



NEW PRODUCT



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IRONWORKER® KITS **Pros**

IRONWORKER KITS

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IRONWORKER® KITS

IRONWORKER® ACETYLENE KIT WITH STAINLESS STEEL DIAPHRAGM REGULATORS
Cuts up to 1" plate, welds up to 1/16" with supplied tips. Cuts up to 8" plate, weld up to 1/2" Plate with larger tips.

PART #	Model #	TORCH HANDLE	FLASHBACK ARRESTORS		MIXER	CUTTING TIP	CUTTING ATTACHMENT	WELDING/ BRAZING TIPS	REGULATORS		ACCESSORIES	WEIGHT
			OXYGEN	FUEL					OXYGEN	FUEL		
4400359	HV3145S-300 DLX	VH31	88-5N FBTR	88-5N FBTL	V-W	V1-101-1	VH24	23A90-3	45S-145-540	45S-15-300	<ul style="list-style-type: none">GogglesStrikerTip CleanerReplacement Flints20' x 1/4" Grade R HoseCooler Bag	18 lbs./ 8.16 kg
4400358	HV3145S-510 DLX	VH31	88-5N FBTR	88-5N FBTL	V-W	V1-101-1	VH24	23A90-3	45S-145-540	45S-15-510		



MODEL SHOWN:
IRONWORKER DLX KIT
P/N: 4400359



MODEL SHOWN:
IRONWORKER DLX KIT
P/N: 4400358

IRONWORKER® 2 ACETYLENE KIT WITH NEOPRENE DIAPHRAGM REGULATORS
Cuts up to 1" plate. Cuts up to 8" plate, weld up to 1/2" Plate with larger tips.

PART #	Model #	TORCH HANDLE	FLASHBACK ARRESTORS		MIXER	CUTTING TIP	CUTTING ATTACHMENT	WELDING/ BRAZING TIPS	REGULATORS		ACCESSORIES	WEIGHT
			OXYGEN	FUEL					OXYGEN	FUEL		
4400361	HV3145-300 DLX	VH31	88-5N FBTR	88-5N FBTL	-	V1-101-1	VH24	-	45-145-540	45-15-300	<ul style="list-style-type: none">GogglesStriker20' x 1/4" Grade R HoseCooler Bag	17 lbs./ 7.71 kg
4400360	HV3145-510 DLX	VH31	88-5N FBTR	88-5N FBTL	-	V1-101-1	VH24	-	45-145-540	45-15-510		



MODEL SHOWN:
IRONWORKER 2 DLX KIT
P/N: 4400360



MODEL SHOWN:
IRONWORKER 2 DLX KIT
P/N: 4400361

Orders: 1.800.241.0804

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45&45S

MODEL



HEAVY DUTY REGULATORS

MODEL SHOWN:
45S-145-540

DESCRIPTION

These single stage regulators are available with neoprene diaphragms (Model 45) or stainless steel diaphragms (Model 45S) for extra safety, longer life, and greater dependability. All Model 45 and Model 45S regulators have internal, tamper-proof high pressure safeties. The model 45S features a self-reseating high pressure safety.

DETAILS

Capacity: Heavy duty

C_v: 0.17

Gauges: 2.5" brass

Seat: One-piece encapsulated seat design with PTFE Teflon® seat

Pressure Regulation:

.2 PSI/100 PSIG-45

.3 PSI/ 100 PSIG-45S

Certifications: CGA E-4

Weight: OXYGEN 3.88 lbs./ 1.76 kg.

FUEL 3.81 lbs./ 1.72 kg.

Featured in Ironworker® and Ironworker® 2 kits



PART #	Model #	GAS	MAX. INLET PSIG	DELIVERY PRESSURE RANGE PSIG	SUPPLY PRESSURE GAUGE PSIG	INLET CONNECTION	OUTLET CONNECTION
3001776	45S-145-540	OXYGEN	3000	0 - 145	4000	CGA 540	1/8" - 18RH
3001777	45S-15-510	ACETYLENE	500	0 - 15	400	CGA 510	1/8" - 18LH
3001778	45S-15-300	ACETYLENE	500	0 - 15	400	CGA 300	1/8" - 18LH
3001781	45-145-540	OXYGEN	3000	0 - 145	4000	CGA 540	1/8" - 18RH
3001782	45-15-510	ACETYLENE	500	0 - 15	400	CGA 510	1/8" - 18LH
3001783	45-15-300	ACETYLENE	500	0 - 15	400	CGA 300	1/8" - 18LH

VH24

MODEL



VICTOR® COMPATIBLE CUTTING ATTACHMENT

MODEL SHOWN:
VH24

DESCRIPTION

The Model VH24 is a Victor® compatible heavy duty cutting attachment. The mixer design resists damage due to flashback. It is equipped with a durable stainless steel lever, has a coupling nut with locking ring to protect cutting attachment seat, and the cutting oxygen valve has an ease-on feature for more precise control.

DETAILS

Capacity: Cuts to 8" / 203.2mm

Duty: Heavy

Length: 12 1/8" / 307.9mm

Weight: 2.41 lbs/ 1.09 kg.

Mixer Type: Equal pressure

Where Used: Heavy fabrication, construction, ship building, pipeline connection

Featured in Ironworker® and Ironworker® 2 kits



					TIP STYLES
PART #	Model #	HEAD ANGLE	COMPATIBLE HANDLES	ACET/H ₂	ALTERNATE* FUEL
1300452	VH24	90°	VH31	V-101, V-101AC	1-GPN, GPP

*Propylene or propane-based fuels and natural gas.

VH31

MODEL

1YR WARRANTY

VICTOR® COMPATIBLE COMBINATION HANDLE

MODEL SHOWN: VH31

DESCRIPTION

The model VH31 is a Victor® compatible heavy duty combination handle for welding, brazing, heating and cutting. It is designed to offer the highest flow possible allowing the use of larger tips. The handle is designed with a tube within a tube construction and is o-ring sealed for greater strength and higher capacity.

DETAILS

Capacity:

Welds to 1/2" / 12.7mm; cuts to 8" / 203.2mm

Duty:

Heavy

Length:

11" / 279.4mm


Weight:

1.91 lbs. / 0.86 kg.







Host Connection:



9/16-18 "B" FITTING


All VH31 handles include model 88-5N FBT&R flashback arrestors installed.



Featured in Ironworker® and Ironworker® 2 kits

WELDING/BRAZING/HEATING		MIXERS	TIP TUBE	WELDING/BRAZING TIP STYLE		HEATING TIP STYLE	
PART #	Model #	COMPATIBLE MIXER(S)	COMPATIBLE TIP TUBE(S)	ACET/H ₂ (SIZE)	ALT. FUEL (SIZE)	ACET/H ₂	ALT. FUEL
							
1400422	VH31	V-W	8593	23A90-3 (0-10)	1390-N (2-80N)	J-63 (1-3)	1390 (H, 3H, B)
Example of Heating Combination: VH31 + V-W + 23A90-3							

CUTTING			
PART #	Model #	COMPATIBLE CUTTING ATTACHMENT	CUTTING TIP STYLE
			
		VH24	V1-101
1400422	VH31	VH24	V-101, V-101AC
Example of Cutting Combination: VH31+VH24+ V1-101			



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V1-101

MODEL

1YR WARRANTY

GENERAL PREHEAT SINGLE PIECE VICTOR® COMPATIBLE HAND CUTTING TIPS

MODEL SHOWN: V1-101

DESCRIPTION

A single piece acetylene hand cutting tip for relatively clean steel. The V1-101 is compatible with Victor® style torches.

DETAILS

Construction:

One-piece

Preheat Type:


General

Where Used:

Metal fabrication, maintaince, shipbuilding

Compatible Equipment:

C9 Tip cleaner P/N: 9000156



			OPERATING PRESSURES		
PART #	TIP SIZE#	DEPTH OF CUT	OXYGEN PSIG	ACETYLENE PSIG	DRILL CUT SIZE
1502088	000	LIGHT GAUGE to 1/8"	20-30	5	#70
1502089	00	1/8" - 5/16"	20-30	5	#69
1502090	0	5/16" - 5/8"	30-40	7	#61
1502091	1	5/8" - 1"	40-50	7	#56
1502092	2	1" - 2"	45-55	8	#53
1502093	3	2" - 3"	50-60	9	#50
1502094	4	3" - 4"	60-75	10	#46
1502095	5	4" - 6"	70-80	11	#39
1502096	6	6"	75-80	12	#31

*For best performance use 3/4" I.D. hose for tip sizes 6 and larger

V1-101AC

MODEL

1YR WARRANTY

HEAVY PREHEAT TWO PIECE VICTOR® COMPATIBLE HAND CUTTING TIP

MODEL SHOWN: V1-101AC

DESCRIPTION

A two piece acetylene handcutting tip for scaled, painted or rusted plate. The V1-101AC is compatible with V-Series and Victor® style torches.

DETAILS

Construction:

Two piece

Preheat Type:


Heavy

Where Used:

Construction, demolition maintenance

Compatible Equipment:

E-9 Tip cleaner P/N: 9000160





			OPERATING PRESSURES		
PART #	TIP SIZE#	DEPTH OF CUT	OXYGEN PSIG	ACETYLENE PSIG	DRILL CUT SIZE
1502069	000	LIGHT GAUGE to 1/8"	20-25	3-5	# .031
1502070	00	1/8" - 1/4"	20-25	3-5	# .036
1502071	0	1/4" - 1/2"	25-35	7	# .040
1502072	1	1/2" - 3/4"	30-35	3-5	# .046
1502073	2	3/4" - 1 1/2"	35-45	3-7	# .059
1502074	3	1 1/2" - 3 1/2"	40-50	4-10	# .067
1502075	4	1 1/2" - 2 1/2"	40-50	5-10	# .093
1502076	5	2 1/2"-3	45-55	5-13	# .110
1502077	6*	5-8	45-55	7-14	# .120

*For best performance use 3/4" I.D. hose for tip sizes 6 and larger

Orders: 1.800.241.0804

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23A90

MODEL



ACETYLENE WELDING AND BRAZING TIPS

MODEL SHOWN:
23A90

DESCRIPTION

Model 23A90 tips are manufactured using environmentally-friendly tellurium copper that has excellent machining properties resulting in a higher quality tip. They are swaged for more precise and consistent flames. They use a universal style mixer design for sizes 0-10, eliminating the expense of using a different mixer for every tip size. All 23A90 tips have a metal-to-metal seat, virtually eliminating possible thread leaks and the need for thread sealants. Most sizes are for use with mixer V-W.



DETAILS

Warranty: 1 year

Where Used:

Fabricating, maintenance

Compatible Equipment:

C-9 Tip cleaner P/N: 9000156

			EQUAL PRESSURE				
PART #	TIP SIZE	METAL THICKNESS INCHES	OXYGEN PSIG	ACETYLENE PSIG	ACETYLENE SCFH *	RECOMMENDED HOSE ID **	TIP THREAD
1600840	0	1/64"	1	1	1 - 3	3/16"	23/64 - 26
1600850	1	1/32"	1	1	2 - 5	3/16"	23/64 - 26
1600860	2	3/64"	2	2	3 - 8	3/16"	23/64 - 26
1600870	3	1/16"	3	3	5 - 11	3/16"	23/64 - 26
1600880	4	3/32"	4	4	6 - 14	3/16"	23/64 - 26
1600890	5	1/8"	5	5	8 - 18	3/16"	23/64 - 26
1600900	6	3/16"	6	6	10 - 20	3/16"	23/64 - 26
1600910	7	1/4"	7	7	13 - 25	3/16"	23/64 - 26
1601920	8	3/8"	8	8	16 - 32	3/16"	23/64 - 26
1600930	9	3/8"	9	9	20 - 37	1/4"	23/64 - 26
1600940	10	1/2"	10	10	24 - 42	1/4"	23/64 - 26
1600960	13***	3/4"	13	13	30 - 50	3/8"	1/2 - 25
1600970	15***	1"	15	15	35 - 65	3/8"	1/2 - 25

* Oxygen SCFH is equal to 1.1 times acetylene for neutral flame.

** Hose sizes are suitable for hoses up to 25'; for longer hoses higher pressures should be used.

*** For tip sizes 13 and 15 use Model V-W-2 (9105214) mixer

Observe 1/4th acetylene rule when determining gas supply.

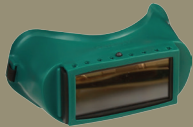
23A90 WELDING & BRAZING TIPS

- 1 Are made from lead-free, environmentally friendly tellurium copper that has excellent machinability characteristics resulting in a higher quality tip with more precise flames.
- 2 Are swaged for more precise and consistent flames.
- 3 Use a universal mixer that fits the complete line of sizes (0-10) eliminating the extra expense of requiring a special mixer for each tip size.
- 3 Have a metal to metal mixer contact seat virtually eliminating thread leaks and the need for thread sealants.

ACCESSORIES



8855094
COOLER BAG



4304482
GOGGLE, GRN/#5 LENS



9105214
MIXER ASSEMBLY, V-W



9000156
TIP-CLEANER, C-9 HARRIS



9004484
FLINTS, BOX 26-L



4300498
20' x 1/4" TWIN
GRADE "R" WELD HOSE



9004486
IGNITOR, #26



4301628
Oxygen 88-5N FBTR
4301629
Fuel 88-5N FBTL



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STRIVE TO REDUCE
OVERALL COSTS,
HARRIS CAN ASSIST IN
THOSE EFFORTS.
OUR TECHNICAL TEAM IS
FOCUSED ON COST REDUCTION
SOLUTIONS FOR SPECIFIC
APPLICATIONS IN YOUR PLANT.**

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