
61 15 803041	6,3 mm	82 x 43 mm
61 15 803042	8 mm	82 x 44 mm

Gas-tight joints and parts under 30 bar pressure

Hose connectors



Catalogue No.	Type	Hose diameter
61 16 926120	6,3-G1/4 (for oxygen hose)	6,3 mm
61 16 926130	8-G3/8 (for acetylene hose)	8,0 mm

Hose clamps



Catalogue No.	Type
63 13 000006	10/16 screw
63 13 000008	12/20 screw
63 13 000025	8/16 screw
63 13 000026	12/22 screw

Gas lighter



Catalogue No.	Type
64 81 020099	MARS ignition unit
64 81 010090	MARS Lighter Stones

Gas "Y" manifolds



Catalogue No.	Type of splitter	Thread at inlet	Thread at outlet	Hose connector	Comments
61 15 803080	R-2-2z	G 3/8	G 1/4	6,3 mm	2 valves on outlet
61 15 803081		G 3/8 LH	G 1/4 LH		
61 15 803082		G 3/8	G 3/8	8 mm	
61 15 803083	R-3-z	G 3/8 LH	G 3/8 LH		6,3 mm
61 15 803050	R-3-3z	G 1/4	G 1/4	6,3 mm	3 valves on outlet
61 15 803070		G 3/8	G 1/4		
61 15 803071		G 3/8 LH	G 1/4 LH	8 mm	
61 15 803072		G 3/8	G 3/8		
61 15 803073	G 3/8 LH	G 3/8 LH			

Welding hammer



Catalogue No.	Type
50 00 001700	MST-400

The length of the hammer: 280 mm, Weight: 0,5 kg

Welding mirror



Catalogue No.	Name
60 34 300200	Welding mirror
60 34 300201	Welding mirror insert



### Welding hoses



Catalogue No.	Type	Length
63 70 000065	Oxygen hose 6,3 mm	50 m
63 71 000089	Acetylene hose 9,0 mm	50 m
63 72 000109	Propane hose 10,0 mm	50 m

### Electric gas heater



Technical data		
Nominal outlet pressure	200 bar	
Maximum CO, flow rate	1000 dm <sup>3</sup> /h	
Power supply	24 V AC, 50 Hz	
Plug	SzR 16 P2 NG 5 (with pins)	
Thread at inlet	W 21,8 x 1/14"	
Thread at outlet	W 21,8 x 1/14"	
Weight	0,8 kg	
Catalogue No.	PG-84 without plug	61 18 577450
	PG-84 with plug	61 18 577460

### Nozzle cleaners



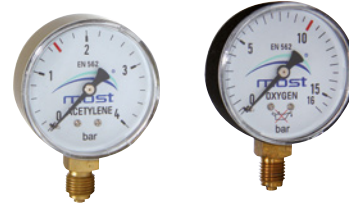
Catalogue No.	Type
61 30 763500	Nozzle cleaning needles

### Gas cylinder trolley



Catalogue No.	Type
65 00 133210	MOST double cylinder trolley
65 00 133219	MOST single cylinder trolley (pneumatic wheels)
65 00 133216	MOST single cylinder trolley (solid wheels)

### Gauge for pressure regulators



Catalogue No.	Type
61 10 000010	MOST for oxygen Ø63 M12x1,5 0-16 bar
61 10 000020	MOST for oxygen Ø63 M12x1,5 0-315 bar
61 10 000030	MOST for acetylene Ø63 M12x1,5 0-4 bar
61 10 000040	MOST for acetylene Ø63 M12x1,5 0-40 bar
61 10 000110	MOST for oxygen Ø63 G1/4 0-16 bar
61 10 000120	MOST for oxygen Ø63 G1/4 0-315 bar
61 10 000130	MOST for acetylene Ø63 G1/4 0-4 bar
61 10 000140	MOST for acetylene Ø63 G1/4 0-40 bar

Perfect MOST manometers.  
High quality design and excellent working properties.

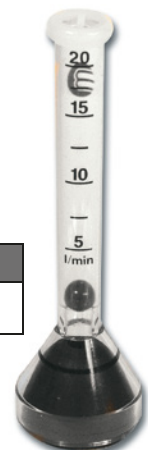
### Rubber gauge covers



Catalogue No.	Type
61 10 899997	MOST BLACK M63
61 10 899998	MOST RED M63 (acetylene)
61 10 899999	MOST BLUE M63 (oxygen)
60 31 000120	MOST double - black cover

Effective rubber covers for pressure manometers.  
They perfectly protect the manometers from mechanical damages.  
Due to special construction they do not cover the safety flaps at the back of the manometers.

### Flow-meter



Catalogue No.	Type
60 31 100080	For testing the gas flow in torches (MIG-MAG type)



# 04



# PERSONAL PROTECTIVE EQUIPMENT

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## ▼ 1. PROTECTIVE CLOTHING

### PROTECTIVE CLOTHING - STANDARDS

**EN ISO 13688** - Protective clothing - General requirements

**EN 11611** - Protective clothing for use in welding and allied processes

**EN 11612** - Protective clothing - Clothing to protect against heat and flame - Minimum performance requirements

### PROTECTIVE CLOTHING - SIZES

MOST leather clothing - size guide			
Symbol	Height [cm]	Chest size [cm]	Waist size [cm]
S	164-170	96-100	84-88
M	170-176	100-104	88-92
L	176-182	104-108	96-100
XL	182-188	108-112	100-104
XXL	188-194	112-116	104-108

UNAL-3 & QUENCH MOST - size guide			
Size	Height [cm]	Chest size [cm]	Waist size [cm]
40	164	80	72
42	164	84	76
44	170	88	80
46	170	92	84
48	176	96	88
50	176	100	92
52	182	104	96
54	182	108	100
56	188	112	104
58	188	116	108
60	194	120	112

MOST SPARK, EXPERT - size guide					
Size	Height [cm]	Chest size [cm]	Jacket max circut size [cm]	Waist size [cm]	Max waist size - dungarees [cm]
S1	164 -170	96-104	134	84-92	106
S2		104-112	140	92-100	114
M1	170-176	96-104	134	84-92	106
M2		104-112	140	92-100	114
M3		112-120	146	100-108	122
L1	176-182	96-104	134	84-92	106
L2		104-112	140	92-100	114
L3		112-120	146	100-108	122
L4		120-128	152	108-116	130
Lmax*		128-136	158	116-124	138
XL1	182-188	96-104	134	84-92	106
XL2		104-112	140	92-100	114
XL3		112-120	146	100-108	122
XXL1	188-194	96-104	134	84-92	106
XXL2		104-112	140	92-100	114
XXL3		112-120	146	100-108	122
XXL4		120-128	152	108-116	130
XXLmax*		128-136	158	116-124	138
XXXL2	194-200	104-112	140	92-100	114
XXXL3		112-120	146	100-108	122

\* extra charge for larger size

The data presented in the size tables are only an approximate guide and are provided to help you choose the right size. If the real size is between two different presented in tables sizes, a larger size should always be chosen, as PPE should always provide maximum comfort of user.

▼ 1.1. Flame-resistant clothing



**HARD flammable clothing MOST QUENCH**

**Material:** 100% flame resistant cotton with satin weave, 380 g/m<sup>2</sup>.

**Sizes:** according to the size guide on page 142.

**Colour:** gray-blue.

- Special flame resistant sewing threads.
- Reflective strips at the front and back side.
- Snap fastenings.
- Internal pockets.
- Two jackets designs: QUENCH 311 (longer- apron), QUENCH 511 (shorter- jacket).
- Two trousers designs: QUENCH 6 (jeans types), QUENCH 611 (straight, with additional pocket on the right side).
- Personal marking with logo-type available.

HIT

04

QUENCH 311  
Catalogue No.:  
77 07 0014xx



QUENCH 511  
Catalogue No.:  
77 07 0014xx



QUENCH 611  
Catalogue No.:  
77 07 0014xx



QUENCH 6  
Catalogue No.:  
77 07 0014xx



Option with short jacket

Special flame resistant threads



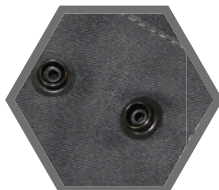
Reflective strips



Personal logo-type available



Snap fastennings







## HARD flammable clothing for welders - MOST UNAL 3

**Material:** 100% flame resistant cotton with satin weave, 380 g/m<sup>2</sup>.

**Sizes:** according to the size guide on page 142.

**Colour:** graphite-blue.

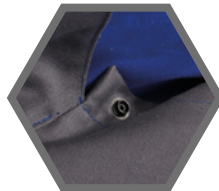
- Special flame resistant sewing threads.
- Snap fastennings.
- Internal pockets.
- Set: dungarees + jacket.
- Personal marking with logo-type available.



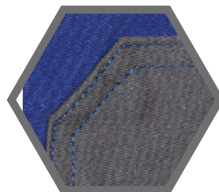
UNAL 3 - set  
Catalogue No.: 77 07 001xxx



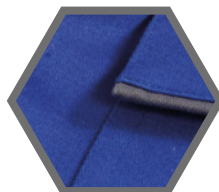
Snap fastennings



Special flame resistant threads



Material: 380 g/m<sup>2</sup> flame resistant cotton with satin weave







## HARD flammable clothing for welders MOST SPARK

**Material:** 100% flame resistant cotton, 310 g/m<sup>2</sup>.

**Sizes:** according to the size guide on page 142.

**Colour:** navy-blue.

- Special flame resistant sewing threads.
- Snap fastenings, covered buttons.
- Internal pockets.
- Set: dungarees + jacet.
- Personal marking with logo-type available.



SPARK - set

**Catalogue No.:** 77 09 0000xx



Personal logo- type available



Snap fastenings



Flame resistant threads



▼ 1.2. Leather clothing



Leather clothing MOST

**Material:** 100% flame resistant cotton, 285 g/m<sup>2</sup> + cow split leather.

**Sizes:** according to the size guide on page 142.

**Colour:** navy-blue (cotton), brown (leather).

- Snap fastenings.
- Internal pockets.
- Set: dungarees + jacket.



Leather clothing - set  
Catalogue No.: 74 10 0005xx



Made of leather and cotton



Snap fastenings



High collar





### ▼ 1.3. General purpose clothing



#### Protective clothing MOST EXPERT

**Material:** 65% polyester, 35% cotton with 250 g/m<sup>2</sup> weight.

**Sizes:** according to the size guide on page 142.

**Colour:** gray-blue.

- Zip fastening.
- Knee reinforcements with additional pads.
- Set: dungarees + jacket.
- Personal marking with logo-type available.



EXPERT- set

Catalogue No.: 77 09 1000xx



Zip fastening



Knee reinforcement



Large pockets



## ▼ 2. FACE AND EYE PROTECTION

### EYE PROTECTION - STANDARDS

- EN 166** - Personal eye protection standards.
- EN 169** - Personal eye protection - Filters for welding and related techniques.
- EN 170** - Personal eye protection - Ultraviolet filters - Transmittance requirements and recommended use.
- EN 171** - Personal eye protection - Infrared filters - Transmittance requirements and recommended use.
- EN 172** - Personal eye protection - Sunglare filters for industrial use.
- EN 175** - Personal protection. Equipment for eye and face protection during welding and allied processes.
- EN 379** - Personal eye protection. Automatic welding filters.

Breakdown of optical classes to EN 379:

- 1 / 1 / 1 / 1** - Optical class - accuracy of vision.
- 1 / 1 / 1 / 1** - Diffusion of light class.
- 1 / 1 / 1 / 1** - Variations in luminous transmittance class (light or dark areas within the lens).
- 1 / 1 / 1 / 1** - Angle dependence on luminous transmittance class.

Range from 1 to 3:

- 1 - the best class,
- 3 - the worst class.

### ▼ 2.1. Welding helmets



#### Welding helmet MOST PYXAR FLIP-UP AIR with the MOST PX-FLOW powered airflow purifying system



MOST PYXAR FLIP-UP AIR with PX-FLOW

- MOST PX-FLOW powered airflow system suitable for MOST PYXAR AIR welding helmets.
- Ergonomic shape of the drive unit.
- FLIP-UP version: lifting cartridge with auto darkening welding filter and big grind visor.
- Universal application - filtration of dust, gases, vapours and welding fumes.
- Operating time up to 10 hours at minimum speed, with new filter and standard battery or up to 12 hours with a full heavy duty battery.
- Adjustable airflow (180 l/min - 220 l/min).
- Electronic constant airflow system.
- Electronic audio-visual and vibration alarm in case of low battery and/or low air flow.
- Convenient and functional control panel with colorful LEDs.
- Filter types: P R SL or ABE1 P R SL.

**Catalogue No.:**

72 00 921159 MOST PYXAR FLIP-UP with PX-FLOW system, complete with bag.

#### Welding helmet MOST PYXAR AIR with the MOST PX-FLOW powered airflow purifying system



MOST PYXAR AIR with PX-FLOW

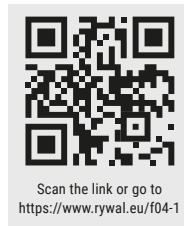
- MOST PX-FLOW powered airflow system suitable for MOST PYXAR AIR welding helmets.
- Ergonomic shape of the drive unit.
- Universal application - filtration of dust, gases, vapours and welding fumes.
- Operating time up to 10 hours at minimum speed, with new filter and standard battery or up to 12 hours with a full heavy duty battery.
- Adjustable airflow (180 l/min - 220 l/min).
- Electronic constant airflow system.
- Electronic audio-visual and vibration alarm in case of low battery and/or low air flow.
- Convenient and functional control panel with colorful LEDs.
- Filter types: P R SL or ABE1 P R SL.

**Catalogue No.:**

72 00 921119 MOST PYXAR AIR with PX-FLOW system, complete with bag.



## Welding helmet MOST PYXAR



- Optical classes acc. to EN 379: 1/1/1/1.
- Viewing area: 98 x 62 mm.
- Number of arc detection sensors: 4.
- Degree of darkening "light": 3.
- Degree of darkening "dark": 5-9 and 10-14.
- Continuously adjustable filter sensitivity.
- Smoothly adjustable filter lightening delay.
- Solar cells and replaceable batteries.
- "Grind" function - external button.
- Scratch-resistant front cover lens made of thermoformed polycarbonate.
- Digital display.
- Warranty: 2 years.
- Suitable for the MOST PX-FLOW forced air flow system.

### Catalogue No.:

72 00 921100 MOST PYXAR

**NEW**  
in offer

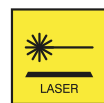


MOST PYXAR

## Welding helmet MOST PYXAR with YAG laser protection filter

- Optical classes acc. to EN 379: 1/1/1/1.
- Viewing area: 98 x 62 mm.
- Number of arc detection sensors: 4.
- Degree of darkening "light": 3.
- Degree of darkening "dark": 5-9 and 10-14.
- Continuously adjustable filter sensitivity.
- Smoothly adjustable filter lightening delay.
- Solar cells and replaceable batteries.
- "Grind" function - external button.
- Scratch-resistant front cover lens made of thermoformed polycarbonate.
- Digital display.
- Warranty: 2 years.
- Suitable for the MOST PX-FLOW forced air flow system.
- Manual laser welding - protection classes in accordance with EN 207:2017:
  - 900-1000 nm DIR LB5
  - 1000-1030 nm DIR LB7 + M LB7Y
  - 1030-1400 nm D LB7 + IR LB8 + M LB8Y
  - 1400-2500 nm DIR LB5
  - 2500-2800 nm DIR LB4
  - 2800-9000 nm DIR LB5
  - 9000-11500 nm DI LB5

**NEW**  
in offer



MOST PYXAR  
with YAG laser protection filter

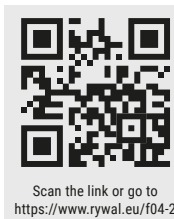
### Catalogue No.:

72 00 921500 MOST PYXAR with YAG laser protective filter





## Welding helmet MOST WELD RAPTOR AIR with the MOST R-FLOW powered airflow purifying system



MOST WELD RAPTOR AIR techno blue with R-FLOW

- MOST R-FLOW powered airflow system suitable for MOST WELD RAPTOR AIR welding helmet.
- Ergonomic shape.
- Flat profile.
- Universal application - filtration of dust, gases, vapours and welding fumes.
- Operating time up to 9 hours at minimum speed, with new filter and standard battery or up to 15 hours with a full heavy duty battery.
- Adjustable airflow (170 l/min - 210 l/min).
- Electronic constant airflow system.
- Electronic audio-visual and vibration alarm in case of low battery and/or low air flow.
- Simple regulation with only one button.
- Filter types: P R SL or ABEK1.

**Catalogue No.:**

72 00 912199 MOST WELD RAPTOR AIR techno blue with R- FLOW system, complete with bag.

## Welding Helmet MOST WELD RAPTOR



MOST WELD RAPTOR techno blue

- Optical classes acc. to EN 379: 1/1/1/1.
- Viewing area: 107 x 75 mm.
- Number of arc detection sensors: 4.
- Degree of darkening "light": 4.
- Degree of darkening "dark": 5-8 and 9-13.
- Continuously adjustable filter sensitivity.
- Smoothly adjustable filter lightening delay.
- Solar cells and replaceable batteries.
- "Grind" function.
- "Test" function.
- Opening automatic filter unit - large viewfinder.
- Side protection glass with shade 5.
- Digital display.
- Warranty: 2 years.
- Suitable for the MOST R-FLOW forced air flow system.

**Catalogue No.:**

72 00 912020 MOST WELD RAPTOR techno blue

Cleaning and maintenance spray for welding masks CLINO M MOST - see chapter 06



Scan the link or go to  
<https://www.rywal.eu/f04-3>

## Welding helmet MOST V1000 AIR with the MOST V-FLOW powered airflow purifying system

- MOST V-FLOW system suitable for MOST V1000 AIR welding helmet.
- Universal application - dust, gases, vapours and welding fumes.
- Operating time up to 10 hours at minimum speed, with standard battery and new filter or up to 15 hours with a full heavy duty battery.
- Adjustable air flow (180 l/min - 220 l/min).
- Electronic constant air flow system.
- Electronic audio- visual and vibration alarm in case of low battery and/or low air flow.
- Easily replaceable particulate filter P R SL.
- Transport bag included.

### Catalogue No.:

72 00 911199 MOST V1000 AIR - helmet with system V-FLOW, complete with bag



MOST V1000 AIR  
 with V-FLOW

## Welding helmet MOST V1000

- Optical classes acc.to EN 379: 1/1/1/2.
- Viewing area: 98 x 53 mm.
- Number of arc detection sensors: 4.
- Degree of darkening "light":4.
- Degree of darkening "dark": 5-9 and 9-13.
- Continuously adjustable filter sensitivity.
- Smoothly adjustable filter lightening delay.
- Solar cells and replaceable batteries.
- "Grind" function - external button.
- "Test" function.
- "True colour" technology.
- Digital display.
- Warranty: 2 years.
- Suitable for the MOST V-FLOW forced air flow system.

### Catalogue No.:

72 00 911000 MOST V1000



MOST V1000

Cleaning and maintenance spray for welding masks CLINO M MOST - see chapter 06



## Welding helmet MOST SPECTRA

HIT



MOST SPECTRA blue



MOST SPECTRA black



MOST SPECTRA terminator

- Optical classes acc.to EN 379: 1/1/1/1.
- Viewing area: 100 x 65 mm.
- Number of arc detection sensors: 4.
- Degree of darkening "light": 4.
- Degree of darkening "dark": 5-9 and 9-13.
- Continuously adjustable filter sensitivity.
- Smoothly adjustable filter lightening delay.
- Solar cells and replaceable batteries.
- "Grind" function.
- "Test" function.
- Warranty: 2 years.

**Catalogue No.:**

- 72 00 982301 MOST SPECTRA black
- 72 00 982302 MOST SPECTRA blue
- 72 00 982303 MOST SPECTRA terminator

## Welding helmet S777

HIT



S777 black

- Optical classes to EN 379: 1/1/1/2.
- Viewing area: 98 x 43 mm.
- Number of arc detection sensors: 2.
- Degree of darkening "light": 4.
- Degree of darkening "dark": 9-13.
- Continuously adjustable filter sensitivity.
- 3-step adjustment of the delay in brightening
- Solar cells - no replaceable batteries.
- "Grind" function.
- Warranty: 1 year.

**Catalogue No.:**

- 72 00 982000 S777 blue
- 72 00 982001 S777 black
- 72 00 982002 S777 eagle
- 72 00 982003 S777 fire
- 72 00 982004 S777 alien



S777 blue



S777 eagle



S777 fire



S777 alien

## ▼ 2.2. Laser safety glasses



### Laser safety glasses T5S3

T5S3 laser safety glasses provide protection for the 200-405 nm and 980-1100 nm wavelength ranges. They are used for eye protection when working with 1064 nm YAG lasers and 1070 nm, 1080 nm and 1100 nm fiber lasers.

#### Characteristics:

- they are CE certified for compliance with the European standard: EN207: 2017,
- protection for typical wavelengths: 1064 nm, 1070 nm, 1080 nm, 1100 nm,
- VLT visible light transmittance: 28%.

#### Application area:

- for laser processing equipment,
- for YAG laser 1064 nm,
- for fiber laser 1070 nm, 1080 nm, 1100 nm.

Wavelength	Range of protection
200-315 nm	DIR LB4
316-405 nm	DIR LB4
980-1100 nm	DIR LB5



#### The set includes:

T5S3 laser safety glasses, glasses cord, a cloth for removing dirt from the lens, protective case for eyeglasses.

#### Catalogue No.

77 37 000100 - T5S3 laser safety glasses (set with case, cord and cloth)

## ▼ 2.3. Welding safety glasses



### Safety glasses MOST 516

- Profiled model for optimum lateral protection.
- Anatomical, soft rubber nose.
- Colourful temples made of anti-allergic rubber.
- Scratch-resistant coating.

#### Catalogue No.:

77 35 916110 MOST 516, clear lens  
77 35 516102 516.01.10.02, grey lens



### Safety glasses MOST 568

- Light and very handy, made entirely of polycarbonate.
- Weight only 23 g.
- Different coatings and lenses.
- Scratch-resistant and fog-resistant coating.
- UV protection 400 (yellow lens).

#### Catalogue No.:

77 35 968200 MOST 568, clear lens  
77 35 568202 568.02.01.02, grey lens  
77 35 568103 568.01.03.03, yellow lens





## Welding protection glasses 0036



- Metal flip up lens with a 5 DIN shade filter.
- Flexible headband.
- Interchangeable passive filters Ø50 mm from 4 to 13 DIN can be used.

**Catalogue No.:**  
72 30 010048 0036 welding goggles

### ▼ 2.4. Face shields and filters



## Anti-Spatter shields OT-1N, OT-1,5N, OT-1



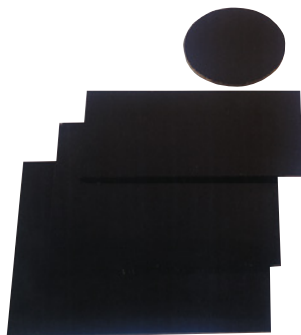
OT-1N, OT-1,5N

OT-1

- Head unit with additional front reinforcement.
- Infinitely variable adjustment of the cover angle.
- Headband adjustment.
- Replaceable polycarbonate front covers.
- Cover thickness: 1 mm (OT-1N, OT-1) and 1.5 mm (OT-1.5N).

**Catalogue No.:**  
72 01 040030 OT-1N  
72 01 040032 OT-1,5N  
72 01 040031 changeable cover 1 mm for OT-1N  
72 01 040033 changeable cover 1.5 mm to OT-1.5N  
72 01 040000 OT-1  
72 01 040001 changable cover for OT-1

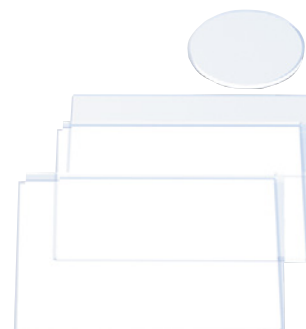
## MOST fixed - shade welding filters



- Thickness: 3 mm.
- Round-shaped with a diameter of 50 mm.
- Rectangular size: 100 x 50 mm, 100 x 80 mm, 110 x 90 mm.
- Shade levels: 4 to 13 DIN.

**Catalogue No.:**  
73 00 05xxxx Passive welding filters MOST Ø50 mm  
73 00 50xxxx Passive welding filters MOST 100 x 50 mm  
73 00 80xxxx Passive welding filters MOST 100 x 80 mm  
73 00 90xxxx Passive welding filters MOST 110 x 90 mm

## Colorless protective glasses MOST



- Glasses available as:
- round-shaped, diameter 50 mm,
  - rectangle-shaped, : 20x100 mm, 50x100 mm, 80x100 mm, 90x110 mm.

**Catalogue no.**  
72 50 xxxxxx

### ▼ 3. HANDS PROTECTION

#### HAND PROTECTION - STANDARDS:

**EN 420** – Protective gloves - standard requirements.

**EN 388** – Protective gloves against mechanical risks:

- (a) Abrasion resistance (0 to 4),
- (b) Blade cut resistance (0 to 4),
- (c) Tear resistance (0 to 4),
- (d) Puncture resistance (0 to 4),
- (e) Cut resistance (A to F),
- (f) Impact test (P).

**EN 407** – Protective gloves against thermal risks (Heat and/or fire):

- (a) Protection from ignition (1 to 4),
- (b) Protection from contact heat: (1 to 4),
- (c) Protection from convective heat (1 to 4)
- (d) Protection from radiant heat (1 to 4),
- (e) Protection from small splashes of molten metal (1 to 4),
- (f) Protection from large quantities of molten metal (1 to 4).

**EN 12477** – Protective gloves for welders.

**Type A** refers to gloves with higher protection against heat but with lower flexibility and dexterity. Designed for all welding methods, in particular MIG/MAG and MMA welding.

**Type B** refers to gloves with lower protection against heat but with greater flexibility and dexterity e.g. TIG welding. The protection requirements for these gloves are met at a lower level.

#### ▼ 3.1. Leather gloves for welding



##### Welding gloves MOST MANTA



- Size: 11.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Additional reinforcements: thumb, palm grip and palm top.
- Completely covered seams.
- Length: 41 cm.
- Packing: 72 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

77 54 031980 Size 11

##### Welding gloves MOST DEEP BLUE



- Size: 10.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Additional reinforcements: thumb, palm grip.
- Completely covered seams.
- Length: 35 cm.
- Packing: 60 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

77 54 031970 Size 10



### Welding gloves MOST JAGUAR



- Sizes: 8, 9, 10.
- Material: cow split leather (palm top) and cowgrain leather- (palm grip).
- Lining: Yes.
- Kevlar threads: Yes.
- Additional reinforcement: no.
- Completely covered seams.
- Length: 35 cm.
- Packing: 72 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

- 77 54 031998 Size 8
- 77 54 031999 Size 9
- 77 54 032000 Size 10

### Welding gloves MOST URAN



- Size: 10, 11.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Additional reinforcements: thumb, palm grip.
- Completely covered seams.
- Length: 35 cm.
- Packing: 72 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

- 77 54 031940 Size 10
- 77 54 031941 Size 11

### Welding gloves MOST GRIZZLY



- Sizes: 10, 11.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Completely covered seams.
- Length: 35 cm.
- Packing: 72 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

- 77 54 032100 Size 10
- 77 54 032101 Size 11

### Welding gloves MOST TIGER



- Size: 10.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Additional reinforcement: thumb base.
- Completely covered seams.
- Length: 35 cm.
- Packing: 60 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**

- 77 54 031960 Size 10



### Leather gloves MOST MARS



- Size: 10.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: No.
- Completely covered seams.
- Length: 35 cm.
- Packing: 60 pairs in carton box / 12 pairs pack.

Standards: EN 420

**Catalogue No.:**  
77 54 031950 Size 10

### Leather gloves MOST LYNX



- Size: 10.
- Material: cow split leather.
- Lining: Yes.
- Kevlar threads: Yes.
- Puller in the top palm.
- Completely covered seams.
- Length: 27 cm.
- Packing: 72 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4133X, EN 407: 423X4X, EN 12477: Type A

**Catalogue No.:**  
77 54 031910 Size 10

### Welding gloves MOST LAMA



- Size: 10.
- Material: goatskin (grip and top palm), cow split leather (cuff).
- Lining: No.
- Kevlar threads: No.
- Length: 35 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X, EN 407: 412X4X, EN 12477: Type B

**Catalogue No.:**  
77 54 031700 Size 10

### Welding gloves MOST HURON



- Size: 10.
- Material: cow split leather.
- Lining: No.
- Kevlar threads: No.
- Length: 35 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2133X, EN 407: 413X4X, EN 12477: Type A

**Catalogue No.:**  
76 10 140110 Size 10





### Welding gloves MOST ALABAMA



HIT

- Size: 10.
- Material: cow split leather (top palm part) and cow grain leather.
- Lining: No.
- Kevlar threads: No.
- Length: 35 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3143X, EN 407: 413X4X, EN 12477: Type A

**Catalogue No.:**  
76 10 140120 Size 10

### Welding gloves MOST ALABAMA KEVLAR



- Size: 10.
- Material: cow split leather (top palm part) and cow grain leather.
- Lining: No.
- Kevlar threads: Yes.
- Length: 35 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3143X, EN 407: 413X4X, EN 12477: Type A

**Catalogue No.:**  
76 10 14122 Size 10

### Welding gloves MOST SUPER TIG



HIT

- Sizes: 8, 9, 10, 11.
- Material: goatskin (grip and top palm), cow split leather (cuff).
- Lining: No.
- Kevlar threads: Yes.
- Length: 35 cm.
- Puller in the top palm part.
- Uncoloured cuff version (SUPER TIG natural).
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X, EN 407: 412X4X, EN 12477: Type B

**Catalogue No.:**  
77 54 0316xx SUPER TIG, sizes 8-11  
77 54 0315xx SUPER TIG natural, sizes 9-11

### Welding gloves SUPER TIG RED MOST



- Sizes: 9, 10, 11.
- Material: goatskin (grip and top palm), cow split leather (cuff).
- Lining: No.
- Kevlar threads: Yes.
- Length: 30 cm.
- Puller in the top palm part.
- Yellow-coloured cuff with RED edging.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X, EN 407: 412X4X, EN 12477: Type B.

**Catalogue No.:**  
77 54 0314XX SUPER TIG RED, sizes 9-11

### ▼ 3.2. General purpose leather gloves



#### MOST GRENADA gloves



HIT

- Sizes: 7, 8, 9, 10, 11.
- Material: cotton reinforced with goatskin
- Lining: No.
- Puller in the dorsal part.
- Cuffed up.
- Length: 23-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X

##### Catalogue No.:

77 55 030007	Size 7
77 55 030008	Size 8
77 55 030009	Size 9
77 55 030010	Size 10
77 55 030011	Size 11

#### MOST MALE gloves



Sizes: 8, 9, 10, 11.

- Material: cotton reinforced red colour with goatskin.
- Lining: No.
- Velcro fastening.
- Cuffed up.
- Length: 23-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 420

##### Catalogue No.:

77 55 031108	Size 8
77 55 031109	Size 9
77 55 031110	Size 10
77 55 031111	Size 11

#### MOST GUYANA gloves



HIT

- Sizes: 8, 9, 10, 11.
- Material: cotton reinforced with goatskin.
- Lining: No.
- Velcro fastening.
- Cuffed up.
- Length: 23-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X

##### Catalogue No.:

77 55 031008	Size 8
77 55 031009	Size 9
77 55 031010	Size 10
77 55 031011	Size 11

#### MOST GUYANA WINTER gloves



- Sizes: 9, 10, 11.
- Material: cotton reinforced with goatskin.
- Black insulated lining in the middle.
- Velcro closure.
- Cuffs to the top.
- Length: 25-27 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2122X, EN 511: X3X

##### Catalogue No.:

77 55 031019	Size 9
77 55 031020	Size 10
77 55 031021	Size 11



### MOST DAKOTA gloves



HIT

- Sizes: 9, 10, 11.
- Material: cow grain leather.
- Lining: No.
- Puller in top palm part.
- Cuffed up.
- Length: 25-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3143X

**Catalogue No.:**

- 77 55 032009 Size 9
- 77 55 032010 Size 10
- 77 55 032011 Size 11

### MOST DAKOTA WINTER gloves



- Sizes: 9, 10, 11.
- Material: cow grain leather
- Black insulated lining in the middle.
- Puller in the top part of the palm.
- Cuffed up.
- Length: 25-27 cm.
- Packing: 120 pairs in a carton / 12 pairs pack.

Standards: EN 388: 3143X, EN 511: X3X

**Catalogue No.:**

- 77 55 032019 Size 9
- 77 55 032020 Size 10
- 77 55 032021 Size 11

### MOST BERMUDA gloves



- Size: 10.
- Material: Cotton reinforced with cow split leather.
- Lining: Yes.
- Rigid, rubberized cuff.
- Length: 26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 420

**Catalogue No.:**

- 77 55 015000 Size 10

### MOST BERMUDA WINTER gloves



- Size: 10.
- Material: Cotton reinforced with cow split leather.
- Lining: Yes / warm lining.
- Rigid, rubberized cuff.
- Length: 26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 420

**Catalogue No.:**

- 77 55 015100 Size 10



### MOST BAHAMA gloves



- Size: 10.
- Material: Cotton reinforced with cow split leather.
- Lining: Yes.
- Rigid, rubberized cuff.
- Length: 26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3122X

**Catalogue No.:**  
77 55 016000 Size 10

### MOST BAHAMA PREMIUM gloves



- Size: 10.
- Material: Cotton reinforced with cow split leather.
- Lining: Yes.
- Rigid, rubberized cuff, double-sided stitching.
- Length: 26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3122X

**Catalogue No.:**  
77 55 016100 Size 10

### MOST TOGO gloves



- Size: 10.
- Material: Cotton reinforced with cow grain leather.
- Lining: Yes.
- Rigid, rubberized cuff.
- double-sided cuff stitching.
- Length: 26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3133X

**Catalogue No.:**  
77 55 020000 Size 10





▼ 3.3. Coated gloves



**MOST YORK gloves**



- Sizes: 9, 10.
- Material: Nitrile-coated cotton.
- SANITIZED™ antibacterial protection.
- Coating area: 3/4.
- Colour: dark blue.
- Cuff: stiff.
- Length: 25-27 cm.
- Packing: 144 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4221B

**Catalogue No.:**

- 77 55 131009 Size 9
- 77 55 131010 Size 10

SANITIZED™ - a special antibacterial protection inside - for comfort, freshness and protection against bacteria and fungi.

**MOST SALAMANCA gloves**



- Sizes: 9, 10, 11.
- Material: Nitrile-coated cotton.
- SANITIZED™ antibacterial protection.
- Coating area: 3/4.
- Colour: yellow.
- Cuff: knitted.
- Length: 25-27 cm.
- Packing: 144 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4111X

**Catalogue No.:**

- 77 55 110009 Size 9
- 77 55 110010 Size 10
- 77 55 110011 Size 11

SANITIZED™ - a special antibacterial protection inside - for comfort, freshness and protection against bacteria and fungi.

**MOST KENT gloves**



- Sizes: 9, 10.
- Material: Nitrile-coated cotton.
- Coating area: full coated
- Colour: dark blue.
- Cuff: stiff.
- Length: 25-27 cm.
- Packing: 144 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4121X

**Catalogue No.:**

- 77 55 120009 Size 9
- 77 55 120010 Size 10

**MOST VIGO gloves**



- Sizes: 9, 10.
- Material: Nitrile-coated cotton.
- Coating area: full coated
- Colour: dark blue.
- Cuff: knitted.
- Length: 25-27 cm.
- Packing: 144 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4121X

**Catalogue No.:**

- 77 55 120109 Size 9
- 77 55 120110 Size 10



### MOST N100 gloves



HIT

- Sizes: 7, 8, 9, 10, 11.
- Material: Nitrile-coated polyester.
- Coating area: fingers and grip palm area.
- Cuff: knitted.
- Length: 22-26 cm.
- Seamless.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4121X

**Catalogue No.:**

- 77 55 303107 Size 7
- 77 55 303108 Size 8
- 77 55 303109 Size 9
- 77 55 303110 Size 10
- 77 55 303111 Size 11

### MOST N200 gloves



HIT

- Sizes: 9, 10, 11.
- Material: Nitrile-coated cotton.
- Coating area: 3/4.
- Colour: yellow.
- Cuff: knitted.
- Length: 25-26 cm.
- Sewn.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 3111X

**Catalogue No.:**

- 77 55 303209 Size 9
- 77 55 303210 Size 10
- 77 55 303211 Size 11

### MOST PU100 gloves



HIT

- Sizes: 7, 8, 9, 10, 11.
- Material: Polyurethane-coated polyester.
- Coating area: fingers and grip palm area.
- Colour: black.
- Cuff: knitted.
- Length: 22-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2121X

**Catalogue No.:**

- 77 55 300107 Size 7
- 77 55 300108 Size 8
- 77 55 300109 Size 9
- 77 55 300110 Size 10
- 77 55 300111 Size 11

### MOST PU200 gloves



- Sizes: 7, 8, 9, 10, 11.
- Material: Polyurethane-coated polyester.
- Coating area: fingers and grip palm area.
- Colour: white.
- Cuff: knitted.
- Length: 22-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2121X

**Catalogue No.:**

- 77 55 300207 Size 7
- 77 55 300208 Size 8
- 77 55 300209 Size 9
- 77 55 300210 Size 10
- 77 55 300211 Size 11



### MOST LX100 gloves



- Sizes: 9, 10, 11.
- Material: Latex-coated cotton.
- Coating area: fingers and grip palm area.
- Colour: Grey.
- Cuff: knitted.
- Length: 24-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.
- Economical version of the LX200 glove.

Standards: EN 420

**Catalogue No.:**

- 77 55 302109 Size 9
- 77 55 302110 Size 10
- 77 55 302111 Size 11

### MOST LX200 gloves



- Sizes: 8, 9, 10, 11.
- Material: Latex-coated cotton.
- Coating area: fingers and grip palm area.
- Colour: green-yellow.
- Cuff: knitted.
- Length: 23-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2121X

**Catalogue No.:**

- 77 55 302208 Size 8
- 77 55 302209 Size 9
- 77 55 302210 Size 10
- 77 55 302211 Size 11

### MOST PX300 gloves



- Sizes: 7, 8, 9, 10, 11.
- Material: Latex-coated polyester.
- Coating area: fingers and grip palm area.
- Colour: black and red.
- Cuff: knitted.
- Length: 22-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 2131X

**Catalogue No.:**

- 77 55 301307 Size 7
- 77 55 301308 Size 8
- 77 55 301309 Size 9
- 77 55 301310 Size 10
- 77 55 301311 Size 11

### MOST ANTI-CUT 5 gloves



- Size : 8, 9, 10, 11.
- Material: anti-cut fibre with admixture of other synthetic fibres.
- Coating area: polyurethane fingers and grip palm area.
- Colour: grey.
- Cuff: elastic, knitted.
- Length: 23-26 cm.
- Packing: 120 pairs in carton box / 12 pairs pack.

Standards: EN 388: 4443C

**Catalogue No.:**

- 77 55 304508 Size 8
- 77 55 304509 Size 9
- 77 55 304510 Size 10
- 77 55 304511 Size 11

## ▼ 4. RESPIRATORY PROTECTION FOR WELDERS



### PASSIVE RESPIRATORY PROTECTION - STANDARDS

**EN 136** - Respiratory protective devices. Full face masks. Requirements, testing, marking

**EN 143** - Respiratory protective devices -Particle filters - Requirements, testing, marking

**EN 140** - Respiratory protective devices - Half masks and quarter masks - Requirements, testing, marking

**EN 148** - Respiratory protective devices - Threads for facepieces - Part 1: Standard thread connection

**EN 149** - Respiratory protective devices - Filtering half masks to protect against particles - Requirements, testing, marking

**EN 14387** - Respiratory protective devices - Gas filter(s) and combined filter(s) - Requirements, testing, marking

### PASSIVE RESPIRATORY PROTECTION - EXPLANATIONS

Type of filters:

A - Gases and vapours of organic compounds

B - Inorganic gases and vapours, e.g. chlorine, hydrogen sulphide, hydrogen cyanide

E - Sulphur dioxide, hydrogen chloride

K - Ammonia and organic Ammonia derivates

X - Disposable

Filter selection table		
Filter class	Reusable	Type of protection:
FFP1	4 X NDS	small dust / aerosol concentration
FFP2	12 X NDS	medium dust / aerosol concentration
FFP3	50 X NDS	large dust / aerosol concentration

Marking of half masks:

NDS - MPC - Maximum permitted concentration of hazardous substances in the air in the workplace

NR - disposable / non-reusable

R - reusable

D - tested using dolomite dust

### ACTIVE RESPIRATORY PROTECTION - STANDARDS

**EN 12021** - Respiratory equipment - Compressed gases for breathing apparatus

**EN 12941** - Respiratory protective devices - Powered filtering devices incorporating a helmet or a hood

**EN 12942** - Respiratory protective devices - Power assisted filtering devices incorporating full face masks, half masks or quarter masks - Requirements, testing, marking



▼ 4.1. Powered air and supplied air systems for welders



**MOST PX-FLOW forced airflow system**



MOST PX-FLOW



**Description**

- Suitable for MOST PYXAR – welding helmet (see page 148).
- Ergonomic drive unit design.
- Operating time of 12 hours or more at minimum airflow speed, full HD battery and new P R SL filter.
- Adjustable air flow rate (180 l/min - 220 l/min).
- Audio-visual, audible and vibration alarm to indicate low airflow and low battery.
- Convenient and functional control panel with colour LEDs.

**Characteristics:**

- Minimum air flow 179 l/min.
- Airflow Adjustable 180-220 l/min.
- Filter Types P R SL or ABE1 P R SL.
- Standard battery lithium-ion 7.4 V / 5200 mAh.
- Heavy duty battery lithium-ion 7.4 V / 7800 mAh.
- Battery charging standard > 4-6 h.
- Charging the Heavy Duty Battery > 4-6 h.
- System working time: full battery standard, minimum air flow and new filter > 10 h (with filter P R SL) > 6 h (with filter ABE1 P R SL).
- System working time: full battery heavy duty, minimum air flow and new filter > 12 h (with filter P R SL) > 8 h (with filter ABE1 P R SL).
- Low battery level indication Visual, audible and vibration alarm.
- Indication of insufficient air flow (below 180 l/min) Visual, audible and vibration alarm.
- Weight (drive unit with standard battery and P R SL filter) 1173 g.
- Protection level according to EN12941 TH 3 - highest level of protection.



MOST PYXAR AIR



MOST PYXAR FLIP-UP AIR

**Catalogue No.:**

- 72 00 921110 MOST PYXAR AIR helmet
- 72 00 921150 MOST PYXAR FLIP-UP AIR helmet
- 72 00 921210 Face seal for MOST PX-FLOW
- 72 00 921209 Hose and Cover Assembly for MOST PX-FLOW
- 72 00 921211 Belt for MOST PX-FLOW 72 00 921215 Harness for belt MOST PX-FLOW
- 72 00 921208 Charger for MOST PX-FLOW (EU + UK + AUS)
- 72 00 921206 Standard Battery (4 Cell) 7,4 V / 5,2 Ah for MOST PX-FLOW
- 72 00 921207 Heavy Duty Battery (6 Cell) 7,4V / 7,8 Ah for MOST PX-FLOW
- 72 00 921200 Driving unit for forced air-flow system for MOST PX-FLOW (without battery and filter)
- 72 00 921201 P R SL Filter MOST PX-FLOW (set of 2 pcs.)
- 72 00 921202 Filter A1B1E1 / P R SL for MOST PX-FLOW (set of 2 pcs.)
- 72 00 921203 Pre-filter for MOST PX-FLOW (pack of 10 pcs.)
- 72 00 921204 Carbon pre-filter for MOST PX-FLOW (pack of 10 pcs.)
- 72 00 921214 Filter spark protector for MOST PX-FLOW (set of 2 pcs.)
- 72 00 921205 Filter cover (set of 2 pcs.)



## Powered airflow purifying system MOST R-FLOW

- Suitable for MOST WELD RAPTOR – welding helmet (see page 150).
- Ergonomic shape.
- Flat profile.
- Universal application - filtration of dust, gases, vapours and welding fumes.
- Operating time up to 9 hours at minimum speed, with new filter and standard battery or up to 15 hours with a full heavy duty battery.
- Adjustable airflow (170 l/min - 210 l/min).
- Electronic constant airflow system.
- Electronic audio-visual and vibration alarm in case of low battery and/or low air flow.
- Simple regulation with only one button.
- Filter types: P R SL or ABEK1.

### Catalogue No.:

- 72 00 912200 Powered airflow system MOST R-FLOW  
 72 00 912110 Helmet MOST WELD RAPTOR AIR black  
 72 00 912120 Helmet MOST WELD RAPTOR AIR techno-blue



MOST R-FLOW



MOST WELD RAPTOR AIR  
techno blue

## Powered airflow purifying system MOST V-FLOW

- Compatible with MOST V-1000 AIR welding helmet - (see page 151).
- Low weight - only 870 g.
- Universal application - filtration of dust, gases, vapours and welding fumes.
- Operating time up to 10 hours at minimum speed, with new filter and standard battery or up to 15 hours with a full heavy duty battery.
- Adjustable airflow (180 l/min - 220 l/min).
- Electronic constant airflow system.
- Electronic audio-visual and vibration alarm in case of low battery and/or low air flow.
- Easily replaceable particle filter P R SL.

### Catalogue No.:

- 72 00 911200 Powered airflow system MOST V-FLOW  
 72 00 911201 Particle filter P R SL to V-FLOW MOST  
 72 00 911202 Dust pre-filter (10-pack) for V-FLOW MOST  
 72 00 911203 Standard battery for V-FLOW MOST  
 72 00 911204 Heavy duty battery for V-FLOW MOST  
 72 00 911206 Charger for V-FLOW MOST  
 72 00 911207 Face seal for V-1000 Air MOST  
 72 00 911208 Air channel header for V1000 AIR MOST  
 72 00 911209 Breathing hose with cover for V-FLOW MOST  
 72 00 911210 Standard belt for V-FLOW MOST  
 72 00 911211 V-FLOW MOST drive unit  
 72 00 911212 Sweatband (2-pack) for V-1000 AIR MOST  
 72 00 911100 MOST V1000 Air helmet



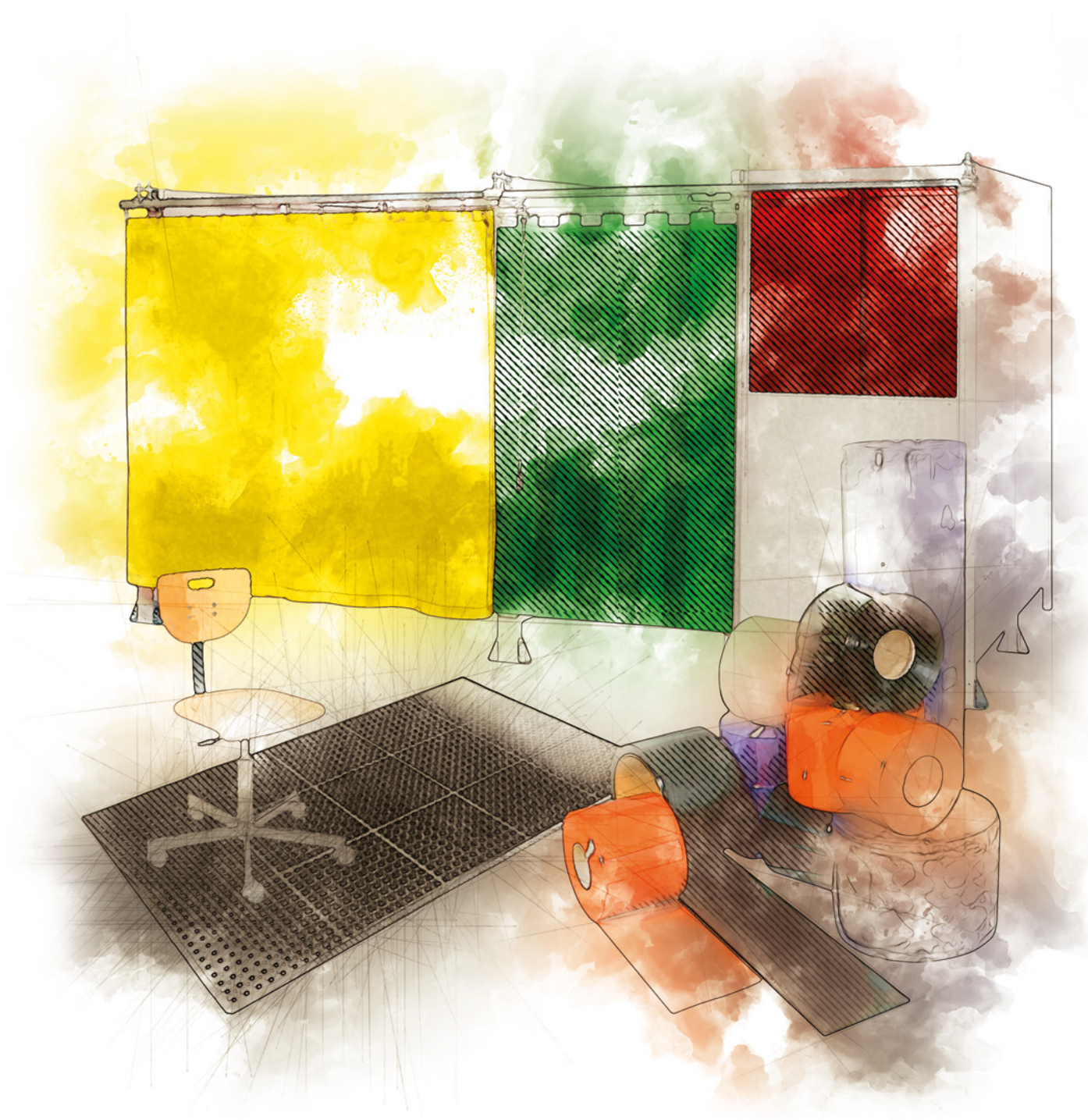
MOST V-FLOW



MOST V1000 AIR



# 05.1



# COMPREHENSIVE EQUIPMENT OF WELDING STATION

## ARRANGEMENT OF WELDING STATION

05.1

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# Introduction

As part of our services we offer consulting, design, delivery and assembly of elements for complex configuration and arrangement of welding stations.

The professional welding station consists of:

- Welding station components such as curtains and welding strips, welding screens, glass protections, soundproof wall elements, welding tables and chairs, welding floor system, heat-resistant materials, tents and welding umbrellas;
- New welding processes like laser welding require new materials to separate the welding stand against the rest of the hall. Standard welding curtains do not protect against the laser ray. Working without the proper protection could cause heavy injuries of bystanders. It is very important to create safe welding station using adequate materials like laser welding curtains.
- Filtration devices: extraction arms, mobile and stationary filtering units, filtration systems (chapter 05.2);
- Clamping systems in the form of manual and pneumatic 3D clamps, assembly and welding tables and magnetic mounting tools (chapter 05.3);
- Lifting systems, i.e. slings and attachment points, transport brackets, hoists, jacks, cranes and overhead travelling cranes (chapter 05.4).

Elements of welding stations configuration must meet the EU requirements.

Additionally, each of the customers who choose a product from our offer is obliged to verify whether the product meets the national safety requirements of the country of destination.

Welding curtains, strips and screens offered by RYWAL-RHC meet the European standards, EN ISO 25980:2014.



For complex arrangements of the welding station we additionally recommend:

- Welding equipment and torches: see chapter 01
- Gas regulators and fuses: see chapter 03
- Welder protective equipment: see chapter 04
- Welding electrodes and wires: see chapter 10

## ▼ 1. SEPARATION OF WELDING STATION

### ▼ 1.1. Curtains and welding strips



#### CEPRO welding curtains

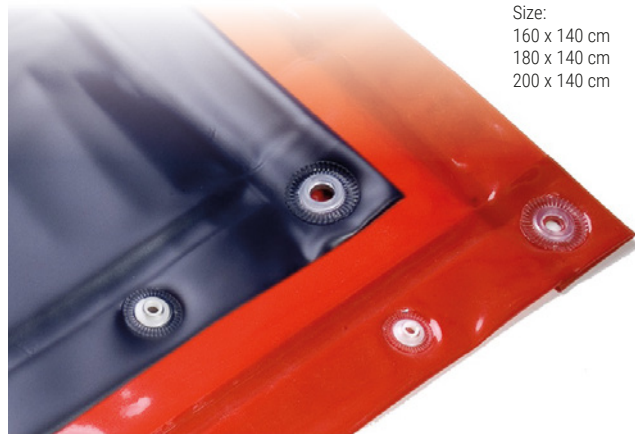
Light radiation generated during the welding process can lead to such diseases as: arc eye, cataracts, skin burns or even cancer. The welder is protected by wearing a welding mask and protective clothing, but bystanders are exposed to the dangerous light. It is therefore important to protect also other workers from harmful light radiation.

When surrounding the welding area, it is important not to insulate the welder from the working environment, so the welding curtain should be made of transparent material. It helps to maintain control over the work progress and to react quickly in case of emergency.

All curtains are non-flammable.

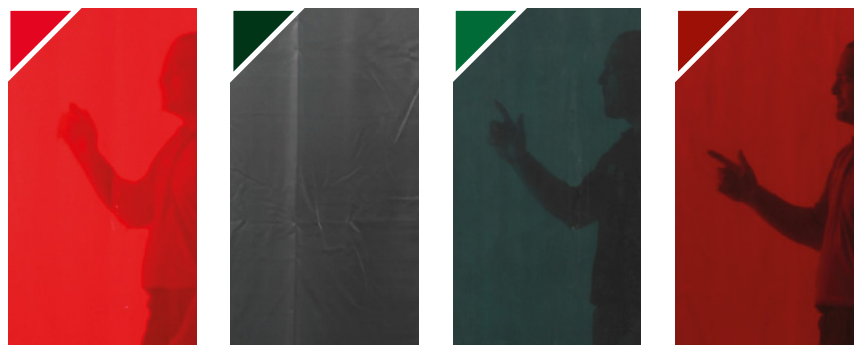


Size:  
160 x 140 cm  
180 x 140 cm  
200 x 140 cm



05.1

#### Welding curtains



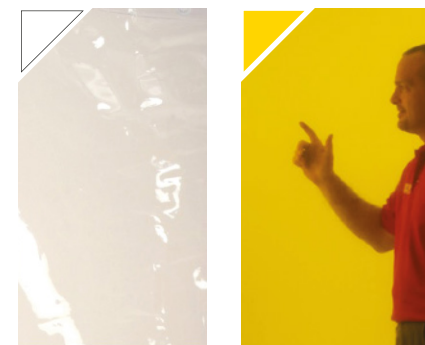
orange  
(orange-CE)

dark green  
(green 9)

light green  
(green 6)

brown  
(bronze-CE)

#### Protective curtains for other applications



clear

yellow UV  
(yellow)

Standard curtain dimensions (HxW)	Curtains according to EN ISO 25980				Curtains for other applications	
	orange (orange-CE)	dark green (green 9)	light green (green 6)	brown (bronze-CE)	clear	yellow UV (yellow)
160 x 140 cm	70 41 161516	70 41 161916	70 41 161616	70 41 161716	70 41 161016	70 41 161116
180 x 140 cm	70 41 161518	70 41 161918	70 41 161618	70 41 161718	70 41 161018	70 41 161118
200 x 140 cm	70 41 161520	70 41 161920	70 41 161620	70 41 161720	70 41 161020	70 41 161120
220 x 140 cm	70 41 161522	70 41 161922	70 41 161622	70 41 161722	70 41 161022	-
240 x 140 cm	70 41 161524	70 41 161924	70 41 161624	70 41 161724	70 41 161024	-
260 x 140 cm	70 41 161526	70 41 161926	70 41 161626	70 41 161726	70 41 161026	-
280 x 140 cm	70 41 161528	70 41 161928	70 41 161628	70 41 161728	70 41 161028	-
300 x 140 cm	70 41 161530	70 41 161930	70 41 161630	70 41 161730	70 41 161030	-
160 x 220 cm	70 41 181516	70 41 181916	70 41 181616	70 41 181716	-	-
180 x 220 cm	70 41 181518	70 41 181918	70 41 181618	70 41 181718	-	-
Customized curtains	70 41 161599	70 41 161999	70 41 161699	70 41 161699	70 41 161099	-

#### Standard curtain:

- plastic eyelets on the top of the curtain,
- 50 mm wide seam all around,
- snap fasteners on both sides of curtain to enable connecting the curtain,
- steel suspension rings -7 pcs.,
- standard normative marking on the upper edge.

#### Customized curtains (on request):

- plastic eyelet for hanging every 22.5 cm,
- 50 mm wide seam all around,
- snap fasteners on both sides of curtain,
- minimum size is 1 m<sup>2</sup>,
- minimum length of one vertical side: 1 m,
- due to the flexibility of the PVC material, a 2% tolerance of each dimension must be considered,
- the maximum size of the curtain is 24 m<sup>2</sup>,
- customized curtains are non-returnable.



## CEPRO strips 300 mm

- Complies with EN ISO 25980.
- Standard width 300 mm.
- Thickness of 2 or 3 mm.
- 50 m long rolls.
- Cut to size and suspension clips available.
- Plastic suspension clips that fit on a 35 mm Ø pipe (10 or 20 cm).
- All welding strips are non-flammable.



Dimensions (W x D)	Ordering unit	CEPRO welding strips according to EN ISO 25980				Strips for other applications
		orange (orange-CE)	dark green (green 9)	light green (green 6)	brown (bronze-CE)	clear
200 x 2 mm	RM (50 m/roll)	-	-	-	-	70 41 262022
300 x 2 mm	RM (50 m/roll)	70 41 262502	70 41 262902	70 41 262602	70 41 262702	70 41 262002
300 x 3 mm	RM (50 m/roll)	70 41 262503	70 41 262903	-	-	70 41 262003
400 x 4 mm	RM (50 m/roll)	-	-	-	-	70 41 262044
*Cutting to size	pcs.	70 41 064825				

\*Cut to size strips and suspension slots available on request, each height with a tolerance of  $\pm 2$  cm

## Welding strips CEPRO 570 mm

- Complies with EN ISO 25980.
- Standard width: 570 mm.
- Thickness: 1 mm.
- Full roll 50 m as packaging or cut in 4 pieces - working width of the entire curtain in the package - 2 m.
- 4 suspension eyelets in the top part of the strip 570 mm.
- Metal suspension clips included.



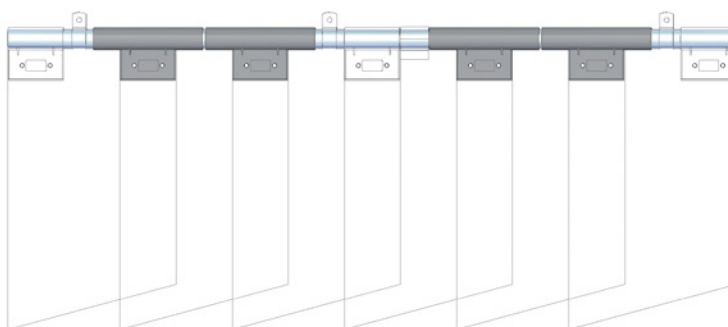
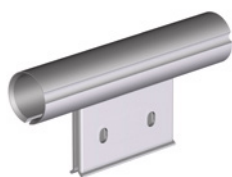
Dimensions (W x D x L)	Ordering Unit	Welding sheets according to EN ISO 25980			
		orange (orange-CE)	dark green (green 9)	light green (green 6)	brown (bronze-CE)
570 x 1 mm	RM (50 m/roll)	70 41 221501	70 41 221901	70 41 221601	70 41 221701
Standard size strips in sets of 4 pcs with suspension clips (total installation width: 2 m)					
570 x 1 x 1600 mm	set	70 41 221516	70 41 221916	70 41 221616	70 41 221716
570 x 1 x 1800 mm	set	70 41 221518	70 41 221918	70 41 221618	70 41 221718
570 x 1 x 2000 mm	set	70 41 221520	70 41 221920	70 41 221620	70 41 221720
570 x 1 x 2200 mm	set	70 41 221522	70 41 221922	70 41 221622	70 41 221722



### 300 mm suspension clips

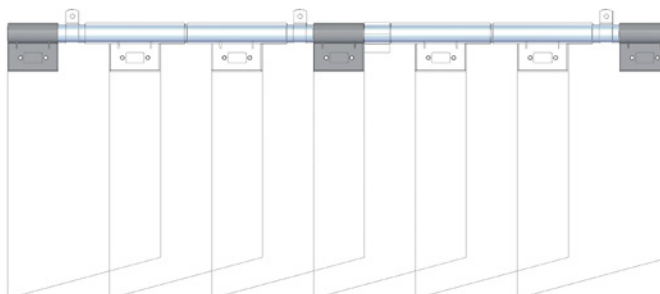
Special plastic clips that fit on a 35 mm Ø pipe are used to assemble welding strips.

Plastic suspension clip - 20 cm.



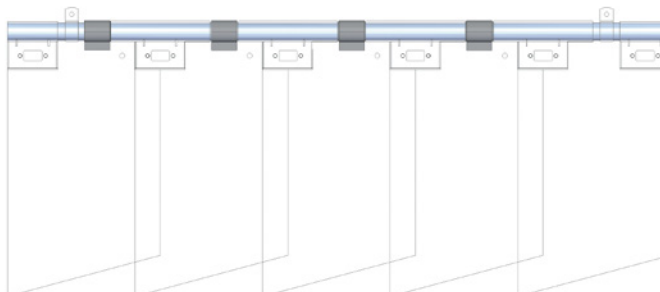
Overlap 2 x 10 cm / 66% overlap (2 holes in the overlap)

Plastic suspension clip 10 cm.  
For use as initial or final element.



Overlap 2 x 10 cm / 66% overlap (2 holes in the overlap)

Plastic spacer - 5 cm.  
For assembly with 5 cm overlap using 20 cm clips.



Overlap 2 x 5 cm / 33% overlap (1 hole in the overlap)

05.1



▼ 1.2. Welding screens



CEPRO Welding Screens

Welding screens are used for quick assembly of the welding stand. We offer 3 types of welding screens: Robusto, Omnium and Gazelle. They are varied in construction and application.



OMNIUM



ROBUSTO



GAZELLE



**ROBUSTO:**

- Strong screen made from profiles 50 x 30 x 2 mm and 35 x 2,5 mm pipes.
- Screen width: 215 cm.
- Frame in grey colour.
- Available with swivel arms 70 or 110 cm.
- Possibility of using a connector between screens.
- Provided with 4 swivel castors Ø75 mm, 2 with a brake.

**OMNIUM:**

- Screen made of 40 x 30 x 2 mm profiles and 30 x 2 mm pipes.
- Screen width: 215 mm.
- Frame in grey colour.
- Available with swivel arms 80 or 110 cm.
- Provided with 4 swivel castors Ø50 mm, 2 with a brake.

**GAZELLE:**

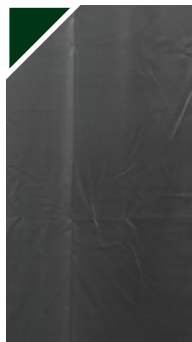
- Made from 1/2" galvanized tubes.
- 6 kg screen weight.
- Provided with a tension curtain with an upper and lower open seam.
- Screen height 200 cm.
- Available width: 140 or 200 cm.
- Packed in a cardboard box measuring only 120 cm therefore easy to send through the regular parcel services.

Screens	ROBUSTO	OMNIUM	GAZELLE	
External frame dimension (WxH)	215 x 210 cm	215 x 200 cm	200 x 200 cm	140 x 200 cm
Frame profiles	50 x 30 x 2 mm	40 x 30 x 2 mm	Ø 21 x 1 mm	Ø 21 x 1 mm
Crossbar tube	Ø 35 x 2,5 mm	Ø 30 x 2 mm	Ø 21 x 1 mm	Ø 21 x 1 mm
Frame painting colour	grey	grey	galvanized	galvanized
Swivel castors	4	4	NO	NO
Wheels with brakes	2	2	NO	NO
Swivel castors diameter Ø	75 mm	50 mm	n.a.	n.a.
Curtain/strips height	180 cm	160 cm	176 cm	176 cm
Swivel arms (optional)	YES	YES	NO	NO
Length of swivel arms	110 and 70 cm	110 and 80 cm	n.a.	n.a.
Curtains/strips with EU standards:	EN ISO 25980	EN ISO 25980	EN ISO 25980	EN ISO 25980
Screen connector 170 cm long (Cat.-No.: 70 41 300232)	YES	NO	NO	NO
Screen connector 210 cm long (Cat.-No.: 70 41 303232)	YES	NO	NO	NO

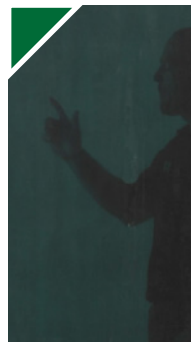
**Welding screens**



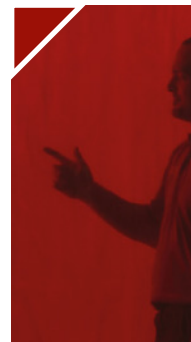
orange  
(orange-CE)



dark green  
(green 9)



light green  
(green 6)



brown  
(bronze-CE)

**Protective screens**



clear

Dimensions (W x H)	Equipment		Welding screens				Screens for other applications	
			orange (orange-CE)	dark green (green 9)	light green (green 6)	brown (bronze-CE)	clear	
<b>ROBUSTO</b>								
210 x 210 cm	single with swivel castors	curtain		70 41 363215	70 41 363219	70 41 363216	70 41 363217	70 41 363210
		strips	300 x 2 mm	70 41 363225	70 41 363229	70 41 363226	70 41 363227	70 41 363220
70/210/70 x 210 cm	triple on swivel castors	curtain		70 41 363115	70 41 363119	70 41 363116	70 41 363117	70 41 363110
		strips	300 x 2 mm	70 41 363125	70 41 363229	70 41 363126	70 41 363127	70 41 363120
110/210/110 x 210 cm	triple on swivel castors	curtain		70 41 363165	70 41 363169	70 41 363166	70 41 363167	70 41 363160
		strips	300 x 2 mm	70 41 363175	70 41 363179	70 41 363176	70 41 363177	70 41 363170
<b>OMNIUM</b>								
215 x 200 cm	single with swivel castors	curtain		70 41 363415	70 41 363419	70 41 363416	70 41 363417	-
		strips	300 x 2 mm	70 41 363425	70 41 363429	70 41 363426	70 41 363427	-
			570 x 1 mm	70 41 363405	70 41 363409	70 41 363406	70 41 363407	-
80/215/80 x 200 cm	triple on swivel castors	curtain		70 41 363615	70 41 363619	70 41 363616	70 41 363617	-
		strips	300 x 2 mm	70 41 363625	70 41 363629	70 41 363626	70 41 363627	-
			570 x 1 mm	70 41 363605	70 41 363609	70 41 363606	70 41 363607	-
110/215/110 x 200 cm	triple on swivel castors	curtain		70 41 363665	70 41 363669	70 41 363666	70 41 363667	-
		strips	300 x 2 mm	-	-	-	-	-
			570 x 1 mm	-	-	-	-	-
<b>GAZELLE</b>								
140 x 200 cm	legs	curtain		70 41 363915	70 41 363919	70 41 363916	70 41 363917	-
200 x 200 cm	legs	curtain		70 41 363925	70 41 363929	70 41 363926	70 41 363927	-
140 x 170 cm	replacable curtain without a frame		70 41 131544	70 41 131944	70 41 131644	70 41 131744	-	
200 x 170 cm	replacable curtain without a frame		70 41 131542	70 41 131942	70 41 131642	70 41 131742	-	

There is a possibility to place heat-resistant Atlas material or Sonic sound absorbing curtain in frames of the screens.

### ▼ 1.3. Protective walls



#### Tinted protection plates CEPRO IMPACT

- Comply with EN ISO 25980.
- Hard impact resistant material.
- Polycarbonate 3 mm thickness.

IMPACT according to EN ISO 25980			
Dimensions	Order unit	brown (brown)	drak green (green)
2050 x 1250 x 3 mm	pcs.	70 41 282701	70 41 282901
1025 x 1250 x 3 mm	pcs.	70 41 282705	70 41 282905

Cut to size available  
Customized elements are non-returnable



### ▼ 1.4. Laser protection curtains

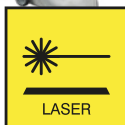
#### Passive multi-layer laser protection curtains

Multi-layer passive laser protection curtain ML-6 is suitable for securing laser areas in which Class 3B, 3R, 4 or 1 (new) lasers are used. If the welding area is temporary, the use of laser curtains in mobile frames is advisable for laser protection.

The ML-6 multi-layer laser protection curtain consists of diffusely reflecting, non-flammable fabric. The suitability of the laser protection curtains for the respective application is subject to the individual assessment of the laser specifications and is the responsibility of local laser protection representative. We'll be happy to support you in the process.

As a light-proof material, the curtain is suitable for the laser wavelengths from 200 to 11,000 nm in the medium power range and is certified according to the standard DIN EN 12254:2012-04 for shielding at laser workplaces.

**NEW**  
in offer



## Test results for ML-6:

- D AB8 + IR AB3 + M AB6Y JUTEC 200-315 DIN-tested
- D AB6 JUTEC 316-1050 DIN-tested
- D AB5 JUTEC 1051-1400 DIN-tested
- I AB8 + R AB6Y + M AB7Y JUTEC 316-1400 DIN-tested
- D AB2 + I AB3 JUTEC 1401-11000 DIN-tested

## Standard - depending on the curtain:

- DIN EN 60825-4 VDE 0837-4:2011-12
- DIN EN 12254:2012-04
- EN ISO 13849-1:2015

Laser protection curtain for passive laser protection, material 3-ply, frontside colour nacre, backside colour black.

Dimensions: width approx. 4000 mm, height approx. 2000 mm, eyelet device on one wide side (4000 mm); eyelet distance standard approx. 300 mm, eyelet diameter approx. 16 mm, equipped with zipper on both high sides for connection with further laser protection curtains.

Laser protection certified acc. to DIN EN 12254:2012-04.

Catalogue No.: 70 41 L01010

(optionally) 70 41 L01011

Mobile frame "Chris A" made out of aluminum profile 40x40, mobile (on 4 rolls), 6 parts. Height: 2000 mm, basic element 1900 mm, one swivel arm 1050 mm per side, which could be screwed straight or 90 degree angles. Vertical and horizontal profiles cut to size incl. mounting elements. Curtain fastening via screw hooks. Tool for assembly not included.

Catalogue No.: 70 41 L01110



INSIDE



OUTSIDE

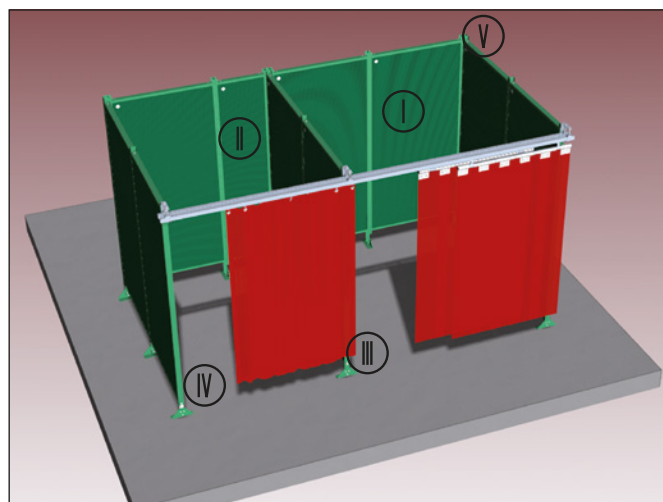


▼ 1.5. Sound-absorbing walls



**CEPRO Sonic soundproof walls**

- Noise reduction.
- Separation of welding or grinding stations.
- Colour: green matt.
- Wall thickness: 50 mm.
- Ventilation gap by the floor: ±180 mm.
- Modular system.
- Other colours on request



**CEPRO Sonic insulating mobile screen**

- Width: 215 cm.
- Height: 220 cm.
- Thickness: 50 mm.
- Colour: green matt.
- 4 Wheels with brakes.

Catalogue No.: 70 41 064530

CEPRO SONIC basic wall elements		
No.	Description	Catalogue No.
I	Modular element 2012 x 1012 x 50 mm, green RAL 6011	70 41 064500
II	Modular element 2012 x 512 x 50 mm, green RAL 6011	70 41 064502
III	Adjustable foot with screws, green RAL 6011	70 41 451000
IV	Adjustable foot support for use at the end of a sequence	70 41 453520
V	Pole for 90° connections	70 41 452001

▼ 1.6. Grinding booths



**CEPRO Sonic work booth**

We offer work booths for particularly intensive grinding and welding treatments. They isolate the rest of the production hall from the noise generated on spot and prevent the dust migration to other workplaces. The cabins can be equipped with windows to light up the workplace, anti-panic doors and filtering and ventilation devices.



Dimensions	Catalogue No.
2130 x 3140 x 2552 mm	70 41 450523
2130 x 2130 x 2552 mm	70 41 450522
Other sizes and versions on request	

## ▼ 2. WORKING TABLES AND CHAIRS



### Working tables

- Frame made of 40 x 40 mm profiles.
- Protected by powder coating.
- Colour: green.
- Table top equipped with a flat grill or 1/3 fire-proof brick.
- Optional support for fixing objects to welding table.
- Self-assembly table.

Model	Dimensions (W x L x H)	Catalogue No.
Table with grill and chamotte brick	630 x 850 x 800 mm	70 41 454185
	630 x 1100 x 800 mm	70 41 454111
Table with grill	630 x 600 x 800 mm	70 41 454260
	630 x 850 x 800 mm	70 41 454285
	630 x 1100 x 800 mm	70 41 454211



Fire proof table and a positioning support

05.1

### Workshop chairs

- Height adjustment by means of a pneumatic lift.
- Adapted for use in the most difficult workshop conditions.
- Stable stand.

HIT



WEREK



BLAZAR X RB



TOOLIP X gts ESD



TOOLIP X gts



TOOLBOX



HUNTER 3D

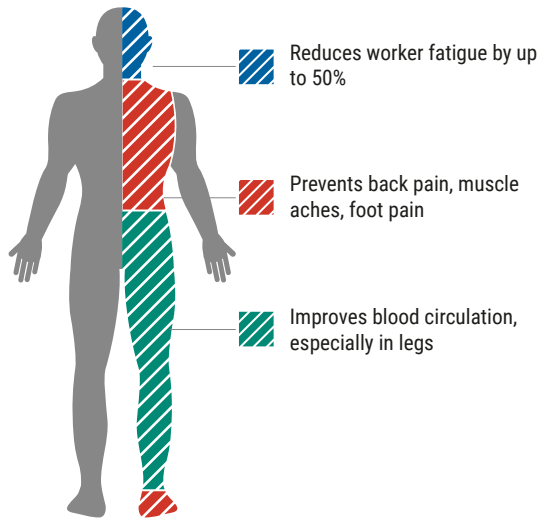


PULSAR WOOD X

Model	WEREK	BLAZAR X RB	TOOLIP X gts ESD	TOOLIP X gts	TOOLBOX	HUNTER 3D	PULSAR WOOD X
Weight	8,10 kg	6,80 kg	8,50 kg	8,50 kg	4,60 kg	7,50 kg	5,30 kg
Seat height	40-53,5 cm	58-83 cm	43-56 cm	43-56 cm	36-49 cm	46-59 cm	39-52 cm
Total height	77-90,5 cm	70-95 cm	73-97 cm	73-97 cm	36-49 cm	52-65 cm	39-52 cm
Stand diameter	67,5 cm	64 cm	64 cm	64 cm	40 cm	63 cm	64 cm
Seat width	40,5 cm	35 cm	46 cm	46 cm	-	38 cm	-
Seat depth	40,5 cm	25 cm	40-45 cm	40-45 cm	-	37,5 cm	-
Backrest height	37 cm	-	29 cm	29 cm	-	-	-
Diameter of the seat	-	-	-	-	33 cm	-	40 cm
Seat backrest material	lacquered beech plywood	black polyurethane	black polyurethane	black polyurethane	black polyurethane	black polyurethane	lacquered beech plywood
Stand	powder-coated steel	powder-coated steel	powder-coated steel	powder-coated steel	polyamide	polyamide	powder-coated steel
Wheels/legs	wheels/legs	legs	wheels/legs	wheels/legs	wheels/legs	wheels/legs	wheels/legs
Warranty	2 years	2 years	2 years	2 years	2 years	2 years	2 years
Certificate of fire resistance	-	declaration of conformity	declaration of conformity	declaration of conformity	-	declaration of conformity	certificate flame-retardant varnish
Catalogue No.	EM 11 070010	EM 11 070081	EM 11 070022	EM 11 070020	EM 11 070015	EM 11 070065	EM 11 070030

### 3. ERGONOMICS AND SAFETY IN THE WORKPLACE

#### WEARWELL®



#### THE BENEFITS OF INVESTING IN MATS:

1. Improved safety in the workplace.
2. Reduction of worker fatigue as well as back and leg pain.
3. Protection from overload and joint injuries.
4. Improved production efficiency.
5. Reduction of employee absenteeism.
6. Protection of floors, machine parts and tools from damage when falling.
7. Improved aesthetics and safety at the workstation.
8. Organized work area according to the LEAN system.

Product Guide	environment				customizable			additional benefit			
	dry	wet	oily	slippery	length	length/width	length/width/shape	cart friendly	non-conductive	antistatic	welding
24/Seven open GR LockSafe		■				■	■				
24/Seven open NBR LockSafe			■			■	■				
24/Seven solid GR LockSafe		■				■	■	■			
24/Seven solid NBR LockSafe			■			■	■	■			
24/Seven solid GS NBR				■		■	■	■			
24/Seven open GS NBR				■		■	■				
Diamond Plate Select	■				■				■		
Diamond Plate Smart	■				■						
Diamond Plate SpongeCote	■				■				■		
ErgoDeck Comfort open		■	■			■	■				
ErgoDeck Comfort solid	■		■			■	■				
ErgoDeck GP open		■	■			■	■	■			
ErgoDeck GP open GS		■	■	■		■	■	■			
ErgoDeck GP solid	■		■			■	■	■			
ErgoDeck GP solid GS	■			■		■	■	■			
ErgoDeck HD open		■	■			■	■	■			
ErgoDeck HD solid	■		■			■	■	■			
ErgoDeck HD solid GS	■			■		■	■	■			
ESD	■									■	
WeldSafe	■				■						■
WorkRite		■									

#### Ergonomic weld-safe mat WELDSAFE® No 447



- Resistant to high temperatures up to 300°C for short periods of time.
- Rough top layer.
- The nitrile enhanced Nitricell sponge base absorbs repeated compression and bounces back to its original form.
- For use in dry applications, especially for welding spot.
- Machine cut and beveled edges prevent tripping.

Size	Thicknes	Colour	Catalogue No.	Uom
61 x 91 cm	14 mm	black	EW 00 447001	pcs.
61 x 2286 cm	14 mm	black	EW 00 447008	reel
91 x 152 cm	14 mm	black	EW 00 447002	pcs.
91 x 2286 cm	14 mm	black	EW 00 447003	reel
122 x 2286 cm	14 mm	black	EW 00 447006	reel
<b>The mat can be cut to the desired length</b>				





## Ergonomic industrial mat DIAMOND-PLATE

- Surface layer made of PVC is abrasion and chemical resistant.
- Diamond plate surface.
- Anti-slip properties: R10 according to DIN 51130 and BG-rules BGR 181.
- Longer lifetime of Diamond-Plate comparing to traditional PCV sponge mats.
- Machine cut and beveled edges prevent tripping.
- 14 mm thick SPONGECOTE and SELECT version, 16 mm SMART version.
- No silicone.
- Self-extinguishing (classification A).
- Ergonomic mats are an addition to the EU standard for Occupational Health and Safety Management systems (OHS).

### Available colors:



BK - black



BYL - black and yellow



05.1



### SPONGECOTE:

- the Nitrile enhanced Nitricell sponge base absorbs repeated compression and bounces back to its original form,
- dedicated to multi-shift operation,
- prolonged lifetime,
- total thickness: 14 mm.



### SELECT:

- sponge underlayment, a dense, closed-cell PVC foam designed to provide solid, stable anti-fatigue performance,
- dedicated to single-shift operation,
- total thickness: 14 mm,
- less resistance to abrasion.



### SMART:

- 100% recycled polyurethane sponge,
- combines economy and ecology,
- more durable than the standard sponge mats,
- total thickness: 16 mm.

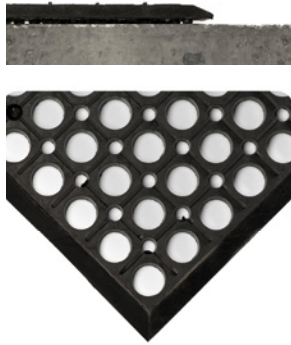
Size	Colour	Spongecote	Select	Smart
61 x 91 cm	Black (BK)	EW 00 415001	EW 00 495001	EW 00 497001
	Black and Yellow (BYL)	EW 00 415002	EW 00 495002	EW 00 497002
91 x 152 cm	Black (BK)	EW 00 415003	EW 00 495003	EW 00 497003
	Black and Yellow (BYL)	EW 00 415004	EW 00 495004	EW 00 497004
61 x 2286 cm	Black (BK)	EW 00 415005	EW 00 495005	EW 00 497005
	Black and Yellow (BYL)	EW 00 415006	EW 00 495006	EW 00 497006
91 x 2286 cm	Black (BK)	EW 00 415007	EW 00 495007	EW 00 497007
	Black and Yellow (BYL)	EW 00 415008	EW 00 495008	EW 00 497008
122 x 2286 cm	Black (BK)	EW 00 415009	-	-
	Black and Yellow (BYL)	EW 00 415010	-	-

The mat can be cut to the desired length

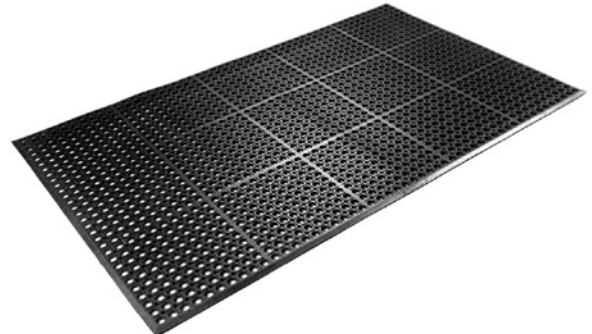




### WorkRite anti-fatigue mat No 474

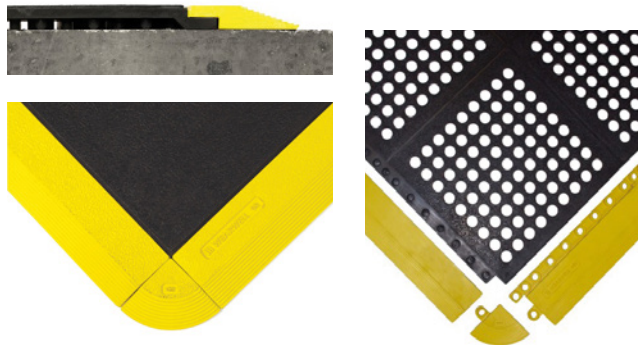


- For use in dry and wet areas.
- All natural rubber.
- Molded-in beveled safety edges.
- Easy to keep clean.
- The holes enable the drainage of fluids.
- Thickness 13 mm.



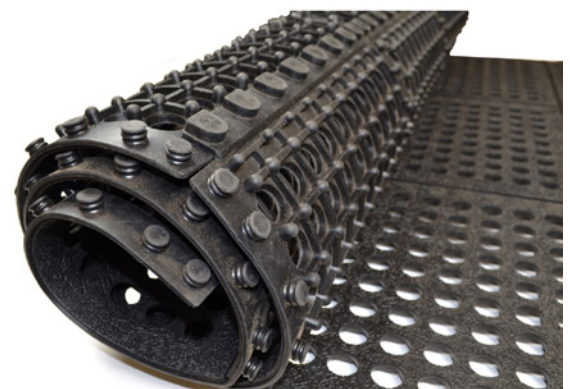
Size	Thicknes	Colour	Catalogue No.	Uom
91 x 152 cm	13 mm	black	EW 00 474001	pcs.
91 x 300 cm	13 mm	black	EW 00 474002	pcs.

### 24/SEVEN® LockSafe GR and NBR Anti-Fatigue Flooring



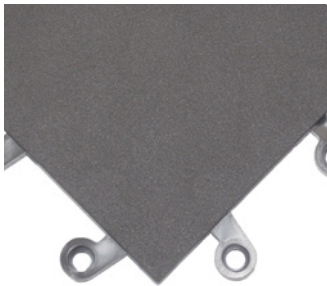
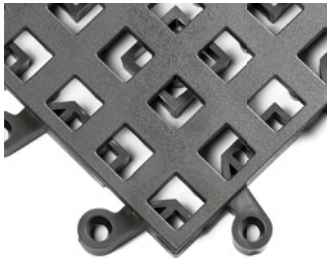
- Thickness: 16 mm.
- The 'positive interlock' technology allows the rubber tiles to lock in.
- Open version - with holes for drainage of fluids.
- Full version - for dry areas.
- Option - GRITSHIELD coating surface for better adhesion.
- Yellow safety borders.
- GR - rubber, NBR - nitrile rubber.
- 91 x 91 cm elements with fasteners on all edges.
- Can be trimmed every 30 cm.

Size	Description / Colour	Catalogue No.	Uom
91 x 91 cm	Solid GR, black, LockSafe	EW 57 758331	pcs.
91 x 91 cm	solid NBR, black, LockSafe	EW 57 758332	pcs.
91 x 91 cm	drainage GR, black, LockSafe	EW 57 858331	pcs.
91 x 91 cm	drainage NBR, black, LockSafe	EW 57 858332	pcs.
91 x 91 cm	Solid with GRITSHIELD NBR, black, LockSafe	EW 58 458331	pcs.
91 x 91 cm	rainage with GRITSHIELD NBR, black, LockSafe	EW 58 658331	pcs.
8 x 99 cm	Male edging GR, yellow, LockSafe	EW 57 833603	pcs.
7 x 99 cm	GR female edging yellow, LockSafe	EW 57 833605	pcs.
7 x 99 cm	NBR male edging, yellow, LockSafe	EW 57 833607	pcs.
7 x 99 cm	NBR female edging, yellow, LockSafe	EW 57 833609	pcs.
10 x 7 cm	Outside corner. GR, yellow, locksafe	EW 57 843000	pcs.
10 x 7 cm	Outside corner. NBR, yellow, LockSafe	EW 57 843010	pcs.





## ErgoDeck anti-fatigue mat



### Surface versions:

- drainage: for use in a wet environment,
- solid: for use on dry surfaces for easy cleaning.

- PVC mat.
- Patented "LockSafe" joining system.
- Modular elements with attachable edges and corners.
- Can be fixed to the floor.
- Thickness: 22 mm, weight: 11.2 kg/m<sup>2</sup>.
- No silicone.
- Self-extinguishing (classification A).
- Ergonomic mats are an addition to the EU standard for Occupational Health and Safety Management systems (OHS).
- Colour: black or grey (other colour on request).

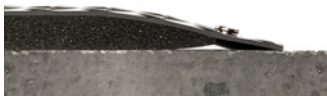
### Available in applications:

- HD - resistant to high loads.
- GP - for general applications.
- Comfort - only for walking.
- Smooth - for vehicle traffic.
- GRITSHIELD - anti-slip.
- ESD - anti-static.

All versions mentioned above are available with solid or drainage surface.

Type	Size	Surface	Colour	Catalogue No.
HD	46 x 46 cm	drainage	black	EW 00 560001
HD	46 x 46 cm	solid	black	EW 00 562001
GP	46 x 46 cm	drainage	grey	EW 00 564001
GP	46 x 46 cm	solid	grey	EW 00 566001
Comfort	46 x 46 cm	drainage	grey	EW 00 556001
Comfort	46 x 46 cm	solid	grey	EW 00 558001
Ramps	15 x 46 cm	-	Yellow	EW 00 560003
Outside corners	15 x 38 cm	-	Yellow	EW 00 560006
Inside corners	15 x 23 cm	-	Yellow	EW 00 560007

## ESD No 786 - Electrically conductive, anti-fatigue mat



### DIAMOND-PLATE surface pattern:

RTT - 1x105 to 8x106Ω  
RTG - 1x105 to 8x106Ω

### Smooth surface pattern:

RTT - 1x103 to 1x106Ω  
RTG - 5x103 to 1x106Ω

- Electrically conductive anti-fatigue mat.
- Nitricell sponge base.
- Diamond plate or smooth surface pattern.
- Grounding snap is attached to the corner of each mat.
- Workers must wear heel.
- Grander or shoes with conductive soles.



475 cm conductive cable



heel grander






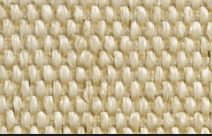


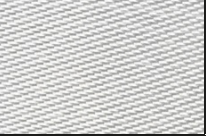
Size	Thickness	Type/Colour	Catalogue No.	Uom
91 x 152 cm	14 mm	Diamond-Plate, black	EW 00 786002	pcs.
91 x 2286 cm	14 mm	Diamond-Plate, black	EW 00 786003	reel
122 x 2286 cm	14 mm	Diamond-Plate, black	EW 00 786005	reel
91 x 152 cm	14 mm	Smooth, black	EW 00 786008	pcs.
91 x 2286 cm	14 mm	Smooth, black	EW 00 786009	reel
122 x 2286 cm	14 mm	Smooth, black	EW 00 786011	reel
Universal	-	Heel grander	EW 00 793001	pcs.
457 cm	-	Cable	EW 00 793002	pcs.

## ▼ 4. HEAT-RESISTANT MATERIALS



### Welding blankets

HIT

Model					
					
	OLYMPUS	SIRIUS	THETIS	KRONOS	APOLLO
<b>Application</b>	Welding blanket for horizontal use	Welding blanket for horizontal use	Welding blanket for horizontal use	Welding blanket for horizontal use	Blanket for light welding work and grinders
<b>Thermal resistance</b>	1000°C (1300°C)	700°C (1000°C)	700°C (900°C)	550°C (600°C)	550°C (600°C)
<b>Thickness</b>	1,5 mm	1,4 mm	1,4 mm	0,7 mm	0,4 mm
<b>Weight</b>	1220 g/m <sup>2</sup>	1035 g/m <sup>2</sup>	1100 g/m <sup>2</sup>	690 g/m <sup>2</sup>	460 g/m <sup>2</sup>
<b>Material</b>	Silicon filament fibers	Textured glass fiber fabric	Textured glass fiber fabric	Textured glass fiber fabric	Textured glass fiber fabric
<b>Coating</b>	Double-side vermiculite	Double-side vermiculite	Double-side graphite	Single-side polyurethan	Single-side polyurethan
Size	Catalogue No.				
90 x 100 cm	70 41 565091	-	-	-	-
90 x 200 cm	70 41 565092	-	-	-	-
100 x 200 cm	-	70 41 565322	70 41 565082	70 41 565062	-
180 x 200 cm	70 41 565095	-	-	-	-
200 x 200 cm	-	70 41 565325	70 41 565085	70 41 565065	-
180 x 300 cm	70 41 565096	-	-	-	-
200 x 300 cm	-	70 41 565326	70 41 565086	70 41 565066	-
300 x 300 cm	-	70 41 565327	-	70 41 565067	-
400 x 300 cm	-	-	-	70 41 565068	-
400 x 400 cm	-	70 41 565329	-	-	-
100 cm x 25 m / roll	-	70 41 565302	70 41 565008	70 41 565006	-
90 cm x 50 m / roll	70 41 565009	-	-	-	-
100 cm x 50 m / roll	-	-	-	-	70 41 565002
Size on request	70 41 565090	70 41 565320	-	70 41 565060	-

### Insulation Sleeves

**Application:**

- controlled weld cooling,
- heating of the details.

Size	Purpose	Catalogue No.
100 x 50 cm	for pipes with a maximum diam. 28 cm	70 41 501011
150 x 50 cm	for pipes with a maximum diam. 44 cm	70 41 501012
200 x 50 cm	for pipes with a maximum diam. 61 cm	70 41 501013







## Welding cushions and insulation blankets

High temperature insulation.

### Application:

- Heating of the details.
- Welder's primer.



Type	Size	Thickness	Filling in	Catalogue No.
Cushion	50 x 50 cm	8 cm	glass wool	70 41 511005
	100 x 100 cm	8 cm	glass wool	70 41 511010
Blanket	100 x 200 cm	3 cm		70 41 502310
	200 x 200 cm	3 cm		70 41 502320
	100 x 200 cm	6 cm		70 41 502610
	200 x 200 cm	6 cm		70 41 502620

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## ▼ 5. TENTS AND WELDING UMBRELLAS



### Welding tent

- Covered with self-extinguishing PVC material.
- Front and back can be closed with a rope-lock.
- 200 mm all-around protection skirt.
- Warning tape at half tent height.
- Frame made of galvanized tubes of 25 mm diameter.

Size	Catalogue No.
190 x 200 x 200 cm / 220 cm	70 41 912011
Other sizes on request.	



### Welding umbrellas

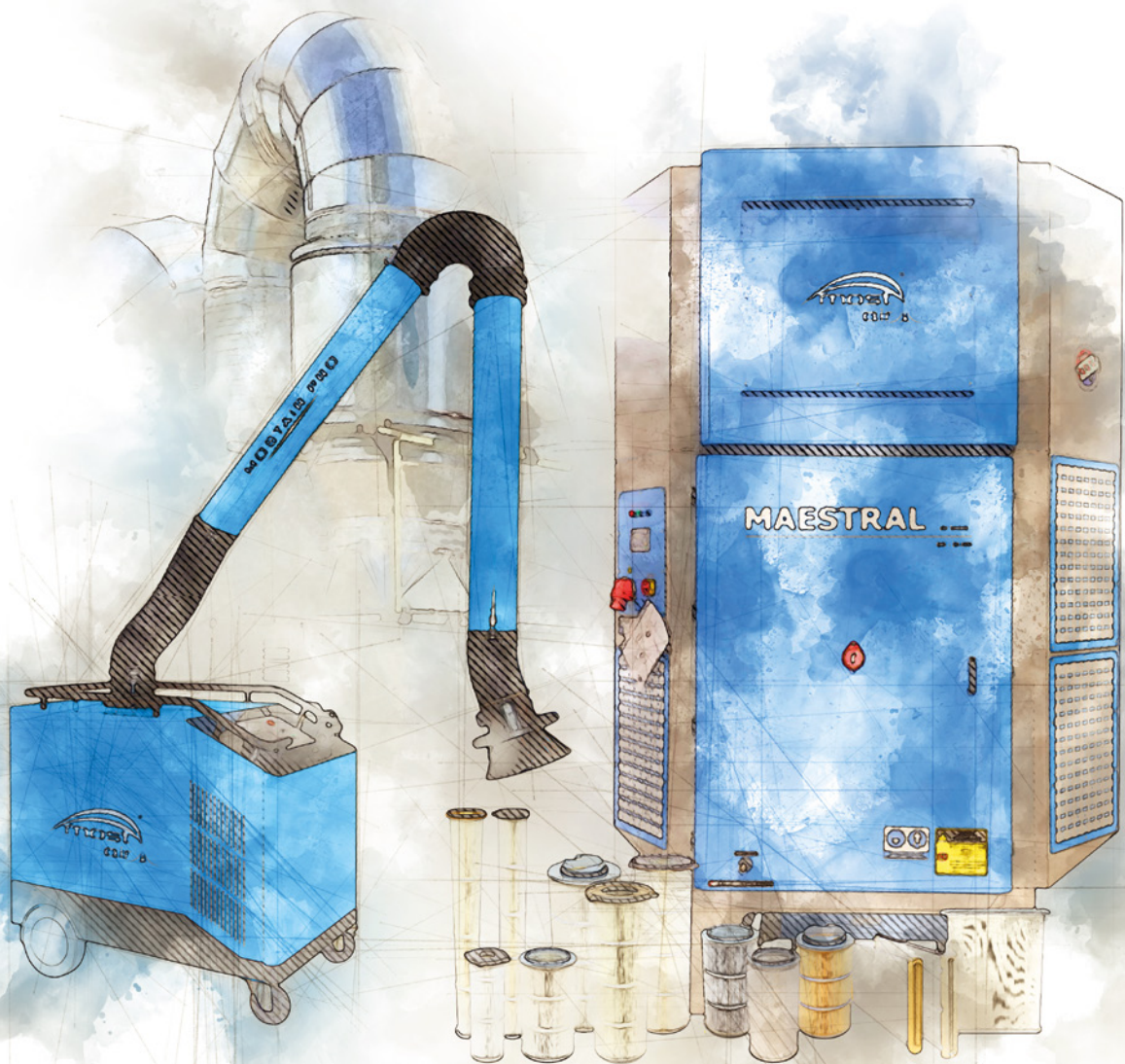
- Protects against weather conditions.
- Made of non-flammable material.
- Colour: green.
- Available diameter: 220 cm or 300 cm.

Diameter	Catalogue No.
Ø220 cm foldable	70 41 932120
Ø300 cm + ground pin	70 41 937120





# 05.2



# COMPREHENSIVE EQUIPMENT OF WELDING STATION

## FILTROVENTILATION EQUIPMENT

05.2

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## ▼ 1. EXTRACTION ARMS



### MOSTAIR KUARM extraction arms

**NEW**  
*in offer*



Flexible extraction arm.

Ball bearing extraction arm with external middle hinge. The removable hood has a safety mesh and a damper. The arm is 360° rotatable.

The MOSTAIR KUARM-160 arm is available in two different types:

- type H: for hanging mounting (wall bracket included),
- type S: for standing mounting (e.g. on a mobile unit).

The MOSTAIR KUARM-160 is intended to be used for the following applications:

- MIG-MAG/GMAW welding,
- TIG welding,
- FCAW welding,
- stick/MMAW welding.

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Type	MOSTAIR KUARM-160
Diameter of the arm	160 mm
Maximum air flow	1200 m <sup>3</sup> /h
Arm length	2/3 m
Possible assembly on the device/table	Yes
Wall assembly possibility	Yes
Possible assembly on an extension arm	Yes
Support console included	Yes
Damper in extraction unit	Yes
Additional lighting can be installed	Yes
ATEX version	No
Catalogue No.	
MOSTAIR KUARM 2 m S Ø160 mm	E0 00 121106
MOSTAIR KUARM 3 m S Ø160 mm	E0 00 111116
MOSTAIR KUARM 4 m S Ø160 mm	E0 00 111117
MOSTAIR KUARM 2 m H Ø160 mm	E0 00 121107
MOSTAIR KUARM 3 m H Ø160 mm	E0 00 121108
MOSTAIR KUARM 4 m H Ø160 mm	E0 00 121109

H = hanging version (wall bracket included); S = standing version;

\*other type of arms on request

## ▼ 2. MOBILE EXTRACTION UNITS



### MOSTAIR mobile welding fume extractor

The MOSTAIR PRO is a mobile welding fume filter with built-in fan. The highly efficient filter cartridge is self-cleaning by the integrated RamAir™ pulse amplifier, based on external compressed air supply. Thanks to the four transport wheels (two of which are swivel casters with brake), the MOSTAIR PRO is suitable for use in relatively small facilities or near sources of pollution without a fixed location. The extraction arm is to be selected and ordered separately.

The MOSTAIR PRO is intended to be used for the following applications:

- MIG-MAG/GMAW welding,
- TIG welding,
- FCAW welding,
- stick/MMAW welding.

MOSTAIR Go is available in 2 versions: MOSTAIR Go and MOSTAIR GoPlus. The fume extractor is always combined with an extraction arm. The arms are available in 2 and 3 meter (6.5 and 10 ft) length, depending on the size of your workpiece and navigation through your workshop. Both Go extractors have an acoustic 'filter full' alarm and an integrated spark deflection plate for enhanced safety. The units also have a service indicator that shows when the filter needs to be replaced.

The MOSTAIR Go & GoPlus units are entry level extractors. It has been designed for the consumption of approx. 1 coil of solid wire or 7,5 kg (16½ lbs) of electrodes per month and TIG welding. The cartridge filter is not regenerable, is disposal.



MOSTAIR PRO



MOSTAIR GO PLUS



MOSTAIR GO

Type of device	MOSTAIR PRO	MOSTAIR GO PLUS	MOSTAIR GO
Intensity of work	large	low to average	low to average
Maximum air flow	950 m³/h - 1200 m³/h	850 m³/h - 1000 m³/h	850 m³/h - 1000 m³/h
Diameter of the arm	Ø160 mm	Ø160 mm	Ø160 mm
Power supply	400 V	230 V	230 V
Engine power	1,1 kW	1,1 kW	1,1 kW
Pre-filter surface	No	1m²	1m²
Main filter surface	20 m²	26 m²	15 m²
Cartridge type	cylindrical	cassette	cassette
Cleaning method	automatic	No	No
Filter indicator/air flow rate	Yes	Yes	Yes
Dimensions without arm (L x W x H)	646 x 1150 x 1024 mm	725 x 730 x 1100 mm	725 x 730 x 1100 mm
Possible arm lengths	3/4 m	2/3 m	2/3 m
Weight without arm	169 kg	84 kg	84 kg
Noise level	72 dB (A)	67 dB (A)	67 dB (A)
Estimation of consume welding wire/electrodes**	>60/30 kg	<60/30 kg	<60/30 kg
Catalogue No.	E0 00 111115	E0 00 304507	E0 00 304505
<b>Extraction arms Catalogue No.</b>			
MOSTAIR KUARM 2 m S Ø160 mm	E0 00 121106	E0 00 121106	-
MOSTAIR KUARM 3 m S Ø160 mm	E0 00 111116	E0 00 111116	-
MOSTAIR KUARM 4 m S Ø160 mm	E0 00 111117	-	-
MOSTAIR EARM 2 m S Ø160 mm	E0 00 121110	-	E0 00 121110
MOSTAIR EARM 3 m S Ø160 mm	E0 00 121111	-	E0 00 121111

\*\*Welded material per month on working station, assuming the filter is used during one year.

We offer filter cartridges for many applications. If you are interested, please send your inquiry to: [export@rywal.com.pl](mailto:export@rywal.com.pl)





**Prime 2**



The PRIME filter unit series is compact and mobile, used for extraction of harmful gases and smoke during welding. Filter cartridges are optionally cleaned with a Pulse jet. Manual control of the unit.

- Suitable for use in processing high alloy steels (Cr-Ni) according to DIN EN ISO 15012.
- Compact mobile filtration unit for dust and fume extraction during welding process.
- PTFE membrane cartridge filter for ultra fine dust filtration 10 m<sup>2</sup>.
- Delivered standard with 2 flexible extraction arm length 3 m.

Type of device	PRIME 2
Motor power	2,2 kW
Power supply	400 V / 50 Hz
Capacity	1500 m <sup>3</sup> /h
Filter surface	10 m <sup>2</sup>
Cleaning cartridge	PULSE JET Timer
Air	5 - 6 bar
Dimensions (WxHxC)	857x1313x1119 mm
Catalogue No.	EX 60 001075

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### ▼ 3. STATIONARY FILTER UNITS



#### MOSTAIR TFK V - Cartridge filter

TFK V - is a filter unit equipped with filter cartridges, and is suitable for smoke extraction and filtration during welding, plasma cutting and laser.

The filter can be used in the workspace and filtered air can be returned back to the production hall, which allows us to save energy. The filter contains an prechamber where we separate coarse particles, which fall into the first dust tank. The particles continue further into the maze where the highly efficient filter cartridges are located and all the particles end up in a second dust tank. The high-efficiency fan is located at the top of the unit to ensure high suction capacity and a compact design, as well as low noise.

##### Standard characteristics:

- Designed and produced according to DIN EN ISO 15012-1.
- Guarantees safe return of air to the workspace, separation class W3 according to ISO 15012.
- Compact and robust design.
- Filter material: 100% Polyester PTFE, PTFE mem., antistatic.
- Cleaning system - Pulse Jet.

##### Additional equipment:

- spark arrester,
- filter regulator,
- start/stop box,
- frequent inverter,
- special bags for dust and dirt,
- motor valves.



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Type of device	TFK-V-10	TFK-V-20	TFK-V-30	TFK-V-40	TFK-V-40s
Motor power	2,2 kW	2,2 kW	2,2 kW	4 kW	3 kW
Cartridge nr.	1	2	3	4	4
Filter surface	18,5 m <sup>2</sup>	37 m <sup>2</sup>	55,5 m <sup>2</sup>	74 m <sup>2</sup>	74 m <sup>2</sup>
Air Flow	2200 m <sup>3</sup> /h	2200 m <sup>3</sup> /h	2200 m <sup>3</sup> /h	3600 m <sup>3</sup> /h	2900 m <sup>3</sup> /h
Pressure	1900 Pa	1900 Pa	1850 Pa	2400 Pa	2195 Pa
Pulse Jet	yes	yes	yes	yes	yes
Dimensions (WxDxH)	855x765x2360 mm	855x1140x2365 mm	949x1200x2630 mm	949x1200x2630 mm	949x1200x2630 mm
Weight	400 kg	450 kg	565 kg	555 kg	600 kg

Type of device	TFK-V-60	TFK-V-60s	TFK-V-80	TFK-V-90	TFK-V-90s
Motor power	5,5 kW	7,5 kW	11 kW	15 kW	22 kW
Cartridge nr.	6	6	8	9	9
Filter surface	111 m <sup>2</sup>	111 m <sup>2</sup>	148 m <sup>2</sup>	166,5 m <sup>2</sup>	166,5 m <sup>2</sup>
Air Flow	4300 m <sup>3</sup> /h	5500 m <sup>3</sup> /h	8000 m <sup>3</sup> /h	11500 m <sup>3</sup> /h	12500 m <sup>3</sup> /h
Pressure	3000 Pa	3000 Pa	3500 Pa	3000 Pa	4200 Pa
Pulse Jet	yes	yes	yes	yes	yes
Dimensions (WxDxH)	949x1585x2630 mm	949x1585x2630 mm	1380x1585x2710 mm	1380x1585x2710 mm	1380x1585x2950 mm
Weight	780 kg	675 kg	945 kg	975 kg	1035 kg



## MAESTRAL MS



Plug&Play welding shop filtration unit.

**Product specification:**

- For the purification of polluted air in large spaces, when welding large and complex metal structures where local suction is not possible.
- MAESTRAL needs to be put in the center of the work area, without connection to the pipeline.
- The fine particles are separated by dust class M filter cartridges.
- Cleaning system - Pulse Jet.
- MS filter tower systems are delivered ready to work (Plug & Play) which eliminates expensive installations.

Type of device	MAESTRAL MS-6500	MAESTRAL MS-10000	MAESTRAL MS-15000	MAESTRAL MS-20000
Motor	5,5 kW	7,5 kW	11 kW	15 kW
Air flow	6500 m³/h	10000 m³/h	15000 m³/h	20000 m³/h
Fan pressure	1800 Pa	1800 Pa	1800 Pa	1800 Pa
Filtering surface	75 m²	100 m²	150 m²	225 m²
Number of cartridges	3	4	6	9
Dimensions (WxDxH)	1410x1200x3105 mm	1410x1200x31055 mm	1810x1585x33405 mm	2240x1585x33405 mm
Weight	1200 kg	1300 kg	1400 kg	1500 kg

## TFV



Individual filter unit with fan integrated for one or two welding spots.

**Product specification:**

- Designed and produced according to DIN EN ISO 15012.
- For the extraction of harmful fumes generated by welding.
- Ideal when you need a smaller unit and when it is possible to mount the unit on the wall.
- PTFE membrane cartridge filter for ultra fine dust filtration.
- Possibility of installing two extraction arms on a single unit.

Type of device	TFV 1,1	TFV 1,5
Nominal fan power	1, 1 kW	2,2 kW
Airflow	1.500 - 2.200 m³/h	
Number of filtering cartridges	1	
Cleaning	Manual	
Sound Level	≥ 78 db(A)	
Dimensions	738 x 645 x 1287 mm	
Weight	100 kg	
Possible number of arms	1	2

\*arms not included

## TFG-K



TFG-K is suction series of grinding tables, meets high industry standard of filtering efficiency. The table removes smoke and particles from the working zone where the workers breathe and work. The fan mounted in the housing guarantees high airflow, high quality suction and low noise level. With built-in cartridges and fans there is no need for additional piping and filter units. It is easy to maintain and transport from one job to another. Dust collector is at the bottom of the suction table, and we use them to collect the dust particles. The sides can be opened to extend the desk surface.

**Product specification:**

- Integrated filter unit.
- Dust drawer is located in the bottom of the table.
- Side panels can be dissolved for extension of workspace.
- Available in three standard sizes.

Type of device	TFG - K 800	TFG - K 1300	TFG - K 1600	TFG - K 2000	TFG - K 2400
Dimensions	894x1136x1560 mm	1394x1136x1560 mm	1694x1136x1560 mm	2094x1136x1560 mm	2494x1136x1560 mm
Airflow	4000 m³/h	4700 m³/h	4700 m³/h	4900 m³/h	5900 m³/h
Weight	460 kg	642 kg	750 kg	783 kg	880 kg



## TEHJET

TEHJET is used in workshops where local exhaust ventilation is not possible. Its use is to complement local exhaust ventilation system. TEHJET is good for environments with changing sources of smoke and dust and for large work pieces or where work positions are well separated.

### Applications:

- Suitable for dry, pourable types of dust.
- Central extraction of multiple dust generating machines.

### Benefits:

- Low operating cost due to cleanable filter cartridges.
- Customer specific design.
- Suitable for most types of dust.

### Optional:

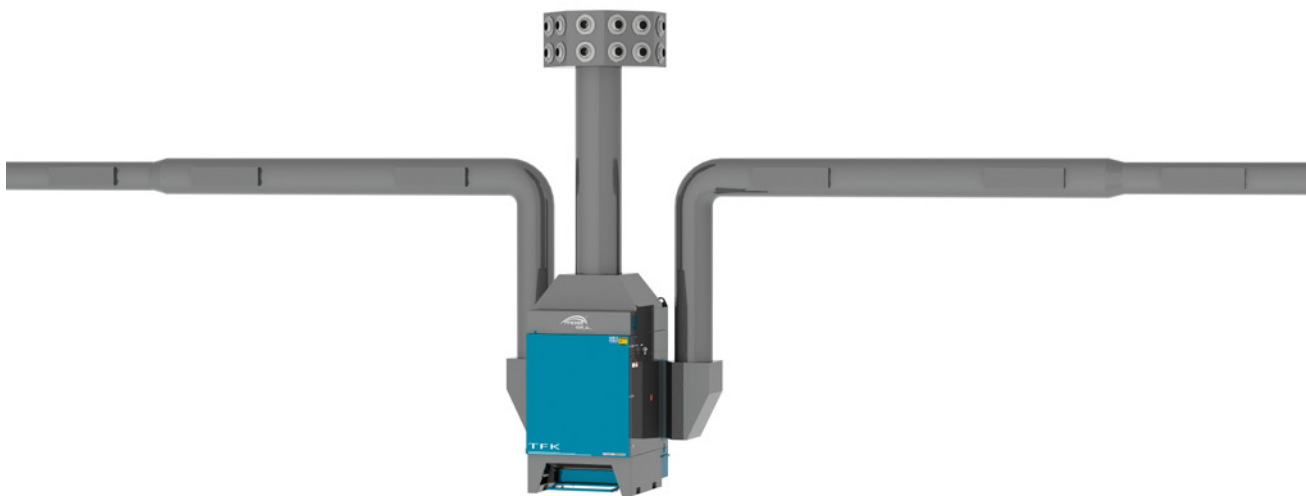
- Variable frequency drive-airflow regulation.
- Automatic start/stop.
- Smart controller.
- Special painting.

Type of device	TEHJET 8000	TEHJET 13000	TEHJET 18000
Motor power	7,5 kW	11 kW	15 kW
Air flow	8000 m <sup>3</sup> /h	13000 m <sup>3</sup> /h	18000 m <sup>3</sup> /h
Pressure	2400 Pa	2000 Pa	2000 Pa
Pulse Jet	yes	yes	yes
Filtering surface	111 m <sup>2</sup>	148 m <sup>2</sup>	166,5 m <sup>2</sup>
Number of cartridges	6	8	9
Dimensions (WxDxH)	1265x1585x6540 mm	1690x1585x6540 mm	1690x1585x6540 mm
Weight	950 kg	1150 kg	1200 kg

**NEW**  
in offer



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## ▼ 4. INDUSTRIAL VACUUM CLEANERS



### MOSTAIR VAC



#### M65/100 JET CLEAN

- compact design,
- large filter area,
- integrated cartridge cleaning system.

The quick release container system makes the M65 / 100 JetClean the ideal single-phase vacuum cleaner for industrial applications. The JetClean® version is equipped with a new system that allows you to clean the cartridge by closing the inlet and opening the filter flap. The vacuum system pushes the air flow from outside through the cartridge, ensuring effective and safe cleaning of the filter unit.

VAC M65 JET

HIT

Type of device	VAC ECO 1	VAC ECO 3	VAC M65 JET	VAC M100 JET	VAC FOX 5,5P	VAC FOX 5,5S	VAC OIL 100
<b>Fan type</b>	Side-channel blower		3 engine / By-Pass		Side-channel blower		Side-channel blower
<b>Engine power</b>	2,2 kW	3 kW	3,9 kW	3,9 kW	4 kW	4,3 kW	3 kW
<b>Voltage</b>	230 V	400 V	230 V	230 V	400 V	400 V	400 V
<b>Max efficiency</b>	350 m³/h	420 m³/h	570 m³/h	570 m³/h	520 m³/h	320 m³/h	420 m³/h
<b>Max vacuum</b>	230 mBar	310 mBar	250 mBar	250 mBar	250 mBar	430 mBar	320 mBar
<b>Vacuum inlet</b>	70 mm	70 mm	50 mm	50 mm	80 mm	80 mm	50 mm
<b>Noise level</b>	72 dB	72 dB	72 dB	72 dB	76 dB	76 dB	78 dB
<b>Filtration class</b>	M	M	M	M	M	M	-
<b>Cleaning of cartridge</b>	manual	manual	Jet Clean	Jet Clean	manual	manual	-
<b>Tank capacity</b>	65 L	65 L	65 L	100 L	100 L	100 L	100 L
<b>Weight</b>	90 kg	95 kg	80 kg	80 kg	155 kg	155 kg	110 kg
<b>Catalogue No.</b>	ED 00 001986	ED 00 03995	ED 00 000065	ED 00 000100	ED 00 055134	ED 00 055159	ED 00 100450

Each vacuum cleaner contains a basic cleaning kit – Tubes and connections.

## ▼ 5. WELDING TEABLES WITH VENTILATION



The extraction system removes fumes and dusts directly from the welder's breathing zone through the work surface. A special spark arrestor under the work surface ensures safety by preventing sparks from entering the filter cartridges.

Inside the unit, filtration is carried out through two oval filter cartridges with a total surface area of 52 m<sup>2</sup>.

They cover a large filter area, resulting in a long filter life. This means less frequent maintenance and reduces overall operating costs.

### MOST DraftMax Basic & DraftMax Ultra

The **MOST DraftMax Basic** is a worktable that provides extraction and filtration for welding and grinding applications. The DraftMax Basic features a work grille, a three-stage pre-filtration system for optimal spark retention, and two disposable main filter cartridges. Both filters have pull-out dust drawers underneath. An indicator on the control panel indicates when the filter cartridges need replacing. The working height of the downdraft table is adjustable. Filter replacement and service can be performed from the front.

**Recommended for:**

- Occasional to daily usage.
- Light applications like grinding, cutting and TIG welding.
- Small workshops.
- Welding schools.

**The MOST DraftMax Basic we offer as Kit consist of:**

- A - Silencer/Outlet duct
- B - Backdraft kit
- C - Side panels
- D - Work grid
- E - DraftMax | Downdraft table

**Optionally:**

- F - HEPA kit

The **MOST DraftMax Ultra** is a worktable that provides extraction and filtration for welding and grinding applications. The DraftMax Ultra features a work grille, a three-stage pre-filtration system for optimal spark retention, and two self-cleaning main filter cartridges. Both drawers are located underneath. The filter cleaning system activates when the pressure drops, and the main filters have ejectable dust bins when they reach a certain maximum value during use (online cleaning). The filter cartridges are individually cleaned from the inside with compressed air. An integrated buzzer indicates when the filter cartridges need to be replaced.

**Recommended for:**

- Occasional to daily heavy-duty usage.
- Professional welders.
- Stainless steel welding with HEPA filter.

**The MOST DraftMax Ultra we offer as Kit consist of:**

- A - Silencer/Outlet duct
- B - Backdraft kit
- C - Side panels
- D - Work grid
- E - DraftMax | Downdraft table

**Optionally:**

- F - HEPA kit



05.2

Type of device	MOST DraftMax Basic Kit	MOST DraftMax Ultra Kit
Maximum capacity	2500 m <sup>3</sup> /h	3000 m <sup>3</sup> /h
Connection diameter	160 mm	160 mm
Maximum compression	2600 Pa	2600 Pa
Power supply	400 V/3~/50 Hz	400 V/3~/50 Hz
Motor power	2,2 kW	2,2 kW
Number of filter cartridges	2 pcs.	2 pcs.
Filtration efficiency	>99,9%	>99,9%
Filtering surface	2 x 26 m <sup>2</sup>	2 x 26 m <sup>2</sup>
Automatic cleaning of the cartridges	No	Yes
Volume of the dust container	90 l	90 l
Dimensions (L x W x H)	1380 x 1005 x 1570 mm	1380 x 1005 x 1570 mm
Dimensions of the working surface (L x W)	1366 x 750 mm	1366 x 750 mm
Weight	245 kg	255 kg
Maximum load on legs/wheels	200/150 kg	200/150 kg
Noise level	69 dB (A)	69 dB (A)
Catalogue No.	E0 00 121112	E0 00 121113

# 05.3



# COMPREHENSIVE EQUIPMENT OF WELDING STATION

## 3D CLAMPING TECHNIQUE

### TABLE OF CONTENT

---

1. Original 3D assembly and welding tables, modular clamping system . . . . .	198
2. Industrial magnetic tools . . . . .	223
3. Manual steel screw clamps . . . . .	228



## ▼ 1. ORIGINAL 3D ASSEMBLY AND WELDING TABLES, MODULAR CLAMPING SYSTEM



More technical data  
and full offer  
Demmeler catalogue 2022 (EN)

Scan the link or go to  
<https://www.rywal.eu/i053-14>

### Wide range of assembly and welding tables and accessories

- Modular clamping system.
- For every application.
- Optimal 3D welding worktable with clamping system increases productivity.

#### Table Worktop:

- SOLID – High-strength base material
- Hardened DEMONT 760M
- Tool steel up to 760 Vickers
- Hardened DEMONT 860M
- High-alloy tool steel up to 860 Vickers



#### Unlimited possibilities of use of accessories or tools:

- PROFIEcoLINE PE 28, 16
- PROFIPlusLINE PL 28, 22, 16
- PROFIPremiumLINE PP 28



#### System bores

Variety of choice, depending on the application  
and the product dimensions:

- System **28** see page 202
- System **22** see page 212
- System **16** see page 216



#### Precision mm scale on the edges of the table



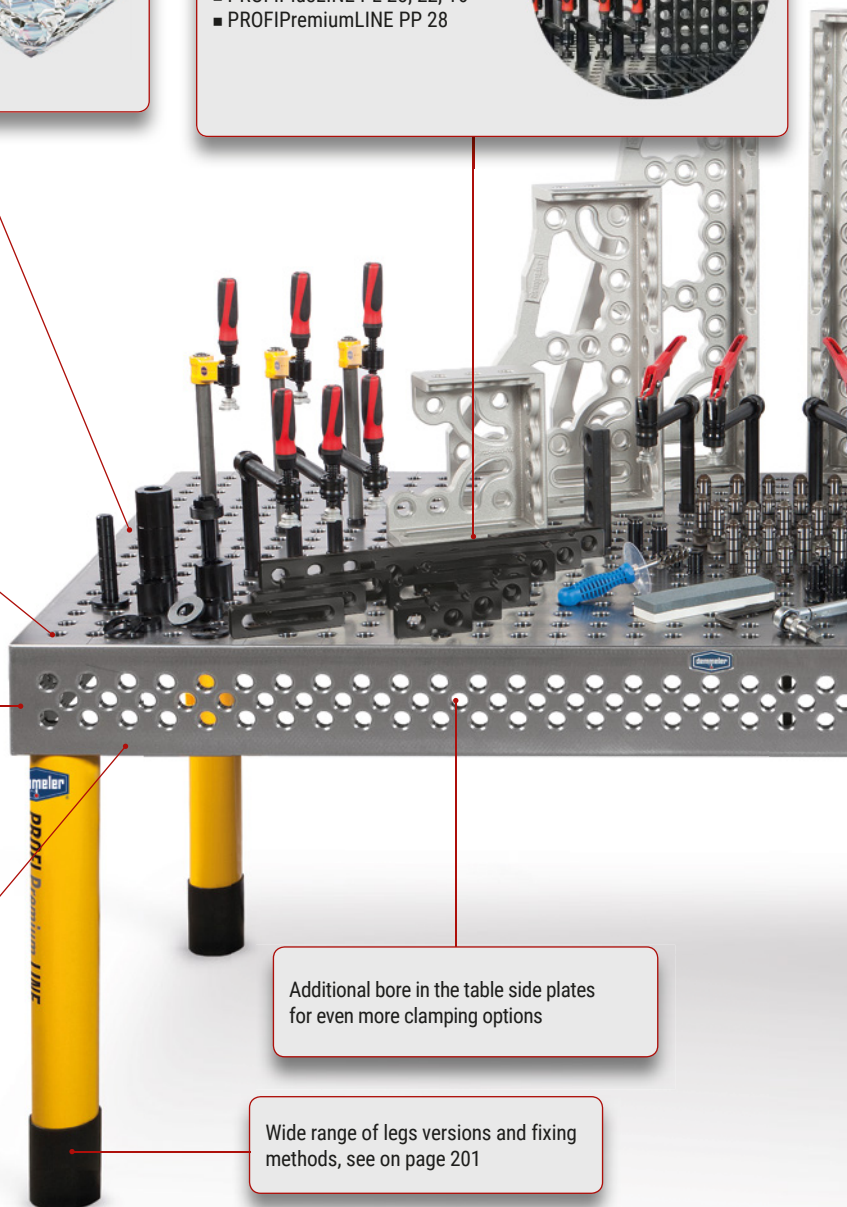
#### System bores / grid:

- PROFIEcoLINE
- PROFIPlusLINE
- PROFIPremiumLINE
- HobbyLINE



Additional bore in the table side plates  
for even more clamping options

Wide range of legs versions and fixing  
methods, see on page 201



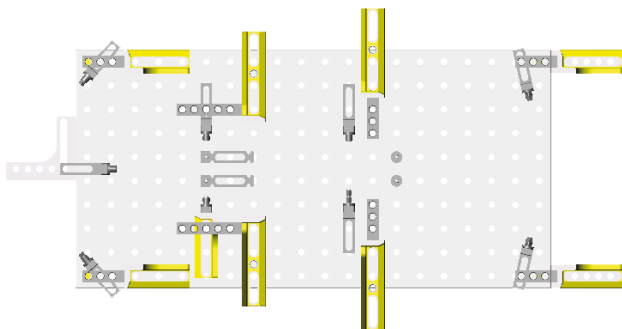
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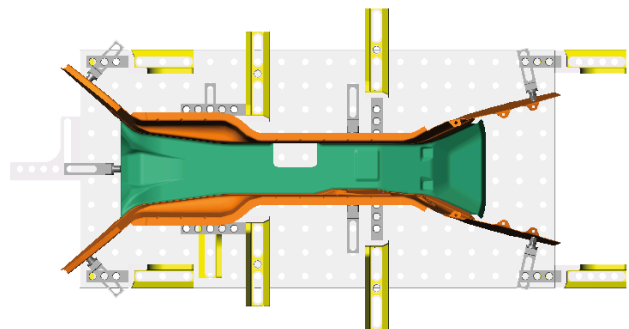
## Design of „ready to use” welding fixtures adapted to the type of production

We offer the service of designing fixture and dedicated tools adapted to the production profile on the basis of a 3D drawing which we receive from Customer. We use the 3D model library of DEMMELER products for designing, which allows:

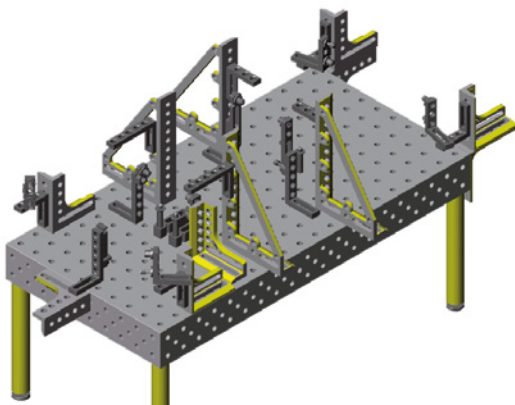
- to select clamps and tools during the design phase,
- to design a specific fixture device,
- to archive all necessary projects.



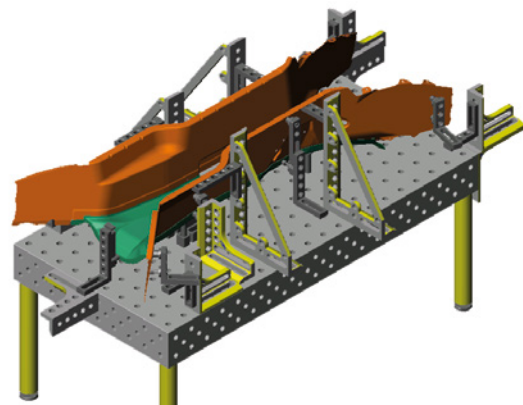
View of the fixture with tools – projection



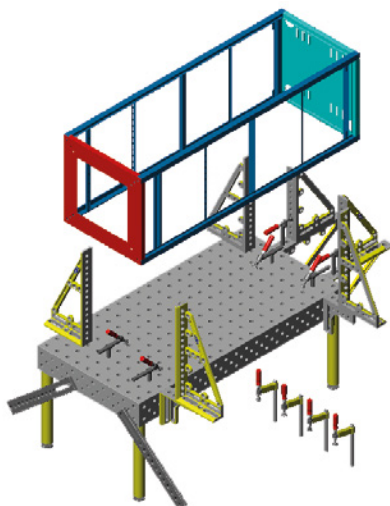
Product in the clamping zone



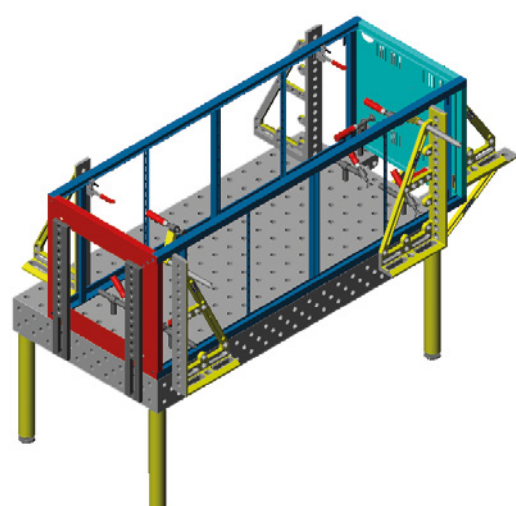
View of the fixture with tools – space drawing



Product during clamping – 3D space drawing



Overview drawing



Overview drawing



### Selection of the worktops and system bores depending on the production profile and material

Name	System	Application	Size of raster /scale	Picture	Dimensions
PROFIEcoLINE (PE28)	28	<ul style="list-style-type: none"> <li>For large and heavy structures</li> <li>For everyday welding work</li> </ul>	<ul style="list-style-type: none"> <li>Grid 100x100 mm</li> <li>3-hole drilling pattern in the table side plates, 50 mm grid in the top row and 100 mm in the middle and bottom rows</li> </ul>		
PROFIPlusLINE (PL28)	28	<ul style="list-style-type: none"> <li>For large and heavy structures</li> <li>For everyday welding work</li> <li>Greater possibilities of tooling construction</li> </ul>	<ul style="list-style-type: none"> <li>Diagonal Grid 100x100 mm</li> <li>3-hole drilling pattern in the table side plates, 50 mm grid in the top row and 100 mm in the middle and bottom rows</li> </ul>		
PROFIPremiumLINE (PP28)	28	<ul style="list-style-type: none"> <li>For large and heavy structures</li> <li>For everyday welding work</li> <li>Unlimited possibilities of tooling construction</li> </ul>	<ul style="list-style-type: none"> <li>Grid 50x50 mm</li> <li>3-hole drilling pattern in the table side plates, 50 mm grid in the top and bottom rows and 100 mm in the middle row</li> </ul>		
HobbyLINE (H28)	28	<ul style="list-style-type: none"> <li>For light structures</li> <li>For everyday welding work</li> <li>For workshops, garages and schools</li> </ul>	<ul style="list-style-type: none"> <li>Grid 100x100 mm</li> <li>Worktop approx. 25 mm high with D28 system bores</li> </ul>		
PROFIPlusLINE (PL22)	22	<ul style="list-style-type: none"> <li>For light and medium-duty applications</li> <li>For single-unit production</li> </ul>	<ul style="list-style-type: none"> <li>Diagonal Grid 100x100 mm</li> <li>2-hole drilling pattern in the table side plates with D22 system bores in 50 mm grid</li> </ul>		
PROFIPremiumLINE (PP22)	22	<ul style="list-style-type: none"> <li>For light and medium-duty applications</li> <li>For small fixing distances</li> </ul>	<ul style="list-style-type: none"> <li>Grid 50x50 mm</li> <li>3-hole drilling pattern in the table side plates with D22 system bores in 50 mm diagonal grid</li> </ul>		
PROFIEcoLINE (PE16)	16	<ul style="list-style-type: none"> <li>For delicate applications</li> <li>For everyday welding work</li> <li>For small dimensions</li> </ul>	<ul style="list-style-type: none"> <li>Grid 50x50 mm</li> <li>3-hole drilling pattern in the table side plates with D16 system bores in 50 mm diagonal grid</li> </ul>		
PROFIPlusLINE (PL16)	16	<ul style="list-style-type: none"> <li>For delicate applications</li> <li>For everyday welding work</li> <li>Greater possibilities of tooling construction</li> </ul>	<ul style="list-style-type: none"> <li>Diagonal Grid 50x50 mm</li> <li>3-hole drilling pattern in the table side plates with D16 system bores in 50 mm diagonal grid</li> </ul>		



## Types of legs



### Standard leg

- Pivoting feet  $\pm 30$  mm fine adjustable.
- Stable M30 threaded spindle.
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly.
- Also suitable as supporting leg in connection with over-hung U-form, length 1 m and up.
- Including countersunk M24 x 60 mounting screw.
- Powder-coated.



### Telescoping leg

- Pivoting feet  $\pm 30$  mm fine adjustable.
- Stable M30 threaded spindle.
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly.
- Telescope adjustment range 350 mm in 50-mm increments.
- For flexible height adjustment of the worktable.
- Including countersunk M24 x 60 mounting screw.
- Powder-coated.



### Heavy-Duty wheel

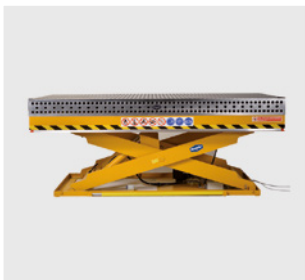
- Fine adjustable  $\pm 30$  mm.
- Stable M30 threaded spindle.
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly.
- Robust version.
- With 360° castor.
- Max. load capacity 600 kg.
- Including countersunk M24 x 60 mounting screw.
- Powder-coated.



### Anchoring leg

- Fine adjustable  $\pm 30$  mm.
- Stable M30 threaded spindle.
- Foot sleeve protects the threaded spindle against dirt and prevents pinching the cable-hose assembly.
- For firm attachment to the hall floor against tension, pressure and shifting (e.g. robot use).
- Including countersunk M24x60 mounting screw.
- For firm anchoring to the floor.
- 2x drop-in anchor, 2x cap screw M16x40.
- Powder-coated.

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### Scissor lift

- Continuously variable height adjustment.
- With safety shutdown board.
- Fully adapted to 3D worktable D28.
- Including hand control.
- Power unit internal / external depending on size.
- Available for D28.



### Holding frame

- Exact positioning of 3D worktables is possible using provided legs or in lengthwise and crosswise direction on the support and foundation track.
- Available for D28.



### Table leg for spacer block

- Connecting elements between spacer block U-form or 3D worktable and support and base rail.
- Different setup heights can be adapted to the work piece by simply exchanging the table legs.
- Available for D28.



### Shifting foot with casters

- Moving installed system components is possible without using hoisting equipment or a crane.
- Different setup heights can be adapted to the work piece by simply exchanging the table legs.
- Highest load capacity in the working position thanks to full surface support of the foot on the rails.
- Available for D28.



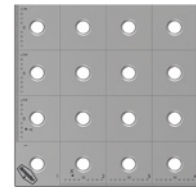


### 3D PROFIEcoLINE table (PE28)

28 System



- Worktop with system bores D28 in a double 100 x 100 mm grid.
- 3-hole drilling pattern in the table side plates, with D28 system bores in 50 mm grid in the top row and 100 mm in the middle and bottom rows, which greatly increases expansion and clamping options.
- All table sizes optionally available in hardened version DEMONT 760 M and DEMONT 860 M.
- All system bores with a new protective countersink, perfect design and ultimate functionality.
- Optimized, outside table edges.
- Improved table reinforcement with additional cross-ribs.
- Continuous gridlines in X and Y-direction over the entire length, 100 mm spacing.
- Precision scaling with millimetre graduation, available in all versions.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment, round design with pivoting foot.



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Worktop PROFIEcoLINE (PE)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	200	330	-	-	PE28-01001-000	PE28-01001-500	PE28-01001-700
	1200	800	200	310	-	-	PE28-11019-000	PE28-11019-500	PE28-11019-700
	1200	1200	200	430	-	-	PE28-01056-000	PE28-01056-500	PE28-01056-700
	1500	1000	200	450	-	-	PE28-01011-000	PE28-01011-500	PE28-01011-700
	1500	1500	200	610	-	-	PE28-01031-000	PE28-01031-500	PE28-01031-700
	2000	1000	200	570	-	-	PE28-01002-000	PE28-01002-500	PE28-01002-700
	2000	2000	200	1100	-	-	PE28-01006-000	PE28-01006-500	PE28-01006-700
	2400	1200	200	820	-	-	PE28-01003-000	PE28-01003-500	PE28-01003-700
	3000	1500	200	1180	-	-	PE28-01004-000	PE28-01004-500	PE28-01004-700
	4000	2000	200	2090	-	-	PE28-01005-000	PE28-01005-500	PE28-01005-700
	4800	2400	200	2980	-	-	PE28-11085-000	PE28-11085-500	PE28-11085-700

Table legs (standard) PROFIEcoLINE (PE)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	850 ±30	364	12 000	4	PE28-01001-001	PE28-01001-011	PE28-01001-021
	1200	800	850 ±30	344	12 000	4	PE28-11019-001	PE28-11019-011	PE28-11019-021
	1200	1200	850 ±30	464	12 000	4	PE28-01056-001	PE28-01056-011	PE28-01056-021
	1500	1000	850 ±30	484	12 000	4	PE28-01011-001	PE28-01011-011	PE28-01011-021
	1500	1500	850 ±30	644	12 000	4	PE28-01031-001	PE28-01031-011	PE28-01031-021
	2000	1000	850 ±30	604	12 000	4	PE28-01002-001	PE28-01002-011	PE28-01002-021
	2000	2000	850 ±30	1134	12 000	4	PE28-01006-001	PE28-01006-011	PE28-01006-021
	2400	1200	850 ±30	854	12 000	4	PE28-01003-001	PE28-01003-011	PE28-01003-021
	3000	1500	850 ±30	1231	18 000	6	PE28-01004-001	PE28-01004-011	PE28-01004-021
	4000	2000	850 ±30	2141	18 000	6	PE28-01005-001	PE28-01005-011	PE28-01005-021
	4800	2400	850 ±30	3074	33 000	11	PE28-11085-001	PE28-11085-011	PE28-11085-021

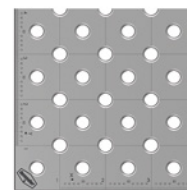


### 3D PROFIPlusLINE table (PL28)

28 System



- Worktop with system bores D28 in a double 100 x 100 mm grid, which gives about 80% more clamping options than PROFIEcoLINE and typical welding tables.
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows and 100 mm in the middle row, which nearly doubles the expansion and clamping options.
- All table sizes optionally available in hardened version DEMONT 760 M and DEMONT 860 M.
- All system bores with a new protective countersink, perfect design and ultimate functionality.
- Optimized, outside table edges.
- Improved table reinforcement with additional cross-ribs.
- Continuous gridlines in X and Y-direction over the entire length, 100 mm spacing.
- Precision scaling with millimetre graduation, available in all versions.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment, round design with pivoting foot.



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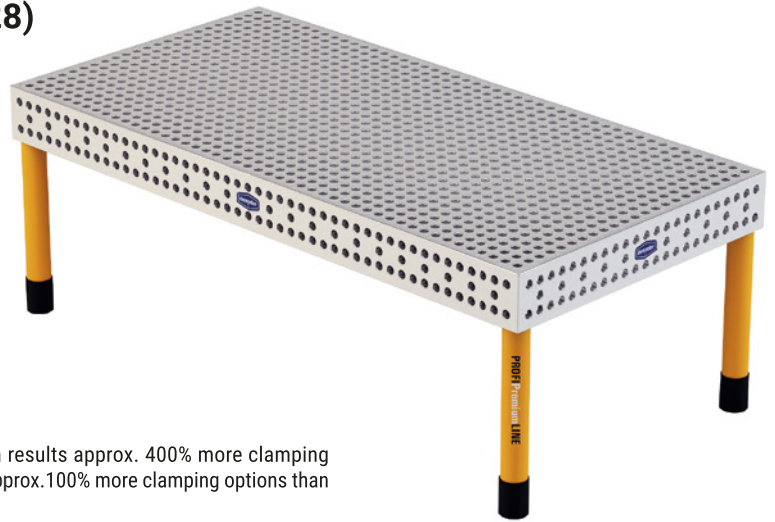
Worktop PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	200	310	-	-	PL28-01001-000	PL28-01001-500	PL28-01001-700
	1200	800	200	300	-	-	PL28-11019-000	PL28-11019-500	PL28-11019-700
	1200	1200	200	410	-	-	PL28-01056-000	PL28-01056-500	PL28-01056-700
	1500	1000	200	430	-	-	PL28-01011-000	PL28-01011-500	PL28-01011-700
	1500	1500	200	590	-	-	PL28-01031-000	PL28-01031-500	PL28-01031-700
	2000	1000	200	550	-	-	PL28-01002-000	PL28-01002-500	PL28-01002-700
	2000	2000	200	1050	-	-	PL28-01006-000	PL28-01006-500	PL28-01006-700
	2400	1200	200	790	-	-	PL28-01003-000	PL28-01003-500	PL28-01003-700
	3000	1500	200	1150	-	-	PL28-01004-000	PL28-01004-500	PL28-01004-700
	4000	2000	200	1980	-	-	PL28-01005-000	PL28-01005-500	PL28-01005-700
4800	2400	200	2830	-	-	PL28-11085-000	PL28-11085-500	PL28-11085-700	

Table legs (standard) PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	850 ±30	344	12 000	4	PL28-01001-001	PL28-01001-011	PL28-01001-021
	1200	800	850 ±30	334	12 000	4	PL28-11019-001	PL28-11019-011	PL28-11019-021
	1200	1200	850 ±30	444	12 000	4	PL28-01056-001	PL28-01056-011	PL28-01056-021
	1500	1000	850 ±30	464	12 000	4	PL28-01011-001	PL28-01011-011	PL28-01011-021
	1500	1500	850 ±30	624	12 000	4	PL28-01031-001	PL28-01031-011	PL28-01031-021
	2000	1000	850 ±30	584	12 000	4	PL28-01002-001	PL28-01002-011	PL28-01002-021
	2000	2000	850 ±30	1084	12 000	4	PL28-01006-001	PL28-01006-011	PL28-01006-021
	2400	1200	850 ±30	824	12 000	4	PL28-01003-001	PL28-01003-011	PL28-01003-021
	3000	1500	850 ±30	1201	18 000	6	PL28-01004-001	PL28-01004-011	PL28-01004-021
	4000	2000	850 ±30	2031	18 000	6	PL28-01005-001	PL28-01005-011	PL28-01005-021
	4800	2400	850 ±30	2925	33 000	11	PL28-11085-001	PL28-11085-011	PL28-11085-021

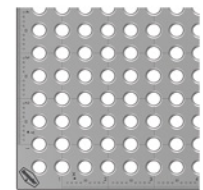


### 3D PROFIPremiumLINE table (PP28)

28 System



- Worktop with system bores D28 in 50 x 50 mm grid, which results approx. 400% more clamping options than PROFIEcoLINE and typical welding tables and approx. 100% more clamping options than PROFIPlusLINE.
- 3-hole drilling pattern in the table side plates with D28 system bores, 50 mm grid in the top and bottom rows and 100 mm in the middle row, which nearly doubles the expansion and clamping options.
- All table sizes optionally available in hardened version DEMONT 760 M and DEMONT 860 M.
- All system bores with a new protective countersink, perfect design and ultimate functionality.
- Optimized, outside table edges.
- Improved table reinforcement with additional cross-ribs.
- Continuous gridlines in X and Y-direction over the entire length, 100 mm spacing.
- Precision scaling with millimetre graduation, available in all versions.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment, round design with pivoting foot.



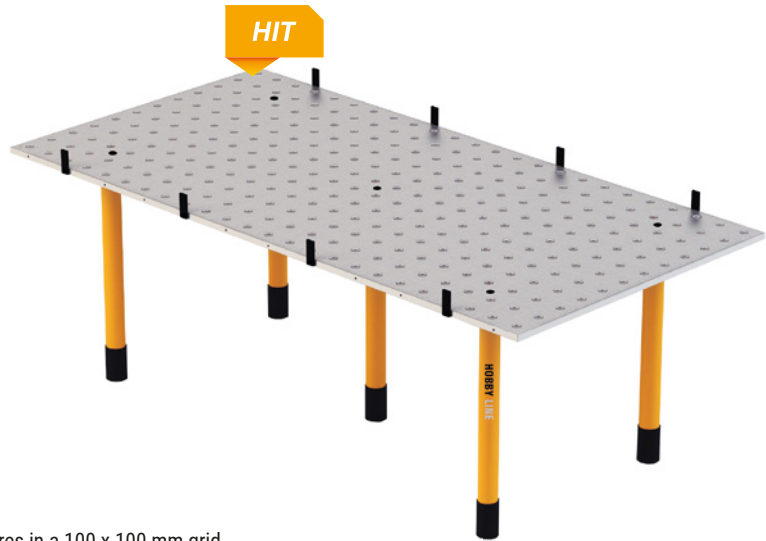
Worktop PROFIPremiumLINE (PP)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	200	290	-	-	PP28-01001-000	PP28-01001-500	PP28-01001-700
	1200	800	200	280	-	-	PP28-11019-000	PP28-11019-500	PP28-11019-700
	1200	1200	200	380	-	-	PP28-01056-000	PP28-01056-500	PP28-01056-700
	1500	1000	200	390	-	-	PP28-01011-000	PP28-01011-500	PP28-01011-700
	1500	1500	200	530	-	-	PP28-01031-000	PP28-01031-500	PP28-01031-700
	2000	1000	200	500	-	-	PP28-01002-000	PP28-01002-500	PP28-01002-700
	2000	2000	200	1000	-	-	PP28-01006-000	PP28-01006-500	PP28-01006-700
	2400	1200	200	710	-	-	PP28-01003-000	PP28-01003-500	PP28-01003-700
	3000	1500	200	1010	-	-	PP28-01004-000	PP28-01004-500	PP28-01004-700
	4000	2000	200	1780	-	-	PP28-01005-000	PP28-01005-500	PP28-01005-700
4800	2400	200	2550	-	-	PP28-11085-000	PP28-11085-500	PP28-11085-700	

Table legs standard PROFIPremiumLINE (PP)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number		
							Standard	Hardened DEMONT 760 M	Hardened DEMONT 860 M
	1000	1000	850 ±30	324	12 000	4	PP28-01001-001	PP28-01001-011	PP28-01001-021
	1200	800	850 ±30	314	12 000	4	PP28-11019-001	PP28-11019-011	PP28-11019-021
	1200	1200	850 ±30	414	12 000	4	PP28-01056-001	PP28-01056-011	PP28-01056-021
	1500	1000	850 ±30	424	12 000	4	PP28-01011-001	PP28-01011-011	PP28-01011-021
	1500	1500	850 ±30	564	12 000	4	PP28-01031-001	PP28-01031-011	PP28-01031-021
	2000	1000	850 ±30	534	12 000	4	PP28-01002-001	PP28-01002-011	PP28-01002-021
	2000	2000	850 ±30	1034	12 000	4	PP28-01006-001	PP28-01006-011	PP28-01006-021
	2400	1200	850 ±30	744	12 000	4	PP28-01003-001	PP28-01003-011	PP28-01003-021
	3000	1500	850 ±30	1061	18 000	6	PP28-01004-001	PP28-01004-011	PP28-01004-021
	4000	2000	850 ±30	1831	18 000	6	PP28-01005-001	PP28-01005-011	PP28-01005-021
	4800	2400	850 ±30	2644	33 000	11	PP28-11085-001	PP28-11085-011	PP28-11085-021

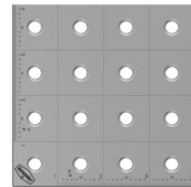


## HobbyLINE worktop (H28)

28 System



- Cost-effective alternative for low loads.
- Worktop approx. in a double 25 mm high with D28 system bores in a 100 x 100 mm grid.
- Accessories for E (EcoLINE), D (PlusLINE), P (PremiumLINE) can be used on the worktop.
- M8 threaded bores on all four sides of the worktop including 8 external stops with screw.
- All system bores with a new protective countersink, perfect design and ultimate functionality.
- Optimized outside table edges.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment, round design with pivoting foot.



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Worktop HobbyLINE (H)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number
							Standard
	1000	1000	25	180	-	-	H28-01001-000
	1200	800	25	180	-	-	H28-11019-000
	1200	1200	25	260	-	-	H28-01056-000
	1500	1000	25	270	-	-	H28-01011-000
	2000	1000	25	360	-	-	H28-01002-000
	2400	1200	25	510	-	-	H28-01003-000

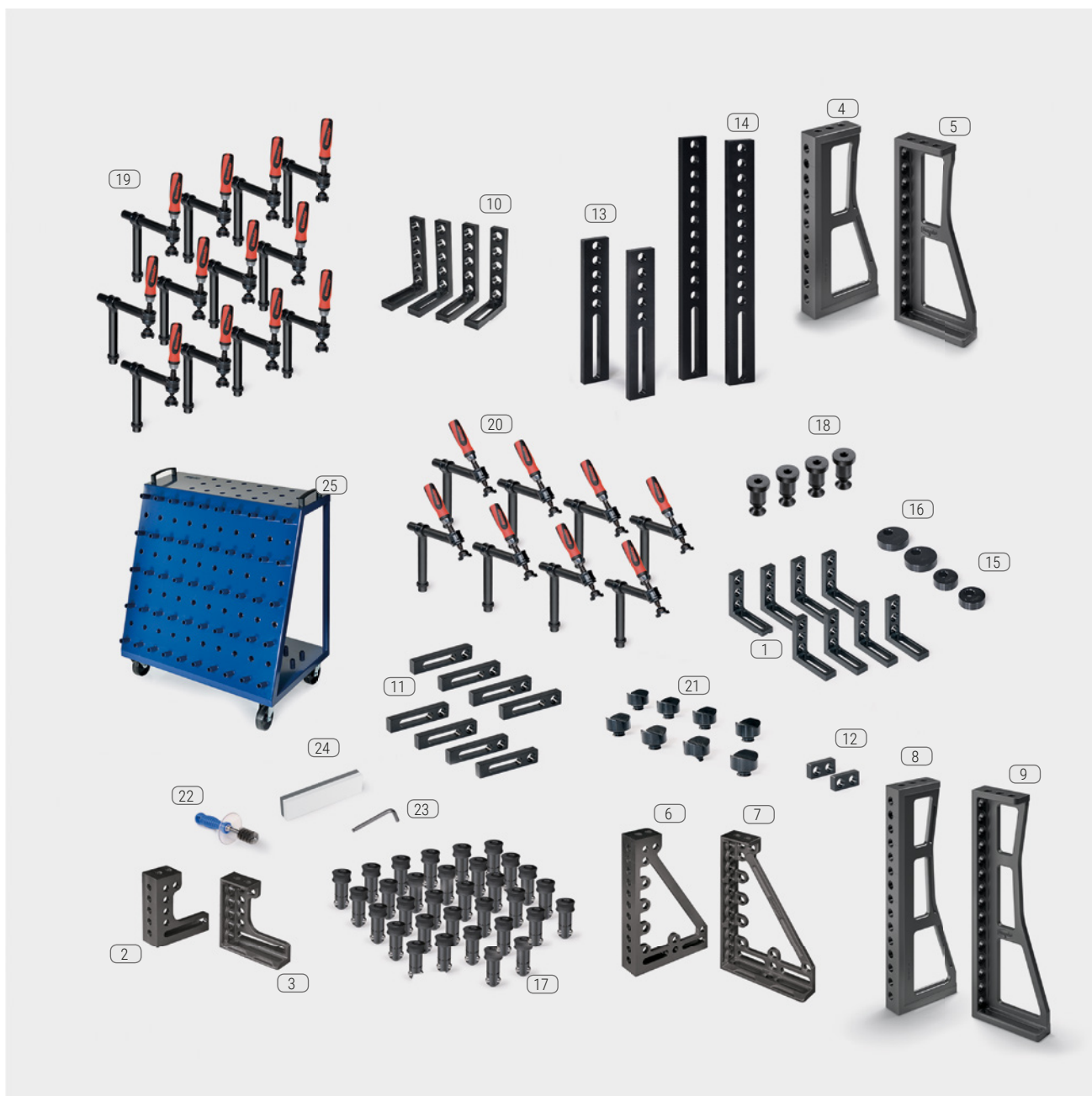
Leg working plate standard HobbyLINE (H)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number
							Standard
	1000	1000	850 ±30	204	600	4	H28-01001-001
	1200	800	850 ±30	204	600	4	H28-11019-001
	1200	1200	850 ±30	284	600	4	H28-01056-001
	1500	1000	850 ±30	300	600	5	H28-01011-001
	2000	1000	850 ±30	390	600	5	H28-01002-001
	2400	1200	850 ±30	540	600	5	H28-01003-001





PROFIEcoLINE sets

28 System



Set name	No. of elements	Manufacturer's item
PROFIEcoLINE E710	32	E28-52000-710
PROFIEcoLINE E720	52	E28-52000-720
PROFIEcoLINE E730	74	E28-52000-730
PROFIEcoLINE E740	104	E28-52000-740



No.	PROFIEcoLINE sets content	E710	E720	E730	E740	Manufacturer's item
1	Clamping and Location Angle 175 x 175 x 50 mm	4	4	4	8	PE28-03001-000
2	Clamping and Location Angle 300 x 275 mm – right		1	1	1	PL28-03002-000
3	Clamping and Location Angle 300 x 275 mm – left		1	1	1	PL28-03002-001
4	PE Clamping and Location Angle 600 x 275 x 80 mm – right			1		PE28-03003-000
5	PE Clamping and Location Angle 600 x 275 x 80 mm – left			1		PE28-03003-001
6	Clamping and Location Angle 600 x 375 mm – right				1	PL28-03003-000
7	Clamping and Location Angle 600 x 375 mm – left				1	PL28-03003-001
8	PE Clamping and Location Angle 800 x 275 x 80 mm – right				1	PE28-03004-000
9	PE Clamping and Location Angle 800 x 275 x 80 mm – left				1	PE28-03004-001
10	Clamping and Location Angle 275 x 175 x 50 mm		2	4	4	PE28-03008-000
11	ECO universal Stop / large 225 x 50 x 25 mm	4	4	8	8	E28-05001-000
12	ECO Universal Stop / small 100 x 50 x 25 mm	2	2	2	2	E28-05002-000
13	ECO Stop-Strip L 500 – 500 x 100 x 25 mm		2	2	2	E28-05003-000
14	ECO Stop- Strip L 800 – 800 x 100 x 25 mm			2	2	E28-05003-001
15	ECO locking disc – 25-50 mm		2	2	2	E28-05013-000
16	ECO locking disc – 25-75 mm	2	2	2	2	E28-05013-001
17	ECO Line bolts / short – Ø28 x 95 mm	12	18	24	32	E28-06001-000
18	ECO connecting bolt with screw and washer – Ø28 x 45 mm				4	E28-06003-000
19	ECO screw clamp 180° with spindle	6	8	10	12	E28-07005-000
20	ECO variable crew clamp 45° with spindle		4	4	8	E28-07009-000
21	ECO V-block location Ø58 mm – 130° – for tubes up to Ø70 mm			4	8	E28-09003-000
22	ECO round brush for holes Ø28 mm	1	1	1	1	E28-10002-000
23	ECO ball-head Allen key AF8	1	1	1	1	E28-10008-000
24	ECO bench stone for cleaning				1	E28-10007-000
25	ECO Tool trolley – W x H x D = 1000 x 650 x 1010 mm				1	E28-11001-000
	<b>Together:</b>	32	52	74	104	

The DEMMELER clamping systems are modular, flexible and compatible. They can be used for all system sizes, on all 3D worktables. The sets can be assembled individually or it is possible to supplement chosen elements with a large selection of DEMMELER accessories!



PROFIplusLINE sets

28 System



Set name	No. of elements	Manufacturer's item
PROFIplusLINE D710	44	D28-52000-710
PROFIplusLINE D720	81	D28-52000-720
PROFIplusLINE D730	120	D28-52000-730
PROFIplusLINE D740	168	D28-52000-740

05.3



No.	PROFIPlusLINE sets content	D710	D720	D730	D740	Manufacturer's item
1	Clamping and location Angle 175 x 175 x 50 mm (hole / slot)	4	4	4	8	PE28-03001-000
2	Clamping and location Angle / small 175 x 75 x 50 mm, scale on both sides		2	4	4	D28-03001-005
3	Clamping and location Angle EN 300 x 275 mm – right		2	1	1	PL28-03002-000
4	Clamping and location Angle EN 300 x 275 mm – left		2	1	1	PL28-03002-001
5	Clamping and location Angle EN 600 x 375 mm – right			1	1	PL28-03003-000
6	Clamping and location Angle EN 600 x 375 mm – left			1	1	PL28-03003-001
7	Clamping and location Angle EN 800 x 375 mm – right				1	PL28-03004-000
8	Clamping and location Angle EN 800 x 375 mm – left				1	PL28-03004-001
9	Universal pivot and tilt angle (0-225°) 475 x 100 x 100 mm – right				1	D28-03007-000
10	Clamping and location Angle 275 x 175 x 50 mm	2	2	4	4	PE28-03008-000
11	Universal Stop / Large 225 x 50 x 25 mm	4	2	4	8	D28-05001-000
12	Stop – Strip L500 – 500 x 100 x 25 mm		4	2	2	D28-05003-000
13	Stop – Strip L800 – 800 x 100 x 25 mm			2	2	D28-05003-001
14	Stop– Strip L1000 – 1000 x 100 x 25 mm				2	D28-05003-008
15	Multi-clamping and support tower Ø55 mm – height 1000 mm				2	D28-05006-000
16	Compensating clamping arm with boring spindle – location Ø55 mm, clamping force 20 kN, AF14				2	D28-05007-000
17	Universal stop L300 – 300 x 50 x 25 mm	2	4	4	4	D28-05009-000
18	Locating disc Ø75 – stop dimension 25-50 mm, continuous			2	2	D28-05013-000
19	Locating disc Ø100 – stop dimension 25-75 mm, continuous		2	2	2	D28-05013-001
20	Angle-setting template, scale on both sides, 0-90°, 15°, 30°, 45°, 60°			2		D28-05013-010
21	Displacement stop – 150 x 50 x 25 mm, scale on both sides	4	4	4	4	D28-05015-000
22	PC-bolt / short – Ø28-0,02, AF 14, clamping range 41-47 mm, 25/200 kN	12	20	24	36	D28-06001-000
23	PC-bolt / long – Ø28-0,02, A F 14, clamping range 66-72 mm, 25/200 kN			2	4	D28-06002-000
24	Stop and positioning bolt Ø28 / 40 x 74 mm	6	10	12	16	D28-06009-000
25	Compensating swing clamp 150 mm with spindle		2	2	2	D28-07001-000
26	Compensating swing clamp 200 mm with spindle	4	2	2	4	D28-07002-000
27	Screw clamp 180° with spindle – vertical tube 220 mm		4	4	4	D28-07005-000
28	Screw clamp 180° with spindle – vertical tube 350 mm		4	4	4	D28-07005-014
29	Screw clamp 180° with quick-action clamping cylinder – vertical tube 350 mm			4	4	D28-07005-015
30	Screw clamp 180° with spindle – vertical tube 500 mm				4	D28-07005-033
31	Vertical screw clamp 90° – vertical tube 260 mm		2	4	4	D28-07008-000
32	Vertical screw clamp 45° with adjusting screw – vertical tube 220 mm	4	4	4	4	D28-07009-000
33	Vertical screw clamp 45° with adjusting screw – vertical tube 350 mm			4	4	D28-07009-011
34	2P clamping bridge with 2 ball pins and 2 steel clamping pads – Ø170 x35 x 35 mm				2	D28-07018-000
35	Spacer set of 11-pieces – Ø50 x 125 mm, height compensation 5-100 mm increment 1 mm		2	2	4	D28-09001-000
36	Spacer set with thread – Ø50 x 125 mm, height compensation 22-105 mm, continuous			2	4	D28-09001-005
37	V-block location blackened steel, Ø58 mm – 130° – for tubes up to Ø70 mm			8	8	D28-09003-000
38	Round hole brush Ø28 x260 mm, with protective cap, for cleaning the system bore	1	1	1	1	D28-10002-000
39	Pump bottle with 1l ecological anti-spatter spray				1	D00-10005-000
40	Bench stone 200x50x25 mm – 2-sided for maintenance of system surface		1	1	1	D00-10007-000
41	Ball end hex wrench AF14 x 150 mm				1	D28-10008-000
42	Ground connector D16/D28 –t for cables 50-70 mm², load up to 500 A			1	1	D00-10009-000
43	Extraction tool – 250 x 40 mm, AF14	1	1	1	1	D00-10016-001
44	Tool trolley – W x H x D = 1000 x 650 x 1010 mm				1	D28-11001-000
	<b>Together:</b>	44	81	120	168	

The DEMMELER clamping systems are modular, flexible and compatible. They can be used for all system sizes, on all 3D worktables. The sets can be assembled individually or it is possible to supplement chosen elements with a large selection of DEMMELER accessories!





PROFIPremiumLINE sets

28 System



Set name	No. of elements	Manufacturer's item
PROFIPremiumLINE P710	46	P28-52000-710
PROFIPremiumLINE P720	77	P28-52000-720
PROFIPremiumLINE P730	122	P28-52000-730
PROFIPremiumLINE P740	158	P28-52000-740



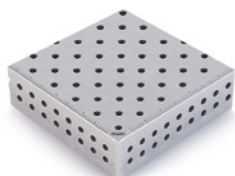
No.	PROFIPremiumLINE sets content	P710	P720	P730	P740	Manufacturer's item
1	PP Clamping and location Angle, right 300 x 275 mm – hardened	1	1	1	1	P28-03002-000
2	PP Clamping and location Angle, left 300 x 275 mm – hardened	1	1	1	1	P28-03002-001
3	PP Clamping and location Angle ALU-TYTAN 600 x 375 mm – right		1	1	1	P28-03003-002
4	PP Clamping and location Angle ALU-TYTAN 600 x 375 mm – left		1	1	1	P28-03003-003
5	Clamping and location Angle 175 x 175 x 50 mm (bore/ oblong hole)	4	4	4	4	PE28-03001-000
6	PP Clamping and location ALU-TYTAN angle 800 x 375 mm – right			1	1	P28-03004-000
7	PP Clamping and location ALU-TYTAN angle 800 x 375 mm – left			1	1	P28-03004-001
8	PP Clamping and location ALU-TYTAN angle 1200 x 375 mm – right				1	P28-03009-000
9	PP Clamping and location ALU-TYTAN angle 1200 x 375 mm – left				1	PL28-03009-001
10	Clamping and location Angle / small 175 x 75 x 50 mm – scale on both sides		2	4	4	D28-03001-005
11	Clamping and location Angle 200 x 225 mm – hardened (bore / bore / oblong hole)			2	2	PL28-03001-015
12	PP Angle bracket, 200 x 200 x 75 mm – hardened right			1		D28-05013-011
13	PP Angle bracket, 200 x 200 x 75 mm – hardened left			1		D28-05013-012
14	Clamping and location Angle , 250x 300 x 50 x 150 mm ALU-TYTAN (bore / bore / oblong hole)		2	2	2	PP28-03001-017
15	PP Angle bracket, 200 x 200 x 75 mm – hardened right				1	P28-05013-011
16	PP Angle bracket, 200 x 200 x 75 mm – hardened left				1	P28-05013-012
17	Universal Pivot and tilt Angle ALU-TYTAN (0-225°) – right				1	D28-03007-004
18	Universal Pivot and tilt Angle ALU-TYTAN (0-225°) – left				1	D28-03007-005
19	Universal stop / large with plunger 225 x 50 x 25 mm			4	4	D28-05001-001
20	Universal stop with a scale 225 x 50 x 25 mm	4	4	4	4	D28-05001-010
21	Stop – strip L500 – 500 x 100 x 25 mm	2	2	2	2	D28-05003-000
22	Stop – strip L800 – 800 x 100 x 25 mm		2	2	2	D28-05003-001
23	Stop – strip L1000 – 1000 x 100 x 25 mm			2	2	D28-05003-008
24	Locating disc Ø75 – stop dimension 25-50 mm, continuous			2	2	D28-05013-000
25	Locating disc Ø100 – stop dimension 25-75 mm, continuous		2	2	2	D28-05013-001
26	Displacement Stop 150 x 50 x 25 mm – scale on both sides	4	4	8	8	D28-05015-000
27	PPC bolt /short- Ø28-0,02, AF 14, full surface support for optimum force transmission	12	20	24	36	D28-06025-000
28	PPC bolt/ long – Ø28-0,02, AF 14, full surface support for optimum force transmission				4	D28-06026-000
29	Stop and positioning bolt Ø28 / 40 x 74 mm	6	10	12	16	D28-06009-000
30	Compensating swing clamp 150 mm with quick- action clamping cylinder			2	2	D28-07001-001
31	Compensating swing clamp 200 mm with spindle	2	2	2	2	D28-07002-000
32	180° screw clamp with spindle – 220 mm vertical	4				D28-07005-000
33	180° screw clamp with spindle – 350 mm vertical tube		4	4	4	D28-07005-014
34	180° screw clamp with quick-action clamping cylinder – vertical tube 350 mm			4	4	D28-07005-015
35	180° screw clamp with spindle – 500 mm vertical tube		4	4	4	D28-07005-033
36	45° variable screw clamp with adjusting screw – 350 mm vertical tube		2	2	2	D28-07009-011
37	45° variable screw clamp with quick-action clamping cylinder – vertical tube 350 mm			2	2	D28-07009-012
38	Performance-clamp including spindle – vertical tube 250 mm, angle-adjustable ±50°	4	4	4	4	D28-07009-033
39	Performance-clamp with quick-action clamping cylinder – vertical tube 250 mm, angle-adjustable ±50°				4	D28-07009-035
40	Spacer Set of 11-pieces – Ø50 x 125 mm, height compensation 5-100 mm increment 1 mm				4	D28-09001-000
41	Spacer set with thread – Ø50 x 125 mm, height compensation 22-105 mm, continuous		2	4	4	D28-09001-005
42	V=Block location blackened Steel, Ø58 mm – 130° – for tubes up to Ø70 mm			8	8	D28-09003-000
43	Round brush Ø28 x260 mm, with protective cap	1	1	1	1	D28-10002-000
44	Pump bottle with 1l ecological anti-spatter spray				1	D00-10005-000
45	Bench stone 200x50x25 mm, 2-sided for cleaning		1	1	1	D00-10007-000
46	Ball and hex wrench AF14x150				1	D28-10008-000
47	Ground connector D16 / D28 – for cables 50-70 mm², load up to 500 A			1	1	D00-10009-000
48	Extraction tool – 250x40 mm, AF14	1	1	1	1	D00-10016-001
49	Tool trolley – W x H x D = 1000 x 650 x 1010 mm				1	D28-11001-000
50	Set of screwdrivers in a carrying case				1	D28-13050-000
	<b>Together:</b>	46	77	122	158	

The DEMMELER clamping systems are modular, flexible and compatible. They can be used for all system sizes, on all 3D worktables. The sets can be assembled individually or it is possible to supplement chosen elements with a large selection of DEMMELER accessories!

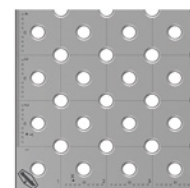


### 3D PROFIPlusLINE table (PL22)

22 System



- Worktop with system bores Ø22 in a 100 x 100 mm diagonal grid.
- 2 rows of holes on the sides of the table with system holes D22 in the grid 50 mm.
- All table sizes available in hardened version DEMONT 760 M.
- All system bores with protective countersink, perfect design and ultimate functionality.
- Optimized, outside table edges.
- Improved table reinforcement through additional cross-ribs.
- Continuous gridlines in X and Y-direction, 100 mm spacing.
- Precision scaling with millimetre division, also available with other version.
- Coordinate marking of the bores in the X and Y-direction.
- Round legs with fine adjustment.



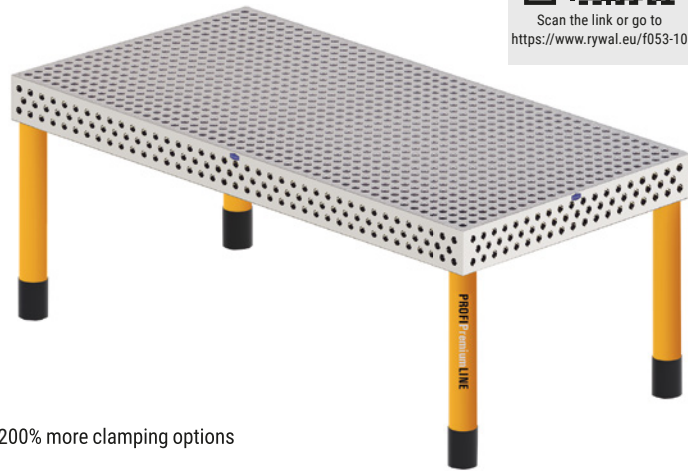
Worktop PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	1000	150	210	-	-	PL22-01001-000	PL22-01001-500
	2000	1000	150	375	-	-	PL22-01002-000	PL22-01002-500
	2400	1200	150	535	-	-	PL22-01003-000	PL22-01003-500
	3000	1500	150	785	-	-	PL22-01004-000	PL22-01004-500

Table legs (standard) PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	1000	850 ±30	244	12 000	4	PL22-01001-001	PL22-01001-011
	2000	1000	850 ±30	409	12 000	4	PL22-01002-001	PL22-01002-011
	2400	1200	850 ±30	569	12 000	4	PL22-01003-001	PL22-01003-011
	3000	1500	850 ±30	836	18 000	6	PL22-01004-001	PL22-01004-011

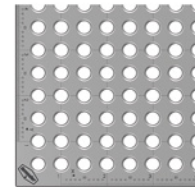


## 3D PROFIPremiumLINE table (PP22)

22 System



- Worktop with Ø22 system bores in a 50 x 50 mm grid, which gives about 200% more clamping options than PROFIPlusLINE.
- 3-hole drilling pattern in the table side plates with D22 system bores in the 50 x 50 mm diagonal grid. This doubles the expansion and clamping options.
- All table dimensions are available as an option with the hardened version DEMONT 760 M.
- All system bores with protective countersink, perfect design and ultimate functionality.
- Optimized, outside table edges.
- Improved table reinforcement through additional crossribs.
- Continuous gridlines in X and Y-direction, 100 mm spacing.
- Precision scaling with millimetre division, also available with other version.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment. Round design with pivoting foot.



05.3

Worktop PROFIPremiumLINE (PP)	Length [mm]	Width [mm]	Height [mm]	The table's weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	1000	150	200	-	-	PP22-01001-000	PP22-01001-500
	2000	1000	150	350	-	-	PP22-01002-000	PP22-01002-500
	2400	1200	150	500	-	-	PP22-01003-000	PP22-01003-500
	3000	1500	150	735	-	-	PP22-01004-000	PP22-01004-500

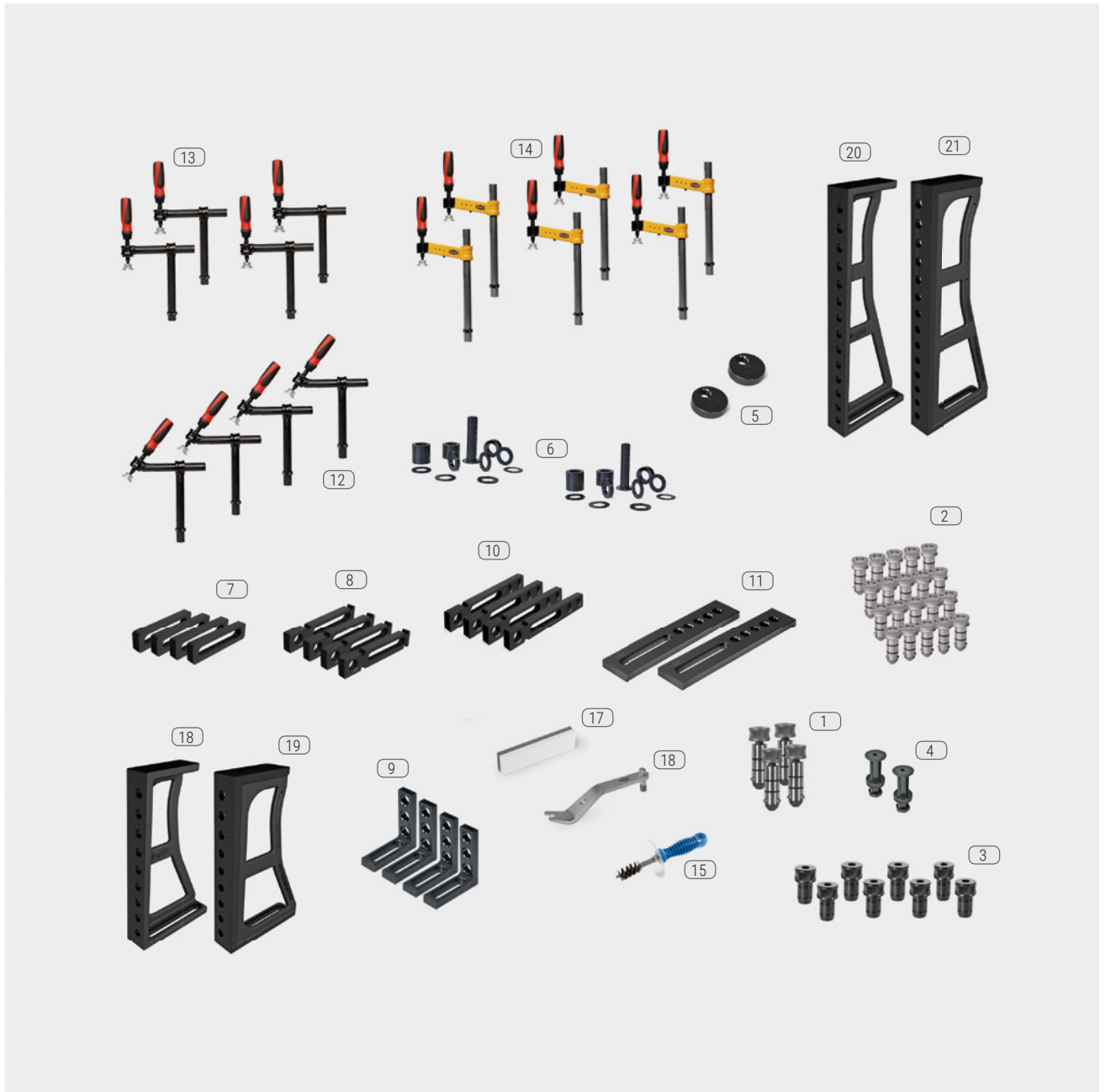
Table legs (standard) PROFIPremiumLINE (PP)	Length [mm]	Width [mm]	Height [mm]	The table's weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	1000	850 ±30	234	12 000	4	PP22-01001-001	PP22-01001-011
	2000	1000	850 ±30	423	12 000	4	PP22-01002-001	PP22-01002-011
	2400	1200	850 ±30	534	12 000	4	PP22-01003-001	PP22-01003-011
	3000	1500	850 ±30	786	18 000	6	PP22-01004-001	PP22-01004-011





PROFIplusLINE sets

22 System



Set name	No. of elements	Manufacturer's item
PROFIplusLINE D710	26	D22-52000-710
PROFIplusLINE D720	57	D22-52000-720
PROFIplusLINE D730	77	D22-52000-730



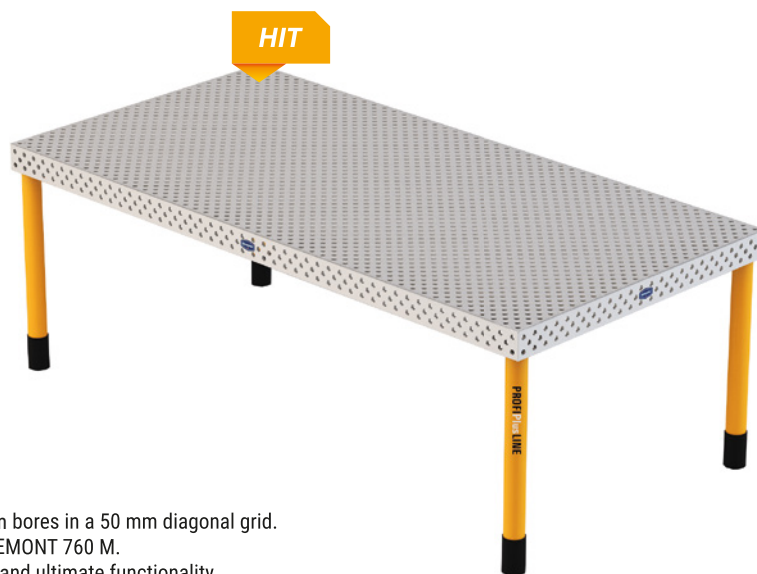
No.	PROFIPlusLINE sets content	D710	D720	D730	Manufacturer's item
1	PCC bolt/long – Ø22, AF 10, clamping range 49–52 mm			4	D22-06026-000
2	EcoLINE bolt/ short – Ø22, AF 6, clamping range 31–34 mm	10	16	20	E22-06025-000
3	Stop and positioning bolts Ø22/31 x 52 mm		6	8	D22-06009-000
4	Spacer set with thread – Ø45 x125 mm, higher compensation 22–105 mm, continuous		2	2	D22-09001-005
5	Stop washer Ø75 – stop dimension 25–50 mm continuous		2	2	D22-05013-000
6	Spacer Set of 11–piece – Ø50 x 125 mm, height compensation 5–100 mm increment 1 mm		2	2	D22-09001-000
7	Displacement stop – 150 x 50 x 18 mm – scale on both sides	4	4	4	D22-05015-000
8	Universal Stop / size 225 x 50 x 18 mm	4		4	D22-05001-000
9	Clamping and Location Angle 175 x 175 mm (bore / oblong hole)		4	4	PE22-03001-000
10	Universal stop L300 – 300 x 50 x 18 mm	2	4	4	D22-05009-000
11	Stop strip L500 – 500 x 100 x 18 mm		2	2	D22-05003-000
12	45° variablescre w clamp with spindle – vertical tube 250 mm		4	4	D22-07009-000
13	180° variable screw clamp with spindle – 250 mm vertical tube	4	4	4	D22-07005-000
14	180° compensating swing clamp with spindle – vertical tube 300 mm		4	6	D22-07001-000
15	Round brush Ø22 mm with protective cap, for cleaning the system bore	1	1	1	D22-10002-000
16	Extraction tools – 250 x 45 mm AF10	1	1	1	D22-10016-001
17	Bench stone 200 x 50 x 25 mm for cleaning		1	1	D00-10007-000
18	Clamping and locating Angle H500, DEMOND 760 M Black edition, hardened cast iron – right			1	PE22-03003-000
19	Clamping and locating Angle H500, DEMONT 760 M Black Edition, hardened cast iron – left			1	PE22-03003-001
20	Clamping and locating Angle H750, DEMONT 760 M Black Edition, hardened cast iron – right			1	PE22-03004-000
21	Clamping and locating Angle H750, DEMONT 760 M Black Edition, hardened cast iron – left			1	PE22-03004-001
	<b>Together:</b>	26	57	77	

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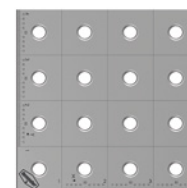


### 3D PROFIEcoLINE table (PE16)

16 System



- Worktop with D16 system bore in 50 x 50 mm grid.
- 3-hole drilling pattern in the table side plates with D16 system bores in a 50 mm diagonal grid.
- All table sizes are optionally available in hardened version DEMONT 760 M.
- All system bores with protective countersink, perfect design and ultimate functionality.
- Optimized outside table edges.
- Continuous gridlines in X and Y-direction, 50 mm spacing.
- Precision scaling with millimetre division, also available with other version.
- Coordinate marking of the bores in the X and Y - direction.
- Table legs with fine adjustment. Round design with pivoting foot.



Worktop PROFIEcoLINE (PE)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	500	100	85	-	-	PE16-01000-000	PE16-01000-500
	1000	1000	100	140	-	-	PE16-01001-000	PE16-01001-500
	1200	800	100	140	-	-	PE16-11019-000	PE16-11019-500
	1200	1200	100	180	-	-	PE16-01056-000	PE16-01056-500
	1500	1000	100	190	-	-	PE16-01017-000	PE16-01017-500
	1500	1500	100	260	-	-	PE16-01011-000	PE16-01011-500
	2000	1000	100	250	-	-	PE16-01002-000	PE16-01002-500
	2400	1200	100	360	-	-	PE16-01003-000	PE16-01003-500
	3000*	1500	100	520	-	-	PE16-01004-000	PE16-01004-500

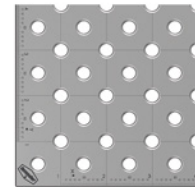
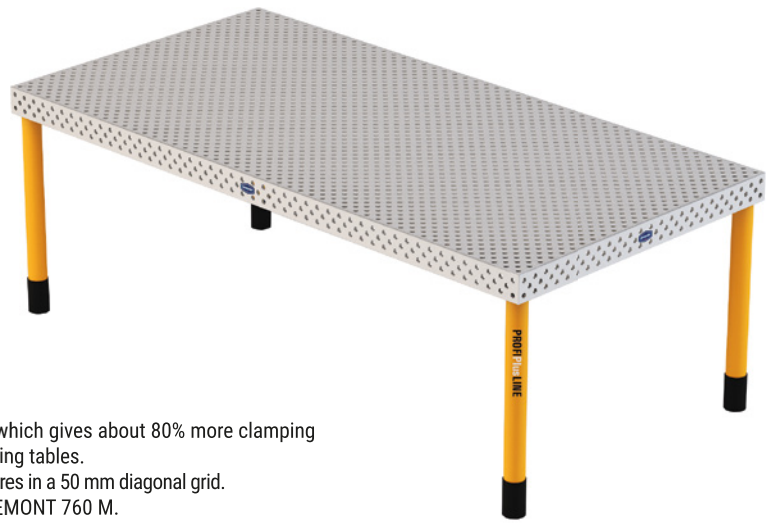
Table legs (standard) PROFIEcoLINE (PE)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	500	850 ±30	109	8000	4	PE16-01000-001	PE16-01000-011
	1000	1000	850 ±30	164	8000	4	PE16-01001-001	PE16-01001-011
	1200	800	850 ±30	164	8000	4	PE16-11019-001	PE16-11019-011
	1200	1200	850 ±30	204	8000	4	PE16-01056-001	PE16-01056-011
	1500	1000	850 ±30	214	8000	4	PE16-01017-001	PE16-01017-011
	1500	1500	850 ±30	284	8000	4	PE16-01011-001	PE16-01011-011
	2000	1000	850 ±30	274	8000	4	PE16-01002-001	PE16-01002-011
	2400	1200	850 ±30	384	8000	4	PE16-01003-001	PE16-01003-011
	3000*	1500	850 ±30	568	16 000	8	PE16-01004-001	PE16-01004-011

\* Consisting of 2 x 1500 x 1500 x 100 mm



### 3D PROFIPlusLINE table (PL16)

16 System



- Worktop with D16 system bores in diagonal 50x50 mm grid, which gives about 80% more clamping options than the PROFIEcoLINE version and other typical Welding tables.
- 3-hole drilling pattern in the table side plates with D16 system bores in a 50 mm diagonal grid.
- All table sizes are optionally available in hardened version DEMONT 760 M.
- All system bores with protective countersink, perfect design and ultimate functionality.
- Optimized outside table edges.
- Continuous gridlines in X and Y-direction, 50 mm spacing.
- Precision scaling with millimetre division, also available with other version.
- Coordinate marking of the bores in the X and Y-direction.
- Table legs with fine adjustment. Round design with pivoting foot.

05.3

Worktop PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	500	100	70	-	-	PL16-01000-000	PL16-01000-500
	1000	1000	100	119	-	-	PL16-01001-000	PL16-01001-500
	1200	800	100	123	-	-	PL16-11019-000	PL16-11019-500
	1200	1200	100	162	-	-	PL16-01056-000	PL16-01056-500
	1500	1000	100	179	-	-	PL16-01017-000	PL16-01017-500
	1500	1500	100	253	-	-	PL16-01011-000	PL16-01011-500
	2000	1000	100	223	-	-	PL16-01002-000	PL16-01002-500
	2400	1200	100	326	-	-	PL16-01003-000	PL16-01003-500
	3000*	1500	100	506	-	-	PL16-01004-000	PL16-01004-500

Table legs (standard) PROFIPlusLINE (PL)	Length [mm]	Width [mm]	Height [mm]	Approx. table weight [kg]	Max load. [kg]	No. of legs	Manufacturer's part number	
							Standard	Hardened DEMONT 760 M
	1000	500	850 ±30	104	8000	4	PL16-01000-001	PL16-01000-011
	1000	1000	850 ±30	154	8000	4	PL16-01001-001	PL16-01001-011
	1200	800	850 ±30	154	8000	4	PL16-11019-001	PL16-11019-011
	1200	1200	850 ±30	194	8000	4	PL16-01056-001	PL16-01056-011
	1500	1000	850 ±30	204	8000	4	PL16-01017-001	PL16-01017-011
	1500	1500	850 ±30	274	8000	4	PL16-01011-001	PL16-01011-011
	2000	1000	850 ±30	264	8000	4	PL16-01002-001	PL16-01002-011
	2400	1200	850 ±30	364	8000	4	PL16-01003-001	PL16-01003-011
	3000*	1500	850 ±30	548	16 000	8	PL16-01004-001	PL16-01004-011

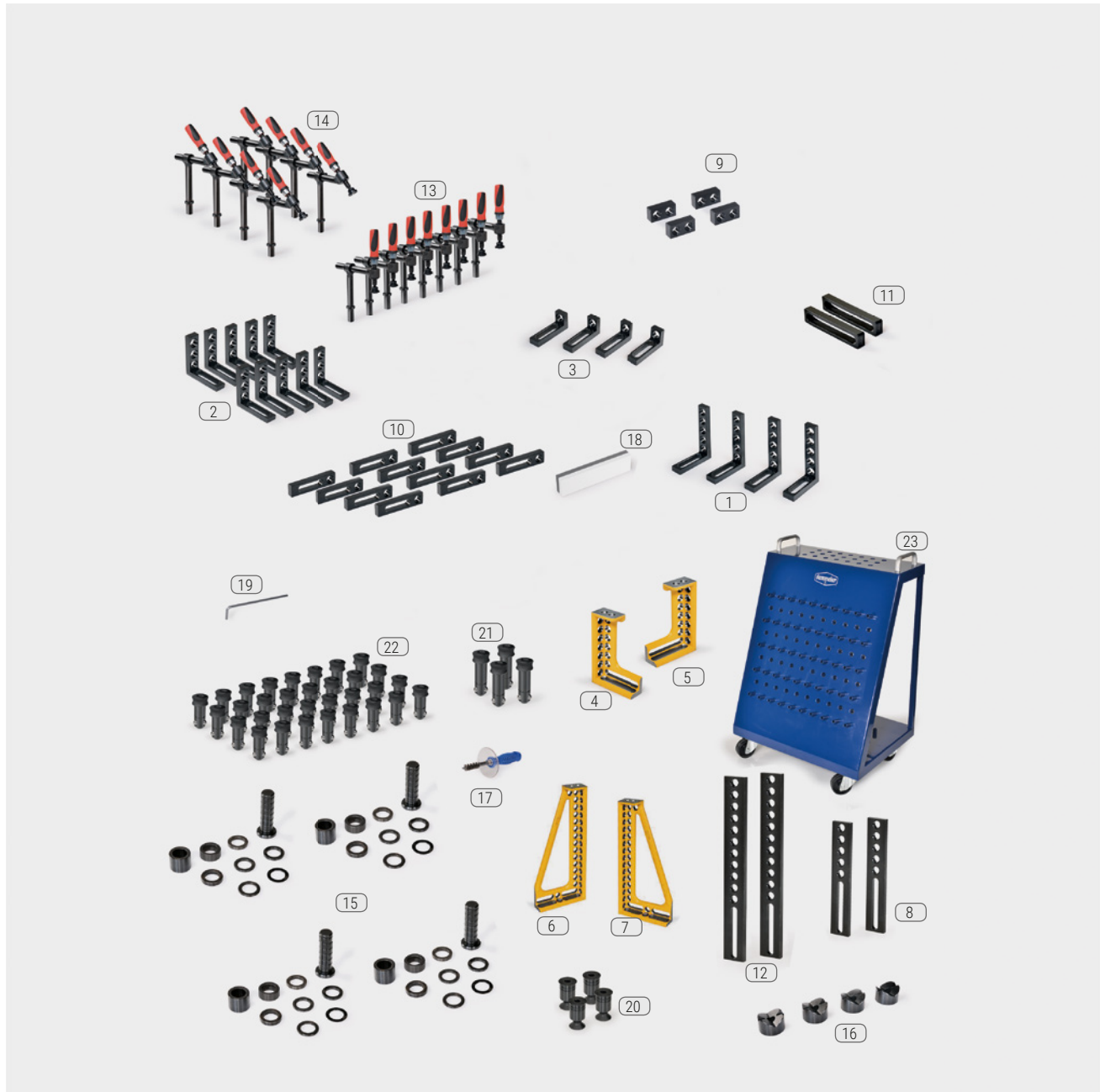
\* Consisting of 2 x 1500 x 1500 x 100 mm





PROFIEcoLINE sets

16 System



Set name	No. of elements	Manufacturer's item
PROFIEcoLINE E200	59	E16-52000-200
PROFIEcoLINE E710	29	E16-52000-710
PROFIEcoLINE E720	79	E16-52000-720
PROFIEcoLINE E730	114	E16-52000-730
PROFIEcoLINE E300	99	E16-52000-300



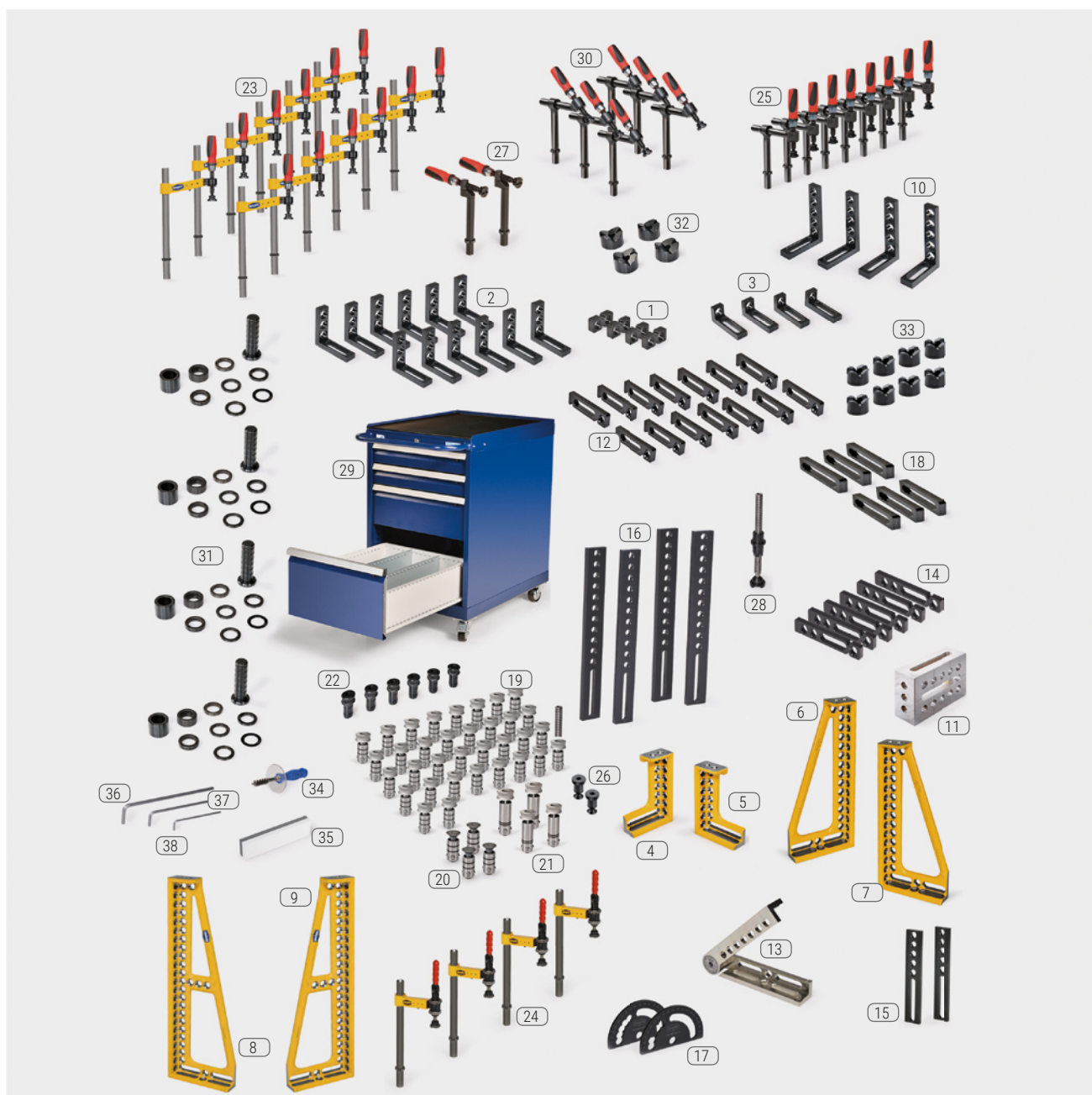
No.	PROFIPlusLINE sets content	E200	E710	E720	E730	E300	Manufacturer's item
1	ECO Clamping and location angle H=140; 140 x 90 x 25 mm	2		4	4	4	E16-03008-000
2	ECO Clamping and location angle H=90; 90 x 90 x 25 mm	4	4	4	10	4	E16-03001-000
3	ECO Clamping and Location angle H=37,5; 90 x 37,5 x 25 mm	2	2	4	4	4	E16-03001-002
4	ECO Clamping and Location angle 200 x 137,5 x 50 mm – right			2	1	1	E16-03002-000
5	ECO Clamping and Location Angle 200 x 137,5 x 50 mm – left			2	1	1	E16-03002-001
6	ECO Clamping and Location angle casting 400 x 137,5 x 50 mm – right					1	E16-03003-000
7	ECO Clamping and Location angle casting 400 x 137,5 x 50 mm – left					1	E16-03003-001
8	ECO stop strip 250 mm	2			4	2	E16-05003-000
9	ECO Universal stop – small	2	2		4	4	E16-05002-000
10	ECO Universal Stop – large	4	4	4	12	4	E16-05001-000
11	ECO Displacement – stop L150	4		4	2	4	E16-05015-000
12	ECO stop strip L400			2	2	2	E16-05003-001
13	180° screw clamp with spindle	6	4	8	8	8	E16-07005-000
14	45° variable screw clamp with spindle	6	2	8	8	8	E16-07009-000
15	Spacer Set 9–pieces	2		4	2	4	E16-09001-000
16	ECO V–block location blackened Steel Ø80 steel spray	4		4	8	8	E16-09003-000
17	Round Brush for bore Ø16 mm	1	1	1	1	1	E16-10002-000
18	Bench Stone for cleaning	1	1	1	1	1	E16-10007-000
19	Ball and hex wrench AF5	1	1	1	1	1	E16-10008-000
20	ECO connecting bolt / short				4	4	E16-06003-000
21	ECO connecting bolt / short	2		2	4	4	E16-06002-000
22	ECO Line bolt / short	16	8	24	32	28	E16-06001-000
23	Tool trolley				1		D16-11001-002
	<b>Together:</b>	59	29	79	114	99	

The DEMMELER clamping systems are modular, flexible and compatible. They can be used for all system sizes, on all 3D worktables. The sets can be assembled individually or it is possible to supplement chosen elements with a large selection of DEMMELER accessories!



PROFIPlusLINE sets

16 System



Set name	No. of elements	Manufacturer's item
PROFIPlusLINE D155	39	D16-52000-155
PROFIPlusLINE D255	87	D16-52000-255
PROFIPlusLINE D720	125	D16-52000-720
PROFIPlusLINE D355	161	D16-52000-355



No.	PROFIPlusLINE Sets content	D155	D255	D720	D355	Manufacturer's item
1	Universal stop / small / L55	2	4		4	D16-05002-000
2	Clamping and Location Angle 90 x 90 x 25 mm (bore / oblong hole)	4	4	8	12	D16-03001-000
3	Clamping and Location Angle / small 90 x 37.5 x 25 mm, scale on both sides	2	2	4	4	D16-03001-002
4	Clamping and Location angle, right, cast iron 200 x 137.5 x 50 mm		1	1	1	D16-03002-000
5	Clamping and Location Angles left, cast iron 200 x 137.5 x 50 mm		1	1	1	D16-03002-001
6	Clamping and Location Angle, right 400 x 187.5 x 50 mm			1		D16-03003-000
7	Clamping and Location, left 400 x 187.5 x 50 mm			1		D16-03003-001
8	Right angles, cast iron 600				1	D16-03004-000
9	Left angles, cast iron 600				1	D16-03004-001
10	Clamping and Location Angle 140 x 90 x 25 mm		4	4	4	D16-03008-000
11	Console Right-hand cast iron				1	D16-03005-001
12	Universal stop with scale - 115 x 25 x 12 mm	6	8	8	14	D16-05001-004
13	Universal pivot and tilt angle, Right-hand				1	D16-03007-000
14	Universal stop L 165	2	2		6	D16-05009-000
15	Stop strip L250 - 250 x 50 x 12 mm			2		D16-05003-000
16	Stop strip L400 - 400 x 50 x 12 mm			4	4	D16-05003-001
17	Angle setting template, scale on both sides, 0-90°, 15°, 30°, 45°, 60°			2		D16-05013-010
18	Displacement stop - 150 x 25 x 12 mm		2	8	6	D16-05015-000
19	PC-bolt / short - Ø16-0.01, AF8, clamping range 20-24 mm, 10/50kN	10	20	24	34	D16-06001-000
20	PC-countersunk bolt / short				4	D16-06004-000
21	PC-bolt / long - Ø16-0.01, AF8, clamping range 32-36 mm, 10/50kN		2	2	4	D16-06002-000
22	Stop and positioning bolt Ø16 / 25x37		4	12	6	D16-06009-000
23	180° compensating clamp with spindle	4	6		12	D16-07001-000
24	Compensating swing clamp 180° with spindle			4		D16-07001-001
25	180° screw clamp with spindle - vertical tube 130 mm	2	4	8	8	D16-07005-000
26	Connecting bolt / short with screw				2	D16-06003-000
27	90° Variable screw clamp, with adjusting screw	2	2	4	2	D16-07008-000
28	Adjusting spindle				1	D16-09008-000
29	Tool trolley				1	D16-11001-000
30	45° Variable screw clamp with adjusting screw		4	8	6	D16-07009-000
31	Set of spacers 9-piece	2	4	4	4	D16-09001-000
32	V-block locations Ø80 mm - 120° / 90° - hardened steel - for pipes up to Ø140 mm		2	8	4	D16-09003-000
33	V-block locations Ø58 mm - 120° / 90° - hardened steel - for pipes up to Ø70 mm		8	4	8	D16-09004-000
34	Round Brush for bores Ø16, with protective cap	1	1	1	1	D16-10002-000
35	Bench stone 200x50x25 mm, 2-sided for cleaning	1	1	1	1	D00-10007-000
36	Ball and hex wrench AF8 x 104 mm	1	1	1	1	D16-10008-000
37	Ball and hex wrench AF6				1	D16-10008-001
38	Ball and hex wrench AF4				1	D16-10008-002
	<b>Together:</b>	39	87	125	161	

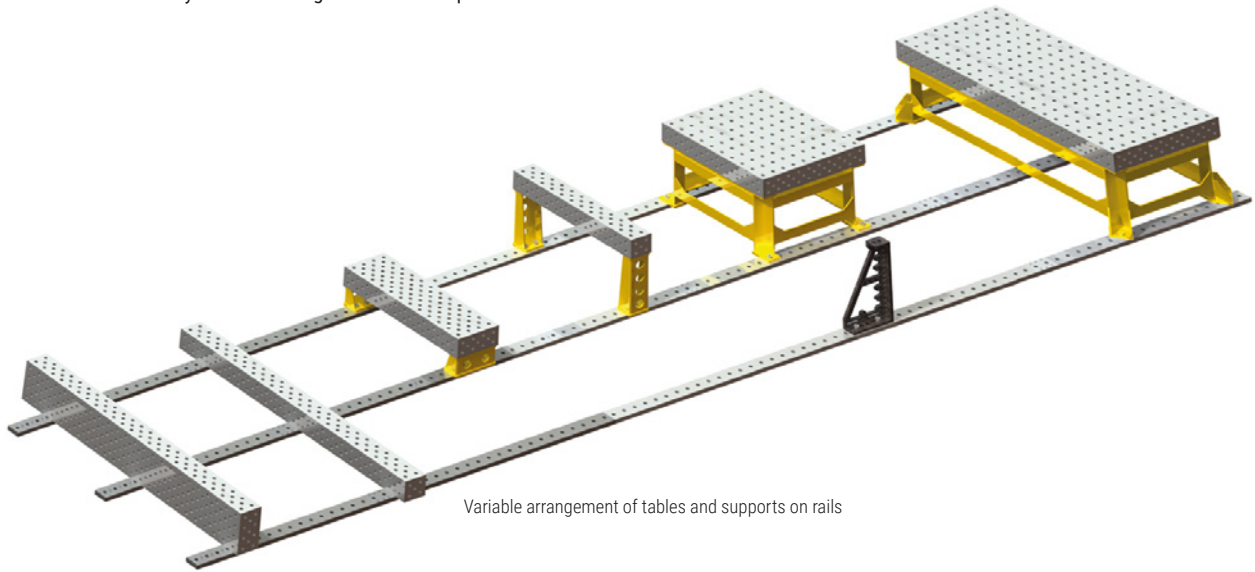
The DEMMELER clamping systems are modular, flexible and compatible. They can be used for all system sizes, on all 3D worktables. The sets can be assembled individually or it is possible to supplement chosen elements with a large selection of DEMMELER accessories!



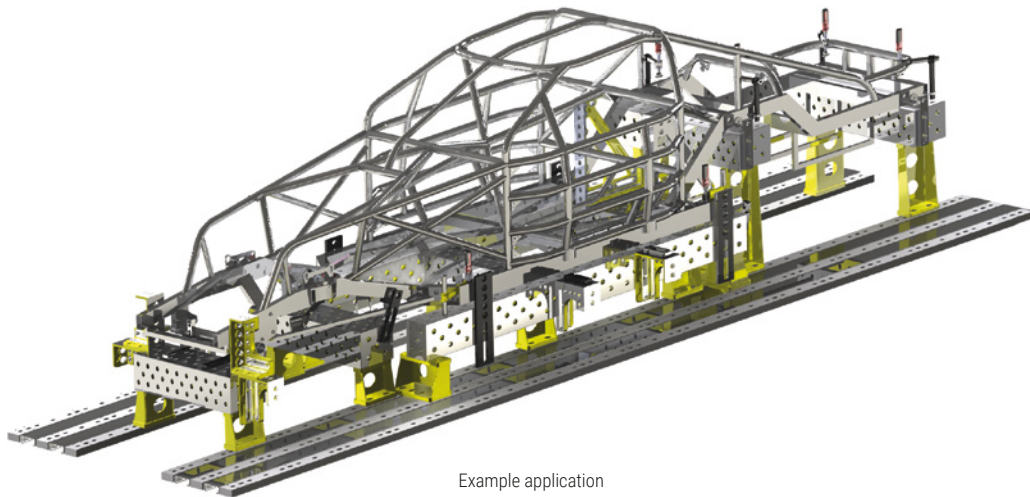


## Track system floor plates

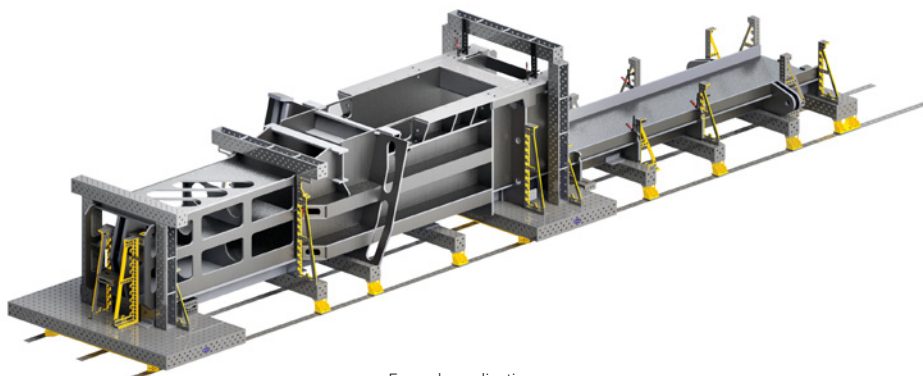
- Foundation rail system fixed to the ground.
- Modular structure of the base rail systems suitable to build many sizes of workstation.
- Exact reference level over the entire work area.
- Flexible assembly system.
- Setup of system components: tables and distance support in any configuration using legs or frames.
- Continuously variable positioning of superstructures.
- We install the rail system according to customer requirements.



Variable arrangement of tables and supports on rails



Example application



Example application

## ▼ 2. INDUSTRIAL MAGNETIC TOOLS



### Magnetic Ground Clamps

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
300 Amp Ground Clamp	40	57,0 x 49,0 x 73,0	0,4	70 08 100746
600 Amp Ground Clamp	89	66,0 x 100,8 x 69,0	0,8	70 08 100747
800 Amp Ground Clamp	136	74,0 x 119,9 x 98,6	1,6	70 08 100552



Safe and quick grounding



Scan the link or go to  
<https://www.rywal.eu/f053-1>

#### Features, application and benefits:

- Quick and easy connect and disconnect the ground wire.
- Easily attaches in hard-to-reach places.
- The new design with increased contact area reduces the temperature by almost 27%!
- No electrical power supply required.
- For both flat and round surfaces.
- Simple switch-on/off by turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.



600 Amp Ground Clamp

05.3

### MagSquares magnetic clamps

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
MagSquare 165	68	63,3 x 30,8 x 48,0	0,3	70 08 700494
MagSquare 400	181	90,7 x 41,3 x 64,0	0,9	70 08 700238
MagSquare 600	272	104,0 x 51,5 x 75,0	1,4	70 08 700106
MagSquare 1000	454	146,6 x 72,0 x 108,0	3,6	70 08 700099



Multi-purpose application,  
magnetic grip on all sides



Scan the link or go to  
<https://www.rywal.eu/f053-2>

#### Features, application and benefits:

- Multi-surface workholding when positioning steel.
- Magnetic grip on 5 sides.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- For both flat and round surfaces.
- Ideal for profiles, sections, tubes and plates.
- Remains clean when switched off – debris, spatters, dirt fall off.



MagSquare 1000



## MAGSWITCH 90° magnetic angle

### Features, application and benefits:

- Precise locking of workpieces at 90°.
- Positioning by adjusting the magnets settings.
- For extra strength add additional MagSquares.
- Unmatched versatility as magnets move up and down or reversible on each axis.
- Possibility to use the magnetic holders separately.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- For both flat and round surfaces.
- Remains clean when switched off – debris, spatters, dirt fall off.

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Angle 90° 165	68	205,0 x 47,0 x 205,0	0,8	70 08 700548
Angle 90° 400	181	262,9 x 133,2 x 262,9	2,8	70 08 700454
Angle 90° 600	272	288,0 x 104,0 x 288,0	3,7	70 08 700495
Angle 90° 1000	454	287,0 x 145,0 x 474,0	9,6	70 08 700503



Scan the link or go to  
<https://www.rywal.eu/f053-3>



Angle 90° 600



Quick right angle adjustment for small and large workpieces

## MAGSWITCH Boomer/Pivot Angles

### Features, application and benefits:

- Universal: adjustable to any angle.
- Possibility to position the arms from inside and outside.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- For both flat and round surfaces.
- Ideal for profiles, sections, tubes and plates.
- Remains clean when switched off – debris, spatters, dirt fall off.

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Boomer Angle 150	49	195,5 x 139,7 x 195,5	1,3	70 08 700091
Boomer Angle 400	181	258,0 x 109,0 x 258,0	3,0	70 08 700453
Boomer Angle 600	272	258,0 x 169,0 x 258,0	4,4	70 08 700090
Pivot Angle 200	90	240,0 x 97,9 x 240,0	1,63	70 08 700367



Scan the link or go to  
<https://www.rywal.eu/f053-4>



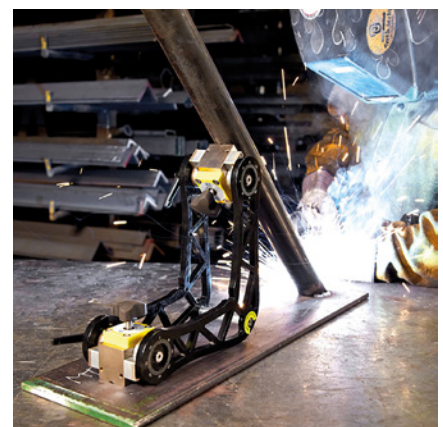
Boomer Angle 600



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<https://www.rywal.eu/f053-5>



Pivot Angle 200



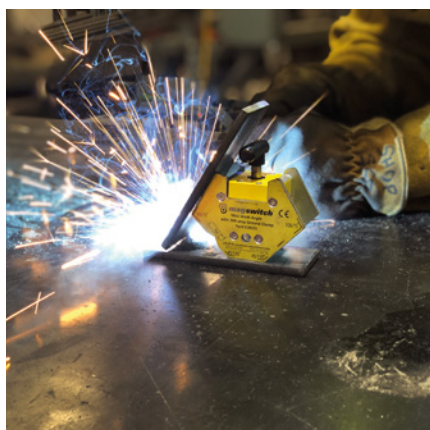
Adjusting and blocking any angle





## MAGSWITCH Mini

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Mini Angle	40	53,6 x 32,0 x 59,0	0,2	70 08 700352
Mini Multi Angle	40	65,0 x 32,0 x 72,0	0,2	70 08 700350
Mini Multi Angle 300 Amp	67	87,0 x 42,0 x 90,5	0,4	70 08 700351
Multi Angle 400 Amp	181	95,5 x 65,0 x 129,0	1,2	70 08 700438



Third hand of the welder



Scan the link or go to  
<https://www.rywal.eu/f053-6>

### Features, application and benefits:

- Frame with standard angles.
- Light and easy to use.
- Irreplaceable in hard-to-reach places.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.



Mini Multi Angle 300 Amp

## MAGSWITCH MagVise

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
MagVise 1000	454	138,0 x 110,0 x 149,8	4,4	70 08 700450
MagVise 1500	681	160,4 x 161,7 x 179,7	9,5	70 08 700897



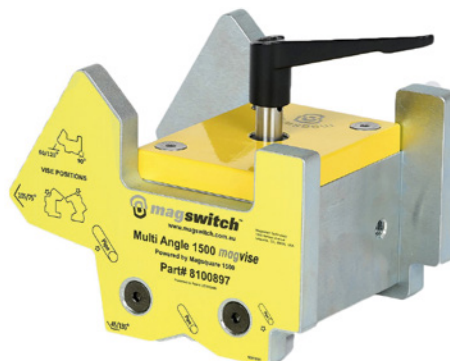
Magnetic vise in action



Scan the link or go to  
<https://www.rywal.eu/f053-6>

### Features, application and benefits:

- Offers clever dual function: a workholding angle tool and a super convenient quick connect/disconnect magnetic vise.
- Is perfect for holding small to medium size steel pieces while drilling, cutting, grinding, beveling etc.
- Holds flat, round, or odd shaped pieces. Incredibly strong.
- Does not require permanent fixing.
- Frame with standard angles.
- No electrical power supply required.
- Simple switch-on/shut-off by turning the handle 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.



MagVise 1500



## MAGSWITCH MagJig

### Features, application and advantages:

- Ideal for use with woodworking machines.
- The screw holes increase the security in a fixture.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
MagJig 60 Keychain	27	44,1 x 26,8 x 39,3	0,1	70 08 100514
MagJig 60	27	49,1 x 26,8 x 39,5	0,1	70 08 100818
MagJig 95	43	46,6 x 34,0 x 57,0	0,1	70 08 110004
MagJig 150	68	52,1 x 44,0 x 57,0	0,2	70 08 110005
MagJig 235	106	78,3 x 60,0 x 88,0	0,5	70 08 110377



MagJig 150



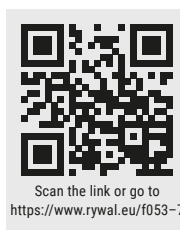
Handy and practical

## MAGSWITCH HAND LIFTERS

### Features, application and benefits:

- For easy transport of hot and burnt elements.
- Push-button control (charger and two batteries – 60 CE Included) or by turning the handle by 180° (60 M).
- Ideal safety pick up of hot, sharp or dirty steel without touching it.
- The safety lock prevents the magnet (60 CE) from being accidentally connected.
- Remains clean when switched off – debris, spatters, dirt fall off.

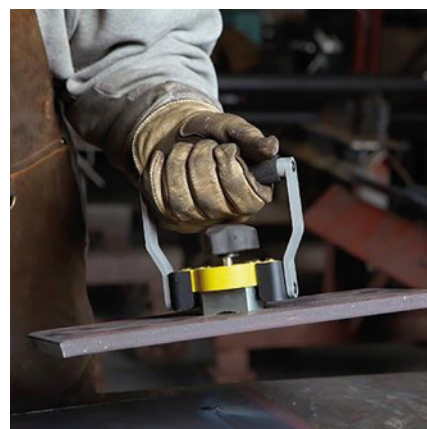
Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Hand lifter 60-M	106/32	145,1 x 120,0 x 134,3	0,6	70 08 700359
Hand lifter 60-CE (electric)	106/32	209,0 x 173,0 x 75,0	1,1	70 08 800487



HAND LIFTER  
electric 60-CE



HAND LIFTER  
60-M



Reliable strength





## MAGSWITCH MagPress

Type	Holding force [kg]	Dimensions (W x S x Ø) [mm]	Weight [kg]	Catalogue No.
MagPress	464,4	632,4 x 177,8 x 414,0	6,0	70 08 100935



Contact and levelling

### Features, application and benefits:

- Aligns large steel sheets with precision.
- Equalizes high and low points between steel gaps.
- Precise adjustment by turning the handle.
- Holds flat and round surfaces of steel.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.



MagPress



Scan the link or go to  
<https://www.rywal.eu/f053-8>

## MAGSWITCH Extenda-Lift

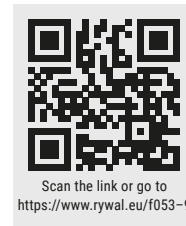
Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Extenda-Lift 600	272	724,0 x 100,0 x 117,0	2,4	70 08 100025
Extenda-Lift 1000	454	731,5 x 108,0 x 122,0	4,4	70 08 130177



Ideal for hard-to-reach places

### Features, application and benefits:

- For pick up hot, sharp or dirty steel without bending over.
- Ideal for cities and utilities.
- No electrical power supply required.
- Simple switch-on/off by turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.
- Ideal for cleaning.



Scan the link or go to  
<https://www.rywal.eu/f053-9>



Extenda-Lift 600/1000

## MAGSWITCH Mag-Utility Hook

Type	Holding force [kg]	Dimensions (W x S x D) [mm]	Weight [kg]	Catalogue No.
Mag-Utility Hook 25	34	89,0 x 40,0 x 47,2	0,2	70 08 700012
Mag-Utility Hook 40	91	103,0 x 67,9 x 69,0	0,9	70 08 700006



Organize workspace

### Features, application and benefits:

- Organizes the workplace by hanging tools, lights, wires and hoses more.
- Secures the power supply cables.
- No electrical power supply required.
- Simple turning the handle by 180°.
- Remains clean when switched off – debris, spatters, dirt fall off.



Mag-Utility Hook 40

### ▼ 3. MANUAL STEEL SCREW CLAMPS

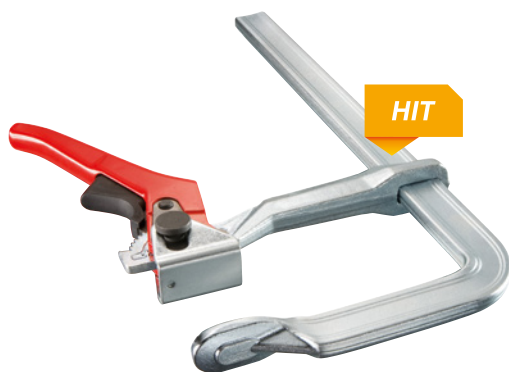


More technical data and full range of clamps - Download Catalogue Bessey 2023/24 (EN)

Scan the link or go to <https://www.rywal.eu/i053-15>

#### Lever clamps (GH series)

- Steel with ergonomic handle.
- Clamping force up to 8500 N.
- The profile-optimized rail allows for an equal generating of clamping force, especially when clamping parts are positioned far from the edge, at the same time offering an increased reserve of force.
- Trigger protection means fewer pinched fingers.
- Secure ratchet mechanism characterized by high wear resistance and increased surface hardness ensures low friction.
- Vibration resistant.



Type	Working range [mm]	Reach [mm]	Rail [mm]	Weight [kg]	Catalogue No.
GH12	120	60	15 x 6	0,49	71 00 700212
GH16	160	80	17,5 x 6,8	0,64	71 00 700216
GH20	200	100	22 x 8,5	1,11	71 00 450001
GH25	250	120	24,5 x 9,5	1,44	71 00 450002
GH30-12	300	120	24,5 x 9,5	1,51	71 00 700232
GH40-12	400	120	24,5 x 9,5	1,75	71 00 700241
GH30	300	140	28 x 11	2,27	71 00 700245
GH40	400	120	28 x 11	2,41	71 00 700240
GH50	500	120	28 x 11	2,61	71 00 700250
GH60	600	120	28 x 11	2,84	71 00 450015
GH80	800	120	28 x 11	3,20	71 00 700280
GH100	1000	120	28 x 11	3,59	71 00 450013



#### Traditional All-steel bar clamps (SG series)

- Clamping force up to 12000 N at a tightening torque of 40 Nm.
- Forced with screw when clamping.
- 20% more clamping force with each spindle turn thanks to the profile-optimized rail.
- Highest safety due to the transmission of forces by the sliding arm moving in a straight line.
- Special clamping pad with sintered steel insert, tilt of up to 35°.



Type	Working range [mm]	Reach [mm]	Rail [mm]	Weight [kg]	Catalogue No.
SG25M	250	140	34 x 13	2,58	71 00 700329
SG30M	300	140	34 x 13	3,00	71 00 700330
SG40M	400	140	34 x 13	3,17	71 00 700340
SG50M	500	140	34 x 13	3,40	71 00 700333
SG60M	600	140	34 x 13	3,80	71 00 700360
SG80M	800	140	34 x 13	4,45	71 00 700342
SG100M	1000	140	34 x 13	4,95	71 00 700466
SG125M	1250	140	34 x 13	5,87	71 00 700467
SG150M	1500	140	34 x 13	6,65	71 00 700468

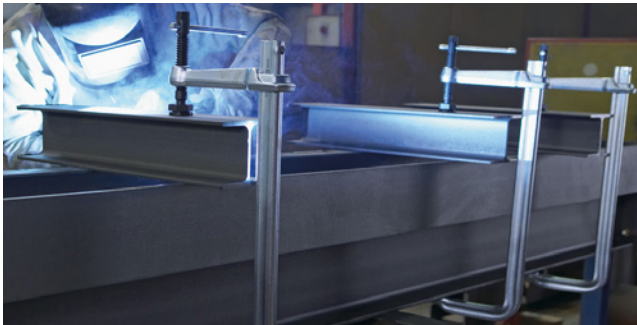




## HEAVY DUTY CLAMPS (STB series)

Type	Working range [mm]	Reach [mm]	Rail [mm]	Weight [kg]	Catalogue No.
STB30M	300	175	40 x 20	5,61	71 00 700430
STB40M	400	175	40 x 20	6,10	71 00 700404
STB50M	500	175	40 x 20	6,67	71 00 700450
STB60M	600	175	40 x 20	7,23	71 00 700460
STB80M	800	175	40 x 20	8,35	71 00 700408
STB100M	1000	175	40 x 20	9,42	71 00 700400
STB125M	1250	175	40 x 20	10,77	71 00 700402
STB150M	1500	175	40 x 20	12,20	71 00 700468

- Clamping force up to 22000 N at a tightening torque of 70 Nm.
- Forced with screw, when clamping.
- With a 19 mm ending for comfort and simple transfer of force when clamping.
- Special clamping pad with sintered steel insert, tilt of up to 35°.



## Track table clamps (GZ series)

Type	Working range [mm]	Reach [mm]	Rail [mm]	Weight [kg]	Catalogue No.
GZ10-2K	100	60	15 x 6	0,31	71 00 700139
GZ12-2K	120	60	15 x 6	0,32	71 00 700100
GZ16-2K	160	80	17,5 x 6,8	0,57	71 00 700106
GZ40-8-2K	400	80	17,5 x 6,8	0,76	71 00 700140
GZ20-2K	200	100	22 x 8,5	1,01	71 00 700143
GZ25-2K	250	120	24,5 x 9,5	1,42	71 00 700144
GZ30-12-2K	300	120	24,5 x 9,5	1,50	71 00 700156
GZ40-12-2K	400	120	24,5 x 9,5	1,65	71 00 700110
GZ50-12-2K	500	120	24,5 x 9,5	1,83	71 00 700151
GZ60-12-2K	600	120	24,5 x 9,5	2,00	71 00 700166
GZ80-12-2K	800	120	24,5 x 9,5	2,20	71 00 700168
GZ100-12-2K	1000	120	24,5 x 9,5	2,45	71 00 700169
GZ30-2K	300	140	28 x 11	2,01	71 00 700103
GZ40-2K	400	120	28 x 11	2,12	71 00 700135
GZ50-2K	500	120	28 x 11	2,33	71 00 700136
GZ60-2K	600	120	28 x 11	2,52	71 00 700104
GZ80-2K	800	120	28 x 11	2,87	71 00 700180
GZ100-2K	1000	120	28 x 11	3,29	71 00 700181
GZ125-2K	1250	120	28 x 11	3,83	71 00 700182

- Steel with plastic handle.
- Clamping force up to 6000 N.
- 20% more clamping force with each spindle turn thanks to the profile optimized rail.
- Highest safety due to the transmission of forces by the sliding arm moving in straight line.
- Fixed and sliding arm tempered to provide flexibility and elasticity during clamping.
- High quality 2-component plastic grip.
- Clamping pads exchangeable without using additional tools.





# 05.4





# COMPREHENSIVE EQUIPMENT OF WELDING STATION

## LIFTING AND TRANSPORT SYSTEMS

05.4

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## ▼ 1. MAGNETIC HOLDERS



### Lifting magnets NEOLIFT

Thanks to Neodymium magnets safety factor for each WALMAG is 3+ (tested according to EN 13155).

- Lifting capacity ranges: 150 kg / 300 kg / 600 kg / 1000 kg / 1500 kg / 2000 kg.
- Neodymium handles are not designed to lift long and flexible elements and cannot be used to grab non-magnetic parts.
- Neodymium magnets have operating parameters specified by the manufacturer (see table).
- Handling flat, round, and cylindrical workpieces.
- Lifting of profiled sections and sheets.



Model	NEOlift 150	NEOlift 300	NEOlift 600	NEOlift 1000	NEOlift 2000
<b>Workload limit:</b>					
▪ flat material [kg]	150	300	600	1000	2000
▪ round material [kg]	65	150	300	500	1000
<b>Max. tested capacity [kg]</b>	450	900	1800	3200	6200
<b>Material diameter min/max [mm]</b>	40/100	60/200	65/270	100/300	150/350
<b>Dimensions (L x W x H) [mm]</b>	93x60x120	152x100x180	246x120x180	306x146x236	478x165x276
<b>Weight [kg]</b>	2,6	10	21	40	90
<b>Catalogue No.</b>	TW 10 00150N	TW 10 00300N	TW 10 00600N	TW 10 01000N	TW 10 02000N

### Battery-powered Lifting Magnets with remote control type BM

- BM type battery-powered Lifting Magnets are designed for repeatable operation and equipped with an IR remote control.
- Can work in pairs operated by one remote control.
- Optionally, there is a metal plate separation function (tempering of lower sheets by temporarily reducing the magnetic force).
- BM type magnets are safety powered by an accumulator integrated with an electromagnetic control device.
- The battery is designed for up to 8 hours of operating time at 50% duty cycle.
- The battery charge time is approx. 8 hours.
- Several replacement batteries can be supplied for 3-shift operation.



Model	BM 1350	BM 2500	BM 3600	BM 5000	BMP 1800	BMP 3600
<b>Length [mm]</b>	272	400	1050	1200	470	760
<b>Width [mm]</b>	242	242	240	300	242	262
<b>Height to crane hook [mm]</b>	460	460	460	460	610	610
<b>Breaking strength [kg]</b>	2700	5000	7200	10000	3600	6800
<b>Lifting capacity for flat material [kg]</b>	1350	2500	3600	5000	1800	3600
<b>Input voltage [V/50-60 Hz]</b>	230	230	230	230	230	230
<b>Power [W]</b>	100	100	100	100	100	100
<b>Battery capacity [Ah]</b>	30	60	60	60	60	60
<b>Working time 50% [h]</b>	8	8	8	8	8	8
<b>Manufacturer's part number</b>	BM1350	BM2500	BM3600	BM5000	BMP1800	BMP3600





## Heavy handling magnetic systems

- We deliver magnetic lifting beams in optimized design for the individual needs of every customer.
- Our heavy handling magnetic systems are able to help with handling almost all materials with magnetic properties with the help of electro and electro-permanent magnets.
- With our magnetic systems, you can handle, for example: sheets both individually and in bundles up to 16 m length, slabs, continuous castings, and other semi-finished products, profiled sections, tubes, pipes of all kinds, individually and in bundles.



## ▼ 2. MANUAL HOISTS



### Manually operated ratchet lever chain hoist

#### Model LH-AA MOST

- Load capacity: 750 kg, 1500 kg, 3000 kg.
- 3 m long galvanized chain, optionally available with longer chain.
- Reinforced hook safety latches.
- Universal hoist for lifting, tensioning and lashing in any direction.
- Solidly constructed steel lever of the hoist, ensures durability and comfort of use thanks to the use of a rubber handle.
- The use of high quality materials ensures smooth operation for many years of use.
- The brake disc is asbestos-free and keeps the load at any given height.
- The upper and lower hooks are equipped as standard with reinforced hook safety latches made of steel castings.
- The galvanized load chain can be easily pulled over by using the slow chain function.

Model	LH-AA 750	LH-AA 1500	LH-AA 3000
Working load limit [kg]	750	1500	3000
Lifting height [m]	3	3	3
Force required to move the lever at maximum load [N]	140	220	320
Number of chain falls [pcs.]	1	1	1
Chain dimension [mm]	6x18	8x24	10x30
Weight of the hoist with 3 m lift [kg]	8,7	13,6	24,3
Catalogue No.	98 12 100410	98 12 100510	98 12 100610





## Manual chain hoists with chain drive

HIT



### Model CH-HB MOST

- Load capacity: 500 kg, 1000 kg, 2000 kg, 3000 kg.
- Load chain and operating chain galvanized.
- Standard lifting height of 3 m, optionally hoists with longer load and operating chain can be ordered.
- It is equipped with a double automatic ratchet brake to prevent the load from falling in case of sudden dynamic load.
- Lightweight and durable construction ensures easy lifting with minimum effort.
- Enlarged brake discs are asbestos-free and ensure safe operation for many years.
- The galvanized load chain and galvanized operating chain allow you to work in all weather conditions.
- The upper and lower hooks are equipped as standard with reinforced hook safety latches made of steel castings.

Model	CH-B 0,5 t	CH-HB 1,0 t	CH-HB 2 t	CH-HB 3 t
Working Load Limit [kg]	500	1000	2000	3000
Lifting height [m]	3	3	3	3
Force required to move the lever at maximum load [N]	200	320	365	385
Number of chain falls [pcs.]	1	1	1	2
Weight of the hoist with 3 m lift [kg]	10,1	12,2	20,8	24,9
Catalogue No.	98 12 003105	98 12 003113	98 12 003121	98 12 003131

05.4

## Aluminium wire rope pulling hoist

HIT



### Model H MOST

- Load capacity: 800 kg, 1600 kg, 3200 kg.
- A 30-metre long rope can be ordered as an option.

Model	H008	H016	H032
Working Load Limit [kg]	800	1600	3200
Standard rope length [m]	20	20	20
Rope stroke at one lever movement [mm]	60	60	40
Rope diameter [mm]	8,3	11	16
Weight of hoist without rope [kg]	6,4	12	23
Catalogue No.	98 12 007100	98 12 007210	98 12 007300



### ▼ 3. SLINGS



#### MOST slings



##### Textile slings acc. to EN 1492-1

Textile or nylon slings, so called protected and round-endless slings, made of different type of textile, are designed for lifting and transporting of loads highly susceptible to surface damage. Textile slings are lightweight in comparison with chain slings and have a safety factor of 7:1. In addition, the color of the sling informs the user about the working load.

In order to protect slings against abrasion and cutting edges during load transport we offer protective covers - sleeves. The protective sleeves are equipped with neodymium magnets, which allow keeping the sling in position. We also offer protective sleeves to prevent abrasion of belt and hose slings.

##### Round Slings acc to EN 1492-2

We offer round slings (hoses) in a seamless version, it is the most cost-effective solution on the market.

On request, we can supply slings with a side seam. Such slings have a double protection which increases their service life by 40%. Additionally, they are stiffer and e.g. easier to move under the load.



Round-endless sling with sleeve EN 1492-2



Textile sling EN 1492-1



Round - Endless sling



Protective corners

Lifting method	Straight tension	Loop	U-shaped	Angle $\beta=0^\circ-45^\circ$	Angle $\beta=45^\circ-60^\circ$	Angle $\beta=0^\circ-45^\circ$	Angle $\beta=45^\circ-60^\circ$
<b>Form factor</b>	M=1,0	M=0,8	M=2,0	M=1,4	M=1,0	M=0,7	M=0,5
<b>Width/colour</b>	WLL	WLL	WLL	WLL	WLL	WLL	WLL
<b>25 mm white</b>	500	400	1000	700	500	350	250
<b>30 mm violet</b>	1000	800	2000	1400	1000	700	500
<b>60 mm green</b>	2000	1600	4000	2800	2000	1400	1000
<b>90 mm yellow</b>	3000	2400	6000	4200	3000	2100	1500
<b>120 mm grey</b>	4000	3200	8000	5600	4000	2800	2000
<b>150 mm red</b>	5000	4000	10000	7000	5000	3500	2500
<b>180 mm brown</b>	6000	4800	12000	8400	6000	4200	3000
<b>240 mm blue</b>	8000	6400	16000	11200	8000	5600	4000
<b>300 mm orange</b>	10000	8000	20000	14000	10000	7000	5000
<b>300 mm orange</b>	12000	9600	24000	16800	12000	8400	6000

In order to prepare an offer, please provide the following data:

- sling length (L),
- maximum load capacity of the sling,
- number of strings.

Send your inquiry by e-mail: [export@rywal.com.pl](mailto:export@rywal.com.pl)

# 06



# INDUSTRIAL CHEMISTRY

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▼ 1. ANTI-SPATTER AGENTS



**UFO MOST**  
Anti-spatter SPRAY

HIT



Packaging- Catalogue No.:  
400 ml - 84 31 100401 (PL, EN, RU)  
400 ml - 84 31 100402 (SK, LT, RO)  
400 ml - 84 31 100403 (PL, EN, PT)\*

\*other languages available

**Properties:**

- Prevents weld spatters from adhering to surfaces.
- Helps to remove the spatters and dirt from the surfaces of welded materials and gas nozzles.
- Does not contain silicones or solvents.

**UFO BIO MOST**  
Anti-spatter SPRAY



Packaging- Catalogue No.:  
320 ml - 84 32 100401

**Properties:**

- Helps to remove the spatters and dirt from the surfaces of welded materials and gas nozzles.
- Non-flammable based on water emulsion.
- Silicone free and odorless. Contains corrosion inhibitors and therefore has anti-corrosion properties.
- Biodegradable.

**UFO CER MOST**  
Ceramic anti-spatter SPRAY



**Properties:**

- Ceramic coating spray to protect the consumables of the welding torch during the welding process.
- Forms a temperature-resistant layer up to 1400°C, which prolongs the lifetime of consumables.

Packaging- Catalogue No.:  
400 ml - 84 30 100401

**WB NOZZ MOST**  
Anti-spatter paste



**Properties:**

- Protects gas nozzles from sticking of spatters during the welding process.
- Non-flammable.

Packaging- Catalogue No.:  
340 ml - 84 23 710301

**UFO CAP MOST**

NEW  
in offer



Scan the link or go to  
<https://www.rywal.eu/f06-4>

Specially designed applicator for the gas nozzles. Ensures quick and precise application of the protective ceramic layer. UFO CAP used with UFO CER MOST optimally protects gas nozzles and consumables against sticking of welding spatters.

- Precise application.
- Savings due to less wear of consumables.
- Optimal application of the ceramic coating on the gas nozzle.
- Dries in seconds.





## WB WELDER MOST

Anti-spatter liquid



Packaging - Catalogue No.:  
 0,5 l - 84 23 781001  
 10 l - 84 23 781011  
 20 l - 84 23 781021  
 200 l - 84 23 781200

Tap type I for jumbo packaging  
 10 l - 84 23 780003  
 Plastic hand-operated pump for drums  
 200 l - 84 12 100050

**Properties:**

- Prevents weld spatters from adhering to nozzles, welded parts, torches and clamping devices.
- No silicone.
- Does not contain hazardous substances dangerous to health.
- If necessary, clean or degrease the surface before further treatment (galvanizing, painting, etc.).
- Optional equipment for 10/20 liters packages: tap type I (see page 240).

## WB MASTER MOST

Anti-spatter liquid



Packaging - Catalogue No.:  
 0,5 l - 84 23 780001  
 10 l - 84 23 780011  
 20 l - 84 23 780021  
 200 l - 84 23 780201

Tap type I for jumbo packaging  
 10 l - 84 23 780003  
 Plastic hand-operated pump for drums  
 200 l - 84 12 100050

**Properties:**

- Prevents weld spatters from adhering to nozzles, welded parts, torches and clamping devices.
- Non-flammable, water-based formula, no silicone.
- Does not contain hazardous substances dangerous to health.
- Does not affect further surface treatment (galvanizing, painting, etc.).
- Optional equipment for 10/20 liters packages: tap type I (see page 240).

## WB MULTI MOST

Anti-spatter liquid



Packaging - Catalogue No.:  
 0,5 l - 84 23 750401  
 10 l - 84 23 750411  
 20 l - 84 23 750421  
 200 l - 84 23 750422

Tap type I for jumbo packaging  
 10 l - 84 23 780003  
 Tap type II for jumbo packaging  
 20 l - 84 23 780004  
 Plastic hand-operated pump for drum  
 200 l - 84 12 100050

**Properties:**

- Odourless agent to prevent sticking of spatters during welding with an integrated cleaning and degreasing effect.
- Prevents weld spatters from adhering to surfaces both wet and dry.
- Provides all welded metals with temporary corrosion protection.
- The surfaces can be easily galvanized or painted immediately after the welding process.
- Suitable for all welding methods, including stainless steel welding.
- Optional equipment for 10 liters packages: tap type I (see page 240).
- Optional equipment for 20 liters packages: tap type II (see page 240).

## WB BIO MOST

Anti-spatter liquid



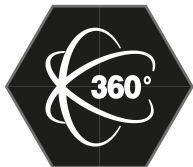
Packaging - Catalogue No.:  
 0,5 l - 84 23 750501  
 10 l - 84 23 750511  
 20 l - 84 23 750521  
 200 l - 84 23 750531

Tap type I for jumbo packaging  
 10 l - 84 23 780003  
 Tap type II for jumbo packaging  
 20 l - 84 23 780004  
 Plastic hand-operated pump for drum  
 200 l - 84 12 100050

**Properties:**

- Odourless, anti-spatter liquid, based on natural ingredients.
- Suitable for all welding methods.
- Supports welding of thin and/or heated sheet metal and multi-layer welding.
- Does not contain silicones or solvents.
- Prevents weld spatters from adhering to surfaces both wet and dry.
- Protects steel against slag adhering in CNC cutting processes.
- Provides all welded metals with temporary corrosion protection.
- Used in cleaning stations for robotic solutions.
- Optional equipment for 10 liters packages: tap type I (see page 240).
- Optional equipment for 20 liters packages: tap type II (see page 240).

## ▼ 2. PROFESSIONAL TECHNICAL SPRAYERS



**360° SYSTEM**  
spray action from any position



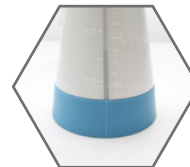
**FPM SEALS**  
high chemical resistance supporting constant operation



**BASE RING**  
stabilize and protect the tank from mechanical damages



**ADJUSTABLE NOZZLE**  
regulate spray application from mist to continuous stream



**LIQUID LEVEL INDICATOR**  
use the transparent scale and control liquid level in the tank

### Sprayer PRO 360 0,5 L MOST

**Application:**

- for easy spraying of MOST anti-spatter liquids.

Catalogue No.: 84 12 100011



**SUPER DOUBLE ACTION™**  
application when the pump layer in pressed and release

### Sprayer PRO 360 1 L PUMP MOST

**Application:**

- spraying of MOST anti-spatter and cleaning liquids,
- steel protection in CNC cutting process,
- maintenance of welding tables,
- cleaning machines and equipment.

Catalogue No.: 84 12 100014



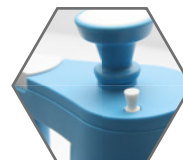
**CONVINIENT HANDLE**

work comfortably even with welding gloves



**SAFETY VALVE**

pressure always under control



**ADJUSTABLE ENDING**

get to the hard-to-reach places



The availability of various chemicals on the market requires the user to test the sprayer with the agent. RYVAL-RHC Sp. z o.o. does not provide universality of the device.

### Tap type I

Catalogue No.: 84 23 780003



**Fits to the packaging:**

- WB WELDER MOST - 10/20 l,
- WB MASTER MOST - 10/20 l,
- WB MULTI MOST - 10 l,
- WB BIO MOST - 10 l,
- CLINO 11 MOST - 10 l,
- CLINO H MOST - 10 l.

### Tap type II

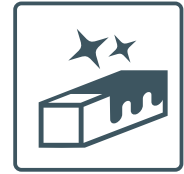
Catalogue No.: 84 23 780004



**Fits to the packaging:**

- WB MULTI MOST - 20 l,
- WB BIO MOST - 20 l.

▼ 3. METALLIC COATINGS



**ZN99L MOST**

Bright-silver zinc SPRAY

HIT

Packaging - Catalogue No.:  
400 ml - 84 24 704551



**Properties:**

- Zinc coating protects surface from aggressive environmental influences.
- Heat-resistant up to 300°C, short term up to 800°C.
- Quick-drying.
- Renews, repairs and corrects the defects on galvanized constructions caused by welding, cutting, bending, drilling, etc.
- Triple corrosion protection thanks to content of: zinc, aluminum and resin pigments.

**ZN99D MOST**

Silver-grey zinc SPRAY

Packaging - Catalogue No.:  
400 ml - 84 24 704559



**Properties:**

- Zinc coating protects surface from aggressive environmental influences.
- Heat-resistant up to 300°C, short term up to 800°C.
- Quick-drying.
- Renews, repairs and corrects the defects on galvanized constructions caused by welding, cutting, bending, drilling, etc.
- Triple corrosion protection thanks to content of: zinc, aluminum and resin pigments.

**ZN99P MOST**

Zinc paint

Packaging - Catalogue No.:  
1 kg - 84 24 703901



**Properties:**

- Zinc paste protects surface from aggressive environmental influences.
- Quick-drying.
- Renews, repairs and corrects the defects on galvanized constructions caused by welding, cutting, bending, drilling, etc.

**AL30 MOST**

Aluminium SPRAY

Packaging - Catalogue No.:  
400 ml - 84 24 701651



**Properties:**

- Aluminium coating protects surface from aggressive environmental influences.
- Resistant to high temperatures up to 800°C.
- Quick-drying.
- Electrically conductive.
- Protects metal surfaces against corrosion.
- Leaves a smooth, non-porous, dry surface-layer.



**CU40 MOST**

Copper SPRAY



Packaging - Catalogue No.:  
400 ml - 84 24 705751

**Properties:**

- Copper coating for renovation, repairs and correction of surfaces made of copper, such as roof gutters, window elements and other copper details.
- Also used for decorative purposes.
- Resistant to weather conditions.
- Quick-drying.

**NICER50 MOST**

Stainless Steel SPRAY



Packaging - Catalogue No.:  
400 ml - 84 24 705651

**Properties:**

- Chromium-nickel coating for renovation, repairs and correction of surfaces where a high esthetic effect is required.
- Anti-corrosion properties.
- Used to coat metal surfaces exposed to corrosive agents (moisture, water, sea water) and chemicals.
- Resistant to temperatures up to 300°C.

▼ **4. SURFACE DEFECTS DETECTION AGENTS**



**Set: SONDA 1 MOST / SONDA 2 MOST / SONDA 3 MOST**

Non-Destructive Testing



**Properties:**

A set of chemical products used for conducting non-destructive tests of defects after process of welding, visible in daylight, which consist of:

**Cleaner SONDA 1 MOST:**

- Quick-drying cleaning agent applied: before test - for surface preparation, during the test - to remove excess of penetrant and after test - to clean surface.

**Penetrant SONDA 2 MOST:**

- Red penetrating agent.
- Compliant with EN ISO 3452-2.
- Meets ASME Section Y, Article 6.
- Accurate and reliable in non-destructing testing.

**Developer SONDA 3 MOST:**

- Quick-drying white powder suspension.
- Compliant with EN ISO 3452-2.
- Meets ASME Section Y, Article 6.
- Accurate and reliable in non-destructing testing.

The above set is used for non-destructive defect detection method used on alloyed and non-alloyed steel, cast iron, metal sinter, copper, brass, ceramics.

Name	Form	Packaging	Catalogue No
Cleaner SONDA 1 MOST	Spray	500 ml	84 23 709031
Penetrant SONDA 2 MOST	Spray	500 ml	84 23 709011
Developer SONDA 3 MOST	Spray	500 ml	84 23 709021





**SONDA L MOST**

Leak-detector SPRAY

**Properties:**

- Chemical agent for leak detection in installations such as: gas welding equipment, pressure vessels, pneumatic pipeline, gas stoves, air conditioning systems, compressors, hose connections.

Packaging- Catalogue No.:  
400 ml - 84 25 762011



**Chemetall**

**Set: CHECKMOR 300 / S85 / LD9**

Non-Destructive Testing

**Properties:**

A set of chemical products used for non-destructive testing of welded connections, visible both under daylight and UV light, consists of:

- CHECKMOR 300 dual-use penetrant - according to EN ISO 3452 Part 2, Type I and EN ISO 3452 Part 2, Type III;
- S85 quick-drying remover with low Sulphur and halogen content, preparation according to EN-ISO 3452 Part 2;
- LD9 developer is a suspension of inert white powder in a fast-drying solvent.

The above set is used for surface tests of forged, welded and cast parts, such as steel, cast iron, aluminium alloys, ceramics, sinter, copper alloys.



Name	Form	Packaging	Catalogue No
Penetrant CHECKMOR 300	spray	400 ml	84 23 709610
Remover S85	spray	300 ml	84 23 709630
Developer LD9	spray	400 ml	84 23 709620

**Set: SUPRAMOR 4 BLACK / WCP 712 / S80**

Magnetic particle inspection

**Properties:**

A set of chemical products used for non-destructive testing in applications requiring inspection under white light, consists of:

- black magnetic testing ink SUPRAMOR 4 BLACK;
- white contrast paint WCP712;
- solvent remover aerosol S80.

Ready-to-use color contrast magnetic ink ideal for the inspection of ferromagnetic materials, structures and components. It can also be used for painted parts.



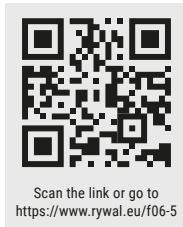
Name	Form	Packaging	Catalogue No
Black slurry SUPRAMOR 4 BLACK	spray	400 ml	84 23 721020
White primer WCP 712	spray	400 ml	84 23 721010
Undercoat remover S80	spray	400 ml	84 23 721030

▼ 5. CLEANING AND MAINTENANCE PRODUCTS



**CLINO M MOST**

Cleaning and maintenance SPRAY for welding masks



Scan the link or go to <https://www.rywal.eu/f06-5>

Packaging - Catalogue No.:  
320 ml - 84 22 760002

**Properties:**

- Perfect for cleaning and maintenance of helmet and replaceable glasses, which extends their lifetime.
- Creates an invisible protective coating.
- Special agent against adhering and melting of spatters to welding helmets.
- Antistatic properties protect against dust and dirt.
- Safe to use.

**CLINO 3 MOST**

Technical cleaner SPRAY

HIT



Packaging - Catalogue No.:  
500 ml - 84 22 600001

**Properties:**

- Excellent for removing of dirt in workshop applications, during assembly work, repairs and inspections.
- Very good penetrating properties.
- Dissolves and removes: oils, greases, tar, wax, resins and other organic and inorganic contaminants.

**CLINO 5 MOST**

Stainless steel cleaning and conservation agent



Packaging - Catalogue No.:  
Spray 400 ml - 84 22 705551  
Liquid 5 l - 84 22 706501

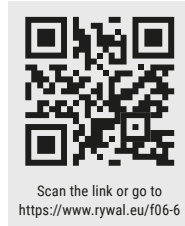
**Properties:**

- Stainless steel conservation and protection product.
- It perfectly removes fingerprints, small scratches and other dirt, leaving no streaks.
- Anti-static features make the surfaces shine.
- Mostly used in kitchens, catering, hospitals, food and health-care industries.

**CLINO 11 MOST**

Industrial Cleaner

HIT



Scan the link or go to <https://www.rywal.eu/f06-6>

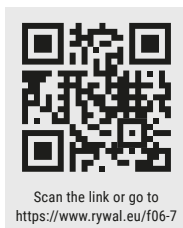
Packaging - Catalogue No.:  
0,5 l - 84 22 752512  
10 l - 84 22 752511  
Tap type I for jerry can  
10 l - 84 23 780003

**Properties:**

- Industrial cleaner (highly concentrated); soluble with water in max. proportions 1:30 depending on the level of dirt, non-flammable.
- Does not create hazardous fumes.
- Biodegradable.
- Can be used to clean engines, machines, tools, vehicles, degrease steel after metalworking processes, etc.
- Thanks to multi-purpose properties is an excellent agent for maintenance departments.
- Optional equipment for 10 liters packages: Tap type I tap (see page 240).

**CLINO C MOST**

Heavy-duty cleaning cloths



Scan the link or go to <https://www.rywal.eu/f06-7>

Packaging - Catalogue No.:  
90 pcs. - 84 22 760001

**Properties:**

- Wet wipes for quick and precise cleaning of most surfaces without water, soap and brush, e.g. tools, machines and hands.
- Accurately removes the heaviest contaminants such as grease, oil, glue, fresh remains of paint and lacquer, tar.
- The coarse side covered with a polymer net has a cleaning force. The other smooth side absorbs dirt.
- The wipes have a pleasant citrus smell and are suitable for repeated use by re-soaking.
- Ideal for everyday and mobile use.



**CLINO 7 MOST**  
Citrus cleaner - Active foam

NEW  
in offer



Packaging - Catalogue No.:  
Spray 400 ml - 84 22 751701

**Properties:**

- Removes dirt such as oils and greases, marks made with markers, glue residues from labels and adhesive tapes, chewing gum, scuff marks on vehicles, pencil marks, pens, stickers from glass surfaces and window frames, etc.
- Quick drying of the cleaned surface.
- High concentration of natural active ingredients, Neutral pH.

**CLINO 200 MOST**  
Hand Washing Paste

NEW  
in offer



Packaging - Catalogue No.:  
500 ml - 84 23 200001  
10 l - 84 23 200002

Dispenser MOST  
Catalogue No.: 84 23 200010

Concentrated handwashing paste designed to remove very strong dirt (wood flour as an abrasive).

**Properties:**

- Highly effective natural ingredients and abrasive material create a protective barrier even for very sensitive skin.
- Dermatologically tested, pH neutral for skin.
- Environmentally friendly thanks to natural ingredients.
- Very fine wood flour does not cause clogging of sanitary systems.
- Does not leave a sticky film after use.
- Very Economical to use.

▼ **6. COOLING AGENTS**

**COOL 10 MOST**  
SPRAY coolant

**Properties:**

- Cooling agent for metalworking such as: threading, drilling, cutting, milling.
- Useful for the hardest stainless steel and titanium to soft metals (copper, brass, aluminium).
- Does not drip from the place of metalworking.
- Extends the lifetime of drills and cutting tools.
- Significantly speeds up the metalworking process.

Packaging - Catalogue No.:  
400 ml - 84 23 700302



Scan the link or go to  
<https://www.rywal.eu/f06-2>

**COOLMAX MOST**  
Emulsifying metalworking liquid

Packaging - Catalogue No.:  
5 kg - 84 53 999005  
20 kg - 84 53 999020



**Properties:**

- Multifunctional, semi-synthetic, high quality emulsifying concentrate designed for a wide range of ferrous and non-ferrous metal processing.
- Very good anticorrosive properties, high resistance to bacteria leading to extended lifetime of the coolant.
- Used for metal treatment such as: cutting, turning, milling, drilling, threading of medium and hard to treat materials, as well as for grinding operations.

**COOL 30 MOST**  
Cooling agent

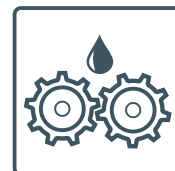
Packaging - Catalogue No.:  
5 l - 84 23 903105



**Properties:**

- Special fluid for cooling all liquid-cooled welding and plasma torches.
- Frost-resistant and non-conductive.
- Protects the torch, hoses, cables and pump from electrolytic corrosion.
- Lubricates the pump, cleans the cooling system and effectively dissipates heat.

▼ 7. LUBRICANTS



**LUBO 1 MOST**  
Multi-purpose agent DUO-SPRAY

Packaging - Catalogue No.:  
400 ml - 84 21 810001



**LUBRICATIONS**  
improves operation of locks, hinges,  
guides and other movable metal  
parts



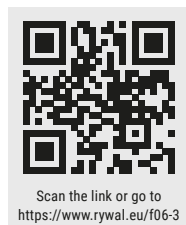
**WATER REMOVAL**  
removes moisture  
and prevents corrosion



**PENETRATION**  
makes it easier to unscrew  
rusty and sealed items such as  
bolts, nuts, etc.



**CLEANING**  
allows to remove many types of  
dirt from most surfaces



**EASY-TO-USE**  
makes application easy and  
precise with DUO-SPRAY applicator

**LUBO 2 MOST**  
Silicone SPRAY



Packaging - Catalogue No.:  
400 ml - 84 44 151917

- Properties:**
- Excellent lubricating properties.
  - Provides long-term protection, maintenance and insulation of plastic, rubber and metal parts.
  - Preservation from dirt and protection against moisture.
  - Anti-adhesive properties – makes it easy to remove form molds.
  - Application area: joints, tools, valves, locks, belts, bearings, doors and hinges.

**LUBO 3 MOST**  
PTFE SPRAY



Packaging - Catalogue No.:  
400 ml - 84 44 151919

- Properties:**
- Dry PTFE is temperatures resistant to -20°C and to 200°C.
  - Provides dry lubrication.
  - Effectively reduces friction and eliminates and prevents squeaking.
  - Creates a colorless protective film protecting against dirt, dust and water.
  - Areas of application: belt conveyors, chains, slide rails, guides.



▼ 8. ANTI-CORROSION AND PROTECTIVE AGENTS



**CORO 1 MOST**  
Corrosion protection wax SPRAY



Packaging - Catalogue No.:  
400 ml - 84 25 702001

**Properties:**

- Protects all metals from corrosion, creates temporary corrosion protective coating.
- Recommended during storage or transport.
- Use a cleaner CLINO 3 MOST spray to remove the protective coating.

**CORO 2 MOST**  
Rust remover MoS<sub>2</sub>

NEW  
in offer



Packaging - Catalogue No.:  
400 ml - 84 25 702 02

**Properties:**

- Fast dissolution of rust because of excellent penetration.
- Protection against rust and oxidation.
- Makes moving parts such as screws, nuts, bolts, hinges etc. working again.

**GALVA Set MOST**

Galvanizing kit

**Description:**

A set of specialized products intended for the preparation of steel elements for the hot-dip galvanizing process and supplementing the zinc coating.

**The kit includes:**

- Galvanizer Marker - for marking before galvanizing
- Galva Protect - protecting coating against galvanizing
- Brush - for Galva Protect application
- CLINO 3 - Technical Cleaner
- ZN99L - zinc spray bright-silver
- GRIP PRO - pistol grip for aerosols

Catalogue No.: 84 22 860002



**SOLAR FLUX TYP B**

Shields the weld joint from oxygen

**Properties:**

- Recommended in welding of stainless steel, (except 309, 310), precipitation hardening steels, chrome-moly steels, other alloy steels with nickel content below 25%.
- To apply: mix Solar Flux with alcohol (methanol/methyl alcohol preferred) and brush on the weld joint.
- Specially formulated for stainless steel & high nickel super alloys. Ideal for pipe and tube welding.
- Formulated to shield the back of the weld joint from oxygen, dissipate heat and unwanted oxides, and to clean the surface of the metal.



Packaging - Catalogue No.:  
450 g - 84 40 000010

## ▼ 9. PICKLING AND PASSIVATION AGENTS FOR STAINLESS STEEL



# Antox®

### ANTOX 75E

Pickling remover

Packaging - Catalogue No.:  
 1 kg - 84 10 750001  
 5 kg - 84 10 750005  
 20 kg - 84 10 750020



**Properties:**

- Stainless steel pickling remover for rust of foreign origin and brightening.
- Does not contain hydrochloric acid and chlorides.
- Pickling time: 20-30 min.
- Efficiency (1 kg): 20-25 m<sup>2</sup>.
- Application method: by brush/spray/bath.

### ANTOX 76E

Pickling remover

Packaging - Catalogue No.:  
 5 kg - 84 10 760005  
 10 kg - 84 10 760010



**Properties:**

- Stainless steel pickling remover for rust of foreign origin and brightening.
- Also contains nitric acid for surface passivation.
- Very useful after mechanical surface treatment: grinding and sandblasting, to restore the passivation layer of treated surfaces.
- Pickling time: 15-30 min.
- Efficiency (1 kg): 20 m<sup>2</sup>.
- Application method: by brush/spray/bath.

### ANTOX 71E PLUS

Pickling and passivation paste

Packaging - Catalogue No.:  
 2 kg - 84 10 710002



**Properties:**

- Highly effective pickling and passivation paste (transparent) for removing scale and discoloration from welds formed in the welding process of stainless steels and nickel alloys.
- Pickling time: steel: 15-60 min, nickel: 5-20 min.
- Efficiency (1 kg): 50-80 rm.
- Application method: brush.

### ANTOX 71E EXTRA

Pickling and passivation paste

Packaging - Catalogue No.:  
 2 kg - 84 10 711002



**Properties:**

- Highly effective pickling and passivation paste (transparent) for removing scale and discoloration from welds created in the welding process of stainless steels and nickel alloys.
- Characterized by a stronger action than ANTOX 71 E PLUS.
- Pickling time: steel: 15-60 min, nickel: 5-20 min.
- Efficiency (1 kg): 50-80 rm.
- Application method: brush.

### ANTOX 73E SG

Stainless steel pickling gel

Packaging - Catalogue No.:  
 10 kg - 84 10 730011



**Properties:**

- Highly effective spray gel for pickling welds and stainless steel surfaces for use in a single work cycle.
- Contains colorant.
- Pickling time: 15-60 min.
- Efficiency (1 kg): 4-6 m<sup>2</sup>.
- Application method: aerosol (sprayer).

### ANTOX 73E EXTRA

Stainless steel pickling gel

Packaging - Catalogue No.:  
 20 kg - 84 10 732020



**Properties:**

- Highly effective, sprayable gel for pickling welds and stainless steel surfaces for use in a single working cycle.
- Possibility to use colorant.
- Characterized by stronger action than ANTOX 73 E.
- Pickling time: 10-60 min.
- Efficiency (1 kg): 4-6 m<sup>2</sup>.
- Application method: aerosol (sprayer).



### ANTOX 2001T

Pickling paste



Packaging - Catalogue No.:  
 1 kg - 84 10 001000  
 KIT A 400 g - 84 10 100400  
 KIT B 1 kg - 84 10 101000

**Properties:**

- For removing scale and discoloration from welds made by TIG welding, as well as for cleaning heavily dirty or rusted stainless steel machinery and equipment.  
 \*Recommended especially for polished steels, as it is the only pickling paste that DOES NOT MATT the surface after use.
- Not recommended for externally mounted parts.
- Available also as a set for application and polishing (KIT A and KIT B) containing cleaners, plugs, spatulas and gloves.
- Pickling time: rust, steel: 10-15 min, polished steel: 1-3 min.
- Application method: manual.

### ANTOX ALU-CLEANER 101

Pickling and cleaning agent for aluminium



Packaging - Catalogue No.:  
 1 kg - 84 14 101001  
 5 kg - 84 14 101005  
 20 kg - 84 14 101020

**Properties:**

- Pickling and cleaning agent for aluminum.
- Ideal before or after welding, as well as before painting.
- Results in clean, shiny surfaces free of aluminum oxides.
- Time of action: 2-3 min.
- Efficiency (1kg): 20 m<sup>2</sup>.
- Application method: by brush/spray/bath.

### ANTOX 80E

Pickling bath agent for stainless steel



Packaging - Catalogue No.:  
 20 kg - 84 10 800020  
 200 kg - 84 10 800200

**Properties:**

- Pickling bath agent for stainless steels for multiple application.
- Dilute with distilled water at a ratio of 1:1 before use.
- Pickling time: from 15 min to 3 hours (depending on the multiplicity of use of the same bath).
- Efficiency (1 kg): 4 m<sup>2</sup>.
- Application method: bath.

### ANTOX 90E

Stainless steel passivator



Packaging - Catalogue No.:  
 5 kg - 84 10 900005  
 20 kg - 84 10 900020

**Properties:**

- Passivator for stainless steels for quick creation of a chromium oxide passivation layer.
- Mainly used after spray and bath pickling.
- Also used to restore the passivation layer after machining the surface of stainless steel.
- Dilute with distilled water at a ratio of 1:1 before use.
- Pickling time: 20-30 min.
- Efficiency (1 kg): 20-25 m<sup>2</sup>.

### ANTOX NP

Neutralizer for pickling paste



Packaging - Catalogue No.:  
 2 kg - 84 10 100002

**Properties:**

- Neutralizer in the form of white paste suitable for neutralizing ANTOX, MOST pickling pastes.
- Efficiency (1 kg): 50-80 m<sup>2</sup>.
- Method of application: brush.





### MOST BLUE

Pickling and pasivating paste

HIT



Packaging- Catalogue No.:  
2 kg - 84 17 100002

**Properties:**

- Pickling paste (transparent) for removing scale layers and weld discoloration created during the welding process of stainless steels and nickel alloys.
- Exposure time: 15-60 min (steel).
- Efficiency (1 kg): 50-80 m.
- Application method: pickling brush.

### MOST NEUTRALIZATOR

Neutralizing paste



Packaging- Catalogue No.:  
2 kg - 84 17 300002

**Properties:**

- Neutralizer paste to neutralize the action of: ANTOX, MOST pickling pastes.
- Efficiency (1 kg): 50-80 m
- Application method: pickling brush.

### Pickling Agents sprayers



1,5 l Acid Line sprayer



6,0 l Acid Line sprayer

Name	Catalogue No	Description
1,5 l Acid Line sprayer	84 12 100016	Specialist, made of acid-resistant materials, efficient hand sprayer designed for spraying ANTOX, MOST agents.
6,0 l Acid Line sprayer	84 12 890000	



## Brushes for the pickling & pasivating agents



POLSIN brush



ANTOX brush - angular, wide



ANTOX brush - round, narrow



ANTOX brush - simple



ANTOX brush - angular, narrow



ANTOX brush - special



ANTOX brush - small

Name	Description	Catalogue No
<b>POLSIN 20 brush</b>	Acid resistant round brush for application of pickling pastes, diameter 20 mm.	84 11 000020
<b>POLSIN 25 brush</b>	Acid resistant round brush for application of pickling pastes, diameter 25 mm.	84 11 000025
<b>POLSIN 30 brush</b>	Acid resistant round brush for the application of pickling pastes, diameter 30 mm.	84 11 000030
<b>ANTOX brush - simple</b>	ANTOX 020151 brush with 50 mm wide flat head, acid resistant, for application of pickling pastes.	84 11 020151
<b>ANTOX brush - angular, wide</b>	ANTOX 020152 brush with 45 mm wide angle head, acid resistant, for application of pickling pastes.	84 11 020152
<b>ANTOX brush - angular, narrow</b>	ANTOX 020153 brush with 25 mm wide angle head, acid resistant, for application of pickling pastes.	84 11 020153
<b>ANTOX brush - round, narrow</b>	ANTOX 020156 brush with round head approx. 15 mm diameter, short, acid-resistant, for the application of pickling pastes.	84 11 020156
<b>ANTOX brush - special</b>	ANTOX 020162 brush with flat head approx. 30 mm wide, short, acid-proof, for the application of pickling pastes.	84 11 020162
<b>ANTOX brush - small</b>	ANTOX 020163 brush with 12 mm wide flat head, very short, acid resistant, for application of pickling pastes.	84 11 020163

## ▼ 10. MARKERS AND TERMOINDICATORS



### Termoindicators TEMPILSTIK

Pencils for pre-welding markings

**Properties:**

- They are a quick and cheap way to accurately measure surface temperatures of various metals.
- Thermo-pencils are used to mark a workpiece before heat treatment.
- The pencil mark will melt when the heated workpiece reaches the designated temperature (it becomes liquid exactly at nominal temperature).
- The TEMPILSTIK are available in 116 temperature indications from 38°C to 1093°C.



**Temperature - Catalogue No.:**

- 55°C - 50 37 910055
- 80°C - 50 37 910080
- 100°C - 50 37 910100
- 125°C - 50 37 910125
- 150°C - 50 37 910150
- 175°C - 50 37 910175
- 200°C - 50 37 910200
- 220°C - 50 37 910220
- 250°C - 50 37 910250
- 280°C - 50 37 910280
- 320°C - 50 37 910320
- 450°C - 50 37 910450
- 550°C - 50 37 910550
- 800°C - 50 37 910800



### Marking starter kit

Set of professional markers 8 pcs.

The starter set is a set of 8 specialist markers, differentiated in terms of the type and place of application, allowing for a wide range of applications. Designed for the most demanding professional users looking for markers for industrial marking.

**Applications:** Automotive industry, welding, metalworking, construction, etc.

**Catalogue No.:** 84 50 000001

**NEW**  
in offer



## ▼ 11. WELD SEAM CLEANING SYSTEMS



### RAPID MOST

Electrochemical weld cleaning device for stainless steel

- Very quick cleaning of TIG welds with a carbon brush.
- Easy to use.
- Quick tool change.

**Catalogue No.:**

RAPID MOST - 84 16 000010  
 RAPID RED Electrolyte - 84 12 000001  
 Case with equipment - 84 16 000011



### 6024 RS BYMAT

Device for cleaning welding joints

- Very fast cleaning of TIG and MIG/MAG welds.
- Polishing.
- Dark and light marking.
- Adjustable voltage.
- Display with multilingual menu.

**Catalogue No.:**

6024 RS BYMAT - 84 16 602400  
 Case with accessories - 84 16 602401

### 1140 RS BYMAT

Device for cleaning welding joints

- Very fast cleaning of TIG and MIG/MAG\* welds.
- Polishing.
- Dark and light marking.
- Display with multilingual menu.

**Catalogue No.:**

1140 RS BYMAT - 84 16 114000  
 Case with accessories - 84 16 114001



Model	MOST RAPID	1140 RS BYMAT	6024 RS BYMAT
Dimensions WxLxH [mm]	295x145x225	420x215x350	385x163x305
Weight [kg]	7,9	17,2	8,8
Power [VA]	800	1200	1608
Input current [A]	80	100	67
TIG cleaning	●	●	●
MIG cleaning	○	●*	●
Polishing	○	●	●
Dark marking	○	●	●
Light marking	○	●	●
Adjustable voltage	○	○	●
Guarantee period	1 year	1 year	2 years

\*using C PLUS electrolyte only

## Choice of liquids for MOST/BYMAT weld cleaning devices



Name	Application	Catalogue No
Electrolyte neutralizator NT 1 L BYMAT	neutralization	84 16 221101
Electrolyte neutralizator NT 5 L BYMAT	neutralization	84 16 225000
Electrolyte ET 5 L BYMAT	dark marking	84 16 211500
Electrolyte ET 1 L BYMAT	dark marking	84 16 211100
Electrolyte EN 1 L BYMAT	light marking	84 16 217100
Electrolyte EN 5 L BYMAT	light marking	84 16 218500
Electrolyte LF 1 L BYMAT	cleaning	84 16 203000
Electrolyte LF 5 L BYMAT	cleaning	84 16 203500
Electrolyte A 1 L BYMAT	cleaning	84 16 203001
Electrolyte A 5 L BYMAT	cleaning	84 16 203501
Electrolyte C 1 L BYMAT	cleaning	84 16 202100
Electrolyte C 5 L BYMAT	cleaning	84 16 202500
RAPID RED Electrolyte MOST	cleaning	84 12 000001
Electrolyte C PLUS 1 L BYMAT	cleaning / polishing	84 16 204000
Electrolyte C PLUS 5 L BYMAT	cleaning / polishing	84 16 204500

Performance	Safety

## MOST/BYMAT equipment for weld cleaning devices

Name	Catalogue No	Photo
Cleaning felt 1206 SF 38 x 60 x 2,6 mm, 20 pcs.	84 16 120600	
Cleaning felt 1207 SF, 38 x 60 x 2,6 mm, 100 pcs.	84 16 120700	
Polishing felt 1216 PF, 40 x 60 x 2,5 mm, 20 pcs.	84 16 121600	
Replacement brush blue 8 mm	84 16 602500	
Replacement brush black 10 mm	84 16 602600	
Replacement brush red 14 mm	84 16 602700	
PTFE adjustment sleeve 8 mm 6025 VH	84 16 602503	
PTFE adjustment sleeve 10 mm 6026 VH	84 16 602609	
PTFE adjustment sleeve 14 mm 6027 VH	84 16 602702	
Replacement brush blue 8 mm with adjustment sleeve	84 16 602501	
Replacement brush black 10 mm with adjustment sleeve	84 16 602601	
Replacement brush red 14 mm with adjustment sleeve	84 16 602701	

# 07





# BRAZING AND SOLDERING CONSUMABLES

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▼ 1. SILVER BASED ALLOYS CADMIUM FREE



- Available as:**
- uncoated rods,
  - coated rods,
  - coils,
  - wires,
  - strips,
  - powders,
  - pastes,
  - rings.

Catalogue No.	Symbol	Composition [%]					Temperature range (SOLIDUS-LIQUIDUS)						Density [g/cm³]	Tensile strength [kg/mm²]	Standards		
		Ag	Cu	Zn	Sn	Si	610°C	650°C	690°C	730°C	770°C	810°C			850°C	ISO 17672	EN 1044
<b>Silver solders with the addition of tin</b>																	
31 60 XXXXXX	Ag60Sn	60	23	14	3		620-685							9,6	48		AG 101
31 56 XXXXXX	Ag56Sn	56	22	17	5		620-650							9,4	48	Ag 156	AG 102
31 55 XXXXXX	Ag55Sn	55	21	22	2		630-660							9,4	44	Ag 155	AG 103
31 45 XXXXXX	Ag45Sn	45	27	25,5	2,5		640-680							9,2	43	Ag 145	AG 104
31 40 XXXXXX	Ag40Sn	40	30	28	2		640-700							9,1	44	Ag 140	AG 105
31 38 XXXXXX	Ag38Sn	38	31	29	2		660-720							9,1	45	Ag 138	
31 34 XXXXXX	Ag34Sn	34	36	27,5	2,5		630-730							9	48	Ag 134	AG 106
31 30 XXXXXX	Ag30Sn	30	36	32	2		650-750							8,8	48	Ag 130	AG 107
31 25 XXXXXX	Ag25Sn	25	40	33	2		680-760							8,8	48	Ag 125	AG 108
<b>Silver solders without the addition of tin</b>																	
31 60 XXXXXX	Ag60	60	26	14			695-730							9,5	45		AG 202
31 45 XXXXXX	Ag44	44	30	26			670-730							9,1	51	Ag 245	AG 203
31 40 XXXXXX	Ag40	40	30	30			660-720							9,1	46	Ag 244	
31 35 XXXXXX	Ag35	35	32	33			680-730							9	48	Ag 235	
31 30 XXXXXX	Ag30	30	38	32			690-760							8,9	50	Ag 230	AG 204
31 25 XXXXXX	Ag25	25	40	35			690-800							8,8	45	Ag 225	AG 205
31 20 XXXXXX	Ag20	20	44	36		X	690-810							8,7	43		AG 206
31 12 XXXXXX	Ag12	12	48	40		X	800-880							8,4	48	Ag 212	AG 207
31 05 XXXXXX	Ag5	5	55	40		X	820-890							8,4	48	Ag 205	AG 208

For soldering work we recommend the use of:

- Safety glasses DIN5 - see chapter 04.
- Protective gloves - see chapter 04.
- Filtration equipment - see chapter 05.2.

## ▼ 2. SILVER BASED ALLOYS FOR SPECIAL APPLICATIONS



**Available as:**

- uncoated rods,
- coated rods,
- coils,
- wires,
- strips,
- powders,
- pastes,
- rings.



Catalogue No.	Symbol	Composition [%]						Temperature range (SOLIDUS-LIQUIDUS)							Density [g/cm³]	Tensile strength [kg/mm²]	Standards	
		Ag	Cu	Zn	Ni	Mn	Other	600°C	660°C	720°C	780°C	840°C	900°C	960°C			ISO 17672	EN 1044
<b>Nickel silver fuses</b>																		
31 27 XXXXXX	Ag27MnNi	27	38	20	5,5	9,5				680-830					8,7	53	Ag 427	AG 503
31 40 XXXXXX	Ag40Ni	40	30	28	2				670-780					8,9		Ag 440		
31 49 XXXXXX	Ag49MnNi	49	16	23	4,5	7,5			680-705					8,9	55	Ag 449	AG 502	
31 49 XXXXXX	Ag49MnNi/1	49	27	21	0,5	2,5			670-890					8,9				
31 50 XXXXXX	Ag50Ni	50	20	28	2				660-715					9	45	Ag 450		
<b>Copper-free silver fused (ammonia resistant)</b>																		
31 72 XXXXXX	Ag72Zn	72		28					710-730					8,4	44			
<b>Zinc-free silver solder (intended for soldering in ovens)</b>																		
31 99 XXXXXX	Ag99,99	99,99											960	10,5				
31 60 XXXXXX	Ag60Sn/1	60	30				Sn10	600-720						9,8		Ag 160	AG 402	
31 72 XXXXXX	Ag72	72	28							780				10	35	Ag 272	AG 401	
31 40 XXXXXX	Ag40Ni/1	40	58		2					780-900				9,6	35			
<b>Silver solders with the addition of indium</b>																		
31 56 XXXXXX	Ag56InNi	56	27	-	2,5	-	In14,5	600-710									AG 403	

## ▼ 3. ALUMINIUM AND ZINC SOLDERS



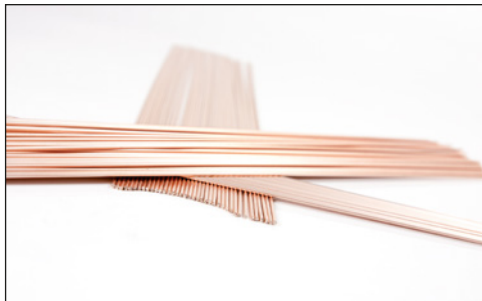
**Available as:**

- wires,
- rods,
- flux cored rods,
- flux-cored wires on spool,
- rings.



Catalogue No.	Symbol	Composition [%]						Temperature range (SOLIDUS-LIQUIDUS)							Standards	
		Al	Si	Mg	Mn	Zn	Zr	555°C	560°C	565°C	570°C	575°C	580°C	585°C	ISO 17672	EN 1044
<b>Aluminium solder</b>																
35 12 XXXXXX	AlSi12	the rest	12	0,05	0,15	0,15						573-585			Al112	Al104
<b>Zinc solders</b>																
								410°C	420°C	430°C	440°C	450°C	460°C	470°C		
35 98 XXXXXX	AlZn98	2				98				430-440					L-ZnAl2	
35 78 XXXXXX	AlZn78	22				78					441-471				L-ZnAl22	

## ▼ 4. COPPER-PHOSPHORUS ALLOYS



Available as:

- rods,
- wires,
- strips,
- powders,
- pastes.

Catalogue No.	Symbol	Composition [%]					Temperature range (SOLIDUS-LIQUIDUS)								Density [g/cm <sup>3</sup> ]	Tensile strength [kg/mm <sup>2</sup> ]	Standards	
		Ag	Cu	P	Sn	Si	640°C	670°C	700°C	730°C	760°C	790°C	820°C	850°C			ISO 17672	EN 1044
33 08 XXXXXX	CuP8		92	8					710-750						8	60		CP 201
33 08 XXXXXX	CuP8 Nano		92	8					710-750						8	60		CP 201
33 07 XXXXXX	CuP7,5		93	8					710-760						8,1	58		
33 07 XXXXXX	CuP7		93	7					710-800						8,1	58	CuP 180	CP 202
33 07 XXXXXX	CuP7 Nano		93	7					710-800						8,1	58	CuP 180	CP 202
33 06 XXXXXX	CuP6		94	6					710-880						8,1	56		CP 203
33 06 XXXXXX	CuP6 Nano		94	6					710-880						8,1	56		CP 203
33 07 XXXXXX	CuP7Sn		86	7	7		650-700								8	60	CuP 386	CP 302
34 03 XXXXXX	Ag0,3CuPSn	0	92	7	1				700-790						8,1	60		
34 04 XXXXXX	Ag0,4CuP	0	93	7					650-810						8,2	58		
34 02 XXXXXX	Ag2CuP	2	92	7					650-810						8,1	55	CuP 279	CP 105
34 02 XXXXXX	Ag2CuP Nano	2	92	7					650-810						8,1	55	CuP 279	CP 105
34 02 XXXXXX	Ag2CuPSi	2	92	7		X			650-810						8,1	55		
34 05 XXXXXX	Ag5CuP	5	89	6					650-810						8,2	55	CuP 281	CP 104
34 05 XXXXXX	Ag5CuP Nano	5	89	6					650-810						8,2	55	CuP 281	CP 104
34 05 XXXXXX	Ag5CuPSi	5	89	6		X			650-810						8,2	55		
34 06 XXXXXX	Ag6CuP	6	87	7					650-810						8,3	55	CuP 283	
34 10 XXXXXX	Ag10CuP	10	84	6					650-740						8,3	65		
34 15 XXXXXX	Ag15CuP	15	80	5					650-750						8,4	54	CuP 284	CP 102
34 15 XXXXXX	Ag15CuP Nano	15	80	5					650-800						8,4	54	CuP 284	CP 102
34 18 XXXXXX	Ag18CuP	18	75	7			650								8,4	50	CuP 286	CP 101

For copper soldering we recommend using:

- Copper coating spray dedicated for covering of surfaces after soldering - CU40 MOST - see chapter 6.



▼ 5. BRASS ALLOYS



Available as:

- rods,
- coated rods,
- wires,
- strips,
- powders,
- pastes.



Catalogue No.	Symbol	Composition [%]								Temperature range (SOLIDUS-LIQUIDUS)					Density [g/cm³]	Tensile strength [kg/mm²]	Standards	
		Cu	Zn	Ag	Ni	Mn	Sn	Si	Other	860°C	870°C	880°C	890°C	900°C			ISO 17672	EN 1044
32 60 XXXXXX	Cu60Zn	60	the rest					x				875-895			8,4	40	Cu 470a	CU 301
32 59 XXXXXX	Cu59ZnSn	59	the rest				x	x				875-895			8,4	45	Cu 470	CU 302
32 59 XXXXXX	Cu59ZnSnMn	59	the rest		x	x	1	x				870-890			8,4	45	Cu 681	CU 306
32 59 XXXXXX	Cu59ZnAg	59	the rest	1		x	x	x				860-890			8,4	45		
32 59 XXXXXX	SUPER Cuprox	59	the rest	1		x	x	x				860-890						
										880°C	890°C	900°C	910°C	920°C				
32 48 XXXXXX	Cu48ZnNi10	48	the rest		10			x				890-920			8,7	54	Cu 773	CU 305
32 48 XXXXXX	Cu48ZnNi9Ag	48	the rest	1	9			x				890-920			8,7	54		
32 53 XXXXXX	Cu53ZnNi6	53	the rest		6			x				900-920			49			
										880°C	930°C	980°C	1030°C	1080°C				
32 97 XXXXXX	Cu97Ni3B	97			3				B 0,03					1081-1101	8,9		Cu 186	
32 87 XXXXXX	Cu87MnCo3	87				10			Co 3			980-1030			8,7			
32 86 XXXXXX	Cu86MnNi2	86			2	12						960-990			8,8			
32 85 XXXXXX	Cu85MnNi3	85			3	12						960-990			8,8			
32 58 XXXXXX	Cu58ZnMnCo2	57,5	38,5			2			Co 2	880-930					8,2			
32 52 XXXXXX	CuMn38Ni9,5	52,5			9,5	38				880-925					7,7			
32 99 XXXXXX	Cu99,9	99,9												1083	8,9	22		CU 101

▼ 6. COOPER SANDWICHED ALLOYS - TRIMETALS



Available as:

- strips
- strips on the spool.



Catalogue No.	Symbol	Composition [%]					Temperature range (SOLIDUS-LIQUIDUS)							Density [g/cm³]	Proportions
		Ag	Cu	Zn	Ni	Mn	650°C	670°	690°C	710°C	730°C	750°C	770°C		
31 49 XXXXXX	Ag49MnNi/1 TR	49	28	21	0,5	2,5		670-690						9	1:2:1
31 49 XXXXXX	Ag49MnNi/1 TR 161	49	28	21	0,5	2,5		670-690					9	1:6:1	
31 49 XXXXXX	Ag49MnNi/1 TR 111	49	28	21	0,5	2,5		670-690					9	1:1:1	
31 40 XXXXXX	Ag40Ni TR	40	30	28	2				670-780				8,9	1:2:1	
31 38 XXXXXX	Ag38MnNi TR	38	26	24	4,5	7,5		650-690					8,9	1:2:1	

▼ 7. SOFT SOLDERS



Available as:

- bars,
- rods,
- wire without flux,
- flux-cored wires,
- powders,
- pastes.

Catalogue No.	Symbol	Composition [%]					Temperature range (SOLIDUS-LIQUIDUS)						Standards	
		Sn	Pb	Ag	Cd	Other	170°C	200°C	230°C	260°C	290°C	320°C	DIN 1707	EN 29453
30 99 XXXXXX	Sn100	99,9							232					
30 80 XXXXXX	SnPb80/20	80	20				183-205						Sn80Pb20	
30 63 XXXXXX	SnPb63/37	63	37				183						Sn63Pb	S-Sn63Pb37
30 60 XXXXXX	SnPb60/40	60	40				183-190						Sn60Pb	S-Sn60Pb40
30 50 XXXXXX	SnPb50/50	50	50				183-215						Sn50Pb	S-Pb50Sn50
30 40 XXXXXX	SnPb40/60	40	60				183-235						Pb60Sn	S-Pb60Sn40
30 33 XXXXXX	SnPb33/67	33	67				183-242						PbSn33	
30 30 XXXXXX	SnPb30/70	30	70				183-255						PbSn30	S-Pb70Sn30
30 08 XXXXXX	SnPb8/92	8	92							280-305				S-Pb92Sn8
30 99 XXXXXX	Pb100		99,9									327		
							200°C	210°C	220°C	230°C	240°C	250°C		
30 95 XXXXXX	SnSb95/5	95				Sb 5				230-240			SnSb5	S-Sn95Sb5
30 97 XXXXXX	SnCu97/3	97				Cu 3				230-250			SnCu3	S-Sn97Cu3
							250°C	260°C	270°C	280°C	290°C	300°C		
30 99 XXXXXX	Cd82Zn16Ag			2	82	Zn 16			270-280				Cd82Zn16Ag2	
							170°C	200°C	230°C	260°C	290°C	320°C		
30 98 XXXXXX	Ag2Sn	98		2				221-225						
30 96 XXXXXX	Ag3,5Sn	96,5		3,5				221						S-Sn97Ag3
30 95 XXXXXX	Ag5Sn	95		5				221-235					SnAg5	
30 90 XXXXXX	Ag10Sn	90		10					221-300					
30 63 XXXXXX	Ag1,4SnPb	63	35,6	1,4			178						Sn63PbAg	
30 05 XXXXXX	Ag1,5SnPb	5	93,5	1,5								296-301		

For soldering work we recommend the use of:

- Safety glasses DIN5 - see chapter 04.
- Protective gloves - see chapter 04.
- Filtration equipment - see chapter 05.2.

## ▼ 8. FLUXES



Available as:

- powders,
- pastes.



Catalogue No.	Symbol	Temperature range				Form			Standards	Application
		500°C	650°C	800°C	1050°C	Powder	Paste	Liquid	EN 1045	
<b>Fluxes for silver-based solders</b>										
39 02 XXXXXX	FLUX AG1	550-800				X	X		FH 10	for general purposes
39 02 XXXXXX	FLUX AG2	550-800				X			FH 10	general purpose – sticks easily to the solder rod
39 02 XXXXXX	FLUX AG3	600-850				X	X		FH 10	for high temperature
39 02 XXXXXX	FLUX AG4	550-800				X	X		FH 10	general purpose - very wide temperature range
39 02 XXXXXX	FLUX AG5		700-1000			X	X		FH 20	for very high temperatures
39 02 XXXXXX	FLUX AG6	550-850				X			FH 11	for aluminium alloys general
39 02 XXXXXX	FLUX AG7	500-800				X	X		FH 10	general purpose, also for stainless steel
39 02 XXXXXX	FLUX AG8	550-800					X		FH 12	for stainless steel and hard metals
39 02 XXXXXX	FLUX AG11	500-800					X		FH 10	general purpose, also for stainless steel for use with automatic flux applicator
39 02 XXXXXX	FLUX AG12	550-800					X		FH 12	for stainless steel and hard metals - for use with automatic dispensing machines
39 02 XXXXXX	ANTIFLUX						X			prevents wetting of brazing alloys (works similarly to anti-spatter when welding)
<b>Fluxes for aluminium-based solders</b>										
39 02 XXXXXX	MOST FLUX AL1					X	X		FL 10	flame brazing of AISi12 alloys
39 02 XXXXXX	MOST FLUX AL3	550-650				X			FL 20	autogenous welding of pure aluminium
39 02 XXXXXX	MOST FLUX AL4	550-650				X			FL 20	autogenous welding of Al-Si and Al-Mg alloys
39 02 XXXXXX	MOST FLUX AL6						X			brazing with zinc-aluminium alloys
<b>Fluxes for brass-based solders</b>										
39 02 XXXXXX	MOST FLUX BR1			850-1100		X	X		FH 20/FH21	brass brazing
<b>Fluxes for Brass brazing with vaporizer systems</b>										
39 02 XXXXXX	MOST FLUX LI1			850-1100				X	FH 21	for brass brazing with Vaporizer systems, low concentration
39 02 XXXXXX	MOST FLUX LI2			850-1100				X	FH 21	for brass brazing with Vaporizer systems, medium concentration
39 02 XXXXXX	MOST FLUX LI3			850-1100				X	FH 21	for brass brazing with Vaporizer systems, high concentration
39 02 XXXXXX	MOST FLUX LI1 ECO			850-1100				X	FH 21	for brass brazing with Vaporizer systems, very low concentration, non-toxic

# 08





# ABRASIVES

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## ▼ 1. CUTTING AND GRINDING WHEELS



### Advantages of MOST cutting and grinding wheels

- Modern production technology - developed as a result of laboratory tests and marketing research.
- Selected raw materials - specially selected materials for all production process.
- Control of every single production level - quality controlled during mixture-preparation, forming, pressing and hardening process.
- Constant high efficiency – affirmed on the basis of conducted tests and users opinion.

### Marking of cutting and grinding wheels

The diagram shows a circular grinding wheel with various markings. Callouts point to the following information:

- Trade name:** most
- EAC Certificate:** EN12413
- Application:** TURBO
- OSA certificate:** OSA
- Type of wheel:** 41 - flat for cutting, 42 - depressed for cutting, 27 - depressed for grinding. Wheel dimensions [mm]: Width x thickness x bore diam.
- Specification of wheels:** A - abrasive Type, 60 - grain size, T - thickness, BF - bond Type.
- Product line:** STANDARD
- Expiry date (month and year):** 15330
- Safety Pictograms:** Various icons for safety instructions.
- Max operating speed- colour bars:** 63 m/s (yellow), 80 m/s (red), 100 m/s (green).
- Max Rotation Speed:** max. 12250 RPM, max. 80m/s
- Max speed:** max. 12250 RPM, max. 80m/s

#### Storage

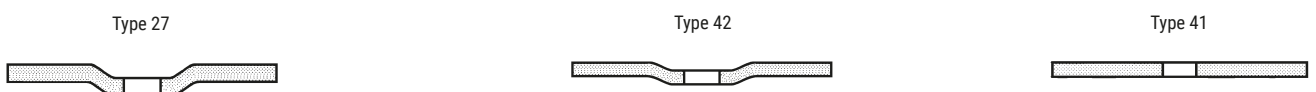
Abrasive tools require appropriate safety rules during transport and storage. They should be stored in such a way that they are not exposed to mechanical damage or harmful effects of the environment. Optimal conditions for storage and use are: temperatures from 10°C to 25°C with relative air humidity below 70%. Deviations from the recommended conditions may result in worse operating conditions for abrasive tools.

#### Safe use of abrasive tools and safety pictograms

While working with MOST cutting & grinding wheels, it is necessary to follow safety rules and regulations. The products of this group are marked with appropriate pictograms of the safety of work.


- Before starting work, read the manual for cutting & grinding wheels
- Use eyes protection while working
- Use protective glove while working
- Use respiratory protection while working
- Use hearing protection while working
- For cutting only, do not grinding
- Do not use when damaged
- Do not use for manual grinders




#### Shapes of resin bonded cutting & grinding wheels







**MOST reinforced resin bonded wheels are available in 3 production lines:  
STANDARD, PRO, CERAMIC**

<p>STANDARD MOST LINE</p> <p><b>MOST STANDARD</b></p>	 <p>MOST STANDARD INOX Type 41 ultra-thin TURBO Type 41, 27</p>	 <p>MOST STANDARD STEEL Type 41 ultra-thin SPEED Type 41, 42, 27</p>	
	<p>Universal medium-hard abrasive discs made of corundum grains. Ideal for industrial abrasive treatment in a wide range of applications. The most popular discs in MOST's range of cutting &amp; grinding wheels thanks to high quality and competitive price.</p>		

<p>PRO MOST LINE</p> <p><b>MOST PRO</b></p>	 <p>MOST PRO INOX Type 41 ultra-thin FUTURE, Type 27</p>	 <p>MOST PRO STEEL+ INOX Type 41 ultra-thin, Type 42 ultra-thin VRS</p>	 <p>MOST PRO STEEL Type 41, 42, 27</p>
	<p>Abrasive discs with increased strength and service life made of modified corundum grains. Used in demanding abrasive applications in heavy industrial conditions. Long service life and efficiency in every application area.</p>		

<p>CERAMIC MOST LINE</p> <p><b>MOST CERAMIC</b></p>	 <p>MOST CERAMIC Ultra STEEL+INOX Type 41 ultra-thin</p>	 <p>MOST CERAMIC STEEL+INOX Type 41 ultra-thin, Type 27</p>	
	<p>Special abrasive discs made of ceramic grains. Innovative solution for fast and efficient abrasive treatment of hardened and hard-to-cut steels. Very high working comfort and increased abrasiveness.</p>		

Pictograms - application



steel



inox







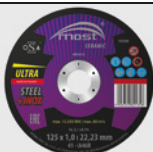


hardened steels

For protective gloves, welding helmets, safety glasses and shields, see chapter 04.



Selection of ultra-thin cutting wheels 125 x 1,0 MOST

	Thin-walled Profiles and Pipes			Thick-walled Profiles and Pipes			Thin plates			Thick plates, solid materials		
	STEEL	INOX	Tool and hardened steel	STEEL	INOX	Tool and hardened steel	STEEL	INOX	Tool and hardened steel	STEEL	INOX	Tool and hardened steel
 <b>MOST STANDARD INOX (Turbo)</b>	●	●		○	○		○	○		○	○	
 <b>MOST STANDARD STEEL (Speed)</b>	●			○			○			○		
 <b>MOST PRO INOX (Futura)</b>	●	●		●	●		●	●		●	●	
 <b>MOST PRO STEEL + INOX</b>	●	●		●	○		●	○		●	○	
 <b>MOST PRO STEEL + INOX (depressed VRS)</b>	●	●		●	○		●	●		●	○	
 <b>MOST CERAMIC STEEL + INOX</b>	○	○	●	○	○	●	○	○	●	○	○	●
 <b>MOST CERAMIC Ultra STEEL + INOX</b>	●	●	○	●	●	○	●	●	○	●	●	○

○ - acceptable  
 ● - recommended





**MOST STANDARD line**

**MOST STANDARD**

**Abrasive wheels  
MOST STANDARD INOX**



- Medium-hard discs for cutting and grinding of stainless steel.
- High cutting and grinding performance and long service life.
- Ultra-thin discs recommended for cutting of thin-walled Profiles and Pipes.
- Do not contain ferro-sulphide compounds (Fe + S + CL < 0.1%).
- Maximum speed: 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin cutting discs for stainless steel - MOST STANDARD INOX Turbo</b>					
1	115 x 1,0 x 22	13 300	50	94 14 115100	41 
2	115 x 1,6 x 22	13 300	25	94 14 115160	
3	125 x 1,0 x 22	12 250	50	94 14 125100	
4	125 x 1,6 x 22	12 250	25	94 14 125160	
5	150 x 1,6 x 22	10 200	25	94 14 150160	
6	180 x 1,6 x 22	8 500	25	94 14 180160	
<b>Cutting discs for stainless steel - MOST STANDARD INOX</b>					
1	115 x 2,0 x 22	13 300	25	94 16 711500	41 
2	125 x 2,0 x 22	12 250	25	94 16 712500	
3	150 x 2,0 x 22	10 200	25	94 16 715000	
4	180 x 2,0 x 22	8 500	25	94 16 718000	
5	230 x 2,0 x 22	6 650	25	94 16 723000	
<b>Grinding discs for stainless steel - MOST STANDARD INOX</b>					
1	115 x 6,5 x 22	13 300	10	94 21 411500	27 
2	125 x 6,5 x 22	12 250	10	94 21 412500	
3	150 x 6,5 x 22	10 200	10	94 21 415000	
4	180 x 6,5 x 22	8 500	10	94 21 418000	
5	230 x 6,5 x 22	6 650	10	94 21 423000	



**MOST STANDARD line**





**MOST STANDARD**

**Abrasive wheels  
MOST STANDARD STEEL**



- Medium-hard discs for cutting and grinding of carbon steel.
- High cutting and grinding performance and long service life.
- Ultra thin discs SPEED recommended for cutting of thin-walled Profiles and Pipes.
- Particularly attractive price/efficiency ratio.
- Maximum speed: 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin cutting discs for black steel - MOST STANDARD STEEL Speed</b>					
1	115 x 1,0 x 22	13 300	50	94 14 315100	41 
2	115 x 1,6 x 22	13 300	25	94 14 315160	
3	125 x 1,0 x 22	12 250	50	94 14 325100	
4	125 x 1,6 x 22	12 250	25	94 14 325160	
5	150 x 1,6 x 22	10 200	25	94 14 325150	
6	180 x 1,6 x 22	8 500	25	94 14 380160	
<b>Cutting Discs for black steel - MOST STANDARD STEEL</b>					
1	115 x 2,0 x 22	13 300	50	94 16 011500	41 
2	115 x 2,5 x 22	13 300	25	94 16 111500	
3	125 x 2,0 x 22	12 250	50	94 16 012500	
4	125 x 2,5 x 22	12 250	25	94 16 125000	
5	150 x 2,0 x 22	10 200	25	94 16 015000	
6	150 x 2,5 x 22	8 500	25	94 16 150000	
7	180 x 2,0 x 22	8 500	25	94 16 018000	
8	180 x 2,5 x 22	8 500	25	94 16 180000	
9	230 x 2,0 x 22	6 650	25	94 16 023000	
10	230 x 2,5 x 22	6 650	25	94 16 230000	
11	300 x 3,2 x 32	5 100	10	94 16 300000	
12	350 x 3,5 x 32	4 400	10	94 16 350000	
13	400 x 4,0 x 32	3 850	10	94 16 400000	
<b>Cutting discs for black steel - MOST STANDARD STEEL</b>					
1	115 x 3,0 x 22	13 300	25	94 20 115000	42 
2	125 x 3,0 x 22	12 250	25	94 20 125000	
3	150 x 3,0 x 22	10 200	25	94 20 150000	
4	180 x 3,0 x 22	8 500	25	94 20 180000	
5	230 x 3,0 x 22	6 650	25	94 20 230000	
<b>Grinding discs for black steel - MOST STANDARD STEEL</b>					
1	115 x 6,5 x 22	13 300	10	94 21 115000	27 
2	125 x 6,5 x 22	12 250	10	94 21 125000	
3	125 x 8,0 x 22	12 250	10	94 21 125001	
4	150 x 6,5 x 22	10 200	10	94 21 150000	
5	180 x 6,5 x 22	8 500	10	94 21 180000	
6	180 x 8,0 x 22	8 500	10	94 21 180001	
7	230 x 6,5 x 22	6 650	10	94 21 230000	
8	230 x 8,0 x 22	6 650	10	94 21 230001	



**MOST PRO line**

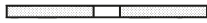



**Abrasive wheels PRO INOX**  
**MOST PRO INOX**



- Modified discs for abrasive treatment of stainless steel.
- Very good cutting and grinding parameters also for carbon steels.
- Extended service life and high efficiency in wide range of applications.
- Increased cutting speed and aggressiveness as well as grinding comfort.
- Do not contain ferro-sulphide compounds (Fe + S + CL < 0.1%).
- Maximum speed: 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin cutting discs for stainless steel - MOST PRO INOX Futura</b>					
1	125 x 1,0 x 22	12 250	50	94 14 712510	<div style="text-align: center;">41</div> 
2	125 x 1,6 x 22	12 250	25	94 14 712516	
3	150 x 1,6 x 22	10 200	25	94 14 715016	
4	230 x 1,9 x 22	6 650	25	94 14 723000	
<b>Grinding discs for stainless steel - MOST PRO INOX</b>					
1	125 x 4,2 x 22	12 250	10	94 21 612501	<div style="text-align: center;">27</div> 
2	125 x 6,8 x 22	12 250	10	94 21 612500	
3	150 x 6,8 x 22	10 200	10	94 21 615000	
4	180 x 6,8 x 22	8 500	10	94 21 618000	
5	230 x 6,8 x 22	6 650	10	94 21 623000	



**MOST PRO line**

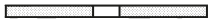
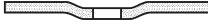
MOST PRO

**Abrasive wheels  
MOST PRO STEEL + INOX**



- Ultra-thin discs for cutting carbon and stainless steels.
- Universal features suitable for cutting thin-walled and thick-walled pipes, profiles and sheets.
- Depressed version type 42 improves stiffness of discs and reduces dangerous vibrations generated during cutting (VRS- Vibration Reduction System).
- Do not contain ferro-sulphide compounds (Fe + S + CL < 0.1%).
- Maximum speed: of 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin discs for cutting black and stainless steel - MOST PRO STEEL + INOX</b>					
1	115 x 1,0 x 22	13 300	50	94 14 615100	41 
2	115 x 1,6 x 22	13 300	25	94 14 615160	
3	125 x 1,0 x 22	12 250	50	94 14 625100	
4	125 x 1,6 x 22	12 250	25	94 14 625160	
5	150 x 1,6 x 22	10 200	25	94 14 650160	
6	180 x 1,6 x 22	8 500	25	94 14 680160	
7	230 x 1,9 x 22	6 650	25	94 14 690000	
<b>Ultra-thin discs for cutting black and stainless steel - MOST PRO STEEL + INOX VRS</b>					
1	125 x 1,0 x 22	12 250	50	94 14 512510	42 
2	125 x 1,6 x 22	12 250	25	94 14 512516	
3	150 x 1,6 x 22	10 200	25	94 14 515016	
4	180 x 1,6 x 22	8 500	25	94 14 518016	
5	230 x 1,9 x 22	6 650	25	94 14 523000	





**MOST PRO line**


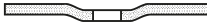
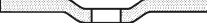


**Abrasive wheels  
MOST PRO STEEL**



- Reinforced discs for cutting and grinding black steel.
- High cutting and grinding aggressiveness and very long service life.
- Grinding discs are thicker and have additional net to reinforce the structure.
- Maximum speed: 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Cutting discs for black steel - MOST PRO STEEL</b>					
1	115 x 2,5 x 22	13 300	25	94 16 511500	<div style="text-align: center;">41</div> 
2	125 x 2,5 x 22	12 250	25	94 16 512500	
3	150 x 2,5 x 22	10 200	25	94 16 515000	
4	180 x 2,5 x 22	8 500	25	94 16 518000	
5	230 x 2,5 x 22	6 650	25	94 16 523000	
6	300 x 3,2 x 32	5 100	10	94 16 530000	
7	350 x 3,5 x 32	4 400	10	94 16 535000	
8	400 x 4,0 x 32	3 850	10	94 16 540000	
<b>Cutting discs for black steel - MOST PRO STEEL</b>					
1	115 x 2,5 x 22	13 300	25	94 20 311500	<div style="text-align: center;">42</div> 
2	125 x 2,5 x 22	12 250	25	94 20 312500	
3	150 x 2,5 x 22	10 200	25	94 20 315000	
4	180 x 2,5 x 22	8 500	25	94 20 318000	
5	230 x 2,5 x 22	6 650	25	94 20 323000	
<b>Grinding discs for black steel - MOST PRO STEEL</b>					
1	115 x 6,8 x 22	13 300	10	94 21 311500	<div style="text-align: center;">27</div> 
2	125 x 6,8 x 22	12 250	10	94 21 312500	
3	150 x 6,8 x 22	10 200	10	94 21 315000	
4	180 x 6,8 x 22	8 500	10	94 21 318000	
5	180 x 8,0 x 22	8 500	10	94 21 318001	
6	230 x 6,8 x 22	6 650	10	94 21 323000	
7	230 x 8,0 x 22	6 650	10	94 21 323001	



**MOST CERAMIC line**

MOST CERAMIC

**Abrasive wheels**

**MOST CERAMIC STEEL+ INOX**



- Innovative discs for cutting and grinding of carbon and stainless steels, alloyed and hardened steels.
- Ceramic abrasive grain used in the products ensures very high aggressiveness during abrasive treatment and reduction of processing time.
- Do not overheat the workpiece.
- Do not require high grinding force, which ensures working comfort and reduces operator fatigue.
- Significantly longer service life in comparison to conventional abrasive discs.
- Ultra-thin discs - especially recommended for cutting alloyed and hard-to-cut steels, solid and thick-walled materials.
- Do not contain ferro-sulphide compounds (Fe + S + CL < 0.1%).
- Maximum speed: 80 m/s.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin cutting discs for carbon and stainless steel - MOST CERAMIC STEEL + INOX</b>					
1	125 x 1,0 x 22	12 250	50	94 14 412510	41 
2	125 x 1,6 x 22	12 250	25	94 14 412516	
3	150 x 1,6 x 22	10 200	25	94 14 415016	
4	180 x 1,6 x 22	8 500	25	94 14 418016	
5	230 x 1,9 x 22	6 650	25	94 14 423019	
<b>Grinding discs for carbon and stainless steel - MOST CERAMIC STEEL + INOX</b>					
1	125 x 7,0 x 22	12 250	10	94 21 512500	27 
2	150 x 7,0 x 22	10 200	10	94 21 515000	
3	180 x 7,0 x 22	8 500	10	94 21 518000	
4	230 x 7,0 x 22	6 650	10	94 21 523000	

**Abrasive wheels**

**MOST CERAMIC ULTRA STEEL+INOX**



- Ultra-thin wheel with ceramic grains for cutting ordinary and stainless steel.
- Product dedicated and especially recommended for cutting carbon and alloyed steels with increased resistance.
- Extraordinary comfort and 30% faster cutting speed.
- Up to 2x more cutting capacity compared to a professional aluminium oxide wheel.



No.	Dimensions Width x thickness x bore [mm]	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	Type
<b>Ultra-thin cutting wheels for carbon and stainless steel - MOST CERAMIC Ultra</b>					
1	125 x 1,0 x 22	12 250	50	94 14 432510	41 










## ▼ 2. FLAP GRINDING DISCS



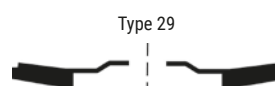
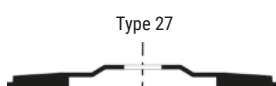
### Advantages of MOST flap grinding discs

- Flap wheels are irreplaceable abrasive tools, characterized by high versatility and efficiency.
- Combination of flaps from abrasive material with a resin backing plate makes it easy and universal abrasive treatment on angle grinders.
- Fan-shaped of abrasive flaps forces the workpiece to be cooled during grinding.
- Flexible flaps allow for precise control of the grinding process.
- Different abrasive grain and grit sizes allow using flap discs for stock removal or smoothing out surface imperfections and deburring.
- MOST's comprehensive range of Flap grinding wheels meets the expectations of most customers and is used in a wide variety of grinding applications.

### MOST flap discs are available in 3 production lines: STANDARD, PRO, CERAMIC

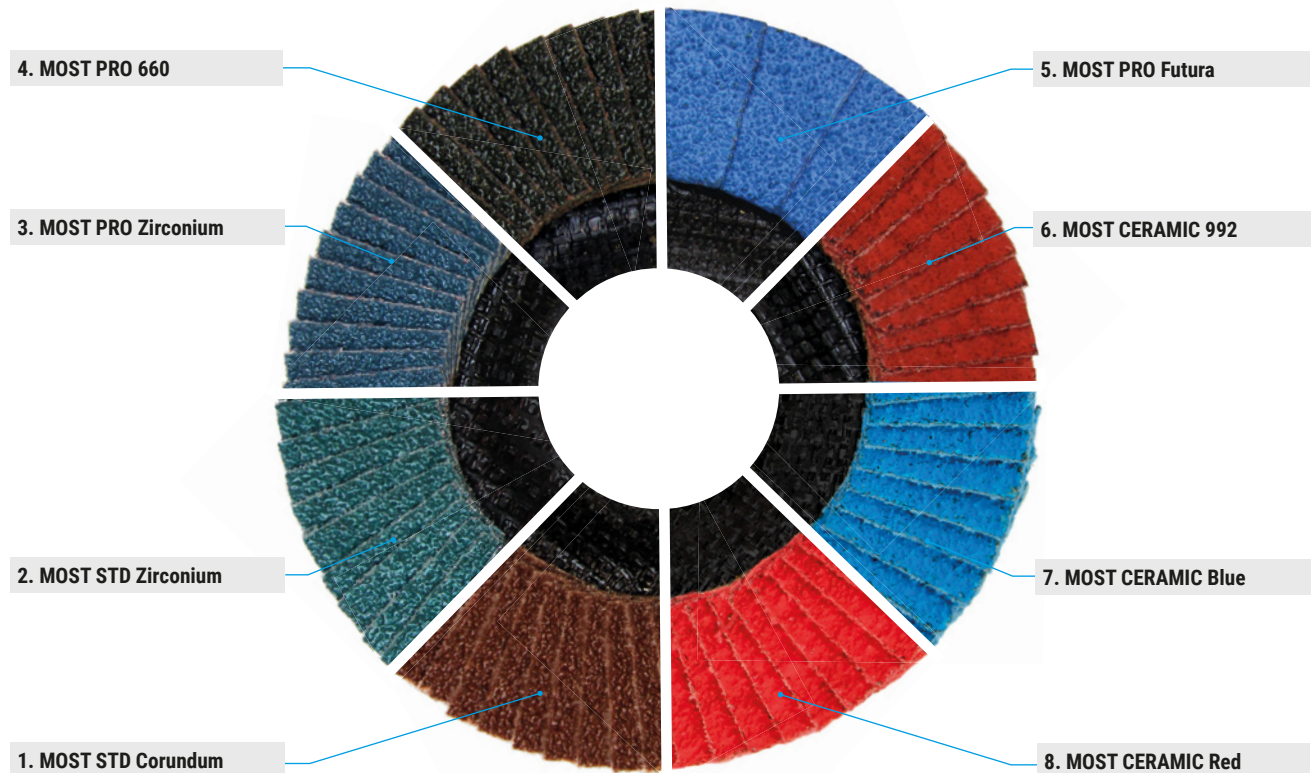
<p>STANDARD MOST LINE</p> <p><b>MOST STANDARD</b></p>	 <p>MOST STANDARD CORUNDUM</p>	 <p>MOST STANDARD ZIRCONIUM</p>	
<p>Discs with soft abrasive flaps for universal grinding and finishing of carbon and stainless steel.</p>			
<p>PRO MOST LINE</p> <p><b>MOST PRO</b></p>	 <p>MOST PRO ZIRCONIUM</p>	 <p>MOST PRO ZIRCONIUM XL</p>	 <p>MOST PRO ZIRCONIUM 660</p>  <p>MOST PRO FUTURA</p>
<p>Discs with abrasive flaps of stiffened cloth for industrial grinding of welded seams and cleaning of carbon and stainless steel surfaces.</p>			
<p>CERAMIC MOST LINE</p> <p><b>MOST CERAMIC</b></p>	 <p>MOST CERAMIC 992 Ø115-180 GR. 40-120</p>	 <p>MOST CERAMIC BLUE Ø115-180 GR. 40-80</p>	 <p>MOST CERAMIC RED Ø115-180 GR. 40-80</p>
<p>Discs with abrasive flaps made of innovative ceramic cloth for aggressive and high-efficient grinding of carbon, stainless and hard-to-cut steels.</p>			

### Shapes of flap grinding discs





## Selection of flap grinding discs according to the type of abrasive cloth



### 1. MOST STD Corundum

Soft cloth with corundum grains on cotton backing:

- for universal grinding and surface finishing.

### 2. MOST STD Zirconium

Soft cloth with zirconium grains on cotton backing:

- for universal sanding and surface finishing.

### 3. MOST PRO Zirconium

Rigid zirconium grains cloth on cotton-polyester backing:

- for aggressive and industrial grinding of welding seams and surfaces,
- increased number and length of flaps in XL version.

### 4. MOST PRO 660

Very rigid cloth with zirconium grains on polyester backing plate:

- for aggressive grinding of edges and welds,
- high pushing force required during grinding.

### 5. MOST PRO Futura

Rigid cloth with zirconium grains with active cooling layer on cotton-polyester backing:

- patented new shape and configuration of flaps increasing efficiency and lifetime of discs,
- reducing of grinding temperature, cooler grinding (less glazing).

### 6. MOST CERAMIC 992

Very rigid cloth with corundum-ceramic grains on polyester backing:

- for aggressive grinding of welds and surfaces,
- high pushing force required during grinding.

### 7. MOST CERAMIC Blue

Rigid cloth with zirconium-ceramic grains and active TOP COATING cooling layer on cotton-polyester backing:

- recommended for grinding of stainless and high-alloyed steels,
- higher efficiency and lifetime comparing to zirconium cloth.

### 8. MOST CERAMIC Red

Rigid cloth with pure ceramic grains and active TOP COATING- cooling layer on cotton-polyester backing:

- recommended for abrasive treatment of hardened steels as well as for sintered materials and special alloys,
- Self-sharpening ceramic grains - highest aggressiveness and efficiency in industrial grinding.





**Cotton cloth „X“:**

- soft and flexible flaps,
- low pressure force required,
- soft treatment of welds, surface finishing.

Name	Material	Backing	Grits			
			120	80	60	40
<b>MOST STD Corundum</b>	Aluminium Oxide	Cotton X	●	●	●	●
<b>MOST STD Zirconium</b>	Zirconium Oxide	Cotton X	●	●	●	●

**Polycotton (cotton + polyester) „XPC“ cloth:**

- stiffened flaps,
- medium pressure force required,
- weld treatment, surface cleaning, removal of chippings and spatters.

Name	Material	Backing	Grits		
			80	60	40
<b>MOST PRO Zirconium</b>	Zirconium Oxide	Cotton + Polyester XPC	●	●	●
<b>MOST PRO Zirconium XL</b>	Zirconium Oxide	Cotton + Polyester XPC	●	●	●
<b>MOST PRO Futura</b>	Zirconium Oxide	Cotton + Polyester XPC	●	●	●
<b>MOST CERAMIC Blue</b>	Ceramic Abrasive + Zirconium Oxide	Cotton + Polyester XPC	●	●	●
<b>MOST CERAMIC Red</b>	Ceramic Abrasive	Cotton + Polyester XPC	●	●	●

**Polyester „XP“ cloth:**

- very stiffed flaps,
- high pressure force required,
- aggressive weld treatment, edges grinding, deburring.

Name	Material	Backing	Grits		
			80	60	40
<b>MOST PRO Zirconium 660</b>	Zirconium Oxide	Polyester XP	●	●	●
<b>MOST CERAMIC 992</b>	Ceramic + Aluminium Oxide	Polyester XP	●	●	●

Name	Application				Working pressure	Lifetime
	Carbon steel	Stainless steel	Hardened steel	Aluminium		
<b>MOST STD Corundum</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium
<b>MOST STD Zirconium</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium
<b>MOST PRO Zirconium</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium-long
<b>MOST PRO Zirconium XL</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		long
<b>MOST PRO Zirconium 660</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium-long
<b>MOST PRO Futura</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		long
<b>MOST CERAMIC 992</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium
<b>MOST CERAMIC Blue</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		medium-long
<b>MOST CERAMIC Red</b>	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■		long

**Pictograms - application**



Safety gloves, respiratory protection, safety spectacles - see chapter 04.



**MOST STANDARD line**

**MOST STANDARD**

**Flap discs  
MOST STD Corundum**



A soft cloth with corundum grains on cotton backing plate:

- for universal grinding and surface finish,
- for grinding of carbon steel.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 18 115040	94 18 115041
2		60	13 300	10	94 18 115060	94 18 115061
3		80	13 300	10	94 18 115080	94 18 115081
4		120	13 300	10	94 18 115120	94 18 115121
5	125 x 22	40	12 250	10	94 18 125040	94 18 125041
6		60	12 250	10	94 18 125060	94 18 125061
7		80	12 250	10	94 18 125080	94 18 125081
8	150 x 22	120	12 250	10	94 18 125120	94 18 125121
9		40	10 200	10	94 18 150040	94 18 150041
10		60	10 200	10	94 18 150060	94 18 150061
11		80	10 200	10	94 18 150080	94 18 150081
12	180 x 22	120	10 200	10	94 18 150120	94 18 150121
13		40	8 500	10	94 18 180040	94 18 180041
14		60	8 500	10	94 18 180060	94 18 180061
15		80	8 500	10	94 18 180080	94 18 180081
16		120	8 500	10	94 18 180120	94 18 180121

**Flap discs  
MOST STD Zirconium**



A soft cloth with zirconium grains on cotton backing:

- for universal grinding and surface finish.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 19 115040	94 19 115041
2		60	13 300	10	94 19 115060	94 19 115061
3		80	13 300	10	94 19 115080	94 19 115081
4		120	13 300	10	94 19 115120	94 19 115121
5	125 x 22	40	12 250	10	94 19 125040	94 19 125041
6		60	12 250	10	94 19 125060	94 19 125061
7		80	12 250	10	94 19 125080	94 19 125081
8	150 x 22	120	12 250	10	94 19 125120	94 19 125121
9		40	10 200	10	94 19 150040	94 19 150041
10		60	10 200	10	94 19 150060	94 19 150061
11		80	10 200	10	94 19 150080	94 19 150081
12	180 x 22	120	10 200	10	94 19 150120	94 19 150 121
13		40	8 500	10	94 19 180040	94 19 180041
14		60	8 500	10	94 19 180060	94 19 180061
15		80	8 500	10	94 19 180080	94 19 180081
16		120	8 500	10	94 19 180120	94 19 180121



**MOST PRO line**



**Flap discs  
MOST PRO Zirconium**



**Rigid cloth made of zirconium grains on polycotton backing:**  
 ■ for aggressive, industrial grinding of welds and surface treatment.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No. Type 29	Catalogue No. Type 27
1	115 x 22	40	13 300	10	94 19 215040	94 19 215041
2		60	13 300	10	94 19 215060	94 19 215061
3		80	13 300	10	94 19 215080	94 19 215081
4	125 x 22	40	12 250	10	94 19 225040	94 19 225041
5		60	12 250	10	94 19 225060	94 19 225061
6		80	12 250	10	94 19 225080	94 19 225081
7	150 x 22	40	10 200	10	94 19 250040	94 19 250041
8		60	10 200	10	94 19 250060	94 19 250061
9		80	10 200	10	94 19 250080	94 19 250081
10	180 x 22	40	8 500	10	94 19 280040	94 19 280041
11		60	8 500	10	94 19 280060	94 19 280061
12		80	8 500	10	94 19 280080	94 19 280081

**Flap discs  
MOST PRO Zirconium XL**



**Rigid cloth made of zirconium grains on polycotton backing:**  
 ■ for aggressive, industrial grinding of welds and surface treatment,  
 ■ increased number and length of flaps in XL version.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No. Type 29	Catalogue No. Type 27
1	115 x 22	40	13 300	10	94 19 215043	94 19 215044
2		60	13 300	10	94 19 215063	94 19 215064
3		80	13 300	10	94 19 215083	94 19 215084
4	125 x 22	40	12 250	10	94 19 225043	94 19 225044
5		60	12 250	10	94 19 225063	94 19 225064
6		80	12 250	10	94 19 225083	94 19 225084
7	150 x 22	40	10 200	10	94 19 250043	94 19 250044
8		60	10 200	10	94 19 250063	94 19 250064
9		80	10 200	10	94 19 250083	94 19 250084



**MOST PRO line**



**Flap discs  
MOST PRO 660**



Very rigid cloth with zirconium grains on polyester backing:

- for aggressive grinding of edges and welds,
- high pressure force required during grinding.



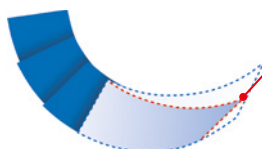
No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 19 615040	94 19 615041
2		60	13 300	10	94 19 615060	94 19 615061
3		80	13 300	10	94 19 615080	94 19 615081
4	125 x 22	40	12 250	10	94 19 625040	94 19 625041
5		60	12 250	10	94 19 625060	94 19 625061
6		80	12 250	10	94 19 625080	94 19 625081
7	150 x 22	40	10 200	10	94 19 650040	94 19 650041
8		60	10 200	10	94 19 650060	94 19 650061
9		80	10 200	10	94 19 650080	94 19 650081
10	180 x 22	40	8 500	10	94 19 680040	94 19 680041
11		60	8 500	10	94 19 680060	94 19 680061
12		80	8 500	10	94 19 680080	94 19 680081

**Flap discs  
MOST PRO Futura**



Rigid cloth with zirconium grains and active cooling layer on a polycotton backing:

- patented new design flaps shape increases efficiency and life time of wheels,
- the cooling active layer ensures reducing of grinding temperature, cooler grinding (less glazing), especially for stainless steel.



The new design and combination of flaps provides excellent efficiency and guarantees a cooler grinding



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packing [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 17 311504	
2		60	13 300	10	94 17 311506	
3	125 x 22	40	12 250	10	94 17 312504	
4		60	12 250	10	94 17 312506	





**MOST CERAMIC line**

MOST CERAMIC

**Flap discs  
MOST CERAMIC 992**



Very rigid cloth with ceramic and corundum grains on polyester backing:

- for aggressive grinding of welds and surface treatment,
- high pressure force required.



No.	Dimensions Width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 17 211504	94 17 211505
2		60	13 300	10	94 17 211506	94 17 211507
3		80	13 300	10	94 17 211508	94 17 211509
4	125 x 22	40	12 250	10	94 17 212504	94 17 212505
5		60	12 250	10	94 17 212506	94 17 212507
6		80	12 250	10	94 17 212508	94 17 212509
7	150 x 22	40	10 200	10	94 17 215004	94 17 215005
8		60	10 200	10	94 17 215006	94 17 215007
9		80	10 200	10	94 17 215008	94 17 215009
10	180 x 22	40	8 500	10	94 17 218004	94 17 218005
11		60	8 500	10	94 17 218006	94 17 218007
12		80	8 500	10	94 17 218008	94 17 218009

**Flap discs  
MOST CERAMIC BLUE**



Rigid cloth with ceramic and zirconium grains and TOP COATING - active cooling layer on polycotton backing:

- specially designed for the grinding of stainless and high-alloyed steels,
- the cooling active layer ensures cooler grinding during stainless steel treatment,
- increased efficiency and lifetime in comparison with zirconium cloth.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 19 715040	94 19 715041
2		60	13 300	10	94 19 715060	94 19 715061
3		80	13 300	10	94 19 715080	94 19 715081
4	125 x 22	40	12 250	10	94 19 725040	94 19 725041
5		60	12 250	10	94 19 725060	94 19 725061
6		80	12 250	10	94 19 725080	94 19 725081
7	150 x 22	40	10 200	10	94 19 750040	94 19 750041
8		60	10 200	10	94 19 750060	94 19 750061
9		80	10 200	10	94 19 750080	94 19 750081
10	180 x 22	40	8 500	10	94 19 780040	94 19 780041
11		60	8 500	10	94 19 780060	94 19 780061
12		80	8 500	10	94 19 780080	94 19 780081





**MOST CERAMIC line**

MOST CERAMIC

HIT

**Flap grinding wheels  
MOST CERAMIC RED**



**Rigid Cloth with pure ceramic grains and TOP COATING - active cooling layer on polycotton backing:**

- self-sharpening ceramic grains ensure highest aggressiveness and efficiency in industrial grinding applications,
- particularly recommended for grinding of hardened and hard-to-cut steels as well as for sinter and special alloys,
- long service life and exceptional grinding comfort.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No. Type 29	Catalogue No. Type 27
1	115 x 22	40	13 300	10	94 19 815040	94 19 815041
2		60	13 300	10	94 19 815060	94 19 815061
3		80	13 300	10	94 19 815080	94 19 815081
4	125 x 22	40	12 250	10	94 19 825040	94 19 825041
5		60	12 250	10	94 19 825060	94 19 825061
6		80	12 250	10	94 19 825080	94 19 825081
7	150 x 22	40	10 200	10	94 19 850040	94 19 850041
8		60	10 200	10	94 19 850060	94 19 850061
9		80	10 200	10	94 19 850080	94 19 850081
10	180 x 22	40	8 500	10	94 19 880040	94 19 880041
11		60	8 500	10	94 19 880060	94 19 880061
12		80	8 500	10	94 19 880080	94 19 880081



### Flap discs TAF ALU



- Exceptional flap discs for treatment of aluminium and non-ferrous metals, with very high resistance to sticking and clogging with aluminium dust or residues.
- The stearin coating of flaps significantly reduces the adhesion of aluminium dust to the grinding wheel surface.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	10	94 11 711504	94 11 711505
2		60	13 300	10	94 11 711506	94 11 711507
3	125 x 22	40	12 250	10	94 11 712504	94 11 712505
4		60	12 250	10	94 11 712506	94 11 712507

### Flap discs TAF Eolo



- A high-technology reinforced ventilated flap discs designed for heavy-duty abrasive work as an alternative to resin-bonded grinding discs.
- In operation, the stroboscopic effect of the slotted mounting plate enables clear view of the working area.
- 100% zirconium oxide grains on poly-cotton cloth and robust plastic plate ensure intensive work.
- Grinding with less vibration and less noise level.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	20	94 11 511505	94 11 511504
2		60	13 300	20	94 11 511507	94 11 511506
3	125 x 22	40	12 250	20	94 11 512505	94 11 512504
4		60	12 250	20	94 11 512507	94 11 512506
5	180 x 22	40	8 500	10	-	94 11 518004
6		60	8 500	10	-	94 11 518006





### Flap discs TAF DUO ZIRCO - CERAMIC



- Manufactured using a top size cloth bonded with a mixture of zirconium oxide and ceramic abrasives, with an additional Top Coating- active cooling.
- High temperature resistance during operation with the medium pressure force recommended for stainless steel treatment.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	40	13 300	20	94 11 111504	94 11 111505
2		60	13 300	20	94 11 111506	94 11 111507
3		80	13 300	20	94 11 111508	94 11 111509
4		120	13 300	20	94 11 111512	94 11 111513
5	125 x 22	40	12 250	20	94 11 112504	94 11 112505
6		60	12 250	20	94 11 112506	94 11 112507
7		80	12 250	20	94 11 112508	94 11 112509
8		120	12 250	20	94 11 112512	94 11 112513
9	180 x 22	40	8 500	10	94 11 118004	-
10		60	8 500	10	94 11 118006	-
11		80	8 500	10	94 11 118008	-
12		120	8 500	10	94 11 118012	-

### Flap discs TAF DUO CERAMIC



- Manufactured using a top size poly-cotton cloth in ceramic abrasive blend with an additional Top Coating- active cooling.
- High temperature resistance during operation with the high pressure force.
- Suitable for heavy-duty applications like edge deburring, beveling and aggressive weld removal.
- Particularly recommended for exotic metals, sintered alloys and other hardened steels.



No.	Dimensions width x bore [mm]	Grits	Rotation Speed [rpm.]	Packaging [pcs.]	Catalogue No.	
					Type 29	Type 27
1	115 x 22	36	13 300	20	94 11 011502	94 11 011503
2		40	13 300	20	94 11 011504	94 11 011505
3		60	13 300	20	94 11 011506	94 11 011507
4		80	13 300	20	94 11 011508	94 11 011509
5	125 x 22	36	12 250	20	94 11 012502	94 11 012503
6		40	12 250	20	94 11 012504	94 11 012505
7		60	12 250	20	94 11 012506	94 11 012507
8		80	12 250	20	94 11 012508	94 11 012509
9	180 x 22	36	8 500	10	94 11 018002	-
10		40	8 500	10	94 11 018004	-
11		60	8 500	10	94 11 018006	-
12		80	8 500	10	94 11 018008	-





## Non-woven flap discs MOST FVV SC-RD



- Discs made of high-quality 3M™ Scotch-Brite Surface Conditioning™ non-woven fabric.
- The fan-shaped flaps dissipate heat well and eliminate the risk of discoloration of grinded material.
- Mainly for deburring, fine grinding, finishing of stainless steel.



No.	Material	Width [mm]	Bore [mm]	Type	Grits			Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
					A CRS	A MED	A VFN			
1	3M™ Scotch-Brite Surface Conditioning™ non-woven	115	22	T29	●	●	●	13 300	10	9M 50 0071xx
2	3M™ Scotch-Brite Surface Conditioning™ non-woven	125	22	T29	●	●	●	12 250	10	9M 50 0072xx

## Non-woven Interleaved Flap discs MOST COMBI SCC-RD



- The combination of a ceramic abrasive cloth with a non-woven abrasive cloth makes possible to remove the material with simultaneous finishing.
- For blending and smooth finishing.
- Ideal for treatment of weld seams on stainless steel.



No.	Material	Width [mm]	Bore [mm]	Type	Grits			Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
					A CRS/60	A MED/80	A VFN/120			
1	3M™ Surface Conditioning™ non-woven	115	22	T29	●	●	●	13 300	10	9M 50 0081xx
2	+ ceramic abrasive	125	22	T29	●	●	●	12 250	10	9M 50 0082xx

## Felt Flap discs MOST FLT LF



- Flaps made of high quality felt.
- The fan-shaped flaps combination reduces the polishing temperature.
- For use with polishing pastes only - see page 311.



No.	Material	Width [mm]	Bore [mm]	Type	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
1	Felt	115	22	T29	4 900	10	9M 50 006115
2		125	22	T29	4 500	10	9M 50 006125

### ▼ 3. VITRIFIED GRINDING WHEELS CERAMIC-BONDED



#### Designations of VITRIFIED GRINDING WHEELS ceramic-bonded MOST STANDARD



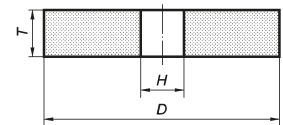
#### Safe use of abrasive tools

While working with MOST abrasive wheels, it is necessary to use safety rules and regulations. The products of this group are marked with appropriate pictograms of the safety work.

#### Safety pictograms

- Before starting work, read the operating manuals for grinding machines and grinding wheels
- Use eyes protection while working
- Use protective glove while working.
- Use hearing protection while working
- Use respiratory protection while working

#### Dimensions D x T x H [mm]



	Marking of grain type	
	Norton	PN/M-59100
Brown Aluminium Oxide	A	95A
White Aluminium Oxide	38A	99A
Black Silicon Carbide	37C	98C

Abrasive grain granulation		
Corse	Medium	Fine
8	30	70
10	36	80
12	40	90
14	46	100
16	54	120
20	60	150
24		180

Dimensions D x T x H [mm]	Characteristics	Working Speed [m/s]	Catalogue No.
<b>Type1 Grain A - Brown Aluminium Oxide (95A)</b>			
150 x 20 x 20	A60KVBE	33	92 20 152001
200 x 20 x 32	A60KVBE	33	92 20 202001
200 x 25 x 32	A60KVBE	33	92 20 202501
250 x 25 x 32	A60KVBE	33	92 20 252501
300 x 32 x 32	A60KVBE	33	92 20 303201
<b>Type1 Grain 38 A - White Aluminium Oxide (99A)</b>			
150 x 20 x 20	38A60KVBE	33	92 20 152002
200 x 20 x 32	38A60KVBE	33	92 20 202002
200 x 25 x 32	38A60KVBE	33	92 20 202502
250 x 25 x 32	38A60KVBE	33	92 20 252502
300 x 32 x 32	38A60KVBE	33	92 20 303202
<b>Type1 Grain 37 C - Black Silicon Carbide (98C)</b>			
150 x 20 x 20	37C60KVK	33	92 20 152000
200 x 20 x 32	37C60KVK	33	92 20 202000
200 x 25 x 32	37C60KVK	33	92 20 202500
250 x 25 x 32	37C60KVK	33	92 20 252500
300 x 32 x 32	37C60KVK	33	92 20 303200



## ▼ 4. FLAP WHEELS WITH SHAFT



### Cloth flap wheels with shaft MOST Corundum PT

- Flexible abrasive flaps allow for precise adaptation to the shape of treated workpiece.
- Corundum cloths can be used for a wide range of applications such as removal of rust, cleaning up welds and finishing of carbon and stainless steels.

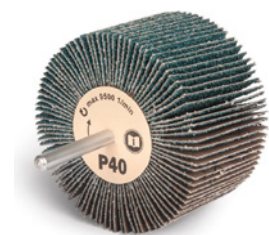


Aluminium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●	●	●	●	●	●	●	●	●		●

Name	Width [mm]	Width [mm]	Shaft [mm]	Recommended speed	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Corundum PT	20	5/10/15/20/25/30	6	17 000 - 23 800	38 100	20	96 01 11xxxx
	25	5/10/15/20/25/30	6	13 700 - 19 000	30 500	20	96 01 12xxxx
	30	5/10/15/20/25/30	6	11 400 - 15 900	25 400	20	96 01 13xxxx
	40	5/10/15/20/25/40	6	8 500 - 12 000	19 000	20	96 01 14xxxx
	50	10/15/20/30/40	6	6 800 - 9 500	15 200	20	96 01 15xxxx
	60	10/15/20/30/40/50	6	5 700 - 7 900	12 700	20	96 01 16xxxx
	80	15/20/30/40/50	6	4 300 - 6 000	8 400	10	96 01 18xxxx
	100	20/30/40/50	6	3 400 - 4 800	6 700	10	96 01 19xxxx

### Cloth Flap wheels with shaft MOST Zirconium PT

- Flexible abrasive flaps allow for precise adaptation to the shape of treated workpiece.
- Zirconium cloth ensures cooler grinding while grinding stainless steel.

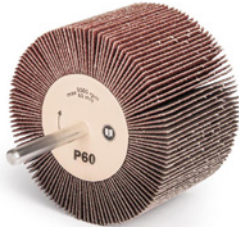


Zirconium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●	●	●								

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Zirconium PT	30	20/30	6	11 400 - 15 900	25 400	20	96 02 03xxxx
	40	15/20/30	6	8 500 - 12 000	19 000	20	96 02 04xxxx
	50	20/30	6	6 800 - 9 500	15 200	20	96 02 05xxxx
	60	15/20/30	6	5 700 - 7 900	12 700	20	96 02 06xxxx
	80	30/50	6	4 300 - 6 000	8 400	10	96 02 08xxxx



### Cloth flap wheels with shaft MOST Ceramic PT



- Flexible abrasive flaps allow for precise adaptation to the shape of treated workpiece.
- Ceramic cloth ensures for aggressive and efficient grinding of carbon, stainless steel and hardened steels.

Aluminium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●		●								

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Ceramic PT	30	20	6	11 400 - 15 900	25 400	20	96 02 13xxxx
	40	20	6	8 500 - 12 000	19 000	20	96 02 14xxxx
	50	20	6	6 800 - 9 500	15 200	20	96 02 15xxxx
	60	30	6	5 700 - 7 900	12 700	20	96 02 16xxxx
	80	30/50	6	4 300 - 6 000	8 400	10	96 02 18xxxx

### 3M™ Trizact™ flap wheels with shaft MOST TZ PT



- Flexible abrasive flaps allow for precise adaptation to the shape of treated workpiece.
- The 3 M™ Trizact™ special abrasive contain precision pyramid-shaped grains.
- Trizact™ abrasive breaks down gradually and uniformly for consistent cut and long life provides a equal finish and high efficiency.

3M™ Trizact™ abrasive	Grits							
	A160	A100	A80	A65	A45	A30	A16	A6
Availability	●	●	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST TZ PT	30	20	6	11 400 - 15 900	25 400	10	96 02 23xxxx
	40	30	6	8 500 - 12 000	19 000	10	96 02 24xxxx
	50	30	6	6 800 - 9 500	15 200	10	96 02 25xxxx
	60	30	6	5 700 - 7 900	12 700	10	96 02 26xxxx
	80	50	6	4 300 - 6 000	8 400	5	96 02 28xxxx



## Non-woven flap wheels with shaft MOST FVV WT

- Soft tools for satin and matting stainless steel.
- Variety of non-woven flaps can be altered to suit different surface finishes.



Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV WT	30	20/30	6	6 400 - 12 500	20 000	20	96 01 23xxxx
	40	20/30/40	6	5 500 - 10 900	15 000	20	96 01 24xxxx
	50	20/30/40	6	4 800 - 9 500	12 000	20	96 01 25xxxx
	60	30/40/50	6	3 800 - 7 600	10 000	20	96 01 26xxxx
	80	25/30/40/50	6	3 200 - 6 300	7 500	10	96 01 28xxxx
	100	50	6	2 400 - 4 700	6 000	10	96 01 299xxx

## Non-woven waved wheels with shaft MOST FVV TPW

- Folding of the abrasive non-woven allows for a uniform grinding pattern over large areas.
- The wavy structure of the non-woven fabric permits polishing and matt- finishing of surfaces without visible transitions.



Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV TPW	80	50	6	3 200 - 6 300	7 500	10	96 01 99780x
	100	50	6	2 400 - 4 700	6 000	10	96 01 99790x

## Interleaved non-woven flap wheels with shaft MOST Combi WPT

- Give a homogeneous grinding pattern while removing surface defects.
- The ratio of Cloth flaps to non-woven flaps can be altered to suit particular applications and ensure aggressiveness of the sharpness of the grinding wheel.



Non-woven	Grits			
	A CRS/P80	A MED/P120	A FIN/P180	A VFN/P320
Availability	●	●	●	●

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Combi WPT	30	20/30	6	6 400 - 12 500	20 000	20	96 01 33xxxx
	40	20/30/40	6	5 500 - 10 900	15 000	20	96 01 34xxxx
	50	20/30/40	6	4 800 - 9 500	12 000	20	96 01 35xxxx
	60	30/40/50	6	3 800 - 7 600	10 000	20	96 01 36xxxx
	80	25/30/40/50	6	3 200 - 6 300	7 500	10	96 01 38xxxx
	100	50	6	2 400 - 4 700	6 000	10	96 01 3950xx

▼ 5. FLAP WHEELS WITH HOLE



**Cloth Flap wheels with hole  
MOST Corundum OL**



- Flap wheels for use on high-power stationary and handheld grinding machines.
- Flexible abrasive flaps allow for precise adaptation to the shape of treated workpiece.

Aluminium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●	●	●	●	●	●	●	●	●		●

Name	Diameter [mm]	Width [mm]	Bore [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Corundum OL	125	25	25	2 300 - 4 600	7 600	5	96 01 412xxx
	150	25/30/50	25/32/44	1 900 - 3 800	6 300	5	96 01 415xxx
	165	25/30/40/50	25/32/44/54	1 700 - 3 500	5 700	5	96 01 416xxx
	200	25/50	32/44/68	1 500 - 3 000	4 700	5	96 01 420xxx
	250	25/30/50/60	68/100	1 200 - 2 300	3 800	2	96 01 425xxx
	300	30/50/75/100	100	1 000 - 2 000	3 200	1	96 01 430xxx
	350	100	100	900 - 1 700	2 700	1	96 01 435xxx
	400	60	170	700 - 1 500	2 400	1	96 01 440xxx

**Cloth flap wheels for angle grinders  
MOST Corundum KL**



- M14 threaded grinding wheels for angle grinders with speed control.
- The wide range of corundum-grained abrasive cloth for roughing and finishing of carbon and stainless steel.

Aluminium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●	●	●	●	●	●	●	●	●		●

Name	Diameter [mm]	Width [mm]	Mounting	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Corundum KL	125	20	M14	6 100 - 7 600	12 200	5	96 01 4525xx





## Non-woven flap wheels with hole MOST FVV OW

- Soft grinding wheels for use on stationary and manual straight grinders with high power to satin and matt of stainless steel.
- Different granulation of the non-woven allows for different surface finishes.



Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Hole [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV OW	150	50/100	60 T	1 300 - 2 600	4 000	2	96 01 5150xx
	165	50	44	1 200 - 2 400	3 700	2	96 01 5165xx
	200	50/100	76 T	1 000 - 2 000	3 000	2	96 01 5200xx
	250	50/100	115 T	800 - 1 600	2 300	2	96 01 5250xx
	300	50	100	650 - 1 300	1 900	2	96 01 5300xx
	390	50	171	500 - 1 000	1 400	2	96 01 5400xx

T - Grinding wheel made on a textured sleeve with the possibility of reducing the hole diameter

## Non-woven waved wheels with hole MOST FVV OPW

- Folding of the abrasive non-woven allows for a uniform grinding pattern over large areas.
- The wavy structure of the non-woven fabric permits polishing and matt finishing of surfaces without visible transitions.



Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Hole [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV OPW	150	50	44	1 300 - 2 600	4 000	2	96 01 55150x
	165	50	25/32/44	1 200 - 2 400	3 700	2	96 01 55165x
	200	50	44	1 000 - 2 000	3 000	2	96 01 55200x

## Interleaved non-woven flap wheels with hope MOST COMBI OWP

- Give a homogeneous grinding pattern while removing surface defects.
- The ratio of cloth flaps to non-woven flaps can be altered to suit particular applications and ensure aggressiveness and sharpness of the grinding wheel.



Non-woven	Grits			
	A CRS/P80	A MED/P120	A FIN/P180	A VFN/P320
Availability	●	●	●	●

Name	Diameter [mm]	Width [mm]	Hole [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST COMBI OWP	150	50/100	60 T	1 300 - 2 600	4 000	2 - 2 - 1 - 1	96 01 5615xx
	165	50	44	1 200 - 2 400	3 700	2	96 01 5616xx
	200	50/100	76 T	1 000 - 2 000	3 000	4 - 2 - 1	96 01 5620xx
	250	50/100	115 T	800 - 1 600	2 300	4 - 2 - 1	96 01 5625xx

T - grinding wheel made on a textured sleeve with the possibility of reducing the hole diameter

## ▼ 6. FLAP ROLLS FOR SATIN FINISHING



### Cloth flap rolls MOST Corundum OL



- Flexible flap rolls for grinding-machines for staining and cleaning of large flat areas.
- Wide range of abrasive cloth with corundum grit for rough and finish treatment of carbon and stainless steel.

Aluminium Oxide	Grits														
	P36	P40	P50	P60	P80	P100	P120	P150	P180	P220	P240	P280	P320	P360	P400
Availability		●		●	●	●	●	●	●	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST Corundum OL	100	50	M14	2 800 - 3 700	6 000	4	96 01 6994xx
	100	50	19/4 grooves	3 000 - 3 800	6 000	2	96 01 6995xx
	100	100	19/4 grooves	3 000 - 3 800	6 000	1	96 01 6999xx

### Non-woven flap rolls MOST FVV OW



- Soft finishing rolls for grinding machines - satin finishing and matting of stainless steel.
- Different granulation of the non-woven allows for different surface finishes.

Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV OW	100	50	M14	2 800 - 3 700	6 000	4	96 01 79951x
	100	75	M14	2 800 - 3 700	6 000	4	96 01 79971x
	100	50	19/4 grooves	2 800 - 3 700	6 000	2	96 01 79950x
	100	100	19/4 grooves	2 800 - 3 700	6 000	1	96 01 79999x

### Cut & Polish non-woven flap rolls MOST FVV CP-MB



- Soft finishing wheels for grinding machines - satin finishing and matting of stainless steel.
- Rollers also available with M14 thread for angle grinders with speed control.
- Cut & Polish non-woven with increased quantity of abrasive grains and high strength.

Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S SFN	S UFN
Availability		●		●		

Name	Diameter [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
FVV CP-MB	100	50	M14	2 800 - 3 700	6 000	4	96 01 79851x
	100	75	M14	2 800 - 3 700	6 000	4	96 01 79871x
	100	50	19/4 grooves	2 800 - 3 700	6 000	2	96 01 79850x
	100	100	19/4 grooves	2 800 - 3 700	6 000	1	96 01 79899x



## Interleaved Non-woven flap rolls MOST COMBI OWP

- Connection of cloth flaps and non-woven flaps ensure larger scratch on the surface and allows the removal of small surface defects at the same time.
- Give a homogeneous grinding pattern while removing surface defects.
- The use of an abrasive cloth increases the aggressiveness and sharpness of the grinding wheel.



Non-woven	Grits			
	A CRS/P80	A MED/P120	A FIN/P180	A VFN/P320
Availability	●	●	●	●

Name	Diameter [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST COMBI OPT	100	50	M14	2 800 - 3 700	6 000	4	96 01 89951x
	100	75	M14	2 800 - 3 700	6 000	4	96 01 89971x
	100	50	19/4 grooves	2 800 - 3 700	6 000	2	96 01 89950x
	100	100	19/4 grooves	2 800 - 3 700	6 000	1	96 01 89999x

## Non-woven waved rolls MOST FVV OPW

- Folding of the abrasive non-woven allows for a uniform grinding pattern over large areas.
- The wavy structure of the non-woven fabric permits polishing and matt finishing of surfaces without visible transitions.



Non-woven	Grits					
	A CRS	A MED	A FIN	A VFN	S FIN	S VFN
Availability	●	●	●	●	●	●

Name	Diameter [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FVV OPW	100	50	M14	2 000 - 3 700	5 700	2	96 01 99850x
	100	100	19/4 grooves	2 000 - 3 700	5 700	1	96 01 99898x

## Non-woven rolls made of 3M™ Clean & Strip MOST CLEAN CS-MB

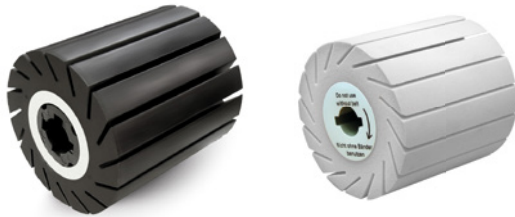
- Nylon cleaning non-woven with synthetic fibres, abrasive grains and resin.
- Ideal for cleaning welded seams, removing rust, discoloration, paint, epoxy and protective PVC layers.
- Very fast surface finishing, which ensures metallic-clean surface without any loss in treated material.
- It is ideal for removing discoloration after welding of stainless steel.
- The open structure of the wheel makes it resistant to clogging and does not overheat the material.



Name	Width [mm]	Width [mm]	Mounting [mm]	Recommended speed [rpm.]	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST CLEAN CS-MB	100	50	M14	2 000 - 3 700	5 700	4	94 17 681051
	100	75	M14	2 000 - 3 700	5 700	4	94 17 681071
	100	50	19/4 grooves	2 000 - 3 700	5 700	2	94 17 681050
	100	100	19/4 grooves	2 000 - 3 700	5 700	1	94 17 681000



### Drums for abrasive belts



- Used in grinder machines to place an abrasive non-woven and felt belts. The drum expands as it rotates to hold the belt securely in place.
- Hard drums are used for belts with hard-backed and coarse-grained cloth for rough treatment.
- Soft drums are a universal tool for other belts made of non-woven and felt cloth.

Name	Hardness	Diameter [mm]	Width [mm]	Mounting [mm]	Size of sleeve [mm]	Catalogue No.
VSDN 16M14	SOFT	100	20	M14	20x316	9M 00 100802
			30		30x316	9M 00 100803
			40		40x316	9M 00 100804
			50		50x316	9M 00 100805
VSDN 15	SOFT	90	100	pin 19x100	100x289	9M 00 100800
VSDN 16		100	100		100x316	9M 00 100801
GO 15	HARD	90	100	pin 19x100	100x289	9M 00 100810
GO 16		100	100		100x316	9M 00 100811

### MOST abrasive belts for expanding drums



- **MOST CERAMIC** - aggressive and high-efficient abrasive cloth made of ceramic Aluminium Oxide grain.
- **MOST TZ** - 3M™ Trizact™ special cloth with a precisely shaped abrasive grains pyramid-shaped.
- **MOST FVV SC** - 3M™ Scotch-Brite™ Surface Conditioning™ non-woven.
- **MOST FLT** - polishing felt, to be used together with polishing pastes.

Name	Material	Drum size [mm]	Width x length [mm]	Grits							Packaging	Catalogue No.
				P36	P40	P60	P80	P120				
MOST Ceramic	Ceramic abrasive	20x100	20x316	●	●	●	●	●			10	9M 02 0xxxxx
		30x100	30x316	●	●	●	●	●			10	9M 03 0xxxxx
		40x100	40x316	●	●	●	●	●			10	9M 04 0xxxxx
		50x100	50x316	●	●	●	●	●			10	9M 05 0xxxxx
		90x100	100x289	●	●	●	●	●			10	9M 10 0xxxxx
		100x100	100x316	●	●	●	●	●			10	9M 10 0xxxxx
MOST TZ	3M™ Trizact™ Aluminium Oxide	20x100	20x316	●	●	●	●	●	●	●	10	9M 02 0xxxxx
		30x100	30x316	●	●	●	●	●	●	●	10	9M 03 0xxxxx
		40x100	40x316	●	●	●	●	●	●	●	10	9M 04 0xxxxx
		50x100	50x316	●	●	●	●	●	●	●	10	9M 05 0xxxxx
		90x100	100x289	●	●	●	●	●	●	●	10	9M 10 0xxxxx
		100x100	100x316	●	●	●	●	●	●	●	10	9M 10 0xxxxx
MOST FVV SC	3M™ SC Non-woven	20x100	20x316			●		●		●	10	9M 02 0xxxxx
		30x100	30x316			●		●		●	10	9M 03 0xxxxx
		40x100	40x316			●		●		●	10	9M 04 0xxxxx
		50x100	50x316			●		●		●	10	9M 05 0xxxxx
		90x100	100x289			●		●		●	10	9M 10 0xxxxx
		100x100	100x316			●		●		●	10	9M 10 0xxxxx
MOST FLT	Felt	20x100	20x316								10	9M 02 0xxxxx
		30x100	30x316								10	9M 03 0xxxxx
		40x100	40x316								10	9M 04 0xxxxx
		50x100	50x316								10	9M 05 0xxxxx
		90x100	100x289								10	9M 10 0xxxxx
		100x100	100x316								10	9M 10 0xxxxx

## ▼ 7. UNITIZED NON-WOVEN ABRASIVES



### Unitized non-woven discs made of 3M™ - EXL material MOST Press XL-RD



- Grinding wheels where layers of non-woven fibers are filled with abrasive grain and resin then compressed and cured.
- Use of 5 different compression stages (2 SF, 2 AM, 3 SF, 6 AM, 8 AC) has made it possible to obtain innovative tools for differential grinding and polishing.
- Ideally suited for treatment of fillet welds and flat metal elements, as well as for deburring, cleaning, removing discolouration, giving the right surface texture and finishing of castings and forgings.
- Gentle abrasive properties remain constant through the entire service life of product.



Name	Width [mm]	Thickness [mm]	Bore [mm]	Type	Grits					Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
					2S FIN	2A MED	3S FIN	6A MED	8A CRS			
MOST Press XL-RD	125	6	22	T27	●	●	●	●	●	7 600	10	94 17 53126x
	125	12	22	T27	●	●				7 600	10	94 17 53128x

### Unitized non-woven wheels made of 3M™ - EXL material MOST Press XL-UW

- Ideal tools for fillet welds (edge work).
- Different material thicknesses allow for versatile processing grinding and polishing.



Name	Width [mm]	Thickness [mm]	Hole [mm]	Grits					Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				2S FIN	2A MED	3S FIN	6A MED	8A CRS			
MOST Press XL-UW	50	3	6				●		14 000 / 21 000*	25	94 17 51053x
	50	6	6	●	●	●	●	●	14 000 / 21 000*	25	94 17 51056x
	50	12	6	●	●				14 000 / 21 000*	25	94 17 51058x
	75	3	6				●		10 000 / 15 000*	25	94 17 51073x
	75	6	6	●	●	●	●	●	10 000 / 15 000*	25	94 17 51076x
	75	12	6	●	●				10 000 / 15 000*	25	94 17 51078x
	125	3	22				●		5 500 / 7 500*	10	94 17 51123x
	125	6	22	●	●	●	●	●	5 500 / 7 500*	10	94 17 51126x
	125	12	22	●	●				5 500 / 7 500*	10	94 17 51128x
	125	25	22	●		●			5 500 / 7 500*	10	94 17 51129x
	150	3	22				●		4 500 / 6 000*	10	94 17 51153x
	150	6	22	●	●	●	●		4 500 / 6 000*	10	94 17 51156x
	150	12	22	●	●				4 500 / 6 000*	10	94 17 51158x
150	25	22	●					4 500 / 6 000*	4	94 17 51159x	

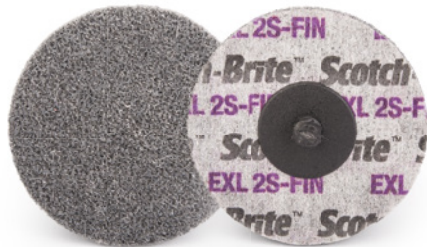
\*for grit sizes 6A/M and 8A/C

Spindles for unitized non-woven wheels and discs - see page 295.





### Unitized non-woven quick-change Roll-on discs - made of 3M™ EXL material MOST Press XL-DR



- Quickly exchangeable discs, which are connected by fastening thread with the backing plate support, part of Roloc system.
- The small diameter of the grinding discs facilitates works and does not require high-power grinding machines.
- Lightweight and handy electric and pneumatic grinders are dedicated to Roloc system.
- They guarantee proper selection of material at every level of treatment also in hard-to-reach places.

Name	Width [mm]	Thickness [mm]	Grits					Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
			2S FIN	2A MED	3S FIN	6A MED	8A CRS			
MOST Press XL-DR	50	6	●	●	●	●	●	22 000	25	9M 00 14500x
	75	6	●	●	●	●	●	15 000	25	9M 00 14750x

### Unitized non-woven wheels with shaft - made of 3M™ EXL material MOST Press XL-ST



- Different diameter and material thicknesses allow for versatile grinding and polishing.
- For use with special straight grinders.

Name	Width [mm]	Thickness [mm]	Shaft size [mm]	Grits					Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				2S FIN	2A MED	3S FIN	6A MED	8A CRS			
MOST Press XL-ST	12	6	3	●	●	●	●	●	40 000	25	94 17 5512xx
		12	6	●	●	●	●	●	40 000	25	94 17 5512xx
	22	6	3	●	●	●	●	●	40 000	25	94 17 5522xx
		12	6	●	●	●	●	●	35 000	25	94 17 5522xx
		25	6	●	●	●	●	●	35 000	25	94 17 5522xx
	25	6	6	●	●	●	●	●	35 000	25	94 17 5525xx
		12	6	●	●	●	●	●	33 000	25	94 17 5525xx
		25	6	●	●	●	●	●	33 000	25	94 17 5525xx
	32	6	6	●	●	●	●	●	27 000	25	94 17 5532xx
		12	6	●	●	●	●	●	27 000	25	94 17 5532xx
		25	6	●	●	●	●	●	22 000	25	94 17 5532xx
	50	6	6	●	●	●	●	●	22 000	25	94 17 5550xx
		12	6	●	●	●	●	●	19 000	25	94 17 5550xx
		25	6	●	●	●	●	●	16 500	25	94 17 5550xx
	60	6	6	●	●	●	●	●	13 000	25	94 17 5560xx
		12	6	●	●	●	●	●	13 000	25	94 17 5560xx
25		6	●	●	●	●	●	11 000	25	94 17 5560xx	

## ▼ 8. NYLON CLEANING ABRASIVES



### Cleaning Non-woven wheels made of 3M™ Clean & Strip material MOST Clean CS-RD

HIT

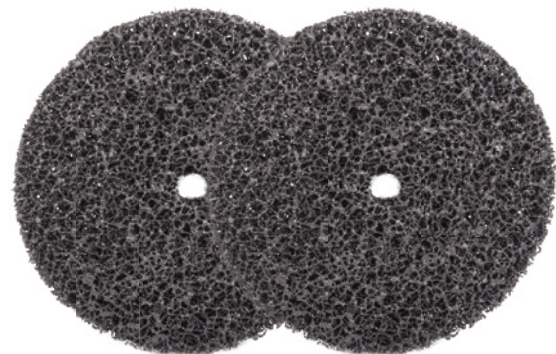
- Nylon Grinding wheels where layers of non-woven fibers are filled with abrasive grain and resin then compressed and cured.
- Ideal for cleaning welded seams, removing rust, discoloration, paint, epoxy and protective PVC layers.
- Very fast surface finishing, which ensures metallic-clean surface without any loss in treated material.
- It is ideal for removing discoloration after welding of stainless steel.
- The open structure of the wheel makes it resistant to clogging and does not overheat the material.
- Very fast cleaning, and meta-clean surface is achieved without loss of material.
- The version with CS-RD resin backing is designed for speed-controlled angle grinders.



Name	Diameter [mm]	Thickness [mm]	Hole [mm]	Type	Grits	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
					X CRS			
MOST Clean CS-RD	115	13	22	T27	●	8 350	10	94 17 671150
	125	13	22	T27	●	7 650	10	94 17 671250

### Cleaning Non-woven discs with hole, made of 3M™ CLEAN & STRIP material MOST Clean CS-DC

- Designed for wheel edge operation.
- Economical version with replaceable arbor.
- For use with special straight grinders.

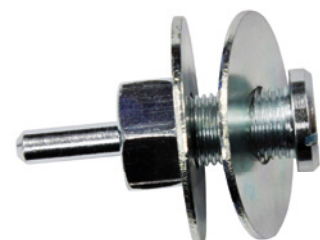


Name	Diameter [mm]	Thickness [mm]	Hole [mm]	Grits	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				X CRS			
MOST Clean CS-DC	75	13	6	●	7 000	25	94 17 650750
	100	13	13	●	5 700	20	94 17 651000
	125	13	13	●	4 500	10	94 17 651250
	150	13	13	●	3 800	10	94 17 651500

### Spindles

- Suitable for MOST Clean and MOST Press non-woven wheels.
- Enables the assembly of grinding tools on a straight grinder or bore machine.
- Maximum tool width 26 mm.

Name	Spindle size [mm]	Hole [mm]	Packaging [pcs.]	Catalogue No.
Spindle size 6/6	6	6	1	94 17 659005
Spindle size 900/6	6	12	1	94 17 659006
Spindle size 900/8	8	12	1	94 17 659008





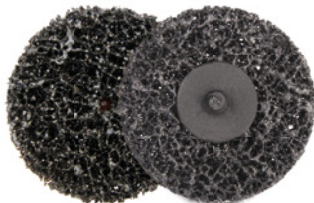
### Cleaning Non-woven wheels with shaft made 3M™ CLEAN & STRIP material MOST Clean CS-ST



- Nylon Grinding wheels where layers of non-woven fibers are filled with abrasive grain and resin then compressed and cured.
- Ideal for cleaning welded seams, removing rust, discoloration, paint, epoxy and protective PVC layers.
- Very fast surface finishing, which ensures metallic-clean surface without any loss in treated material.
- Ideal for removing discoloration after welding of stainless steel.
- The open structure of the wheel makes it resistant to clogging and do not overheat the material.

Name	Diameter [mm]	Width [mm]	Shaft [mm]	Grits	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				X CRS			
MOST Clean CS-ST	75	13	6	●	7 000	10	94 17 660750
		26	6	●	7 000	10	94 17 660751
	100	13	6	●	5 700	10	94 17 661000
		26	6	●	5 700	10	94 17 661001
	125	13	6	●	4 500	10	94 17 661250
		26	6	●	4 500	10	94 17 661251
	150	13	6	●	3 800	10	94 17 661500
		26	6	●	3 800	10	94 17 661501

### Cleaning Non-woven quick-change Roll-on discs made of 3M™ CLEAN & STRIP material MOST Clean CS-DR



- Quickly exchangeable discs, which are connected by fastening thread with the backing plate support, part of Roloc system.
- The small diameter of the grinding discs makes the works easier and does not require high-power grinding machines.
- Lightweight and handy electric and pneumatic grinders are dedicated to Roloc system.
- They guarantee proper selection of material at every level of treatment also in hard-to-reach places.

Name	Diameter [mm]	Thickness [mm]	Grits	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
			X CRS			
MOST Clean CS-DR	50	13	●	20 000	25	9M 00 130500
	75	13	●	12 000	25	9M 00 130750

### Cleaning Non-woven Rolls made of 3M™ CLEAN & STRIP material MOST Clean CS-MB



- Grinding wheels for cleaning large flat surfaces.
- Very fast surface finishing, which ensures metallic-clean surface without any loss in treated material.
- The open structure of the wheel makes it resistant to clogging and does not overheat the material.
- For use with special satin-finishing machines.

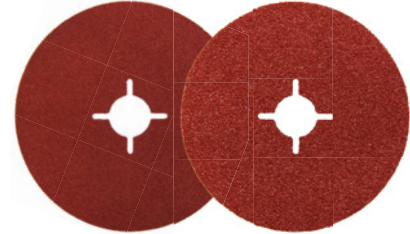
Name	Diameter [mm]	Width [mm]	Mounting [mm]	Grits	Recommended speed [rpm.]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				X CRS				
MOST CLEAN CS-MB	100	50	M14	●	2 000 - 3 700	5 700	5	94 17 681051
	100	75	M14	●	2 000 - 3 700	5 700	4	94 17 681071
	100	50	19/4 grooves	●	2 000 - 3 700	5 700	2	94 17 681050
	100	100	19/4 grooves	●	2 000 - 3 700	5 700	1	94 17 681000

## ▼ 9. FIBRE DISCS



### Aluminium Oxide fiber discs MOST Corundum

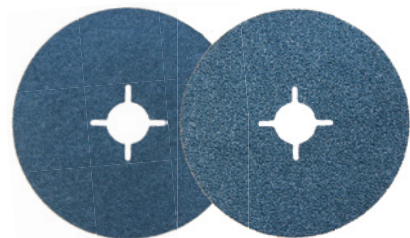
- Universal fiber disks for treatment of any type of steel.
- The wide size of grains in abrasive cloth allows the right choice of tool for each application.
- Very good price / quality ratio.



Name	Material	Diameter [mm]	Hole [mm]								Max speed [rpm.]	Packaging [pcs.]	Catalogue No.	
				16	24	36	50	60	80	100				120
MOST Corundum DA81T	Aluminium Oxide	115	22	●	●	●	●	●	●	●	●	13 200	100	94 11 9315xx
		125		●	●	●	●	●	●	●	●	12 000		94 11 9325xx
		180		●	●	●	●	●	●	●	●	8 500		94 11 9380xx

### Zirconium Oxide fiber discs MOST Zirconium

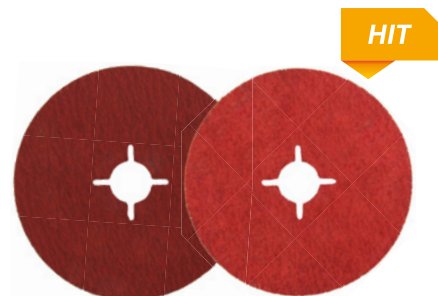
- Definitely higher efficiency and lifetime compared to standard fiber discs.
- Synthetic abrasive grain reduces these grinding temperatures.
- Optimal solution for industrial treatment of carbon and alloyed steels.



Name	Material	Width [mm]	Bore [mm]							Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
				24	36	50	60	80	120			
MOST Zirconium DZ73T	Zirconium Oxide	115	22	●	●	●	●	●		13 200	100	94 11 9415xx
		125		●	●	●	●	●		12 000		94 11 9425xx
		180		●	●	●	●	●		8 500		94 11 9480xx

### Ceramic abrasive fiber discs MOST Ceramic

- High aggressiveness and grinding efficiency due to self-sharpening ceramic grain.
- Low grinding temperature due to the additional active layer - TOP COATING.
- Particularly recommended for the fast treatment of stainless and hard-to-cut steel.

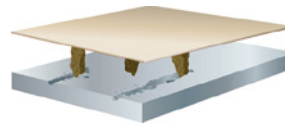
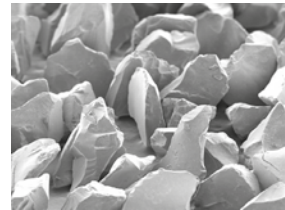


Name	Material	Width [mm]	Bore [mm]								Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
				24	36	50	60	80	100	120			
MOST Ceramic DG67TOP	Ceramic abrasive	115	22	●	●	●	●	●	●	●	13 200	100	94 11 9215xx
		125		●	●	●	●	●	●	●	12 000		94 11 9225xx
		180		●	●	●	●	●	●	●	8 500		94 11 9280xx

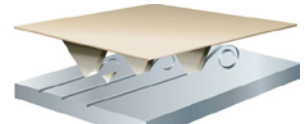
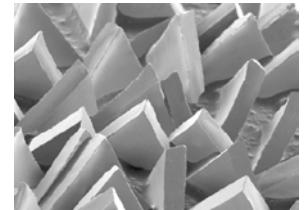
For use with suitable backing pads - see page 303.



3M™ Cubitron™ II Hookit™ Clean Sanding Film Disc 775L features 3M Precision Shaped Ceramic Grain, a revolutionary advancement in abrasive technology. The triangular shaped ceramic mineral is designed to slice through the substrate, rather than gouging or “plowing” like conventional abrasives, resulting in a disc that cuts up to 2x as fast and lasts up to 6x as long as conventional abrasives.



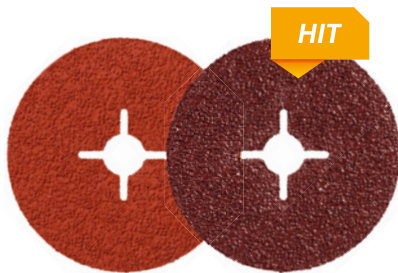
Standard Grain



3M™ Cubitron™ II

### 3M™ Cubitron™ II Fibre Discs

The product can be sold only on designated markets. Needs confirmation when submitting an inquiry. Please, contact: [export@rywal.com.pl](mailto:export@rywal.com.pl)



- Manufactured with use of 3M Precision-Shaped Grain in revolutionary advancement in abrasive technology.
- Very high grinding speed and up to twice the cut-rate, durability, and life in comparison to other standard fiber discs.
- Less grinding pressure required - less operator fatigue, better comfort of work.
- Designed for grinding carbon 982C) and stainless (987C) steels.
- Use of original 3M pads is recommended to increase the performance and lifetime of abrasive discs - see page 305.

Name	Width [mm]	Bore [mm]	Grits			Packaging [pcs.]	Catalogue No.
			36+	60+	80+		
982C Cubitron™ II	115	22	●	●	●	25	93 41 0526xx
	125		●	●	●		93 41 0527xx
	180		●	●	●		93 41 0580xx
987C Cubitron™ II	115	22	●	●	●	25	93 41 0626xx
	125		●	●	●		93 41 0627xx
	180		●	●	●		93 41 0680xx



## ▼ 10. QUICK-CHANGE ROLL-ON DISCS



### Coated abrasive quick-change discs MOST Roll-on

**MOST ZIRCONIUM** – Roll-on zirconium discs with polyester backing.

- Active additives for cool grinding.
- Extended lifetime and aggressive cutting power.

**MOST CERAMIC** - Roll-on ceramic discs with polyester backing.

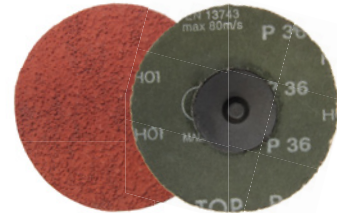
**MOST CERAMIC HD** - Roll-on ceramic discs with fiber backing.

**MOST CERAMIC ACC** - Roll-on ceramic (VSM Actirox) discs with fiber backing.

- High aggressiveness and grinding efficiency due to self-sharpening ceramic grains.
- Low grinding temperature due to the additional active layer - TOP COATING.

**MOST TZ** - Roll-on discs made of special 3M™ Trizact™ abrasive cloth.

- Precision pyramid-shaped abrasive grains.
- Provides equal finishing quality and high grinding efficiency.



Name	Material	Width [mm]	Grits								Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
			36	40	60	80	120						
MOST Zirconium	Zirconium abrasive + polyester backing	50	●	●	●	●	●				20 000	50	9M 00 1150XX
		70	●	●	●	●	●				12 000	25	9M 00 1175XX
MOST Ceramic	Ceramic abrasive + polyester backing	50		●	●	●	●				20 000	50	9M 00 1250XX
		75		●	●	●	●				12 000	25	9M 00 1275XX
MOST Ceramic HD	Ceramic abrasive + fiber backing	50	●		●	●	●				20 000	50	9M 00 1251XX
		75	●		●	●	●				12 000	25	9M 00 1276XX
MOST Ceramic ACC	VSM Actirox abrasive + fiber backing	50	●								20 000	50	9M 00 1252XX
		75	●								12 000	25	9M 00 1277XX
			A160	A100	A80	A65	A45	A30	A16	A6			
MOST TZ	3M™ Trizact™	50	●	●	●	●	●	●	●	●	20 000	50	9M 00 1253XX
		75	●	●	●	●	●	●	●	●	12 000	25	9M 00 1278XX

### Non-woven quick-change Roll-on discs made of 3M™ material MOST FVV SC-DR

- Different granulation of the grinding non-woven allows obtaining various surface finishing effects.
- For surface preparation, cleaning and finishing, removes small defects, gives a satin finish and removes rust and discoloration.
- For treatment of most metals, especially recommended for stainless steel.



Name	Material	Diameter [mm]	Grits				Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
			A CRS	A MED	A VFN	Type T			
MOST FVV SC-DR	3M™ Scotch-Brite Surface Conditioning™	50	●	●	●	●	20 000	50	9M 00 10500x
		75	●	●	●	●	12 000	25	9M 00 10750x



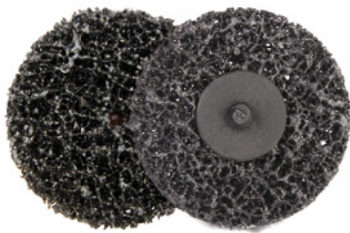
### Unitized non-woven quick-change discs made of 3M™ Scotch-Brite™ SC material MOST Press XL-DR



- Grinding discs where layers of non-woven fibers are filled with abrasive grain and resin then compressed and cured.
- Use of 5 different compression stages has made it possible to obtain innovative tools for differential grinding and polishing.
- Ideally suited for treatment of fillet welds and flat metal elements, as well as for deburring, cleaning, removing discoloration, giving the right surface texture and finishing of castings and forgings.
- Gentle abrasive parameters remain constant through the entire service life of product.

Name	Material	Width [mm]	Thickness [mm]	Grits					Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
				2S FIN	2A MED	3S FIN	6A MED	8A CRS			
MOST PRESS XL-DR	Unitized Non-woven 3M™	50	6	●	●	●	●	●	20 000	25	9M 00 14500x
		75	6	●	●	●	●	●	12 000	25	9M 00 14750x

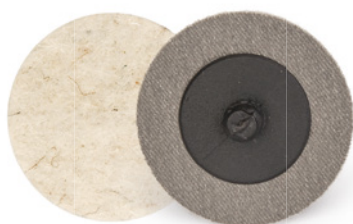
### Cleaning non-woven quick-change Roll-on discs made of 3M™ Clean & Strip material MOST Clean CS-DR



- Nylon Grinding discs where layers of non-woven fibers are filled with abrasive grain and resin then compressed and cured.
- Ideal for cleaning welded seams, removing rust, discoloration, paint, epoxy and protective PVC layers.
- Very fast surface finishing, which ensures metallic-clean surface without any loss in treated material.
- It is ideal for removing discoloration after welding of stainless steel.
- The open structure of the wheel makes it resistant to clogging and do not overheat the material.

Name	Material	Width [mm]	Thickness [mm]	Grits	Max rotation speed [rpm.]	Packaging [pcs.]	Catalogue No.
				X CRS			
MOST Clean CS-DR	Non-woven Clean & Strip 3M™	50	13	●	20 000	25	9M 00 130500
		75	13	●	12 000	25	9M 00 130750

### Quick-change Roll-on discs made of felt MOST FLT



- Felt discs for polishing different types of steel, aluminium and plastics.
- For use with polishing pastes only – see page 311.

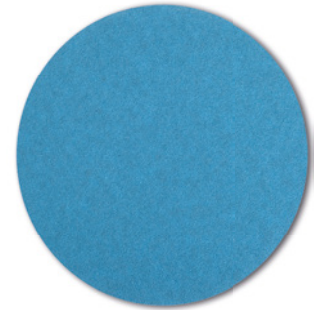
Name	Material	Width [mm]	Thickness [mm]	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FLT	Felt	50	5	20 000	25	9M 00 131500
		75	5	12 000	25	9M 00 131750

## ▼ 11. ABRASIVE DISCS



### Coated velcro-type discs MOST

- MOST Corundum PS22K - Aluminium Oxide discs for universal grinding of all types of steel.
- MOST Zirconium PS21FK – Zirconium Oxide discs for aggressive rough and finish treatment of carbon and stainless steel.
- MOST Ceramic PS61FK - high efficiency self-sharpening ceramic - abrasive discs for stainless steels and hard-to-cut steels.
- MOST TZ - discs made from a special 3M™ Trizact™ abrasive cloth with a precise pyramid-shaped abrasive grain. They provide equal finishing quality and high stock removal.



Name	Material	Backing	Diameter [mm]	Grits										Packaging [pcs.]	Catalogue No.	
				24	40	60	80	120	150	180	220	240	320			400
MOST Corundum PS22K	Aluminium Oxide	Paper	125	●	●	●	●	●	●	●	●	●	●	●	50	9M 51 0120xx
			150	●	●	●	●	●	●	●	●	●	●	●		9M 51 0150xx
MOST Zirconium PS21FK	Zirconium Oxide	Paper	125		●	●	●	●	●	●		●	●	50	9M 51 1120xx	
			150		●	●	●	●	●		●	●	●		9M 51 1150xx	
MOST Ceramic PS61FK	Ceramic abrasive	Cotton	125		●	●	●	●	●			●		50	9M 51 2120xx	
			150		●	●	●	●	●						9M 51 2150xx	
				A160	A100	A80	A65	A45	A30	A16	A6					
MOST TZ	3M™ Trizact™	Cotton	125	●	●	●	●	●	●	●	●			25	9M 51 3120xx	
			150	●	●	●	●	●	●	●	●				9M 51 3150xx	

On request, the discs are available with holes for dust exhaust systems.

### Non-woven discs made of 3M™ Scotch-Brite™ SC material MOST FVV SC

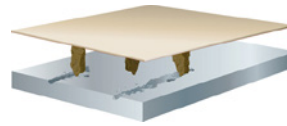
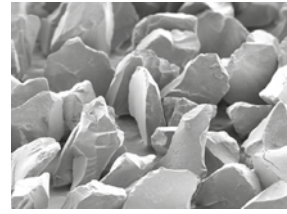
- Non-woven discs for angle and oscillating grinders with Velcro-type fastening (SC-DH) and 22 mm hole (SC-DC) for work on backing pads.
- Different granulation of the grinding non-woven allows obtaining different effects of surface finishes.
- For preparing, cleaning and finishing of surface, removing minor defects, satin scratches and removing rust and discolouration.
- For treatment of most metals, especially recommended for stainless steel.



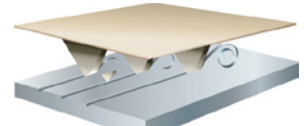
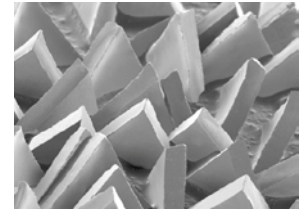
Name	Material	Diameter [mm]	Mounting [mm]	Grits				Packaging [pcs.]	Catalogue No.	
				A CRS	A MED	A VFN	Type T			
MOST FVV SC-DH - velcro type	3M™ Surface Conditioning™ non-woven	115	Velcro	●	●	●	●	10	9M 51 4115xx	
		125		●	●	●	●		10	9M 51 4125xx
		150		●	●	●	●		10	9M 51 4150xx
		180		●	●	●	●		10	9M 51 4180xx
MOST FVV SC-DC - for backing pads	3M™ Surface Conditioning™ non-woven	115	22 mm hole	●	●	●	●	10	9M 51 5115xx	
		125		●	●	●	●		10	9M 51 5125xx
		150		●	●	●	●		10	9M 51 5150xx
		180		●	●	●	●		10	9M 51 5180xx



3M™ Cubitron™ II Hookit™ clean sanding film disc 775L features 3M Precision Shaped Ceramic Grain, a revolutionary advancement in abrasive technology. The triangular shaped ceramic mineral is designed to slice through the substrate, rather than gouging or “plowing” like conventional abrasives, resulting in a disc that cuts up to 2x as fast and lasts up to 6x as long as conventional abrasives.



Standard Grain



3M™ Cubitron™ II

The product can be sold only on designated markets. Needs confirmation when submitting an inquiry. Please, contact: export@rywal.com.pl



### 3M™ Cubitron™ II Hookit™ Clean Sanding Film Disc 775L

- For aggressive treatment of putty surfaces and old varnishes, preparation for painting, cleaning and rust removal as well as levelling and uniforming the surface.
- Tear resistant polyester film backing.
- Multihole system of small dust extraction openings provides efficient dust removal without the risk of disc clogging.
- Use of original 3M™ pads is recommended to increase the performance and lifetime of abrasive discs - see page 305.

Name	Material	Backing	Width [mm]	Hole	Grits								Packaging [pcs.]	Catalogue No.
					80	120	150	180	220	240	320	400		
775L Cubitron™ II	Precision Shaped Ceramic	Polyester Film	125	none						●	●	●	50	93 41 0183xx
				Multihole	●	●	●	●	●	●	●	●		93 41 0182xx
			150	none						●	●	●		93 41 0186xx
				Multihole	●	●	●	●	●	●	●	●		93 41 0185xx

The product can be sold only on designated markets. Needs confirmation when submitting an inquiry. Please, contact: export@rywal.com.pl



HIT

### 3M™ Cubitron™ II Hookit™ disc 950U

- For aggressive treatment of putty surfaces and old varnishes, preparation for painting, cleaning and rust removal as well as levelling and uniforming the surface.
- Also available with dust extraction holes (15 and 17 holes).
- Use of original 3M™ pads is recommended to increase the performance and lifetime of abrasive discs - see page 305.

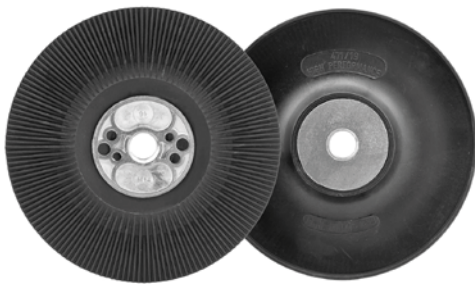
Name	Material	Backing	Width [mm]	Holes	Grits					Packaging [pcs.]	Catalogue No.
					60	80	120	150	180		
950U Cubitron™ II	Precision Shaped Ceramic	Paper	125	none	●	●	●	●	●	50	93 41 0212xx
				5 holes	●	●	●	●	●		93 41 0213xx
			150	none	●	●	●	●	●		93 41 0215xx
				15 holes	●	●	●	●	●		93 41 0216xx
				17 holes	●	●	●	●	●		93 41 0217xx

## ▼ 12. BACKING PADS



### Backing pads for fiber discs MOST

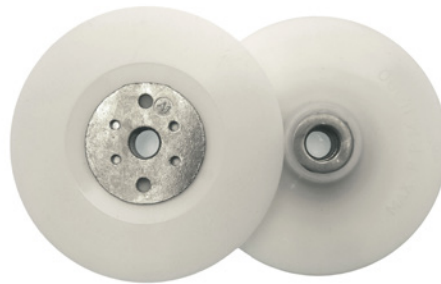
- Wide range of pads with different stiffness.
- Very hard, rib pattern pads should be used for rough treatment with high granulation fiber discs (P36 - P40).
- The hard pads can be used for universal treatment with medium granulation fiber discs (P60 - P80).
- Elastic pads (medium-hard) are best suited for discs with low granulation (above P80).



MOST Coolflow Very Hard



MOST Turbo Hard



MOST White Medium

Name	Diameter [mm]		Mounting	Hardness	Packaging [pcs.]	Catalogue No.
	Backing	Disc				
MOST Coolflow Very Hard	113	115	M14	Very hard, Ribbed	1	9M 00 100340
	123	125			1	9M 00 100350
	173	180			1	9M 00 100360
MOST Turbo Hard	107	115	M14	Hard	1	9M 00 100341
	117	125			1	9M 00 100351
	172	180			1	9M 00 100361
MOST White Medium	107	115	M14	Medium	1	9M 00 100342
	117	125			1	9M 00 100352
	172	180			1	9M 00 100362





### Roll-on quick-change backing plates



MOST Roll-on 50



MOST Roll-on 75



Adapter Roll-on M14



MOST Roloc M14/44



MOST Roloc M14/70

- The Roll-on system is a quick change abrasive discs with a diameter of 50 and 75 mm, which is connected to the backing pad by means of a plastic fastening thread.
- The small diameter of the discs makes grinding lighter and does not require a lot of power from the grinding machine.
- Lightweight and handy electric and pneumatic grinders dedicated to the Roll-on system ensure easier and precise grinding in hard-to-reach places.

Name	Width [mm]	Mounting	Packaging [pcs.]	Catalogue No.
MOST Roll-on 50	50	arbor 6 mm/M¼" thread	1	9M 00 100001
MOST Roll-on 75	75	arbor 6 mm/M¼" thread	1	9M 00 100002
MOST Roll-on M14/44	44	M14	1	9M 00 100010
MOST Roll-on M14/70	70	M14	1	9M 00 100011
MOST Roll-on M14/¼" adapter	-	arbor 6 mm/M¼" thread	1	9M 00 100012

### Velcro-type backing pads for abrasive discs MOST



MOST Velcro



MOST Velcro 8+1



MOST Velcro Micro Grip

- Available without holes for angle grinders and with holes for orbital grinders.
- Diameter and hole pattern depend on the type of grinder and dust exhaust system.

Name	Diameter [mm]	Holes	Mounting	Hardness	Packaging [pcs.]	Catalogue No.
MOST Velcro	115	none	M14	Medium-hard	1	9M 00 100514
	125	none	M14	Medium-hard	1	9M 00 100515
	150	none	M14	Medium-hard	1	9M 00 100516
	180	none	M14	Medium-hard	1	9M 00 100517
MOST Velcro 8+1	125	8+1	5/16+M8	Medium	1	9M 00 100525
	150	8+1	5/16+M8	Medium	1	9M 00 100526
MOST Velcro Micro Grip	150	53 Micro Grip	5/16+M8	Medium	1	9M 00 100536
	150	53 Micro Grip	5/16+M8	Soft	1	9M 00 100546



### 3M™ RIB pattern backing pads for fiber discs

- Higher rigidity and resistance to temperatures above 100°C.
- Unique ribbed pattern increases impact and aggressive grinding.
- Used together with 3M™ Cubitron II- fiber discs extend the service life.



Name	Width [mm]	Mounting	Hardness	Packaging [pcs.]	Catalogue No.
3M™ 64860	115	M14	Very hard, Ribbed	1	93 41 021202
3M™ 64861	125	M14		1	93 41 021200
3M™ 64862	180	M14		1	93 41 021204

### 3M™ Multihole backing pads for fastening discs 3M™ Hookit™

Ultra-tough and flexible fiber glass back plate with side dust extraction vents can be used for flat surfaces. Recommended for orbital sanders together with hole pattern discs Hookit™.

- Multihole pattern allows more dust to be extracted, which improves efficiency and prevents clogging of the material.
- Low profile of construction foam and conical edges (angle 35), additionally increases the durability of the pad.
- Velcro backing pad ensures perfect support of abrasive disc and optimal use during entire life cycle.

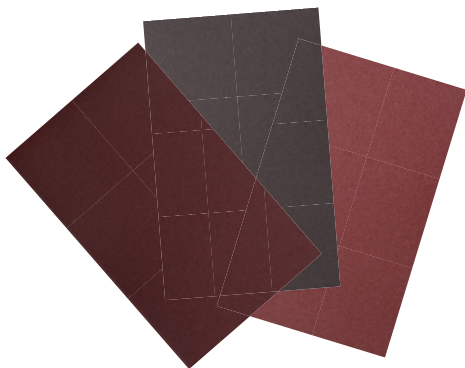


Name	Width [mm]	Holes	Mounting	Hardness	Packaging [pcs.]	Catalogue No.
3M™ 20353	125	Multihole 44	5/16 - 24	Medium-hard	1	93 41 021210
3M™ 20465	150	Multihole 53	5/16 - 24	Medium-hard	1	93 41 021211

▼ 13. ABRASIVE SHEETS



**Abrasive Paper and Cloth  
MOST Corundum**



- **MOST Corundum PL28C** - Multi-purpose sanding paper for manual and electrical sanding of wood and other materials.
- **MOST Corundum PS8A/C** - Very flexible waterproof abrasive paper, very good adaptation to treated material.
- **MOST Corundum KL375J** - High quality abrasive cloth for universal use. Optimal adaptation to the treated material thanks to a very flexible cotton backing - clean and simple tearing possible.

Name	Material	Backing	Dimensions [mm]	Grits															Packaging [pcs.]	Catalogue No.									
				36	40	60	80	120	150	180	220	240	320	360	400	500	600	800			1000	1200	1500	2000	2500				
MOST Corundum PL28C	Aluminium Oxide	Paper	230x280		●	●	●	●	●	●	●	●															50	9M 52 000xxx	
MOST Corundum PS8A/C	Silicon Carbide	Paper waterproof	230x280			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	50	9M 52 01xxxx
MOST Corundum KL375J	Aluminium Oxide	Cloth	230x280	●	●	●	●	●	●	●	●	●															50	9M 52 020xxx	

**Non-woven sheets MOST FVV**



- Universal non-woven material of Standard type with flexible structure.
- Homogenous grain-coating over the entire non-woven surface.
- For manual cleaning and finishing of metal and other surfaces.

Name	Material	Dimensions [mm]	Grits					Packaging [pcs.]	Catalogue No.
			A CRS	A MED	A FIN	A VFN	S UFN		
MOST FVV	Non-woven Standard	152x222	●	●	●	●	●	10	9M 00 15000x

## ▼ 14. ABRASIVE ROLLS



### Abrasive paper and cloth rolls MOST

- **MOST Corundum PS30D** - Standard abrasive paper with corundum grain for manual treatment of wood, varnish, paint and putty.
- **MOST Corundum KL381J** - Standard abrasive cloth with corundum grain for manual metal and wood treatment.
- **MOST Zirconium CS411X** - High efficient abrasive cloth with zirconium grain. Universal use in all areas of metalworking. High aggressiveness and efficiency in coarse grinding of carbon and stainless steel.



Name	Material/ backing	Width [mm] x Length [m]	Grits																Packaging [pcs.]	Catalogue No.	
			24	36	40	50	60	80	100	120	150	180	220	240	280	320	360	400			
MOST Corundum PS30D	Aluminium Oxide / Paper	93x50					●	●		●	●	●								1	9M 53 0093xx
		115x5					●	●		●	●	●								10	9M 53 0114xx
		115x50					●	●		●	●	●	●	●		●				1	9M 53 0115xx
		150x50					●	●		●	●									1	9M 53 0150xx
MOST Corundum KL381J	Aluminium Oxide / Cloth	150x30	●	●	●														1	9M 53 1150xx	
		150x50					●	●		●	●	●	●	●		●		●	1	9M 53 1150xx	
		200x30	●	●	●															1	9M 53 1200xx
		200x50					●	●		●	●	●	●	●						1	9M 53 1200xx
		920x30	●	●	●															1	9M 53 1920xx
		920x50					●	●		●	●	●	●	●						1	9M 53 1920xx
MOST Zirconium CS411X	Zirconium Oxide / Cloth	200x25					●	●											1	9M 53 2200xx	

### Non-woven abrasive rolls MOST FVV

- Universal non-woven material of Standard type with flexible structure.
- Homogenous grain-coating over the entire non-woven surface.
- For manual cleaning and finishing of metal and other surfaces.



Name	Material	Width [mm]	Length [m]	Grits					Packaging [pcs.]	Catalogue No.
				A CRS	A MED	A FIN	A VFN	S UFN		
MOST FVV	Non-woven Standard	100	5	●	●	●	●	●	1	9M 00 15002x

▼ 15. ENDLESS ABRASIVE BELTS



**MOST endless belts for stationary grinders MOST and GRIT**



- **MOST CORUNDUM** - universal abrasive cloth with aluminium oxide grain.
- **MOST ZIRCONIUM** - universal abrasive cloth with zirconium grain.
- **MOST ZIRCONIUM HD** - very efficient Heavy Duty abrasive cloth with zirconium grain and active cooling layer.
- **MOST CERAMIC** - aggressive and high efficient abrasive cloth with ceramic grain.
- **MOST TZ** - 3M™ Trizact™ special cloth with precise pyramid-shaped abrasive grain.
- **MOST FVV SC** - 3M™ Scotch-Brite™ Surface Conditioning™ abrasive non-woven.
- **MOST FLT** - polishing felt, to be used together with polishing pastes.

Name	Material	Width [mm]	Length [mm]	Grits								Packaging [pcs.]	Catalogue No.	
				36	40	60	80	120	180	240	320			400
MOST Corundum	Aluminium Oxide	75	2000	●	●	●	●	●	●	●	●	●	10	9M 07 5xxxxx
		150	2000	●	●	●	●	●	●	●	●	●		9M 15 0xxxxx
MOST Zirconium	Zirconium Oxide	75	2000	●	●	●	●	●					10	9M 07 5xxxxx
		150	2000	●	●	●	●	●						9M 15 0xxxxx
MOST Zirconium HD	Zirconium Oxide + Top Coating	75	2000	●	●	●	●	●					10	9M 07 5xxxxx
		150	2000	●	●	●	●	●						9M 15 0xxxxx
MOST Ceramic	Ceramic Abrasive	75	2000	●	●	●	●	●					10	9M 07 5xxxxx
		150	2000	●	●	●	●	●						9M 15 0xxxxx
				A160	A100	A80	A65	A45	A30	A16	A6			
MOST TZ	3M™ Trizact™	75	2000	●	●	●	●	●	●	●	●		10	9M 07 5xxxxx
		150	2000	●	●	●	●	●	●	●	●			9M 15 0xxxxx
				A CRS	A MED	A VFN	Type T							
MOST FVV SC	3M™ Surface Conditioning™ non-woven	75	2000	●		●		●		●			10	9M 07 5xxxxx
		150	2000	●		●		●		●				9M 15 0xxxxx
MOST FLT	Felt	75	2000									10	9M 07 5xxxxx	
		150	2000										9M 15 0xxxxx	





**MOST endless belts for manual grinders**



Name	Material	Width [mm]	Length [mm]	Grits						Packaging [pcs.]	Catalogue No.		
				40	60	80	120						
MOST Ceramic	Ceramic Abrasive	6	520	●	●	●	●			10	9M 00 6xxxxx		
		12	520	●	●	●	●			10	9M 01 2xxxxx		
		19	520	●	●	●	●			10	9M 01 9xxxxx		
		30	533	●	●	●	●			10	9M 03 0xxxxx		
		30	610	●	●	●	●			10	9M 03 0xxxxx		
		50	450	●	●	●	●			10	9M 05 0xxxxx		
				A160	A100	A80	A65	A45	A30	A16	A6		
MOST TZ	3M™ Trizact™	6	520	●	●	●	●	●	●	●	●	10	9M 00 6xxxxx
		12	520	●	●	●	●	●	●	●	●	10	9M 01 2xxxxx
		19	520	●	●	●	●	●	●	●	●	10	9M 01 9xxxxx
		30	533	●	●	●	●	●	●	●	●	10	9M 03 0xxxxx
		30	610	●	●	●	●	●	●	●	●	10	9M 03 0xxxxx
		50	450	●	●	●	●	●	●	●	10	9M 05 0xxxxx	
				A CRS	A MED	A VFN	Type T						
MOST FVV SC	3M™ Surface Conditioning™ non-woven	6	520	●	●	●	●					10	9M 00 6xxxxx
		12	520	●	●	●	●					10	9M 01 2xxxxx
		19	520	●	●	●	●					10	9M 01 9xxxxx
		30	533	●	●	●	●					10	9M 03 0xxxxx
		30	610	●	●	●	●					10	9M 03 0xxxxx
		50	450	●	●	●	●				10	9M 05 0xxxxx	
MOST FLT	Felt	6	520									10	9M 00 6xxxxx
		12	520									10	9M 01 2xxxxx
		19	520									10	9M 01 9xxxxx
		30	533									10	9M 03 0xxxxx
		30	610									10	9M 03 0xxxxx
		50	450								10	9M 05 0xxxxx	



**Endless abrasive belts 3M™ - Cubitron™ II for manual grinders**



Name	Material	Width [mm]	Length [mm]	Grits			Packaging [pcs.]	Catalogue No.
				36+	60+	80+		
784 F Cubitron™ II	Precision Shaped Ceramic Abrasive	19	520	●	●	●	10	9K 01 9xxxxx
		30	533	●	●	●	10	9K 03 0xxxxx
		30	610	●	●	●	10	9K 03 0xxxxx
		50	450	●	●	●	10	9K 05 0xxxxx
984 F Cubitron™ II	Precision Shaped Ceramic Abrasive	19	520	●	●	●	10	9K 01 9xxxxx
		30	533	●	●	●	10	9K 03 0xxxxx
		30	610	●	●	●	10	9K 03 0xxxxx
		50	450	●	●	●	10	9K 05 0xxxxx

## ▼ 16. POLISHING PRODUCTS



### Cotton polishing buffs MOST



- Blue impregnated cotton buffing discs for initial polishing (pre-polishing).
- Type 215 cotton disc for basic polishing.
- Type 101 cotton disc for final polishing.

Name	Diameter [mm]	Thickness [mm]	Bore [mm]	Application	Packaging [pcs.]	Catalogue No.
Blue impregnated cotton	152	14	32*	Pre-polishing (cuts no.)	1	9M 50 000015
	203					9M 50 000020
Type 215 cotton	152	14	32*	Basic polishing	1	9M 50 000115
	203					9M 50 000120
Type 101 cotton	152	12	32*	Final polishing	1	9M 50 000215
	203					9M 50 000220

\*On request, available adapters for diameter 12.7 / 15.8 / 20 / 22 / 25.4 mm.

### Felt flap wheels MOST FLT LF



- Discs made of high quality felt.
- The fan-shaped flap construction reduces the polishing temperature.
- For use with polishing pastes only - see page 311.

Material	Width [mm]	Bore [mm]	Type	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
Filc	115	22	T29	4 900	10	9M 50 006115
	125	22	T29	4 500	10	9M 50 006125

### Felt velcro-type discs MOST FLT



- Felt wheels for polishing different types of steel, aluminium and plastics.
- Available in 5 and 10 mm thickness.
- For use with polishing pastes only - see page 311.

Name	Material	Width [mm]	Mounting	Max speed [rpm.]	Packaging [pcs.]	Catalogue No.
MOST FLT	FLT	125x5	Velcro	3 000	5	9M 50 002205
		125x10	Velcro	3 000	5	9M 50 002210
		150x5	Velcro	2 500	5	9M 50 002305
		150x10	Velcro	2 500	5	9M 50 002310



### Solid compounds for metal polish

- Solid polishing compound for polishing carbon steel, stainless steel and aluminum and non-ferrous metals.
- For use in single or multi-stage polishing operations.
- For use in combination with polishing felt or polishing MOST discs.



Name	Weight [kg]	Application	Features	Packaging [pcs.]	Catalogue No.
Polishing compound brown P1000	1	Pre-polishing and basic polishing of aluminium and non-ferrous metals	Cutting, highly abrasive, medium gloss	1	9M 50 001101
Polishing compound white P3000	1	Pre-polishing and basic polishing of stainless steel	Cutting, highly abrasive, medium gloss	1	9M 50 001102
Polishing compound blue C2000	1	Gloss polishing of stainless steel, aluminium and non-ferrous metals	Finishing, high gloss	1	9M 50 001103

### Liquid compounds for metal polish

- Liquid compounds for polishing carbon steel, stainless steel and aluminum and non-ferrous metals.
- For use as final polishing.
- For use with polishing cloths and cotton polishing discs.



Name	Weight	Application	Features	Packaging [pcs.]	Catalogue No.
Unipol Metal Polish	125	Universal for polishing stainless steel, aluminium and non-ferrous metals	Finishing, high gloss	1	9M 50 001201
Unipol Metal Polish	1000			1	9M 50 001202

### Liquid compounds for acrylic polish

- Liquid compounds for polishing plastic.
- For use as final polishing.
- For use with polishing cloths and cotton polishing discs.



Name	Weight	Application	Features	Packaging [pcs.]	Catalogue No.
Unipol Dur Plastic Polish	125	Universal for plastic and acrylic polishing	Finishing, high gloss	1	9M 50 001211
Unipol Dur Plastic Polish	1000			1	9M 50 001212



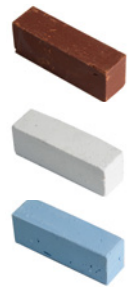
### Polishing compounds kit Small



Kit contains:

- Brown compound (50g) = Pre-polish for aluminium and non-ferrous metals.
- White compound (50g) = Pre-polish for carbon and stainless steel.
- Blue compound (50g) = Gloss polish for carbon, stainless and non-ferrous metals.

Catalogue No. 9M 50 001311



### Polishing compounds kit Large



Kit contains:

- Brown compound (50g) = Pre-polish for aluminium and non-ferrous metals.
- White compound (50g) = Pre-polish for carbon and stainless steel.
- Blue compound (50g) = Gloss polish for carbon, stainless and non-ferrous metals.
- 2 x Sisal/cloth (cutting) folded buffs.
- 2 x NOTIFLEX® fleece hard (polishing) folded buffs.
- 2 x NOTIFLEX® fleece soft (colouring) folded buffs.
- 1 x tapered shank, Ø6 mm.

Catalogue No. 9M 50 001312



### Metal polishing kit - Unipol Metal Polish



The practical universal kit for polishing all types of metal and chrome surfaces.

Kit contains:

- tube of metal polish (125 ml),
- sponge for application and polishing,
- cloth for repeated polishing and cleaning.

Catalogue No. 9M 50 001321



### Acrylic and plastic polishing kit - Unipol Dur Plastic Polish

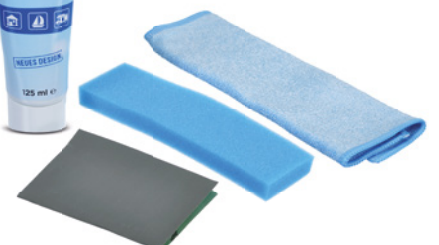


The practical universal kit for all types of plastic and acrylic polishing.

Kit contains:

- tube of dur plastic polish (125 ml),
- sandpaper,
- sponge for application and polishing,
- cloth for repeated polishing and cleaning.

Catalogue No. 9M 50 001322



▼ 17. WIRE BRUSHES



**MOST knotted wire, cup brushes, M14 thread**

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel wire	0,50 mm	Ø65 mm	12 500 rpm	93 38 608 151
	0,50 mm	Ø75 mm	11 500 rpm	93 38 608 152
	0,50 mm	Ø80 mm	8 500 rpm	93 38 608 153
	0,50 mm	Ø100 mm	8 500 rpm	93 38 608 154
	0,50 mm	Ø125 mm	6 500 rpm	93 38 608 156
Stainless steel wire	0,35 mm	Ø65 mm	12 500 rpm	93 38 608 331
	0,50 mm	Ø65 mm	12 500 rpm	93 38 608 351
	0,50 mm	Ø80 mm	8 500 rpm	93 38 608 353



**MOST crimped wire, cup brushes, M14 thread**

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel wire	0,30 mm	Ø60 mm	12 500 rpm	93 38 613 161
	0,30 mm	Ø75 mm	12 500 rpm	93 38 613 162
	0,30 mm	Ø80 mm	8 500 rpm	93 38 613 163
	0,30 mm	Ø100 mm	8 500 rpm	93 38 613 164
	Stainless steel wire	0,30 mm	Ø60 mm	12 500 rpm
0,30 mm		Ø75 mm	11 500 rpm	93 38 613 362
0,30 mm		Ø80 mm	8 500 rpm	93 38 613 363
0,30 mm		Ø100 mm	8 500 rpm	93 38 613 364



**MOST crimped wire, cup brush, 6 mm shank mounted**

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel wire	0,30 mm	Ø50 mm	4 500 rpm	93 38 600 821
	0,30 mm	Ø75 mm	4 500 rpm	93 38 600 921
Stainless steel wire	0,30 mm	Ø50 mm	4 500 rpm	93 38 600 832
	0,30 mm	Ø75 mm	4 500 rpm	93 38 600 361
	0,20 mm	Ø75 mm	4 500 rpm	93 38 600 921



**MOST knotted wire, bevel brushes, M14 thread**

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel wire	0,50 mm	Ø100x13 mm	12 500 rpm	93 38 622 151
	0,50 mm	Ø115x13 mm	12 500 rpm	93 38 632 151
	0,50 mm	Ø125x13 mm	12 500 rpm	93 38 632 152
Stainless steel wire	0,50 mm	Ø100x13 mm	12 500 rpm	93 38 622 351
	0,50 mm	Ø115x15 mm	12 500 rpm	93 38 632 351



**MOST crimped wire, bevel brushes, M14 thread**

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel wire	0,30 mm	Ø100 x 16 mm	12 500 rpm	93 38 512 161
	0,30 mm	Ø100 x 20 mm	12 500 rpm	93 38 512 162
	0,30 mm	Ø125 x 10 mm	12 500 rpm	93 38 514 161
Stainless steel wire	0,30 mm	Ø100 x 10 mm	12 500 rpm	93 38 512 361
	0,30 mm	Ø100 x 20 mm	12 500 rpm	93 38 512 362
	0,30 mm	Ø125 x 10 mm	12 500 rpm	93 38 514 361
	0,20 mm	Ø100 x 20 mm	12 500 rpm	93 38 512 342







**MOST knotted wire, wheel brushes, M14 thread**



Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,50 mm	Ø125 x 13 mm	11 000 rpm	93 38 631 161
Stainless steel wire	0,50 mm	Ø125 x 13 mm	12 500 rpm	93 38 631 361

**MOST crimped wire, wheel brushes, M14 thread**



Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,30 mm	Ø115 x 13 mm	11 000 rpm	93 38 631 152
Stainless steel wire	0,30 mm	Ø115 x 13 mm	12 500 rpm	93 38 532 361

**MOST knotted wire, wheel brushes, with arbor hole 22 mm**



Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,50 mm	Ø115 x 12 mm	12 500 rpm	93 38 631 150
	0,50 mm	Ø125 x 13 mm	12 500 rpm	93 38 631 151
	0,50 mm	Ø125 x 6 mm	12 500 rpm	93 38 626 251
Stainless steel wire	0,50 mm	Ø115 x 12 mm	12 500 rpm	93 38 631 350
	0,50 mm	Ø125 x 13 mm	12 500 rpm	93 38 631 351
	0,50 mm	Ø178 x 13 mm	12 000 rpm	93 38 653 350

**MOST crimped wire, wheel brushes, with arbor hole 32 mm\***



Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,30 mm	Ø125 x 22 x 20 mm	6 000 rpm	93 38 532 162
	0,30 mm	Ø150 x 25 x 32 mm	6 000 rpm	93 38 544 162
	0,30 mm	Ø178 x 25 x 32 mm	6 000 rpm	93 38 554 062
	0,30 mm	Ø200 x 25 x 32 mm	4 500 rpm	93 38 566 162
	0,30 mm	Ø250 x 25 x 32 mm	3 600 rpm	93 38 576 162
Stainless steel wire	0,20 mm	Ø150 x 20 x 32 mm	6 000 rpm	93 38 544 341
	0,30 mm	Ø150 x 20 x 32 mm	6 000 rpm	93 38 544 361
	0,20 mm	Ø200 x 20 x 32 mm	6 000 rpm	93 38 566 341
	0,30 mm	Ø200 x 20 x 32 mm	4 500 rpm	93 38 566 361
	0,20 mm	Ø250 x 20 x 32 mm	4 500 rpm	93 38 576 341
	0,30 mm	Ø250 x 20 x 32 mm	3 600 rpm	93 38 576 361

\*On request, available adapters for diameter 12.7 / 15.8 / 20 / 22 / 25.4 mm.

**MOST knotted wire, wheel brushes, 6 mm shank mounted**



Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,50 mm	Ø75 x 12 mm	20 000 rpm	93 38 611 151
Stainless steel wire	0,50 mm	Ø75 x 12 mm	20 000 rpm	93 38 612 151



### MOST crimped wire wheel brushes, 6 mm shank mounted

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,30 mm	Ø40 x 5 mm	4 500 rpm	93 38 600 121
	0,30 mm	Ø50 x 7 mm	4 500 rpm	93 38 600 221
	0,30 mm	Ø63 x 9 mm	4 500 rpm	93 38 600 321
	0,30 mm	Ø75 x 10 mm	4 500 rpm	93 38 600 421
	0,30 mm	Ø100 x 12 mm	4 500 rpm	93 38 600 521
Stainless steel wire	0,20 mm	Ø50 x 7 mm	4 500 rpm	93 38 601 221
	0,30 mm	Ø75 x 10 mm	4 500 rpm	93 38 601 421
	0,20 mm	Ø75 x 10 mm	4 500 rpm	93 38 601 431
	0,20 mm	Ø100 x 10 mm	4 500 rpm	93 38 601 531
Stainless steel wire (high-speed)	0,20 mm	Ø50 x 17 mm	15 000 rpm	93 38 504 342
	0,30 mm	Ø50 x 10 mm	15 000 rpm	93 38 504 361
	0,20 mm	Ø70 x 18 mm	15 000 rpm	93 38 506 342
	0,30 mm	Ø70 x 18 mm	15 000 rpm	93 38 506 362
	0,30 mm	Ø80 x 19 mm	15 000 rpm	93 38 507 362



### MOST crimped wire, end brushes, 6 mm shank mounted

Type	Wire thickness	Dimensions	Max. speed	Catalogue No.
Carbon steel	0,30 mm	Ø12 mm	4 500 rpm	93 38 509 161
	0,30 mm	Ø17 mm	4 500 rpm	93 38 509 162
	0,30 mm	Ø25 mm	4 500 rpm	93 38 509 163
	0,30 mm	Ø30 mm	4 500 rpm	93 38 509 164
Stainless steel wire	0,30 mm	Ø10 mm	20 000 rpm	93 38 509 361
	0,30 mm	Ø17 mm	18 000 rpm	93 38 509 362
	0,30 mm	Ø25 mm	18 000 rpm	93 38 509 363
	0,30 mm	Ø30 mm	15 000 rpm	93 38 509 364



### MOST hand scratch brushes

Type	Catalogue No.
<b>Carbon Steel wire, wooden handle</b>	
2 rows	93 38 152 132
3 rows	93 38 152 133
4 rows	93 38 152 134
5 rows	93 38 152 135
<b>Stainless steel wire, wooden handle</b>	
2 rows	93 38 152 332
3 rows	93 38 152 333
4 rows	93 38 152 334
5 rows	93 38 152 335
<b>Carbon Steel wire, steel spine &amp; plastic handle - red</b>	
universal 265/140	93 38 462 291
<b>Stainless steel wire, steel spine &amp; plastic handle - green</b>	
universal 265/140	93 38 462 391
<b>Brass Steel wire, steel spine &amp; plastic handle - yellow</b>	
universal 265/140	93 38 462 591
<b>Carbon Steel wire, plastic spine &amp; handle - yellow/black</b>	
slotted 2-rows	93 38 462 162



## ▼ 18. TUNGSTEN CARBIDE ROTARY BURRS



**MOST tungsten carbide burrs:**

- Tungsten carbide burrs (otherwise rotary deburring tools) are intended for work on welds, edges, holes and details made of different types of metal.
- The precise cutting edge geometry on the burr head allows for long term and precise cutting in all applications where high speed grinding machines are used.
- The key issue affecting the service life and aggressiveness of carbide burrs is the selection of the correct rotation speed and the correct using of the tool.

**Recommendations for users:**

- To achieve optimum burrs efficiency, it may require detailed selection and precise adjustment – see table below to check rotation speed references.
- Hardened materials require lower rotation speed.
- Extra-long burrs over 150 mm should be used in lower rotation speed (max. 15.000 rpm).
- Use low pressure force and constant feed while working.
- Working below optimum speed will encourage chipping of the burr head.
- Working above optimum speed will result in excessive wear to the burr head.
- Do not overheat the burr, too high temperature may cause the head and spindle connection to melt or even destroy the welder joint.
- Improper assembly of burr to grinder or operation with a worn grinder may damage the burrs.
- Do not push the burr into work-piece deeper than 1/3 of its length.

**Recommended rotation speed [rpm.]**

Diameter	3 mm	6 mm	10 mm	12 mm	16 mm
Steel	60 000 - 90 000	45 000 - 60 000	30 000 - 40 000	22 500 - 30 000	18 000 - 24 000
Hardened	60 000 - 90 000	30 000 - 45 000	19 000 - 30 000	15 000 - 22 500	12 000 - 18 000
Stainless	60 000 - 90 000	30 000 - 45 000	19 000 - 30 000	15 000 - 22 500	12 000 - 18 000
Cast Iron	45 000 - 90 000	22 500 - 60 000	15 000 - 40 000	11 000 - 30 000	9 000 - 24 000
Titan	60 000 - 90 000	30 000 - 45 000	19 000 - 30 000	15 000 - 22 500	12 000 - 18 000
Nickel	60 000 - 90 000	30 000 - 45 000	19 000 - 30 000	15 000 - 22 500	12 000 - 18 000
Copper	45 000 - 90 000	22 500 - 60 000	15 000 - 40 000	11 000 - 30 000	9 000 - 24 000
Aluminium	30 000 - 90 000	15 000 - 70 000	10 000 - 50 000	7 000 - 38 000	6 000 - 30 000
Plastics	30 000 - 90 000	15 000 - 70 000	10 000 - 50 000	7 000 - 38 000	6 000 - 30 000
Ceramic materials	60 000 - 90 000	30 000 - 45 000	19 000 - 30 000	15 000 - 22 500	12 000 - 18 000

**Cutting styles**



The health and safety regulations must be used while working with burrs. For protective glasses and gloves, see chapter 04.



**MOST STANDARD line**

**MOST STANDARD**

**MOST STD Double cut**



- Medium double cut blades, pattern-breaking.
- A large amount of removed material.
- Good quality of treated surface.
- Low vibration and short chips.
- Popular head shape suitable for universal treatment of black and stainless steel.



Shape	Name (shape)	Symbol	Dimensions [mm]	Catalogue No.
	Cylindrical A (ZYA)	A 0616 D A 0820 D A 1020 D A 1225 D A 1625 D	6x16x6 8x20x6 10x20x6 12x25x6 16x25x6	94 85 100616 94 85 100820 94 85 101020 94 85 101225 94 85 101625
	Cylindrical with end cut B (ZYA-S)	B 0616 D B 0820 D B 1020 D B 1225 D B 1625 D	6x16x6 8x20x6 10x20x6 12x25x6 16x25x6	94 85 010616 94 85 010820 94 85 011020 94 85 011225 94 85 011625
	Cylindrical with radius cut C (WRC)	C 0616 D C 0820 D C 1020 D C 1225 D C 1625 D	6x16x6 8x20x6 10x20x6 12x25x6 12x25x8 16x25x6	94 85 020616 94 85 020820 94 85 021020 94 85 021225 94 85 221225 94 85 021625
	Ball D (KUD)	D 0605 D D 0806 D D 1009 D D 1210 D D 1614 D	6x5x6 8x7x6 10x9x6 12x11x6 16x14x6	94 85 030605 94 85 030806 94 85 031009 94 85 031210 94 85 031614
	Oval E (TRE)	E 0610 D E 0813 D E 1016 D E 1220 D E 1625 D	6x10x6 8x13x6 10x16x6 12x22x6 16x25x6	94 85 040610 94 85 040813 94 85 041016 94 85 041220 94 85 041625
	Tree with Radius End F (RBF)	F 0618 D F 0820 D F 1020 D F 1225 D F 1225 D F 1625 D	6x18x6 8x20x6 10x20x6 12x25x6 12x25x8 16x25x8	94 85 050618 94 85 050820 94 85 051020 94 85 051225 94 85 251225 94 85 051625
	Tree with Pointed End G (SPG)	G 0618 D G 0820 D G 1020 D G 1225 D G 1625 D	6x18x6 8x20x6 10x20x6 12x25x6 16x25x6	94 85 060618 94 85 060820 94 85 061020 94 85 061225 94 85 061625
	Flame H (-)	H 0618 D H 0820 D H 1020 D H 1232 D H 1636 D	6x18x6 8x20x6 10x20x6 12x32x6 16x36x6	94 85 070618 94 85 070820 94 85 071020 94 85 071232 94 85 071636
	Cone with Radius End L (KEL)	L 0616 D L 0822 D L 1025 D L 1230 D L 1230 D L 1633 D	6x16x6 8x22x6 10x25x6 12x30x6 12x30x8 16x33x6	94 85 080616 94 85 080822 94 85 081025 94 85 081230 94 85 281230 94 85 281633
	Cone M (SKM)	M 0618 D M 0820 D M 1020 D M 1225 D M 1625 D	6x18x6 8x20x6 10x20x6 12x25x6 16x25x6	94 85 090618 94 85 090820 94 85 091020 94 85 091225 94 85 091625



**MOST STANDARD line**

**MOST STANDARD**

**MOST STD Speed Cut**

- Two types of cutting blades in one burr - Coarse and Fine.
- Coarse blades provide faster material removal.
- Fine blades provide smooth treatment of material surface.
- Lighter and more comfortable material grinding.
- 30% higher cutting efficiency and service life.



Shape	Name (shape)	Symbol	Dimensions [mm]	Catalogue No.
	Cylindrical A (ZYA)	A 0820 SPEED A 1020 SPEED A 1225 SPEED	8x20x6 10x20x6 12x25x6	94 87 100820 94 87 101020 94 87 101225
	Cylindrical with end cut B (ZYA-S)	B 0820 SPEED B 1020 SPEED B 1225 SPEED	8x20x6 10x20x6 12x25x6	94 87 010820 94 87 011020 94 87 011225
	Cylindrical with radius cut C (WRC)	C 0820 SPEED C 1020 SPEED C 1225 SPEED C 1225 SPEED	8x20x6 10x20x6 12x25x6 12x25x8	94 87 020820 94 87 021020 94 87 021225 94 87 221225
	Oval E (TRE)	E 0813 SPEED E 1016 SPEED E 1220 SPEED	8x13x6 10x16x6 12x22x6	94 87 040813 94 87 041016 94 87 041220
	Tree with Radius End F (RBF)	F 0820 SPEED F 1020 SPEED F 1225 SPEED F 1225 SPEED	8x20x6 10x20x6 12x25x6 16x25x8	94 87 050820 94 87 051020 94 87 051225 94 87 251225
	Tree with Pointed End G (SPG)	G 0820 SPEED G 1020 SPEED G 1225 SPEED	8x20x6 10x20x6 12x25x6	94 87 060820 94 87 061020 94 87 061225
	Flame H (-)	H 0820 SPEED H 1020 SPEED H 1232 SPEED	8x20x6 10x20x6 12x32x6	94 87 070820 94 87 071020 94 87 071232
	Cone with Radius End L (KEL)	L 0822 SPEED L 1025 SPEED L 1230 SPEED L 1230 SPEED	8x22x6 10x20x6 12x30x6 12x30x8	94 87 080822 94 87 081025 94 87 081230 94 87 281230
	Cone M (SKM)	M 0820 SPEED M 1020 SPEED M 1225 SPEED	08x20x6 10x20x6 12x25x6	94 87 090820 94 87 091020 94 87 091225





**MOST PRO line**



**MOST PRO Steel Cut**

- Innovative burrs for the aggressive treatment of black steel, made of the highest quality tungsten carbide.
- Specially developed cutting edges geometry of carbide burr head provides high speed and efficiency of metal treatment.
- Double speed of cutting compared to the conventional burrs.
- Limited heat generation at the cutting edge of the burr and at the workpiece.
- High surface quality of treated material.



Shape	Name (shape)	Symbol	Dimensions [mm]	Catalogue No.
	Cylindrical A (ZYA)	A 1020 STEEL A 1225 STEEL	10x20x6 12x25x6	94 88 001020 94 88 001225
	Cylindrical with end cut B (ZYA-S)	B 1020 STEEL B 1225 STEEL	10x20x6 12x25x6	94 88 011020 94 88 011225
	Cylindrical with radius cut C (WRC)	C 1020 STEEL C 1225 STEEL	10x20x6 12x25x6	94 88 021020 94 88 021225
	Oval E (TRE)	E 1016 STEEL E 1220 STEEL	10x16x6 12x22x6	94 88 041016 94 88 041220
	Tree with Radius End F (RBF)	F 1020 STEEL F 1225 STEEL F 1225 STEEL	10x20x6 12x25x6 16x25x8	94 88 051020 94 88 051225 94 88 151225
	Tree with Pointed End G (SPG)	G 1020 STEEL G 1225 STEEL	10x20x6 12x25x6	94 88 061020 94 88 061225
	Flame H (-)	H 1020 STEEL H 1232 STEEL	10x20x6 12x32x6	94 88 071020 94 88 071232
	Cone with Radius End L (KEL)	L 1025 STEEL L 1230 STEEL	10x20x6 12x30x6	94 88 081025 94 88 081230
	Cone M (SKM)	M 1020 STEEL M 1225 STEEL	10x20x6 12x25x6	94 88 091020 94 88 091225



**MOST PRO line**



**MOST PRO Alu Cut**

- Wide single-sided burrs designed for working on aluminium and its alloys, as well as for plastic and hard rubber.
- Wide spacing between blades prevents clogging and sticking of treated material.
- Sharped edges of burr head generate large chips and allow for quick treatment of material.



Shape	Name (shape)	Symbol	Dimensions [mm]	Catalogue No.
	Cylindrical with end cut B (ZYAS)	B 1225 ALU	12x25x6	94 88 411225
	Cylindrical with radius cut C (WRC)	C 1225 ALU	12x25x6	94 88 421225
	Tree with Radius End F (RBF)	F 1225 ALU	12x25x6	94 88 451225
	Tree with Pointed End G (SPG)	G 1225 ALU	12x25x6	94 88 461225
	Flame H (-)	H 1232 ALU	12x32x6	94 88 471232
	Cone with Radius End L (KEL)	L 1230 ALU	12x30x6	94 88 481230

For MOST burrs we recommend high-speed grinders.  
 Electric grinders – see RYWAL-RHC polish catalogue page 501.  
 Pneumatic grinding machines, see RYWAL-RHC polish catalogue page 501.  
 Caution! Follow the recommended rotation speeds of grinding tools in use.

## ▼ 19. BELT GRINDERS



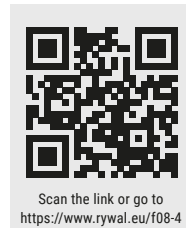
### MOST stationary belt grinders: JSG 75, JSG 150

Professional stationary belt grinders for grinding on endless belts (made of coated abrasive cloth) and polishing. Perfect for rough grinding, edge finishing, peripheral grinding of carbon steel, stainless steel, wood and plastics.



**Features:**

- Robust three-phased motor of 3 kW (JSG 75) or 4 kW (JSG 150) power consumption.
- Fast and simple grinding belt changing.
- Access to grind flat surfaces using the entire length of the belt.
- Two speeds of grinding belt what makes it suitable for working with non-woven and coated abrasive.
- Possible to connect the extraction system.



Grinding on contact wheel



Grinding on graphit pad

Type	JSG 75	JSG 150
Power consumption [kW]	3	4
Rotation Speed [rpm.]	1500/3000	1500/3000
Belt dimensions [mm]	75x2000	150x2000
Weight [kg]	72	95
Catalogue No.	94 56 000001	94 56 000002

For belt grinders MOST we recommend to use endless abrasive belts MOST - see page 308.

## ▼ 20. LOW-VIBRATION PNEUMATIC TOOLS



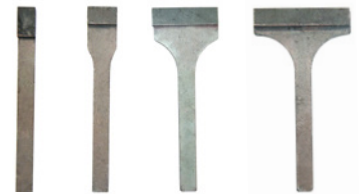
More power - less vibration!

### Low-vibration chisel scaler MOST HRV-95A



**Accessories:**

- Carbide chisels for HRV-95A (blade width in mm):
- 10 mm (94 72 101010),
  - 17 mm (94 72 101017),
  - 36 mm (94 72 101036),
  - 53 mm (94 72 101053).



- Advanced impact device with vibration reduction system and with a very low vibration level during work.
- This patented vibration reduction system makes the user less stressed, tired and less exposes the worker to noise and vibration.
- Designed to slag removal and stress relieving welds, removal of coatings, corrosion and other accumulated materials, cleaning mixers, formwork and machinery, etc.
- The low level of generated vibrations and the relatively short chisels stroke additionally improve the precision of the device.
- Standard version of device do not include the chisels.

Type	Length [mm]	Mass [kg]	Vibration level* [m/s <sup>2</sup> ]	Noise level [dB]	Frequency [Hz]	Stroke length [mm]	Max. total airflow [l/min]	Air pressure [bar]	Hose coupling [inches]	Recomm ended hose [inches]	Catalogue No.
HRV-95A	210	1,45	<3,5	79	150	6	90	6,5-7	1/4	1/4	94 72 100101

\*In accordance with EN ISO 28927-9

### Low-vibration needle scaler MOST SNV-18



**Accessories:**

Needles Ø3,2 mm:

- Standard equipment: set of 18 needles - 127 mm long (94 72 101718).
- Optional equipment: set of 18 needles - 140 mm long (94 72 101618).

- Impact, low-vibration needle scaler device for cleaning surfaces, slag removal and stress relieving welds, removal of coatings, corrosion and other accumulated materials, etc.
- The patented vibration reducing system makes the user less stressed, tired and less exposes the worker to noise and vibration.
- Easy and quick needle exchange.
- Standard device includes a set of 18 needles in length of 127 mm.
- Possibility to use needles in length of 140 mm.

Type	Length [mm]	Mass [kg]	Vibration level* [m/s <sup>2</sup> ]	Noise level [dB]	Frequency [Hz]	Max. total airflow [l/min]	Air pressure [bar]	Hose coupling [inches]	Recomm ended hose diameter [mm]	Catalogue No.
SNV-18	195	1,65	3,1	89	115	90	6,5-7	1/4	10	94 72 100110

\*In accordance with EN ISO 28927-9



## Low-vibration needle scaler MOST PNV-19

**Accessories:**

Ø3,2 mm needles:

- Standard equipment: set of 19 needles - 140 mm long (94 72 101619),
- Optional equipment: set of 19 needles - 178 mm long (94 72 101519).



- Low-vibration impact needle scaler devices for cleaning of surfaces, slag removal and stress relieving welds, removal of coatings, corrosion and other accumulated materials, etc.
- This patented vibration reducing system makes the user less stressed, tired and less exposes the worker to noise and vibration.
- High power and exceptional efficiency.
- Easy and quick needle exchange.
- Standard device includes a set of 19 needles in length of 140 mm.
- Possibility to use needles in length of 178 mm.

Type	Length [mm]	Mass [kg]	Vibration level* [m/s <sup>2</sup> ]	Noise level [dB]	Frequency [Hz]	Max. total airflow [l/min]	Air pressure [bar]	Hose coupling [inches]	Recommended hose diameter [mm]	Catalogue No.
PNV-19	272	2,4	<3,7	90	110	110	6,5-7	1/4	10	94 72 100111

\*In accordance with EN ISO 28927-9

## Air Engraver pen MOST EP-100

**Accessories:**

- Standard equipment: needle from tungsten carbide (94 72 910101).



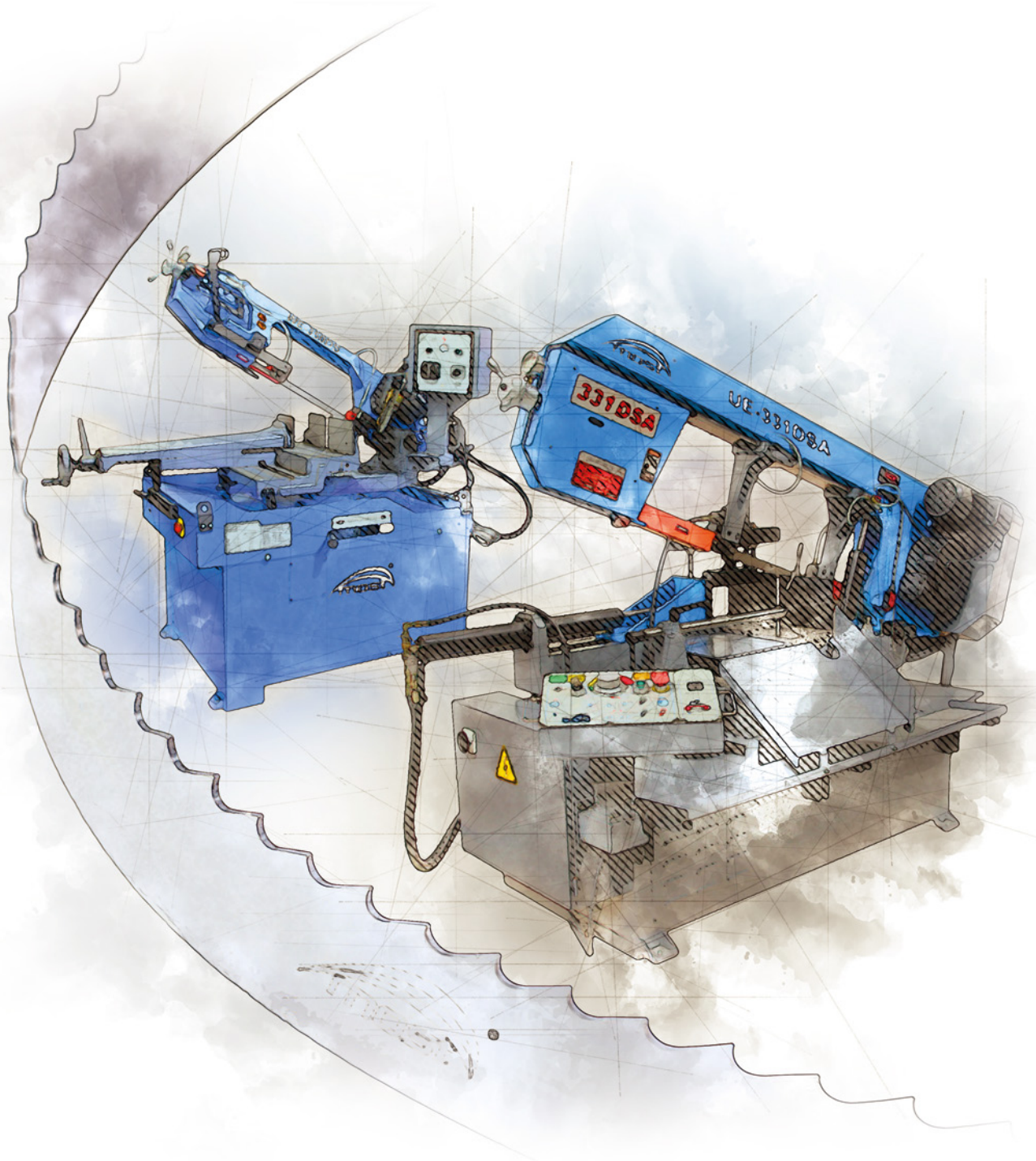
- Light-weight pneumatic marker with very low vibration level generation.
- This patented vibration reducing system enables faster, all-day fatigue-free work and provides excellent tool control.
- The perfect tool for marking and engraving in black, alloyed and hardened steel, titanium, glass, stone, plastic and wood.
- Low noise level and air consumption.
- A simple exchange of needle from tungsten carbide.

Type	Length [mm]	Mass [kg]	Vibration level* [m/s <sup>2</sup> ]	Noise level [dB]	Frequency [Hz]	Max. total airflow [l/min]	Air pressure [bar]	Hose coupling [inches]	Recommended hose diameter [mm]	Catalogue No.
EP-100	132	0,16	≤ 2,0	65	350	0,6	6-6,5	1/4	6	94 72 100120

\*In accordance with EN ISO 28927-9



# 09



# BAND SAWING MACHINES AND BAND SAW BLADES

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## ▼ 1. BAND SAWING MACHINES

### ▼ 1.1. Workshop band saws



*Economical workshop equipment designed for low load support work.*

**Basic functions and properties:**





- Construction allowing for one-sided angled cutting.
- Downfit movement of cutting head controlled by hydraulic brake.
- Electric pump for the band lubrication and cooling (closed circuit liquid cooling system).
- Brush band-cleaning device.
- Model UE-712 C equipped with transport wheels for easy movement of the device.



MOST WE-210 SH



MOST UE-712 C

Model	Size of the cutting blade [mm]	Cutting blade speed [m/min]	Engine 3~ [kW]	Net weight [kg]	Catalogue No.	Cutting range [mm]			
						Cutting angle 			
MOST UE-712 C	2360x20x0,9	22/33/45/65	0,75	130	94 55 007120	0°	178	178	178x280
						+45°	110	110	180x110
MOST WE-210 SH	2111x20x0,9	45/90	0,75	156	94 55 002100	0°	170	170	210x95
						+45°	120	110	-
						+60°	70	60	-

RYWAL-RHC provides warranty and post-warranty service for band saw machines. The addresses of service points at the end of the catalogue.

Supporting equipment is required in addition to the band sawing machines:

- Band saw blades - see page 330.
- Coolmax MOST, coolant - see chapter 06, subsection 6.
- Conveyors and takeover rollers - see page 329.
- Eye protection - see chapter 04, subsection 2.

▼ 1.2. Semi-automatic band sawing machines with hydraulic brake



Stable equipment designed for production work under medium load.

**Basic functions and properties:**

- Regulation of the cutting head performed by a hydraulic choke.
- Two cutting blade speeds to cut stainless and carbon steel.
- Swivel head for high angle cutting accuracy on one side (SH version) or both sides (DS version).
- Built-in gauge to measure the tension of the cutting blade.
- Closed circuit liquid cooling system.
- Brush band-cleaning device.



MOST WE-260 SH



MOST WE-350 DS

We recommend the use of Coolmax MOST for band saws - see chapter 06, subsection 6.

Model	Size of the cutting blade [mm]	Cutting blade speed [m/min]	Engine 3~ [kW]	Net weight [kg]	Catalogue No.	Cutting range [mm]			
						Cutting angle - +	○	□	▭
MOST WE-260 SH	2460x27x0,9	36/72	1,1	216	94 55 002600	0°	227	220	260x110
						+45°	150	145	200x125
						+60°	90	85	-
MOST WE-275 DS	2460x27x0,9	36/72	1,1	315	94 55 002750	0°	227	220	260x110
						+45°	150	145	200x125
						+60°	90	85	-
						-45°	110	110	160x110
MOST WE-310 DS	2725x27x0,9	36/72	1,1	310	94 55 003100	0°	250	240	310x210
						+45°	200	180	200x140
						+60°	120	95	120x95
						-45°	150	150	170x90
MOST WE-350 DS	3160x27x0,9	34/68	1,5	360	94 55 003500	0°	270	260	350x220
						+45°	240	220	240x160
						+60°	160	150	-
						-45°	210	180	-



▼ 1.3. Semi-automatic hydraulic band saws



Stable equipment designed for heavy-duty production work.

**Basic functions and properties:**

- Hydraulic down / up positioning of the cutting head.
- Hydraulic quick-clamping vice with adjustable clamping force.
- Stepless regulation of cutting blade speed.
- High cutting accuracy at 0°, -45°, -60° on the left and right sides.
- Built-in gauge to measure the tension of the cutting blade.
- Brush band-cleaning device.



MOST UE-460 DSAE



MOST UE-331 DSA

We recommend the use of Coolmax MOST for band saws - see chapter 06, subsection 6.

Model	Size of the cutting blade [mm]	Cutting blade speed [m/min]	Engine 3~ [kW]	Net weight [kg]	Catalogue No.	Cutting range [mm]			
						Cutting angle -/+ °	○	□	▭
MOST UE-331 DSA	4180x34x1,1	26-80	2,20	850	94 55 003310	0°	331	320	510x260
						+/-45°	315	315	-
						+/-60°	215	195	-
MOST UE-460 DSAE	5330x41x1,3	26-80	3,70	1320	94 55 004604	0°	460	460	440x600
						+/-45°	445	410	-
						+/-60°	295	295	-
MOST UE-530 DSA	6240x41x1,3	20-85	5,6	1880	94 55 005300	0°	530	530	700x335
						+45°	490	435	500x300
						+60°	335	320	305x400
						-45°	480	435	480x300
						-60°	335	320	305x400



## ▼ 2. CONVEYORS FOR BAND SAWING MACHINES



- Universal roller table systems in width of 360 mm and adjustable height from 580-1030 mm.
- Suitable for most of small and medium sized band saw machines on the market.
- Recommended for MOST band saws WE-260SH, WE-275SH, WE-275DS, WE-310DS, WE-350DS.
- Available in 1 m and 2 m modules.
- Conveyors also available as single supports for cut material with a horizontal roll or two V-shaped rolls.



MOST HRS 52-1



MOST HRS 52V



MOST HRT 60-4



MOST HRT 60-7

Type	Roll width [mm]	Height [mm]	Maximum load [kg]	Number of rolls	Roller diameter [mm]	Weight [kg]	Length [mm]	Catalogue No.
MOST HRS 52-1	350	580-790	400	1	52	16	-	94 55 250001
MOST HRS 52V	220	580-790	400	2	52	17	-	94 55 250002
MOST HRT 60-4	360	580-1030	300	4	60	40	1030	94 55 250004
MOST HRT 60-7	360	580-1030	400	7	60	53	2030	94 55 250005

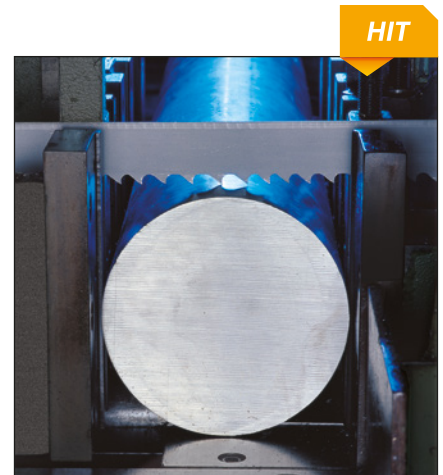
### ▼ 3. BAND SAW BLADES



#### MOST Multicut

- High efficient bimetal band saw blades.
- Universal, ideal for cutting carbon, stainless and alloyed steels as well as tool steel, etc.
- Tine tips made of M42 high speed steel ensure long service life of the saw.
- Specially developed tooth geometry prevents the tooth tips from tearing off.
- The shape of space between teeth ensures precise and accurate cutting.
- Precise teeth setting guarantees a smooth cut surface.
- A properly selected support body made of high-parameters steel gives the blade a high fatigue life.

Available dimensions and tooth pitch							
Width x thickness [mm]	Pitch (number of teeth per inch - TPI)						
	2/3	3/4	4/6	5/8	6/10	8/12	10/14
13x0,6					●	●	●
19x0,9			●	●	●	●	●
27x0,9		●	●	●	●	●	●
34x1,1	●	●	●	●	●	●	
41x1,3	●	●	●				



Bandsaw cutting  
(advice)

Scan the link or go to  
<https://www.rywal.eu/f09-3>

#### MOST M42

- Economical general purpose bimetallic saw blade.
- Designed for cutting a wide range of materials and different shapes.
- Variable tooth pitch provides less vibration during cutting.
- Cobalt high speed steel guarantees long blade life.

Available dimensions and tooth pitch							
Width x thickness [mm]	Pitch (number of teeth per inch - TPI)						
	2/3	3/4	4/6	5/8	6/10	8/12	10/14
20x0,9			●	●	●	●	●
27x0,9	●	●	●	●	●	●	●
34x1,1	●	●	●	●	●		
41x1,3	●	●	●	●			



To speed up the realization of orders, we launched our own welding point for band saw blades manufacture. Saw blades in width 20-41 mm are welded according to order and sent to customer within few days.

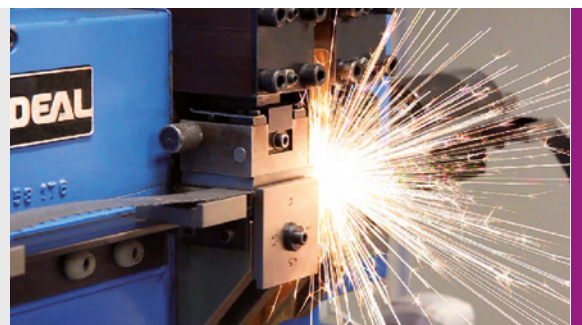
In order to quickly complete your order, we need:

- the name of the saw blade,
- parameters of the blade (length, width, thickness),
- pitch (number of teeth per inch),
- order quantity e.g. MOST M42, 3660 x 27 x 0.9 mm, 4/6 - 10 pieces.

In case you are not sure which band saw blade to use, our experienced staff will be happy to give you advice.

We just need:

- the name of the material to be cut (if possible, German DIN material number),
- material cross-section (for pipes cross-section and wall thickness),
- the shape of the material (round, pipe, section, etc.),
- surface description (quality and type: forged, rolled, cast, pulled),
- type of cut (single, layered or in sets with the number of layers or pieces as well as their configuration / size and shape of bars in set),
- size of band saw blade (length, width, thickness),
- machine type (for two-column machines, please also specify the inclination / angle of attack / saw bar).

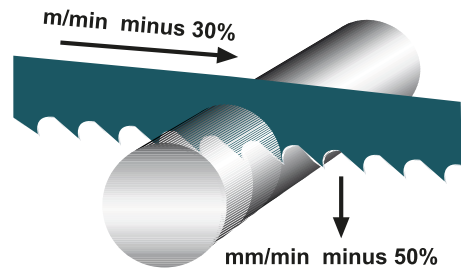


### Break-in of new band saw blade

The service life of the new saw blade depends mainly on the controlled break-in of blade.

We recommend the following actions:

- 1 step - select the appropriate cutting speed  $V_c$  (m/min) and cutting efficiency  $V_z$  (cm<sup>2</sup>/min) based on the cutting parameters presented in tables.
- 2 step - start with 70% of normal cutting speed and 50% of normal feed efficiency (see graphics opposite).
- 3 step - if there are still vibrations and noises, the cutting speed should be changed slightly again until they disappear. It is always important that you create the chips continuously.
- 4 step - after cutting approx. 400-600 cm<sup>2</sup> or after at least 15 minutes of effective cutting time for the pipes and profiles you can slowly reach normal cutting speed and then normal feed rate.

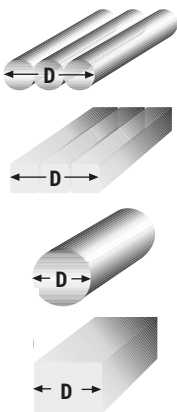


### Cooling liquids

The service life of band saw blades depends mainly on the correct concentration of the coolant (oil content in the coolant). In the case of emulsions, they must be controlled by means of a refractometer. We recommend a concentration of 8-12% for normal cutting (low and medium alloyed materials), 13-18% for high and very high alloyed steels and alloys.

### Selection of the tooth pitch (number of teeth per inch TPI) of the cutting blade

#### Solid materials



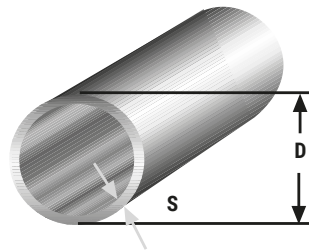
D = section (cutting channel)

Bimetallic band saw blades		Carbide band saw blades	
Variable pitch		Variable pitch	
Material cross-section	Teeth per inch - TPI	Material cross-section	Teeth per inch - TPI
up to 25 mm	10/14	50-120 mm	3/4
15-40 mm	8/12	100-250 mm	2/3
25-50 mm	6/10	150-400 mm	1,5/2
35-70 mm	5/8	350-600 mm	1,1/1,6
40-90 mm	5/6	>500 mm	0,85/1,5
50-120 mm	4/6	-	-
80-180 mm	3/4	-	-
130-350 mm	2/3	-	-
150-450 mm	1,5/2	-	-
200-600 mm	1,1/1,6	-	-
>500 mm	0,75/1,25	-	-

**Tips:**

- When cutting stainless steel and aluminium, we recommend choosing one pitch finer blade than that shown in the table.
- If material is heat treated or hardened (>1200 N/mm<sup>2</sup>), select one pitch coarser blade than shown in the table.

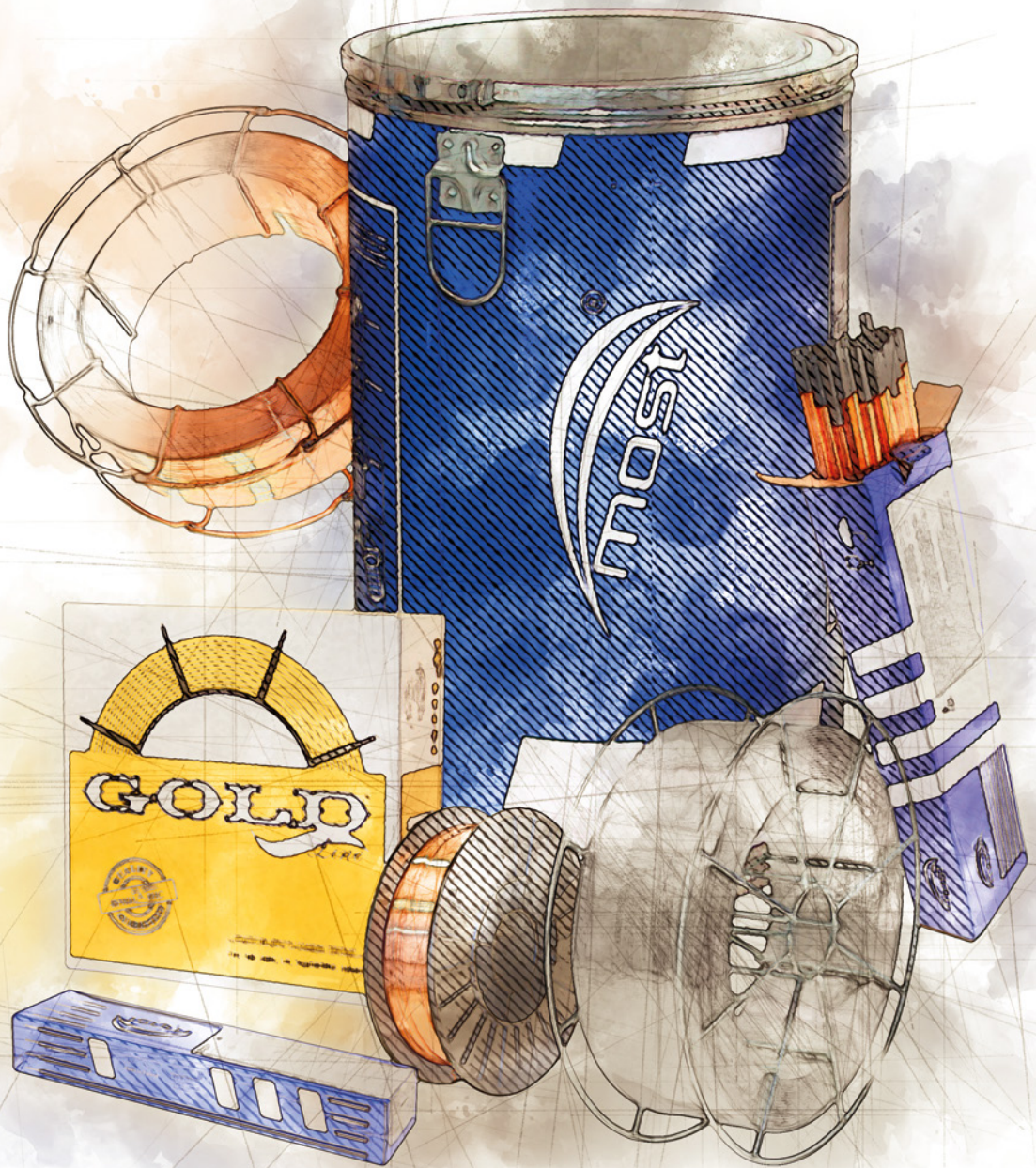
#### Pipes and profiles



Wall thickness S[mm]	Variable pitch of blade									
	External pipe diameter D [mm]									
	20	40	60	80	100	120	150	200	300	500
2	14	10/14	10/14	10/14	10/14	8/12	8/12	8/12	8/12	5/8
3	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10	5/8
4	10/14	10/14	8/12	8/12	8/12	6/10	5/8	5/8	5/8	4/6
5	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6	4/6	4/6
6	10/14	8/12	8/12	6/10	6/10	5/8	4/6	4/6	4/6	4/6
8	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6	4/6	4/6
10		8/12	6/10	5/8	4/6	4/6	4/6	4/6	4/6	4/5
12		8/12	6/10	4/6	4/6	4/6	4/6	4/6	4/6	4/5
15		8/12	6/10	4/6	4/6	4/6	4/6	4/5	4/5	4/5
20			4/6	4/6	4/6	4/6	4/6	4/5	4/5	3/4
30				4/6	4/6	4/5	4/5	4/5	4/5	2/3
50							4/5	3/4	2/3	2/3
80								3/4	2/3	2/3
>100									2/3	1,5/2



# 10



# WELDING CONSUMABLES

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# Introduction

In the thematic group „Welding consumables“ the following sub-groups were developed and published according to EN and standards:

- EN ISO 2560:2010 „Covered electrodes for manual metal arc welding of non-alloy and fine grain steels - Classification“.
- EN ISO 18275:2018 „Covered electrodes for manual metal arc welding of high-strength steels - Classification“.
- EN ISO 3580:2017 „Covered electrodes for manual metal arc welding of creep-resisting steels - Classification“.
- EN ISO 3581:2016 „Covered electrodes for manual metal arc welding of stainless and heat-resisting steels - Classification“.
- EN ISO 14341:2011 „Wire electrodes and weld deposits for gas shielded metal arc welding of non-alloy and fine grain steels - Classification“.
- EN ISO 16834:2012 „Wire electrodes, wires, rods and deposits for gas shielded arc welding of high strength steels. Classification“.
- EN ISO 21952:2012 „Wire electrodes, wires, rods and deposits for gas shielded arc welding of creep-resisting steels. Classification“.
- EN ISO 14343:2017 „Wire electrodes, strip electrodes, wires and rods for arc welding of stainless and heat resisting steels Classification“.
- EN ISO 17632:2016 „Tubular cored electrodes for gas shielded and non-gas shielded metal arc welding of non-alloy and fine grain steels - Classification“.
- EN ISO 18276:2017 „Tubular cored electrodes for gas-shielded and non-gas-shielded metal arc welding of high strength steels Classification“.
- EN ISO 17634:2015 „Tubular cored electrodes for gas shielded metal arc welding of creep-resisting steels. Classification“.
- EN ISO 17633:2018 „Tubular cored electrodes and rods for gas shielded and non-gas shielded metal arc welding of stainless and heat-resisting steels. Classification“.
- EN ISO 14174:2019 „Fluxes for submerged arc welding and electroslag welding. Classification“.
- EN ISO 26304:2018 „Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification“.
- EN ISO 14171:2016 „Solid wire electrodes, tubular cored electrodes and electrode/flux combinations for submerged arc welding of non-alloy and fine grain steels“.
- EN ISO 14175:2009 „Gases and gas mixtures for fusion welding and allied processes“.
- EN ISO 20378:2018 „Rods for gas welding of non-alloy and creep-resisting steels. Classification“.
- EN ISO 636:2017 „Rods, wires and deposits for tungsten inert gas welding of non-alloy and fine-grain steels. Classification“.
- EN ISO 1071:2016 „Covered electrodes, wires, rods and tubular cored electrodes for fusion welding of cast iron - Classification“.
- EN ISO 14172:2015 „Covered electrodes for manual metal arc welding of nickel and nickel alloys. Classification“.
- EN ISO 18273:2016 „Wire electrodes, wires and rods for welding of aluminium and aluminium alloys - Classification“.
- EN 14700:2014 „Welding consumables for hard-facing“.
- EN ISO 18274:2011 „Solid wire electrodes, solid strip electrodes, solid wires and solid rods for fusion welding of nickel and nickel alloys - Classification“.
- EN ISO 24034:2010 „Solid wire electrodes, solid wires and rods for fusion welding of titanium and titanium alloys - Classification“.
- EN ISO 24598:2019 „Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of creep-resisting steels. Classification“.
- EN ISO 24373:2018 „Solid wires and rods for fusion welding of copper and copper alloys. Classification“.
- EN ISO 26304:2018 „Solid wire electrodes, tubular cored electrodes and electrode-flux combinations for submerged arc welding of high strength steels - Classification“.
- EN ISO 544:2018-02 „Technical delivery conditions for filler materials and fluxes - Type of product, dimensions, tolerances and markings“.
- EN ISO 6947:2011 „Welding and allied processes. Welding positions“.

Welding consumables for hardfacing and regeneration, for which standard EN 14700 applies, are classified according to DIN 8555.

Recently introduced standards for welding consumables for steel: European (EN) and international (ISO) classification systems are mostly divided into two separate classification systems (A and B). This classification can be used together (i.e. A and B) or separately and this classification is the basis for determining the type and character of materials. Since the designations in each standard are identical for certain characteristics, their symbols and designations are presented below.

**SYSTEM „A” MARKINGS**

The designations according to the „A” system are based on the Euronorms (EN) that have been in force in Europe. These standards contain symbols and markings common to the entire collection:

- Symbols indicating material strength values (Table 1) system „A”.
- Symbols indicating the temperature at which the materials meet the minimum impact toughness 47 J (for classification system „A”) or 27 J for classification system „B”) (Table 2).
- Hydrogen content in deposited metal (in ml/100 g) (Table 3).
- Metal deposition symbols and welding current type (Table 4).
- Type of coating - designation given below (Table 5).
- Symbols identifying the product (filler material) or weld (joint) technology (Table 6).
- Welding positions (Table 7).
- Symbols for shielding gases (Table 8).

Symbol	Minimum yield point R <sub>e</sub> [N/mm <sup>2</sup> ]	Tensile strength R <sub>m</sub>	Minimum elongation A <sub>5</sub> [%]
35	355	440÷570	22
38	380	470÷600	20
42	420	500÷640	20
46	460	530÷680	20
50	500	560÷720	18
55	550	640÷820	18
62	620	700÷890	18
69	690	770÷940	17
79	790	880÷1080	16
89	890	940÷1180	15

**Table 1.** Symbols indicating the strength values - of materials

Symbol	Temperature for impact toughness requirements 47 J [°C]
Z	No requirements
A lub Y(1)	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60
7	-70
8	-80
9	-90
10	-100

NOTE 1: The designation „Y” appears in the classification „B”.

**Table 2.** Symbols indicating the temperature at which the samples impact toughness

Symbol	Hydrogen content [ml/100 g]
H5	5
H10	10
H15	15

**Table 3.** Hydrogen content in the

Symbol	Deposition rate [%]	Type of current
1	<105	alternating and direct
2	<105	direct
3	105÷125	alternating and direct
4	105÷125	direct
5	125÷160	alternating and direct
6	125÷160	direct
7	>160	alternating and direct
8	>160	direct

**Table 4.** Deposition efficiency symbols and welding current type

Symbol	Coating
A	acid coating
R	rutile coating
RC	rutile cellulose coating
RB	rutile-basic coating
C	cellulose coating
RR	thick rutile coating
RA	rutile-acid coating
B	basic coating

**Table 5.** Type of coating

Symbol	Characteristics
E	welding with coated electrode - coated electrode
G	MIG/MAG welding - solid wire for MIG/MAG welding
T	cored wire welding - flux-cored wire
W	TIG welding - wires for TIG welding
S	Submerged Arc Welding - Solid wire for welding
B	Submerged Arc Welding or Electroslag Welding with Band Electrode
P	plasma welding
L	laser welding
R	cast bar (cast iron welding consumables)
SS	solid wire for welding of stainless and heat-resistant steels used in various welding methods

**Table 6.** Symbols identifying the product (filler material) or weld (joint) technology

Symbol	Welding position
1	PA, PB, PC, PD, PE, PF and PG
2	PA, PB, PC, PD, PE and PF
3	PA and PB
4	PA
5	PA, PB and PG

- 1G/1F/PA Position (Flat)
- 2F/PB Position (Horizontal)
- 2G/PC Position (Horizontal)
- 4F/PD Position (Overhead)
- 4G/PE Position (Overhead)
- 3G Uphill/PF Position (Vertical)
- 3G Downhill/PG Position (Vertical)

**Table 7.** Welding positions

Symbol	Type of gas
J	inert gas (argon or helium - mixtures of these
M	gas mixture (Ar + 15÷25% CO <sub>2</sub> )
C	carbon dioxide (100% CO <sub>2</sub> )
A	mixture (argon + 1÷5% O <sub>2</sub> )
N	without gas shield (self shielding wire)
G	composition of the mixture established with the manufacturer

**Table 8.** Symbols of shielding gases

## SYSTEM „B” MARKINGS

The „B” system designations are based on AWS (American Welding Society) standards. The main change in relation to the American standards is the specification of strength properties of the deposited metal in MPa. AWS standards are used in the USA and Far East countries. Tensile strength ( $R_m$ ) is given as the strength properties - in the system „A” yield point ( $R_e$ ).

### 1. Symbols of material strength according to „B” system (Table 9).

Symbol	Minimum yield point $R_e$ [N/mm <sup>2</sup> ]	Tensile strength $R_m$	Minimum elongation $A_5$ [%]
43x	330	430÷600	20
49x	400	490÷660	20
55x	470	550÷700	18
62x	540	620÷760	15
69x	670	690÷830	14

NOTE: An „X” can mean:  
 A - raw state of metal deposition  
 P - state of metal deposition after heat treatment  
 AP - classification of metal deposition in both states  
**Table 9.** Symbols of material strength properties „B” system

### 2. Welding positions:

Symbol „O” – PA and PB

Symbol „1” – PA, PB, PC, PD, PE, PE, PF and PG

Because in the catalogs of various manufacturers, the values of strength properties ( $R_e$  and  $R_m$ ) are given in megapascals [MPa] or in newtons per mm<sup>2</sup> [N/mm<sup>2</sup>] to unify the designations in this catalog. Are assumed N/mm<sup>2</sup> designations. The numerical values for both markings are identical. In this chapter universal markings of welding positions and welding & polarity currents are used.

Symbol	Welding current and polarity	Symbol	Welding current and polarity
	direct - plus to the electrode		direct - minus to electrode or alternating
	direct - minus to the electrode		direct or alternating
	alternating		alternating or direct - plus to the electrode
	direct - plus to electrode or alternating		alternating or direct - minus to the electrode

**Table 10.** Welding current and polarity markings

Symbol	Welding position	Symbol	Welding position
	all		all positions, except vertical up and vertical down
	all in vertical position from top downwards only fillet weld		downhand, horizontal and vertical up
	all except vertical downward		horizontal
	downhand, horizontal and vertical up		downhand, horizontal and vertical down
	downhand, horizontal		downhand, horizontal, vertical and overhead
	downhand		downhand, vertical and vertical down
	vertical downward		downhand, vertical, overhead and vertical up
	downhand, horizontal, and vertical		downhand, vertical and vertical down
	vertical up and vertical down		all positions, except vertical down to up
	vertical up		downhand and vertical
	all positions, except overhead		downhand, vertical and vertical upward

**Table 11.** Welding position markings

In this chapter a number of symbols and abbreviations is used:

Symbol	Description	Symbol	Description
MAG	Metal Gas welding with wire in active gas environment	CCS	Chinese Classification Society
MIG	Metal Inert Gas welding with wire in noble gas environment	CE	CE declaration of Conformity
TIG	Gas tungsten arc welding with wire or rod in noble gas environment	CO	Controlas
AC	Alternating current	CR	CR Welding Services Ltd
DC	Direct current	CWB	Canadian Welding Bureau
Re	Yield Strength	DB	Deutsche Bahn
Rm	Tensile strength	DNV-GL	Det Norske Veritas - Germanischer Lloyd
A4, A5	Elongation	LR / LRS	Lloyds Register of Shipping
KV	Impact Properties ISO „V”	NAKS / HAKC	State Welding Control Agency Russia
HB	Hardness Brinella	PRS	Polish Register of Shipping
HV	Hardness Vickersa	RINA	Registro Italiano Navale
HRC	Hardness Rockwella	RMS / R.M.R.S.	Russian Marine Ship Register
FN	Ferrite number	SEPROS	Ukrainian UkrSEPRO Certificates
O.C.	Heat treatment	TÜV (-D)	Technischer Überwachungs Verein
ABS	American Bureau of Shipping	TÜV (-Ö)	Technischer Überwachungs Verein – Austria
AWS	American Welding Society	UDT	Office of Technical Inspection - Poland
BV	Bureau Veritas		

Table 12. Explanation of markings

The rules for marking of welding consumables in this catalogue are based on:

1. „Welding and hardfacing of metals” Józef Pilarczyk, Jan Pilarczyk; Published in Silesia 1996.
2. European standards included in Company Catalogues: ESAB, WDI and KOBELCO.
3. „Principles of selection of shielding gases and solid wires for welding of various metals and their alloys using the following methods MIG/MAG and TIG”, Poligaz, Gdansk 1997.
4. Engineer’s Guide - Welding, Volume I, WNT 2003 and Volume II WNT 2005.
5. Welding Calendars PIS 2008, 2009, 2010, 2011, 2012, 2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020.

Welding process parameters given in the catalogue are general guideline values and cannot be the basis for the development of detailed welding technologies. They only describe the ranges in which these parameters may be used in a given welding method. The selection of welding parameters is determined by many factors such as: length and type of arc, position, type of welding current, geometry of edge preparation, quality of surfaces of welded elements, etc. and therefore must be established each time depending on the conditions. In case of any doubts, please consult our representatives.

When welding, it is necessary to remember about the use of personal protective equipment and proper ventilation.

- See chapter 04 for welder protection.
- See section 05.2 for welding fume extraction and filtration equipment.



▼ **1. COATED ELECTRODES FOR MANUAL WELDING**  
 ▼ **1.1. Electrodes for welding of non-alloyed and fine-grained steel**

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST 6012</b>                      Universal electrode for welding of steel constructions, especially small-sized and thin-walled. Recommended for welding in forced positions including up-down. Used in devices with a low voltage of <math>U_0 &gt; 42</math> V.                      CE declaration of Conformity.                      Coating: rutile-cellulose.</p>	EN ISO 2560-A: E 38 0 RC 11 AWS A5.1: E 6013			$R_e = 380$ N/mm <sup>2</sup> $R_m = 470-600$ N/mm <sup>2</sup> $A_5 = 20\%$ $KV = 47$ J (0 °C)	C=0,08; Si=0,30; Mn=0,50		2,0 mm: 06 30 6012xx 2,5 mm: 06 30 6012xx 3,25 mm: 06 30 6012xx 4,0 mm: 06 30 6012xx 5,0 mm: 06 30 6012xx
<p><b>MOST 6013</b>                      Universal medium-coated rutile electrode for welding of steel constructions exposed to static and dynamic loads (steel or building construction, rolling stock). Recommended for assembly work. It has very good welding properties.                      CE declaration of Conformity.                      Coating: rutile-cellulose.</p>	EN ISO 2560-A: E 38 0 RC 11 AWS A5.1: E 6013			$R_e = 360$ N/mm <sup>2</sup> $R_m = 440-570$ N/mm <sup>2</sup> $A_5 = 22\%$ $KV = 47$ J (0 °C)	C=0,08; Si=0,20; Mn=0,50	ABS, LRS	2,5 mm: 06 30 6013xx 3,25 mm: 06 30 6013xx 4,0 mm: 06 30 6013xx 5,0 mm: 06 30 6013xx
<p><b>MOST 346 (6020)</b>                      Coarse-coated rutile-acid electrode for welding of high resistant steel, welding of boilers, tanks, pipelines.                      CE declaration of Conformity.                      Coating: rutile-acidic.</p>	EN ISO 2560-A: E 38 2 RA 13 AWS A5.1: E 6020			$R_e = 380$ N/mm <sup>2</sup> $R_m = 470-600$ N/mm <sup>2</sup> $A_5 = 20\%$ $KV = 47$ J (0 °C)	C=0,08; Si=0,20; Mn=0,60		2,0 mm: 06 30 6020xx 2,5 mm: 06 30 6020xx 3,25 mm: 06 30 6020xx 4,0 mm: 06 30 6020xx 5,0 mm: 06 30 6020xx
<p><b>MOST 246</b>                      Coarse-coated electrode for welding of carbon steel constructions exposed to static and dynamic load (ship constructions, rolling stock, machine building, etc.).                      Recommended for welding of containers and pipelines.                      CE declaration of Conformity.                      Coating: rutile-basic.</p>	EN ISO 2560-A: E 35 2 RB 12 AWS A5.1: E 7014			$R_e = 380$ N/mm <sup>2</sup> $R_m = 470-600$ N/mm <sup>2</sup> $A_5 = 20\%$ $KV = 47$ J (0 °C)	C=0,10; Si=0,20; Mn=0,50		2,0 mm: 06 30 6246xx 2,5 mm: 06 30 6246xx 3,25 mm: 06 30 6246xx 4,0 mm: 06 30 6246xx 5,0 mm: 06 30 6246xx
<p><b>MOST 7018</b>                      Electrode with very good parameters recommended for welding of carbon steels and high-resistant steels, especially in the shipbuilding industry, machine building, and rolling stock. It is recommended for welding constructions exposed to dynamic load.                      CE declaration of Conformity.                      Coating: basic.</p>	EN ISO 2560-A: E 42 4 B 42 H5 AWS A 5.1: E 7018			$R_e = 440$ N/mm <sup>2</sup> $R_m = 510-610$ N/mm <sup>2</sup> $A_5 = 20\%$ $KV > 47$ J (-40 °C)	C=0,08; Si=0,60; Mn=1,00		2,5 mm: 06 30 7018xx 3,25 mm: 06 30 7018xx 4,0 mm: 06 30 7018xx 5,0 mm: 06 30 7018xx
<p><b>MOST 7018 PREMIUM</b>                      Basic-coated electrode for making high quality welds. Extremely temperature resistant up to -50 °C. Efficiency: around 110%. Good weldability in all positions except vertical downwards. Low hydrogen content in the weld (according to AWS HD ≤ 4 ml/100 g). Electrodes for use in welding of steel constructions, boilers, containers, vehicles, ships and machines, also as a buffer layer in welding of high-carbon steels. Particularly suitable for welding of off-shore constructions.                      CE declaration of Conformity.                      Coating: basic.</p>	EN ISO 2560-A: E 42 5 B 42 H5 AWS A5.1: E 7018-1H4			$R_e = 460$ (≥420) N/mm <sup>2</sup> $R_m = 560$ (500-640) N/mm <sup>2</sup> $A_5 = 27\%$ (≥20) $KV > 190$ J (+20 °C) 160 J (-20 °C) 70 J (-50 °C)	C=0,08; Si=0,40; Mn=1,20	TÜV, DB, ABS, BV, DNV-GL, LR	2,5 mm: 06 30 7020xx 3,2 mm: 06 30 7020xx 4,0 mm: 06 30 7020xx





➤ **1.2. Coated electrodes for welding of high-alloy steels**  
 (\* material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST 308L-16</b> Electrode for welding of 18 Cr and 8 Ni high-alloy steels. CE declaration of Conformity. Coating: rutile.	EN ISO 3581-A: E 19 L R 12 AWS A5.4: E 308 L-16 Werkstoff nr. 1.4316			R <sub>e</sub> > 360 N/mm <sup>2</sup> R <sub>m</sub> > 540-610 N/mm <sup>2</sup> A <sub>5</sub> > 32% KV > 80 J (20°C)	C < 0,03; Si < 0,90; Ni = 9-11; Mn = 0,90; Cr = 18-21; FN = ~80,0		2,0 mm: 07 20 3082xx 2,5 mm: 07 20 3083xx 3,2 mm: 07 20 3083xx 4,0 mm: 07 20 3084xx
<b>MOST INOX 347 B*</b> Electrodes with Nb or Ti content for welding of high-alloy steels. Coating: rutile.	EN ISO 3581-A: E 19 ND R 22 AWS A5.4: E 347 15 Werkstoff nr. 1.4551			R <sub>e</sub> > 350 N/mm <sup>2</sup> R <sub>m</sub> > 550-610 N/mm <sup>2</sup> A <sub>5</sub> > 30% KV > 60 J (20°C)	C < 0,03; Si < 0,90; Ni = 9-11; Mn = 0,80; Cr = 18-21; Nb = 0,30; FN = 8,0		2,5 mm: 07 20 3472xx 3,2 mm: 07 20 3473xx 4,0 mm: 07 20 3474xx
<b>MOST 316L-16</b> Electrode with Mo content for welding of high-alloy steels in grade 18 Cr, 8 Ni, 3 Mo. CE declaration of Conformity. Coating: rutile.	EN ISO 3581-A: E 19 12 3 L R 12 AWS A5.4: E 316 L - 16 Werkstoff nr. 1.4430			R <sub>e</sub> > 400 N/mm <sup>2</sup> R <sub>m</sub> > 560-650 N/mm <sup>2</sup> A <sub>5</sub> > 32% KV > 70 J (20°C)	C < 0,03; Si < 0,90; Ni = 11-13; Mn = 0,85; Cr = 18-20; Mo = 2,5-3,0; FN = 8,0		2,0 mm: 07 20 3162xx 2,5 mm: 07 20 3162xx 3,2 mm: 07 20 3163xx 4,0 mm: 07 20 3164xx
<b>MOST 310-15*</b> Electrode for welding heat-resistant steels (1150°C) in grade 310. Coating: basic.	EN ISO 3581-A: E 25 20 B 22 AWS A5.4: E 310 - 15 Werkstoff nr. 1.4842			R <sub>e</sub> > 400 N/mm <sup>2</sup> R <sub>m</sub> > 550 N/mm <sup>2</sup> A <sub>5</sub> > 30% KV > 70 J (20°C)	C < 0,10; Si < 0,50; Ni = 19-21; Mn = 2,50; Cr = 24-26		2,0 mm 2,5 mm 3,2 mm 4,0 mm
<b>MOST 312-17*</b> Special-purpose electrode for hard-to-weld steels and joints of dissimilar steels. Coating: rutile.	EN ISO 3581-A: E 29 9 R 32 AWS A5.4: E 312 - 17 Werkstoff nr. 1.4337			R <sub>e</sub> > 500 N/mm <sup>2</sup> R <sub>m</sub> > 700-800 N/mm <sup>2</sup> A <sub>5</sub> > 20% Hardness: 240 HB	C < 0,10; Si = 0,9-1,20; Ni = 8-10; Mn = 1,0; Cr = 28-30; Mo = 0,50		2,0 mm 2,5 mm 3,2 mm 4,0 mm
<b>MOST 309L-16*</b> Low C-content electrode for welding of high-alloy steels in grade 309 and joints of dissimilar steels. Coating: rutile.	EN ISO 3581-A: E 23 12 L R 32 AWS A5.4: E 309 L - 16 Werkstoff nr. 1.4332			R <sub>e</sub> = 400 N/mm <sup>2</sup> R <sub>m</sub> = 550-660 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV > 60 J (20°C)	C < 0,03; Si < 0,80; Ni = 12-13; Mn = 1,0; Cr = 23-24; FN = 15,0		2,0 mm: 07 20 3092xx 2,5 mm: 07 20 3092xx 3,2 mm: 07 20 3093xx 4,0 mm: 07 20 3094xx
<b>MOST 309MoL-17*</b> Electrode for welding of high-alloy steels in grade 309 L and joints of dissimilar steels. It forms an austenitic filler metal. Coating: rutile.	EN ISO 3581-A: E 23 12 L R 32 AWS A5.4: E 309 L Mo - 17 Werkstoff nr. 1.4332			R <sub>e</sub> > 450 N/mm <sup>2</sup> R <sub>m</sub> = 580-680 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV > 60 J (20°C)	C < 0,03; Si = 0,80; Ni = 12-13; Mn = 0,9; Cr = 22-23; Mo = 2,3-3		2,0 mm 2,5 mm 3,2 mm 4,0 mm
<b>MOST 307-16*</b> High - efficient electrode (160%) for welding and hardfacing of high-alloy steels with increased Mn content. Coating: rutile.	EN ISO 3581-A: E 18 8 Mn R 12 AWS A5.4: E 307 - 16 Werkstoff nr. 1.4370			R <sub>e</sub> > 400 N/mm <sup>2</sup> R <sub>m</sub> = 600-690 N/mm <sup>2</sup> A <sub>5</sub> > 30% KV > 75 J (20°C)	C < 0,10; Si = 0,80; Ni = 8-10; Mn = 6,0; Cr = 19-21		2,5 mm 3,2 mm 4,0 mm
<b>MOST 307 B*</b> Electrodes for welding, hardfacing and regeneration of stainless steels with increased Mn content. Coating: basic.	EN ISO 3581-A: E 18 8 B 42 AWS A5.4: -E 307 - 15 Werkstoff nr. 1.4370			R <sub>e</sub> > 400 N/mm <sup>2</sup> R <sub>m</sub> = 600-750 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV > 90 J (20°C)	C < 0,1; Si = 0,40; Ni = 8-0; Mn = 6,0; Cr = 18,0		2,5 mm 3,2 mm 4,0 mm



1.3. Coated electrodes for hardfacing and regeneration

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST EL-HARD 300</b> Undercoat (buffer) layer during hardening of heavy components. Abrasive wear- and impact - resistant. Weld can be mechanically processed. Applications: rolls, rails, blades, wheels, bearing pivots, etc.</p>	DIN 8555: E 1-UM-300-P; EN 14700: EFe1-300-P			Hardness: 275-325 HB	C=0,20; Mn=1,50; Mo=0,60; V=0,20		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-HARD 350</b> Regeneration and hardfacing of components exposed to abrasive wear and impact. Crack-free, can be mechanically processed. Applications: road wheels, earth-working machines, the most common types of chain runners, chain guides, etc.</p>	DIN 8555: E 1-UM-350-P EN 14700: EFe1-350-P			Hardness: 350-400 HB	C=0,10; Mn=1,0; Cr=3,0		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-Mn/Cr</b> Electrode with high manganese and chromium content with increased resistance to abrasive wear and cavitation. Gets hardness under crushing. It can be used as a undercoat (buffer) layer for the hardening of elements exposed to stresses. Applications: mining, quarries (crushers), railway (turnouts and crossovers).</p>	DIN 8555: E 7-UM-200-500-KP EN 14700: EFe9-250-KNP			Hardness: 250 HB (after hardfacing) 55 HRC (after crushing)	C=0,70; Mn=17,0; Cr=14,0		2,5 mm 3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-HARD 600 K</b> The weld is resistant to abrasive wear and impact, Cannot be mechanically processed. Applications: ground-moving machines, steel and forging industry, gear wheels teeth, breakers, crusher jaws, etc.</p>	DIN 8555: E 6-UM-60 EN 14700: EFe8-60-P			Hardness: 58-61 HRC	C=0,50; Mn=0,40; Cr=9,0; Mo=1,0; V=1,50		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST 600</b> Universal electrode designed for welding of machine elements exposed to abrasive wear in combination with impact. High-carbon and susceptible to cracking materials should be heated up to 200-300°C depending on the chemical composition and size of the hardened element. When materials made of manganese steel and susceptible to cracking, a undercoated layer form EI-4370 or EL-MnCr is recommended. The weld can be processed by grinding. Applications: ground moving machines, gear wheels teeth, crusher hammers, steel industry, forging, mining.</p>	DIN 8555: E 6-UM-60 EN 14700: EFe8			Hardness: 57-62 HRC	C=0,50; Cr=7,50		3,2 mm: 07 20 6003xx 4,0 mm: 07 20 6004xx 5,0 mm: 07 20 6005xx
<p><b>MOST EL-HARD 63</b> The weld with excellent abrasive wear resistance combined with resistance to moderate impact. Applications: crushing and abrasive equipment, concrete extruders, buoyant press slugs, plough blades, etc.</p>	DIN 8555: E 10-UM-60 GR EN 14700: EFe15-65-GTR			Hardness: 61-63 HRC	C=4,50; Cr=34,0		3,2 mm 4,0 mm 5,0 mm

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST EL-HARD 65</b> The weld resistant to mineral-abrasive wear and moderate impact. The weld contains not only chromium carbides but also inclusions in the form of Mo, Nb, W and V carbides, which increase abrasive wear resistance in high temperatures. Applications: valves, mixers, scrapers, conveyor and press screws, disc aerators, mineral crushers, etc.</p>	DIN 8555: E 10-UM-65 Z EN 14700: EFe 16-65-GTR			Hardness: 63-65 HRC 45 HRC (400°C)	C=4,50; Si=1,20; Cr=24,0; Mo=6,0; V=1,0; W=2,0; Nb=6,20		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-HARD 70</b> The weld resistant to extreme abrasive wear and moderate impact in high temperatures. The Boron content increases the abrasive wear resistance. Applications: rollers, chutes, crushers, sieves, screw conveyors, etc.</p>	DIN 8555: E 10-UM-70 GRZC EN 14700: EFe 15-70-GT2			Hardness: 66-67 HRC 60 HRC (600°C)	C=5,0; Cr=38,0; B=3,50		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-TUBE 60T</b> Cored electrode (tubular) for hardfacing of components exposed to extreme abrasive wear and impact. Maximum hardness obtained after the first layer Applications: crushers, mixers, sieves, pumps, screw conveyors, agricultural machinery, etc.</p>	EN 14700: E/ T Fe 15-65-GT2			Hardness: 62-64 HRC	C=5,50; Mn=1,50; Cr=40,0		6,0 mm
<p><b>MOST Lastek 211</b> A high-efficient electrode with sintered carbide core in a special coating, which guarantees very thin and smooth padding weld with exceptional resistance to abrasive wear. Single electrode (Ø4,0 mm) will cover an area of approx. 10,000 mm² with continuous hardfacing work during about 6 minutes. Applications: screw conveyors, mixer blades, plough blades, cement industry and mining etc.</p>							3,0 mm 4,0 mm
<p><b>MOST EL-TOOL 50</b> Hardfacing and regeneration of hot-working tools. The weld can be mechanically processed. Applications: forging dies, pressure molds, arbors, etc.</p>	DIN 8555: E 3-UM-50 T EN 14700: EFe 3-50-T			Hardness: 48-50 HRC after tempering 50-52 HRC	C=0,25; Mn=0,80; Cr=2,5,0; W=4,50; V=0		2,5 mm 3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-TOOL 54</b> The weld resistant to metal-to-metal abrasive wear mainly designed for regeneration of cold-working tools. Mechanically processed only by grinding. Applications: cutting edges, molds, etc.</p>	DIN 8555: E 2-UM-55 EN 14700: EFe 3-55-T			Hardness: 55 HRC	C=0,40; Cr=7,50; Si=0,40; Mo=2,50; Mn=1,40		3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-TOOL 60</b> The weld resistant to metal-to-metal abrasive wear combined with impact. Regeneration and hardfacing of fast-cutting steels. Applications: cutting tools, scrapers, punches, moulds, extruders, extrusion molds, knives, cutters, profiles, wood working tools., etc.</p>	DIN 8555: E 4-UM-60 T EN 14700: EFe 4-60-ST			Hardness: 59-62 HRC after tempering 59-62 HRC	C=0,90; Cr=4,50; Mo=8,0; V=1,50; W=2,0		2,5 mm 3,2 mm 4,0 mm 5,0 mm



## Coated electrodes for hardfacing and regeneration

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST EL-Ni Alloy Co</b> Hardfacing and regeneration of cold-working and hot-working tools. Hardening after crushing. Efficiency: 170%. Applications: forging dies, knives, pump seals, hot cutting and punching tools, etc.</p>	<p>DIN 8555: E 23-UM-250 ENKPTZ EN 14700: E23-250-CKNPTZ</p>			<p>Hardness: 220 HB after hardening 400 HB</p>	<p>C=0,06; Cr=16,50; W=4,50; Mo=17,0; Fe=7,0; Co=2,50; Ni=rest</p>		<p>2,5 mm 3,2 mm 4,0 mm 5,0 mm</p>
<p><b>MOST EL-Co 1</b> Cobalt-based electrode. The weld is resistant to extreme abrasive metal-to-metal wear up to 950°C. Applications: cups, shafts, pumps, rollers, cutting blades, etc.</p>	<p>DIN 8555: E 20-UM-55 CTZ EN 14700: ECo 2-55-CSTZ</p>			<p>Hardness: 53-58 HRC (20°C) 42-45 HRC (600°C)</p>	<p>C=2,50; Si=1,0; Ni=max 2,50; Fe=max 2,50; Mn=1,0; Cr=33,0; W=12,0; Co=rest</p>		<p>3,2 mm 4,0 mm 5,0 mm</p>
<p><b>MOST EL-Co 6</b> Cobalt-based electrode. The weld is resistant to extreme abrasive metal-to-metal wear and pressures up to 950°C. Very good resistance to thermal and mechanical shocks. Applications: hot-cutting blades, rollers, industrial fittings, engine valves, hot-working tools, etc.</p>	<p>DIN 8555: E 20-UM-45 CRTZ EN 14700: ECo 2-40-CTZ</p>			<p>Hardness: 40-45 HRC (20°C) 30 HRC (600°C)</p>	<p>C=1,10; Si=1,0; Ni=max 3,0; Fe=max 2,50; Mn=1,0; Cr=28,0; W=5,0; Co=rest</p>		<p>2,5 mm 3,2 mm 4,0 mm 5,0 mm</p>
<p><b>MOST EL-Co 12</b> Cobalt-based electrode. The weld is resistant to extreme abrasive wear up to 950°C. Applications: extruder dies, saw blades, guides, etc.</p>	<p>DIN 8555: E 20-UM-50 CTZ EN 14700: ECo 2-50-CTZ</p>			<p>Hardness: 49-51 HRC (20°C) 38-40 HRC (600°C)</p>	<p>C=1,80; Si=1,0; Ni=max 2,50; Fe=max 2,50; Mn=1,0; Cr=29,0; W=9,0; Co=rest</p>		<p>3,2 mm 4,0 mm 5,0 mm</p>
<p><b>MOST EL-Co 21</b> Cobalt-based electrode. The weld is resistant to extreme abrasive metal-to-metal wear and pressures up to 950°C. Hardening by crushing. Applications: forging and hot and cold forming tools, gas turbine components, etc.</p>	<p>DIN 8555: E 20-UM-350 CKTZ EN 14700: ECo 2-300-CTZ</p>			<p>Hardness: 32-38 HRC (20°C) 38-40 HRC (600°C) 42-45 HRC (after crushing)</p>	<p>C=0,25; Si=1,0; Ni=2,50; Fe=max 3,0; Mn=1,0; Mo=5,50; Cr=27,0; Co=rest</p>		<p>3,2 mm 4,0 mm 5,0 mm</p>
<p><b>MOST EL-4370</b> Undercoat (buffer) layer before hardfacing or regeneration. Material for joints of dissimilar types of steel. The weld is resistant to corrosion and temperature up to 850°C.</p>	<p>DIN 8555: E 18 8 Mn R 26 EN ISO 3581-A: E 18 8 Mn R12</p>			<p>Hardened after crushing up to 350 HB. A<sub>5</sub>&gt;35%</p>	<p>C=0,10; Mn=6,0; Si=0,90; Cr=19,0; Ni=9,0</p>		<p>2,5 mm 3,2 mm 4,0 mm 5,0 mm</p>



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST EL-29/9</b> An electrode with austenitic-ferritic (duplex) structure designed for welding of high-carbon steels and steels with unknown chemical composition. Suitable for joints of dissimilar steels (stainless steels with low carbon steels) and hard to weld steels (tool steels, manganese steels, spring steels, etc.). The weld is characterized by excellent resistance to cracking and acids. It is used as buffer layer in hardening welding.</p>	DIN 8555: E 29 9 R 23 EN ISO 3581-A: E 29 9 R12			Hardened after crushing up to 430 HB. A <sub>5</sub> >20%	C<0,10; Mn=1,0; Si=0,90; Cr=29,0; Ni=9,0		2,0 mm 2,5 mm 3,2 mm 4,0 mm 5,0 mm
<p><b>MOST EL-Ni182</b> Electrode designed to repair and join nickel alloys. It is used for joining similar and dissimilar materials working in temperatures from -196°C to 550°C (e.g. stainless steel - low alloyed steel, stainless steel - nickel alloyed steel) and for welding of hard to weld steels. The weld is crack-resistant and resistant to acid-solutions, salts and hydroxides, molten salts in an oxidizing atmosphere and carburizing. Undercoat (buffer layer) during hardening welding. Applications: welding of heat-resistant plates in the cement industry, furnace elements, burners, moulds, tanks, storage and transport of liquid gases; chemical, petrochemical, glass and other industries.</p>	DIN 1736: E NiCr 16 FeMn AWS A5.1: E NiCrFe-3/mod			A <sub>5</sub> >35%	C<0,05; Mn=6,0; Si=0,60; Cr=16,0; Mo=1,0; Nb=2,0; Ni>65,0		2,5 mm 3,2 mm 4,0 mm 5,0 mm

➤ **1.4. Coated electrodes for welding cast iron**  
(\*material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST Cast Iron</b> Universal electrode with bimetal Ni-Fe core designed for cold welding of any type of cast iron and for joining cast iron with each other. It has excellent welding parameters, does not overheat during welding and does not require any welding interruption. CE declaration of Conformity.</p>	EN ISO 1071-A: E C NiFe-CI DIN 8573: E Ni Fe BG 1 AWS A-5.15: E Ni Fe-CI			R <sub>m</sub> =450 N/mm <sup>2</sup> Hardness: 160-190 HB	Ni=54,0; Fe=42,0		2,5 mm: 07 20 700xxx 3,2 mm: 07 20 700xxx 4,0 mm
<p><b>MOST FONTE Ni-2*</b> Nickel electrode for welding, regeneration and hardfacing of grey cast iron. Coating: basic.</p>	AWS A5.15: E Ni-CI EN ISO 1071: E C Ni-CI1			R <sub>m</sub> >300 N/mm <sup>2</sup> Hardness:~180 HB	C=1,0; Si<1,20; Fe<2,0; Ni>95,0		2,5 mm 3,2 mm 4,0 mm
<p><b>MOST Fe-Ni/Cu*</b> Electrode made of Ferro-Nickel alloy for welding, regeneration and hardfacing of all cast iron grades. Coating: basic.</p>	AWS A5.15: E NiFe-CI EN ISO 1071: E C NiFe-CI1			R <sub>m</sub> >400 N/mm <sup>2</sup> Hardness:~200 HB	C=1,0; Si=1,50; Fe=rest; Ni=53,0; Cu=6,0		2,5 mm 3,2 mm 4,0 mm





## Coated electrodes for welding cast iron

(\*material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST BIMETAL NiFe*</b> Electrode for welding, regeneration and hardfacing of cast iron. Coating: graphite-basic.	AWS A5.15: E NiFe-CI EN ISO 1071: E C NiFe-CI1			R <sub>e</sub> >300 N/mm <sup>2</sup> R <sub>m</sub> >450-550 N/mm <sup>2</sup> A <sub>5</sub> >15%, Hardness:~220 HB	C<1,0; Si<1,50; Fe=rest; Ni=55,0; Mn<1,0		2,5 mm 3,2 mm 4,0 mm
<b>MOST FONTE Fe*</b> Electrode for welding, regeneration and hardfacing of old and contaminated cast iron. Mechanical processing only by grinding.	AWS A5.15: ESt EN ISO 1071: E C Fe-13			Hardness:~350 HB	C<0,13; Si<0,90; Fe=rest; Mn=0,50		2,5 mm 3,2 mm 4,0 mm
<b>MOST FONTE - Ni*</b> Pure Ni electrode for welding, regeneration and hardfacing of cast iron. Coating: graphite-basic.	AWS A5.15: E Ni-CI EN ISO 1071: E C Ni-CI1			R <sub>e</sub> >200 N/mm <sup>2</sup> R <sub>m</sub> >300-400 N/mm <sup>2</sup> Hardness: 150 HB	C<1,0; Si<2,0; Fe<2,0; Ni=rest (95% min.); Mn<1,0		2,5 mm 3,2 mm 4,0 mm 5,0 mm
<b>MOST FERRO - Ni*</b> High-efficiency electrode made of Ferro-Nickel alloy for welding, regeneration and hardfacing of cast iron and joining of cast iron with steel. Coating: graphite-basic.	AWS A5.15: E NiFe-CI EN ISO 1071: E C NiFe-CI1			R <sub>e</sub> >300 N/mm <sup>2</sup> R <sub>m</sub> >450-550 N/mm <sup>2</sup> Hardness:~200 HB	C<1,0; Mn<1,0; Si<2,0; Ni=58-60; Fe=rest		2,5 mm 3,2 mm 4,0 mm 5,0 mm
<b>MOST Lastek 40E*</b> Nickel electrode designed for welding of grey and malleable cast iron. Enables welding of cast iron contaminated with oil and grease. The weld has excellent mechanical processing, free of pores and cracks. Applications: cold-welding of cast iron, broken engine blocks, pump housings, gears, valve clamping, etc.	DIN 8573: E Ni-BG 11 AWS A5.15: E Ni-CI			R <sub>m</sub> >320 N/mm <sup>2</sup> A <sub>5</sub> >18% Hardness: 130-160 HB			2,5 mm 3,2 mm 4,0 mm
<b>MOST Lastek 41E*</b> Ferro-Nickel cored electrode for welding of grey, ductile and alloyed cast iron. Due to the higher tensile strength and ductility than nickel electrode, can make satisfactory weld on heavy or highly stressed section. Applications: regeneration of grey and alloyed cast iron, machine bases, engine blocks, gears, cast iron tools, pumps, repairing of casting defects (good color match), etc.	DIN 8573: E NiFe-BG 11 AWS A5.15: E NiFe-CI			R <sub>m</sub> >400 N/mm <sup>2</sup> A <sub>5</sub> >120% Hardness: 150-180 HB			2,5 mm 3,2 mm 4,0 mm
<b>MOST Lastek 43*</b> An electrode developed to permit repair of "non-weldable" cast iron where the nickel electrode does not allow to obtain satisfactory results. It allows to make a smooth weld with excellent fusion even on oxidized cast iron. Due to the absorption of carbon from cast iron, the weld is hard and non-machinable. The electrode should be used in combination with the MOST Lastek 1900 electrode as a buffer layer before welding with MOST Lastek 40E/41E. Applications: engine blocks, oxidized furnace elements, defect repairs, undercoat (buffer) layers on poor quality cast iron, etc.	DIN 8573: E FeC-BG 11 AWS A5.15: ESt			R <sub>m</sub> >390			3,2 mm 4,0 mm



➤ **1.5. Coated electrodes for welding of nickel and nickel alloys**  
 (\*material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST EL-182 / MOST Ni 182*</b> Electrode for welding of nickel alloys, hard weldable steels and various types of joints. Coating: basic.	AMS A5.11: E NiCrFe-3 Werkstoff nr. 2.4620 EN ISO 14172: E-Ni 6182			R <sub>e</sub> >380 N/mm <sup>2</sup> R <sub>m</sub> >620 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >35% KV >80 J (20°C) 65 J (-196°C)	C<0,04; Si=0,40; Mn=6,0; Cr=16,5; Nb=2,0; Fe=6,0; Ni=rest (>60%)		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-190 / MOST Ni 190*</b> Electrode for welding, regeneration and hardfacing of monel Cu-Ni type alloys. High corrosion resistance. Coating: basic.	AMS A5.11: E NiCu-7 Werkstoff nr. 2.4366 EN ISO 14172: E-Ni 4060			R <sub>e</sub> >300 N/mm <sup>2</sup> R <sub>m</sub> >480 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >30% KV >80 J (20°C)	C<0,05; Si=0,70; Mn=3,20; Cu=29,0; Ti=0,50; Fe=1,20; Ni=rest (>60%)		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-C-276 / MOST Ni 276*</b> Electrode for welding Ni-based alloys and some special stainless steels. Coating: basic.	AMS A5.11: E NiCrMo-4 Werkstoff nr. 2.4887 EN ISO 14172: E-Ni 6276			R <sub>e</sub> >450 N/mm <sup>2</sup> R <sub>m</sub> >720 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >30% KV >70 J (20°C)	C<0,02; Si=0,20; Mn=0,60; Cr=16,5; Mo=16,0; Fe=5,0; Ni=rest; W=4,0		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-625 / MOST Ni 625*</b> Electrode for welding of corrosion-resistant nickel-based alloys. Coating: basic.	AMS A5.11: E NiCrMo-3 Werkstoff nr. 2.4631 EN ISO 14172: E-Ni 6625			R <sub>e</sub> >450 N/mm <sup>2</sup> R <sub>m</sub> >760 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >30% KV >70 J (20°C)	C<0,04; Si=0,40; Mn=0,60; Cr=22,0; Nb=3,40; Fe=3,0; Ni=rest; Mo=9,0		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-Ni Ti 3 / MOST Ni Ti 3*</b> Electrode with 2.5% Ti for welding of pure nickel. Coating: basic.	AMS A5.11: E Ni-1 Werkstoff nr. 2.4156 EN ISO 14172: E-Ni 2061			R <sub>e</sub> >300 N/mm <sup>2</sup> R <sub>m</sub> >430 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >28% KV >160 J (20°C) 130 J (-196°C)	C<0,03; Si=0,80; Mn=0,30; Al=0,30; Ti=2,20; Ni=rest (>94)		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-182 A / MOST B 90*</b> Inconel type electrode for welding and regeneration and hardfacing of Ni-based alloys. Coating: basic.	AMS A5.11: E NiCrFe-3 Werkstoff nr. 2.4807 EN ISO 14172: E-Ni 6182			R <sub>e</sub> >390 N/mm <sup>2</sup> R <sub>m</sub> >550 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >30% KV >60 J (20°C)	C<0,10; Si<0,50; Mn=7,8,5; Cr=15-16; Nb=1,5-2,5; Fe<10,0; Ni=rest (>60)		2,5 mm 3,2 mm 4,0 mm 5,0 mm
<b>MOST B 91*</b> Electrode for regeneration of nickel alloys type INCONEL 600, INCONEL 650 and others. Coating: rutile-basic.	AMS A5.11: E NiCrMo-3 EN ISO 14172: E-Ni 6625			R <sub>e</sub> >450 N/mm <sup>2</sup> R <sub>m</sub> >760 N/mm <sup>2</sup> A <sub>5</sub> <sup>+</sup> >30% Hardness: ~240 HB	C<0,04; Si=0,50; Mn=0,80; Cr=21,0; Nb=3,30; Fe=4,0; Ni=rest; Mo=8,50		2,5 mm 3,2 mm 4,0 mm



▼ **1.6. Coated electrodes for welding of copper and copper alloys**  
 (\*material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<b>MOST Cu 114*</b> Electrode for welding and hardfacing of copper alloys including tin bronzes. Coating: basic.	AWS A5.6: E Cu Sn-A DIN 1733: EL-Cu Sn7			Hardness:~100 HB	Sn=6,0; Mn=0,80; Cu=rest		2,5 mm 3,2 mm 4,0 mm
<b>MOST Cu 116*</b> Electrode for welding and regeneration of copper and aluminum bronze alloys. Coating: basic.	AWS A5.6: E CuAl-A2 DIN 1733: EL-CuAl9			R <sub>p</sub> >180 N/mm <sup>2</sup> R <sub>m</sub> >420 N/mm <sup>2</sup> A <sub>5</sub> >20% Hardness: 130 HB	Al=8,0; Fe=0,70; Mn=1,0; Cu=rest		2,5 mm 3,2 mm 4,0 mm
<b>MOST Cu 115*</b> Electrode for welding and hardfacing of copper alloys, including aluminum bronze and cast iron. Coating: basic.	AWS A5.6: E CuSn-C Werkstoff nr. 2.1025 DIN 1733: EL-CuSn7			R <sub>p</sub> >120 N/mm <sup>2</sup> R <sub>m</sub> >300 N/mm <sup>2</sup> A <sub>5</sub> >20% Hardness:~110 HB	Sn=7,0; Fe=0,15; Mn=0,90; P=0,10; Cu=rest		2,5 mm 3,2 mm 4,0 mm

▼ **1.7. Coated electrodes for welding aluminium and aluminium alloys**  
 (\* material outside the basic offer needs confirmation of availability and MOQ requirements)



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<b>MOST EL-AISI 5*</b> Electrode for the repair of castings made of aluminium alloys.	AWS A5.3: E 4043 EN ISO 18273: AISi5 (4032A)			R <sub>e</sub> >70-100 N/mm <sup>2</sup> R <sub>m</sub> >110-130 N/mm <sup>2</sup> A <sub>5</sub> >20% Hardness:~60 HB	Si=5,0; Mn<0,50; Fe<0,50; Al=rest		2,5 mm 3,2 mm 4,0 mm
<b>MOST EL-AISI 12*</b> Electrode for welding of castings made of aluminium alloys.	EN ISO 18273: AISi12 (4047A)			R <sub>e</sub> =80 N/mm <sup>2</sup> R <sub>m</sub> =200 N/mm <sup>2</sup> A <sub>5</sub> =8%	Si=12,0; Mn<0,50; Fe=0,50; Al=rest		2,5 mm 3,25 mm 4,0 mm 5,0 mm

▼ **2. WIRES AND RODS FOR MIG/MAG AND TIG WELDING**  
 ▼ **2.1. Wires and rods for welding non-alloyed and fine-grained steels**



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST SG2 ITS</b>                      Coppered, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. It allows to use high currents for spraying arc and low currents for short-circuit metal transfer.                      CE declaration of Conformity.                      Types of packaging: S200 - plastic spool, B300 - basket-metal spool, BS-300 - basket metal spool no adapter needed, drums.                      Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>.                      Welding method: MAG.</p>	EN ISO 1.4341-A: G4Z4M/C 3S11 AWS A5.18: ER70S-6 Werkstoff nr. 1.5125			Ar+20% CO <sub>2</sub> R <sub>e</sub> =490 N/mm <sup>2</sup> R <sub>m</sub> >590 N/mm <sup>2</sup> A <sub>5</sub> ≥25% KV≥100 J (0°C) 80 J (-20°C)	C=0,10; Si=0,90; Mn=1,50	TÜV, DB, DNV-GL, PRS,	0,8 mm: 11 60 170xxx 1,0 mm: 11 60 170xxx 1,2 mm: 11 60 170xxx 1,6 mm: 11 60 170xxx
<p><b>MOST SG2 ITS blank</b>                      Non-Coppered, Blank, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. It allows to use high currents for spraying arc and low currents for short-circuit metal transfer.                      CE declaration of Conformity.                      Types of packaging: S200 - plastic spool, B300 - basket-metal spool and drums.                      Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>.                      Welding method: MAG.</p>	EN ISO 1.4341-A: G4Z4M/C 3S11 AWS A5.18: ER70S-6 Werkstoff nr. 1.5125			Ar+20% CO <sub>2</sub> R <sub>e</sub> =490 N/mm <sup>2</sup> R <sub>m</sub> >590 N/mm <sup>2</sup> A <sub>5</sub> ≥25% KV≥100 J (0°C) 80 J (-20°C)	C=0,10; Si=0,90; Mn=1,50	TÜV, DB, DNV-GL, PRS,	0,8 mm: 11 69 170xxx 1,0 mm: 11 69 170xxx 1,2 mm: 11 69 170xxx 1,6 mm: 11 69 170xxx
<p><b>MOST SG3 ITM</b>                      Coppered, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. Compared to MOST SG2 wire has an increased content of Si-Mn components, which provides higher strength of weld metal and resistance to surface impurities. CE declaration of Conformity.                      Types of packaging: B300 - basket-metal spool or drums.                      Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>.                      Welding method: MAG.</p>	EN ISO 1.4341-A: G464M/C 4S11 AWS A5.18: ER70S-7 Werkstoff nr. 1.5130			Ar+20% CO <sub>2</sub> R <sub>e</sub> =450 N/mm <sup>2</sup> R <sub>m</sub> =560 N/mm <sup>2</sup> A <sub>5</sub> ≥28% KV≥80 J (-20°C)	C=0,10; Si=1,0; Mn=1,70	TÜV, DB, DNV-GL, PRS	0,8 mm: 11 60 280xxx 1,0 mm: 11 60 280xxx 1,2 mm: 11 60 280xxx 1,6 mm: 11 60 280xxx
<p><b>MOST SG3 ITM blank</b>                      Non-Coppered, Blank, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. Compared to MOST SG2 wire has an increased content of Si-Mn components, which provides higher strength of weld metal and resistance to surface impurities. CE declaration of Conformity.                      Types of packaging: B300 - basket-metal spool or drums.                      Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>.                      Welding method: MAG.</p>	EN ISO 1.4341-A: G464M/C 4S11 AWS A5.18: ER70S-7 Werkstoff nr. 1.5130			Ar+20% CO <sub>2</sub> R <sub>e</sub> =450 N/mm <sup>2</sup> R <sub>m</sub> =560 N/mm <sup>2</sup> A <sub>5</sub> ≥28% KV≥80 J (-20°C)	C=0,10; Si=1,0; Mn=1,70	TÜV, DB, DNV-GL, PRS	0,8 mm: 11 69 280xxx 1,0 mm: 11 69 280xxx 1,2 mm: 11 69 280xxx 1,6 mm: 11 69 280xxx



Wires and rods for welding non-alloyed and fine-grained steels

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>GOLD G3 Si1</b> Coppered, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. It allows to use high currents for spraying arc and low currents for short-circuit metal transfer. CE declaration of Conformity. Types of packaging: S200, S300 - plastic spool, B300 - basket-metal spool or drums, BS300 - basket spool no Adapter. Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>. Welding method: MAG.</p>	<p>EN ISO 14341-A: G424M/C 3Si1 AWS A5.18: ER70S-6 DIN 8559: SG2 Werkstoff nr. 1.5125</p>			<p>Ar+20% CO<sub>2</sub>; R<sub>e</sub>=490 N/mm<sup>2</sup> R<sub>m</sub>=590 N/mm<sup>2</sup> A<sub>5</sub>=25% KV=100 J (-10°C) 80 J (-20°C)</p>	<p>C=0,10; S=0,90; Mn=1,50; Cu coating</p>	<p>TÜV, DB, LR, ABS, NAKS, CWB, RMRS</p>	<p>0,6 mm: 11 50 17xxxx 0,8 mm: 11 50 17xxxx 1,0 mm: 11 50 17xxxx 1,2 mm: 11 50 17xxxx 1,6 mm: 11 50 17xxxx</p>
<p><b>GOLD G3 Si1 blank</b> Non-Coppered, blank, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. It allows to use high currents for spraying arc and low currents for short-circuit metal transfer. CE declaration of Conformity. Types of packaging: S200, S300 - plastic spool, B300 - basket-metal spool or drums. Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>. Welding method: MAG.</p>	<p>EN ISO 14341-A: G424 C1/M21 3Si1, AWS A5.18: ER 70 S-6</p>			<p>Ar+20% CO<sub>2</sub>; R<sub>e</sub>=460 N/mm<sup>2</sup> R<sub>m</sub>=560 N/mm<sup>2</sup> A<sub>5</sub>=30% KV=47 J (-40°C)</p>	<p>C=0,10; S=0,90; Mn=1,50; P=0,01 S=0,01</p>	<p>TÜV, DB</p>	<p>0,8 mm: 11 50 177xxx 1,0 mm: 11 50 177xxx 1,2 mm: 11 50 177xxx 1,6 mm: 11 50 177xxx</p>
<p><b>GOLD G4 Si1</b> Coppered, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. Compared to MOST SG2 wire has an increased content of Si-Mn components, which provides higher strength of metal and resistance to surface impurities. CE declaration of Conformity. Types of packaging: B300 - basket-metal spool or drums. Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>. Welding method: MAG.</p>	<p>EN ISO 14341-A: G462M/C 4Si1 AWS A5.18: ER70S-7 Werkstoff nr. 1.5130</p>			<p>Ar+20% CO<sub>2</sub>; R<sub>e</sub>=475 N/mm<sup>2</sup> R<sub>m</sub>=570 N/mm<sup>2</sup> A<sub>5</sub>=30% KV≥70 J (-40°C)</p>	<p>C=0,10; Si=1,0; Mn=1,70; Cu coating</p>	<p>TÜV, DB, RMRS</p>	<p>0,8 mm: 11 50 28xxxx 1,0 mm: 11 50 28xxxx 1,2 mm: 11 50 28xxxx 1,6 mm: 11 50 28xxxx</p>
<p><b>GOLD G4 Si1 blank</b> Non-Coppered, blank, manganese-silicium solid wire, designed for MAG welding of low-carbon construction steels, boiler, shipbuilding, as well as fine-grained carbon-manganese steels. Compared to MOST SG2 wire has an increased content of Si-Mn components, which provides higher strength of metal and resistance to surface impurities. CE declaration of Conformity. Types of packaging: B300 - basket-metal spool or drums. Shielding gas: CO<sub>2</sub>, Ar+CO<sub>2</sub>. Welding method: MAG.</p>	<p>EN ISO 14341-A: G424 C1 4Si1, EN ISO 14341-A: G464 M21 4Si1, AWS A5.18: ER 70 S-6</p>			<p>Ar+20% CO<sub>2</sub>; R<sub>e</sub>=450 N/mm<sup>2</sup> R<sub>m</sub>=560 N/mm<sup>2</sup> A<sub>5</sub>=28% KV≥80 J (-20°C)</p>	<p>C=0,10; Si=1,0; Mn=1,70; P=0,01 S=0,01</p>	<p>TÜV, DB</p>	<p>0,8 mm: 11 50 283xxx 1,0 mm: 11 50 283xxx 1,2 mm: 11 50 283xxx 1,6 mm: 11 50 283xxx</p>



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST W3 Si 1</b> Manganese-silicium solid rods for TIG welding of low-carbon construction steels. Rods are copper-coated. CE declaration of Conformity. Shielding gas: Ar. Welding method: TIG.</p>	EN ISO 1636-A: W 42 3W3Si1			$R_e=470$ N/mm <sup>2</sup> $R_m=560$ N/mm <sup>2</sup> $A_4=26\%$ KV=70 J (-30°C)	C=0,09; Si=0,90; Mn=1,50		1,6 mm: 11 61 170xxx 2,0 mm: 11 61 170xxx 2,4 mm: 11 61 170xxx 3,2 mm: 11 61 170xxx
<p><b>MOST W4 Si1</b> Manganese-silicium solid rods with increased Si-Mn content, providing higher strength of metal weld and resistance to surface impurities. For welding of low-carbon and low-alloy steels. CE declaration of Conformity. Shielding gas: Ar. Welding method: TIG.</p>	EN ISO 1636-A: W 46 3W4Si1			$R_e=530$ N/mm <sup>2</sup> $R_m=595$ N/mm <sup>2</sup> $A_5=26\%$ KV=70 J (-30°C)	C=0,10; Si=1,0; Mn=1,70		1,6 mm: 11 61 280xxx 2,0 mm: 11 61 280xxx 2,4 mm: 11 61 280xxx 3,2 mm: 11 61 280xxx



➤ 2.2. Welding wires and rods for high strength steels

Marking and description	Approvals	Classification	Diameter
<b>MOST NiMoCr</b>	DB, TÜV	AWS A5.28: ER 110 - S G EN ISO 16834-A: G 694MMn3NiCrMo	1,0 mm 1,2 mm

▼ **2.3. Welding wires and rods for welding of high resistant steels**  
 (\*material outside the basic offer needs confirmation of availability and MOQ requirements)

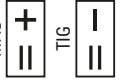
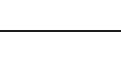

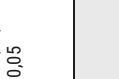









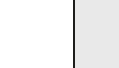



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<b>MOST CrMo 1*</b> Steels for high temperature operation. Shielding gas: Ar+CO <sub>2</sub> . Welding method: MAG.	EN ISO 21952-A: G CrMo1Si AWS A5.28: ER80S-G			Ar+CO <sub>2</sub> : R <sub>e</sub> >450 N/mm <sup>2</sup> R <sub>m</sub> >500 N/mm <sup>2</sup> A <sub>5</sub> >20%; KV>90 J (20°C)	C=0,10; Si=0,60; Mn=1,0; Mo=0,50; Cr=1,15		1,2 mm
<b>MOST CrMo 2*</b> Steels for high temperature operation. Shielding gas: Ar+CO <sub>2</sub> . Welding method: MAG.	EN ISO 21952-A: G CrMo2Si AWS A5.28: ER90S-G			Ar+CO <sub>2</sub> : R <sub>e</sub> >420 N/mm <sup>2</sup> R <sub>m</sub> >520 N/mm <sup>2</sup> A <sub>5</sub> >20%; KV>90 J (20°C)	C=0,06; Si=0,60; Mn=1,10; Mo=1,0; Cr=2,80		1,2 mm

▼ **2.4. Welding wires and rods for high-alloy steels**















Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST Inox MIG 307 Si / TIG 307 Si</b> CE declaration of Conformity. Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 18 8 (W 18 8) AWS A5.9: ER307Si Werkstoff nr. 1.4370	MAG TIG		R <sub>e</sub> >460 N/mm <sup>2</sup> R <sub>m</sub> >650 N/mm <sup>2</sup> A <sub>5</sub> >41% KV>140 J (20°C)	C=0,08; Si=0,90; Mn=7,0; Cr=18,0; Ni=8,0; Mo<0,50; Cu<0,10; N<0,06	TÜV	Wire diameters: 0,8 mm: 11 70 502xxx 1,0 mm: 11 70 502xxx 1,2 mm: 11 70 502xxx Rod diameters: 1,6 mm: 11 71 502xxx 2,0 mm: 11 71 502xxx 2,4 mm: 11 71 502xxx 3,2 mm: 11 71 502xxx
<b>MOST 307 Si</b> CE declaration of Conformity. Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 18 8 (W 18 8) AWS A5.9: ER307Si Werkstoff nr. 1.4370	MAG TIG		R <sub>e</sub> >460 N/mm <sup>2</sup> R <sub>m</sub> >650 N/mm <sup>2</sup> A <sub>5</sub> >41% KV>140 J (20°C)	C=0,08; Si=0,90; Mn=7,0; Cr=18,0; Ni=8,0; Mo<0,50; Cu<0,10; N<0,06	TÜV, DB	Wire diameters: 0,8 mm: 17 20 502xxx 1,0 mm: 17 20 502xxx 1,2 mm: 17 20 502xxx Rod diameters: 1,6 mm: 17 21 502xxx 2,0 mm: 17 21 502xxx 2,4 mm: 17 21 502xxx 3,2 mm: 17 21 502xxx


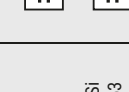

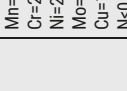
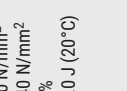




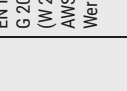
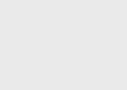

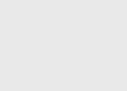
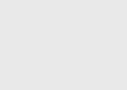

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST Inox MIG 308 L Si / TIG 308 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	EN ISO 14343: G 19 9 L Si (W 19 9 L Si) AWS A5.9: ER308LSi Werkstoff nr. 1.4316	MAG  TIG 		R <sub>e</sub> >390 N/mm <sup>2</sup> R <sub>m</sub> >600 N/mm <sup>2</sup> A <sub>5</sub> >34% KV>120 J (20°C)	C<0,025; Si=0,40; Mn=1,80; Cr=20,0; Ni=10,0; N<0,06	TÜV, DB	Wire diameters: 0,8 mm: 11 70 504xxx 1,0 mm: 11 70 504xxx 1,2 mm: 11 70 504xxx Rod diameters: 1,6 mm: 11 71 504xxx 2,0 mm: 11 71 504xxx 2,4 mm: 11 71 504xxx 3,2 mm: 11 71 504xxx
<p><b>MOST 308 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	EN ISO 14343: G 19 9 L Si (W 19 9 L Si) AWS A5.9: ER308LSi Werkstoff nr. 1.4316	MAG  TIG 		R <sub>e</sub> >390 N/mm <sup>2</sup> R <sub>m</sub> >600 N/mm <sup>2</sup> A <sub>5</sub> >34% KV>120 J (20°C)	C<0,025; Si=0,40; Mn=1,80; Cr=20,0; Ni=10,0; N<0,06	TÜV, DB	Wire diameters: 0,8 mm: 17 20 504xxx 1,0 mm: 17 20 504xxx 1,2 mm: 17 20 504xxx Rod diameters: 1,0 mm: 17 21 504xxx 1,2 mm: 17 21 504xxx 1,6 mm: 17 21 504xxx 2,0 mm: 17 21 504xxx 2,4 mm: 17 21 504xxx 3,2 mm: 17 21 504xxx
<p><b>MOST Inox MIG 309 L Si / TIG 309 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	EN ISO 14343: G 23 12 L Si (W 23 12 L Si) AWS A5.9: ER309LSi Werkstoff nr. 1.4332	MAG  TIG 		R <sub>e</sub> >410 N/mm <sup>2</sup> R <sub>m</sub> >600 N/mm <sup>2</sup> A <sub>5</sub> >41% KV>120 J (20°C)	C<0,025; Si=0,40; Mn=1,70; Cr=24,50; Ni=12,50; N<0,05		Wire diameters: 0,8 mm: 11 70 506xxx 1,0 mm: 11 70 506xxx 1,2 mm: 11 70 506xxx Rod diameters: 1,6 mm: 11 71 506xxx 2,0 mm: 11 71 506xxx 2,4 mm: 11 71 506xxx 3,2 mm: 11 71 506xxx
<p><b>MOST 309 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	EN ISO 14343: G 23 12 L Si (W 23 12 L Si) AWS A5.9: ER309LSi Werkstoff nr. 1.4332	MAG  TIG 		R <sub>e</sub> >410 N/mm <sup>2</sup> R <sub>m</sub> >600 N/mm <sup>2</sup> A <sub>5</sub> >41% KV>120 J (20°C)	C<0,025; Si=0,40; Mn=1,70; Cr=24,50; Ni=12,50; N<0,05	TÜV, DB	Wire diameters: 0,8 mm: 17 20 506xxx 1,0 mm: 17 20 506xxx 1,2 mm: 17 20 506xxx Rod diameters: 1,0 mm: 17 21 506xxx 1,2 mm: 17 21 506xxx 1,6 mm: 17 21 506xxx 2,0 mm: 17 21 506xxx 2,4 mm: 17 21 506xxx 3,2 mm: 17 21 506xxx
<p><b>MOST 310</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	EN ISO 14343: G 25 20 (W 25 20) AWS A5.9: ER 310 Werkstoff nr. 1.4842	MAG  TIG 		R <sub>e</sub> >390 N/mm <sup>2</sup> R <sub>m</sub> >590 N/mm <sup>2</sup> A <sub>5</sub> >43% KV>175 J (20°C)	C<0,12; Si=0,30; Mn=1,80; Cr=26,0; Ni=21,0; Mo<0,30; Cu<0,10; N<0,06		Wire diameters: 0,8 mm: 17 20 510xxx 1,0 mm: 17 20 510xxx 1,2 mm: 17 20 510xxx Rod diameters: 2,0 mm: 17 21 510xxx



### Welding wires and rods for high-alloy steels

(\* material outside the basic offer needs confirmation of availability and MOQ requirements)

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST Innox MIG 316 L Si / TIG 316 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	<p>EN ISO 14343:                      G 19 12 3 L Si                      (W 19 12 3 L Si)                      AWS A5.9: ER316LSi</p>	<p>MAG </p> <p>TIG </p>		<p>R<sub>e</sub> &gt;380 N/mm<sup>2</sup>                      R<sub>m</sub> &gt;500 N/mm<sup>2</sup>                      A<sub>5</sub> &gt;35%                      KV &gt;130 J (20°C)</p>	<p>C&lt;0,025;                      Si=0,90;                      Mn=1,80;                      Cr=18,50;                      Ni=12,0;                      Mo=2,60;                      Cu&lt;0,20</p>		<p>Wire diameters:                      0,8 mm: 11 70 512xxx                      1,0 mm: 11 70 512xxx                      1,2 mm: 11 70 512xxx                      Rod diameters:                      1,6 mm: 11 71 512xxx                      2,0 mm: 11 71 512xxx                      2,4 mm: 11 71 512xxx                      3,2 mm: 11 71 512xxx</p>
<p><b>MOST 316 L Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	<p>EN ISO 14343:                      G 19 12 3 L Si                      (W 19 12 3 L Si)                      AWS A5.9: ER316LSi</p>	<p>MAG </p> <p>TIG </p>		<p>R<sub>e</sub> &gt;380 N/mm<sup>2</sup>                      R<sub>m</sub> &gt;500 N/mm<sup>2</sup>                      A<sub>5</sub> &gt;35%                      KV &gt;130 J (20°C)</p>	<p>C&lt;0,025;                      Si=0,90;                      Mn=1,80;                      Cr=18,50;                      Ni=12,0;                      Mo=2,60;                      Cu&lt;0,20</p>		<p>Wire diameters:                      0,8 mm: 17 20 512xxx                      1,0 mm: 17 20 512xxx                      1,2 mm: 17 20 512xxx                      Rod diameters:                      1,0 mm: 17 21 512xxx                      1,2 mm: 17 21 512xxx                      1,6 mm: 17 21 512xxx                      2,0 mm: 17 21 512xxx                      2,4 mm: 17 21 512xxx                      3,2 mm: 17 21 512xxx</p>
<p><b>MOST 347 Si</b>                      CE declaration of Conformity.                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	<p>EN ISO 14343:                      G 19 9 Nb Si                      (W 19 9 Nb Si)                      AWS A5.9: ER347Si                      Werkstoff nr. 1.4551</p>	<p>MAG </p> <p>TIG </p>		<p>R<sub>e</sub> &gt;400 N/mm<sup>2</sup>                      R<sub>m</sub> &gt;610 N/mm<sup>2</sup>                      A<sub>5</sub> &gt;35%                      KV &gt;110 J (20°C)</p>	<p>C=0,04;                      Si=0,90;                      Mn=1,20;                      Cr=19,50;                      Ni=10,0;                      Mo&lt;0,50;                      Cu&lt;0,20;                      N&lt;0,06</p>		<p>Wire diameters:                      0,8 mm: 17 20 505xxx                      1,0 mm: 17 20 505xxx                      1,2 mm: 17 20 505xxx                      Rod diameters:                      2,0 mm: 17 21 505xxx                      2,4 mm: 17 21 505xxx</p>
<p><b>MOST 312*</b>                      Shielding gas: Ar+O<sub>2</sub> (MAG), Ar (TIG).                      Welding method: MAG and TIG.</p>	<p>EN ISO 14343:                      G 29 9 (W 29 9)                      AWS A5.9: ER312                      Werkstoff nr. 1.4337</p>	<p>MAG </p> <p>TIG </p>		<p>R<sub>e</sub> &gt;520 N/mm<sup>2</sup>                      R<sub>m</sub> &gt;730 N/mm<sup>2</sup>                      A<sub>5</sub> &gt;25%                      KV &gt;100 J (20°C)</p>	<p>C=0,10;                      Si=0,40;                      Mn=1,80;                      Cr=30,50;                      Ni=9,0;                      Mo&lt;0,40;                      Cu&lt;0,20;                      N&lt;0,06</p>		

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST 318 Si*</b> Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 19 12 3 Nb Si (W 19 12 3 Nb Si) AWS A5.9: ER 318 Si Werkstoff nr. 1.4563	MAG  TIG 		R <sub>e</sub> >400 N/mm <sup>2</sup> R <sub>m</sub> >610 N/mm <sup>2</sup> A <sub>5</sub> >36% KV>110 J (20°C)	C<0,04; Si=0,90; Mn=1,20; Cr=18,50; Ni=12,50; Mo=2,60; Cu<0,20; N<0,065		1,2 mm: 17 20 518xxx
<b>MOST 2209*</b> Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 22 9 3 NL (W 22 9 3 NL) AWS A5.9: ER 2209 Werkstoff nr. 1.4462	MAG  TIG 		R <sub>e</sub> >600 N/mm <sup>2</sup> R <sub>m</sub> >750 N/mm <sup>2</sup> A <sub>5</sub> >25% KV>160 J (20°C)	C<0,02; Si=0,50; Mn=1,60; Cr=23,0; Ni=9,0; Mo=3,20; N=0,16		1,0 mm: 17 20 522103 1,2 mm: 17 20 522123
<b>MOST 385 (904 L)*</b> Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 20 25 5 CuL (W 20 25 5 CuL) AWS A5.9: ER385 Werkstoff nr. 1.4519	MAG  TIG 		R <sub>e</sub> >320 N/mm <sup>2</sup> R <sub>m</sub> >540 N/mm <sup>2</sup> A <sub>5</sub> >37% KV>120 J (20°C)	C<0,02; Si=0,40; Mn=18,0; Cr=20,0; Ni=25,0; Mo=4,50; Cu=1,50; N<0,06		1,2 mm: 17 20 585xxx
<b>MOST 430 Ti*</b> Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G Z 17Ti W Z 17Ti AWS A5.9: ER430Ti Werkstoff nr. 1.4502	MAG  TIG 		R <sub>e</sub> >295 N/mm <sup>2</sup> R <sub>m</sub> >490 N/mm <sup>2</sup> A <sub>5</sub> >20%	C<0,07; Si=0,70; Mn=0,30; Cr=17,50; Ti=0,60		Wire diameters: 1,2 mm: 17 20 530123 Rod diameters: 2,0 mm: 17 21 530207 2,4 mm: 17 21 530247
<b>MOST 410 NiMo*</b> Shielding gas: Ar+O <sub>2</sub> (MAG), Ar (TIG). Welding method: MAG and TIG.	EN ISO 14343: G 13 4 (W 13 4) AWS A5.9: ER410NiMo Werkstoff nr. 1.4351	MAG  TIG 		R <sub>e</sub> >600 N/mm <sup>2</sup> R <sub>m</sub> >800 N/mm <sup>2</sup> A <sub>5</sub> >15% KV>50 J (20°C)	C<0,03; Si=0,70; Mn=0,70; Cr=13,0; Ni=4,50; Mo=0,50		





2.5. Wires and rods for hardfacing and regeneration

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST EL-250 HB</b> Wire for hardfacing impact-resistant weld. Low-alloyed solid wire designed for repair of elements exposed to wear. Applications: machine parts, rollers, rails, etc. Welding method: MIG/MAG and TIG.</p>	<p>DIN 8555: MSG 1-250 Werkstoff nr. 1.8401 DIN EN ISO 14700: SFe1</p>			<p>Hardness: 225-275 HB</p>	<p>C=0,30; Si=0,450; Mn=1,10; Cr=1,0; Al=0,10; Ti=0,20</p>		<p>Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm</p>
<p><b>MOST EL-350 HB</b> Wire for hardfacing impact-resistant weld. Low-alloyed solid wire designed for repair of elements exposed to wear. Applications: machine parts, rollers, rails, shafts, etc. Welding method: MIG/MAG and TIG.</p>	<p>DIN 8555: MSG 2-350 Werkstoff nr. 1.8405 DIN EN ISO 14700: SFe2</p>			<p>Hardness: 370 HB</p>	<p>C=0,70; Si=0,45; Mn=2,0; Cr=1,0; Al=0,10; Ti=0,20</p>		<p>Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 1,0 mm; 1,6 mm 2,0 mm; 2,4 mm 3,2 mm</p>
<p><b>MOST EL-500 HB</b> Wire for hardfacing impact-resistant weld. Solid designed for repair of elements exposed to wear and pressure, made of construction steel, cast steel, manganese steel. Applications: machine parts, shaft pivots, rollers, rails, etc. Welding method: MIG/MAG and TIG.</p>	<p>DIN 8555: MSG 2-50 Werkstoff nr. 1.8425 DIN EN ISO 14700: SFe2</p>			<p>Hardness: 47-52 HRC</p>	<p>C=1,10; Si=0,45; Mn=1,90; Cr=2,0; Al=0,10; Ti=0,20</p>		<p>Wire diameters: 1,0 mm; 1,2 mm 1,6 mm Rod diameters: 1,0 mm; 1,6 mm 2,0 mm; 2,4 mm 3,2 mm</p>
<p><b>MOST EL-600 HB</b> Wire for hardfacing impact-resistant weld. The weld is free of cracks, hard, resistant to abrasive wear and impact. In the case of hard to weld materials pre-heating or undercoat (buffer layer) is recommended. Applications: crusher wheels, loader bucket elements, final layer in hardfacing of manganese steels. Structure: martensitic. Welding method: MIG/MAG and TIG.</p>	<p>DIN 8555: MSG 6-60 Werkstoff nr. 1.4718 DIN EN ISO 14700: SFe8</p>			<p>Hardness: 59 HRC</p>	<p>C=0,50; Si=3,0; Mn=0,40; Cr=9,0</p>		<p>Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 1,0 mm; 1,6 mm 2,0 mm; 2,4 mm 3,2 mm</p>
<p><b>MOST EL-650 HB</b> Wire for hardfacing impact-resistant weld. Solid wire is designed for hardfacing of hot working elements exposed to abrasive wear, impacts and temperatures up to 500°C. Applications: machine parts, roller dies, etc. Welding method: MIG/MAG and TIG.</p>	<p>DIN 8555: MSG 3-GZ-60T Werkstoff nr. 1.2606</p>			<p>Hardness: 57-59 HRC</p>	<p>C=0,35; Si=1,10; Mn=0,40; Cr=5,50; Mo=1,20; V=0,25; W=1,30</p>		<p>Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 1,0 mm; 1,6 mm 2,0 mm; 2,4 mm</p>
<p><b>MOST W 45</b> Rods for hardfacing of tool steels. Designed for hot-working elements repairs. Welding method: TIG.</p>	<p>DIN 8555: MSG 3-45T Werkstoff nr. 1.2567</p>			<p>Hardness: 44-50 HRC</p>	<p>C=0,20; Si=0,20; Mn=0,30; Cr=2,40; W=4,50; V=0,60</p>		<p>1,6 mm 2,0 mm 2,4 mm</p>
<p><b>MOST W 60</b> Rods for hardfacing of tool steels. Designed for repairs of elements with high-speed steel characteristics. Welding method: TIG.</p>	<p>DIN 8555: MSG 4-60-S Werkstoff nr. 1.3348</p>			<p>Hardness: 58 HRC</p>	<p>C=1,0; Si=0,30; Mn=0,30 W=1,80; Mo=8,30; Cr=4,0; V=1,90</p>		<p>1,6 mm; 2,4 mm 2,0 mm; 3,2 mm</p>

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST EL-Co 1</b> Cobalt-based weld, resistant to extreme abrasive metal-to-metal wear up to 950°C. Applications: pan, shafts, pumps, rollers, cutting blades, etc. Welding method: TIG.</p>	<p>DIN 8555: MF 20-55-CGTZ AWS A5.13-70: RCoCr-C DIN EN ISO 14700: TCo 2-65-CGTZ</p>			<p>Hardness: 52-59 HRC (20°C) 42-45 HRC (600°C)</p>	<p>C=2,50; Si=0,80; Ni=max 3,0; Fe=max 3,0; Cr=30,0; W=13,0; Co=rest</p>		<p>Rod diameters: 2,5 mm; 3,2 mm 4,0 mm; 5,0 mm Wire diameters: 1,2 mm; 1,6 mm</p>
<p><b>MOST EL-Co 6</b> Cobalt-based weld, resistant to extreme metal-to-metal abrasive wear and pressures up to 950°C. Very good resistance to thermal and mechanical shocks. Applications: hot cutting blades, rollers, industrial fittings, engine valves, hot-working tools, etc. Welding method: TIG.</p>	<p>DIN 8555: MF 20-45-CTZ AWS A5.13-70: RCoCr-A DIN EN ISO 14700: TCo 2-45-CTZ</p>			<p>Hardness: 39-46 HRC (20°C) 30 HRC (600°C)</p>	<p>C=1,10; Si=1,0; Ni=max 3,0; Fe=max 3,0; Cr=28,0; W=4,0; Co=rest</p>		<p>Rod diameters: 2,5 mm; 3,2 mm 4,0 mm; 5,0 mm Wire diameters: 1,2 mm; 1,6 mm</p>
<p><b>MOST EL-Co 12</b> Cobalt-based weld, resistant to extreme abrasive wear up to 950°C. Applications: extruder nozzles, saw blades, guides etc. Welding method: TIG.</p>	<p>DIN 8555: MF 20-50-CTZ AWS A5.13-70: RCoCr-B DIN EN ISO 14700: TCo 2-50-CTZ</p>			<p>Hardness: 46-52 HRC (20°C) 38-40 HRC (600°C)</p>	<p>C=1,40; Si=1,50; Ni=max 3,0; Fe=max 3,0; Cr=29,0; W=8,0; Co=rest</p>		<p>Rod diameters: 2,5 mm; 3,2 mm 4,0 mm; 5,0 mm Wire diameters: 1,2 mm; 1,6 mm</p>
<p><b>MOST EL-Co 21</b> Cobalt-based weld, resistant to extreme abrasive metal-to-metal wear and pressures up to 950°C. Hardening after crush. Applications: forging and hot and cold forming tools, gas turbine components, etc. Welding method: TIG.</p>	<p>DIN 8555: MF 20-350-CKTZ AWS A5.13-70: RCoCr-E DIN EN ISO 14700: TCo 1-350-CKTZ</p>			<p>Hardness: 32-38 HRC (20°C) 38-40 HRC (600°C) 42-45 HRC (after crushing)</p>	<p>C=2,50; Si=1,0; Ni=2,50; Fe=max 3,0; Mo=5,50; Cr=27,0; Co=rest</p>		<p>Rod diameters: 2,5 mm; 3,2 mm 4,0 mm; 5,0 mm Wire diameters: 1,2 mm; 1,6 mm</p>



2.6. Welding wires and rods for cast iron, nickel and nickel alloys

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST EL-NiFe</b> Ferro-Nickel solid wire for welding cast iron and joining cast iron with steel. Applications: centrifugal cast iron, ductile cast iron, malleable cast iron. Welding method: MIG and TiG.</p>	DIN 8573: MSG NiFe1 Werkstoff nr. 2.4472/2.4560				Ni=55,0; C=1,50; Fe=rest		Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 2,0 mm
<p><b>MOST EL-Ni 4155</b> Solid wire for welding of nickel (up to 450°C) and its alloys and for joining nickel alloys to steel, cast steel and copper. The weld is temperature resistant up to -196°C. Welding method: MIG and TiG.</p>	AWS A5.14: ER Ni 1 Werkstoff nr. 2.4155 DIN 1736: SG NiTi 4			R <sub>e</sub> > 300 N/mm <sup>2</sup> R <sub>m</sub> > 500 N/mm <sup>2</sup> A <sub>5</sub> > 35%	C=0,02; Si=0,40; Mn=0,40; Fe=0,20; Ti=3,0; Ni=rest		Wire diameters: 1,2 mm; 2,0 mm 3,2 mm Rod diameters: 2,0 mm; 3,25 mm 4,0 mm; 5,0 mm
<p><b>MOST EL-Ni 4886</b> Stainless wire for connecting and repairing nickel alloys and high-temperature steels and for their joints to low- and high-alloy steels and cast steel. Operating temperatures up to 400°C. Temperature resistant weld up to -196°C. Welding method: MIG and TiG.</p>	Werkstoff nr. 2.4886 AWS A5.14: ER NiCrMo-4 DIN 1736: SG NiMo16Cr16W			R <sub>e</sub> > 470 N/mm <sup>2</sup> R <sub>m</sub> > 780 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV=80 J (20°C) 60 J (-196°C)	C=0,01; Cr=15,50; Fe=5,0; Mn=0,50; Mo=1,6,0; Si=0,06; V=0,30; W=4,0; Ni=rest		Wire diameters: 1,2 mm; 1,6 mm 2,0 mm; 2,4 mm 3,2 mm Rod diameters: 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm
<p><b>MOST EL-Ni 4377</b> Wire for welding and repairing NiCu alloys and joining copper alloys to steel. Operating temperatures up to 425°C. Weld resistant to temperatures up to -196°C. Welding method: MIG and TiG.</p>	Werkstoff nr. 2.4377 AWS A5.14: ER NiCu7 DIN 1736: SG NiCu30MnTi			R <sub>e</sub> > 300 N/mm <sup>2</sup> R <sub>m</sub> > 500 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV=150 J (20°C) 110 J (-196°C)	C=0,02; Si=0,20; Mn=3,30; Fe=1,0; Cu=30,0; Ti=2,0; Ni=rest		Wire diameters: 1,0 mm; 1,2 mm 1,6 mm; 2,0 mm Rod diameters: 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm
<p><b>MOST EL-Ni 4806</b> Stainless, heat-resistant wire for welding and repairing nickel alloys, high-temperature steels and austenitic-ferritic joints at temperatures up to 500°C. The weld is temperature resistant from -300°C to 900°C. Welding method: MIG and TiG.</p>	Werkstoff nr. 2.4806 AWS A5.14: ER NiCr3 DIN 1736: SG NiCr20Nb			R <sub>e</sub> > 400 N/mm <sup>2</sup> R <sub>m</sub> > 680 N/mm <sup>2</sup> A <sub>5</sub> > 40% KV=150 J (20°C)	C=0,02; Si=0,20; Mn=3,0; Fe=1,0; Ti=0,50; Ni=rest; Cr=20,0; Nb+Ta=2,50		Wire diameters: 1,0 mm; 1,2 mm 1,6 mm; 2,0 mm Rod diameters: 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm
<p><b>MOST EL-Ni 4831</b> Stainless, heat-resistant wire for welding and repairing nickel alloys, high-temperature steels and austenitic-ferritic joints at temperatures up to 500°C. The weld is temperature resistant from -300°C to 900°C. Welding method: MIG and TiG.</p>	Werkstoff nr. 2.4831 AWS A5.14: ER NiCrMo3 DIN 1736: SG NiCr21Mo9Nb			R <sub>e</sub> > 420 N/mm <sup>2</sup> R <sub>m</sub> > 800 N/mm <sup>2</sup> A <sub>5</sub> > 35% KV=110 J (20°C) 85 J (-196°C)	C=0,02; Si=0,20; Mn=0,20; Fe=1,50; Mo=9,0; Ni=rest; Cr=22,0; Nb+Ta=3,30		Wire diameters: 0,8 mm; 1,2 mm 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm Rod diameters: 1,6 mm; 2,0 mm 2,4 mm; 3,2 mm

## 2.7. Welding wires and rods for copper and copper alloys
















(\*material outside the basic offer needs confirmation of availability and MOQ requirements)


















Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST CuAl 8*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuAl-A1 Werkstoff nr. 2.0921			R <sub>e</sub> >200 N/mm <sup>2</sup> R <sub>m</sub> >430 N/mm <sup>2</sup> A <sub>5</sub> >40% KV >100 J (20°C)	Cu>90,0; Al=8,0		Wire diameters: 1,2 mm Rod diameters: 2,0 mm
<b>GOLD CuAl 8*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuAl-A1 Werkstoff nr. 2.0921			R <sub>e</sub> >200 N/mm <sup>2</sup> R <sub>m</sub> >430 N/mm <sup>2</sup> A <sub>5</sub> >40% KV >100 J (20°C)	Cu>90,0; Al=8,0		1,2 mm: 11 50 803xxx
<b>MOST CuSn*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER Cu Werkstoff nr. 2.1006			R <sub>e</sub> >100 N/mm <sup>2</sup> R <sub>m</sub> >210-240 N/mm <sup>2</sup> A <sub>5</sub> >30% KV >80 J (20°C)	Si=0,30; Mn=0,30; Cu>98,0; Sn=0,80		Wire diameters: 1,2 mm Rod diameters: 2,0 mm
<b>MOST CuSn 6*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	Werkstoff nr. 2.1022			R <sub>e</sub> >150 N/mm <sup>2</sup> R <sub>m</sub> >220-360 N/mm <sup>2</sup> A <sub>5</sub> >20% KV >80 J (20°C)	Cu>92,0; Sn=6,40;		Wire diameters: 1,2 mm Rod diameters: 2,0 mm
<b>MOST CuSi 3*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuSi-A Werkstoff nr. 2.1461			R <sub>e</sub> >120 N/mm <sup>2</sup> R <sub>m</sub> >350 N/mm <sup>2</sup> A <sub>5</sub> >40% KV >60 J (20°C)	Si=3,0; Mn=1,0; Cu>94,0; Fe=0,07; Zn=0,10; Sn=0,10		Wire diameters: 1,2 mm Rod diameters: 2,0 mm
<b>MOST CuNi 30 Fe*</b> Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuNi Werkstoff nr. 2.0837			R <sub>e</sub> >250 N/mm <sup>2</sup> R <sub>m</sub> >400 N/mm <sup>2</sup> A <sub>5</sub> >30% KV >100 J (20°C)	C>0,05; Mn=1,0; Cu=rest; Ti=0,30; Ni=3,0,0; Fe=0,60		Wire diameters: 1,2 mm Rod diameters: 2,0 mm
<b>GOLD CuSi 3</b> CE declaration of Conformity. Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuSi-A Werkstoff nr. 2.1461			R <sub>e</sub> >120 N/mm <sup>2</sup> R <sub>m</sub> >350 N/mm <sup>2</sup> A <sub>5</sub> >40% KV >60 J (20°C)	Si=3,0; Mn=1,0; Cu>94,0; Fe=0,07; Zn=0,10; Sn=0,10		Wire diameters: 0,8 mm: 11 50 805083 1,0 mm: 11 50 805103 Rod diameters: 1,6 mm: 11 51 805167 2,0 mm: 11 51 805207 2,4 mm: 11 51 805247

▼ **2.8. Wires and rods for welding aluminium and aluminium alloys**  
 (\*material outside the basic offer needs confirmation of availability and MOQ requirements)



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST Al 99,5 Ti (IA 1450)*</b> CE declaration of Conformity. Shielding gas: Ar. Welding method: MIG and TiG.	DIN 1732: SG Al 99,5 Ti Werkstoff nr. 3.0805 EN ISO 18273: S Al 1450 (Al 99,5 Ti)	MIG  TiG 		R <sub>e</sub> = 40-60 N/mm <sup>2</sup> R <sub>m</sub> = 70-90 N/mm <sup>2</sup> A <sub>5</sub> = 25-35%	Al > 99,5; Si < 0,25; Mn > 0,05; Mg = 0,05; Cu = 0,05; Zn = 0,10; Fe < 0,40; Ti < 0,15		Wire diameters: 0,8 mm; 1,0 mm 1,2 mm; 1,6 mm Rod diameters: 1,6 mm; 2,0 mm 3,2 mm; 4,0 mm
<b>MOST Al Mg 3 (IA 5754)*</b> CE declaration of Conformity. Shielding gas: Ar. Welding method: MIG and TiG.	AWS A5.10: ER 5754 Werkstoff nr. 3.3536 EN ISO 18273: S Al 5754 (AlMg3)	MIG  TiG 		R <sub>e</sub> = 80-100 N/mm <sup>2</sup> R <sub>m</sub> = 175-205 N/mm <sup>2</sup> A <sub>5</sub> = 15-20%	Si = 0,40; Mn = 0,1-0,6; Mg = 2,6-3,6; Cr < 0,30; Zn = 0,02; Fe < 0,15; Ti < 0,25; Cu = 0,05; Al = rest		Wire diameters: 0,8 mm; 1,0 mm; 1,2 mm; 1,6 mm Rod diameters: 1,6 mm; 2,0 mm; 3,2 mm; 4,0 mm
<b>GOLD Al Mg 3 (IA 5754)*</b> CE declaration of Conformity. Shielding gas: Ar. Welding method: MIG.	AWS A5.10: ER 5754 Werkstoff nr. 3.3536 EN ISO 18273: S Al 5754 (AlMg3)	MIG  TiG 		R <sub>e</sub> = 80-100 N/mm <sup>2</sup> R <sub>m</sub> = 175-205 N/mm <sup>2</sup> A <sub>5</sub> = 15-20%	Si = 0,40; Mn = 0,1-0,6; Mg = 2,6-3,6; Cr < 0,30; Zn = 0,02; Fe < 0,15; Ti < 0,25; Cu = 0,05; Al = rest		Wire diameters: 1,0 mm; 1,2 mm; 1,6 mm
<b>MOST Al Mg 5 (IA 5356)</b> CE declaration of Conformity. Shielding gas: Ar. Welding method: MIG and TiG.	AWS A5.10: ER 5356 Werkstoff nr. 3.3556 EN ISO 18273: S Al 5356 (AlMg5Cr)	MIG  TiG 		R <sub>e</sub> = 100-135 N/mm <sup>2</sup> R <sub>m</sub> = 220-260 N/mm <sup>2</sup> A <sub>5</sub> = 15-25%	Si < 0,25; Mn < 0,2; Mg = 4,5-5,2; Cu = 0,05; Zn = 0,02; Fe < 0,40; Ti = 0,25; Cr < 0,30; Al = rest	TÜV, DB, ABS, BV, DNV-GL, LR	Wire diameters: 0,8 mm; 1,0 mm; 1,2 mm; 1,6 mm Rod diameters: 1,6 mm; 2,0 mm; 2,4 mm; 3,2 mm
<b>GOLD Al Mg 5 (IA 5356)</b> CE declaration of Conformity. Shielding gas: Ar. Welding method: MIG and TiG.	AWS A5.10: ER 5356 Werkstoff nr. 3.3556 EN ISO 18273: S Al 5356 (AlMg5Cr)	MIG  TiG 		R <sub>e</sub> = 100-135 N/mm <sup>2</sup> R <sub>m</sub> = 220-260 N/mm <sup>2</sup> A <sub>5</sub> = 15-25%	Si < 0,25; Mn < 0,2; Mg = 4,5-5,2; Cu = 0,05; Zn = 0,02; Fe < 0,40; Ti = 0,25; Cr < 0,30; Al = rest	TÜV, DB, ABS, BV, DNV-GL, LR	Wire diameters: 0,8 mm; 1,0 mm; 1,2 mm; 1,6 mm Rod diameters: 1,6 mm; 2,0 mm; 2,4 mm; 3,2 mm






Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST Al Mg 4.5 Mn (IA 5183)</b>                      CE declaration of Conformity.                      Shielding gas: Ar.                      Welding method: MIG and TIG.</p>	<p>AWS A5.10: ER 5183                      Werkstoff nr. 3.3548                      EN ISO 18273:                      S AI 5183                      (AlMg4,5Mn0,7)</p>	<p>MIG                       TIG </p>		<p><math>R_e=110-150 \text{ N/mm}^2</math>  <math>R_m=275-335 \text{ N/mm}^2</math>  <math>A_5=15-20\%</math></p>	<p>Si&lt;0,25;                      Mn=0,6-1,0;                      Mg=4,3-5,2;                      Cu=0,05; Zn=0,25;                      Fe&lt;0,40;                      Ti&lt;0,25;                      Cr&lt;0,25;                      Al=rest</p>	<p>TÜV, DB, BV,                      DNV-GL, LR</p>	<p>Wire diameters:                      0,8 mm: 11 40 907xxx                      1,0 mm: 11 40 907xxx                      1,2 mm: 11 40 907xxx                      1,6 mm:                      Rod diameters:                      1,6 mm: 11 41 907xxx                      2,0 mm: 11 41 907xxx                      3,2 mm: 11 41 907xxx                      4,0 mm: 11 41 907xxx</p>
<p><b>GOLD Al Mg 4.5 Mn (IA 5183)</b>                      CE declaration of Conformity.                      Shielding gas: Ar.                      Welding method: MIG and TIG.</p>	<p>AWS A5.10: ER 5183                      Werkstoff nr. 3.3548                      EN ISO 18273:                      S AI 5183                      (AlMg4,5Mn0,7)</p>	<p>MIG                       TIG </p>		<p><math>R_e=110-150 \text{ N/mm}^2</math>  <math>R_m=275-335 \text{ N/mm}^2</math>  <math>A_5=15-20\%</math></p>	<p>Si&lt;0,25;                      Mn=0,6-1,0;                      Mg=4,3-5,2;                      Cu=0,05; Zn=0,25;                      Fe&lt;0,40;                      Ti&lt;0,25;                      Cr&lt;0,25;                      Al=rest</p>	<p>TÜV, DB, BV,                      DNV-GL, LR</p>	<p>Wire diameters:                      0,8 mm                      1,0 mm: 11 50 907xxx                      1,2 mm: 11 50 907xxx                      1,6 mm: 11 50 907xxx                      Rod diameters:                      1,6 mm: 11 51 907xxx                      2,0 mm: 11 51 907xxx                      3,2 mm: 11 51 907xxx                      4,0 mm: 11 51 907xxx</p>
<p><b>MOST Al Mg 4,5 Mn Zr (IA 5087)*</b>                      Shielding gas: Ar.                      Welding method: MIG and TIG.</p>	<p>AWS A5.10: ER 5187                      Werkstoff nr. 3.3546                      EN ISO 18273:                      S AI 5087                      (AlMg4,5MnZr)</p>	<p>MIG                       TIG </p>		<p><math>R_e=110-150 \text{ N/mm}^2</math>  <math>R_m &gt; 285 \text{ N/mm}^2</math>  <math>A_5=15-20\%</math></p>	<p>Si&lt;0,25;                      Mn=0,6-1,0;                      Mg=4,3-5,2;                      Cu=0,05;                      Zn=0,25;                      Fe&lt;0,40;                      Zr=0,10;                      Cr&lt;0,25;                      Al=rest;                      Ti&lt;0,25</p>	<p>TÜV, DB,                      DNV-GL</p>	<p>Wire diameters:                      0,8 mm                      1,0 mm                      1,2 mm: 11 40 905122                      1,6 mm                      Rod diameters:                      1,6 mm:                      2,0 mm: 11 41 905207                      3,2 mm                      4,0 mm</p>
<p><b>MOST Al Si 5 (IA 4043)</b>                      CE declaration of Conformity.                      Shielding gas: Ar.                      Welding method: MIG and TIG.</p>	<p>AWS A5.10: ER 4043                      Werkstoff nr. 3.2245                      EN ISO 18273:                      S AI 4043 (AlSi5)</p>	<p>MIG                       TIG </p>		<p><math>R_e=50 \text{ N/mm}^2</math>  <math>R_m=120-150 \text{ N/mm}^2</math>  <math>A_5=10-18\%</math></p>	<p>Si=4,5-5,5;                      Mn=0,10;                      Mg=0,10;                      Cu=0,05;                      Fe&lt;0,40;                      Ti&lt;0,25;                      Al=rest</p>	<p>DB</p>	<p>Wire diameters:                      0,8 mm                      1,0 mm: 11 40 904xxx                      1,2 mm: 11 40 904xxx                      1,6 mm                      Rod diameters:                      2,0 mm: 11 41 904xxx                      3,2 mm: 11 41 904xxx</p>
<p><b>GOLD Al Si 5 (IA 4043)</b>                      CE declaration of Conformity.                      Shielding gas: Ar.                      Welding method: MIG and TIG.</p>	<p>AWS A5.10: ER 4043                      Werkstoff nr. 3.2245                      EN ISO 18273:                      S AI 4043 (AlSi5)</p>	<p>MIG                       TIG </p>		<p><math>R_e=50 \text{ N/mm}^2</math>  <math>R_m=120-150 \text{ N/mm}^2</math>  <math>A_5=10-18\%</math></p>	<p>Si=4,5-5,5;                      Mn=0,10;                      Mg=0,10;                      Cu=0,05;                      Fe&lt;0,40;                      Ti&lt;0,25;                      Al=rest</p>	<p>DB</p>	<p>Wire diameters:                      0,8 mm: 11 50 904xxx                      1,0 mm: 11 50 904xxx                      1,2 mm: 11 50 904xxx                      1,6 mm:                      Rod diameters:                      2,0 mm: 11 51 904xxx                      3,2 mm: 11 51 904xxx</p>

## Wires and rods for welding aluminium and aluminium alloys

(\*material outside the basic offer needs confirmation of availability and MOQ requirements)




Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST Al Si 12 (IA 4047)*</b> Shielding gas: Ar, Ar+He. Welding method: MIG and TIG.	AWS A5.10: ER 4047 Werkstoff nr. 3.2885 EN ISO 18273: S Al 4047 (AlSi12)	MIG  TIG 		$R_e > 70 \text{ N/mm}^2$ $R_m > 160-190 \text{ N/mm}^2$ $A_5 = 10-15\%$	Si=11-13,5; Mn>0,50; Mg=0,05; Cu=0,05; Zn=0,10; Fe<0,60; Al=rest; Ti<0,15		Wire diameters: 0,8 mm 1,0 mm 1,2 mm 1,6 mm Rod diameters: 1,6 mm 2,0 mm 3,2 mm 4,0 mm

## 2.9. Titanium welding wires and rods

(\*material outside the basic offer needs confirmation of availability and MOQ requirements)





Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<b>MOST Ti Grade 2*</b> Titanium alloy wire of Grade 2 for welding of various titanium alloys, where good mechanical properties are required. The wire is suitable for welding of heat exchangers, tanks and pipelines in chemical industry and constructions in aviation industry. Shielding gas: Ar. Welding method: TIG.	AWS A 5.16: ERTi-2 EN ISO 24034: S Ti 0120 (Ti99,6)			$R_e > 270 \text{ N/mm}^2$ $R_m > 390 \text{ N/mm}^2$ $A_5 = 22\%$ KV=34 (20°C)	C<0,03 Ti=rest Fe<0,20		

## 3. FLUX CORED WIRES FOR MIG/MAG WELDING

### 3.1. Flux-cored wires for welding of unalloyed and fine grained steels



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>MOST E71 T-1</b> Flux-cored wire used in machine, ship and bridge construction. The properties of the alloy are comparable to those of SF 71. Stable welding in all positions and fluctuations. CE declaration of Conformity. Shielding gas: CO <sub>2</sub> .	AWS A5.20: E71T-1C EN ISO 17632-A: T422PCT			$R_e > 545 \text{ N/mm}^2$ $R_m > 572 \text{ N/mm}^2$ $A_5 = 28\%$ KV>110 J (0°C) 70 J (-20°C)	C=0,03; Si<0,51; Mn=1,26; P=0,01; S=0,011	BV, LR DB, ABS, RMRS	1,2 mm: 11 33 502123 1,4 mm

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST E71 T-1 Extra H5</b> Rutile flux-core wire for single or multi-track welding of carbon and manganese-carbon steels and similar materials, including fine-grades steels in a CO<sub>2</sub> shielding. Properties: high conformity, good weldability, correct weld, few spatters during welding. Good mechanical properties of the weld at low temperatures (-20°C). Wire intended for manual welding as well as for robotized and automated welding of steels with a strength of 490 MPa. CE declaration of Conformity. Shielding gas: CO<sub>2</sub>.</p>	<p>EN ISO 17632-A: T46 2 P C 1 H5 AWS A5.20: E71 T-1 C</p>			<p>R<sub>e</sub> &gt;490 (≥460) N/mm<sup>2</sup> R<sub>m</sub> &gt;560 (550-660) N/mm<sup>2</sup> A<sub>5</sub> &gt;24% (≥20) KV &gt;130 J (-20°C)</p>	<p>C=0,045; Si=0,40; Mn=1,15</p>	<p>BV, DNV-GL, LR, RINA, ABS</p>	<p>1,2 mm: 11 33 504123</p>
<p><b>MOST E71 T-1 M Extra H5</b> Rutile flux-core wire for single or multi-track welding of carbon and manganese-carbon and similar materials including fine-grades steels in Argon 75-80%+20% CO<sub>2</sub> or CO<sub>2</sub> shielding. Properties: high conformity, good weldability, correct weld, few spatters during welding. Good mechanical properties of the weld at low temperatures (-20°C). Wire intended for manual welding as well as for robotized and automated welding of steels with strength of 490 MPa. CE declaration of Conformity. Shielding gas: CO<sub>2</sub>, M21.</p>	<p>EN ISO 17632-A: T46 2 P C/M 21 H5 AWS A5.20: E71 T-1 C/1M</p>			<p>for C1: R<sub>e</sub> &gt;490 (≥460) N/mm<sup>2</sup> R<sub>m</sub> &gt;560 (550-660) N/mm<sup>2</sup> A<sub>5</sub> &gt;26% (≥20) KV &gt;120 J (-20°C) for M21: R<sub>e</sub> &gt;520 (≥460) N/mm<sup>2</sup> R<sub>m</sub> &gt;585 (550-660) N/mm<sup>2</sup> A<sub>5</sub> &gt;28% KV &gt;140 J (-20°C)</p>	<p>for C1: C=0,045; Si=0,40; Mn=1,15 for M21: C=0,05; Si=0,45; Mn=1,20</p>	<p>DNV-GL, BV, LR</p>	<p>1,2 mm: 11 33 504124</p>
<p><b>MOST 710 Metal C Extra</b> Metal-cored wire for single or multi-track welding of carbon steels and manganese-carbon and similar materials, including fine-grained steels in Ar-CO<sub>2</sub> mixtures shielding. Properties: high efficiency, good weldability, correct weld, few spatters during welding. Good mechanical properties of the weld at low temperatures (-30°C) as well as after heat treatment of the weld. The wire is designed for manual welding as well as for robotized and automated welding of steel with strength of 490 MPa. CE declaration of Conformity. Shielding gas: M21.</p>	<p>EN ISO 17632-A: T42 3 M M 1 H5 EN ISO 17632-B: T49 T115-1MA-H5 AWS A5.18: E70C-6M AWS A5.18M: E 48C-6M</p>			<p>for M21: R<sub>e</sub> &gt;480 (≥460) N/mm<sup>2</sup> R<sub>m</sub> &gt;570 (550-660) N/mm<sup>2</sup> A<sub>5</sub> &gt;30% (≥20) KV &gt;101 J (-30°C)</p>	<p>for M21: C=0,058; Si=0,65; Mn=1,55</p>	<p>DNV-GL, ABS, BV</p>	<p>1,2 mm: 11 33 507125</p>
<p><b>MOST 710 Metal C NS</b> Metallic cored wire for single or multi-track welding of carbon and manganese-carbon steels and similar including fine-grained steels. High productivity, good weldability, correct weld, few spatter during welding. Good mechanical properties of the weld at low temperatures as well as after heat treatment of the weld. The wire is suitable for manual welding as well as for robotic and automated welding of steel with a strength of 490 MPa. CE declaration of Conformity. Shielding gas: Ar+CO<sub>2</sub>.</p>	<p>EN ISO 17632-A: T46 3 M M21 1 H5 AWS A5.18: E 70C-6M H4</p>			<p>for M21: R<sub>e</sub> &gt;490 (≥460) N/mm<sup>2</sup> R<sub>m</sub> &gt;590 (550-660) N/mm<sup>2</sup> A<sub>5</sub> &gt;25% (≥20) KV &gt;90 J (-30°C) 27 J (-20°C)</p>	<p>for M21: C=0,07; Si=0,70; Mn=1,50</p>	<p>TÜV, DNV-GL, ABS, LR, BV</p>	<p>1,2 mm: 11 33 507122</p>
<p><b>GOLD E71T-11 SHELF SHIELD</b> Self-shielding flux-cored wire designed for welding in all positions of non-alloy, low-carbon steels, for use in the assembly of steel constructions. CE declaration of Conformity.</p>	<p>AWS A5.20: E71T-11 EN ISO 17632: T 42 2 Y1</p>			<p>R<sub>e</sub> &gt;400 N/mm<sup>2</sup> R<sub>m</sub> &gt;480 N/mm<sup>2</sup> A<sub>5</sub> &gt;20%</p>	<p>Si=0,60; Mn=1,75; P=0,03; S=0,03; Al=1,80; Ni=0,50;</p>		<p>0,8 mm: 11 53 600xxx</p>



**MOST ceramic backings**

No.	Type - dimensions [mm]	Length	Notes
1	<p>MOST LT05 TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on 85 wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs. Catalogue No.: 50 49 500550</p> <p>For welding with solid or flux-cored wires.</p>
2	<p>MOST LT05-6 TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on 85 mm wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs. Catalogue No.: 50 49 500560</p> <p>For welding with solid or flux-cored wires.</p>
3	<p>MOST LT 05TT TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on 85 mm wide self-adhesive aluminium tape.</p> <p>Package: 60 pcs. Catalogue No.: 50 49 500500</p> <p>For welding with flux-cored wires or coated electrodes.</p>
4	<p>MOST LT 06 TIA</p>	600 mm 24 seg x 25 mm	<p>25 mm ceramic blocks are mounted on 85 mm wide self-adhesive aluminium tape.</p> <p>Package:                      Ø6,0 mm - 250 pcs.                      Ø8,0 mm - 160 pcs.                      Ø10,0 mm - 120 pcs.                      Ø12,0 mm - 100 pcs.                      Ø15,0 mm - 75 pcs.                      Catalogue No.:                      Ø6,0 mm - 50 49 500060                      Ø8,0 mm - 50 49 500080                      Ø10,0 mm - 50 49 500100                      Ø12,0 mm - 50 49 500120                      Ø15,0 mm - 50 49 500150</p>



### 3.2. Cored wires for hardfacing and regeneration

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST F-200 K</b> The weld resistant to corrosion, temperature and thermal shocks up to 850°C. Due to high elongation (40%), it is suitable for use as a undercoat (buffer) layer before hardfacing and for joining of dissimilar materials and difficult-to-weld steels. Applications: crusher crosses, rollers, rails, beaters, etc.</p>	DIN 8555: MF 8-200-CKNPZ EN 14700: T Fe 10-200-CKNPZ			Hardness: 180-200/400 HB	C=0,10; Si=0,40; Mn=6,0; Cr=19,0; Ni=8,5; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-240 K</b> It is suitable for joining of manganese steel elements (Hadfield type) exposed to high impacts. The weld is non-magnetic, crack-free and can be hardened by crushing. Applications: crusher jaws, railroad track elements, excavator buckets, manganese steel elements, etc.</p>	DIN 8555: MF 7-200-KNP EN 14700: T Fe 9-250-KNP			Hardness: 200-230/450 HB	C=1,0; Si=0,40; Mn=14,0; Cr=4,0; Ni=0,60; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-250 K</b> High-manganese and high-chromium, corrosion-resistant and non-magnetic weld with high plasticity. It is used as a undercoat (buffer) layer for hardening welding (especially for the regeneration of used elements). Compression-resistant, stress- and impact-resistant.</p>	DIN 8555: MF 7-250-KNP EN 14700: T Fe 9-2500-KNP			Hardness: 220-250/500 HB	C=0,40; Si=0,40; Mn=16,0; Cr=14,0; Ni=1,20; Mo=0,60; V=0,20; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-300</b> Low-alloyed, ductile, crack-free weld designed for regeneration, especially in cases where multiple layers are required. Applications: tractor wheels, shafts, transmissions and kingpins in rail connections, etc.</p>	DIN 8555: MF 1-300-P EN 14700: T Fe 1-300-P			Hardness: 280-325 HB	C=0,10; Si=0,50; Mn=2,0; Cr=1,50; Mo=0,40; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-350 G</b> Cored wire for hardfacing. The weld can be mechanically processed with excellent resistance to impact loads and metal-to-metal wear. Applications: running gears, gears, conveyor rollers, clutches, etc.</p>	EN 14700: T Fe 1 DIN 8555: MF 1-GF-350-P	= +		Hardness: 350 HB	C=0,20; Mn=1,60; Cr=1,60; Si=0,60; Mo=0,60		1,2 mm 1,6 mm
<p><b>MOST F-450</b> Machinable, low-alloyed weld for multilayer hardfacing. In the case of a base material with a high-carbon content, pre-heating or undercoat (buffer) layer is required. Applications: wheel rims, chain links, bucket chains, etc.</p>	DIN 8555: MF 3-45-PT EN 14700: T Fe 2-45-PT			Hardness: 42-45 HRC	C=0,20; Cr=4,50; Mo=0,30; V=0,20; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-601</b> The weld with high abrasive and impact resistance, maintaining high hardness at temperatures up to 550°C. It can be heat treated to increase the hardness. Applications: hammers, rollers, bucket teeth, etc.</p>	DIN 8555: MF 6-60-PT EN 14700: T Fe 6-60-PT			Hardness: 55-58 HRC	C=0,50; Si=1,00; Mn=3,0; Cr=6,0; Mo=1,60; V=1,50; W=1,0; Fe=rest		1,6 mm 2,4 mm
<p><b>MOST F-WZ 50</b> Material designed to regenerate and repair hot-working tools. Heat treatable, machinable, hardness at temperatures up to 550°C. Applications: mandrels, forging dies, hot cutting knives, etc.</p>	DIN 8555: MF 3-50-ST EN 14700: T Fe 3-50-ST			Hardness: 48-50 HRC	C=0,30; Cr=2,50; V=0,60; W=4,50; Fe=rest		1,2 mm 1,6 mm 2,4 mm
<p><b>MOST F-WZ 59</b> The weld with wear and high-temperature resistance with futures of high-speed steel for regeneration and production of hot- and cold-working tools. Applications: stamps, dies, etc.</p>	DIN 8555: MF 4-55-ST EN 14700: T Fe 4-55-ST			Hardness: 57-59 HRC	C=0,6; Cr=4,0; Mo=3,5; W=3,5; Fe=rest		1,2 mm 1,6 mm 2,4 mm





### Cored wires for hardfacing and regeneration

Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST F-59</b> The weld with chromium carbide has high abrasive wear and moderate impact resistance. Applications: agricultural tools, excavators, screw conveyors, etc.</p>	DIN 8555: MF 10-60-GR EN 14700: T Fe 14-60-GR			Hardness: 59-61 HRC	C=5,0; Si=1,50; Cr=32,0; Fe=rest		1,2 mm 1,6 mm 2,4 mm
<p><b>MOST F-58 G</b> Cored wire for welding in a shielding gas mixture. The weld with hardness of approx. 600 HB is characterized by high strength, crack-free, shock-, impact- and abrasive wear-resistance. The weld is workable only by grinding. Martensitic structure. Application: hammers and crusher jaws, elements of buckets and excavators, stirrers, cognizant parts of agricultural machinery, final layer for welding of manganese steel.</p>	EN 14700: T Fe 2 DIN 8555: MF 6-GF-60-P	☰ +		Hardness: 58 HRC	C=0,50; Mn=1,0; Cr=5,80; Si=0,50; Mo=0,50		1,2 mm 1,6 mm
<p><b>MOST F-64</b> The weld with high-temperature, mineral-resistance, hard martensitic carbide microstructure. It can be used for single-layer hardfacing without significant loss of hardness. Applications: cement industry, mineral brickworks, etc.</p>	DIN 8555: MF 10-65-GZ EN 14700: T Fe 16-65-GZ			Hardness: 62-64 HRC	C=3,80; Cr=22,0; V=0,80; W=0,80; Fe=rest		1,2 mm 1,6 mm 2,0 mm 2,4 mm 2,8 mm 3,2 mm
<p><b>MOST F-65</b> The weld with extremely hard-carbides content. It is designed to joint components exposed to high-mineral wear at temperatures up to 650°C. Applications: blast furnace cones, sintering plants, screw conveyors, etc.</p>	DIN 8555: MF 10-65-GZ EN 14700: T Fe 16-65-GZ			Hardness: 63-65 HR	C=5,20; Cr=21,0; Mo=7,0; Nb=7,0; V=1,0; W=2,0; Fe=rest		1,6 mm 2,0 mm 2,4 mm 3,2 mm

### 3.3. Flux cored wires for cast iron



Marking and description	Classification	Welding current	Welding position	Features	Chemical composition [%]	Approvals	Diameter
<p><b>MOST F-NiFe 36</b> Cored wire for welding cast iron and joining steel to cast iron. The weld is machinable and has an extremely low coefficient of thermal expansion.</p>	Werkstoff nr. 1.3912			Hardness: 140-160 HB	Mn=3,0; Ni=36,0; Fe=rest		1,6 mm 2,0 mm 2,4 mm 2,8 mm
<p><b>MOST F-NiFe 60/40</b> Ferro-Nickel cored wire for welding cast iron and joining steel to cast iron. Available also as solid wire. Applications: centrifugally cast iron, GGG cast iron, malleable cast iron.</p>	DIN 8555: MF NiFe-2 EN 14700: NiFe-CI			Hardness: 160-190 HB	Mn=4,0; Fe=40,0; Ni=rest		1,6 mm 2,0 mm 2,4 mm 2,8 mm

## 4. SPECIAL WELDING CONSUMABLES

### 4.1. Electrodes for cutting and gouging



Marking and description	Classification	Welding current	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<b>CARBON ELECTRODE MOST</b> Carbon electrodes are used for: <ul style="list-style-type: none"> <li>▪ welding of steel and non-ferrous metals,</li> <li>▪ gouging and cutting,</li> <li>▪ removal of old welds, joint finishing,</li> <li>▪ cleaning and repairing cast iron and non-ferrous metal castings,</li> <li>▪ cutting metals under water.</li> </ul>			Example size selection for round electrodes: <ul style="list-style-type: none"> <li>▪ width of groove: electrodes diameter x 1,4/1,5 mm</li> <li>▪ depth of groove: electrodes diameter x 0,7/0,8 mm</li> <li>▪ arc amperage: electrodes diameter x (40-50) A</li> </ul>	C=98,0		6,0 mm: 03 77 257062 8,0 mm: 03 77 257082 10,0 mm: 03 77 257102

### 4.2. Special electrodes

(\*material outside the basic offer needs confirmation of availability and MOW requirements)



Marking and description	Classification	Welding current	Features	Chemical composition [%]	Approvals	Diameter
<b>MOST Lastek 1000*</b> Cutting all metals without compressed air (stainless steel, aluminum, cast iron, bronze, copper, etc.). When cutting stainless steel, clean cutting edges without carbon-deposits. Applications: Weld removal, riveting, hole cutting, demolition work, etc.						2,5 mm 3,2 mm 4,0 mm 5,0 mm
<b>MOST Lastek 1001*</b> Post pre-heating and heating of metals - without weld. Applications: Artistic and decorative works, disassembly of machine parts, heating of weld before forging, etc.						3,2 mm 4,0 mm
<b>MOST Lastek 1008*</b> Underwater welding electrode. Applications: Drilling platforms, ship repairs, port work, etc.						3,2 mm 4,0 mm 5,0 mm
<b>MOST Lastek 1010*</b> Welding electrode for spot welding of metals, which is an alternative to resistance welding machines. Designed for joining metal sheets of total thickness up to 10 mm thick (e.g. 5 mm + 5 mm) with full penetration and for welding (riveting) sheets up to 10 mm thick with larger elements (without total) penetration. Applications: Chemical industry (stainless steel welding with profiles), general workshop activities etc.						1,5 mm 2,0 mm 2,5 mm 3,2 mm 4,0 mm
<b>MOST Lastek 1900*</b> Electrode for gouging and melting all metals, designed for use in all positions. Applications: Surface preparation prior to cast iron repair, removal of old fillings before regeneration, beveling of edges, removal of overburden in foundries, etc.						2,5 mm 3,2 mm 4,0 mm 5,0 mm



▼ 4.3. Gas welding rods

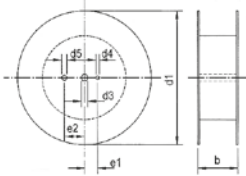
Marking and description	Classification	Welding current	Features	Chemical composition [%]	Approvals	Diameter / Catalogue No.
<p><b>MOST SpG1A</b>                      Wire for gas: acetylene and oxygen welding, designed for unalloyed steels. Typically used for water and heating installations and tanks. CE declaration of Conformity.</p>	<p>EN ISO 20378: 01                      AWS A5.2: R45</p>			<p>C=0,10;                      Si&lt;0,15;                      Mn=0,50</p>		<p>Black:                      2,5 mm: 11 61 010xxx                      3,2 mm: 11 61 010xxx                      4,0 mm: 11 61 010xxx                      Cu:                      2,5 mm: 11 61 011xxx                      3,2 mm: 11 61 011xxx                      4,0 mm: 11 61 011xxx</p>

## ▼ 5. TYPES OF PACKAGING FOR WELDING WIRES

**GOLD**  
Line

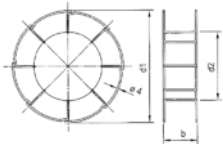
**most**®

### Plastic spools

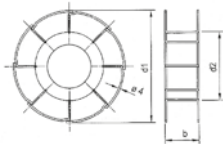


Type	Reel weight [kg]	Outer diameter d1 [mm]	Width internal b [mm]	Bore diameter d3 [mm]	Means according to EN ISO 544:2018
S 100	0,5-1,0	100	45	16,5	S 100
S 200	2-5	200	55	50,5	S 200
S 300	6-20	300	100	50,5	S 300

### Wire baskets – metal spools



B 200/300

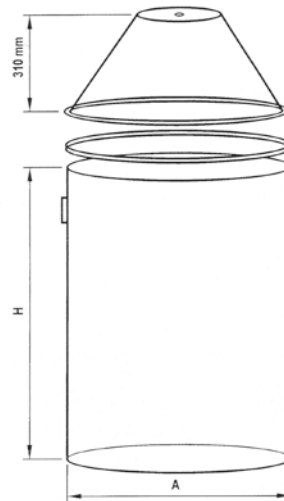


BS 300

Type	Reel weight [kg]	Outer diameter d1 [mm]	Outer diameter d2 [mm]	Internal width b [mm]	Means according to EN ISO 544:2018
B 200	2-5	200	90	55	-
B 300	6-20	300	180	100	B 300
BS 300	6-20	300	180	55	BS 300

### Drums

Type	Drum weight [kg]	Outer diameter A [mm]	Height H [mm]	Height with cover [mm]
Drum	250-280	510	810	1120



## ▼ 6. STORAGE AND TRANSPORT OF WELDING CONSUMABLES

Welding consumables must be transported in such a way that their packaging and the consumables themselves are not damaged.

The binders should be stored in a dry and clean room at a positive temperature between +10°C and +30°C. In the case of substrates made of mineral mats (cement, clinker), it is recommended to store them on wooden transport pallets or wooden shelves to avoid moisture and dirt. When storing packages with electrodes wrapped in layers, their number should not exceed eight. Packaging of partially used materials should be additionally protected against moisture and soiling.

Humidity in rooms where welding consumables are stored, depending on the ambient temperature (the higher temperature, the lower the humidity) should not exceed 50-60% for basic electrodes, wires, rods, solid and powder tapes, and 70% for fluxes. Good air circulation should be ensured in storage areas. Materials in vacuum packs do not require special storage conditions.

The period of storage in the intact factory packaging for wrapped electrodes is 3-5 years, for wires, rods, fluxes and tapes for about 2 years, is unlimited for stainless steel and vacuum-packed products. In special cases the storage period is determined by the manufacturer.

The conditions presented are general, as no national and European standard specifies recommendations for storage and transport of welding consumables.

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