

GRASP THE BENEFIT OF VERSATILITY AND MANEUVERABILITY

PRO-TORCH™ TIG TORCHES



KEY FEATURES

PRO-Torch™ TIG Torches are used for a variety of applications in aerospace, motorsports, education, power plant construction, job shops, tool and die work, construction sites and production plants. Light and easy to use, these torches give you the power of maximum versatility and maneuverability.

- Wide range of both air-cooled and water-cooled torches
- “F” model torches feature a flexible head for greater comfort and improved access to tight spaces
- “V” model torches have a convenient gas valve on the torch to easily control shielding gas flow for power sources that do not have built in gas solenoid valves

Processes »
TIG

Product Number »
See back for details

KEY FEATURES Continued

- Select TIG torch models are available with Ultra-Flex™ power cable providing over five times the flexibility of a standard power cable
- Comfortable knurled handle for a non-slip sure grip and precise control
- Molded lip on torch handle allows cable cover to be securely attached to torch handle
- 1-piece cables consist of a power conductor inside a rubber hose. 2-piece cables consist of a separate power conductor and a braided hose
- One-year Lincoln Electric warranty on torch

Gas Control Valve Models



Manual Gas Valve

Flexible Head Models



1-Pc. Vs. 2-Pc. Cable Ends



Ultra-Flex Cable Models



Recommended Accessories

Twist-Mate™ Adapters, Collets, Collet Bodies, Gas Lens Collet Bodies, Alumina Nozzles, and Parts Kits including Tungsten Electrodes.

Expendable parts are also interchangeable with industry standard torches. Use the Industry Reference Numbers as a cross reference guide to order Lincoln Electric premium replacement parts.

Available Torches



PTA-9
Air-cooled TIG torch, rated 125 amps at 60% duty cycle.



PTW-20
Water-cooled TIG torch, rated 250 amps at 100% duty cycle.



PTA-17, PTA-17V, PTA-17F and PTA-17FV
Air-cooled TIG torch, rated 150 amps at 60% duty cycle. The PTA-17V is equipped with a valve for gas flow control. The PTA-17F is equipped with a flexible head for easy maneuverability into tight spaces. The PTA-17FV is equipped with both a gas valve and a flexible head.



PTW-18
Water-cooled TIG torch, rated 350 amps at 100% duty cycle.



Ultra-Flex PTA-9F TIG Torch Package
This torch package includes a PTA-9F flex head torch with a 12.5 ft. (3.8 m) Ultra-Flex cable and K1622-1 Twist-Mate adapter. Also includes a 1/16 in. (1.6 mm) gas lens collet body, collet and gas lens for connection to Square Wave™ TIG 175, Precision TIG® 225 and Invertec® V160-T power sources.



20H-320-25R
20 Series Heavy Duty 320 amp water-cooled TIG torch, rated 320 amps at 100% duty cycle. Includes cable cover.



PTA-26, PTA-26V, PTA-26F and PTA-26FV
Air-cooled TIG torch, rated 200 amps at 60% duty cycle. The PTA-26V is equipped with a valve for gas flow control. The PTA-26F is equipped with a flexible head for easy maneuverability into tight spaces. The PTA-26FV is equipped with both a gas valve and flexible head.

What You Need To Get Started

Along with your Pro-Torch TIG torch, you may need to purchase the following accessories to begin welding:

TIG Torch Adapter

A variety of adapters exist to connect to a variety of output terminals such as 1/2 in. (12.7 mm) studs, Twist-Mate output terminals and Precision TIG-style connectors.

Collets

These hold the tungsten firmly in your torch. They are purchased according to the tungsten size and must be used with the proper corresponding collet bodies, or gas lens collet bodies.

Collet Bodies and Gas Lens Collet Bodies

Collet bodies hold the collet and tungsten in place. Gas lens collet bodies are used in conjunction with gas lenses when precise control of shielding gas flow is required.

Alumina Nozzles

These nozzles, made of high temperature ceramic material, protect the collet body and direct the gas flow to the weld. Choose them according to the chart on this page 7, for your specific application.

Back Cap

Each torch comes with one back cap which is sufficient for most applications. PTA-9 and PTW-20 torches include a medium back cap. PTA-17, PTA-26 and PTW-18 torches include a long back cap. The 20H-320-25R includes a medium back cap. However, optional longer or shorter back caps are available for each torch.

Tungsten Electrode

Your welding supplier can provide you with the proper electrode for your application. Use the chart listed below, as a guide for ordering the appropriate tungsten.

Parts Kits

Parts Kits conveniently provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box.

Tungsten - Pure Tungsten Is Not Recommended For Inverter Based Power Sources

COLOR	TUNGSTEN TYPES	AC POLARITY	DC POLARITY	APPLICATIONS
Gold	1.5% Lanthanum		•	Good choice for welding titanium, nickel, copper, mild steel and stainless steel
Blue	2% Lanthanum	•	•	Good all around choice for both AC and DC, in welding low alloyed and non-corroding steels, aluminum, magnesium, titanium, nickel, and copper
Grey	2% Ceriated	•	•	
Chartreuse or Purple	1.5% Lanthanum, 0.08% Zirconium, 0.08% Yttrium	•	•	A very good choice for aluminum or magnesium alloys
White	0.08% Zirconiated	•		

Tungsten Diameter in (mm)	Cup Size	DC- Polarity Amp Range	AC Polarity Amp Range	
		Pure Tungsten and Tungsten with oxide additives	Tungsten with oxide additives	Pure Tungsten
0.020 (0.5)	3, 4 or 5	2-20	2-20	2-15
0.040 (1)	4 or 5	15-80	15-80	10-60
1/16 (1.6)	4, 5 or 6	70-150	70-150	50-100
3/32 (2.4)	6, 7 or 8	150-250	140-235	100-160
1/8 (3.2)	7, 8 or 10	250-400	225-325	150-210
5/32 (4)	8 or 10	400-500	300-400	200-275

TUNGSTEN SHAPING



Tungsten should have a slightly blunted tip.

Lincoln Electric Tungsten Electrodes

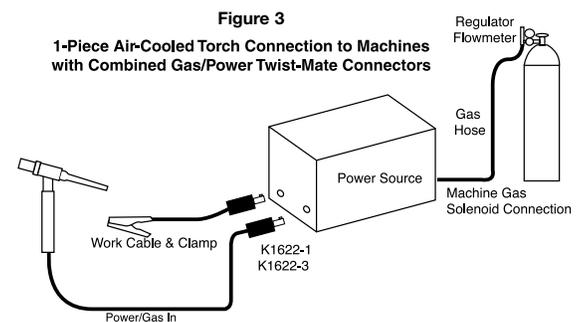
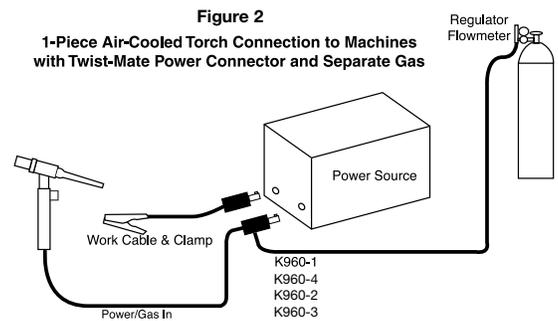
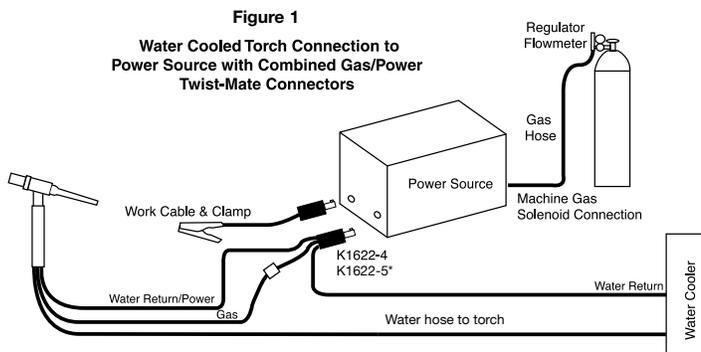
Classification	Color	Part Numbers	Diameter Range in [mm]
2% Lanthanated	Blue	KP4721-XXX	.020-5/32 [0.5-4.0]
2% Ceriated	Grey	KP4722-XXX	.020-5/32 [0.5-4.0]
WX Multi-Oxide	Purple	KP4723-XXX	

TIG TORCH CONNECTION ADAPTERS

These adapters connect the TIG torch cables to the power source. May be required for certain torches.

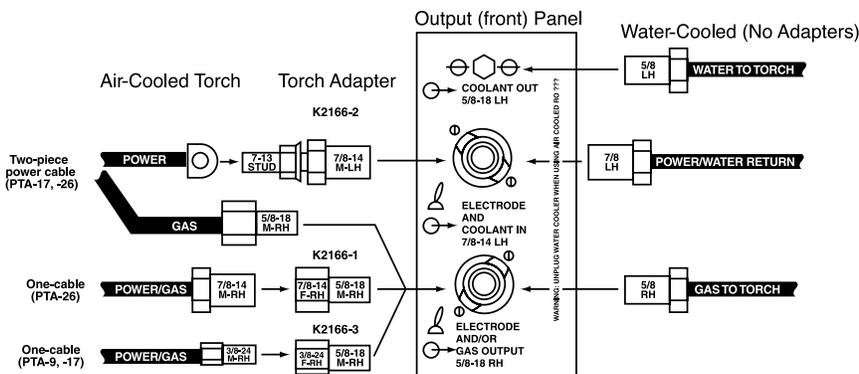
DESCRIPTION	PART NO.	FIGURE
PRECISION TIG 275 & 375 POWER SOURCES		
PTA-9, 9F, 17F, 17V, 17FV one piece cable	K2166-3	4
PTA-17V, -26V two piece cable	K2166-2	4
PTA-26, 26V, 26F, 26FV one piece cable	K2166-1	4
PTW-18, 20 and 20H-320	No adapter required	-
FOR POWER SOURCES WITH 1/2 IN OUTPUT TERMINALS (INCLUDING THE TIG MODULE)		
PTA-9 17, 17F, 17V, 17FV one piece cable	K2505-2, K1622-1	-
PTA-17V, 26V two piece cable	No adapter required	-
PTA-26, 26F, 26V, 26FV one piece cable	K2505-2, K1622-3	-
PTW-18, 20 and 20H-320	K2505-2, K1622-4	-
FOR SQUARE WAVE TIG 200, PRECISION TIG 225, INVERTEC V160-T, AND ASPECT® 375 AND POWER SOURCES WITH TWIST-MATE RECEPTACLE (WITH GAS PASS THROUGH)		
PTA-9, -9F, 17, 17F, 17V, 17FV one piece cable	K1622-1	3
PTA-26, 26V, 26F, 26FV one piece cable	K1622-3	3
PTW-18, 20 and 20H-320	K1622-4, K1622-5* *(recommended for the Aspect 375)	1
FOR INVERTEC V155-S AND POWER SOURCES WITH SMALL TWIST-MATE RECEPTACLE AND SEPARATE GAS		
PTA-17V, 17FV one piece cable	K960-2	2
FOR POWER SOURCES WITH TWECO STYLE OUPUT TERMINAL AND SEPARATE GAS		
PTA-17V, 17FV one piece cable	K960-4	2
PTA-26V, 26FV one piece cable	K960-3	2
PTW-18, 20, 20H-320	K1622-6	-
FOR POWER MIG® 210 MP AND POWER SOURCES WITH TWIST-MATE RECEPTACLE AND SEPARATE GAS		
PTA-17V, 17FV one piece cable	K960-1	2
FOR POWER MIG® 350 MP AND POWER WAVE® C300		
PTA-17, 17F, 17V, 17FV one piece cable	K2505-3, K1622-1	-
PTA-26, 26F, 26V, 26FV one piece cable	K2505-3, K1622-3	-

- Use K2505-1 for connecting Twist-Mate Adapter with gas pass through to Twist-Mate receptacle without gas pass through (separate gas).



TIG TORCH CONNECTION ADAPTERS

Figure 4
Precision TIG 275 & 375



PARTS KITS

Parts Kits provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box. Five kits are available.

KP507 (For PTA-9 Series Air-Cooled Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP4745-L	41V24	Back Cap	Long
1	KP4749-040	13N21	Collet	.040 (1.0)
1	KP4749-116	13N22	Collet	1/16 (1.6)
1	KP4751-040	13N26	Collet Body	.040 (1.0)
1	KP4751-116	13N27	Collet Body	1/16 (1.6)
1	KP4755-4	13N08	Alumina Nozzle	1/4 (6.0)
1	KP4755-5	13N09	Alumina Nozzle	5/16 (8.0)
1	KP4755-6	13N10	Alumina Nozzle	3/8 (10.0)
1	KP4722-040		Tungsten Electrode, 2% Ceriated .040 X 7.0 in. (1.0 x 178 mm)	
1	KP4722-116		Tungsten Electrode, 2% Ceriated 1/16 X 7.0 in. (1.6 x 178 mm)	

KP508 (For PTA-17 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP4746-S	57Y04	Back Cap	Short
1	KP4750-040	10N22	Collet	.040 (1.0)
1	KP4750-116	10N23	Collet	1/16 (1.6)
1	KP4750-332	10N24	Collet	3/32 (2.4)
1	KP4752-040	10N30	Collet Body	.040 (1.0)
1	KP4752-116	10N31	Collet Body	1/16 (1.6)
1	KP4752-332	10N32	Collet Body	3/32 (2.4)
1	KP4756-4	10N50	Alumina Nozzle	1/4 (6.0)
1	KP4756-5	10N49	Alumina Nozzle	5/16 (8.0)
1	KP4756-6	10N48	Alumina Nozzle	3/8 (10.0)
1	KP4722-040		Tungsten Electrode, 2% Ceriated .040 X 7.0 in. (1.0 x 178 mm)	
1	KP4722-116		Tungsten Electrode, 2% Ceriated 1/16 X 7.0 in. (1.6 x 178 mm)	
1	KP4722-332		Tungsten Electrode, 2% Ceriated 3/32 X 7.0 in. (2.4 x 178 mm)	

PARTS KITS

KP509 (PTW-18, PTA-26 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP4746-S	57Y04	Back Cap	Short
1	KP4750-116	10N23	Collet	1/16 (1.6)
1	KP4750-332	10N24	Collet	3/32 (2.4)
1	KP4750-18	10N25	Collet	1/8 (3.2)
1	KP4752-116	10N31	Collet Body	1/16 (1.6)
1	KP4752-332	10N32	Collet Body	3/32 (2.4)
1	KP4752-18	10N28	Collet Body	1/8 (3.2)
1	KP4756-5	10N49	Alumina Nozzle	5/16 (8.0)
1	KP4756-6	10N48	Alumina Nozzle	3/8 (10.0)
1	KP4756-8	10N46	Alumina Nozzle	1/2 (12.5)
1	KP4722-040		Tungsten Electrode, 2% Ceriated 1/16 X 7.0 in. (1.6 x 178 mm)	
1	KP4722-116		Tungsten Electrode, 2% Ceriated 3/32 X 7.0 in. (2.4 x 178 mm)	
1	KP4722-332		Tungsten Electrode, 2% Ceriated 1/8 X 7.0 in. (3.2 x 178 mm)	

KP510 (For PTW-20, 20H-320 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP4745-L	41V24	Back Cap	Long
1	KP4749-116	13N22	Collet	1/16 (1.6)
1	KP4749-332	13N23	Collet	3/32 (2.4)
1	KP4749-18	13N24	Collet	1/8 (3.2)
1	KP4751-116	13N27	Collet Body	1/16 (1.6)
1	KP4751-332	13N28	Collet Body	3/32 (2.4)
1	KP4751-18	13N29	Collet Body	1/8 (3.2)
1	KP4755-5	13N09	Alumina Nozzle	5/16 (8.0)
1	KP4755-6	13N10	Alumina Nozzle	3/8 (10.0)
1	KP4755-8	13N11	Alumina Nozzle	1/2 (12.5)
1	KP4722-116		Tungsten Electrode, 2% Ceriated 1/16 X 7.0 in. (1.6 x 178 mm)	
1	KP4722-332		Tungsten Electrode, 2% Ceriated 3/32 X 7.0 in. (2.4 x 178 mm)	
1	KP4722-18		Tungsten Electrode, 2% Ceriated 1/8 X 7.0 in. (3.2 x 178 mm)	

KP2414-1 Gas Lens Parts Kit (For PTA-9, PTW-20, 20H-320 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP4745-L	41V24	Back Cap	Long
1	KP4749-040	13N21	Collet	.040 (1.0)
1	KP4749-116	13N22	Collet	1/16 (1.6)
1	KP4749-332	13N23	Collet	3/32 (2.4)
1	KP4753-040	45V42	Gas Lens Collet Body	.040 (1.0)
1	KP4753-116	45V43	Gas Lens Collet Body	1/16 (1.6)
1	KP4753-332	45V44	Gas Lens Collet Body	3/32 (2.4)
1	KP4757-5	53N59	Gas Lens Nozzle	5/16 (8.0)
1	KP4757-6	53N60	Gas Lens Nozzle	3/8 (10.0)
1	KP4757-7	53N61	Gas Lens Nozzle	7/16 (11.1)
1	KP4722-040		Tungsten Electrode, 2% Ceriated .040 X 7.0 in. (1.0 x 178 mm)	
1	KP4722-116		Tungsten Electrode, 2% Ceriated 1/16 X 7.0 in. (1.6 x 178 mm)	
1	KP4722-332		Tungsten Electrode, 2% Ceriated 3/32 X 7.0 in. (2.4 x 178 mm)	

Parts shown are not actual size.

EXPENDABLE PARTS

COLLET



FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP4749-020	13N20	0.020 (0.5)
	KP4749-040	13N21	0.040 (1.0)
	KP4749-116	13N22	1/16 (1.6)
	KP4749-332	13N23	3/32 (2.4)
	KP4749-18	45V24	1/8 (3.2)

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP4750-020	10N21	0.020 (0.5)
	KP4750-040	10N22	0.040 (1.0)
	KP4750-116	10N23	1/16 (1.6)
	KP4750-332	10N24	3/32 (2.4)
	KP4750-18	10N25	1/8 (3.2)
	KP4750-532	54N20	5/32 (4.0)

COLLET BODY



FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP4751-020	13N25	0.020 (0.5)
	KP4751-040	13N26	0.040 (1.0)
	KP4751-116	13N27	1/16 (1.6)
	KP4751-332	13N28	3/32 (2.4)
	KP4751-18	13N29	1/8 (3.2)

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP4752-020	10N29	0.020 (0.5)
	KP4752-040	10N30	0.040 (1.0)
	KP4752-116	10N31	1/16 (1.6)
	KP4752-332	10N32	3/32 (2.4)
	KP4752-18	10N28	1/8 (3.2)
	KP4752-532	406488	5/32 (4.0)

ALUMINA NOZZLES



FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP4755-4	13N08	1/4 (6)	4	1-5/32 in (29.3 mm)
	KP4755-5	13N09	5/16 (8)	5	
	KP4755-6	13N10	3/8 (10)	6	
	KP4755-7	13N11	7/16 (11)	7	
	KP4755-8	13N12	1/2 (12.5)	8	
	KP4755-10	13N13	5/8 (16)	10	

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP4756-4	10N50	1/4 (6)	4	1-5/32 in (29.3 mm)
	KP4756-5	10N49	5/16 (8)	5	
	KP4756-6	10N48	3/8 (10)	6	
	KP4756-7	10N47	7/16 (11)	7	
	KP4756-8	10N46	1/2 (12.5)	8	
	KP4756-10	10N45	5/8 (16)	10	

Parts shown are not actual size.

EXPENDABLE PARTS

GAS LENS COLLET BODIES



FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body	KP4753-020	45V41	0.020 (0.5)
	KP4753-040	45V42	0.040 (1.0)
	KP4753-116	45V43	1/16 (1.6)
	KP4753-332	45V44	3/32 (2.4)
	KP4753-18	45V45	1/8 (3.2)

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body ¹	KP4754-020	45V29	0.020 (0.5)
	KP4754-040	45V24	0.040 (1.0)
	KP4754-116	45V25	1/16 (1.6)
	KP4754-332	45V26	3/32 (2.4)
	KP4754-18	45V27	1/8 (3.2)
	KP4754-532	45V28	5/32 (4.0)

ALUMINA GAS LENS NOZZLES



FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle	KP4757-4	53N58	1/4 (6)	4	1 in (25.4 mm)
	KP4757-5	53N59	5/16 (8)	5	
	KP4757-6	53N60	3/8 (10)	6	
	KP4757-7	53N61	7/16 (11)	7	
	KP4757-8	53N61S	1/2 (12.5)	8	

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle ²	KP4758-4	54N18	1/4 (6)	4	1-5/8 in (41.3 mm)
	KP4758-5	54N17	5/16 (8)	5	
	KP4758-6	54N16	3/8 (10)	6	
	KP4758-7	54N15	7/16 (11)	7	
	KP4758-8	54N14	1/2 (12.5)	8	
	KP4758-11	54N19	11/16 (17)	11	1-1/8 in (28.5 mm)

BACK CAPS



(1) Note: Use of these Gas Lens Collet Bodies requires a KP4748-GL (54N01) Gas Lens Insulator

(2) Note: Use of these Alumina Gas Lens Nozzles requires a KP4748-GL (54N01) Gas Lens Insulator

FOR PTA-9, PTW-20 & 20H-320 SERIES TORCHES

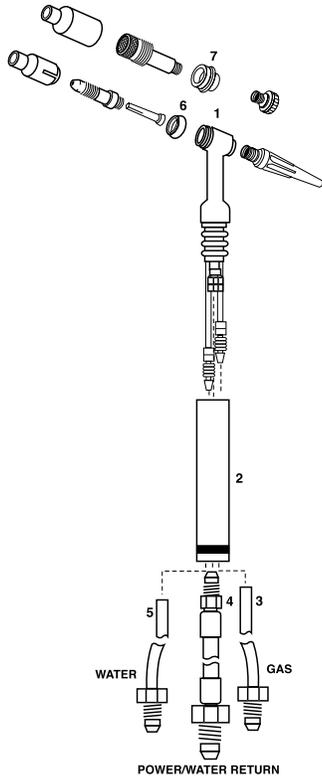
Name	Part No.	Industry Ref. No.	Length
Back Caps	KP4745-S	41V33	Short
	KP4745-M	41V35	Medium
	KP4745-L	41V24	Long

FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Length
Back Caps	KP4746-S	57Y04	Short
	KP4746-M	57Y03	Medium
	KP4746-L	57Y04	Long

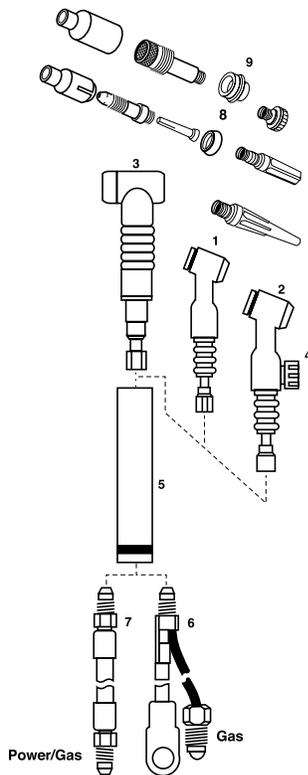
Parts shown are not actual size.

REPLACEMENT PARTS



FOR PTW-18 SERIES & PTW-20 SERIES TORCHES

Item No.	Part No.	Industry Ref. No.	Description ft. (m)
1	S19261-1	—	Torch body with gaskets, PTW-18
1	S19262-1	—	Torch body with gaskets, PTW-20
2	S19511-2	—	Torch Handle, PTW-18
2	S19511-1	—	Torch Handle, PTW-20
3	S19512-17	40V75	Gas Hose, 12.5 (3.8), PTW-18
3	S19512-20	40V30	Gas Hose, 25 (7.6), PTW-18
3	S19512-11	45V09	Gas Hose, 12.5 (3.8), PTW-20
3	S19512-14	45V10	Gas Hose, 25 (7.6), PTW-20
4	S19512-15	40V64	Power Cable, 12.5 (3.8), PTW-18
4	S19512-9	45V03	Power Cable, 12.5 (3.8), PTW-20
4	S19512-18	41V29	Power Cable, 25 (7.6), PTW-18
4	S19512-12	45V04	Power Cable, 25 (7.6), PTW-20
5	S19512-16	40V74	Water Hose, 12.5 (3.8), PTW-18
5	S19512-10	45V07	Water Hose, 12.5 (3.8), PTW-20
5	S19512-19	41V32	Water Hose, 25 (7.6), PTW-18
5	S19512-13	45V08	Water Hose, 25 (7.6), PTW-20
6	S19515-7	18CG	Cup Gasket, 2 pack, PTW-18
6	S19515-6	598882	Cup Gasket, 2 pack, PTW-20
7	KP2037-3B1	54N01	Gas Lens Insulation, 2 pack, PTW-18



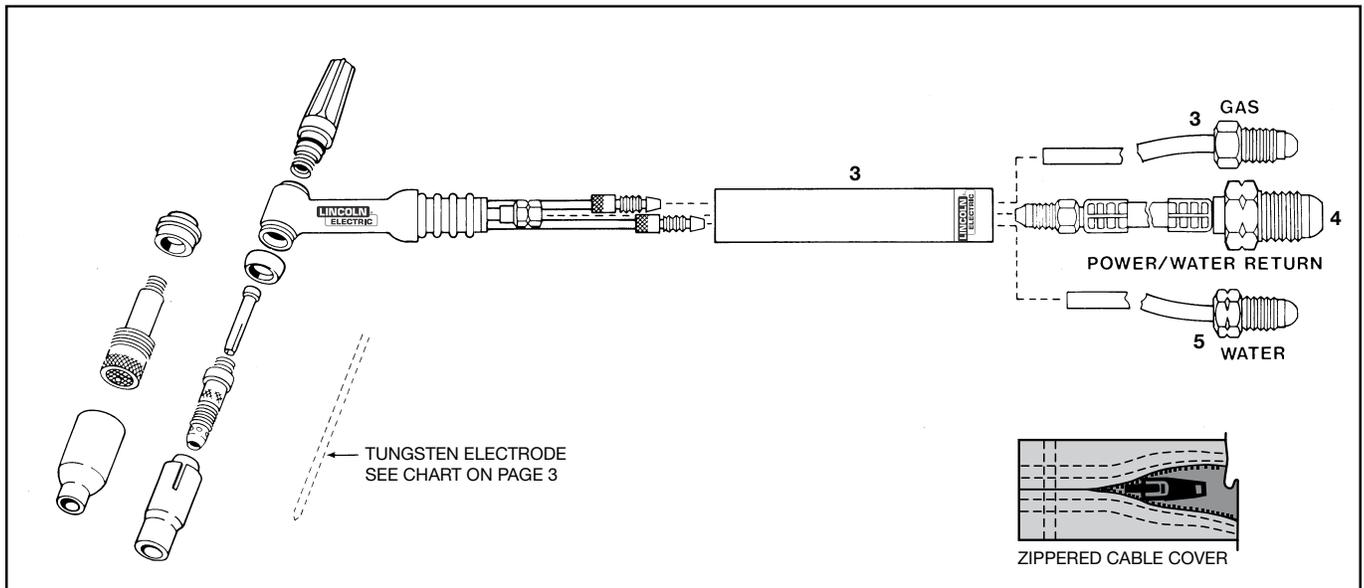
PTA-9, -17, -26 SERIES AIR-COOLED REPLACEMENT PARTS

Item No.	Part No.	Industry Ref. No.	Description ft. (m)
1	S19258-1	—	Torch body with gaskets, PTA-9
1	S19259-1	—	Torch body with gaskets, PTA-17
1	S19260-1	—	Torch body with gaskets, PTA-26
2	S19259-2	—	Torch body with gaskets, PTA-17V
2	S19260-2	—	Torch body with gaskets, PTA-26V
3	S24923-1	—	Torch Body with gaskets, PTA-17F
3	S24925-1	—	Torch Body with gaskets, PTA-26F
4	S19515-1	VS-2	Valve Knob with "O" Ring, PTA-17V
4	S19515-2	VS-1	Valve Knob with "O" Ring, PTA-26V
5	S19511-1	—	Torch Handle, PTA-9, 17, 17V
5	S19511-2	—	Torch Handle, PTA-26, 26V
6	S19512-2	57Y01-2	Power Cable and Gas, 2Pc, 12.5 (3.8), PTA-9, 17
6	S19512-6	46V28-2	Power Cable and Gas, 2Pc, 12.5 (3.8), PTA-26,
6	S19512-4	57Y03-2	Power Cable and Gas, 2Pc, 25 (7.6), PTA-9
6	S19512-8	46V30-2	Power Cable and Gas, 2Pc, 25 (7.6), PTA-26
7	S19512-1	57Y01R	Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-9, 17,
7	S19512-5	46V28R	Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-26,
7	S19512-3	57Y03R	Power Cable and Gas, 1Pc, 25 (7.6), PTA-9, 17
7	S19512-7	46V30R	Power Cable and Gas, 1Pc, 25 (7.6), PTA-26
7	S25811-1	57Y01BR	Ultra-Flex Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-9, -17
7	S25811-2	46V28BR	Ultra-Flex Power Cable and Gas, 1Pc, 12.5 (3.8), PTA-26
8	S19515-6	598882	Cup Gasket, 2 pack, PTA-9
8a	S19515-7	18CG	Cup Gasket, 2 pack, PTA-17, 26
9	KP2037-3B1	54N01	Gas Lens Insulation, 2 pack, PTA-26, 17

REPLACEMENT PARTS

20H-320-25R WATER-COOLED 320 AMPS

Item No.	Part No.	Industry Ref No.	Description ft. (m)
1	S31183-4	-	Torch body, red silicone
2	S31183-5	-	Torch handle, fluted
3	S31183-2	45V10R	Gas hose, 25 [7.6]
4	S31183-1	45V04HR	Power cable, 25 [7.6]
5	S31183-3	45V08HR	Water hose, 25 [7.6]
6	KP4745-M	41V35	Medium cap
7	-	18CG	Cup gasket



RECOMMENDED GENERAL OPTIONS



TIG-Mate 17V Air-Cooled TIG Torch Starter Pack
 Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17V Ultra-Flex torch, parts kit, Harris' flowmeter/regulator, Twist-Mate adapter with 10 ft. (3.0 m) gas hose, and work clamp and cable.
Order K2265-1



TIG-Mate 17 Air-Cooled TIG Torch Starter Pack
 Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTA-17 Ultra-Flex torch, parts kit, Harris flowmeter/regulator, 10 ft. (3.0 m) gas hose, Twist-Mate adapter, and work clamp and cable.
Order K2266-1



TIG-Mate 20 Water-Cooled TIG Torch Starter Pack
 Get everything you need for TIG welding in one complete easy-to-order kit packaged in its own portable carrying case. Includes: PTW-20 torch, parts kit, Harris flowmeter/regulator, Twist-Mate adapter, 10 ft. (3.0 m) gas hose, water hose coupler and water hoses, work clamp and cable.
Order K2267-1



Hand Amptrol™
 Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6 pin plug connection). Velcro straps secure torch.
Order K963-3 [One size fits all Pro-Torch TIG Torches].



Zippered Cable Covers
 Optional zippered cable covers are available for 12.5 ft. (3.8 m) and 25 ft. (7.6 m) torches which protect the torch cables in high abrasion applications.
Order K918-1 [10 ft.]
Order K918-2 [22 ft.]



Foot Amptrol™
 Provides 25 ft. (7.6 m) of remote current control for TIG welding. (6 pin plug connection).
Order K870



Arc Start Switch
 May be used in place of the Foot or Hand Amptrol. Comes with a 25 ft. (7.6 m) cable. Attaches to the TIG torch for convenient finger control to start and stop the weld cycle at the current set on the machine.
Order K814

15 Foot TIG Torch Extension
 This extension has a male Twist-Mate connector on the power source side and a female connector on the torch side. Allows you to extend your torch length quickly for an extra 15 ft. (4.5 m) of reach. Rated 200A 60% duty cycle.
Order K2412-1

PRODUCT SPECIFICATIONS PTA-9, -17, -26 SERIES AIR-COOLED TIG TORCHES

Product Name	Part Number	Rated Amperage	Duty Cycle	Cable Length ft. (m)	Number of Cables	Tungsten Range in (mm)
PTA-9	K1781-1	125	60%	12.5 (3.8)	1	0.020 - 1/8 (0.8 - 3.2)
	K1781-3			25.0 (7.6)		
PTA-9F Ultra-Flex [®] Pkg.	K1781-9	125	60%	12.5 (3.8)	1	0.020 - 1/8 (0.8 - 3.2)
PTA-17	K1782-1	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-2			12.5 (3.8)	2	
	K1782-3			25.0 (7.6)	1	
	K1782-4			25.0 (7.6)	2	
PTA-17F	K1782-10	150	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-17FV	K1782-11	150	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-13			12.5 (3.8)		
PTA-17V	K1782-6	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1782-7			12.5 (3.8)	2	
	K1782-8			25.0 (7.6)	1	
	K1782-9			25.0 (7.6)	2	
PTA-17 Ultra-Flex	K1782-12	150	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0 mm)
PTA-26	K1783-1	200	60%	12.5 (3.8)	1	0.020 - 5/32 (0.5 - 4.0)
	K1783-2			12.5 (3.8)	2	
	K1783-3			25.0 (7.6)	1	
	K1783-4			25.0 (7.6)	2	
PTA-26F	K1783-10	200	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-26FV	K1783-11	200	60%	25.0 (7.6)	1	0.020 - 5/32 (0.5 - 4.0)
PTA-26V	K1783-7	200	60%	12.5 (3.8)	2	0.020 - 5/32 (0.5 - 4.0)
	K1783-8			25.0 (7.6)	1	
	K1783-9			25.0 (7.6)	2	

(1) Pre-configured package with K1622-1 Twist-Mate adapter and 1/16 in. (1.6 mm) gas lens collet body, collet and gas lens installed.

PRODUCT SPECIFICATIONS PTW-18, -20 & 20H-320 SERIES WATER-COOLED TIG TORCHES

Product Name	Part Number	Rated Amperage	Duty Cycle	Cable Length ft. (m)	Number of Cables	Tungsten Range in (mm)
PTW-18	K1784-1	350	100%	12.5 (3.8)	3	0.020 - 5/32 (0.5 - 4.0)
	K1784-2			25.0 (7.6)		
PTW-20	K1784-3	250	100%	12.5 (3.8)	3	0.020 - 1/8 (0.5 - 3.2)
	K1784-4			25.0 (7.6)		
20H-320-25R	K4168-2	320	100%	25.0 (7.6)	3	0.020 - 1/8 (0.5 - 3.2)

For best welding results with Lincoln Electric[®] equipment, always use Lincoln Electric consumables. Visit www.lincolnelectric.com for more details.

CUSTOMER ASSISTANCE POLICY

The business of The Lincoln Electric Company[®] is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

The Lincoln Electric Company
22801 St. Clair Avenue • Cleveland, OH • 44117-1199 • U.S.A.

www.lincolnelectric.com