GasiQ®

Intelligent solutions for industry

GAS EQUIPMENT

REGULATORS AND PRODUCTS FOR GAS CUTTING AND WELDING, SOLDERING AND BRAZING.

GASIQ – THE INTELLIGENT CHOICE IN GAS EQUIPMENT

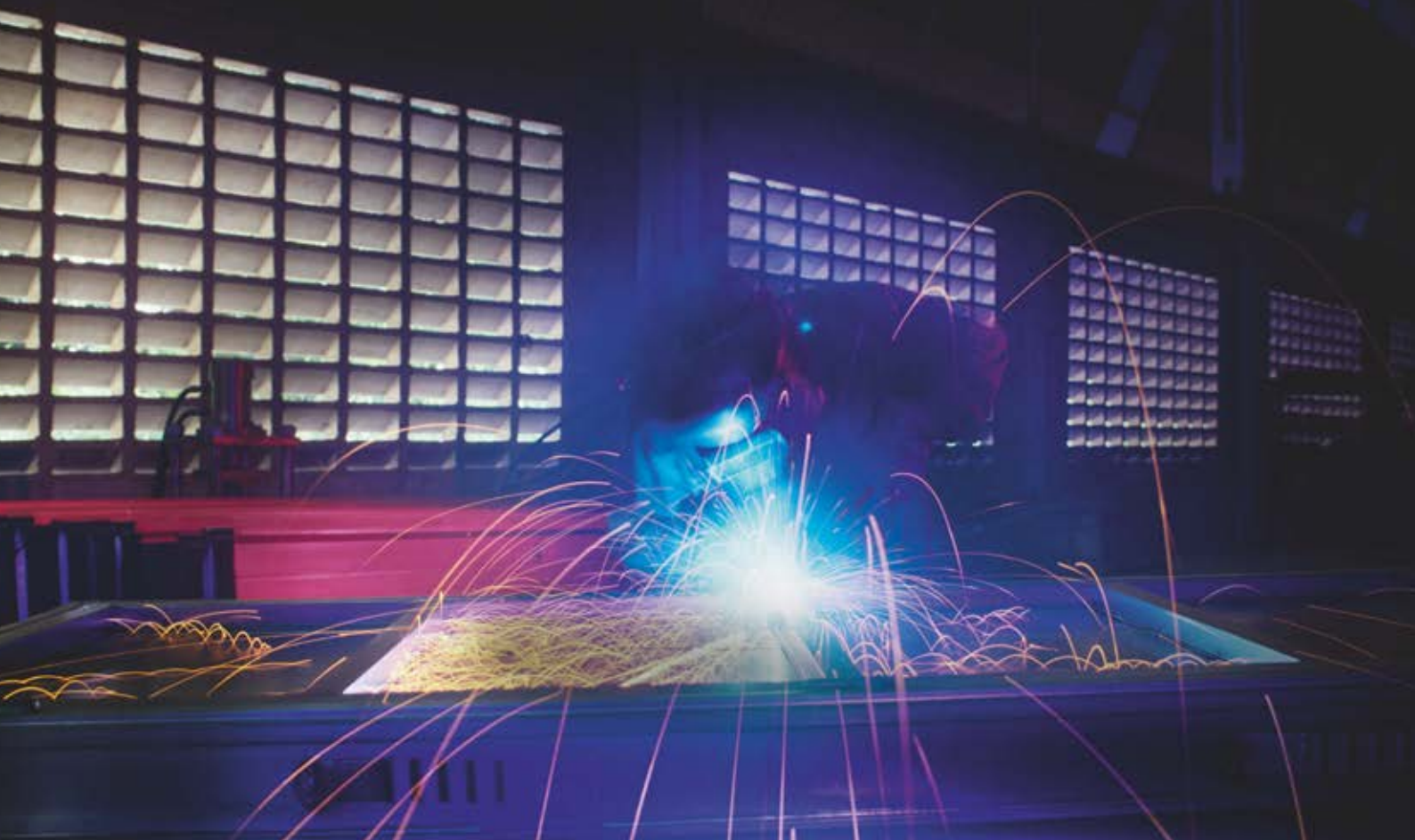
GasIQ is a smart choice for gas equipment when you are looking for high quality and excellent economy. Since we offer the whole chain from regulator to cutting torch and nozzles, we can supply complete solutions providing both minimal gas consumption and a perfect flame. In Stenkullen, just outside Gothenburg, we manufacture products for gas cutting and welding, soldering and brazing, as well as regulators for gas shielded welding.

Intelligent solutions since 1938
GasIQ was established in 2007 through a management buyout from Elga AB, which has been manufacturing gas equipment since 1938. In the past years, we have supplemented our massive experience with major investment, partly in state-of-the-art CNC machinery. Our ambition is always to be at the cutting edge of the development and production of quality products.

Minimal gas consumption with Optimator®
One result of our dynamic product development is Optimator®, a unique regulator which reduces shielding gas consumption by up to 50 %. Optimator® is currently slashing gas consumption and lowering welding costs at workplaces throughout the world.

In-house production in Sweden
We have decided to base our production in Sweden, close to our domestic market. In addition to giving us full control of the whole production chain, we also believe that, as a customer, you appreciate the fact that we are close at hand. When it is needed, we can provide you with new products rapidly and easily.

The specialist in gas equipment
The smarter solutions, in any sector and in any area, are usually supplied by specialists. GasIQ is the specialist in gas equipment. Working closely with you, we ensure that you benefit from a smart solution which gives both higher quality and improved economy. In partnership with us, you take your operation to the next level.



GasiQ®
Intelligent solutions for industry

EQUIPMENT THAT CAN TAKE IT

Our products are used in tough environments. Often for long periods, and for very high precision work. That is why GasIQ's cutting and welding systems and products have been developed to give optimal sensitivity and precision – in very demanding situations. By combining ergonomic design and the best materials, we can create hard-wearing and easily-handled cutting and welding systems which ensure minimal gas consumption and a perfect flame.

Ergonomic and hard-wearing design
The ergonomic design of our cutting and welding systems gives excellent grip and controllability for the welder, vital over long working days and in projects which demand high precision. In addition, our products are manufactured from hard-wearing materials which can cope with tough environments and high workloads.

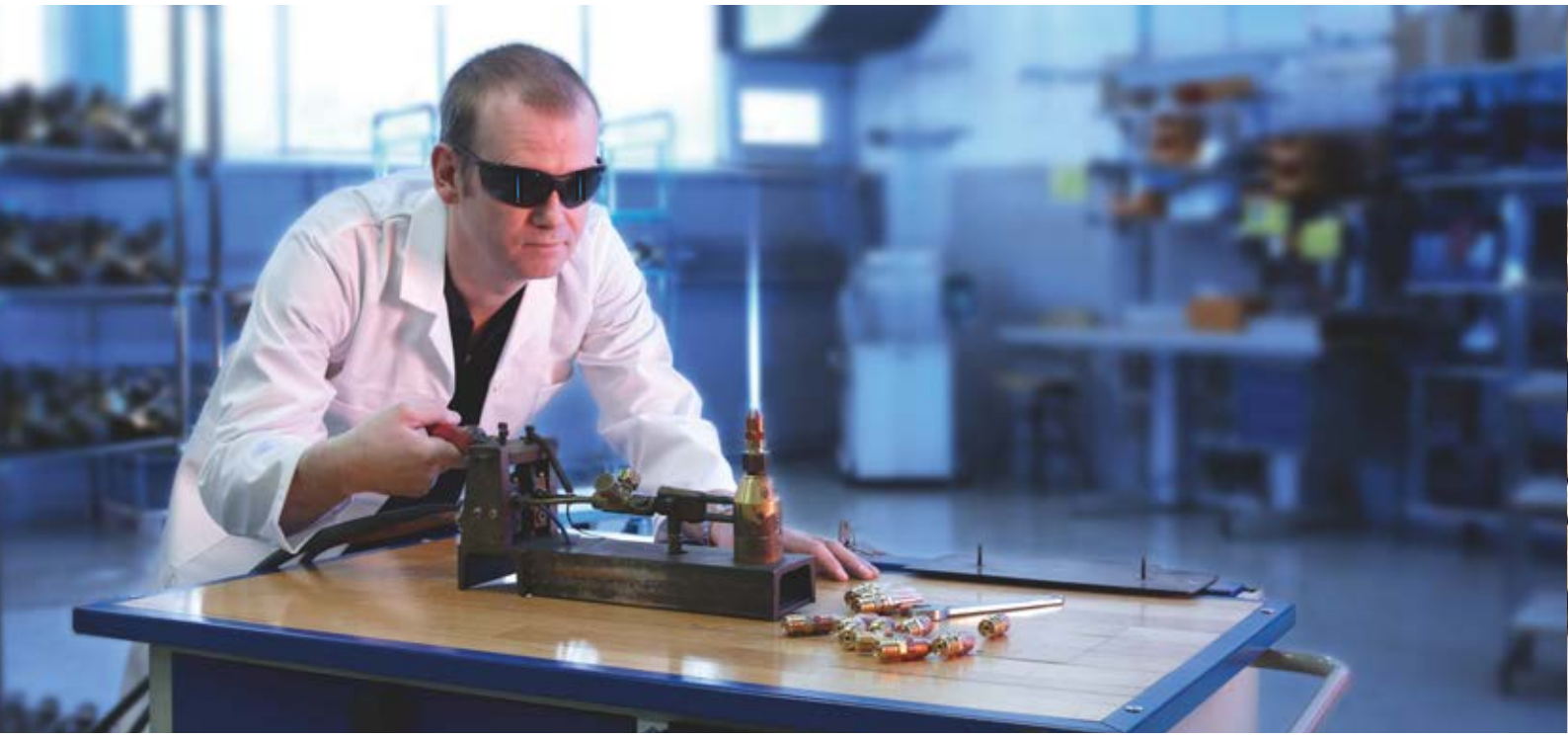
Volvo cut gas consumption by 43 %
In a test at Volvo Buss in Uddevalla, the amount of gas saved by GasIQ's Optimator® regulator was measured. During the test, the welder first worked through a welding cycle with the existing outlet point, and the next cycle with Optimator®. A mass flow meter with digital counter was connected to measure gas consumption during the two welding processes. The test showed that Volvo saved at least 43 % of the gas in the welding cycle where Optimator® was used.

Use original parts
Using GasIQ's original parts throughout the system from regulator to cutting torch and nozzle achieves the perfect flame, which gives a perfect cut and excellent economy. Remember: never use non-OEM parts! Original parts give better flame and reduce gas consumption – they save you money in the long run.

Some of the companies which use and trust our products:
ABB, BMW, GM, Caterpillar, JCB, Aker Kvaerner, Volvo and Autoliv.

GASIQ R&D

Are you looking for a unique solution for your weld cell? Perhaps you need specially-adapted connections? GasIQ's Research & Development Centre can help you develop products and complete solutions to meet your specific requirements.



Product development with high flexibility
GasIQ is committed to constant product development to meet the most stringent requirements and expectations of a demanding industry. At our R&D Centre, we design using a 3D solid modulation programs, so that we can simulate function and design right on the drawing board. This gives us the flexibility essential for customised products.

Modern production in Sweden
Just next door to our Design Department, we have our in-house machining and assembly workshop. This gives us control over the whole process, from concept to finished product. With cutting-edge machine tools, including six axis CNC machines, we can meet the highest standards of quality manufacturing. In our factory, we produce components focusing on quality, safety, ergonomics and economy.

Large and small runs
We are happy to turn out either large or small runs. Assembly is carried out by skilled personnel with considerable experience and a high level of expertise. All our products are tested and checked before delivery.

GasIQ holds ISO 9001:2008 and ISO 14001:2004 certification through Lloyd's Register of Quality Assurance.

MADE IN SWEDEN

Are you looking for straight answers, fast delivery and a high level of flexibility? Our products are manufactured in Sweden, close to our market, in our own state-of-the-art production facility outside Gothenburg. We are committed to high precision and flexibility, both in our own production and in subcontract assignments.

Multi-operation turning of the highest quality
Our production facility uses modern machine tools providing leading-edge machining technology. They include Emco six axis multi-operation machines which are ideal for all sizes of production runs of both large and small components, with 1000 mm between spindles and a maximum turning diameter of 500 mm.

Double spindle machining for optimal efficiency
Our multi-operation machines are double spindle with 65 mm bar passage. Both the head spindle and the counter spindle have integrated spindle motors which are liquid-cooled for accurate tolerances. Since the machines are double spindle, we can machine complex components completely in a single operation. The driven tools, along with the y-axis, enable us to handle a range of machining modes, such as tracyl, transmit and polygon. The machines are equipped with integrated parts capture devices for reliable removal from the machine.

Subcontracting
GasIQ carries out extensive subcontract work on behalf of a range of industries, including heating, ventilation and sanitation, as well as the gas industry. If you would like help with product development and/or manufacture, we can develop solutions tailored to your unique requirements, and can handle both large and small production runs.

UNIQUE RANGE OF FIRST-CLASS REGULATORS

GasIQ offers a wide selection of high-quality pressure reduction valves, high-pressure regulators and two-stage regulators, for a range of applications. Optimator, our flagship, is a two-stage reducing valve, and the second stage is extremely pressure sensitive, which sharply reduces the gas puff created during the first moment of starting. This reduction cuts your gas consumption by up to 50 %.

Other popular products include Maxex, a heavy-duty regulator with high-capacity; Minex, an excellent economic alternative for gas shielded welding with smaller welding machines; and the TIGex regulator which is intended for work where particularly accurate control of the gas flow is required.

All regulators are designed to fulfil the standard EN ISO 2503.

Make it easy to regulate and monitor pre-set flows and pressure.

Labelled **"Approved"** and initialled by the fitter in charge after final check.

Meet the current requirements of EN ISO 2503.

Manufactured under GasIQ's quality assurance system in accordance with **ISO 9000.**

Equipped with **pre-installed, built-in safety valve** to prevent the pressure gauge or flow meter bursting in the event of an unintended pressure surge.

Durable and tough, for long service life.

Individually checked and tested, and put through a simulated running-in procedure.

Easy to mount and remove from the cylinder, since the connection nut to the cylinder is double-length.

Fitted with hose connectors for 5.0/6.3 mm or 6.3/8 mm internal hose diameter. Each regulator comes with additional seals.





SAVE 50 % GAS WITH GASIQ OPTIMATOR®!

If you work with welding, you know only too well how much welding rods cost per kilo. But have you checked how much shielding gas costs per metre of weld run? It is just as expensive as rod. With Optimator®, you have a unique regulator and you reduce shielding gas consumption by up to 50 %. An investment which pays for itself in less than six months – the rest is pure profit.

Optimal flow right from the start
Every time you start a traditional regulator, a large amount of gas disappears for no benefit. Optimator® gives you an optimal start flow right from the first second – just one quarter as much as a traditional regulator.

The more stop-start welding you do, the more gas you lose and the more money you will save by switching to Optimator®.

Higher quality welds
Optimator® gives a steady start flow, which, in addition, gives you higher quality welds, since it avoids the turbulence which can interfere with the welding process.

Available in different versions
Optimator® is available in two different basic versions. One is for connection to gas cylinders and the other for use on systems for GasIQ outlet points. Optimator® can also be equipped with lockable gas flow. A real advantage if you want to ensure a high and even level of weld quality.

Excellent welding economy
We have sold previous generations of Optimator® since the beginning of the 1980s, and in tens of thousands of examples throughout the world, and we know that it delivers what we promise. We suggest that you total your costs for shielding gas and welding rods and contact your nearest authorised distributor of GasIQ gas equipment. They can help you cut the cost of your welding.

Proven lower gas consumption
To check how much gas it was possible to save using Optimator®, Volvo Buss in Uddevalla carried out the following test: At one of the company's welding stations, a recurring welding cycle which takes around 60 minutes is carried out. The test involved the welder first working through one cycle with the existing outlet point, and the next welding cycle using Optimator®. A mass flow meter with digital counter was connected to measure gas consumption during the two welding processes. Checks were carried out at the welding torch using a flow meter to ensure that the gas flow was the same for both outlet points. The gas flow was recorded at 18 l per minute.

Result
Consumption of gas at existing outlet point: 838 l.
Consumption of gas at Optimator® outlet point: 429 l.

The test proved that Optimator® consumed a full 49 % less gas. To make absolutely sure, an error margin of 10 % was added to the measured value at the flow meter. This verified that Optimator® generated gas savings of at least 43 % in this welding cycle at Volvo.

Read more on www.gasiq.com


34
30
26
22
18
14
10
6
2
Optimator
200
EN 837-1
100
300
0
bar
400
WIKA
CL 2.5
ARGON - MIX

GASIQ OPTIMATOR®

The GasIQ Optimator is a two-stage regulator for advanced gas shielded welding. The GasIQ Optimator's second stage is extremely pressure sensitive, and it substantially reduces the gas puff which normally occurs in the first moment of starting gas arc welding. The reduction in the gas puff can cut gas consumption during normal welding by up to 50 %. Lower gas consumption also means fewer cylinder changes, which increases effective production time in welding. In addition, it improves welding quality, by reducing the risk of pores.

The GasIQ Optimator's two-stage principle regulates the gas flow very accurately and keeps it constant even as the cylinder pressure gradually falls. Supplied with hose connectors for 5.0 mm and 6.3 mm internal hose diameter, as well as extra seals.

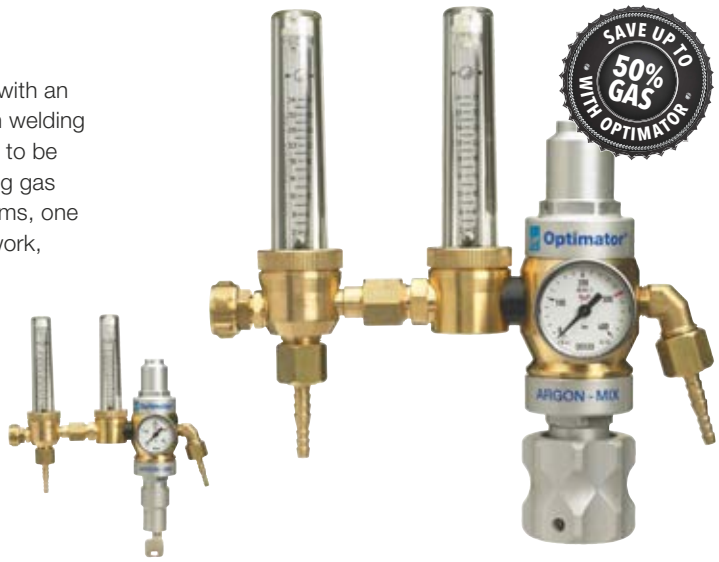
Gas type:		**AR/mix**	**AR/mix** *lockable Gas flow*	**CO^2**	**AR/H2mix**	**300 bar AR/mix** *Nevoc*
Part number						
Group 1 *Scandinavia*		3737-0000	3737-9000	3738-0000	3737-1450	3737-4000
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**	***20 l*** ***34 l***	3737-1200 3737-1230	3737-9200 3737-9230	3737-1200 3737-1230	3737-1400 3737-1450	3737-4200 3737-4230
Group 3 *Side entry: Great Britain, India, Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	3737-2010 3737-1010	3737-2090 3737-1090	3738-0000 3738-1010	3737-2014 3737-1014	3737-4000 -
Group 4 *Russia*		3737-1260	3737-9260	3737-1260	3737-1460	3737-4000
Group 5 *Italy*		3737-3010	3737-3090	3738-0000	3737-3014	3737-4000
Group 6 *France*		3737-1350	3737-9350	3737-1350	3737-1450	3737-4350
Group 7 *Spain*		3737-1300	3737-9300	3738-0000	3737-1450	3737-4000
Group 8 *Middle East*		3737-8020	3737-9020	3738-0000	3737-1480	-
Group 9 *USA***		3737-8000	3737-8090	3738-8000	3737-8450	-
Flow meter		0-34 l/min	0-34 l/min	0-34 l/min	0-34 l/min	0-34 l/min

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*
*** Flow meter calibrated 0-70 SCFH*

GASIQ OPTIMATOR II®

GasIQ Optimator II is a special version of GasIQ's Optimator with an extra outlet for backing gas. This regulator is used primarily in welding operations where both the shielding gas and backing gas are to be taken from a single gas cylinder. It provides the same shielding gas savings as the GasIQ Optimator above. In purely practical terms, one of the benefits is that in operations such as pipe installation work, fewer gas cylinder changes are required.

Supplied with hose connectors for 5.0 mm and 6.3 mm internal hose diameter, as well as extra seals.



Gas type:		AR/mix	AR/H2mix	300 bar AR/mix *Nevoc*
Part number				
Group 1 *Scandinavia*		3739-0000	3739-1450	3739-4000
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**	***20 l*** ***34 l***	3739-1200 3739-1230	3739-1400 3739-1450	3739-4200 3739-4230
Group 3 *Side entry: Great Britain, India, Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	3739-2010 3739-1010	3739-2014 3739-1014	3739-4000 -
Group 4 *Russia*		3739-1260	3739-1460	3739-4000
Group 5 *Italy*		3739-3010	3739-3014	3739-4000
Group 6 *France*		3739-1350	3739-1450	3739-4350
Group 7 *Spain*		3739-1300	3739-9300	3739-4000
Group 8 *Middle East*		3739-8020	3739-1480	-
Group 9 *USA***		3739-8000	3739-8450	-
Flow meter		2x0-34 l/min	2x0-34 l/min	2x0-34 l/min

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*
*** Flow meter calibrated 0-70 SCFH*
**** Other versions with lockable gas flow on request*

OUTLET POINTS FOR CENTRAL SYSTEMS

A central gas system consists of the following main components:

- Gas cylinders/cylinder bundles
- Central gas supply system with central regulator
- Pipelines
- Outlet points

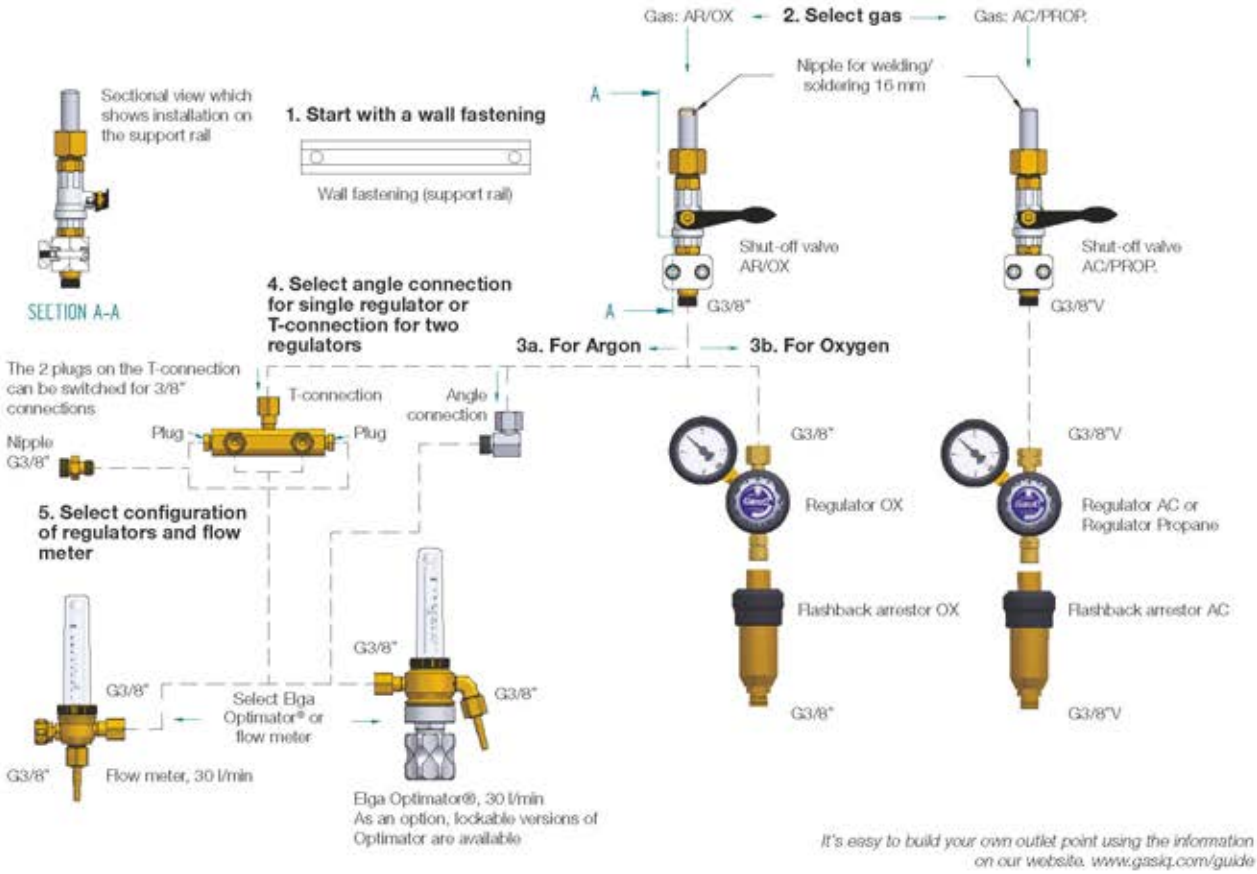
GasIQ has outlet points for both acetylene/oxygen and shielding gases. All outlet points for shielding gases are included in the Optimator range, and are supplied with GasIQ's unique gas-saving function, which slashes welding costs.

Outlet points are available as complete units or for fitting to the shut-off valves on existing outlet points.

For the installation of a simple central gas supply system with the associated components: see page 16.

For further information on central gas supply systems, please contact your nearest authorised distributor of GasIQ gas equipment.

Module system for GasIQ outlet points

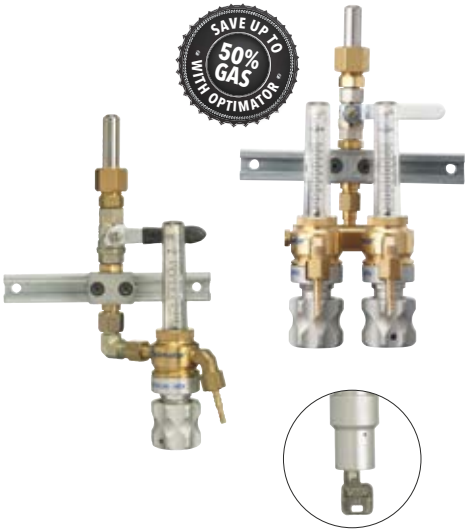


It's easy to build your own outlet point using the information on our website. www.gasiq.com/guide

Complete single or double outlet point GasIQ Optimator® for AR/mix

Description	No. of	Part No.	Part No. *DIN STD*
Wall fastening (support rail)	1 off	3112-0050	-
Shut-off valve, complete OX/Ar	1 off	3112-0000	-
Angle connection (single)	1 off	3163-0107	-
T-connection (double)	1 off	3112-0040	-
GasIQ Optimator®, 34 l/min	1 off (2 off)	3712-3260	3712-3130
GasIQ Optimator®, 34 l/min, lockable*	1 off (2 off)	3712-9200	3712-9180

** For more variants, see www.gasiq.com*



Optimator® built-in to welding machine/feed

This valve is a special version of GasIQ Optimator outlet point. With its compact design, it is ideal for direct mounting or building in to the welding machine or feed. In combination with flow meter model 3712-0530, this is an excellent alternative where very long welding hoses are involved, and the regulating function is wanted close to the welding location. Supplied with hose connections for hoses with 5.0 and 6.3 mm internal hose diameter.

Connection	Part No.
R 1/4” - R 1/4”	3711-5000
R 3/8” - R 3/8”	3711-6000
Quick connector EN 561	3711-7900

As an extra, the 3712-0530 flow meter can be mounted directly on the outlet point.

Version for connecting to ALTOP-type integrated regulator. The standardised quick connections make it easy to connect between the regulator outlet and the hose.

Double outlet with and without Optimator® for Altop/Minitop

This combination of flow meters has been specially developed for Air Liquide Altop and Minitop cylinders. They are easy to attach with the quick connector (EN 561), and no additional connection components are required.

Designation	Part No.
Double outlet Optimator, 1 flow meter	3711-7920
Double outlet, 2 flow meters	3711-7910

Complete outlet point for oxygen and acetylene

Description	No. of	Part No.	Part No. *DIN STD*
Wall fastening (support rail)	1 off	3112-0050	-
Shut-off valve, complete OX/Ar	1 off	3112-0000	-
Regulators, Oxygen	1 off	3720-0000	3720-1500
Optional flashback arrestor SAFE-X Oxygen	1 off	3004-1000	3004-1500
Shut-off valve, complete Ac/Propane	1 off	3121-0000	-
Regulator, Acetylene	1 off	3721-0000*	-
Flashback arrestor SAFE-X Acetylene	1 off	3004-0000	-

**For an oxygen/propane installation, the 3721-0000 regulator is replaced with the 3704-0000*

SINGLE CENTRAL GAS SUPPLY WITH ACCESSORIES

NOTE: SCANDINAVIA ONLY

Shut-off valve

Shut-off cylinder valve type with attachment for wall mounting. The shut-off is suitable for building-in to a single central gas supply system. The outlet threads are the same as the cylinder standard for the intended gas. The inlet threads are W21.8x14/1" and are suitable for connecting high-pressure hose. The maximum pressure for the shut-off valve is 200 bar.

Designation	Part No.
Shut-off Oxygen	3150-0001
Shut-off Argon/Nitrogen	3150-0002
Shut-off Acetylene	3150-0003
Shut-off Formier	3150-0004

High-pressure hose

Designation		Part No.
High-pressure hose	Ox/CO^2, 1m	3150-1100
High-pressure hose	Ox/CO^2, 2m	3150-2100
High-pressure hose	Argon/Nitrogen, 1m	3150-1200
High-pressure hose	Argon/Nitrogen, 2m	3150-2200
High-pressure hose	Ac, 1m	3150-1300
High-pressure hose	Ac, 2m	3150-2300
High-pressure hose	Formier, 1m	3150-1400
High-pressure hose	Formier, 2m	3150-2400

Other gas types and hose lengths are available.

Overflow hose

Designation	Part No.
Overflow hose Argon/Nitrogen, 1m	3150-0200
Overflow hose Formier, 1m	3150-0400

Other gas types and hose lengths are available.

For choice of regulators, see pages 18-19 or 22.

OTHER REGULATORS

GASIQ MINEX

GasIQ Minex has been specially developed for outlets supplying small to medium quantities of gas for gas shielded welding.

Minex is an excellent low-cost alternative for gas shielded welding in small workshops or for hobbyists.

Minex is supplied with hose connections for hoses with 5.0 and 6.3 mm internal diameter.

Gas type:		AR/mix	CO^2
Part number			
Group 1 *Scandinavia*		3708-0000	3707-0000
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**		3708-1200	3708-1200
Group 3 *Side entry: Great Britain, India, Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	3708-2010 3708-1010	3707-0000 3707-1010
Group 4 *Russia*		3708-1260	3708-1260
Group 5 *Italy*		3708-3010	3707-0000
Group 6 *France*		3708-1350	3708-1350
Group 7 *Spain*		3708-1300	3707-0000
Group 8 *Middle East*		3708-8020	3707-0000
Working pressure gauge		0-30 l/min	0-30 l/min
Max working pressure		10 bar	10 bar

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*

GASIQ MAXEX

GasIQ Maxex is a high-quality and high-capacity regulator, (class 3 ISO 2503). Maxex is ideal for normal to high gas flows, e.g. in cutting and heating with high-performance cutting and welding systems such as N76/S80 etc.

Maxex is a heavy duty and robust ergonomically-designed regulator for accurate control of gas flow. It is available for most types of gases. The regulator comes with a built-in pre-set safety valve to ensure the highest possible level of safety.

Supplied with hose connections for 5.0 /6.3 mm or 6.3/8.0 mm internal diameter hose, and extra seals.

300 bar on request.

Gas type:		Oxygen	Acetylene	AR/mix
Part number				
Group 1 *Scandinavia*		4220-0000	4221-0000	4715-0000
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**		4220-1500	4221-1500	4715-1200
Group 3 *Side entry: Great Britain, India Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	4220-2000 4220-2100	4221-2000 4221-2100	4715-2000 4715-2100
Group 4 *Russia*		4220-1260	4221-1260	4715-1360
Group 5 *Italy*		4220-0000	4221-2000	4715-3010
Group 6 *France*		4220-1350	4221-1350	4715-1350
Group 7 *Spain*		4220-2000	4221-2000	4715-1300
Group 8 *Middle East*		4220-8025	4221-8025	4715-8020
Working pressure gauge		0-10 bar	0-1,5 bar	0-35 l/min
Max working pressure		10 bar	1,5 bar	10 bar

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*
*** Finland 4204-1000*

CO^2	CO^2 *Brewing/Foods*	Nitrogen	Hydrogen	Technical air	Propane
4713-0000	4219-0000	4222-0000	4217-0000	4218-0000	4204-0000**
4715-1200	4219-1200	4222-0000	4217-0000	4218-0000	4204-1000
4713-0000 4713-2100	4219-0000 4219-2100	4222-2000 4222-2100	4217-2000 4217-2100	4218-2000 4218-2100	4204-2000 -
4715-1360	4219-1260	4222-1260	4217-1260	4218-1260	4204-1260
4713-0000	4219-0000	4222-1300	4217-3010	4218-3010	4204-3010
4713-1350	4219-1350	4222-1350	4217-1350	4218-1350	4204-1350
4713-0000	4219-0000	4222-1300	4217-0000	4218-1300	4204-1300
4713-0000	4219-0000	4222-8020	4217-8020	4218-8020	4204-8025
0-35 l/min	0-10 bar	0-10 bar	0-10 bar	0-10 bar	0-6 bar
10 bar	10 bar	10 bar	10 bar	10 bar	6 bar

GASIQ TIGEX I

Regulator with flow meter tubes for gas shielded welding or backing gas cover. TIGex I is specially designed for work requiring very accurate metering of the gas flow.

Available with single or double individually adjustable flow meters. The regulator is equipped with a built-in pre-installed safety valve. To ensure the highest standards of safety, the flow meter outer tube is made from safety glass.

To cut welding costs in gas shielded welding, we recommend the GasIQ Optimator. TIGex I is supplied with connections for 5.0 and 6.3 mm internal diameter hoses, as well as extra seals.

300 bar and other flow ratings on request.

Gas type:		**AR/mix**	**CO^2**	**Formier /backing gas cover**
Part number				
Group 1 *Scandinavia, Holland*		3710-5000	3714-5000	3718-5000
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**	***20 l*** ***34 l***	3710-1200 3710-1230	3710-1200 3710-1230	3718-5200 3718-5000
Group 3 *Side entry: Great Britain, India, Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	3710-2010 3710-1010	3714-5000 3714-1010	3718-2010 3718-1010
Group 4 *Russia*		3710-1260	3710-1260	3718-1260
Group 5 *Italy*		3710-3010	3714-5000	3718-3010
Group 6 *Spain*		3710-1300	3714-5000	3718-5000
Group 7 *Middle East*		3710-8020	3714-5000	3718-8020
Group 8 *USA***		3710-8000	3714-8000	3718-8000
Flow meter		0-34l/min	0-34l/min	0-34l/min

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*
*** Flow meter calibrated in 0-70 SCHF*

GASIQ TIGEX II

Version with double flow meter with individually adjustable flow. Can supply, for example, two welding machines or backing gas cover.

TIGex II is supplied with connections for 5.0 and 6.3 mm internal diameter hoses, as well as extra seals.

Gas type:		AR/mix	CO^2	Formier /backing gas cover
Part number				
Group 1 *Scandinavia, Holland*		3710-5100	3714-5100	3718-5100
Group 2 DIN Standard *Germany, Austria, Switzerland, Poland, Czech Republic, Slovakia, Romania and Slovenia**	***20 l*** ***34 l***	3710-1500 3710-1530	3710-1500 3710-1530	3718-5300 3718-5100
Group 3 *Side entry: Great Britain, India, Turkey* *Top entry: Great Britain*	***Side entry*** ***Top entry***	3710-2020 3710-1020	3714-5100 3714-1020	3718-2020 3718-1020
Group 4 *Russia*		3710-1560	3710-1560	3718-1560
Group 5 *Italy*		3710-3020	3714-5100	3718-3020
Group 6 *Spain*		3710-1400	3714-5100	3718-5100
Group 7 *Middle East*		3710-8120	3714-5100	3718-8120
Group 8 *USA***		3710-8000	3714-8100	3718-8100
Flow meter		0-34l/min	0-34l/min	0-34l/min

** These countries are also in Group 2: Hungary, Croatia, Bosnia, Serbia, Montenegro, Macedonia and Bulgaria*
*** Flow meter calibrated in 0-70 SCHF*

SPECIAL REGULATORS

HIGH-PRESSURE REGULATOR 825 DS

Stainless membrane and regulating valve on the outlet side. Ideal for installations requiring higher working pressure and capacity, such as laser installations or for hydrostatic tests.

Gas type:	**Oxygen** *0-25 bar*	**Oxygen** *0-50 bar*	**Nitrogen/Argon** *0-50 bar*
Part number			
Group 1 *Scandinavia*	3781-2025	3781-2040	3781-2240
Group 2 *Side entry: Great Britain, India, Turkey*	3781-2026	3781-2041	3781-2241

Top entry on request.

High-pressure regulator 825 DS

Connection outlet:	G3/8”
Max input pressure:	230 bar
Max Working pressure:	25/50 bar
Capacity:	350/450 m^3
Scale, working pressure gauge:	0-40/0-100 bar

HIGH-CAPACITY REGULATOR H25

Stainless membrane. Ideal for installations requiring high capacity, such as laser installations or for plasma cutting.

Gas type:	**Acetylene**	**Oxygen**	**Nitrogen/Argon**
Part number			
Group 1 *Scandinavia*	3791-2100	3791-2025	3791-2225
Group 2 *Side entry: Great Britain, India, Turkey*	3791-2126	3791-2026	3791-2226

Top entry on request.

High-capacity regulator H25

Connection outlet:	G1/2”
Max input pressure:	230 bar
Max Working pressure:	25 bar
Capacity:	500 m^3
Scale, working pressure gauge:	0-40 bar

2-STAGE REGULATOR 996 DS

Stainless membrane. Ideal for installations requiring a high level of accuracy in working pressure, such as machine cutting or laboratory systems.

Gas type:	Oxygen	Nitrogen/ Argon
Part number		
Group 1 *Scandinavia*	3782-2010	3782-2210
Group 3 *Side entry: Great Britain, India, Turkey*	3782-2011	3782-2211
Top entry on request.		

High-pressure regulator 996 DS

Connection outlet:	G3/8”
Max input pressure:	230 bar
Max Working pressure:	10 bar
Capacity:	150 m^3
Scale, working pressure gauge:	0-16 bar

HIGH-PRESSURE REGULATOR 987

Regulator with working pressure 0-170 bar for Nitrogen. Stainless membrane. Ideal for installations requiring extremely high working pressure and capacity, such as hydrostatic tests.

Gas type:	Nitrogen
Part number	
Group 1 *Scandinavia*	3781-2200
Group 3 *Side entry: Great Britain, India, Turkey*	3781-2201
Top entry on request.	

High-pressure regulator 987

Connection outlet:	1/4” NPT
Max input pressure:	230 bar
Max Working pressure:	170 bar
Capacity:	500 m^3
Scale, working pressure gauge:	315 bar

SPECIAL GAS REGULATORS

GasIQ Special gas regulators are a series of high/low-pressure regulators for pure and high-purity gases. Available in one-stage and two-stage designs, and as pipeline regulators.

Working pressure: 2.7 and 14 bar.

Gases: Nitrogen, Oxygen, Helium, Hydrogen etc., as well as aggressive gases (toxic and corrosive gases). This is only a brief summary of our range, please contact GasIQ for more information.

SERIES 700

The Series 700 regulators in chromium-plated hot-pressed brass with stainless membrane are suitable for non-aggressive gases with a purity of up to 5.0 (99.999)

Applications: Laboratory gases and laser applications.

SERIES 720

The Series 720 regulators in chromium-plated brass from rolling stock with stainless membrane are suitable for non-aggressive gases with a purity of 5.0 (99.999) and above.

Applications: Laboratory gases for analysis and emissions systems.

SERIES 740

The Series 740 regulators in stainless steel are suitable for aggressive gases with a purity of 6.0 (99.9999) and above.

Applications: Laboratory gases, ideal for research and analysis.

ACCESSORIES

A full range of accessories including purging valves and flow meters is available

CENTRAL GAS SYSTEMS

Central gas system, semi-automatic
SG 900

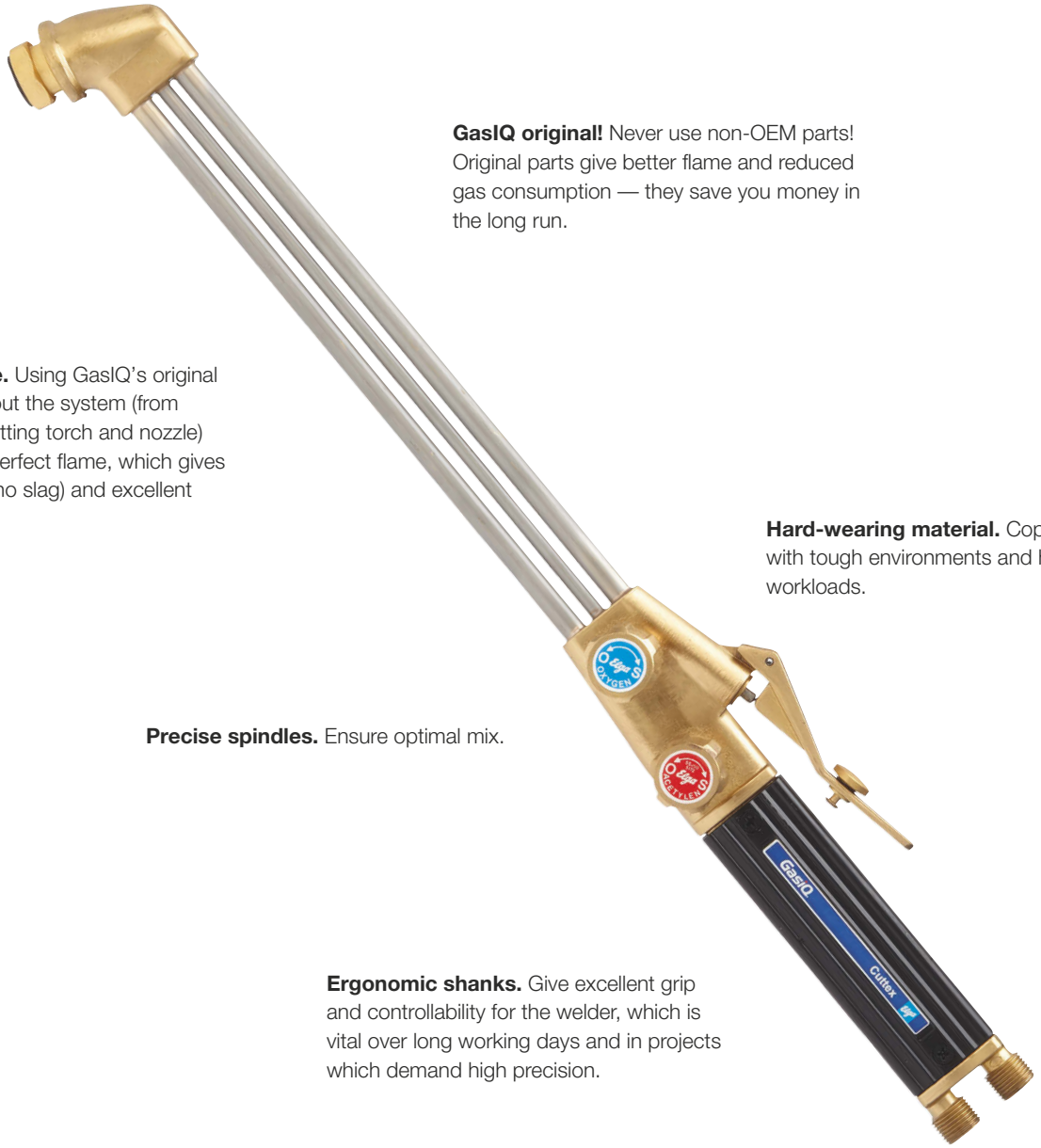
Central gas system, fully automatic
SG 960

CUTTING AND WELDING SYSTEMS

Right across the GasIQ range of cutting and welding systems, all components are manufactured with very high precision and accuracy to give optimal quality and safety in the finished products. Every component is function-tested before delivery. The seals in valves, connections and shanks, the flame form at nozzles and the welding nozzles are just some of the factors that we check. GasIQ offers two main types of cutting and welding systems: injector and pressure torch.

The injection principle
The injection principle means that oxygen is drawn in with the fuel gas into the torch. One of the advantages of the injection principle is that it is very easy to set the gas mixture.

The pressure principle
The pressure principle means that the oxygen and the fuel gas have the same input pressure to the heating flame, and the higher-pressure cutting oxygen is fed through a separate gas duct to the cutting nozzle. One of the advantages of the pressure principle is that it can cut thicker material.



GasIQ original! Never use non-OEM parts! Original parts give better flame and reduced gas consumption — they save you money in the long run.

Perfect flame. Using GasIQ's original parts throughout the system (from regulator to cutting torch and nozzle) achieves the perfect flame, which gives a perfect cut (no slag) and excellent economy.

Hard-wearing material. Copes with tough environments and high workloads.

Precise spindles. Ensure optimal mix.

Ergonomic shanks. Give excellent grip and controllability for the welder, which is vital over long working days and in projects which demand high precision.

GASIQ D75 ERGO CUTTING AND WELDING SYSTEMS

TABLE FOR THE RANGE OF D75 SYSTEMS

Part No.	Designation	D75 kit* Lever 3595-0100 Control valve 3595-0000	D75 kit* Heating, and plumbing 3595-0200	D75 kit* Basic 3595-6100	MiniCar plus Lever 3936-1100 Control valve 3936-1000	MiniCar plus Heating, and plumbing 3936-1200
3308-1100	Shanks D75 ERGO complete	x	x	x	x	x
3316-0000	Welding nozzle 80 l/h	x		x	x	
3316-0100	Welding nozzle 160 l/h	x		x	x	
3316-0200	Welding nozzle 315 l/h	x	x	x		x
3316-0300	Welding nozzle 500 l/h	x	x		x	x
3316-0400	Welding nozzle 800 l/h	x	x			x
3362-0000	Cutting attachment 90°, control valve	(x)			(x)	
3362-0100	Cutting attachment 90°, lever valve	(x)	x	x	(x)	x
3383-0100	Cutting nozzle 1-3 mm	x				
3383-0200	Cutting nozzle 3-8 mm	x	x	x	x	x
3383-0300	Cutting nozzle 8-20 mm	x		x		
3383-0400	Cutting nozzle 20-50 mm	x	x		x	x
3325-0100	Bendable welding nozzle 160 l/h		x			x
3325-0300	Bendable welding nozzle 500 l/h		x			x
3319-0300	Multiflame heating nozzle 500 l/h		x			x
3319-0400	Multiflame heating nozzle 800 l/h		x			x
3324-1006	Sealing kit (5 seals)	x	x	x	x	x
3522-0000	2-wheel cutting support	x				
3618-0000	Spanner, 15 mm	x	x		x	x
3574-1000	Sheet-metal storage box	x	x	x	x	x
3615-0000	Cleaning needles	x	x	x	x	x
3008-0000	THERMEX, Flashback arrestor, Ac				x	x
3008-1000	THERMEX, Flashback arrestor, Ox				x	x
5621-2000	Gas hose, red/blue, 5 mm, 5 m, *complete with flame arrestors*				x	x
4220-0000	Maxex, Ox				x	x
4221-0000	Maxex, Ac				x	x
5538-0000	Flame resistant mittens				x	x
3122-1000	Bracket Ac				x	x
5335-1000	Trolley for MiniCar				x	x
5527-0000	Warning sign				x	x
5556-0000	Shurlite gas lighter				x	x
5647-0000	Protective goggles				x	x

** For models with flame arrestors on the shank (standard in Finland), see page 29.*


Gasiq
OXYGEN
Gasiq
D75 ERGO

GASIQ D75 ERGO CUTTING AND WELDING SYSTEM

– THE BIG SELLER WHICH COMBINES ERGONOMICS WITH EXCELLENT DESIGN!

The GasIQ D75 ERGO is one of the most popular cutting and welding systems on the market. The main component is the ergonomically-designed shank which gives perfect grip and optimal controllability for the welder. The system uses the injection principle, which means that oxygen is drawn in with the fuel gas (acetylene) in the torch. This makes it very easy to set the gas mix correctly, and to empty the acetylene cylinder more effectively.

Other components are the attachments for cutting, welding, soldering and heating. All components are interchangeable with other equivalent cutting and welding systems on the market.

Cutting
There is a range of cutting attachments in the D75 system. Lever valve or rotary control valve for the cutting oxygen. Cutting head with 90° or 0° cutting angle.

Welding, soldering and heating
The D75 system has a selection of welding nozzles. The standard model in wrought copper and chromium-plating for effective thermal dissipation and to prevent build-up of weld spatter. In addition, there is a bendable welding nozzle of drawn copper pipe, and a multi-flamed mixer blowpipe.

All kits come in GasIQ's sturdy metal box along with operating and maintenance instructions, and welding table.

Compatible nozzles, see page 48.

Complete D75 kits

Designation	Part No.
D75 kit, control valve	3595-0000
D75 kit, Lever	3595-0100
D75 kit, Heating and plumbing	3595-0200
D75 kit, Basic	3595-6100
D75 kit, Basic + flame arrestors	3595-6200
D75 kit, Control valve + flame arrestors	3595-7000
D75 kit, Lever + flame arrestors	3595-7100
D75 kit, Heating and plumbing + flame arrestors	3595-7200

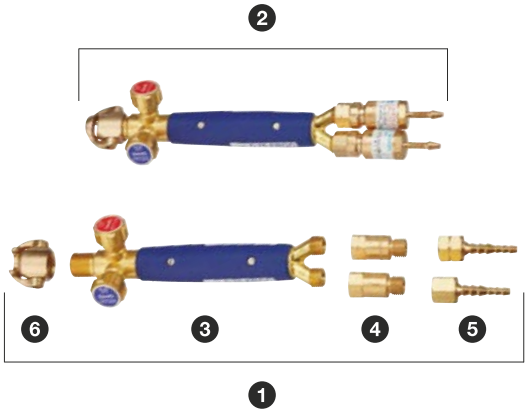
D75 kit, heating, and plumbing

D75 kit, lever valve

GASIQ D75 ERGO

Shank with accessories

Designation		Part No.
1.	Shank D75 ERGO, complete with non-return valves and quick connector	3308-1100
2.	Shank D75 ERGO, complete with flame arrestor and quick connector	3308-7100
3.	Shank D75 ERGO, only	3308-0000
4.	Non-return valve set	3007-0000
5.	Hose connection set complete Ac+Ox ø 5+6.3 mm	3308-0022
6.	Quick connector	3317-0000



Welding nozzles

Gas flow *oxygen l/h*	Material thickness *mm*	Part No.
80	< 1	3316-0000
160	1 – 2	3316-0100
230	1 – 3	3316-0150
315	2 – 4	3316-0200
400	3 – 5	3316-0250
500	4 – 6	3316-0300
650	5 – 7	3316-0350
800	6 – 9	3316-0400
1000	8 – 10	3316-0500

Bendable welding nozzles

Gas flow *oxygen l/h*	Material thickness *mm*	Part No.
160, fully-forged	< 2	3325-0100
315, fully-forged	2 – 4	3325-0200
500, fully-forged	4 – 6	3325-0300
160, brass tips	< 2	3325-1100
315, brass tips	2 – 4	3325-1200
500, brass tips	4 – 6	3325-1300

Multi-flamed heating nozzles

Gas flow *oxygen l/h*	**Part No.**
500	3319-0300
800	3319-0400

Cutting attachments

	Part No.
1. Lever valve, cutting head 90°	3362-0100
2. Control valve, cutting head 90°	3362-0000
3. Control valve, cutting head 0°	3362-0200
4. Nozzle nut	3388-0015
5. Sealing kit (5 off)	3324-1006

Cutting support and other accessories

Designation	**Part No.**
Circle cutting support	3515-0000
Support for hole cutting blowpipe ø 15–70 m	3508-0100
Cutting support 2-wheel	3522-0000
Cleaning needles	3615-8000
Welding table	3619-0000
Spanner, 15 mm	3618-0000

MINICAR PLUS WITH D75 ERGO

Transportable equipment for welding, cutting and soldering. The large wheels make it easy to manoeuvre the trolley, even up stairs. The extendable handle makes it very compact for transport. The equipment is easy to bring along, which makes it particularly suitable for service engineers, planners, farmers and hobbyists. The version with bendable and multi-flamed mixer blowpipes/soldering attachments is especially suited for the heating and plumbing industry.

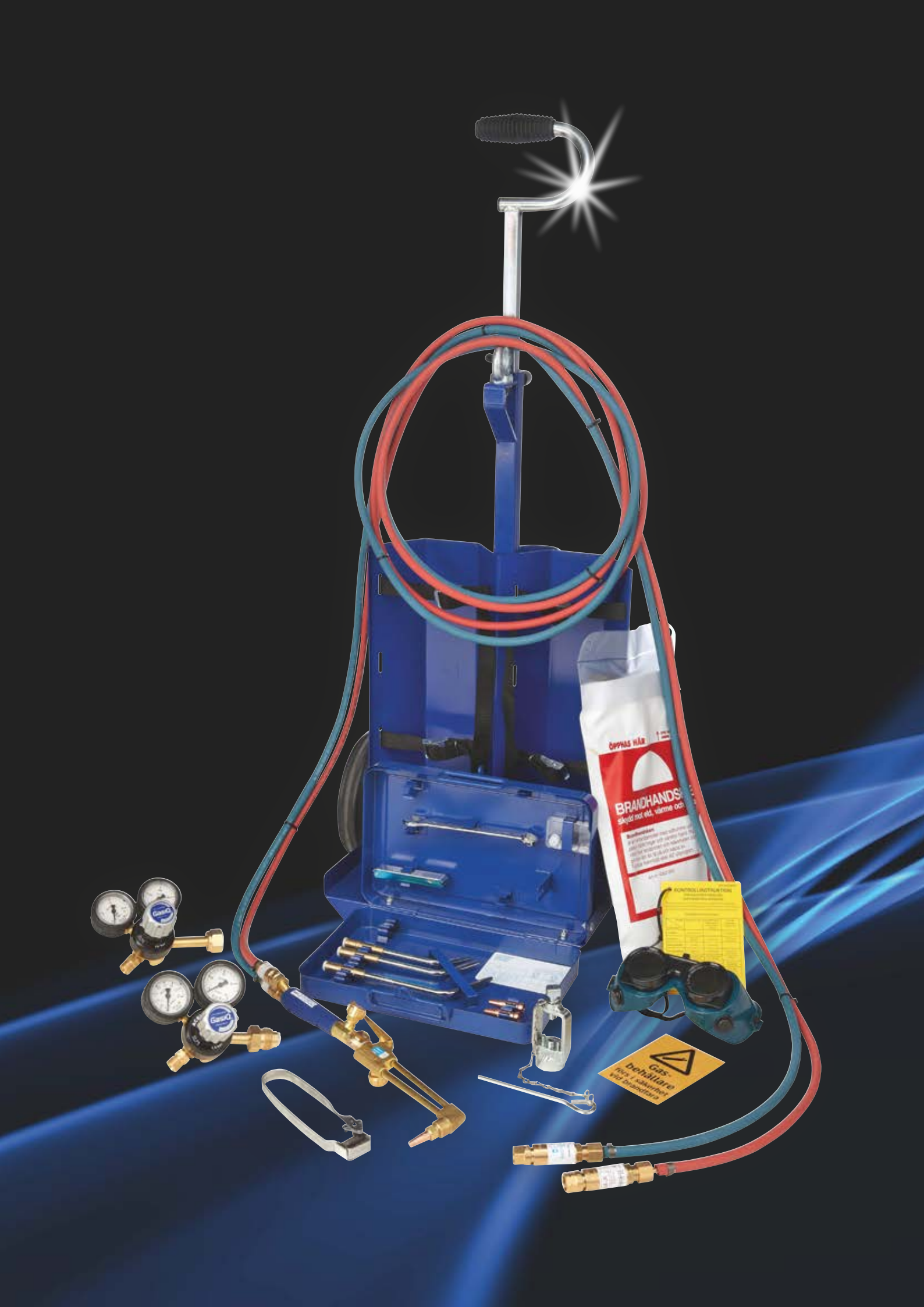
Two 5 or 11 litre gas cylinders are carried on the practical trolley, which is CE approved and approved for lifting. Accessories are hung in the well protected, lockable box fitted to the trolley. (The trolley in the photograph is fitted with extra equipment.)

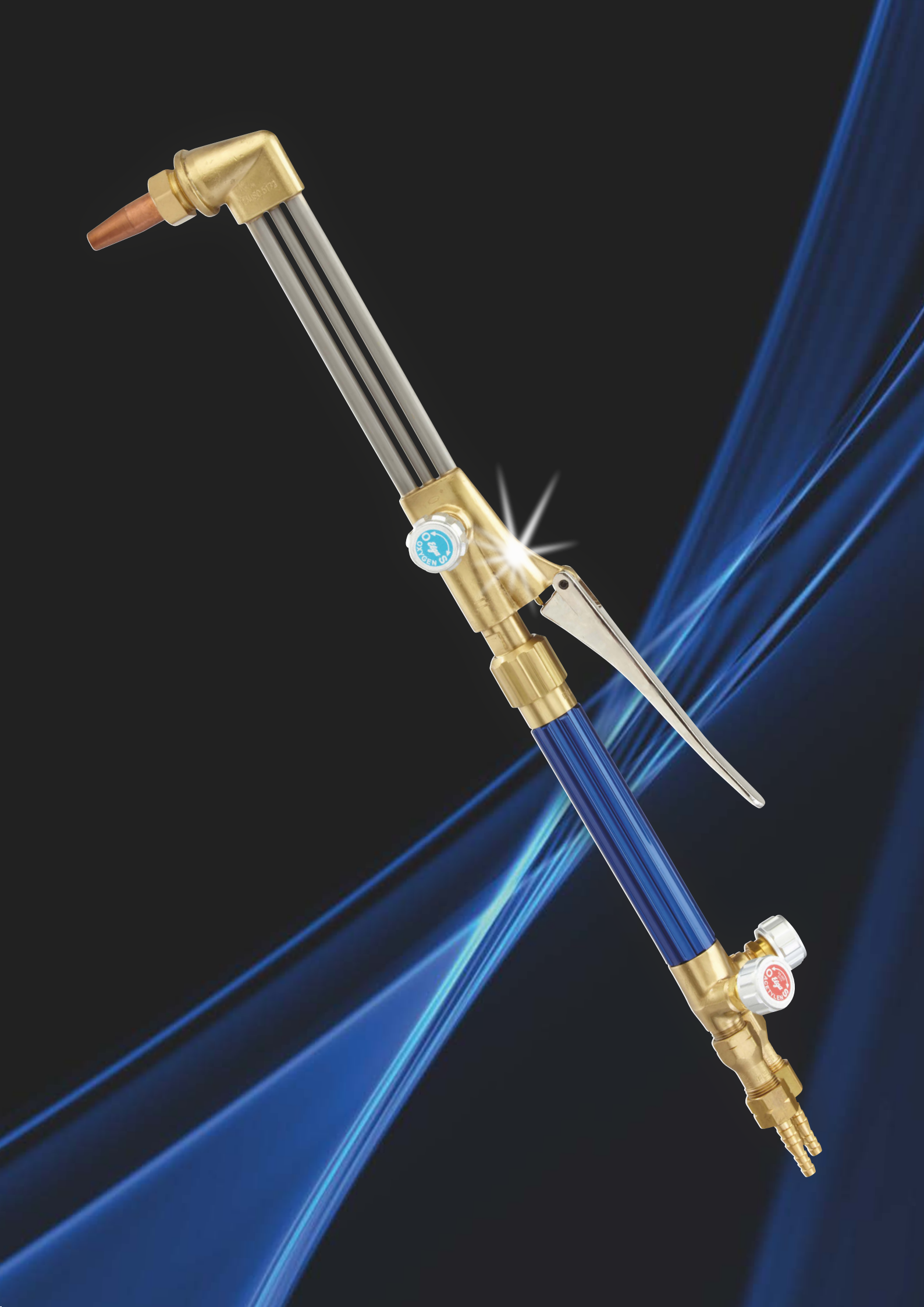
Contents, see table page 27. Total height with fully extended handle: 132 cm. Total height with handle in transport position: 88 cm.

MiniCar plus	Part No.
Lever model	3936-1100
Control valve model	3936-1000
Heating and plumbing model	3936-1200

MiniCar plus trolleys	Part No.
MiniCar-trolley with box	5335-1100
MiniCar-trolley without box	5335-1000

Adjustable handle.


ÖPPNAS HÄR
BRANDHANDS
Gas-
behållare
förs i säkerhet
vid brandfara


OXYGEN
ACETYLENE

CUTTING AND WELDING SYSTEMS GASIQ S80

– THE NATURAL CHOICE FOR THE OFFSHORE INDUSTRY.

GasIQ S80 cutting and welding systems are designed to use the pressure principle or the injection principle, depending on which cutting attachment is selected. All S80 components are manufactured with high precision and accuracy to ensure the final product has the highest possible quality.

The GasIQ S80 system is robust and designed for medium to heavy work, including in the demanding offshore industry. All components are interchangeable with equivalent systems on the market.

Cutting
Cutting attachments are available with 90°, 75° and 0° cutting head. The system is supplied with lever valve or rotary control valve for the cutting oxygen. The cutting attachments are designed for heavy duty use.

Welding
The GasIQ S80's welding nozzles are forged entirely from chromium-plated copper, for effective thermal dissipation.

Heating
Single-flame and multi-flame mixer blowpipes are included in the S80 system.

The GasIQ S80 kit consists of:
- Shank with non-return valves (or flame arrestors)
- Connection nuts
- Welding nozzles, 6 off (80, 230, 400, 650, 1000 and 1250 l/h)
- Cutting attachment 90°
- Cutting nozzles, 3 off (10, 25 and 50 mm material thickness)
- Circle cutting attachments
- 2-wheel cutting support
- Cleaning needles
- O-ring sets

The kit is supplied in GasIQ's sturdy metal box along with operating and maintenance instructions, and welding table and O-ring sets.

Complete S80 kits

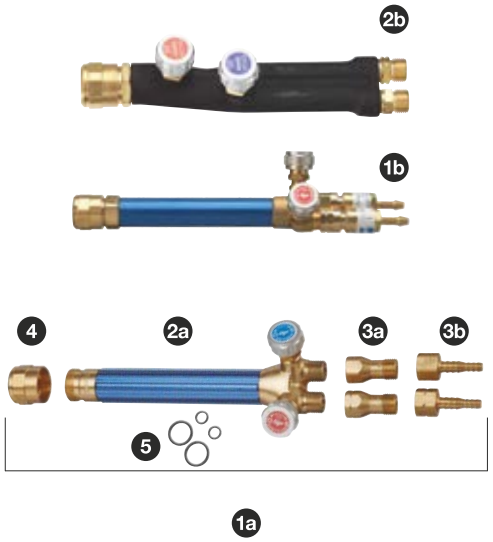
Designation	Part No.
S80-kit	3597-0000
S80-kit with flame arrestors	3597-7000

Compatible cutting nozzles S80, see page 48, 49 and 50.

GASIQ S80

Shank with accessories

Designation		Part No.
1a.	Shank, complete with non-return valves and connection nuts, round	3306-1000
	Shank, complete with non-return valves and connection nuts, oval	3305-1000
1b.	Shank, complete with flame-arrestor and connection nuts, round	3306-7100
	Shank, complete with flame-arrestor and connection nuts, oval	3305-7100
2a.	Shank only, round	3306-0000
2b.	Shank only, oval	3305-5500
3a.	Non-return valve set	3007-1000
3b.	Hose connection set Ac+Ox complete Ø 6.3+8mm	3215-0080
4.	Connection nuts	3306-0010
5.	O-ring sets	



Welding and heating nozzles – single-flame

Gas flow *oxygen l/h*	**Material thickness**	**Part No.**
80	< 1	3322-0100
230	1 – 3	3322-0200
400	3 – 5	3322-0300
650	5 – 7	3322-0400
1000	7 – 10	3322-0500
1250	9 – 14	3322-0600
1800	14 – 20/heating	3322-0700
2500	heating	3329-0000
5000	heating	3329-0100

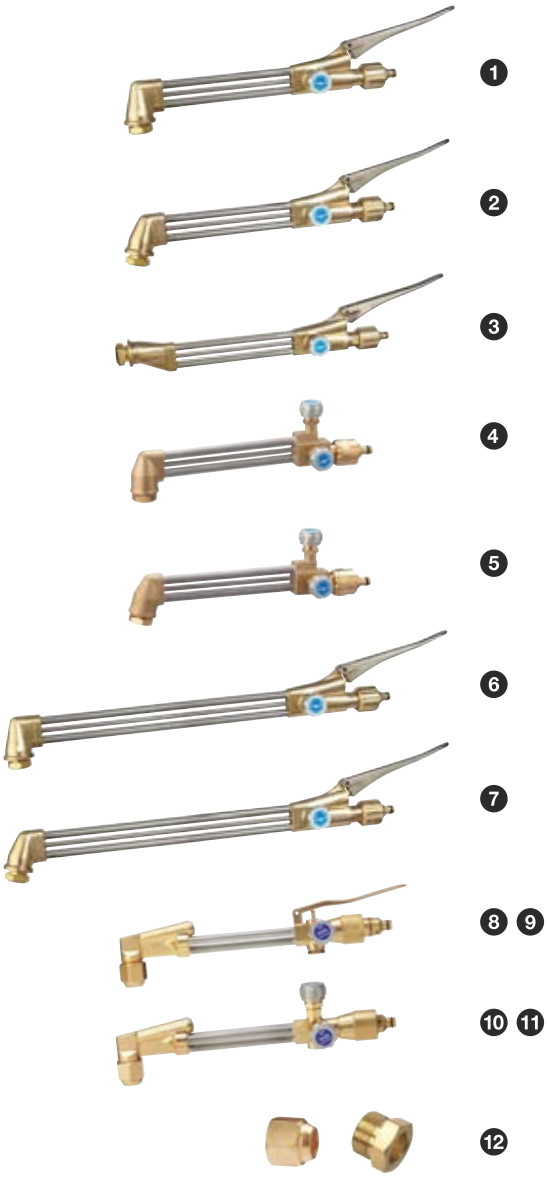
Multi flamed heating nozzles

Gas flow *oxygen l/h*	**Part No.**
2500	3322-1800
5000	3322-1900

Cutting attachments AC-Propane/Oxygen

Designation	Part No.
1. Cutting head 90° lever valve	3350-2100
2. Cutting head 75° lever valve	3350-2300
3. Cutting head 0° lever valve	3350-2200
4. Cutting head 90° control valve	3350-4100
5. Cutting head 75° control valve	3350-4300
6. Cutting head 90° lever valve, 790 mm	3350-3100
7. Cutting head 75° lever valve, 790 mm	3350-3300
8. Cutting head 90° lever valve, Injector*	3350-5100
9. Cutting head 75° lever valve, Injector*	3350-5300
10. Cutting head 90° control valve, Injector*	3350-6100
11. Cutting head 75° control valve, Injector*	3350-6300
12. Nozzle nut	3386-0015
12. Nozzle nut, Injector	6450-7015

** Injector model 8-11 is designed for Acetylene/Oxygen. Contact us for other variants.*



Cutting support and other accessories

Designation	Part No.
Circle cutting support	3515-0000
Cutting support 2-wheel	3523-0000
Cleaning needles	3615-8000
Welding table	

GASIQ N76 CUTTING AND WELDING SYSTEM

– THE SWEDISH SHIPYARD CLASSIC!

The GasIQ N76 injector cutter is fitted with a highly-effective flashback arrestor. The N76 has an excellent reputation for safety, durability and ease of service. Its advantages include:

- Heavy-duty injector, forward located to minimise flashback risk.
- Stainless cutting oxygen pipe for increased safety and durability.
- All valves have stainless steel spindles with precision frames for easy and secure shut-off.
- The cutting attachment with lever has a smooth-opening cutting oxygen valve with stainless spindle and Viton O-rings which minimise the risk of corrosion.
- Shank in seamless drawn aluminium profile which makes servicing easy.

The main components in the N76 system are the torch shank with a range of cutting and heating attachments. All components are interchangeable with other equivalent cutting and welding systems on the market.

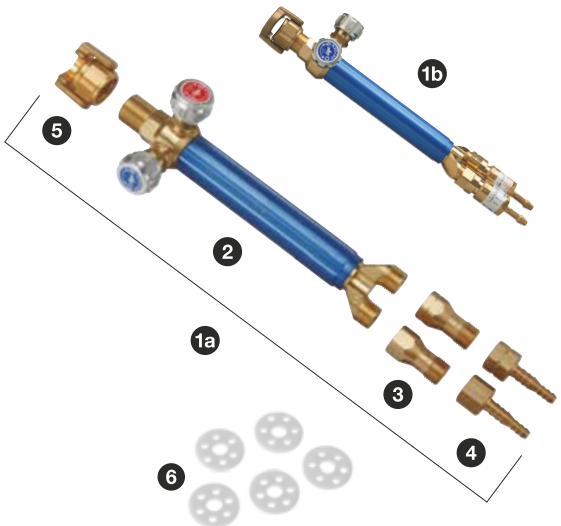
Cutting
There is a selection of cutting attachments in the N76 system. Lever valve or rotary control valve for the cutting oxygen. 90° or 75° cutting head. All cutting attachments are robustly designed to cope with heavy workloads in the toughest of environments.

Heating
High-capacity single-flame and multi-flame heating nozzles are included in the N76 system.

Compatible nozzles, see pages 48 and 49.

Shank with accessories

Designation		Part No.
1a.	Shank, complete with non-return valves and quick connector	3304-1100
1b.	Shank, complete with flame arrestor and quick connector	3304-7100
2.	Shank, only	3304-2000
3.	Non-return valve set	3007-1000
4.	Hose connection set Ac+Ox complete ø 6.3+8 mm	3215-0080
5.	Quick connector	3318-0000
6.	Sealing kit (5 off seals)	3304-1006



Heating nozzles – single-flame

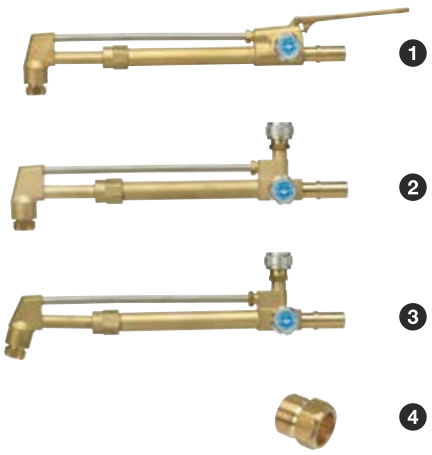
Gas flow *oxygen l/h*	**Part No.**
1800	3323-0600
2500	3323-0800
5000	3323-0900

Heating nozzles – multi-flame

Gas flow *oxygen l/h*	**Part No.**
2500	3323-1800
5000	3323-1900

Cutting attachments

Designation	**Part No.**
1. Cutting head 90°, lever valve	3353-4000
2. Cutting head 90°, control valve	3351-4000
3. Cutting head 75°, control valve	3352-4000
4. Nozzle nut	3384-0015



Cutting support and other accessories

Designation	**Part No.**
Circle cutting support	3515-0000
Cutting support 2-wheel	3523-0000
Cleaning needles	3615-8000
Welding table	3620-0000

GASIQ MOD 43-2 CUTTING AND WELDING SYSTEM

The GasIQ Model 43-2 is a heavy-duty cutting and welding system for a range of fuel gases including acetylene and propane, along with oxygen. It is ideal for cutting, heating and soldering.

The main component in the 43-2 system is the torch shank with a range of attachments for welding, cutting and soldering. All components are interchangeable with other equivalent cutting and welding systems on the market. The system is modular, so the individual components can be chosen for the particular type of work to be carried out.

Cutting. Cutting attachments in the system have a lever valve for the cutting oxygen and a 90° cutting head. The cutting attachments are robustly designed to cope with heavy workloads in the toughest of environments.

Welding/soldering. The model 43-2s nozzles are copper, for effective thermal dissipation.

Heating. A selection of high-capacity heating nozzles is included in the system.

Cutting nozzles, see page 50.

Shank	Part No.
Shank 43-2	6440-0000
Non-return valve set	3007-1000
Hose connection set	3215-0080

Cutting attachments	Gas type	Part No.
Cutting attachment 49-3F 90 Gr Lever	Propane	6490-0100
Cutting attachment 49-3F 90 Gr Lever	Acetylene	6490-1100
Nozzle nut		6490-0015

Mixer	Gas type	Part No.
Mixer E 43	Acetylene	6490-1101
Mixer F 43	Propane	6490-0101

Tip tube			Part No.
2393-F	bent	915 mm	6490-0001
2393-F	bent	710 mm	6490-0002
2393-F	bent	380 mm	6490-0003
2393-F	bent	275 mm	6490-0004
2393-F	straight	915 mm	6490-0005
2393-F	bent	1200 mm	6490-0006
Nozzle adapter 2357-3			6490-0102

Flame cleaning nozzle		Flow	Gas type	Part No.
RBP 43	50 mm	700-1050 l/h	Propane	6490-0151
RBP 43	100 mm	1850-2500 l/h	Propane	6490-0152
RBP 43	150 mm	3000-4150 l/h	Propane	6490-0153

Heating nozzle – single-flame *Propane/Ox*	Flow	Gas type	Part No.
2290-13N	850 l/h	Propane	6490-0161
2290-15N	1050 l/h	Propane	6490-0162
2290-20N	1500 l/h	Propane	6490-0163
2290-30N	2000 l/h	Propane	6490-0164
2290-80N	2400 l/h	Propane	6490-0165

Heating nozzle – multi-flame *Propane/Ox*			
2290-1H	1000-2000 l/h	Propane	6490-0171
2290-2H	1500-3200 l/h	Propane	6490-0172
2290-3H	2200-5700 l/h	Propane	6490-0173
2290-4H	3600-7100 l/h	Propane	6490-0174
2290-5H	4300-10000 l/h	Propane	6490-0175

Tip tube	Gas type	Part No.
8593	Propane/Acetylene	6490-1100

Welding and brazing nozzle *Ac/Ox*	Flow	Gas type	Part No.
Nozzle 1390 -0	45 l/h	Acetylene	6490-1150
Nozzle 1390 -1	65 l/h	Acetylene	6490-1151
Nozzle 1390 -2	100 l/h	Acetylene	6490-1152
Nozzle 1390 -3	160 l/h	Acetylene	6490-1153
Nozzle 1390 -4	250 l/h	Acetylene	6490-1154
Nozzle 1390 -5	350 l/h	Acetylene	6490-1155
Nozzle 1390 -6	500 l/h	Acetylene	6490-1156
Nozzle 1390 -7	700 l/h	Acetylene	6490-1157
Nozzle 1390 -8	1000 l/h	Acetylene	6490-1158

Brazing nozzle *Propane/Ox*	Flow	Gas type	Part No.
Soldering nozzle 1390-H, multi-flame	1050 l/h	Propane	6490-0161
Soldering nozzle 1390-2N	75 l/h	Propane	6490-0182
Soldering nozzle 1390-3N	140 l/h	Propane	6490-0183
Soldering nozzle 1390-4N	175 l/h	Propane	6490-0184
Soldering nozzle 1390-5N	225 l/h	Propane	6490-0185
Soldering nozzle 1390-6N	275 l/h	Propane	6490-0186
Soldering nozzle 1390-7N	345 l/h	Propane	6490-0187
Soldering nozzle 1390-8N	375 l/h	Propane	6490-0188
Soldering nozzle 1390-9N	415 l/h	Propane	6490-0189
Soldering nozzle 1390-10N	500 l/h	Propane	6490-0190

GASIQ 62-5 HAND CUTTING TORCH

– UNRIVALLED FOR CUTTING SCRAP AND SIMILAR TOUGH JOBS

The GasIQ 62-5 is a robust and rugged hand cutting torch for propane and oxygen, for cutting materials up to 300 mm thick. The GasIQ 62-5 is primarily intended for demanding work in cutting scrap, and meets the EN ISO 5172 standard.

The cutter is a stock item in accordance with the table. If special variants such as different lengths and 0° cutting head are required, we are, of course, happy to supply them.

Compatible nozzles: NX and NFF, see page 50.

Available with the following options:

Designation	Part No.
Hand cutting torches GasIQ 62-5, 530 mm, 70 gm	6450-0200
Hand cutting torches GasIQ 62-5, 530 mm, 90 gm	6450-0250
Hand cutting torches GasIQ 62-5, 900 mm, 70 gm	6450-0400
Hand cutting torches GasIQ 62-5, 1210 mm, 70 gm	6450-0500
Hand cutting torches GasIQ 62-5, 1500 mm, 70 gm	6450-0600
Non-return valve set	3007-1000
Hose connection set complete Ø 6.3+8 mm	3215-0080
Nozzle nut	6450-7015

530 mm

900 mm

1210 mm

1500 mm

GASIQ CUTTEX HAND CUTTING TORCH

Cuttex is a hand cutting torch with flat shank, which uses the pressure principle (II), meets the standards of EN ISO 5172 and has a lockable lever valve for the cutting oxygen.

Various fuel gases, such as acetylene and propane can be used. 3-cone sealed cutting nozzles are compatible. Naturally, cutting support and non-return valves also fit this cutter. Standard lengths supplied are 510 mm and 900 mm. Other lengths and designs are available on request.

Compatible cutting nozzles: all 3-cone sealed, on page 49.

Available with the following options:

Designation		Part No.
Hand cutting torches GasIQ Cuttex 75°	510 mm	6690-0000
Hand cutting torches GasIQ Cuttex 90°	510 mm	6690-0100
Hand cutting torches GasIQ Cuttex 75°	855 mm	6690-0400
Hand cutting torches GasIQ Cuttex 90°	855 mm	6690-0500
Non-return valve set		3007-1000
Hose connection set complete Ø 6.3+8 mm		3215-0080
Nozzle nut		3386-0015

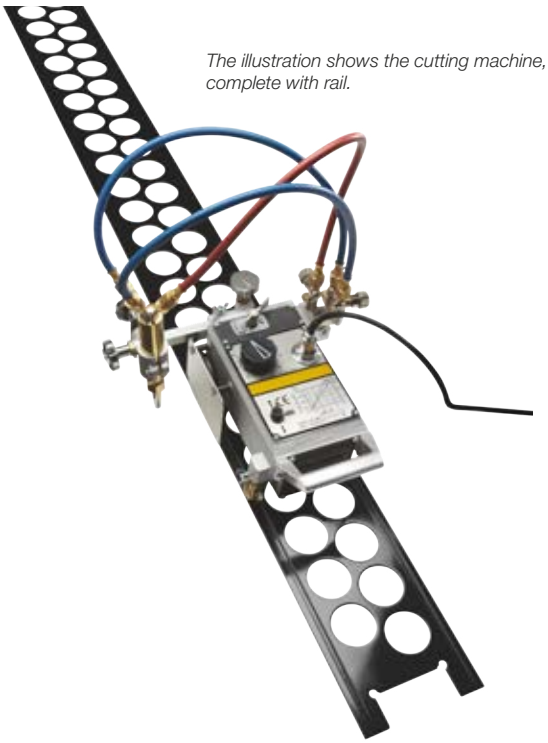
510 mm

855 mm

GASIQ CUTTING MACHINE PLUS

High-quality, compact, mortar-driven cutting machine, with a well-earned reputation for versatility and flexibility.

- For different types of fuel gas; acetylene and propane.
- Continuously-variable drive system which maintains a constant cutting speed even in high temperatures. Ensures problem-free cutting.
- Light weight, 9.5 kg, makes it easy to carry.
- Accessories such as straight rail and circle cutting attachments are available to order.
- Supplied complete with hoses, cutting (model 198-4F or 198-4 depending on gas type), three cutting nozzles, tool set, instructions and power cable.
- Tiltable cutting head
- Continuously-variable speed control



The illustration shows the cutting machine, complete with rail.

Technical Data:

Voltage:	230V
Cutting depth:	3-150 mm
Cutting rate:	150-800 mm/min
Weight:	9.5 Kg
Dimensions:	L=360 mm B=140 mm H=175 mm
Cutter:	Propane or Acetylene
Cutting nozzles:	VVC or VAX (page 51)

Available with the following options:

Designation		Part No.
Cutting machine	Acetylene/Oxygen	6711-0000
Cutting machine	Propane/Oxygen	6711-1000
Cutting rail	1800 mm	6711-0010
Circle cutting attachment	Ø 50-2400 mm	6711-0020
Non-return valve set	Fuel gas/Oxygen	6711-0300


SPEED DIAL
STOP
SERIAL NO
VOLTAGE AC

GASIQ MACHINE CUTTING TORCH

Our machine cutting torch provides high-quality, operational reliability and long service life.

Models 198-2TF and 198-2T
Separate heat and cutting oxygen ducts for better capacity. Fast opening oxygen valve.

Cutting capacity: < 380 mm
Length: 250 mm (other lengths on request)
Diameter: 32 mm

Compatible cutting nozzles, see page 51.

Designation	Gas type	Part No.
Model 198-2TF	Propane/Oxygen	6710-0010
Model 198-2T	Acetylene/Oxygen	6710-0020
Non-return valve set	Fuel gas/Oxygen	6711-0300

Models 198-4F and Model 198-4
Standard cutter for GasIQ PLUS cutting machine. Separate heat and oxygen ducts for better capacity. Delivered as standard with PLUS cutting machine.

Cutting capacity: < 200 mm
Length: 110 mm
Diameter: 32 mm

Compatible cutting nozzles, see page 51.

Designation	Gas type	Part No.
Model 198-4F	Propane/Oxygen	6710-0110
Model 198-4	Acetylene/Oxygen	6710-0120
Non-return valve set	Fuel gas/Oxygen	6711-0300

Models 133-2FV and Model 133-2V
3-duct model with separate shut-off valves.

Cutting capacity: < 200 mm
Length: 65 mm
Diameter: 30 mm

Compatible cutting nozzles, see page 51.

Designation	Gas type	Part No.
Model 133-2FV	Propane/Oxygen	6710-0210
Model 133-2V	Acetylene/Oxygen	6710-0220
Non-return valve set	Fuel gas/Oxygen	6711-0300

TH-98 twin cutter **Part No.**

Twin cutter for making two cuts simultaneously. 6710-0013
Adjustable from 30 to 305 mm.

Compatible cutting nozzles, see page 51.

Beveling head with extra preheating BV-98-2 **Part No.**

Phase cutter attachment for Propane/Oxygen 6710-0012

Compatible cutting nozzles: VVC (Propane) Page 51.
Heating nozzles: 1390-3H, **Part No.** 6490-0163

S-98-C adjustable tip adapter **Part No.**

Adjustable tip adapter to enable adjustment of nozzle angle between 0 and 90 degrees. O-ring sealed. 6710-0011

Capacity: < 200 mm

Compatible cutting nozzles, see page 51.

CUTTING NOZZLES

REMEMBER:
A bad nozzle can destroy the whole job!

GasIQ has a range of cutting nozzles for various applications. The most important functions for the nozzle are to control the heating flame and the cutting oxygen jet. The geometry of the nozzle determines its capabilities. That is why it is essential to use cleaning needles with particular care to avoid altering the geometry.

GasIQ has two main types of cutting nozzles: face sealed and 3-cone sealed. The face sealed type is used for injector torches, and the 3-cone sealed type is used for pressure torches.

CUTTING NOZZLES FOR GASIQ D75

The nozzles are also compatible with face-sealed torches from other manufacturers.		Working pressure		Part No.
	Material thickness mm	*Fuel gas bar*	*Oxygen bar*	
1. Swaged type nozzles Face-sealed forged entirely from copper. The gas ducts have a precisely cylindrical geometry to ensure a turbulence-free cutting jet.	1-3	0.1-0.8	0-1.5	3383-0100
	3-8	0.1-0.8	1.5-2.0	3383-0200
	8-20	0.1-0.8	3.0-4.0	3383-0300
	20-50	0.1-0.8	4.0-4.5	3383-0400
	50-100	0.1-0.8	3.0-6.5	3383-0500
2. Ring-type cutting nozzles Face sealed with ring-shaped heating flame, which gives a gentle heating flame. This type is ideal for cutting thin sheet metal.	1-10	0.1-0.8	1.5-2.0	3377-0000
	10-30	0.1-0.8	2.0-2.5	3377-0100
	30-50	0.1-0.8	2.5-3.0	3377-0200

CUTTING NOZZLES FOR GASIQ N76

(MA ALSO COMPATIBLE WITH S80 INJECTOR)

		Working pressure		Part No.
	Material thickness mm	*Fuel gas bar*	*Oxygen bar*	
3. Ring-type cutting nozzle Face sealed nozzle with ring-shaped heating flame, which gives a gentle heating flame. Ideal for cutting thin sheet metal. The nozzle is three-part.	1-5	0.1-0.8	1.5-2.0	3370-0000
	5-20	0.1-0.8	2.0-3.0	3370-0100
	20-30	0.1-0.8	3.0-4.0	3370-0200
	30-75	0.1-0.8	4.5-5.0	3370-0300
	75-150	0.1-0.8	5.0-7.0	3370-0400
4. MA-nozzle Face sealed 2-part nozzle for acetylene-oxygen. Used for cutting up to 100 mm. Produces a concentrated cutting jet. The nozzle is easy to take apart for cleaning.	3-8	0.2-0.8	3.5-5.0	3813-0000
	8-15	0.2-0.8	5.0-6.0	3813-0100
	15-30	0.2-0.8	6.0-7.0	3813-0200
	30-50	0.2-0.8	6.5-7.5	3813-0300
	50-70	0.2-0.8	7.0-7.5	3813-0400
	70-100	0.2-0.8	7.0-8.0	3813-0500

Cutting nozzles for GasIQ N76, cont.

	Joint width mm	Joint depth mm	Working pressure Fuel gas bar	Working pressure Oxygen bar	Part No.
5. Gouging nozzle 4-part slotted-flame nozzle. Used for oxygen gouging and edge preparation.	4-6	2-4	0.3-0.8	2.5-3.5	3372-1000
	6-8	2-6	0.3-0.8	3.0-4.0	3372-2000
	9-11	5-8	0.3-0.8	4.0-5.0	3372-3000

CUTTING NOZZLES FOR GASIQ S80 AND GASIQ CUTTEX

The nozzles are also compatible with torches from other manufacturers.	Material thickness mm	Working pressure Fuel gas bar	Working pressure Oxygen bar	Part No.
6. Swaged type nozzles 3-cone sealed nozzle forged from a single piece of copper. For all types of cutting up to 300 mm.	3-10	0.3-0.8	1.0-2.0	6370-0200
	10-25	0.3-0.8	3.0-4.0	6370-0300
	25-50	0.3-0.8	3.0-5.0	6370-0400
	50-100	0.3-0.8	4.0-5.5	6370-0500
	100-200	0.3-0.8	4.5-6.0	6370-0600
	200-300	0.3-0.8	5.0-7.0	6370-0700
7. Rivet cutting nozzle 3-cone sealed swaged-type nozzle. Forged entirely from copper. Specially designed to cut rivet joints and rusted screw joints. The joints are cut level with the metal.	5-25	0.2-0.5	2.0-3.0	6119-0100
	25-50	0.2-0.5	3.0-4.0	6119-0200
	50-100	0.2-0.5	3.0-6.0	6119-0300
	75-150	0.2-0.5	4.0-7.0	6119-0400
8. Propane nozzle 3-cone sealed 2-part nozzle for all types of cutting. The inner part has milled slits to control the propane flame effectively. The nozzle is easy to clean.	1-3	0.3-1.5	1.0-1.5	6470-0100
	3-10	0.3-1.5	1.5-2.0	6470-0200
	10-25	0.3-1.5	3.0-4.0	6470-0300
	25-50	0.3-1.5	3.0-5.0	6470-0400
	50-100	0.3-1.5	4.0-5.5	6470-0500
	100-200	0.3-1.5	4.5-6.0	6470-0600
	200-300	0.3-1.5	5.0-7.0	6470-0700
	300-500	0.3-1.5	7.0-10.0	6470-0800

	Joint width mm	Joint depth mm	Working pressure Fuel gas bar	Working pressure Oxygen bar	Part No.
9. Straight gouging nozzle 3-cone sealed fully-forged nozzle for oxygen gouging and edge preparation.	6-8	3-6	0.3-0.6	3.0-4.0	6196-0600
	8-11	6-8	0.3-0.6	4.0-5.0	6196-0800
	9-12	8-11	0.3-0.6	5.0-6.0	6196-1000
10. Bent gouging nozzle 3-cone sealed fully-forged nozzle for oxygen gouging and edge preparation.	6-8	3-6	0.3-0.8	3.0-4.0	6183-0600
	8-11	6-8	0.3-0.8	4.0-5.0	6183-0800
	9-12	8-11	0.3-0.8	5.0-6.0	6183-1000
	10-15	10-13	0.3-0.8	6.0-7.0	6183-1200

CUTTING NOZZLES FOR GASIQ 62-5, GASIQ 49-3 AND S80 INJECTOR

For GasIQ and HARRIS cutting torches	*Material thickness mm*	**Working pressure** *Fuel gas bar*	*Oxygen bar*	**Part No.**
1.Cutting nozzle Propane NX Cutting nozzle for normal preheating. This nozzle is particularly well-suited to cutting scrap with the GasIQ 62-5 torch or the Harris Injector hand cutting torch.	5-10	0.3-0.8	1.5-2.0	6415-0100
	10-15	0.3-0.8	2.0-3.0	6415-0200
	15-25	0.3-0.8	2.5-3.5	6415-0300
	25-50	0.3-0.8	3.0-4.0	6415-0400
	50-75	0.3-0.8	3.0-4.5	6415-0500
	75-150	0.3-0.8	3.5-5.5	6415-0600
	150-200	0.3-0.8	4.5-5.5	6415-0700
2. Cutting nozzle Propane NFF Capabilities are as for NX but with more preheating.	15-25	0.3-0.8	2.5-3.5	6414-0100
	25-50	0.3-0.8	3.0-4.0	6414-0200
	50-75	0.3-0.8	3.0-4.5	6414-0300
	75-150	0.3-0.8	3.5-5.5	6414-0400
	150-200	0.3-0.8	4.5-5.5	6414-0500
	200-300	0.3-0.8	5.0-6.5	6414-0600
3. Cutting nozzle Acetylene 6290 This nozzle is specially adapted for the GasIQ 49-3 cutting attachment or the Harris injector cutter.	5-10	0,3-0,8	1.0-2.0	6418-0100
	10-15	0.3-0.8	1.5-2.5	6418-0200
	15-25	0.3-0.8	2.0-3.5	6418-0300
	25-50	0.3-0.8	3.0-4.5	6418-0400
	50-100	0.3-0.8	3.0-4.5	6418-0500
	100-175	0.3-0.8	3.5-5.5	6418-0600
	175-250	0.3-0.8	4.5-5.5	6418-0700
	250-300	0.3-0.8	5.0-6.5	6418-0800

VVC, VAX AND VPM MACHINE CUTTING NOZZLES

For GasIQ and HARRIS machine cutting torches	*Material thickness mm*	Working pressure *Fuel gas bar*	Working pressure *Oxygen bar*	Part No.
1. VVC Propane/Oxygen VVC-nozzle with high capacity.	1-4	0.2	4.0	6413-0000
	4-6	0.2	2.5	6413-0100
	6-9	0.2	5.0	6413-0200
	9-12.5	0.2	5.0	6413-0300
	12.5-20	0.2	6.0	6413-0400
	20-35	0.2	7.0	6413-0450
	35-60	0.2	7.0	6413-0500
	60-75	0.2	6.5	6413-0550
	75-100	0.2	6.5	6413-0600
	125-150	0.2	6.5	6413-0650
	150-175	0.2	7.0	6413-0700
	175-200	0.2	6.5	6413-0800
	200-225	0.2	6.0	6413-0900
2. NH Propane/Oxygen VVC-nozzle with high capacity.	225-250	0.2	4.0	6413-1000
	250-275	0.2	4.0	6413-1100
	275-300	0.2	4.5	6413-1200
	300-380	0.2	4.5	6413-1300
3. Machine cutting nozzle VAX Acetylene/Oxygen Cutting nozzles for machine cutting torches. VAX=High-speed	1-8	0.2	2.5-4.0	6416-0100
	8-15	0.2	5.0	6416-0200
	15-35	0.2	7.0	6416-0300
	35-75	0.2	7.0	6416-0400
	75-150	0.2	5.0	6416-0500
	150-200	0.2	6.5	6416-0600
4. Machine cutting nozzle VPM MAPP/OXYGEN Cutting nozzles for machine cutting torches. VPM=High-speed	1-4	0.2	3.0	6417-0100
	4-8	0.2	3.5	6417-0200
	8-15	0.2	5.0	6417-0300
	15-35	0.2	7.0	6417-0400
	35-75	0.2	7.0	6417-0500
	75-150	0.2	7.0	6417-0600
	150-200	0.2	7.0	6417-0500
	200-300	0.2	4.0	6417-0600

SAFETY PRODUCTS

NOTE! *A flashback arrestor is a legal requirement on every regulator and outlet point for acetylene.*

GasIQ has a wide selection of safety equipment for both combustible gases and for oxygen. The Swedish Civil Contingencies Agency's Regulations on Inflammable Gas in Loose Containers, SÄIFS 1998:7, lay down that a flashback arrestor must be fitted to the regulator/outlet point for acetylene. Since oxygen increases the speed of combustion, a flashback arrestor should also be fitted to regulators and outlet points for oxygen. The blocking and protective function of the flashback arrestor must be tested every 24 months.

Non-return valves must be fitted to the torch shank in accordance with the Swedish Work Environment Agency's Regulations for Fusion Welding and Thermal Cutting, AFS 1992:9, on both the acetylene and the oxygen side.

GASIQ SAFE-X 2000 FLASHBACK ARRESTOR

The GasIQ SAFE-X 2000 is a resettable flashback arrestor with a number of unique properties.

- Designed to be user-friendly.
- Clear indication of operating mode or blocked mode. A green stripe indicates operating mode. In the event of a flashback, the valve closes and the red stripe indicates that the gas flow has been blocked.
- Very easy resetting in the event of a flashback. When the system has been depressurised and the cause of the flashback determined, the SAFE-X 2000 is reset by pulling out the reset button until the green stripe appears.
- No loose handles or catches which can be damaged or disappear. The reset mechanism is integrated into the design.

As you would expect, the SAFE-X2000 has all the safety functions of a modern flashback arrestor, and is recommended by the Swedish Welding Commission.

- Filter which prevents contamination affecting the operation of the non-return valve.
- Sinter metal flame arrestor which stops and extinguishes flashback.
- Non-return valve which prevents flow-back.
- Flow arrestor which automatically shuts off the gas flow on flashback.
- Thermal fuse which shuts off the gas flow on overheating.

The SAFE-X 2000 is manufactured in accordance with EN-730.

Designation	Part No.
SAFE-X 2000 Acetylene	3004-0000
SAFE-X 2000 Oxygen	3004-1000

GASIQ SAFE-X 1000 FLASHBACK ARRESTOR

The SAFE-X 1000 is a flashback arrestor with lower capacity, but with all the functions of its big brother, the SAFE-X 2000. Dimensioned for the D75 system.

Designation	Part No.
SAFE-X 1000 Acetylene	3005-0000
SAFE-X 1000 Oxygen	3005-1000

GENERAL
For more information on safety, an excellent resource is the Swedish Welding Commission's control instruction, "Gula kortet" [the Yellow Card], order from www.svets.se.

GASIQ THERM-X FLASHBACK ARRESTOR

NOTE! *It is a legal requirement to fit non-return valves fitted on the cutter shank on both the acetylene and the oxygen side.*

THERM-X includes the most important safety functions, but is not resettable. This means that the flashback arrestor must be replaced after a flashback has occurred.

- Filter which prevents contamination affecting the operation of the non-return valve.
- Sinter metal flame arrestor which stops and extinguishes flashback.
- Non-return valve which prevents flow-back.
- Thermal fuse which shuts off the gas flow on overheating.

Designation	Part No.
THERM-X Acetylene	3008-0000
THERM-X Oxygen	3008-1000
THERM-X Oxygen DIN standard (G 1/4")	3008-1500

THERM-X is manufactured in accordance with EN-730.

NON-RETURN VALVES

The non-return valves functions as a complement to the flashback arrestor to prevent flow-back of gases. If flow-back is permitted, there is a risk that the gases will mix, which can lead to a hose explosion if the gas mixture is ignited.

Non-return valves Ox-Ac with threaded connection	Part No.
1. D75 G1/4"	3007-0000
2. S80 / N76 / Cuttex / 62-5 / 43-2 G3/8"	3007-1000
3. Machine torch (2x Ox, 1x Ac) G3/8"	6711-0300

FLAME ARRESTOR

The flame arrestor is a safety device which gives increased protection compared with the use of a non-return valve alone. The flame arrestor consists partly of a non-return valve, and partly of a flame filter which blocks and extinguishes any flashback.

Designation	Part No.
3. Ox 1/4" x 5.0 mm	3009-0500
3. Ac 1/4"V x 5.0 mm	3009-0600
3. Ox 1/4" x 6.3 mm	3009-0100
3. Ac 1/4"V x 6.3 mm	3009-0200
3. Ox 3/8" x 6.3 mm	3009-0700
3. Ac 3/8"V x 6.3 mm	3009-0800
3. Ox 3/8" x 8.0 mm	3009-0300
3. Ac 3/8"V x 8.0 mm	3009-0400
3. Ox 9/16" x 8.0 mm	3009-0350
3. Ac 9/16"V x 8.0 mm	3009-0450

WARNING SIGNS

Must comply with the instructions in the Swedish Code of Statutes. Black text on a yellow reflective background.

Designation	Part No.
Self-adhesive, plastic, A5	5527-0100
Self-adhesive, plastic, 90x130 mm	5527-0000

ACCESSORIES

We offer an extensive range of accessories including protective mittens and goggles. The other equipment includes gas lighters and electric gas preheaters for carbon dioxide and argon/mix. We also supply selected components as spare parts for our most popular products.

Flame-resistant protective mittens
Full-hand model with separate thumb, fits both right and left hand.
CE approved. Made from flame-retardant wool.

Flame-resistant protective mittens	**Part No.** 5538-0000

Protective goggles – CE marked
Model 220. Made from sturdy soft plastic.
Adjustable elastic headband and raisable glasses. May be used over ordinary vision spectacles.

Protective goggles	**Part No.** 5647-0000

Gas lighter
Model Shurlite. Spring-loaded blade, replaceable flints.

Shurlite gas lighter	**Part No.** 5556-0000
Spare flints, Shurlite 5 off	**Part No.** 5556-0002

Bracket
For connecting the regulator to the 5-litre acetylene cylinder.

Bracket	**Part No.** 3122-1000

Opener
For acetylene gas cylinders.

Opener	**Part No.** 5607-0000

Gas preheater for CO2 and AR/mix
The gas preheater is connected between the gas cylinder and the pressure regulator and is used for high-capacity outlets for carbon dioxide or AR/mix, as the regulator is exposed to extreme chilling.
Supplied with 3 m earthed cable. Max flow: 1,200 l/h

220 V, 1-phase, 25 W, W21.8 x 14/1", Co^2	**Part No.** 3707-1500
220 V, 1-phase, 25 W, W24.32 x 14/1", AR/mix	**Part No.** 3707-1600

NOTE! Must not be connected to oxygen.

Gas hose
Complete with hose connections, nuts, flame arrestors.

Ø 5.0 mm, 5 m, Ox+Ac (blue/red)	**Part No.** 5621-2000

Double outlet
Double outlet for two gas outlets from one regulator. Fitted with connections for 5.0 and 6.3 mm internal diameter hose.

Gas outlet valve Ox/AR G3/8”	**Part No.** 3020-0000
Gas outlet valve Ac G3/8”V	**Part No.** 3020-0100

T-connection
T-connection for connection of two regulators to one cylinder.

Argon/Nitrogen connection (W24.32 x 14/1”)	**Part No.** 3020-0500
Co2/Oxygen (W21.8 x 14/1”)	**Part No.** 3020-0600

Hose accessories

Hose connector, complete	Part No.
Intended for a hose with internal diam. 5.0 mm	3541-0000
Intended for a hose with internal diam. 8.0 mm	3541-0200

Connections adapter for hose joint systems	Part No.
G3/8” Right	3201-0025
G3/8” Left	3202-0025

Hose connections complete		Part No.
G1/4”R+L	Ø5+6.3 mm	3308-0022
G3/8”R+L	Ø5+6.3 mm	3215-0080
G3/8”R	Ø5+6.3 mm	3215-0075
G3/8”L	Ø5+6.0 mm	3216-0075
G3/8”R	Ø6.3+8 mm	3215-0085
G3/8”L	Ø6.3+8 mm	3216-0085

(loose hose connections in various dim+nuts: see pricelist)

Left *Right*

QUICK CONNECTORS

Quick connectors approved in accordance with EN 561.

Female

For connection at regulator or flashback arrestor.

Designation		Part No.
Quick connector female G3/8” int.	Ox	3010-0100
Quick connector female G3/8” int. left	Ac-Propane	3010-0200
Quick connector female G3/8” int.	AR/MIX	3010-0300
Quick connector female G1/4” int.	Ox	3010-0400
Quick connector female G1/4” int.	AR/MIX	3010-0500

Male

For connection on the hose side.

Designation		Part No.
Quick connector male 5.0 + 6.3 mm	Ox	3010-0150
Quick connector male 8.0 + 9.5 mm	Ox	3010-0180
Quick connector male 10.5 mm	Ox	3010-0190
Quick connector male 5.0 + 6.3 mm	Ac-Propane	3010-0250
Quick connector male 8.0 + 9.5 mm	Ac-Propane	3010-0280
Quick connector male 10.5 mm	Ac-Propane	3010-0290
Quick connector male 5.0 + 6.3 mm	AR/MIX	3010-0350

Female with hose connector

For connection on the hose side.

Designation		Part No.
Quick connector female 5.0 + 6.3 mm	Ac-Propane	3010-0240
Quick connector female 8.0 + 9.5 mm	Ac-Propane	3010-0245
Quick connector female 5.0 + 6.3 mm	Ox	3010-0140
Quick connector female 8.0 + 9.5 mm	Ox	3010-0145
Quick connector female 5.0 + 6.3 mm	AR/MIX	3010-0340
Quick connector female 8.0 + 9.5 mm	AR/MIX	3010-0345

Male with thread

For connection on the shank non-return valve. NOTE! It is a legal requirement to fit non-return valves between shank and quick connector.

Designation		Part No.
Quick connector male G1/4” int. left	Ac	3010-0210
Quick connector male G3/8” int. left	Ac	3010-0220
Quick connector male G1/4” int.	Ox	3010-0110
Quick connector male G3/8” int.	Ox	3010-0120

For overview of applications, see www.gasiq.com

PRESSURE GAUGES AND FLOW METER

Optimator	Part No.
0-400 bar, Ar+CO^2	3033-4500
Flow meter complete 0-34 l/min	3712-2210
Outer flow meter tubes	3712-2205

Tigex		Part No.
0-400 bar	Ø 50 mm G1/4”	3033-1500
Flow meter complete 0-34 l/min		3712-2210
Outer flow meter tubes		3712-2205

Minex (from 2012)		Part No.
0-315 bar	Ø 50 mm G1/8”	3033-3500
0-30 l/min	Ø 50 mm G1/8”	3033-3600

Maxex/Argonex		Part No.
0-40 bar	Ø 50 mm G1/4”, Ac HT	3033-1400
0-4 bar	Ø 50 mm G1/4”, Ac LT	3033-1200
0-400 bar	Ø 50 mm G1/4”, all apart from Ac HT	3033-1500
0-16 bar	Ø 50 mm G1/4”, OX, Hydr. Nitr. Air LT	3033-1300
0-35 l/min	Ø 50 mm G1/4”, Ar+CO^2 LT	3033-1600
0-6 bar	Ø 50 mm G1/4”, Propane LT	3033-1700

Inlet stem gaskets	Part No.
Acetylene (5 off)	3202-0070
OX, AR-Co^2 and other gases	3710-0050

Flow meter tubes	Part No.
For measuring the precise gas flow at the welding torch gas nozzle	3712-9000


H44 Mo
SVETSTRÅD
WELDING RODS
HITSAUSLANKA
GasiQ
Intelligent solutions for industry
Elga
H44 Mo

CONSUMABLES

GasIQ's range of consumables for gas welding and soldering includes products for the majority of applications. The main groups consist of gas welding rods, silver solder, copper-phosphorus brazing rods and fluxes. For product information sheets: se www.gasiq.com. See also the chapter on handling on page 66.

The main range is listed in our catalogue. Since we represent one of the world's largest producers in the soldering/ brazing sector, we can also provide special solders in a range of formats, including thread, ring and band.

Please get in touch with us at GasIQ to discuss your application.

GAS WELDING RODS

GasIQ H-44
The GasIQ H-44 is a bright-drawn quality welding rod with a weld metal tensile strength of 430 N/ mm2 for gas welding unalloyed steel. The rod is suitable for welding in accordance with the Boiler Welding Standard and the Construction Welding Standard. Sold in minimum quantities of 20 kg.

Diameter *mm*	**Length** *mm*	**Weight /casing** *kg*	**Part No.**
1.60	700	5.0	5144-1500
2.00	700	5.0	5144-2000
2.50	700	5.0	5144-2500
3.00	700	5.0	5144-3000
4.00	700	5.0	5144-4000
5.00	700	5.0	5144-5000

GasIQ H-44 Mo
GasIQ H-44 Mo is a bright-drawn molybdenum alloy welding rod for unalloyed and low alloyed steel. The addition of molybdenum gives wider applications than standard H-44 in, for example, applications such as welding pressure vessels and pipes. Sold in minimum quantities of 20 kg.

Diameter *mm*	**Length** *mm*	**Weight /casing** *kg*	**Part No.**
2.00	700	5.0	5144-2010
2.50	700	5.0	5144-2510
3.00	700	5.0	5144-3010

GasIQ G-4
GasIQ G-4 is alloyed with 0.5 % molybdenum (Mo). Applications include welding pipelines and pressure vessels. The rod is copper coated which guarantees a clean and pore-free weld. GasIQ G-4 is approved by TÜV and DB.

Diameter *mm*	**Length** *mm*	**Weight /casing** *kg*	**Part No.**
2.00	1000	5.0	5160-2000
2.50	1000	5.0	5160-2400
3.00	1000	5.0	5160-3000

TECHNICAL DATA

Type	**Standards**		**Technical data**	**Principal analysis %**				
	AWS A5.2	*DIN 8554*	*Weld metal tensile strength*	*C*	*Si*	*Mn*	*Mo*	*Fe*
H-44	R60-G	GII 21	390-440 N/mm^2	0.10	0.15	1.0		Rest
H-44 Mo		GIV 22	450-520 N/mm^2	0.11	0.20	1.1	0.5	Rest
G-4		GIV 22	450-520 N/mm^2	0.11	0.20	1.1	0.5	Rest

SELECTING SOLDER

Steel and cast steel:
All silver solder can be used for soldering steel. For soldering tool steel, the usual preference is to use as low a bonding temperature as possible, and we recommend starting with silver solder S-44 or S-55.

Stainless steel:
Silver solder S-55 is recommended for soldering stainless steel, since it is a good colour match and has a low working temperature.

Nickel and nickel alloys:
Use silver solder S-44 or S-55.

Copper and copper alloys:
All solders are usable. For soldering pure copper, use S-2-K (Heating and plumbing solder) or S-5-K, (the silver content improves the flow, fluxes are required only for soldering copper alloys such as brass). For brass, the easiest method is to use silver solder e.g. S-44 or S-55 FC.

	Copper	Brass	Bronze	Red metal	Carbon steel	Stainless steel	Heat-treated steel	Cast-iron	Malleable iron castings	Nickel, nickel alloys	Cemented carbide	Low-alloy steel
Copper	●▼											
Brass	●▼	●▼										
Bronze	●▼	●▼	●▼									
Red metal	●▼	●▼	●▼	●▼								
Carbon steel	●	●	●	●	●							
Stainless steel	●	●	●	●	●	●						
Heat-treated steel	●	●	●	●	●	●	●					
Cast-iron	●	●	●	●		●	●	●				
Malleable iron castings	●	●	●	●		●	●	●	●			
Nickel, nickel alloys	●	●	●	●	●	●	●	●	●	●		
Cemented carbide	●	●	●	●	●	●	●	●	●	●	●	
Low-alloy steel	●	●	●	●		●	●	●	●	●	●	●

● Silver solder
GasIQ S-44
GasIQ S-55 / S-55 FC

Fluxes for silver solder
GasIQ H-flux
GasIQ H-pasta

▼ Copper-phosphorus brazing rods
GasIQ S-2-K
GasIQ S-5-K
GasIQ S-15-K

SILVER SOLDER

GasIQ S-44
A cadmium-free silver solder used, for example, in the food processing industry and where the soldered joint may come into contact with drinking water.

Type	Diameter *mm*	Length *mm*	Weight /casing *kg*	Part No.
S-44	1.5	500	1.0	5244-1015
S-44	2.0	500	1.0	5244-1020
S-44	1.5	500	3 pcs.	5244-1515
S-44	2.0	500	3 pcs.	5244-1520

GasIQ S-55 / S-55 FC
A cadmium-free solder with high silver content (55 %) which makes it extremely easy flowing with a high capillary action and deep penetration. It has excellent corrosion resistance, which is particularly suitable, for example, for petrochemical applications. The non-toxic formulation of the solder also makes it ideal for soldering stainless components in the food processing industry. The high silver content gives an excellent colour match for soldering stainless steel and silver. Also available flux-coated (FC).

Type	Diameter *mm*	Length *mm*	Weight /casing *kg*	Part No.
S-55	1,5	500	1.0	5255-1015
S-55	2,0	500	1.0	5255-1020
S-55 FC	1,5	500	1.0	5255-2015
S-55 FC	2,0	500	1.0	5255-2020
S-55 FC	2,0	500	0.25	5255-5020
S-55 FC	1,5	500	4 pcs.	5255-5015

Type	Standards			Technical data			Principal analysis %			
	AWS 5,8	*DIN 8513*	*EN 1044*	*Weld metal tensile strength*	*Working temp.*	*Melting range*	*Ag*	*Cu*	*Sn*	*Zn*
S-44	B-Ag-44CuZn	L-Ag44	AG 203	400 N/mm²	650°C	620-650°C	44.0	30.0		26.0
S-55/ S-55 FC	B-Ag-55CuZnSn	L-Ag55Sn	AG 103	350 N/mm²	660°C	630-660°C	55.0	21.0	2.0	22.0

FLUXES

GasIQ Silver flux
Used in conjunction with GasIQ's silver solder S-44 and S-55. Also used for soldering brass and other copper alloys using GasIQ's copper-phosphorus brazing rods. Working temperature: 500-800 °C.

Type	Weight/unit gram	Part No.
GasIQ H-flux	250	5491-0700
GasIQ H-paste	500	5492-0800

SOFT SOLDER

Silver alloy soft solder is particularly useful in heating and plumbing applications – soldering with all metals apart from Aluminium. Good capillary properties. Silver content: 3.5 %

Diameter *mm*	**Weight** *kg*	**Part No.**
Ø 2.0	0.5	5435-1020
Ø 3.0	0.5	5435-1030

COPPER-PHOSPHORUS BRAZING RODS

GasIQ S-2-K
An approved heating and plumbing solder with 2 % silver for increased flow in the binding zone, which ensures that the joints have excellent durability.

GasIQ S-5-K
The addition of 5 % silver gives a solder with excellent flow properties and a certain amount of ductility in the soldered joint. GasIQ S-5-K is also a popular solder for heating and plumbing applications.

GasIQ S-15-K
An easy-flowing solder with 15 % silver content, and exceptional soldering properties. Particularly well-suited for series production.

Diameter *mm*	**Length** *mm*	**Weight /casing** *kg*	**Part No.**
Ø 2.0	500	1.0	5202-1020
Ø 2.5	500	1.0	5202-1025
Ø 3.0	500	1.0	5202-1030
2x2	500	1.0	5202-1120
2.5x2.5	500	1.0	5202-1125
3x3	500	1.0	5202-1130
Ø 2.0	500	1.0	5205-1020
Ø 2.5	500	1.0	5205-1025
Ø 3.0	500	1.0	5205-1030
2x2	500	1.0	5205-1120
2.5x2.5	500	1.0	5205-1125
3x3	500	1.0	5205-1130
Ø 2.0	500	1.0	5215-1020

Type	**Standards**			**Technical data**			**Principal analysis %**			
	AWS/SFA 5,8	***DIN 8513***	***EN 61190***	***Weld metal tensile strength***	***Working temp.***	***Melting range***	***Ag***	***Cu***	***P***	***Sn***
S-2-K	BCuP6	L-Ag2P	CP 105	250 N/mm²	710°C	645-825°C	2.0	91.5	6.5	-
S-2-K	BCuP3	L-Ag5P	CP 104	250 N/mm²	715°C	645-815°C	5.0	89.0	6.0	-
S-15-K	BCuP5	L-Ag15P	CP 102	250 N/mm²	705°C	645-800°C	15.0	80.0	5.0	-
Silver soft solder	-	-	Sn96Ag04	-	221°C	217°C	3.5	-	-	96

SAFETY INFORMATION AND HANDLING

In all types of work involving acetylene and oxygen, there is always a risk of accident. Using the proper procedure and safe equipment minimises the risk. The most important part of this chapter is the section on safety and choice of equipment.

To make sure that you can utilise GasIQ's products efficiently, this chapter also contains information on the best way of carrying out various types of work.

SAFETY INFORMATION

A complete set-up for welding and soldering must consist of the following:

- 2 gas cylinders, oxygen and acetylene, which must be solidly fixed.
- 2 regulators (1 acetylene and 1 oxygen)
- 1 flashback arrestor, to be connected to the acetylene valve

  NOTE! For increased safety, we also recommend fitting a flashback arrestor to the oxygen regulator.
- Gas hose, red for acetylene and blue for oxygen
- Cutter shank
- Non-return valve on the cutter shank
- Welding nozzles for welding
- Cutting attachment with cutting nozzle for cutting
- Flame-resistant mittens
- Protective goggles
- Warning sign

ASSEMBLY

Before the regulator is fitted, the cylinder valve must be blown clean by opening it briefly. Make sure that the gas jet is not pointing towards a naked flame, hot objects or another person.

- Unscrew the regulator screw until the spring pressure releases (important to avoid damage to the regulator).
- Screw the regulator firmly to the cylinder valve.
- Open the cylinder carefully and note the gas pressure on the contents pressure gauge. Set the required gas pressure using the regulating screw.

  NOTE! Oxygen cylinders and armatures must be kept free from oil and fat. Even small quantities can cause explosions.
- The flashback arrestor is fitted to the acetylene regulator. The connection nut has a left-hand thread. For increased safety, we also recommend fitting a flashback arrestor to the oxygen regulator.
- Connect the hoses to the oxygen valve and to the acetylene flashback arrestor.

  NOTE!
  Blue – oxygen
  Red – acetylene
  Use only clean and undamaged high-quality hoses (EN/ISO marked).
- Fit the non-return valve to the shank of the welding torch and then connect the hoses. The connection nipples on the torch are marked Ox and Ac to avoid mistakes.
- Fit the welding nozzle or cutting attachment using the quick connector on the shank. Secure all gas hoses with hose clamps.

CHOICE OF EQUIPMENT

Regulators

If you are new to welding, you should select regulators with very easy to read pressure gauges (MAXEX), which show both the cylinder pressure and the set working pressure. This helps you set the correct values in accordance with the recommendation table and to avoid emptying the gas cylinders completely, which makes filling more difficult and may even leave you without gas.

Flashback arrestor

There are some imported products on the market which are of dubious quality. Remember that the flashback arrestor is there to protect you! Do not put your safety at risk. Always choose a flashback arrestor of a known make and which is approved by the Swedish authorities. Our SAFE-X2000, SAFE-X 1000 and THERM-X are excellent examples.

Welding and cutting equipment

Gas welding equipment is a high-precision tool. Highly-inflammable gases are involved. Leaks and incorrect mixtures can often destroy the equipment totally, and even lead to serious accidents! Always choose quality Swedish equipment when you are buying kit for gas welding.
The GasIQ D75 will cope well with the vast majority of work. If you need higher-capacity equipment, choose the GasIQ N76 or GasIQ S80.

GasIQ D75 kit.

The sturdy metal box contains a complete welding and cutting system.

SAFETY INSTRUCTIONS

- Make sure that the workplace is well-ventilated and free from combustible material and rubbish.
- Keep a bucket of water beside the worksite.
- Take note of where fire fighting equipment is located, so that you can deploy it immediately. Familiarise yourself with how it works.
- Set out the warning sign in a highly visible place at the door of the room in which the gas cylinders are stored.
- Check that there is no leakage from hoses and connections. This can be done using soapy water or leak spray.
- The flashback arrestor must be used to prevent a flashback entering the regulator and gas cylinder. If a flashback arises, close the valves on the torch and on the gas cylinders. This means that you must always keep the cylinder key and flame-retardant gloves where they are easily accessible.
- Through external heating all gas cylinders, and, where acetylene cylinders are concerned, also through events such as flashback from the torch, hose explosions etc., the working temperature of the cylinder can become so high that there is a risk that it might explode. To avoid this, in the event of leaks, shut off the cylinder valve and cool the cylinder from a safe place.
- To avoid burns and eye damage, the welder must use suitable protective equipment at all times.

GAS WELDING

Gas welding is suitable for welding pipes, fabrications in thin and medium sheet metal, cast iron and non-ferrous metals, as well as surfacing and hard-facing.

Lighting and extinguishing the torch:
Make sure that both valves on the shank are closed.

Set the required working pressure on the regulator (see welding table).

First open the oxygen valve on the shank and let the gas flow for a second or two. Then open the acetylene valve about 1/4 turn.

Light the flame with the gas lighter. **NOTE!** When using the pressure torch (S80), always light the flame on acetylene only, and then open the oxygen valve.

Adjust the size and appearance of the flame using the valves on the shank.

When you are extinguishing the flame, first close the acetylene valve on the shank and then the oxygen valve.

Leftward welding method: With this method, the flame is directed away from the molten pool. It is used for welding material thicknesses up to 3 mm.

Backward welding: With this method, the flame is directed towards the molten pool. It is used for material thicknesses over 3 mm, as it gives better burn-through.

SOLDERING

Soldering is the process of joining the soldered objects together through the use of a consumable which has a lower melting point than the base material. To achieve a good result, it is essential that the joint surfaces are free from oil, fat and scale, and that the edges are rounded to avoid local overheating and to increase the binding zone. The binding zone is the area on which the solder flows out to achieve a metallic bond. It is also known as the diffusion zone.

The most important thing in soldering is that the solder is applied only when the work piece has been evenly heated to the melting point of the solder, which can then “wet” the base material.

Lighting and extinguishing the torch: See under gas welding above.

Braze welding: The method is similar to gas welding and is used for the same type of joints. It does not, however, melt the base material, but only heats the joint surfaces to the working temperature of the filler metal. The filler metal is then applied using the leftward welding method.

Brazing: The working temperature of the filler metal is above 450 °C. Used with small gaps where the filler metal is drawn into the joint by capillary action when the object for brazing is heated. But joints and overlap joints are the most common joint types for capillary brazing. With overlap joints, an overlap of 3-6 times the thickness of the thinnest material is recommended.

Soft soldering: The working temperature of the solder is below 450 °C, otherwise, the process is similar to brazing. The recommended gap for the best capillary action is 0.05-0.2 mm. The maximum permitted gap is 0.5 mm.

CUTTING

Gas cutting is a fast and simple method of cutting and bevelling ferrous metals. The process involves heating the object in advance so that the ferrous metal can burn in pure oxygen.

In cutting, the work piece is heated using the cutter flame. The nozzle is held around 2-3 mm over the location at which the cutting is to begin. When the material is heated to a yellowish-white colour, the cutting oxygen valve (rotary or lever) is opened. The heated ferrous metal then begins to burn and is forced out by the pressure of the flame as the cutter is advanced. To achieve a straight cut, a guide should be used. The torch must be advanced gently and steadily.

Lighting and extinguishing the torch:
Fit the cutting attachment to the shank. Attach an appropriate cutting nozzle (see the section on nozzles, page 48).

Open the oxygen valve on the shank fully and close the acetylene valve. Close the heating oxygen valve on the cutting attachment.

Open the shut-off valve on the regulator if there is one. Set the recommended working pressure using the regulating screw on the regulator.

Open the heating oxygen valve and allow the gas to flow for a second or two. A long hose or small cutting nozzle requires a longer flow time. Do not close the valves fully, but maintain a low gas flow.

Open the acetylene gas valve and allow the gas to flow for a second or two. Light the flame using the gas lighter.
NOTE! When using a pressure torch (S80 and Cuttex), ignite the flame on the acetylene only and then open the heating oxygen valve.

Open the cutting oxygen valve. Adjust to the correct pressure using the regulating screw on the regulator.

Adjust the heating flame using the acetylene gas valve on the shank and the heating oxygen valve on the cutting attachment with the cutting oxygen turned on. The torch is now ready for cutting.

When extinguishing the flame, make sure that the cutting oxygen valve is closed. Close the acetylene gas valve on the shank first, and then the heating oxygen valve on the cutting attachment.

REGISTER

INTRODUCTION

REGULATORS

CUTTING AND WELDING SYSTEMS

CUTTING NOZZLES

SAFETY PRODUCTS

ACCESSORIES

CONSUMABLES

SAFETY INFORMATION AND HANDLING

GasIQ is a Swedish manufacturer of leading products for gas cutting and welding, soldering brazing, and of regulating equipment for gas shielded welding. The company's range includes Optimator®, a unique regulator which reduces gas consumption by at least 43 %. GasIQ's products are sold through local distributors in Europe and throughout the world. GasIQ uses state-of-the-art CNC machinery, and the company has been located in Stenkullen outside Gothenburg since 2003.

www.gasiq.com

GasIQ®

Intelligent solutions for industry

GasIQ AB
Täljstensvägen 5
SE-443 61 Stenkullen, SWEDEN
info@gasiq.com

Phone: +46 (0)302-246 80
Fax: +46 (0)302-246 90
www.gasiq.com