

# CATALOGUE

2008

... all for welding



- ▶ Welding equipment
- ▶ Accessories for gas cutting and welding
- ▶ Safety products
- ▶ Technical chemistry
- ▶ Brazing and soldering consumables
- ▶ Abrasives
- ▶ Supporting equipment
- ▶ Welding consumables



The logo for 'most' features a stylized blue and purple wave above the word 'most' in a bold, lowercase, sans-serif font. A registered trademark symbol (®) is located to the right of the wave.

„RYWAL-RHC” is a private enterprise established in 1992, acting as distributor and wholesaler of welding consumables and equipment, abrasive materials, cutting equipment, ventilation systems, technical chemistry, safety products, technical gases and additional equipment.

The head office and main store are located in Toruń. All efforts and activities of our organisation are dedicated to satisfy needs of large, medium and small companies, as well as individual customers.



„Rywal-RHC” is the biggest welding distributor on the Polish market. The growing number of customers confirms our market success. We have received several rewards from Polish newspapers and business organizations for the most dynamically developing company. **The company also obtained ISO 9001:2000 certificate.**

For the past several years „RYWAL-RHC” has been successfully offering many goods on the OEM basis (with its own brand name).

„MOST” logo has already appeared on many items such as: welding consumables, welding machines, abrasive consumables, technical chemistry, gas welding accessories and personal protective equipment.



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# WELDING EQUIPMENT



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## 1. EQUIPMENT MIG/MAG FANMIG III semi-automatic welding machines



FANMIG 600WP SYNERGY

■ MOST® proudly presents a series of professional semi-automatics FANMIG III designed for industry and crafts. As a result of tests conducted on selected imported machinery a number of modifications has been made. Upgraded machines are therefore produced under the MOST® brand and all comply both our and clients' specific demands.

Machines are designed for welding steel, stainless steel and aluminium (after adaption of welding torch and feeder). Transformers windings are made of copper and though provide high welding quality. They include built in fans for cooling electrical compartment and thermal switches protecting equipment against overloading. Two different kinds of latest technology control panels MINOR and SYNERGY are available for these welding models.

Functions available with MINOR control panel:

- Continuous welding, spot and internal welding,
- Digital display,
- 2 or 4 roll wire feed mechanisms,
- Values of start speed of wire, gas pre-flow / gas past-flow and burn back time are to be set

by manufacturer for farer correction by user.

- Buttons for adjustment flow of gas and fiding of wire from a new spool.
- All the abovementioned settings are to be set using one and only one dial placed at the control panel.

Functions available with SYNERGY include also:

- 6 synergic programs for steel welding (program setting according to welding current A, wire feeding speed m/min or material thickness),
- Digital displays of welding current A+V with HOLD function, provide all setting parameters data.

### Technical data

	FANMIG 180-2 MINOR	FANMIG 280-2 MINOR	FANMIG 280-4 MINOR	FANMIG 320-4 MINOR	FANMIG 400-4 SYNERGY	FANMIG 400GP SYNERGY	FANMIG 400WP SYNERGY	FANMIG 600WP SYNERGY
Main voltage	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V	3x400 V
Fuse	16 A	16 A	16 A	25 A	32 A	32 A	32 A	63 A
Setting range	30-180 A	30-280 A	30-280 A	40-320 A	40-400 A	40-400 A	40-400 A	40-600 A
High duty cycle	30%	20%	20%	40%	30%	30%	30%	25%
Welding range: • at 60% duty cycle • at 100% duty cycle	140 A 110 A	210 A 170 A	210 A 170 A	250 A 210 A	320 A 260 A	320 A 260 A	320 A 260 A	530 A 430 A
Welding range settings no.	7	10	10	12	20	20	20	30
Protection class	IP 21	IP 21	IP 21	IP 21	IP 21	IP 21	IP 21	IP 21
Wire feeder	2 - reel	2 - reel	4 - reel	4 - reel	4 - reel	Fanfeed 4G	Fanfeed 4W	Fanfeed 4W
Feeding speed	1-17 m/min	1-19 m/min	1-20 m/min	1-20 m/min	1-20 m/min	1-20 m/min	1-20 m/min	1-20 m/min
Wire diameters: • steel • stainless steel • aluminium	0,6 - 0,8 mm 0,6 - 0,8 mm -	0,8 - 1,0 mm 0,8 - 1,0 mm -	0,8 - 1,0 mm 0,8 - 1,0 mm 1,0 - 1,2 mm	0,8 - 1,2 mm 0,8 - 1,0 mm 1,0 - 1,2 mm	0,8 - 1,2 mm 0,8 - 1,2 mm 1,0 - 1,2 mm	0,8 - 1,2 mm 0,8 - 1,2 mm 1,0 - 1,2 mm	0,8 - 1,2 mm 0,8 - 1,2 mm 1,0 - 1,2 mm	0,8 - 1,6 mm 0,8 - 1,6 mm 1,0 - 1,6 mm
Weight	59 kg	81 kg	81 kg	98 kg	101 kg	120 + 20 kg	140 + 22 kg	210 + 22 kg
Dimention LxWxH (mm)	750x300x600	790x400x780	790x400x780	790x400x780	500x790x780	630x860x800	630x860x800	510x800x810
Catalogue no.	51 00 022180	51 00 022280	51 00 022284	51 00 022324	51 00 022410	51 00 023410	51 00 023420	51 00 023610

Delivery includes earth cables and power-supply cable (3m), Cables connecting power source and the feeder (5m) supplied with Fanmig 400GP, Fanmig 400WP & Fanmig 600WP versions. Different cable lengths available on request.

We also present standard welding torches dedicated for Fanmig machines. Available cable lengths are 3m, 4m and 5m.

Dedicated models are:

- FANMIG 180-2 MINOR: M15 and M25 MOST
- FANMIG 280-2 MINOR i 280-4 MINOR: M24 and M25 MOST
- FANMIG 320-4 MINOR, 400-4 SYNERGY, 400 GP SYNERGY: M24 and M36 MOST.
- FANMIG 400WP, FANMIG 600WP SYNERGY: M401 lub M501 MOST

For technical data and detailed drawings go to pages 9-20.

FANMIG MOST devices are covered by 24-month guarantee starting with the sale date.

Devices are constantly designed and upgraded though delivered products May vary from those presented in catalogue.

### Main functions of FANMIG semi-automatic machines:

- Compact machines with built in or separated wire feeder (FANMIG 400GP, Fanmig 400WP i FANMIG 600WP),
- Designed for welding with wire (15kg and 18g spools),
- 2 or 4 roll wire feeding systems, all using the same type of feeding wheels
- 400V main voltage,
- Water cooled (Fanmig 400WP, FANMIG 600WP) and air cooled version,
- Enables welding with solid and fluxed-covered wires, argon or gas mixture shield,
- Standard 5m source – feeder cable (extended up to 20m available on request),
- Euro-sockets suitable for any welding torches,
- Ergonomic design, front panel integrated with carrying handle,
- One of front wheels includes a break (except FANMIG 180-2 MINOR).

## 2. EQUIPMENT MMA

### Ponte 1300 MOST Hobby invertors

■ **Ponte 1300 MOST** is the simplest available welding machine for MMA covered electrode. Ponte 1300 MOST was designed to be an alternative to previously popular welding transformers commonly used for welding in the DIY enthusiasts. If compared to welding transformers devices Ponte 1300 is characterised by:

- Low Weight (3,4 kg)
- Competitive price
- Low energy consumption enabling welding using cable extensions.  
Is able to cooperate with weak electric installation.
- Enable to use 3,25 dia electrodes
- Features HotStart and ArcForce functions and anti stick

Machine package includes welding cables, all fitted in a easy to carry suitcase.



Technical data	
	Ponte 1300
Main voltage (50/60 Hz)	1x230V ± 15%
Max. electricity consumption	5 kVA
Welding current ( at 40°C)	
PJ 5%	130A
PJ 60%	45A
PJ 100%	40A
Welding efficiency at 20°C	
fi 2,0 mm/ 55A	50 electrodes
fi 2,5 mm/ 80A	47 electrodes
fi 3,2 mm/ 115A	24 selectrodes
Welding current	10 – 130A
Open circuit voltage	80V
Protection class	IP 21
Dimensions	125 x 240 x 170
Weight	3,4 kg
Catalogue No.	53 00 030130

## Ponte 131/151 MOST



■ **Ponte 131/151 MOST** are inverter welding rectifiers for welding with coated electrodes and for TIG DC welding (arc ignition by tungsten electrode). Ponte 131 and 151 have high duty cycle 45% fo maximum welding current. For Ponte 131-130A and Ponte 151-150A. Both machines have active function Hot Start and anti Stick System.

New, modern, plastic cover assures to the equipment IP 23 protection class.

Thanks to this Ponte 131 and 151 can be suitable for indoor and outdoor working area.

Technical data		
	Ponte 131	Ponte 151
Main voltage (50/60 Hz)	1x230 V +20%/-15%	1x230 V +20%/-15%
Welding current range	10-130 A	10-150 A
Maximal power consumption (45%)	17,4 A	20 A
Maximal electricity consumption (45%)	4,0 kVA	4,7 kVA
Welding current:		
- at 45% duty cycle	130 A	150 A
- at 60% duty cycle	110 A	130 A
- at 100% duty cycle	80 A	100 A
Open circuit voltage	88 V	88 V
Protection class	IP 23	IP 23
	F	F
Dimensions	270x130x240 mm	
Weight	5,1 kg	5,3 kg



Abovementioned data is valid up to 40°C. Detailed technical data are described in servicing instruction. The producer and importer reserve the right to make modifications.

### Catalogue No.:

MMA Ponte 131 Most*	5300030531
MMA Ponte 151 Most*	5300030551
Earth cable and welding cable MOST 3 m	5399990003
TIG SR-17V torch 4m	5603016810
TIG SR-17V torch 8 m	5603016830
Regulator for argon MOST	6230760679
*) without welding cables	

### 3. TIG INVERTOR

#### Pontig 1880 HF

■ **Pontig 1880HF** is welding machine designed for TIG DC welding with ignition HF or striking as well as MMA with coated electrodes. It is the most economical solution to the problem of welding thin stainless steel elements, when proximity arc ignition is required.

Simple to operate control panel, single-phase feed, possibility to weld by tungsten electrodes fi 1,6 or 2,4 mm – it can be successfully used in repairs in food industry, handicraft or small production. One knob on the control panel adjusts all functions and values of the welding parameters.

Construction based on patented DDR (Dual Density Reinforcement) system assures unique solution.

The machine is offered in plastic case as a complete set with torch and welding cables. New, modern cover made of plastic with rubber elements, guarantee protection against shocks even in difficult conditions.



Technical data	
	PONTIG 1880HF
Main voltage (50/60 Hz)	1x230V ± 15%
Maximal electric consumption TIG/MMA	5,4 / 6,7 kVA
Welding current TIG/ MMA PJ 45% PJ 60% PJ 100%	160/160A 140/130A 120/100A
Welding current	10 – 160A
Open circuit voltage	80V
Protection class	IP 23C
Insulation class	H
Dimensions LxWxH (mm)	320x135x285
Weight	4,9 kg
Catalogue No.:	52 00 005300

## 4. COOLING SYSTEMS

### Universal cooling system Fancool 600-WA MOST for welding and cutting torches

■ **Fancool 600WA MOST** is an independent cooling unit for welding and cutting torches.

Old type machines with gas cooled welding torches could not weld efficiently with higher current. The solution is connect to the welding machine MIG, TIG or plasma cutter Fancool 600 WA MOST and water cooled welding torches.



Technical data	
	Fancool 600-WA MOST
Tank	max 4,5 l
Max. pressure	p= 0,35 MPa at Q= 0 l/min
Max flow rate	Q= 10 l/min at p= 0 MPa
Cooling efficiency	1100 W Q= 2 l/min, liquid tmp. 60°C at air tmp. 20°C
Cooling liquid	BTC-15 (TIG or plasma) or liquid for aluminium cooling devices (MIG/MAG)
Power rating	300 VA
Power	230 V/ 50 Hz
Catalogue no.	50 03 003800

## 5. WELDING GENERATORS

### Welding generators MOST

Welding generators are specific type of power generators. Machine is recommended to use everywhere, even in extreme conditions. The main task is to supply power to MMA welding machine. The main advantages of welding generator are: perfect cooperation between the engine and welding generator as well lower price than in case of purchase of combined system – power generator plus welding unit. Obviously, welding generators have output sockets 400 V/230 V and can be used as usual source of current while not welding.

Technical data		
Type	MOST 220S	MOST 300SE
Welding current~	220 A/35%	300 A/35%
Power rating 3~ max nominal	6,7 kVA 6,5 kVA	10,5 kVA 10,0 kVA
Power rating 1~	3,5 kVA	4 kVA
Voltage rating	230 V 400 V	230 V 400 V
Current 3~	9,6 A	15,2 A
Current 1~	15,2 A	17,3 A
Frequency	50 Hz	50 Hz
Current generator	Synchron IP 23	Synchron IP 23
Engine	Honda GX390, 4-stroke engine, 1-cylinds, OHV, 390 ccm reversionary staring by cord, 3000 r.p.m.	VANGUARD , HP22, 4-stroke engine, 2-cylidrs, OHV, 627 ccm starting by cord or starter, 3000 r.p.m.
Tank and sort of fuel	6,5 l unleaded petrol	20 l unleaded petrol
Fuel consumption at ¾ rated load	2,7 l/h	3,6 l/h
Working time ¾ rated load	2,4 h	5,5 h
Quantity of oil in a pot	1,3 l	1,7 l
Noise level	98 dB	98 dB
Dimensions (L x W x H)	775x565x595 mm	900x645x620 mm
Weight	92 kg	167 kg
Standard equipment	Oil absence switch, single-phase socket 16A, triple-phase socket 16A, thermal switch, welding machine 220A (35% duty cycle)	Oil absence switch, single-phase socket 16A, triple-phase socket 16A, thermal switch, magnetic switch with differential gear, volt- meter, frequency meter.
Catalogue No.	50 10 070722	50 10 071030



MOST 220S



MOST 300SE

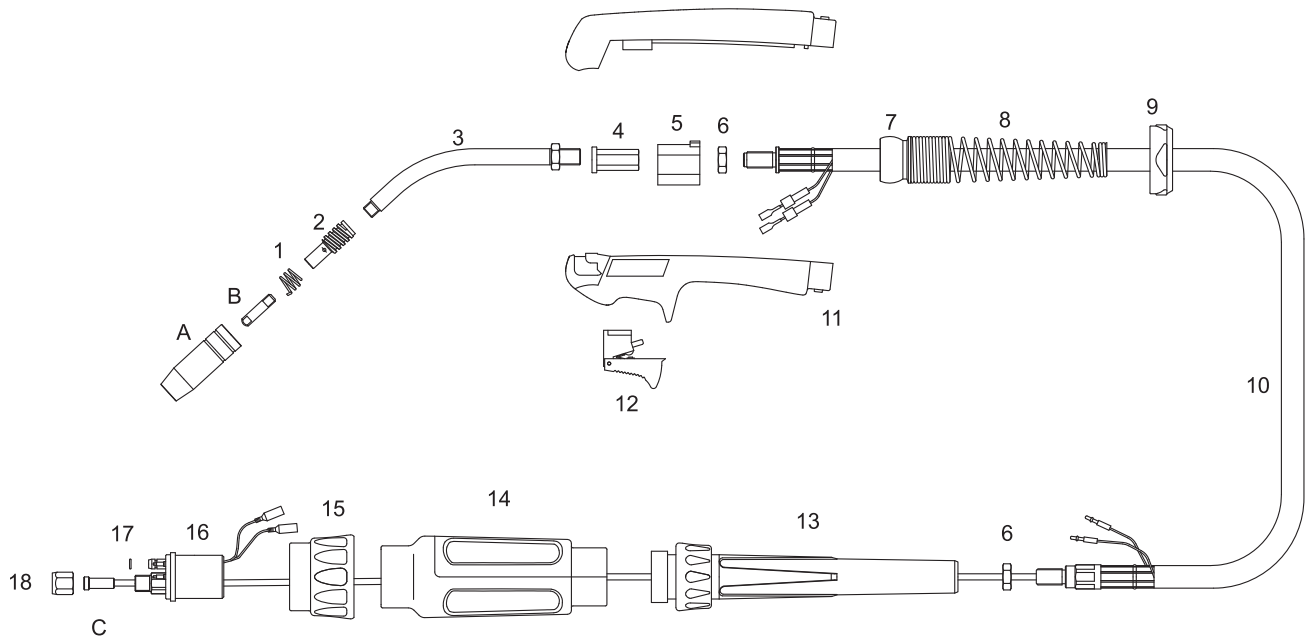
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Welding equipment

## 6. WELDING TORCHES

### 6.1. Torches MIG/MAG

#### M15 MOST



No.	Name	Catalogue No.
A	Cylindrical nozzle fi 16	55 12 300885
	Conical nozzle*	55 12 300890
	Tapered nozzle fi 9,5	55 12 300880
	Gas Spot welding nozzle	55 12 300882
1	Spring*	55 13 008340
2	Tip adaptor*	55 13 003750
3	Swan neck M-15	55 13 014059
3.1	Swan neck M-15 without nozzle and tip	55 13 014060
4	Hexagonal fitting	55 13 003760
5	Ergo Handle Location Body	55 13 013258
6	Lock nut M10x1	55 13 004309
7	MOST Ball Joint M15, 24, 25, 36 ECO8029	55 13 006829
8	MOST Spring Cable Support M15, 24, 25 ECO8016	55 13 006816
9	MOST Handle Lock Nut M15/501 B8008	55 13 006808
10	Hyperflex Cable Assembly 3 m	55 13 016003
10.1	Hyperflex Cable Assembly 4 m	55 13 016004
10.2	Hyperflex Cable Assembly 5 m	55 13 016005
11	MOST Ergo Handle Kit M15/501 B2514/KJ/B	55 13 006514
12	MOST Ergo Trigger M15/501 B2516	55 13 006516
13	MOST Cable support B1841	55 13 006841
14	MOST Gun Plug Housing c/w Nut M15/36 B1518	55 13 006518
15	MOST Gun Plug Nut c/w Insert M15/501 B1519	55 13 006519
16	Gun Plug Body c/w Fixed pins	55 13 013252
17	Gun Plug „O” Ring 4x1	55 13 013962
18	Liner Nut	55 13 004300
B	Contact tip (see in the table on page 20)	
C	Steel liner (see in the table on page 20)	

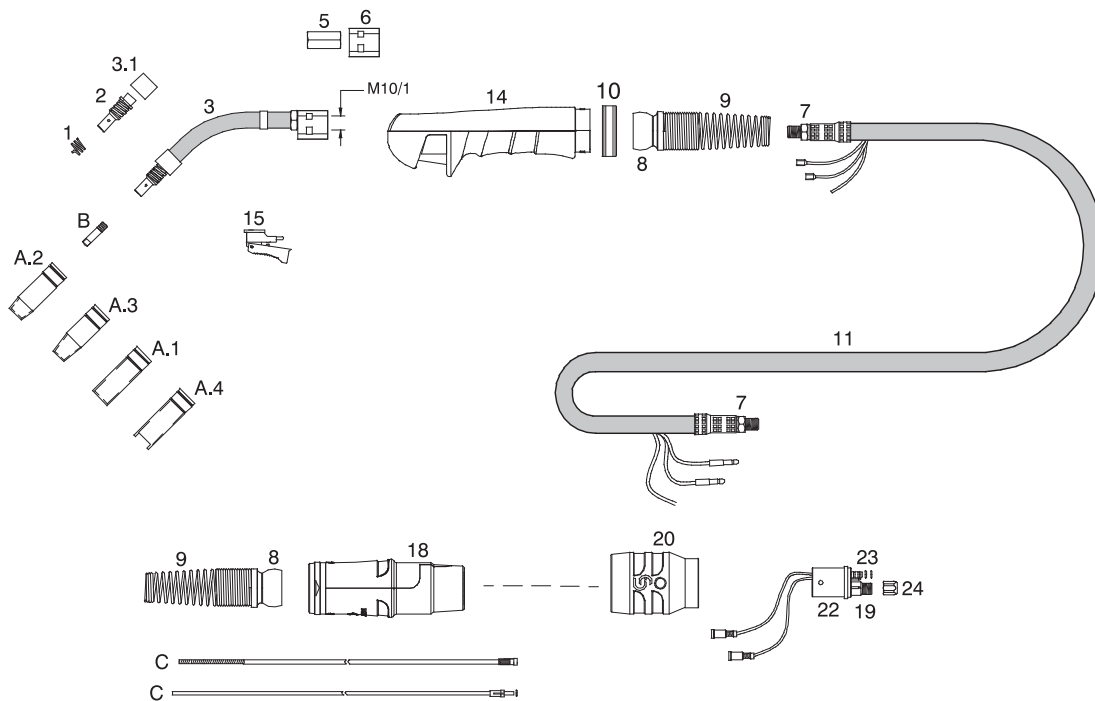
\*) standard version

Type	M 15 MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	180 A CO <sub>2</sub> 150 A mix gas M21
Diameter of wire	0,6 - 1,0 mm

Length	Catalogue No.
3,0 m	55 01 001530
4,0 m	55 01 001540
5,0 m	55 01 001550

M15 MOST PREMIUM



No.	Name	Catalogue No.
A.1	Cylindrical nozzle fi 16	55 12 300885
A.2	Conical nozzle *	55 12 300890
A.3	Tapered nozzle. Fi 9,5	55 12 300880
A.4	Gas Spot welding nozzle	55 12 300882
B	Contact tip (see table on page 20)	
C	Steel liner (see table on page 20)	
1	Spring*	55 13 008340
2	Tip adaptor *	55 13 003750
3	Swan neck M-15 without nozzle and tip	55 13 014060
3.1	Isolated Difuser. M15	55 13 009451
5	Hexagonal fitting	55 13 003760
6	Ergo Handle Location Body	55 13 013258
7	Lock nut M10x1	55 13 004309
8	MOST Ball joint M15/501Premium	55 13 006610
9	MOST Spring Cable Support M15/501Premium	55 13 006611
10	MOST Handle Lock Nut M15/501 Premium	55 13 006636
11	Cable Assembly 3m	55 13 016115
11.1	Cable Assembly 4m	55 13 016116
11.2	Cable Assembly 5m	55 13 016117
14	MOST Handle M15/501Premium	55 13 006601
15	MOST Button M15/501 Premium	55 13 006620
18	MOST Europlug Body M15/36 Premium	55 13 006630
19	MOST Pr Plug PIN 199FT03	55 13 006640
19.1	MOST Pr Socket PIN 199M204	55 13 006641
20	MOST Europlug Lock Nut M15/501 Premium	55 13 006635
22	Gun Plug Body c/w Fixed pins	55 13 013252
23	O-ring 4x1	55 13 013962
24	Liner Nut	55 13 004300

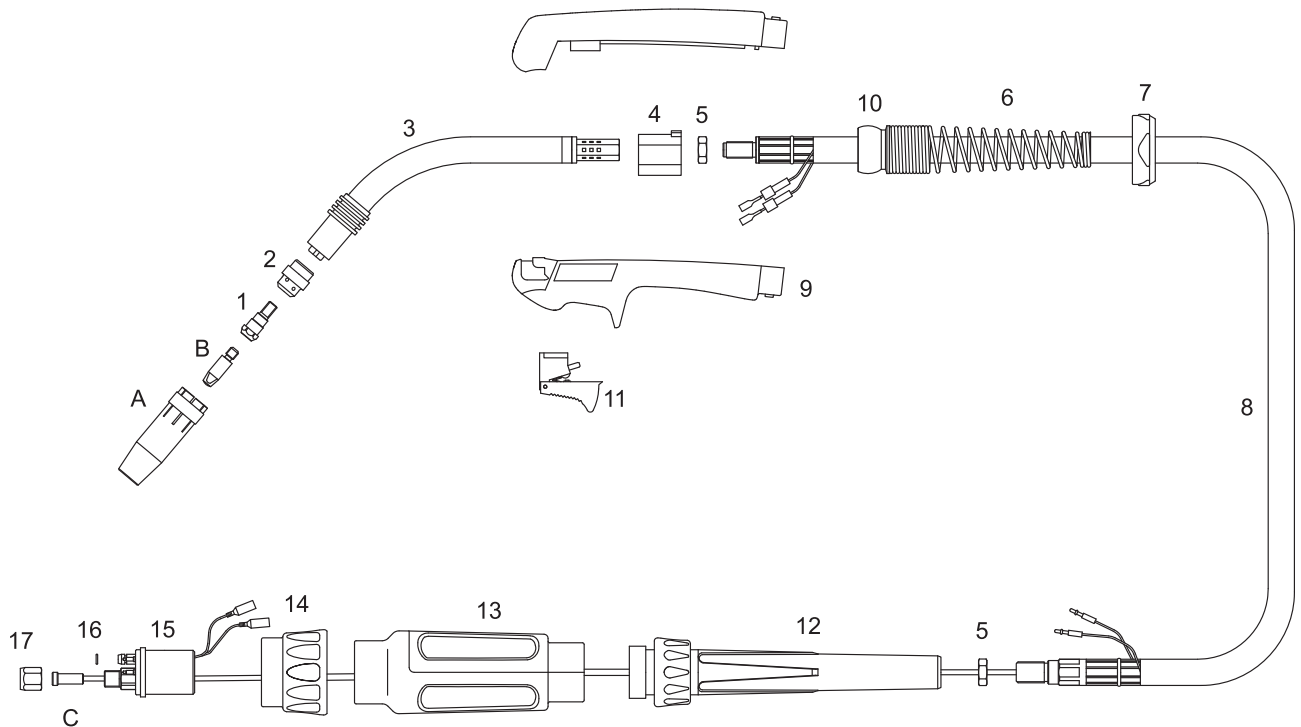
\*) standard version

Type	M 15 MOST PREMIUM
Cooling	Gas

Technical data according to EN 60 974-7	
22Max. load at 60% duty cycle	180 A CO <sub>2</sub> 150 A mix gas M21
Diameter of wire	0,6 - 1,0 mm

Length	Catalogue No.
3,0 m	55 01 010153
4,0 m	55 01 010154
5,0 m	55 01 010155

## M24 MOST



No.	Name	Catalogue No.
A	Cylindrical nozzle 17 x 68	55 12 300897
	Conical nozzle 12,5 x 68*	55 12 300895
	Tapered nozzle 10 x 68	55 12 300896
1	Tip adaptor M6*	55 13 003800
2	Diffuser ceramic M24*	55 13 009460
2.1	Diffuser white M24	55 13 009465
3	Swan Neck M24	55 13 014063
4	Ergo handle location body	55 13 013258
5	Lock Nut M10x1	55 13 004309
6	MOST Spring cable support M15, 24, 25, 36 ECO8016	55 13 006816
7	MOST Handle Lock Nut M15/501 B8008	55 13 006808
8	MOST Hyperflex Cable Assembly M24 3 m	55 13 016023
8.1	MOST Hyperflex Cable Assembly M24 4 m	55 13 016024
8.2	MOST Hyperflex Cable Assembly M24 5 m	55 13 016025
9	MOST Ergo handle Kit M15/501 B2514/KJ/B	55 13 006514
10	MOST Ball Joint M15, 24, 25, 36 ECO8029	55 13 006829
11	MOST Ergo Trigger M15/501 B2516	55 13 006516
12	MOST Cable Support M24/25	55 13 006842
13	MOST Gun Plug Housing c/w Nut M15/36 B1518	55 13 006518
14	MOST Gun Plug Nut c/w Insert M15/501 B1519	55 13 006519
15	Gun Plug Body c/w Fixed Pins	55 13 013252
16	Gun Plug „O” Ring 4x1	55 13 013962
17	Linnet Nut	55 13 004300
B	Contact Tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	

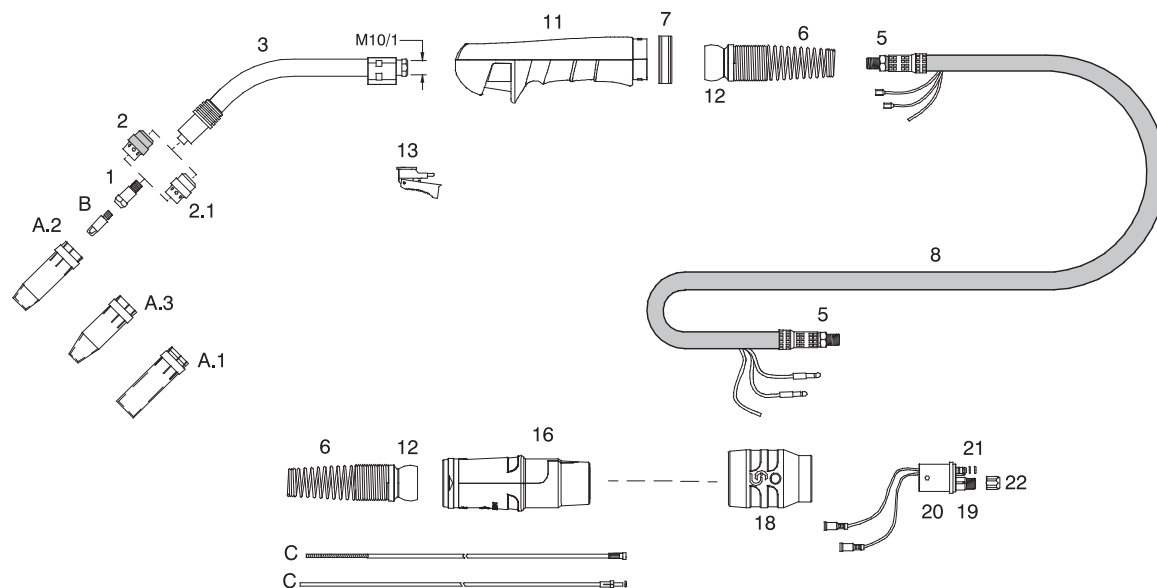
\*) standard version

Type	M 24 MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	250 A CO <sub>2</sub> 220 A mix gas M21
Diameter of wire	0,8 - 1,2 mm

Length	Catalogue No.
3,0 m	55 01 002430
4,0 m	55 01 002440
5,0 m	55 01 002450

## M24 MOST PREMIUM



No.	Name	Catalogue No.
A.1	Cylindrical nozzle 17x68	55 12 300897
A.2	Conical nozzle 12,5x68*	55 12 300895
A.3	Tapered nozzle 10x68	55 12 300896
B	Contact Tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	
1	Tip adaptor M6*	55 13 003800
2	Diffuser ceramic M24*	55 13 009460
2.1	T Diffuser white M24	55 13 009465
3	Swan Neck M24	55 13 014063
5	Lock Nut M10x1	55 13 004309
6	MOST Handle Spring M15/501Premium	55 13 006611
7	MOST Handle Lock Nut M15/501 Premium	55 13 006636
8	MOST Cable Assembly M24 3m	55 13 016120
8.1	MOST Cable Assembly M24 4m	55 13 016121
8.2	MOST Cable Assembly M24 5m	55 13 016122
11	MOST Handle support M15/501 Premium	55 13 006601
12	MOST Ball Joint M15/501 Premium	55 13 006610
13	MOST Button M15/501 Premium	55 13 006620
16	MOST Europlug Body M15/36 Premium	55 13 006630
18	MOST Europlug Lock Nut M15/501 Premium	55 13 006635
19	MOST Pr Plug PIN 199FT03	55 13 006640
19.1	MOST Pr Socket PIN 199M204	55 13 006641
20	Gun Plug Body c/w Fixed pins	55 13 013252
21	O-ring 4x1	55 13 013962
22	Liner Nut	55 13 004300

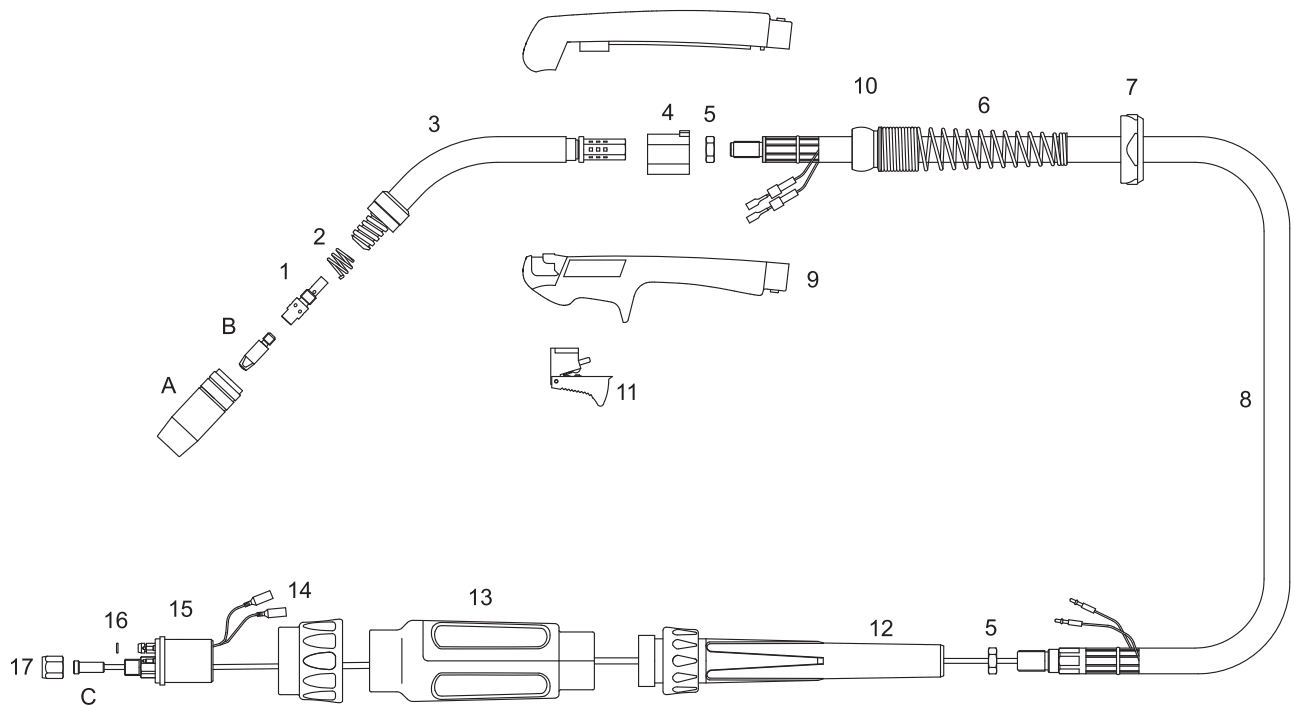
\*) standard version

Type	M 24 MOST PREMIUM
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	250 A CO <sub>2</sub> 220 A mix gas M21
Diameter of wire	0,8 - 1,2 mm

Length	Catalogue No.
3,0 m	55 01 010243
4,0 m	55 01 010244
5,0 m	55 01 010245

## M25 MOST



No.	Name	Catalogue No.
A	Cylindrical Nozzle	55 12 300901
	Conical Nozzle 15x57*	55 12 300900
	Tapered Nozzle 11,5x57	55 12 300904
	Spot welding Nozzle	55 12 300903
1	Tip adaptor M25*	55 13 003804
2	Shrouds Spring M25*	55 13 008360
3	Swan Neck M-25	55 13 014070
3.1	Swan Neck M-25 without nozzle and tip	55 13 014072
4	Ergo Hand Location Body	55 13 013258
5	Lock Nut M10x1	55 13 004309
6	MOST Spring Cable Support M15, 24, 25 ECO8016	55 13 006816
7	MOST Handle Lock Nut M15/501 B8008	55 13 006808
8	Hyperflex Cable Assembly M-25 3 m	55 13 016060
8.1	Hyperflex Cable Assembly M-25 4 m	55 13 016070
8.2	Hyperflex Cable Assembly M-25 5 m	55 13 016075
9	MOST Ergo Handle Kit M15/501 B2514/KJ/B	55 13 006514
10	MOST Ball Joint M15, 24, 25, 36 ECO8029	55 13 006829
11	MOST Ergo Trigger M15/501 B2516	55 13 006516
12	MOST Cable Support M24/25	55 13 006842
13	MOST Gun Plug Housing c/w Nut M15/36 B1518	55 13 006518
14	MOST Gun Plug Nut c/w Insert M15/501 B1519	55 13 006519
15	Gun Plug Body c/w Fixed Pins	55 13 013252
16	Gun Plug „O” Ring 4x1	55 13 013962
17	Liner Nut	55 13 004300
B	Contact tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	

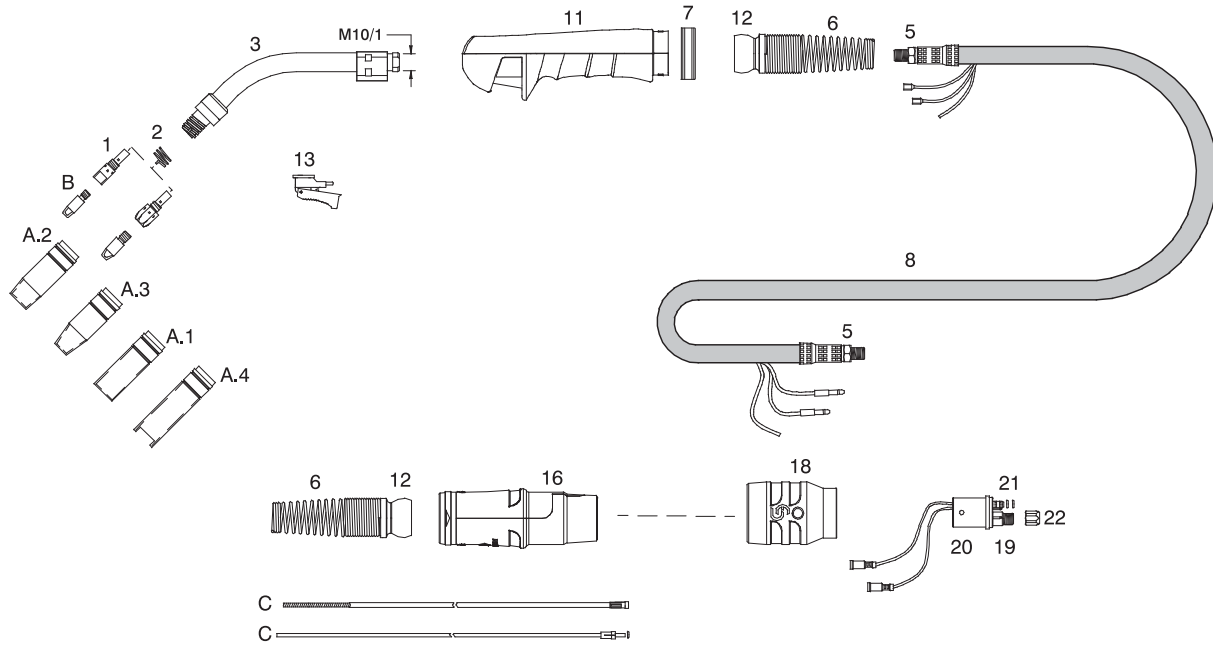
\*) standard version

Type	M 25 MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	230 A CO <sub>2</sub> 200 A mix gas M21
Diameter of wire	0,8 - 1,2 mm

Length	Catalogue No.
3,0 m	55 01 002530
4,0 m	55 01 002540
5,0 m	55 01 002550

M25 MOST PREMIUM



No.	Name	Catalogue No.
A.1	Cylindrical Nozzle	55 12 300901
A.2	Conical Nozzle 15x57*	55 12 300900
A.3	Tapered Nozzle 11,5x57	55 12 300904
A.4	Spot welding Nozzle.	55 12 300903
B	Contact tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	
1	Tip adaptor M25*	55 13 003804
2	Shrouds Spring M25*	55 13 008360
3	Swan Neck M-25 without nozzle and tip	55 13 014072
5	Lock Nut M10x1	55 13 004309
6	MOST Spring Handle M15/501Premium	55 13 006611
7	MOST Handle Lock Nut M15/501 Premium	55 13 006636
8	MOST Cable Assembly M-25 3m	55 13 016060
8.1	MOST Cable Assembly M-25 4m	55 13 016070
8.2	MOST Cable Assembly M-25 5m	55 13 016075
11	MOST Handle Support M15/501 Premium	55 13 006601
12	MOST Ball Joint M15/501 Premium	55 13 006610
13	MOST Button M15/501 Premium	55 13 006620
16	MOST Euro Plug Body M15/36 Premium	55 13 006630
18	MOST Euro Plug Body M15/501 Premium	55 13 006635
19	MOST Electric Socket PIN 199FT03	55 13 006640
19.1	MOST Electric Socket PIN 199M204	55 13 006641
20	Gun Plug Body c/w Fixed Pins	55 13 013252
21	O-ring 4x1	55 13 013962
22	Liner Nut	55 13 004300

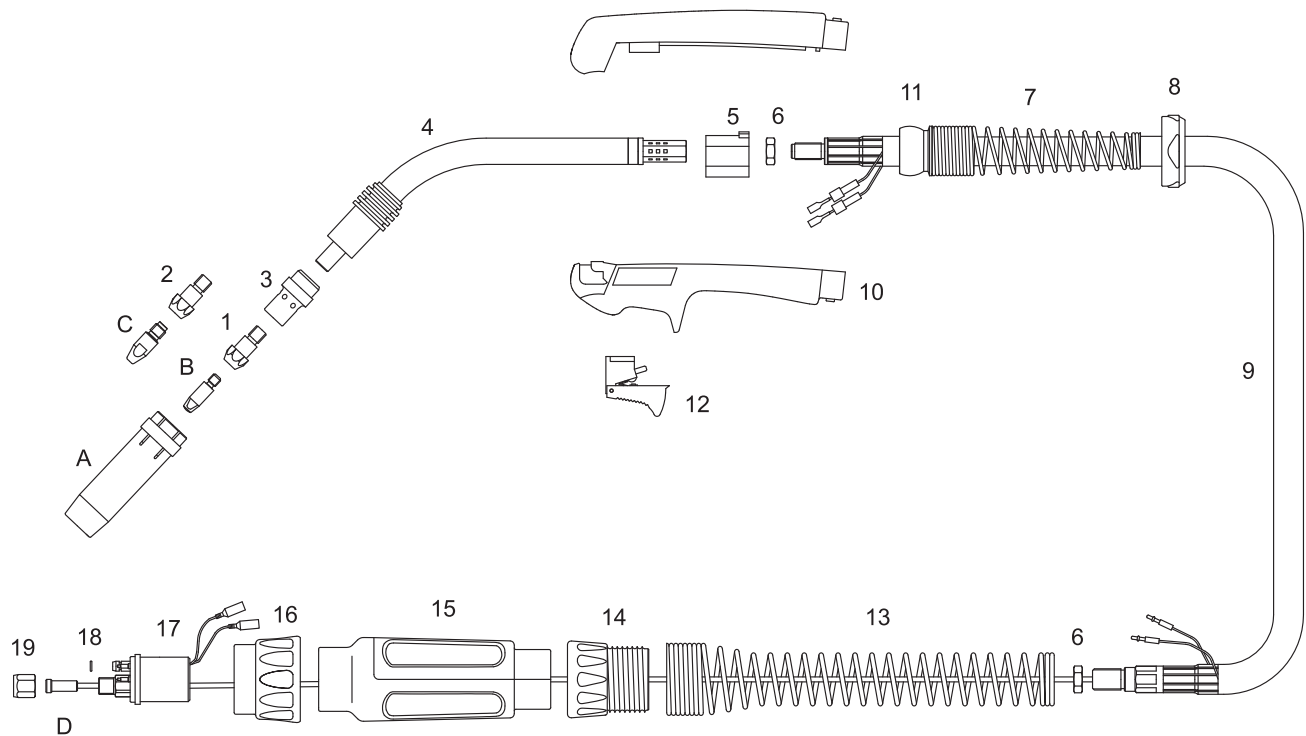
\*) standard version

Type	M 25 MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	230 A CO <sub>2</sub> 190 A mix gas M21
Diameter of wire	0,8 - 1,2 mm

Length	Catalogue No.
3,0 m	55 01 010253
4,0 m	55 01 010254
5,0 m	55 01 010255

## M36 MOST



No.	Name	Catalogue No.
A	Cylindrical Nozzle straight 19x84	55 12 300915
	Conical Nozzle 16x84*	55 12 300910
	Tapered Nozzle 12x84	55 12 300913
	Spot Welding Nozzle	55 12 300917
1	Tip adaptor M6x28*	55 13 003806
2	Tip adaptor M8x28	55 13 003816
3	Diffuser ceramic M36 *	55 13 009486
3.1	Diffuser white M36	55 13 009485
4	Swan Neck M36	55 13 014080
5	Ergo Handle Location Body	55 13 013258
6	Lock Nut M10x1	55 13 004309
7	MOST Spring Cable Support M36	55 13 006818
8	MOST Handle Lock Nut M15/501 B8008	55 13 006808
9	MOST Hyperflex Cable Assembly M36 3 m	55 13 016083
9.1	MOST Hyperflex Cable Assembly M36 4 m	55 13 016084
9.2	MOST Hyperflex Cable Assembly M36 5 m	55 13 016085
10	MOST Ergo Handle Kit M15/501 B2514/KJ/B	55 13 006514
11	MOST Ball Joint M15, 24, 25, 36 ECO8029	55 13 006829
12	MOST Ergo Trigger M15/501 B2516	55 13 006516
13	MOST Cable Support M36	55 13 006826
14	MOST Gun Plug Housing c/w Nut M36/501	55 13 006828
15	MOST Cable Support Nut M15/36 B1518	55 13 006518
16	MOST Gun Plug Nut c/w Insert M15/501 B1519	55 13 006519
17	Gun Plug Body c/w Fixed Pins	55 13 013252
18	Gun Plug „O” Ring 4x1	55 13 013962
19	Liner Nut	55 13 004300
B	Contact tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	

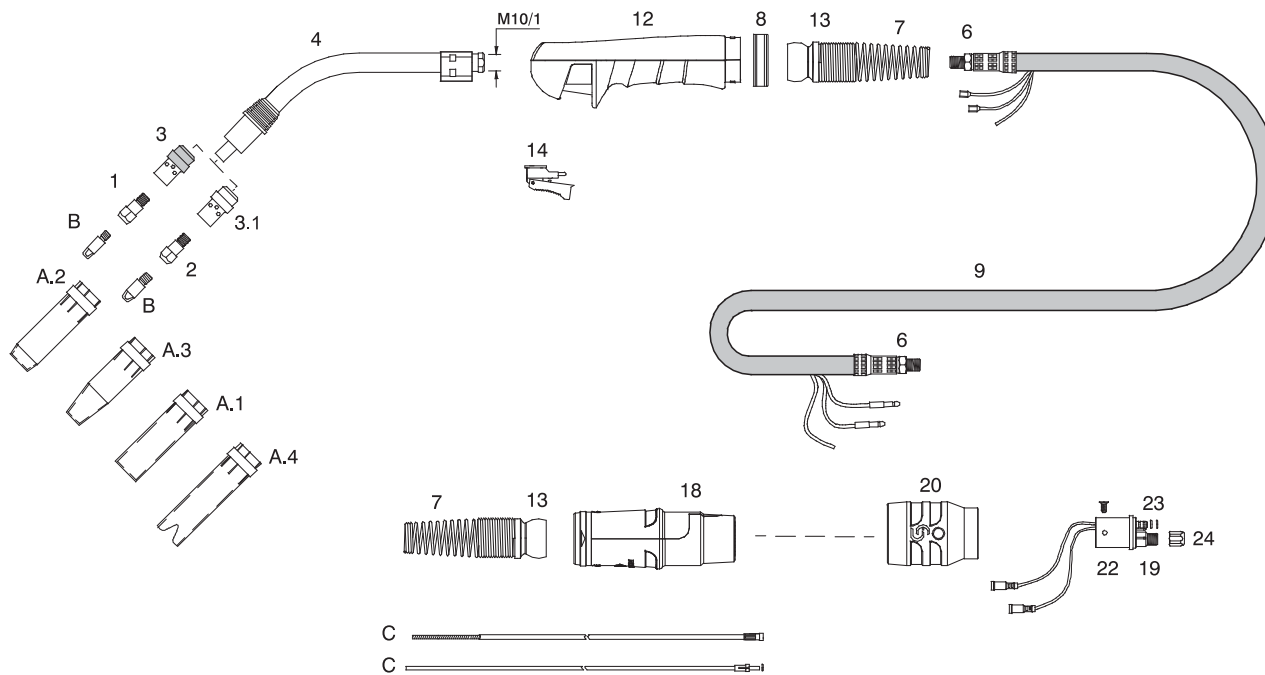
\*) standard version

Type	M 36 MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	300 A CO <sub>2</sub> 270 A mix gas M21
Diameter of wire	0,8 - 1,2 mm

Length	Catalogue No.
3,0 m	55 01 003630
4,0 m	55 01 003640
5,0 m	55 01 003650

### M36 MOST PREMIUM



No.	Name	Catalogue No.
A.1	Cylindrical Nozzle 19x84	55 12 300915
A.2	Conical Nozzle 16x84*	55 12 300910
A.3	Tapered Nozzle 12x84	55 12 300913
A.4	Spot welding Nozzle	55 12 300917
B	Contact tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	
1	Tip adaptor M6x28*	55 13 003806
2	Tip adaptor M8x28	55 13 003816
3	Diffuser ceramic M36 *	55 13 009486
3.1	Diffuser white M36	55 13 009485
4	Swan Neck M36	55 13 014080
6	Lock Nut M10x1	55 13 004309
7	MOST Handle Spring M15/501 Premium	55 13 006611
8	MOST Handle Lock Nut M15/501 Premium	55 13 006636
9	Cable Assembly M36 3m	55 13 016136
9.1	Cable Assembly M36 4m	55 13 016137
9.2	Cable Assembly M36 5m	55 13 016138
12	MOST Handle Support M15/501 Premium	55 13 006601
13	MOST Ball Joint M15/501 Premium	55 13 006610
14	MOST Trigger M15/501 Premium	55 13 006620
18	MOST Euro Plug Body M15/36 Premium	55 13 006630
19	MOST Electric Plug PIN 199FT03	55 13 006640
19.1	MOST Electric Socket PIN 199M204	55 13 006641
20	Most Euro Plug Nut M15/501 Premium	55 13 006635
22	Gun Plug Body c/w Fixed Pins	55 13 013252
23	O-ring 4x1	55 13 013962
24	Liner Nut	55 13 004300

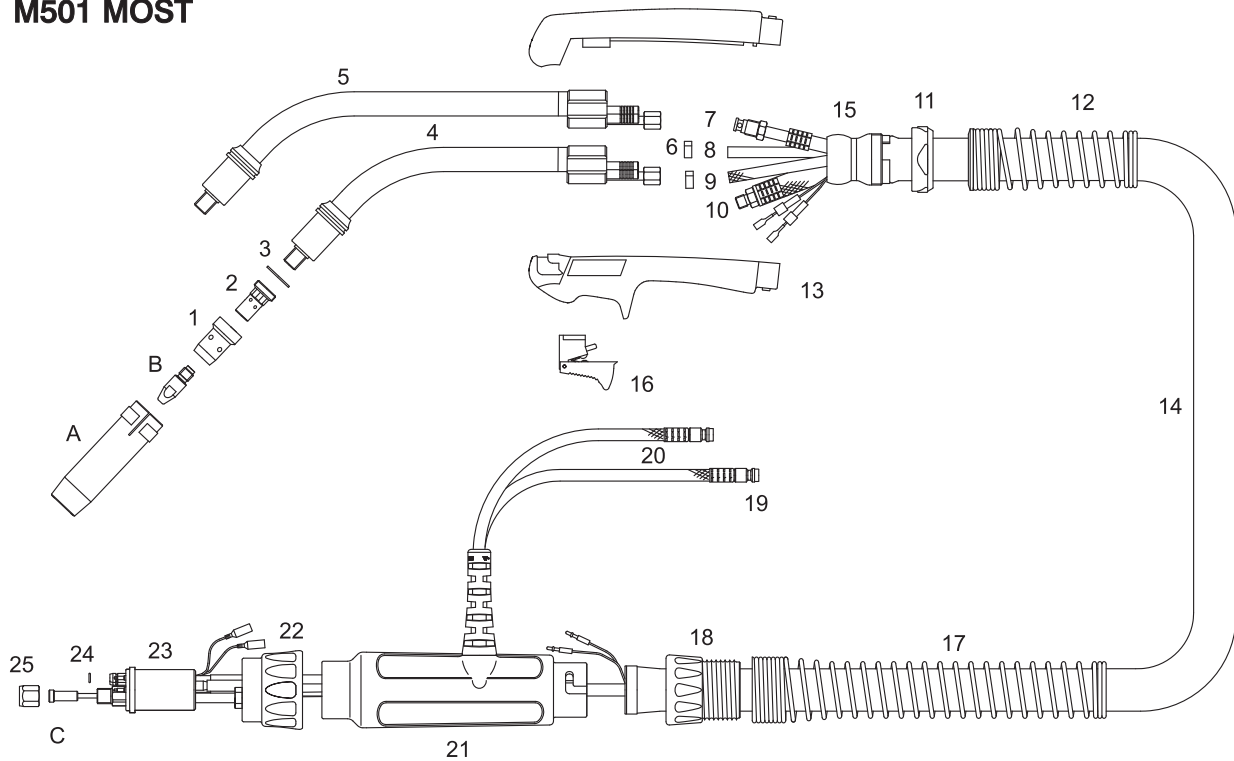
\*) standard version

Type	M 36 MOST PREMIUM
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	340 A CO <sub>2</sub> 310 A mix gas M21
Diameter of wire	0,8 - 1,6 mm

Length	Catalogue No.
3,0 m	55 01 010363
4,0 m	55 01 010364
5,0 m	55 01 010365

## M401 MOST / M501 MOST



No.	Name	Catalogue No.
A	Cylindrical Nozzle 20x76	55 13 000610
	Conical Nozzle 16x76*	55 13 000600
	Tapered nozzle 14x76	55 13 000615
	Spot Welding Nozzle	55 13 000613
1	Diffuser ceramic M401/501*	55 13 009493
1.1	Diffuser white M401/501	55 13 009491
2	Tip Adaptor M401/501 M6x25	55 13 003991
2.1	Tip Adaptor M401/501 M6x29	55 13 003993
2.2	Tip Adaptor M401/501 M8x25*	55 13 003990
2.3	Tip Adaptor M401/501 M8x29	55 13 003992
3	Insulating water M401/501	55 13 013966
4	Swan Neck M401	55 13 014085
5	Swan Neck M501	55 13 014095
6	Water Hose Clamp 9,5 mm	50 15 000095
11	MOST Handle Lock Nut M15/501 B8008	55 13 006808
12	MOST Spring Cable Support M401/501	55 13 006817
13	MOST Ergo Handle Kit M15/501	55 13 006514
15	MOST Ball Joint M401/501	55 13 006839
16	MOST Ergo Trigger M15/501 B2516	55 13 006516
17	MOST Spring Cable Support M401/501	55 13 006827
18	MOST Cable Support Nut M36/501	55 13 006828
19	Water Hose Nipple fi 6	50 14 182003
20	Water Outlet Hose 5x15	51 13 007115
20.1	Water Outlet Hose 5x1,5	51 13 007120
21	MOST Gun Plug Housing M401/501	55 13 006522
22	MOST Gun Plug Nut c/w Insert M15/501 B1519	55 13 006519
23	MOST Gun Plug c/w Fixed Pins WZ-2	55 13 013250
24	Gun Plug „O” Ring 4x1	55 13 013962
25	Liner Nut	55 13 004300
B	Contact Tips (see in the table on page 20)	
C	Steel liner (see in the table on page 20)	

Type	M 401 MOST
Cooling	Liquid

Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	400 A CO <sub>2</sub> 350 A mix gas M21
Diameter of wire	0,8 - 1,6 mm

Length	Catalogue No.
3,0 m	55 01 004130
4,0 m	55 01 004140
5,0 m	55 01 004150

Typ	M 501 MOST
Cooling	Liquid

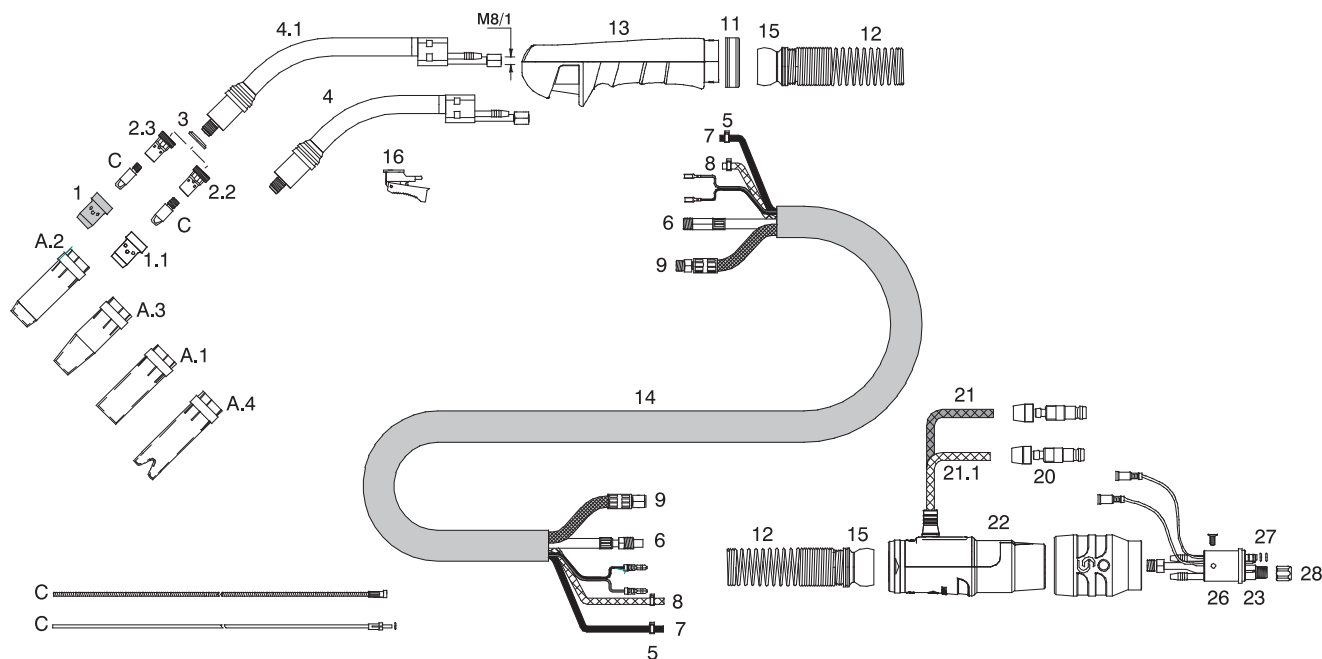
Technical data according to EN 60 974-7	
Max. load at 60% duty cycle	520 A CO <sub>2</sub> 420 A mix gas M21
Diameter of wire	0,8 - 1,6 mm

Length	Catalogue No.
3,0 m	55 01 005130
4,0 m	55 01 005140
5,0 m	55 01 005150

\*) standard version

No.	Description	3,0 m	4,0 m	5,0 m
7	Outer Linter Assy	55 13 006503	55 13 006504	55 13 006505
8	Gas Hose Assy		55 13 015370 (m)	
9	Water Inlet Hose Assy 5 x 1,5		51 13 007120 (m)	
10	Power Cable Assy	55 13 015968	55 13 015969	55 13 015970
14	Switch Lead Assy	55 13 015660	55 13 015661	55 13 015662

M401 MOST PREMIUM / M501 MOST PREMIUM



No.	Name	Catalogue No.
A.1	Cylindrical Nozzle straight 20x76	55 13 000610
A.2	Conical Nozzle 16x76*	55 13 000600
A.3	Tapered Nozzle 14x76	55 13 000615
A.4	Spot welding Nozzle	55 13 000613
B	Contact tips (see in the table on page 20)	
C	Steel Liner (see in the table on page 20)	
1	Diffuser ceramic 401/501 cream white*	55 13 009493
1.1	Diffuser white M401/501	55 13 009491
2	Tip Adaptor M401/501 M6x25	55 13 003991
2.1	Tip Adaptor M401/501 M6x29	55 13 003993
2.2	Tip Adaptor M401/501 M8x25*	55 13 003990
2.3	Tip Adaptor M401/501 M8x29	55 13 003992
3	Insulating water M401/501	55 13 013966
4	Swan Neck M401 MOST	55 13 014085
4.1	Swan Neck M501 MOST	55 13 014095
5	Water Hose Clamp GER 9,5	50 15 000095
11	MOST Handle Lock Nut M15/501 Premium	55 13 006636
12	MOST Spring Support M15/501Premium	55 13 006611
13	MOST Handle Support M15/501Premium	55 13 006601
15	MOST Ball Joint M15/501 Premium	55 13 006612
16	MOST Trigger M15/501 Premium	55 13 006620
20	Water Hose Nipple fi 6	50 14 182003
21	Water Outlet Hose 5x15	51 13 007115
21.1	Water Outlet Hose 5x1,5	51 13 007120
22	MOST Euro Plug Body M401/501Premium	55 13 006632
23	MOST Electric Plug PIN 199FT03	55 13 006640
23.1	MOST Electric Socket PIN 199M204	55 13 006641
24	MOST Euro Plug Nut M15/501 Premium	55 13 006635
26	MOST Gun Plung c/w Fixed Pins WZ-22	55 13 013250
27	O-ring 4x1	55 13 013962
28	Liner Nut	55 13 004300

Type	M 401 MOST PREMIUM
Cooling	Liquid

Technical data according to EN 60 974-7 M401	
Max. load at 60% duty cycle	400 A CO <sub>2</sub> 350 A mix gas M21
Diameter of wire	0,8 - 1,6 mm

Length	Catalogue No.
3,0 m	5501014013
4,0 m	5501014014
5,0 m	5501014015

Type	M 501 MOST PREMIUM
Cooling	Liquid

Technical data according to EN 60 974-7 M501	
Max. load at 60% duty cycle	520 A CO <sub>2</sub> 420 A mix gas M21
Diameter of wire	0,8 - 1,6 mm

Length	Catalogue No.
3,0 m	5501015013
4,0 m	5501015014
5,0 m	5501015015

\*) standard version

No.	Name	3,0 m	4,0 m	5,0 m
6	Spiral cable	55 13 006643	55 13 006644	55 13 006645
7	Gas Hose Black [mb]	55 13 015370 (mb)		
8	Water Inlet Hose 5x1,5 [mb]	51 13 007120 (mb)		
9	Power Cable Assy.	55 13 015968	55 13 015969	55 13 015970
14	Switch Lead Assy.	55 13 015660	55 13 015661	55 13 015662
14.1	Switch Lead. [mb]	55 13 015964 (mb)		

## 6.2. SPARE PARTS FOR WELDING TORCHES MIG/MAG

Contact tips table						
Contact tip type	MOST M15, MB-15, (M6 slim), M6x25	MOST M24/M25/M36, MB-24, MB-25, MB-36, (M6 thick), M6x28	MOST M401/M501, MB-401D, MB-501D M8x30	MB 15 (M6 slim) M6x25 (n8. Abicor Binzel)	MB 24, MB 25, MB 36 (M6 thick) M6x28 (no. Abicor Binzel)	MB 401 D MB 501 D M8x30 (no. Abicor Binzel)
0,6 mm	55 13 002150	-	-	140.0008	-	-
0,8 mm	55 13 002170	55 13 002180	55 13 002250	140.0059	140.0051	140.0114
1,0 mm	55 13 002320	55 13 002330	55 13 002340	140.0253	140.0242	140.0313
1,2 mm	55 13 002470	55 13 002480	55 13 002490	-	140.0379	140.0442
1,4 mm	-	55 13 002610	55 13 002605	-	-	-
1,6 mm	55 13 002720	55 13 002730	55 13 002800	-	140.0555	140.0587
0,6 mm CuCrZr	55 13 002151	-	-	140.0855	-	-
0,8 mm CuCrZr	55 13 002171	55 13 002190	55 13 002251	140.0062	140.0054	140.0117
1,0 mm CuCrZr	55 13 002321	55 13 002331	55 13 002341	140.0256	140.0245	140.0316
1,2 mm CuCrZr	55 13 002473	55 13 002482	55 13 002491	-	140.0382	140.0445
1,4 mm CuCrZr	-	-	55 13 002600	-	-	140.0536
1,6 mm CuCrZr	55 13 002725	55 13 002731	55 13 002801	-	140.0558	140.0590
0,8 mm al.	55 13 002172	55 13 002210	55 13 002253	141.0002	141.0001	141.0003
1,0 mm al.	55 13 002324	55 13 002335	55 13 002365	141.0007	141.0006	141.0008
1,2 mm al.	55 13 002475	55 13 002484	55 13 002493	-	141.0010	141.0015
1,6 mm al.	55 13 002726	55 13 002732	55 13 002808	-	141.0020	141.0022
0,8 mm al. CuCrZr	55 13 002173	55 13 002212	55 13 002254	-	-	-
1,0 mm al. CuCrZr	55 13 002325	55 13 002336	55 13 002370	-	-	-
1,2 mm al. CuCrZr	55 13 002447	55 13 002485	55 13 002494	-	-	-
1,6 mm al. CuCrZr	55 13 002728	55 13 002733	55 13 002809	-	-	-

Steel liners for welding torches MIG/MAG – spiral liners for steel wires-						
Diameter	MOST M15/M24/M25/M36, MB-15AK, MB-24KD, MB-25AK, MB-36KD			MOST M401/M501, MB-240D, MB-401D, MB-501D non - coated		
	3,0 m	4,0 m	5,0 m	3,0 m	4,0 m	5,0 m
0,8 mm	55 13 012390*	55 13 012400*	55 13 012402*	55 13 012390	55 13 012400	55 13 012402
1,0 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,2 mm	55 13 012440**	55 13 012470**	55 13 012480**	55 13 012490	55 13 012500	55 13 012505
1,6 mm	55 13 012510***	55 13 012530***	55 13 012541***	55 13 012570	55 13 012573	55 13 012575

Colours  
 \*) blue  
 \*\*) red  
 \*\*\*) yellow

Steel liners for welding torches MIG/MAG – teflon liners for aluminium wires						
Diameter	MOST M15/M24/M25/M36, MB-15AK, MB-24KD, MB-25AK, MB-36KD			MOST M401/M501, MB-240D, MB-401D, MB-501D		
	3,0 m	4,0 m	5,0 m	3,0 m	4,0 m	5,0 m
0,8 mm	55 13 012120*	55 13 012170*	55 13 012175*	55 13 012120*	55 13 012170*	55 13 012175*
1,0 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,2 mm	55 13 012205**	55 13 012206**	55 13 012207**	55 13 012205**	55 13 012206**	55 13 012207**
1,6 mm	55 13 012210***	55 13 012212***	55 13 012214***	55 13 012210***	55 13 012212***	55 13 012214***
1,0 - 1,2 mm Karbon-teflon-brass	55 13 012668	55 13 013003	55 13 012664	55 13 012668	55 13 013003	55 13 012664

Colours  
 \*) blue  
 \*\*) red  
 \*\*\*) yellow

### 6.3. Wire feeder rollers

Roller type: Fi 37 2R Fanmig II	
Dimensions	[mm]
Diameter	37
Inner diameter	10
Width	15 (17)
Producer	Machine type
Most	Fanmig II: Fanmig 230 C-2 (since Nov 2005 r.), Fanmig 271 C-2
Catalogue No.	Wire diameter
5113007802	0,8 – 1,0
5113007883	1,0 – 1,2
5113007803	0,8 – 1,0 Al

Roller type: Minimig/ZP-2 OZAS	
Dimensions	[mm]
Diameter	36,7
Inner diameter	16
Width	10
Producer	Machine type
OZAS	Minimig 163-250-360, rollers: ZP-2/7/9 (new types)
Catalogue No.	Wire diameter
5113007785	0,6
5113007790	0,8
5113007800	0,8 Al
5113007850	1,0
5113007881	1,0 Al
5113007910	1,2
5113007920	1,2 Al
5113007990	1,6
5113008000	1,6 Al

Type: Fi 30 Cooptim (Fanmig III, Bester)	
Dimensions	[mm]
Diameter	30
Inner diameter	22
Width	10
Producer	Machine type
Most (Alfa In)	Fanmig III
Bester	some: Magster 250 4x4, 250T, 315T (TYP COOPTIM CWF 4010)
Catalogue No.	Wire diameter
5113007783	0,6-0,8
5113007788	0,6-0,8 Al
5113007960	1,2-1,6 Al
5113007783	0,6-0,8
5113007826	0,8-1,0
5113007828	0,8-1,0 Al
5113007862	1,0-1,2
5113007863	1,0-1,2 Al
5113007956	1,2-1,6
5113007895	1,0-1,2 R
5113007899	1,2-1,4 R

Roller type: Fi 37 Powertec- Fanmig II-Ozas-Esab	
Dimensions	[mm]
Diameter	37
Inner diameter	19
Width	12
Producer	Machine type
Most	Fanmig II: Fanmig 271 C-4, Fanmig 351 C-4, Fanmig 351LWF I Fanmig 451WWF
Lincoln Electric	Powertec: 1 roller: 200C, 250C, 300C, feeder LF 22; 2 rollers: 300C, 280Pro, 350Pro, 420Pro; PT 300, 360, 420 i 500 With external feeder LF 24, 33
OZAS/ESAB	Minimig-241/341; Magomigi with feeder ZP-22/30; feeders ZP-30/20, OrigoMig; OrigoFeed 30
Catalogue No.	Wire diameter
5113007793	0,6-0,8
5113007808	0,8-1,0
5113007809	0,8-1,0 Al
5113007856	1,0-1,2R
5113007865	1,0-1,2
5113007885	1,0-1,2 Al
5113007928	1,2 Al
5113007931	1,2-1,6
5113007935	1,2-1,6 Al
5113007937	1,2-1,6 R

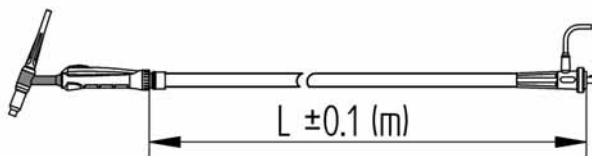
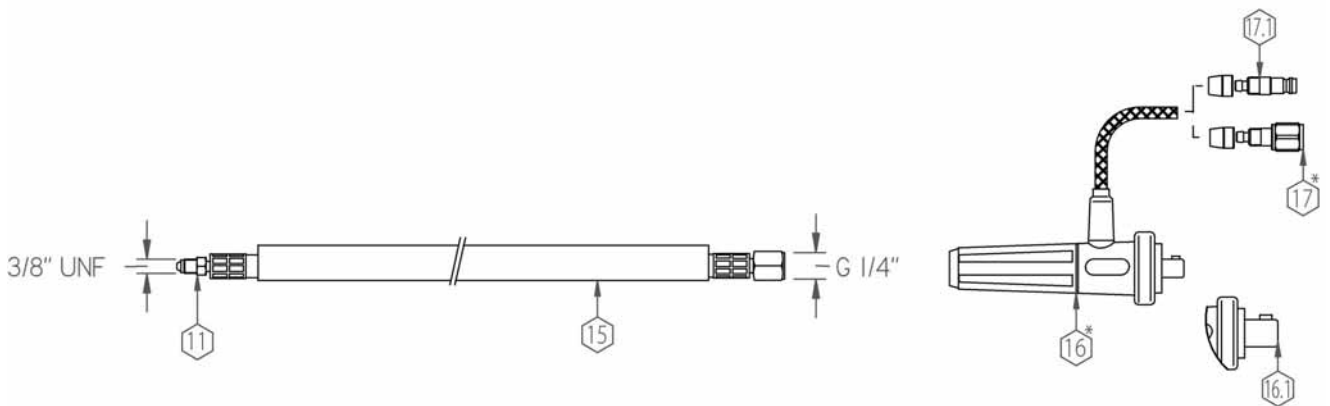
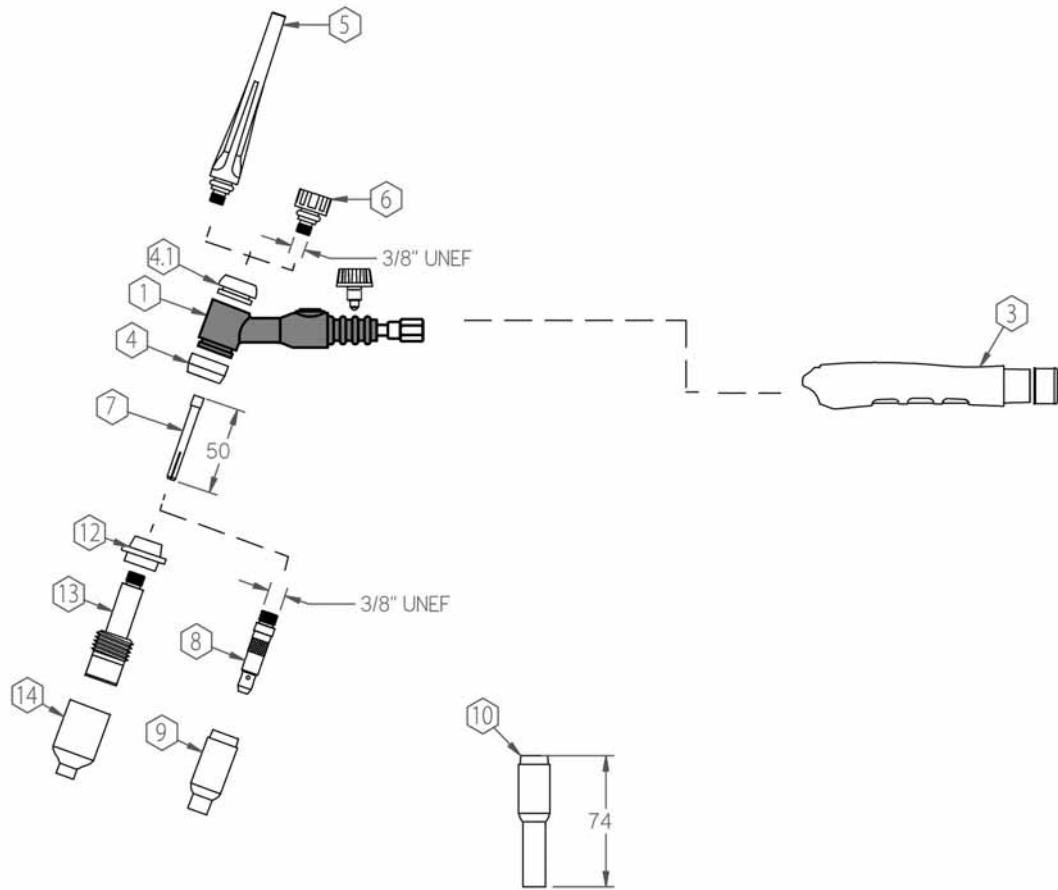
Roller type: Fi 30 Lorch-Esab-OZAS-Bester-Fanmig I	
Dimensions	[mm]
Diameter	30
Inner diameter	14
Width	12
Producer	Machine type
Most	Fanmig I: Fanmig – 190 – 270 C2/C4 – 350 C4 – 350LWF i 450 WWF
Lorch	All
OZAS	Minimig 164-240-320, wire feeder ZP-10 – 11 – 12 – 15 – 20 (old types), Minimig 281
ESAB	LKB-260-320-400, MEK2/4, EsabFeed 30 and others
Bester	Some: Magster 250 4x4, 250T, 315 4x4, 315T, 350C, 350W, 450C, 500 (TYP Fortrans)
Catalogue No.	Wire diameter
5113007796	0,6-0,8
5113007805	0,8 Al
5113007810	0,8-1,0
5113007811	1,0 Al
5113007855	1,0/1,2 R – 1,4/1,6 R
5113007860	1,0-1,2
5113007891	1,0/1,2 R
5113007905	1,2
5113007918	1,2/1,4/1,6 R
5113007925	1,2 Al
5113007934	1,2-1,6 Al
5113007930	1,2-1,6
5113007989	1,4/1,6 R
5113007995	1,6 Al
5113007998	2,0

Roller type: Fi 40 Cooptim (Bester)	
Dimensions	[mm]
Diameter	37
Inner diameter	19
Width	10
Producer	Machine type
Bester	Some: Magster 350C, 450C, 500W; All: Magster-351W, 400 Plus/W, 500PlusW, 501W, Optymag (TYP COOPTIM CWF 5110)
Catalogue No.	Wire diameter
5113007991	2,4-3,2 R
5113007787	0,6-0,8 Al
5113007792	0,6-0,8
5113007825	0,8-1,0
5113007827	0,8-1,0 Al
5113007862	1,0-1,2 Al
5113007866	1,0-1,2 R
5113007871	1,0-1,2
5113007955	1,2-1,6
5113007958	1,2-1,6 Al
5113007997	1,6-2,0 R
5113007999	1,6-2,0

## 6.4. TIG torches

### 17V MOST

WWW.RYWAL.COM.PL



**L: 4, 8 m**

## 17V MOST (technical specification)

No.	Name	Catalogue No.	
1	Torch SR-17V MOST	56 13 003417	217VA01
2	Valve SR-17V	56 13 003135	299TV01
3	Handle SR-17V MOST	56 13 007510	
4	Insulator SR-17/18/26	56 13 014810	
4.1	Cup goshet SR-17/18/26 Most	56 13 014811	
5	Long back cup SR-17/18/26	56 13 003181	
6	Short back cup SR-17/18/26	56 13 003270	
7	Standard collet 1,0 SR-17/18/26	56 13 009930	
	Standard collet 1,6 SR-17/18/27	56 13 009932	
	Standard collet 2,0 SR-17/18/28	56 13 009934	
	Standard collet 2,4 SR-17/18/29	56 13 009936	
8	Standard collet body 1,0 SR-17/18/29	56 13 003830	
	Standard collet body 1,6 SR-17/18/30	56 13 003883	
	Standard collet body 2,0 SR-17/18/31	56 13 003914	
	Standard collet body 2,4 SR-17/18/32	56 13 003921	
9	Standard ceramic cup 6,5x47 #4	56 13 000768	
	Standard ceramic cup 8,0x47 #5	56 13 000770	
	Standard ceramic cup 9,5x47 #6	56 13 000780	
	Standard ceramic cup 11,0x47 #7	56 13 000783	
	Standard ceramic cup 12,5x47 #8	56 13 000784	
10	Long ceramic cup 8,0x76 #5	56 13 001006	
	Long ceramic cup 9,5x76 #6	56 13 001008	
	CLong ceramic cup 11,0x76 #7	56 13 001010	
11	Electric-Gas Cable SR-17 MOST 4m	56 13 016112	217CX04
11.1	Electric-Gas Cable SR-17 MOST 8m	56 13 016113	217CX08
12	Laminar Insulator	56 13 014812	
13	Standard gas lens body 1,0 SR-17/18/26	56 13 008235	
	Standard gas lens body 1,6 SR-17/18/26	56 13 008252	
	Standard gas lens body 2,4 SR-17/18/26	56 13 008272	
14	Standard gas lens cup 6,5x42 lam #4	56 13 000902	
	Standard gas lens cup 8,0x42 lam #5	56 13 000900	
	Standard gas lens cup 9,5x42 lam #6	56 13 000888	
	Standard gas lens cup 11,0x42 lam #7	56 13 000886	
	Standard gas lens cup 12,5x42 lam #8	56 13 000884	
15	Cable cover assembly 35x1,5 [mb]	51 13 015240	
16	Plug Assy SR-17V MOST 10-25	56 13 016412	4AM1025
16.1	Plug Assy SR-17V MOST 35-50	56 13 016414	4AM3550
17	Nut with Nipple 1/4	50 14 182040	299TG2
17.1	Nipple fi 5 (below nut)	50 14 182044	299TG881

Plugs – see table at page 30

Type	17V MOST
Cooling	Gas

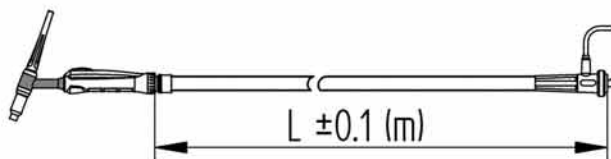
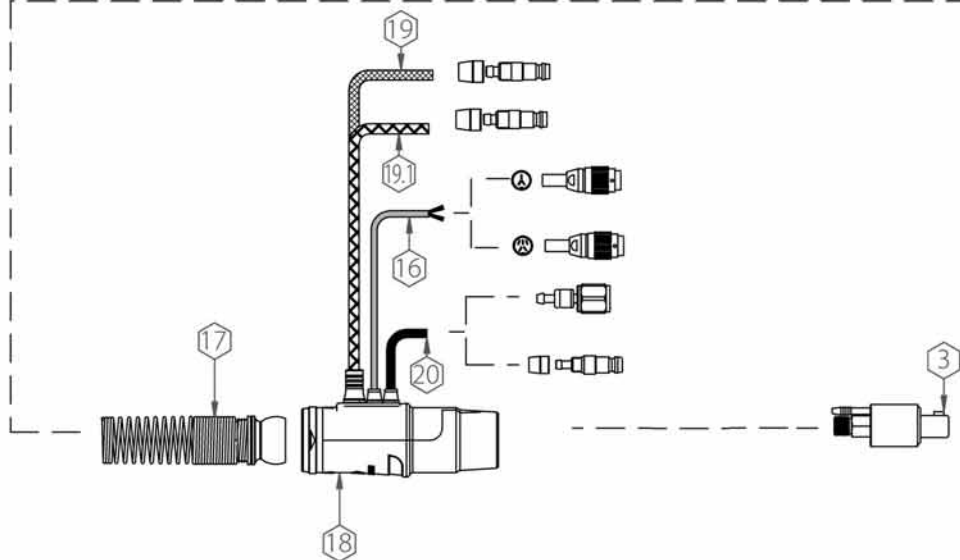
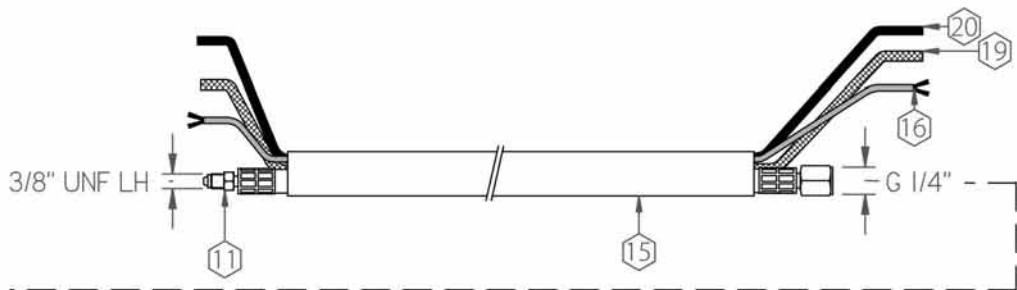
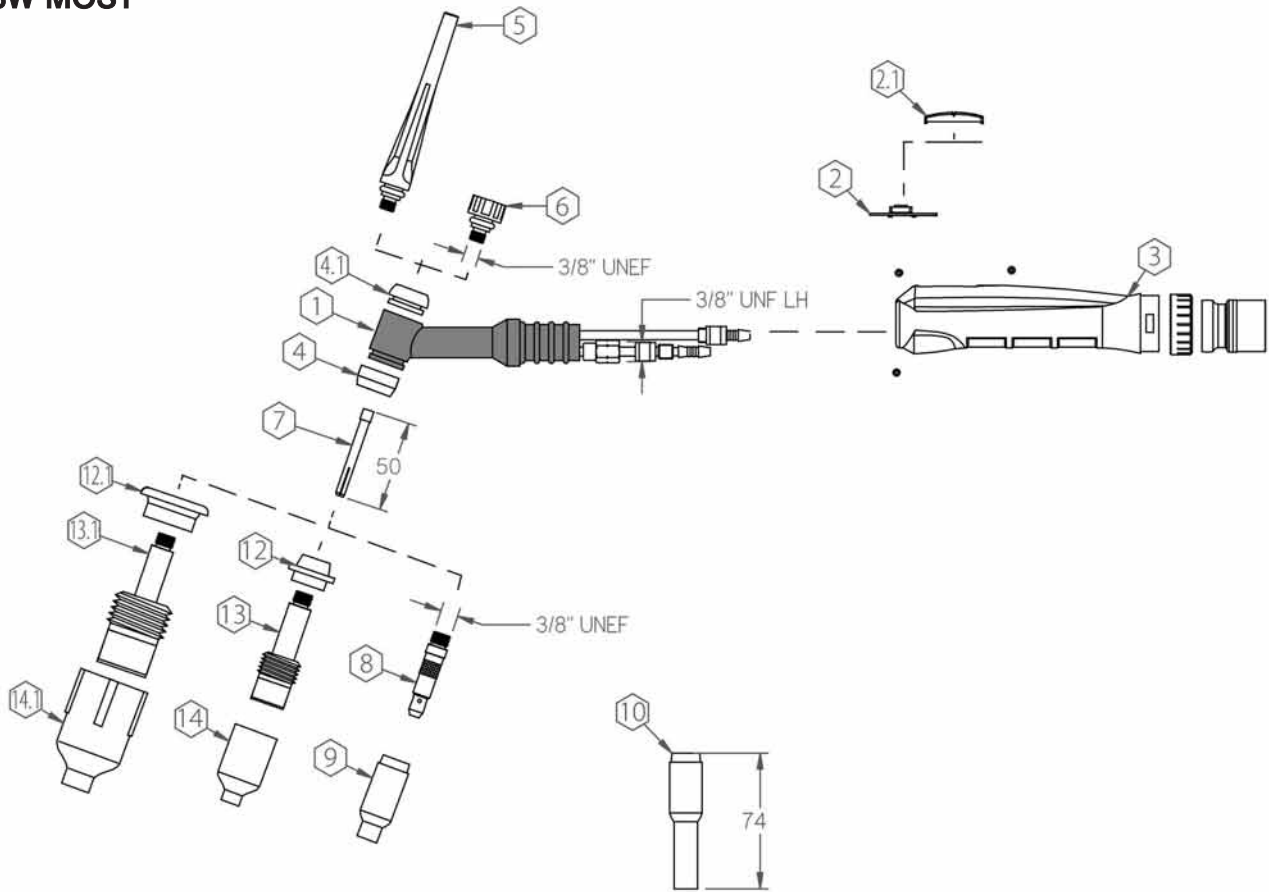
Technical data according to EN 60 974-7	
Max. load at 60% / 100% duty cycle	125 A AC / 100 A AC 140 A DC / 110 A DC
Diameter of wolfram electrode	0,5 - 2,4 mm

V – handle with gas valve, no trigger  
DC / AC

Holder length	Catalogue No.
4,0 m	56 03 016810
8,0 m	56 03 016830

18W MOST

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**L: 4, 8 m**

Welding equipment

## 18W MOST

No.	Name		Catalogue No.
1	Torch SR-18W MOST	218EL01	56 13 003418
2	Switch TIG -Electric MOST	06ERI2	56 13 016200
2.1	Switch TIG -Trigger MOST	0299ERI2	56 13 016210
3	Handle SR-18/20/26 MOST	XM9ER1	56 13 007700
4	Insulator SR-17/18/26		56 13 014810
4.1	Cup goshet SR-17/18/26 MOST		56 13 014811
5	Long back cup SR-17/18/26		56 13 003181
6	Short back cup SR-17/18/26		56 13 003270
7	Standard collet 1,0 SR-17/18/26		56 13 009930
	Standard collet 1,6 SR-17/18/27		56 13 009932
	Standard collet 2,0 SR-17/18/28		56 13 009934
	Standard collet 2,4 SR-17/18/29		56 13 009936
	Standard collet 3,2 SR-17/18/29		56 13 009940
	Standard collet 4,0 SR-17/18/29		56 13 009942
8	Standard collet body 1,0 SR-17/18/29		56 13 003830
	Standard collet body 1,6 SR-17/18/30		56 13 003883
	Standard collet body 2,0 SR-17/18/31		56 13 003914
	Standard collet body 2,4 SR-17/18/32		56 13 003921
	Standard collet body 3,2 SR-17/18/32		56 13 003952
	Standard collet body 4,0 SR-17/18/32		56 13 003960
9	Standard ceramic cup 6,5x47 #4		56 13 000768
	Standard ceramic cup 8,0x47 #5		56 13 000770
	Standard ceramic cup 9,5x47 #6		56 13 000780
	Standard ceramic cup 11,0x47 #7		56 13 000783
	Standard ceramic cup 12,5x47 #8		56 13 000784
	Standard ceramic cup 16,0x47 #10		56 13 000786
	Standard ceramic cup 19,5x47 #12		56 13 000788
10	Long ceramic cup 8,0x76 #5		56 13 001006
	Long ceramic cup 9,5x76 #6		56 13 001008
	Long ceramic cup 11,0x76 #7		56 13 001010
11	Electric Water Cable SR-18W MOST 4m	218CX04	56 13 015994
11.1	Electric Water Cable SR-18W MOST 8m	218CX08	56 13 015998
12	Laminar insulator		56 13 014812
12.1	Large laminar insulator		56 13 017813
13	Standard gas lens body 1,0 SR-17/18/26		56 13 008235
	Standard gas lens body 1,6 SR-17/18/26		56 13 008252
	Standard gas lens body 2,4 SR-17/18/26		56 13 008272
	Standard gas lens body 3,2 SR-17/18/26		56 13 008301
	Standard gas lens body 4,0 SR-17/18/26		56 13 008310
13.1	Large gas lens body 2,4 SR-17/18/27 Jumbo		56 13 008276
	Large gas lens body 3,2 SR-17/18/27 Jumbo		56 13 008280
14	Standard gas lens cup 6,5x42 lam #4		56 13 000902
	Standard gas lens cup 8,0x42 lam #5		56 13 000900
	Standard gas lens cup 9,5x42 lam #6		56 13 000888
	Standard gas lens cup 11,0x42 lam #7		56 13 000886
	Standard gas lens cup 12,5x42 lam #8		56 13 000884
	Standard gas lens cup 19,5x42 lam #12		56 13 000882
14.1	Large gas lens cup 9,5x48 Jumbo #6		56 13 001115
	Large gas lens cup 12,5x48 Jumbo #8		56 13 001116
	Large gas lens cup 16x48 Jumbo #10		56 13 001117
	Large gas lens cup 19,5x48 Jumbo #12		56 13 001119
15	Cable cover assembly 35x1,5 [mb]		51 13 015240
16	Control Cable		56 13 015900
17	Plug Spring	1EM9EPOW	56 13 016416
18	Plug Cover TIG TIG20/18W	2EN9924W	56 13 016910
19	Water Inlet Hose Assy		51 13 007120
19.1	Water Hose Assy (red)		51 13 007115
20	Gas Hose Assy		55 13 015370
21	Plug Assy TIG 20/18W	218AM15	56 13 016416

Type	18W MOST
Cooling	Liquid

## Technical data according to EN 60 974-7

Max. load at 60% / 100% duty cycle	250 A AC / 135 A AC 320 A DC / 250 A DC
Diameter of wolfram electrode	0,5 - 4,0 mm
Liquid flow	3 - 11 l/min

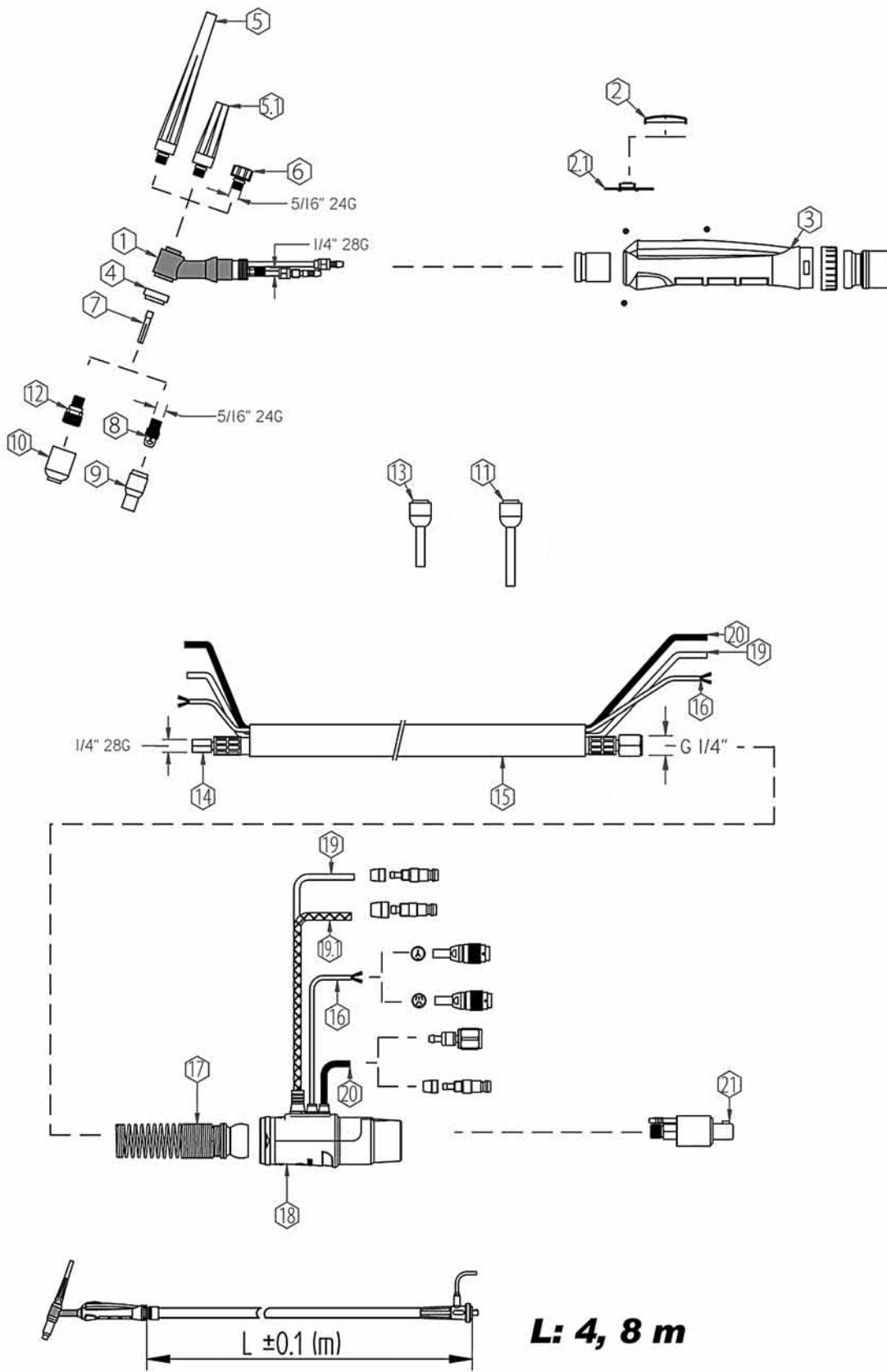
DC / AC

Handle lenght	Catalogue No.
4,0 m	56 00 018W04
8,0 m	56 00 018W08

20W MOST

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Welding equipment



## 20W MOST (technical specification)

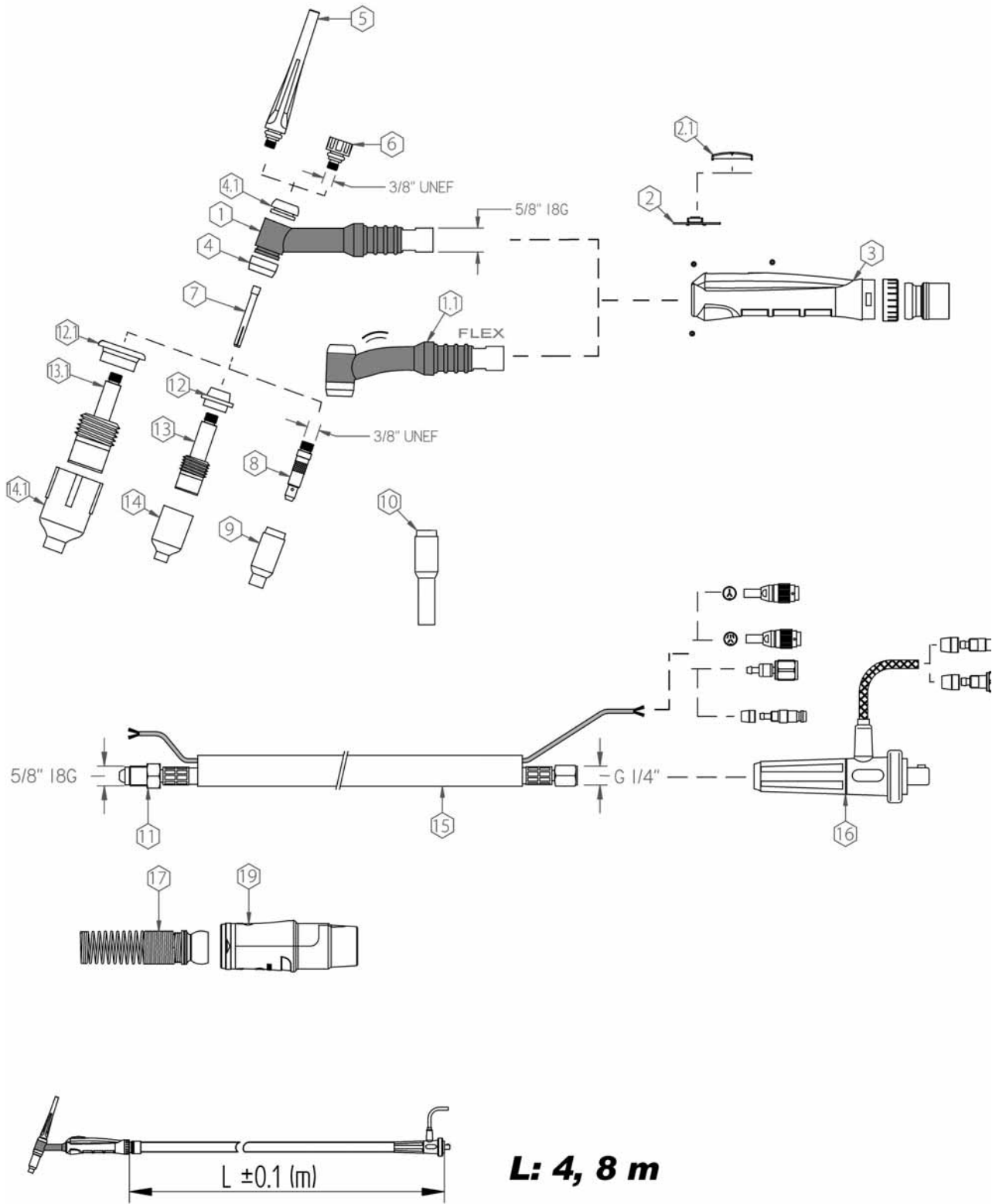
No.	Name		Catalogue No.
1	Torch SR-20W MOST	220EL01	56 13 003420
2	Trigger TIG -plytka el. MOST	06ERI2	56 13 016200
2.1	Trigger TIG -przycisk MOST	0299ERI2	56 13 016210
3	Handle SR-9/20/17/18/26 MOST	XM9ER1	56 13 007700
4	Insulator SR-9/20		56 13 014806
5	Cup goshet long SR-9/20		56 13 003170
5.1	Cup goshet medium SR-9/20		56 13 003250
6	Cup goshet short SR-9/20		56 13 003280
7	Standard collet 1,0 SR-9/20		56 13 009920
	Standard collet 1,6 SR-9/20		56 13 009922
	Standard collet 2,0 SR-9/20		56 13 009923
	Standard collet 2,4 SR-9/20		56 13 009924
	Standard collet 3,2 SR-9/20		56 13 009927
8	Standard collet body 1,0 SR-9/20		56 13 003840
	Standard collet body 1,6 SR-9/20		56 13 003881
	Standard collet body 2,0 SR-9/20		56 13 003912
	Standard collet body 2,4 SR-9/20		56 13 003920
	Standard collet body 3,2 SR-9/20		56 13 003950
9	Standard ceramic cup 6,5x30 #4		56 13 000384
	Standard ceramic cup 8,0x30 #5		56 13 000386
	Standard ceramic cup 9,5x30 #6		56 13 000390
	Standard ceramic cup 11,0x30 #7		56 13 000394
	Standard ceramic cup 12,5x30 #8		56 13 000396
	Standard ceramic cup 16,0x30 #10		56 13 000398
10	Gas lens cup 6,5x25,5 #4		56 13 000908
	Gas lens cup 8x25,5 #5		56 13 000910
	Gas lens cup 9,5x25,5 #6		56 13 000911
	Gas lens cup 11 x25,5 #7		56 13 000912
11	Extra long ceramic cup 6,5x63 #4		56 13 000914
	Extra long ceramic cup 8x63 #5		56 13 000915
12	Standard collet body 1,0 SR-9/20		56 13 008230
	Standard collet body 1,6 SR-9/20		56 13 008250
	Standard collet body 2,4 SR-9/20		56 13 008271
	Standard collet body 3,2 SR-9/20		56 13 008300
13	Long ceramic cup 1,0 SR-9/20		56 13 000947
	Long ceramic cup 1,6 SR-9/20		56 13 000946
	Long ceramic cup 2,4 SR-9/20		56 13 000945
14	Electric-Water Cable SR-20W MOST 4m	220CX04	56 13 015984
14.1	Electric-Water Cable SR-20W MOST 8m	220CX08	56 13 015988
15	Assembly Cover 35x1,5 [mb]		51 13 015240
16	Control Cable mb		56 13 015900
17	Plug Spring	1EM9EPOW	56 13 016416
18	Plug Body TIG	2EN9924W	56 13 016910
19	Water Inlet Hose Assy.		51 13 007120
19.1	Water inlet Hose [red]		51 13 007115
20	Gas Hose mb		55 13 015370
21	Plug Assy. TIG 20/18W	218AM15	56 13 016416

Type	20W MOST
Cooling	Liquid

Technical data according to 60 974-7	
Max. load at 60% / 100% duty cycle	175 A AC / 135 A AC 250 A DC / 195 A DC
Diameter of wolfram electrode	0,5 - 3,2 mm
Liquid flow	3 - 9 l/min

DC / AC

Handle lenght	Catalogue No.
4,0 m	56 00 020W04
8,0 m	56 00 020W08



## 26 / 26F MOST (technical specification)

No.	Name		Catalogue No.
1	Torch SR-26 MOST	226EL01	56 13 003426
1.1	Torch SR-26F (flexible) MOST	226EL01F	56 13 003428
2	Trigger TIG –electric plate MOST	06ERI2	56 13 016200
2.1	Trigger TIG -trigger MOST	0299ERI2	56 13 016210
3	Handle SR-18/20/26 MOST	XM9ER1	56 13 007700
4	Insulator SR-17/18/26		56 13 014810
4.1	Cup goshet SR-17/18/26 MOST		56 13 014811
5	Long back cup SR-17/18/26		56 13 003181
6	Medium back cup SR-17/18/26		56 13 003270
7	Standard collet 1,0 SR-17/18/26		56 13 009930
	Standard collet 1,6 SR-17/18/27		56 13 009932
	Standard collet 2,0 SR-17/18/28		56 13 009934
	Standard collet 2,4 SR-17/18/29		56 13 009936
	Standard collet 3,2 SR-17/18/29		56 13 009940
	Standard collet 4,0 SR-17/18/29		56 13 009942
8	Standard collet body 1,0 SR-17/18/29		56 13 003830
	Standard collet body 1,6 SR-17/18/30		56 13 003883
	Standard collet body 2,0 SR-17/18/31		56 13 003914
	Standard collet body 2,4 SR-17/18/32		56 13 003921
	Standard collet body 3,2 SR-17/18/32		56 13 003952
	Standard collet body 4,0 SR-17/18/32		56 13 003960
9	Standard ceramic cup 6,5x47 #4		56 13 000768
	Standard ceramic cup 8,0x47 #5		56 13 000770
	Standard ceramic cup 9,5x47 #6		56 13 000780
	Standard ceramic cup 11,0x47 #7		56 13 000783
	Standard ceramic cup 12,5x47 #8		56 13 000784
	Standard ceramic cup 16,0x47 #10		56 13 000786
	Standard ceramic cup 19,5x47 #12		56 13 000788
10	Long ceramic cup 8,0x76 #5		56 13 001006
	Long ceramic cup 9,5x76 #6		56 13 001008
	Long ceramic cup 11,0x76 #7		56 13 001010
11	Electric Gas Cable SR-26 MOST 4m	226CX04	56 13 016000
11.1	Electric Gas Cable SR-26 MOST 8m	226CX08	56 13 016005
12	Laminar Insulator		56 13 014812
12.1	Laminar Insulator Large		56 13 017813
13	Gas lens body 1,0 SR-17/18/26		56 13 008235
	Gas lens body 1,6 SR-17/18/26		56 13 008252
	Gas lens body 2,4 SR-17/18/26		56 13 008272
	Gas lens body 3,2 SR-17/18/26		56 13 008301
	Gas lens body 4,0 SR-17/18/26		56 13 008310
13.1	Large gas lens body 2,4 SR-17/18/27 Jumbo		56 13 008276
	Large gas lens body 3,2 SR-17/18/27 Jumbo		56 13 008280
14	Standard gas lens cup 6,5x42 lam #4		56 13 000902
	Standard gas lens cup 8,0x42 lam #5		56 13 000900
	Standard gas lens cup 9,5x42 lam #6		56 13 000888
	Standard gas lens cup 11,0x42 lam #7		56 13 000886
	Standard gas lens cup 12,5x42 lam #8		56 13 000884
	Standard gas lens cup 19,5x42 lam #12		56 13 000882
14.1	Large gas lens cup 9,5x48 Jumbo #6		56 13 001115
	Large gas lens cup 12,5x48 Jumbo #8		56 13 001116
	Large gas lens cup 16x48 Jumbo #10		56 13 001117
	Large gas lens cup 19,5x48 Jumbo #12		56 13 001119
15	Cable cover assembly 35x1,5 [mb]		51 13 015240
16	MOST Plug Assy. SR-26 MOST 35-50	4AM3550	56 13 016414
17	MOST Plug Spring	1EM9EPOW	56 13 016416
18	MOST Plug Body TIG	2EN9924	56 13 016418

Type	26 / 26F MOST
Cooling	Gas

Technical data according to EN 60 974-7	
Max. load at 60% / 100% duty cycle	200 A AC / 155 A AC 240 A DC / 190 A DC
Diameter of wolfram electrode	0,5 - 4,0 mm
Gas flow	3 - 9 l/min

F – flexible torch  
V – holder with valve, no trigger  
DC / AC

Holder lenght-	Catalogue No.
MOST 26 - 4,0 m	56 00 026004
MOST 26 - 8,0 m	56 00 026008
MOST 26F - 4,0 m	56 00 026F04
MOST 26F - 8,0 m	56 00 026F08

## 6.5 TIG welding accessories

### Substitutes for TIG holders

Other TIG Holders (substitutes for wearable parts)							
ABICOR BINZEL	ABICOR BINZEL (old)	TRAFISTEL	TRANSLAS	WELDCRAFT	ESAB	LORCH	MOST
ABITIG 9	SRT-9 / SR-9	TIG-9	TL-9	CK-9	BTD123 HW-20ARV BTF-140	WLT-9	-
ABITIG 17	SRT-17 / SR-17	TIG-17	TL-17	CK-17	BTD153 HW-17 BTF150	WLT-17	MOST 17V
ABITIG 20	SRT-20 / SR-20	TIG-20	TL-20	CK-20	BTD253W HW-20 BTF250W	WWT-20	MOST 20W
ABITIG 26	SRT-26 / SR-26	TIG-26	TL-26	CK-26	BTD203 HW-26 BTF200	WLT-26	MOST 26
ABITIG 18	SRT-18 / SR-18	TIG-18	TL-18	CK-18	BTD403W HW-18 (BTF400W)	WWT-18	MOST 18W

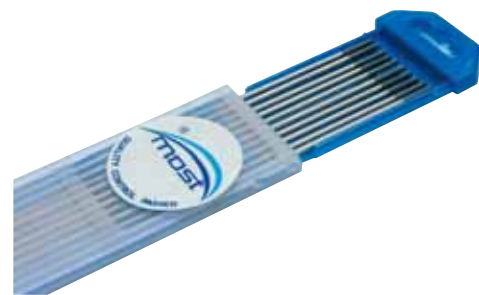
Some versions include:  
V – Gas Valve instead of a Trigger,  
F – Flexible Torch.

### Plugs

Plugs	Name	Comments	Catalogue No.
Gas	Hose Plug fi 6	Faltig + GER 9,5	50 14 182003
	Nipple Nut 1/4 299TG2	Esab, Aspa + GER 9,5	50 14 182040
	Nipple Nut fi 5 299TG881		50 14 182044
	Hose Plug 2,7	LE, Lorch + GER8,0	50 14 182006
Controlling	Plug SzR16P2NG5	Faltig-160	51 13 014495
	Plug SzR20P4NG4	Faltig-315	51 13 014497
	Plug Amphenol 2-bolt.	ESAB	51 13 014450
	Plug (3 bolt) Tuchel 175.0009	Faltig 161, 200, 250, 400	56 13 140140
	Plug (5 bolt) Tuchel 175.0011	LE, Lorch	51 13 014470
For Liquids	Hose Plug fi 6	GER 9,5	50 14 182003
Locking band	GER 9,5		50 15 000095
	GER 8,0		50 15 000080



### Tungsten (wolfram) Electrodes for TIG welding -



Catalogue No.	Name and signature	Marking Colour	Current	Comments
50 19 92XX17	with Thorium 2% WT20	red	DC	Slightly radioactive
50 19 93XX17	Pure Wolfram WP	green	AC	
50 19 91XX17	with Lanthanum WL10	black	AC/DC	
50 19 97XX17	with Cerium WC20	grey	AC/DC	
50 19 94XX17	with Lanthanum WL15	golden	AC/DC	
50 19 95XX17	with rare-earth-elements Multi-Strike	turquoise	AC/DC	Best properties with steel and aluminium welding; length: 150 mm; dia. 1,0; 1,6; 2,4; 3,2; 4,0 mm

XX – electrode diameter, eg. fi 1,6 mm = 16; 2,4 mm = 24; etc.

Electrodes available in length: 175 mm.

Typical diameters (mm): 1,0; 1,6; 2,0; 2,4; 3,0; 3,2; 4,0.

AC – variable current / aluminium welding  
DC – direct current / stainless and carbon steel welding

## 7. MMA ELECTRODE HOLDERS

### MMA Holders



COMFORT MOST

COMFORT 200A MOST	Catalogue No.:	57 00 000200
COMFORT 400A MOST	Catalogue No.:	57 00 000400
COMFORT 600A MOST	Catalogue No.:	57 00 000600
ROTATIONAL 200A MOST	Catalogue No.:	57 00 001002
ROTATIONAL 400A MOST	Catalogue No.:	57 00 001004
ROTATIONAL 600A MOST	Catalogue No.:	57 00 001006
PRIMA 200A MOST	Catalogue No.:	57 00 001020
PRIMA 400A MOST	Catalogue No.:	57 00 001040
160A/20 MOST*	Catalogue No.:	57 00 001160
200A/30 MOST*	Catalogue No.:	57 00 001200
250A/40 MOST*	Catalogue No.:	57 00 001250
300A/60 MOST*	Catalogue No.:	57 00 001300

\*) Welding cable is fitted onto box ending



MOST ROTATIONAL



PRIMA MOST

## 8. WELDING ACCESSORIES

### Earth crocodile clamp



150A MOST	Catalogue No.	57 00 003009
200A MOST	Catalogue No.	57 00 003010
300A MOST	Catalogue No.	57 00 003011

### Earth screw-crocodile clamp



600A MOST	Catalogue No.	57 00 004660
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### Welding hammers



300 g spring MOST	50 00 001610
300 g euro MOST	50 00 001620

**Magnetic triangles**



Small triangle MOST  
Big triangle MOST

57 00 004800  
57 00 004850

**Magnetic bracket**



Torch bracket  
MIG MOST 57 00 004880  
TIG MOST 57 00 004890





**Rotating magnetic bracket**



Catalogue No.

57 00 003000

**Connectors for welding cables**

Name	Catalogue No.	
Cable plug 10/25 MOST	57 00 007025	
Cable plug 35/50 MOST	57 00 007050	
Cable plug 50/70 MOST	57 00 007070	
Cable plug 70/95 MOST	57 00 007095	
Cable socket 35/50 MOST	57 00 007150	
Cable socket 50/70 MOST	57 00 007170	
Socket for device 10/25 MOST	57 00 007225	
Socket for device 50/70 MOST	57 00 007270	
Plug to device 50/70 MOST	57 00 007370	

**Welding cables OS1 (H01N2D)**



Welding cables	
Name	Catalogue No.
OS-16	54 60 000016
OS-25	54 60 000025
OS-35	54 60 000035
OS-50	54 60 000050
OS-70	54 60 000070
OS-95	54 60 000095

## Termic pencil MOST (termic indicator)

■ Termic pencil MOST is designed for marking the material before heat processing it. The marking melts when material's temperature reaches opportune (it becomes liquid in significant temperature).

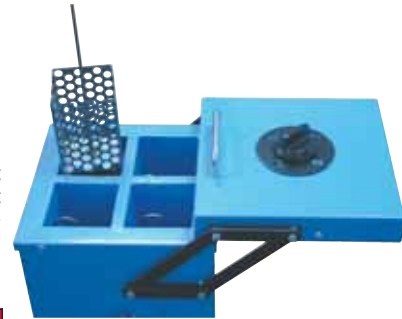


Termic pencil 55°C MOST	Catalogue No: 50 37 910 055	Termic pencil 220°C MOST	Catalogue No: 50 37 910 220
Termic pencil 80°C MOST	Catalogue No: 50 37 910 080	Termic pencil 250°C MOST	Catalogue No: 50 37 910 250
Termic pencil 100°C MOST	Catalogue No: 50 37 910 100	Termic pencil 280°C MOST	Catalogue No: 50 37 910 280
Termic pencil 125°C MOST	Catalogue No: 50 37 910 125	Termic pencil 320°C MOST	Catalogue No: 50 37 910 320
Termic pencil 150°C MOST	Catalogue No: 50 37 910 150	Termic pencil 450°C MOST	Catalogue No: 50 37 910 450
Termic pencil 175°C MOST	Catalogue No: 50 37 910 175	Termic pencil 550°C MOST	Catalogue No: 50 37 910 550
Termic pencil 200°C MOST	Catalogue No: 50 37 910 200	Termic pencil 800°C MOST	Catalogue No: 50 37 910 800

## Drying oven PD 0-20 MOST / Thermos GS-6P MOST

■ **Electrode oven PD 0-20 MOST** is designed to dry the electrodes before welding process. Usually electrodes demand drying for 2-3 hours at temp. 350°C. After drying process electrodes should be kept in thermos at temp. 100°C. We recommend thermos GS-6P MOST. This device is adapted to voltage range 230 V.

■ **Electrode thermos GS-6P MOST** is designed for proper keeping electrodes after drying at temp. 350°C e.g. in dryer PD-020 MOST. Usually electrodes should be dried for 2-3 hours at 350°C and brought to working place and should be kept at temp. 100°C which protects from getting moist again. The device is adapted to voltage range 230 V.



Technical data		
	Dryer PD 0-20 MOST	Thermos GS-6P MOST
Voltage	230 V	230 V
Power output	1200 W	300 W
Capacity	20 kg of electrodes in 4 chambers	6 kg of electrodes in 1 chamber
Temperature setting	60-400°C	30-110°C
Weight	14 kg	4 kg
Dimensions (L x W x H)	690 x 215 x 215 mm	545 x 305 x 115 mm
Catalogue No.	50 00 003000	50 00 003006



## 9. WELD GAUGES



### ■ MS 1 type Gage MOST

Weld gauge designed for exact measurements of fillet and butt welds.

**Applications:** measurement of fillet welds legs length, measurement of allowable convexity and concavity of fillet welds, measurement of allowable weld reinforcement.

**Catalogue No.:** 70 42 000001



### ■ MS 2 type Gage MOST

Weld gauge designed for exact measurements of fillet and butt welds.

**Applications:** measurement of fillet welds legs length, measurement of allowable convexity and concavity of fillet welds, measurement of allowable weld reinforcement.

**Catalogue No.:** 70 42 000002



### ■ MS 3 type Gage MOST

Cam-bridge weld gauge.

**Applications:** measurement of weld reinforcement, measurement of fillet welds length and thickness, measurement of shift extent, measurement of sheets bevel angle, measurement of undercut. Measurement range: angle values 0°-60° every 5°.

**Catalogue No.:** 70 42 000003

## 10. CERAMIC BACKINGS

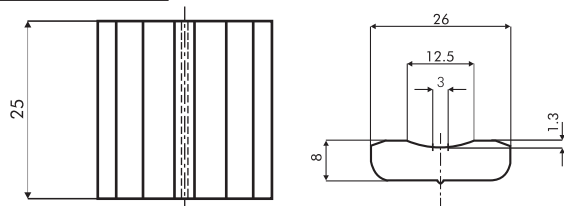
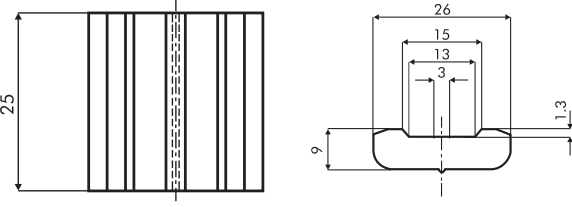
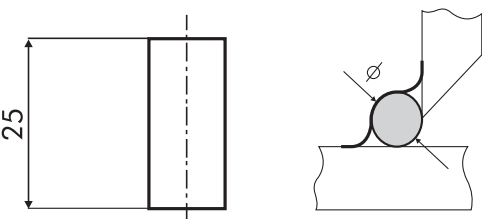
■ The requirement for better quality of products and higher efficiency of production processes results in high technological characteristic of welding action. At manual welding with coated electrodes and semi-automatic with gas shielding, in the root of weld can extensively appear inadmissible defects, such as: slag inclusions, gas blowhole, lack of weld penetration. In automatic welding process with the use of flux, when observation of welding process is infinitesimal and simultaneous regulation of parameters is complicated can appear burn-through of contacts. Therefore, for executing root of welders with best qualifications are needed; or the root of weld can be cut out and gouged. Cutting out and gouging of root of weld is carried out in very difficult to work ceiling position or it is executed after turning out of the construction, which requires carrying out many additional actions (e.g. construction stiffening).

Problems can be eliminated by the use of ceramic backings protecting melted metal from the side of the root. Backings are mounted in welded construction by means of non-complicated systems, which is not a very labour-consuming process.

The advantages of using ceramic backings are as follows:

- reduced labour consumption thanks to elimination of whole variety of labour-consuming actions (root of weld cutting out, gouging, construction turning),
- welding actions can run on one-side in technically convenient positions,
- possibility of employment of low qualified welders,
- elimination of fusion weld defects in the part of root and necessity of removal of them.

It should be emphasised that labour consumption constitutes 70-75% of typical welding construction costs and any reduction of it brings about measurable economical effects, several times higher than the cost of purchase of backings.

No.	Type – dimensions [mm]	Length	Comments
1	<p><b>MOST LT05</b></p> 	<p>600 mm</p> <p>24 segments x 25 mm</p>	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm wide.</p> <p>Packaging: 30 pieces</p> <p>Catalogue No.: 50 49 300550</p>
2	<p><b>MOST LT 05TT</b></p> 	<p>600 mm</p> <p>24 segments x 25 mm</p>	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm wide.</p> <p>Packaging: 25 pieces</p> <p>Catalogue No.: 50 49 000555</p>
3	<p><b>MOST LT 06</b></p> 	<p>600 mm</p> <p>24 segments x 25 mm</p>	<p>25 mm ceramic blocks are mounted on self-adhesive aluminium tape 85 mm.</p> <p>Packaging :</p> <ul style="list-style-type: none"> <li>Ø 8,0 mm - 40 pcs.</li> <li>Ø 10,0 mm - 40 pcs.</li> <li>Ø 12,0 mm - 30 pcs.</li> <li>Ø 15,0 mm - 20 pcs.</li> </ul> <p>Catalogue No.:</p> <ul style="list-style-type: none"> <li>Ø 8,0 mm - 50 49 300608</li> <li>Ø 10,0 mm - 50 49 300610</li> <li>Ø 12,0 mm - 50 49 300612</li> <li>Ø 15,0 mm - 50 49 300615</li> </ul>

# ACCESSORIES FOR GAS CUTTING AND WELDING



1. Regulators
2. Gas torches for cutting
3. Arrestors and coupling
4. Accessories

## Contents

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# 1. REGULATORS

## MOST cylinder regulators



Oxygen



Ar/CO<sub>2</sub>



Acetylene

All our regulators are fitted for working under inlet pressure 200 bar (20 MPa) and keep the inlet pressure at a constant level set by the user. The setting of working pressure is simple and accurate. Regulators meet all requirements and remain in compliance with ISO 2503 standard in respect to safety demands, applied materials, quality control, performance characteristic and calibration.

Used manometers meet requirements of ISO 5171 standard. Situated beyond manometers, on the back of the regulator, safety valve increases to large extent the service staff work safely.

Each regulator is equipped with an outlet valve, which facilitates the work. The staff has to set the working pressure only once and has to shut the valve during a break.

### Gas regulator

The unique construction of the gas regulator, proved well in many-years experience largely increases life and stability of the regulator work. Gas regulator is situated in a specially designed capsule crowned with a very precise filter, which is made of sintered powders of microporous structure, which prevents dust, metal filings and other impurities that would be likely to bring about the regulator leakage from sticking to the seat of gas regulator

Catalogue no.	Gas type	Max. inlet gas pressure	Working pressures range	Max. flow	Nut thread at inlet	Nut thread at outlet	Hose end	Characteristics
62 30 760676	Oxygen	200 bar	0-10 bar	30 m <sup>3</sup> /h	G 3/4	G 3/4	6,3 mm	One stage regulator
62 30 760677	Acetylene	25 bar	0-1,5 bar	5 m <sup>3</sup> /h	Shackle	G 3/8LH	8 mm	One stage regulator
62 30 760678	CO <sub>2</sub>	200 bar	0-10 bar	30 m <sup>3</sup> /h	W 21,8 x 1/14"	G 1/4	6,3 mm	One stage regulator
62 30 760679	Ar/CO <sub>2</sub>	200 bar	0,5-6 bar	0-32 l/min	W 21,8 x 1/14"	G 1/4	6,3 mm	Cylinder regulator with manometric gas flow gauge

## MOST Alu - Regulators



Oxygen



Acetylene

### Advantages of MOST regulators:

- possibility to work under inlet pressure 200 bar (20 MPa),
- solid and safe construction,
- simple to operate,
- large stability of working pressure,
- simple and accurate pressure control,
- large durability,
- simple maintenance,
- simple and time-saving service,
- spare parts availability,
- the price comprises a cut-off valve,
- equally high quality of each piece,
- high-quality safe manometers,
- reasonable price.



Ar/CO<sub>2</sub>

Gas type	Max. inlet gas pressure	Working pressures range	Max. flow	Nut thread at inlet	Nut thread at outlet	Hose end
Oxygen	200 bar	0-10 bar	30 m <sup>3</sup> /h	G 3/4	G 1/4 RH	6,3 mm
Acetylene	25 bar	0-1,5 bar	5 m <sup>3</sup> /h	Shackle	G 3/8 LH	8-9 mm
Ar/CO <sub>2</sub>	200 bar	0,5-5 bar	0-32 l/min	W 21,8 x 1/14"	G 1/4 RH	6,3 mm

## 2. GAS TORCHES FOR CUTTING

### Cutting torch CUT-A/P MOST

■ Cutting injector type torches CUT-A/P are characterized by internal mixing of flammable gas with oxygen - in the mixer equipped with an injector. The unit includes grooved nozzles that enable cutting fastening accompanied by cutting quality increase. Grooved nozzles also allow decrease of technical gases consumption. MOST torches are additionally equipped with anti-reversion valves that prevent gases from reverse flow.



Oxygen nozzles



Heating nozzles

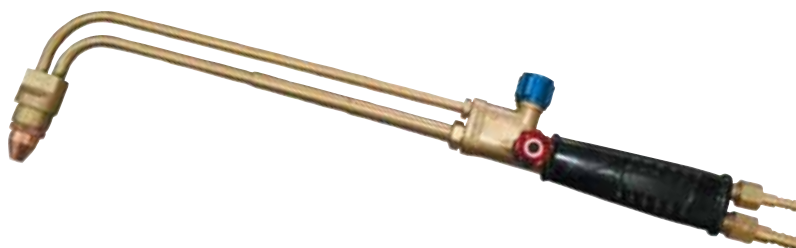
Catalogue No.	Name	Cutting range	Weight
60 20 000010	Torch CUT-A MOST - Acetylene	3-300 mm	1,2 kg
60 20 000020	Torch CUT-P MOST Propane, Propane-butane, CNG gas	3-300 mm	1,2 kg

**Accessories:** nozzle set, gasket set, universal spanner, rollers, cut off valves set. Cardboard package.

Gas	Nozzles - cut off thickness range (mm)								
	Oxygen nozzles						Heating nozzles		
	3-8	5-15	15-30	30-60	60-100	100-200	200-300	3-100	100-300
Acetylen (Cut-A)	61 40 00001	61 40 00002	61 40 00003	61 40 00004	61 40 00005	61 40 00006	61 40 00007	61 40 00009	61 40 00010
Propan (Cut-P)	61 40 00011	61 40 00012	61 40 00013	61 40 00014	61 40 00015	61 40 00016	61 40 00017	61 40 00019	61 40 00020

### Cutting torch PC 211 A/P MOST

■ Cutting injector torches PC 211A/P MOST are characterized by internal mixing of flammable gas with oxygen - in the mixer equipped with an injector. The unit includes grooved nozzles that enable cutting fastening accompanied by cutting quality increase. Grooved nozzles also allow decrease of technical gases consumption. MOST torches are additionally equipped with anti-reversion valves that prevent gases from reverse flow.



Catalogue No.	Name	Cutting range	Weight
60 20 000011	Torch PC 211 A MOST - Acetylene	3-300 mm	1,2 kg
60 20 000021	Torch PC 211 P MOST - Propane	3-300 mm	1,2 kg

**Accessories:** nozzle set, gasket set, universal spanner, rollers, cut off valves set. Cardboard package.

Accessories for gas cutting and welding

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### 3. ARRESTORS AND COUPLINGS

#### MOST flashback arrestors for torches



Dry safety catches at torch MOST		
Catalogue No.	Type	Connection
63 94 001128	MOST - Oxygen	G 1/4
63 94 001118	MOST - acetylene, propane, hydrogen	G 3/8 lh
Table of MOST safety catches gas flow capacity		
Pressure in	Acetylene	Oxygen
0,4 bar	2 m <sup>3</sup> /h	-
0,8 bar	7 m <sup>3</sup> /h	-
1,0 bar	8 m <sup>3</sup> /h	-
2,5 bar	-	18 m <sup>3</sup> /h
5 bar	-	27 m <sup>3</sup> /h
7,5 bar	-	32 m <sup>3</sup> /h
10 bar	-	39 m <sup>3</sup> /h

#### MOST flashback arrestors for regulators



Catalogue No.	Type	Connection	Characteristics
63 94 001030	MOST - Oxygen	G 1/4	Safety catches At regulator for gas, with 3 safety levels (against reverse gas flow, flame and fire of a hose).
63 94 001130	MOST-Acetylene, Propane, Hydrogen	G 3/8 LH	

#### MOST hose couplings



Catalogue No.	Type
63 80 010048	MOST - SZP-O Oxygen
63 80 010049	MOST - SZP-A Acetylene

#### 4. ACCESSORIES

##### Hose nipples



Catalogue no.	Inside diameter of a hose	Nipple length
61 15 803001	4 mm	71 mm
61 15 803002	6,3 mm	
61 15 803003	8 mm	
61 15 803004	10 mm	
61 15 803005	12,5 mm	75 mm
61 15 803006	16 mm	

Gas-tight at 30 bar

##### Hose double-nipple



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

Connections and parts gas-tight at 30 bar

##### Hose triple-connector



Catalogue no.	Inside diameter of a hose	Nipple dimensions
61 15 803040	4 mm	82 x 41 mm
61 15 803041	6,3 mm	82 x 43 mm
61 15 803042	8 mm	82 x 44 mm

Connections and parts gas-tight at 30 bar  
Consists of tee and endings

##### Hose connector stems



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

##### Hose clamp



Catalogue no.	Type
60 39 300001	Double
63 13 000006	Wormed 10/16
63 13 000008	Wormed 12/20

##### Ignition lighters



Catalogue no.	Type
60 34 300000	SATURN gas lighter
60 34 299999	Stones for SATURN lighter



Catalogue no.	Type
64 81 020099	MARS gas lighter
64 81 010090	Stones for MARS lighter

##### Gas „Y” Pieces

Catalogue no.	Type	Thread at inlet	Nut thread at outlet	Hose ending	Comments
61 15 803080	R-2-2z	G 3/8	G 1/4	6,3 mm	2 valves on outlet
61 15 803081		G 3/8 LH	G 1/4 LH		
61 15 803082		G 3/8	G 3/8	8 mm	
61 15 803083		G 3/8 LH	G 3/8 LH		
61 15 803050	R-3-z	G 1/4 (safety valve)	G 1/4	6,3 mm	3 studs
61 15 803070	R-3-3z	G 3/8	G 1/4	6,3 mm	3 valves on outlet
61 15 803071		G 3/8 LH	G 1/4 LH		
61 15 803072		G 3/8	G 3/8	8 mm	
61 15 803073		G 3/8 LH	G 3/8 LH		



## Welding hoses

Catalogue no.	Type	Length
63 70 000060	Hose for oxygen 6,3 mm	50 m
63 71 000090	Hose for acetylene 9,0 mm	50 m
63 72 000100	Hose for propane 10,0 mm	50 m



## Electric gas heater



Catalogue no.	Type
61 18 577470	PGNd-2

The unit composition:

- Heater (1 piece)
- User's guide (1 piece)
- Technical leaflet (1 piece)
- Package: cardboard box

Technical information	
Nominal outlet pressure	200 bar
Max. CO <sub>2</sub> flow	1000 dm <sup>3</sup> /h
Power supply	24 V AC, 50 Hz
Power plug	SzR 16 P2 NG 5 (with clots)
Thread at inlet	W 21,8 x 1/14"
Thread at outlet	W 21,8 x 1/14"
Weight	0,8 kg

## Trolleys for gas cylinders

Catalogue no.	Type
65 00 133300	Two-cylinder trolley
65 00 133400	One-cylinder trolley



## Welding mirror



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

## Covers for gauges



Catalogue no.	Type
61 10 899997	MOST BLACK M63
61 10 899998	MOST RED M63 (acetylene)
61 10 899999	MOST BLUE M63 (oxygen)
60 31 000120	Double shielding - Black MOST

These effective rubber shielding provide excellent mechanical protection of manometers. Due to their construction, small safety flaps at manometers' back side are no covered.

## Gauges for technical gases



Catalogue no.	Type
61 10 000010	MOST for oxygen Ø 63 M12x1,5 0-16 Bar
61 10 000020	MOST for oxygen Ø 63 M12x1,5 0-315 Bar
61 10 000030	MOST for acetylene Ø 63 M12x1,5 0-4 Bar
61 10 000040	MOST for acetylene Ø 63 M12x1,5 0-40 Bar
61 10 000110	MOST for oxygen Ø 63 G1/4 0-16 Bar
61 10 000120	MOST for oxygen Ø 63 G1/4 0-315 Bar
61 10 000130	MOST for acetylene Ø 63 G1/4 0-4 Bar
61 10 000140	MOST for acetylene Ø 63 G1/4 0-40 Bar

Excellent MOST manometers provide high quality and very good technical parameters. They were certified by TÜV and BAM.

### Welding chalk



Catalogue no.	Type
60 30 400006	Natural round chalk
60 30 400007	Round handle for chinks

### Marker B PAINTSTICK and BALL PAINT

#### Marker B PAINTSTICK (pack. 12 pcs)

Catalogue no.	Color
60 30 400001	Marker B White
60 30 400004	Marker B Black

B Paintstick markers generally used for identity marking.

#### Marker BALL PAINT (pack. 12 pcs)

Catalogue no.	Color
60 30 400002	Marker BALL Yellow
60 30 400005	Marker BALL Black

Paint Ball markers generally used for identity marking.



### Tip cleaner



Catalogue no.	Type
61 30 763500	Tips for cleaning the nozzle

### Flowmeter

designed for measuring gas flow in torches (devices of MIG-MAG type)

Catalogue no.: 60 31 100080



## MOST high pressure cylinders

### Cylinders - capacity 5 l

Catalogue No.	Gas
64 95 100005	Oxygen
64 95 200005	Acetylene

### Cylinders - capacity 10 l

Catalogue No.	Gas
64 95 100010	Oxygen
64 95 200010	Acetylene
64 95 300010	CO <sub>2</sub>
64 95 400010	Argon
64 95 500010	Nitrogen
64 95 600010	Helium

### Cylinders - capacity 27 l

Catalogue No.	Gas
64 95 100027	Oxygen
64 95 200027	CO <sub>2</sub>
64 95 300027	Argon
64 95 400027	Nitrogen
64 95 500027	Helium

### Cylinders - capacity 40 l

Catalogue No.	Gas
64 95 100040	Oxygen
64 95 200040	Acetylene
64 95 300040	CO <sub>2</sub>
64 95 400040	Argon
64 95 500040	Nitrogen
64 95 600040	Helium
64 95 700040	Compressed air
64 95 900040	Argon & CO <sub>2</sub>
64 95 900041	Hydrogen



# SAFETY PRODUCTS



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## 1. WELDER PROTECTION GEAR



### Welding helmet MULTIVISION MOST

Description on page 48

Catalogue No.: 72 00 961635

### Leather Suit HEBAN

Recommended for welding work. Made of thick grinded cow leather with fire-resistant lining stitched with Kevlar® threads. Available sizes L-XL-XXL, jacket or trousers are also offered separately.

Catalogue No.: 74 10 01010x

### Welding gloves MOST BIZON

Description on page 52

Catalogue No.: 76 10 140130

### Welding shoes wz. 441

Protective shoes for welders made of natural leather with metal tips and metal "safe" buckle. Stitched with Kevlar® threads. Rubber soles resistant to oils, petrol, abrasion, cutting and temperature after short term exposure up to 300°C.

Available sizes: 39-46

Catalogue No.: 76 30 0103xx

**Welding suit WELDMAN  
non-flammable**

A light protective welding suit consisting of a blouse and trousers dungarees. Made of fabric Class II. Available in various sizes.

Catalogue No.: 75 3x xxxxxx

**Welding Helmet  
NEW VISION MOST**

Description on page 48

Catalogue No.: 72 00 961000

With automatic filter V913 DS MOST,  
Description on page 50

Catalogue No.: 72 00 990925

**Leather gloves  
MOST MARS**

Description on page 52

Catalogue No.: 77 54 031950

**Welding shoes wz. 441**

Description on page 44

Catalogue No.: 76 30 0103xx





### Welding goggles 0036

Description on page 51

Catalogue No.: 75 30 010048

### Working Suit MASTERMAN

Working suit consisting of a jacket and braces trousers. Made of mixture: cotton 35% and polyester 65%. Various sizes available.

Catalogue No.:

75 22 108098 size 182/108/98

75 2X XXXXXX

### Leather sleeve D1

Made of cow split leather. Also available sleeves made of grain leather.

Catalogue No.: 76 20 020099

### Welding gloves MOST A 14

Description on page 52

Catalogue No.: 76 10 140100

### Welder's apron

Made of cow split leather, secures protection from welding spatters. Aprons made of grain leather also available.

Catalogue No.: 75 10 011099

### Knee pads

Knees shield, made of leather and felt. Adjustment: straps fasteners.

Catalogue No.: 74 08 001399

### Made of grain leather, good to protect feet shins from hot welding spatter

Made of grain leather, good to protect feet shins from hot splinters.

Catalogue No.: 74 08 001099

## 2. EYE AND FACE PROTECTION



### Welding helmet GOLD VISION

- Welding helmet GOLD provides comfort and protection during welding:
    - by constant and alternating current,
    - in shielding area by consumable and not-consumable electrode Helmet protects welder's eyes and face from harmful radiation and welding sparks during welding. Fulfills PN-EN requirements. Can not be applied during laser welding or cutting. Helmet goes with:
      - frame made of heat-resistant material
      - welding helmet head gear
      - welding passive filter with external protecting plate made of polycarbonate
- Automatic welding filter can be installed in helmet.

#### Technical Information:

- dimension of external protecting polycarbonate plate is 95 x 116 mm
- size of welding helmet is 90x110 mm
- helmet weight together with protecting pad and filter is 330 g

#### Catalogue No.:

- |              |  |
|--------------|--|
| 72 00 970000 | with a filter 10 DIN   |
| 72 20 010032 | HEAD GEAR MOST, GOLD   |
| 72 00 970110 | outside safety lens 95 x 116mm   |
| 72 50 900xxx | passive welding filters 90 x 110 mm of fixed darkening 8 DIN to 13 DIN |

### Welding helmet GOLD VISION with 3M WF-340 filter

#### Catalogue No.:

- |              |  |
|--------------|--|
| 72 00 970010 | GOLD VISION Helmet with 3M WF-340 automatic filter |
| 72 20 010032 | head gear MOST, GOLD                               |
| 72 00 970110 | outside safety lens 95x116 mm                      |
| 72 00 970120 | inside safety lens 42x91 mm                        |

### Automatic welding filter 3M WF-340

- adjustable darkening level
- adjustable sensitivity level
- protection class 1/2/2 EN 379
- darkening level (light) 4 DIN
- darkening level (dark) 10-12 DIN
- field of vision 93x 42mm
- darkening time (light-dark): 0,4 ms
- lightening time (dark-light): 150-250 ms
- darkening before activation: 7 DIN
- protection class UV/IR: UV 13 DIN / IR 13 DIN
- work tmp. range: -5°C to +55°C
- power: two li. batteries 3V
- batteries life-span 1500 h
- weight: 105g

Catalogue No.: 77 00 000340





### Welding helmet MULTIVISION MOST

■ Solid shock resistant helmet made of composite is equipped with adjustable head-gear. In a standard version equipped with passive fixed-darkening filter DIN 10. Able to cooperate with any optional auto darkening MOST filter. Useful with all welding methods. MULTIVISION MOST provides:

- protection from high temperature and hot welding sparks,
- protection from UV and infrared radiation,
- large visual field,
- simple to individual adjustment.

#### Catalogue no.:

72 00 961635	welding helmet MULTIVISION MOST
72 20 010032	welding helmet head-gear GOLD MOST
72 00 961636	outside safety lens 92x112 mm
72 00 990900	inside safety lens 51x108 mm
72 50 900xxx	passive welding filters 90x110mm of fixed-darkening from 8 DIN to 13 DIN



### Welding helmet NEW VISION MOST

■ New, unusually light welding helmet made of PA 66 with adjustable head-gear. As a standard equipped with passive fixed-darkening filter DIN 10. Optionally can be equipped with a Clean-air® Basic ventilation system or a protecting helmet. Able to cooperate with auto darkening filter MOST (fixed or adjustable darkening degree) Useful with all welding methods. NEW VISION MOST provides:

- protection from high temperature and hot welding sparks,
- protection from UV and infrared radiation,
- optimal shape to protect face and ears,
- large visual field,
- weight (only 330 g, without automatic filter),
- simple to operate and exchange worn out elements.

#### Catalogue No.:

72 00 961000	welding helmet NEW MULTIVISION MOST
72 00 961210	welding helmet NEW VISION MOST with a protective helmet
72 00 010032	welding helmet head-gear GOLD MOST
72 00 991000	sweatband NEW VISION MOST
72 00 961050	frame NEW VISION MOST
72 50 090110	outside safety lens 90x110 mm
72 00 990900	inside safety lens 51x108 mm
72 50 900xxx	passive welding filters 90x110mm of darkening 8 DIN to 13 DIN



### Welding helmet NEW VISION MOST with CLEAN AIR BASIC 2000 FLOW CONTROL

■ Powered air flow system Clean-air® Basic 2000 with welding helmet NEW VISION MOST is a modern comfortable protection from welders respiratory tracts in places where oxygen content in air is not less than 17%. Easy to exchange P3 class dust filter protects from particulate and gas matters such as toxicants and dust which are generated during welding. Lights on control panel show current air flow, which can be regulated by buttons-arrows. Air supply can be regulated in interval from 140 l/min to 210 l/min. Microprocessor keeps constant air supplying even if filter is dirty or battery is running down. Signal indicates when battery charge is too low for microprocessor to keep air supplying. Certificates: EN 12 941 TH2P/TH3P.

#### Catalogue No.:

72 00 961100	helmet NEW VISION with CLEAN AIR BASIC 2000 FLOW CONTROL (pack)
72 00 961110	helmet NEW VISION dedicated to CA Basic 2000
72 00 961180	CA Basic 2000 Flow Control
72 00 961200	driving unit designed for CA Basic 2000 Flow Control
72 00 961201	exchangeable filter P3 for CA Basic 2000
72 00 961202	initial filter for CA Basic 2000
72 00 961203	NiMH battery 4,8V4,5Ah for CA Basic 2000
72 00 961204	charger CA Basic 2000
72 00 961205	insulating for CA Basic 2000
72 00 961206	air hose CA Basic 2000
72 00 961207	breathing hose PVC do CA Basic 2000
72 00 961208	Standard belt for CA Basic 2000
72 00 961209	Super belt for CA Basic 2000

## WELDING HELMET NEW VISION MOST "GRAFIT COLOUR"

Welding helmet New Vission offered in a package with an automatic welding filter MOST U913DSADC. Prepared accordingly to the market requirements in very modern Grafit colour.

Product is being offered in 3 versions:

- straight welding shield
- welding shield with a protective helmet
- welding helmet with an adflow

**Catalogue no:**

- 72 00 96 1030
- 72 00 96 1230
- 72 00 96 1130



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Safety products

WELDING PROCESS \ AMPERAGE	0,5	1,0	2,5	5,0	10	15	20	30	40	60	80	100	125	150	175	200	225	250	275	300	350	400	450	500	550
coated electrode											9	10				11				12				13	14
MIG													10	11				12				13	14		
MIG - light metals													10	11			12			13			14	15	
TIG						9	10			11			12			13			14						
MAG											10	11			12				13			14	15		
plasma-arc welding		5	6	7	8	9	10	11				12			13				14	15					
plasma cutting																11			12			13			

Darkened fields correspond with amperages which do not appear at given welding method. Depending on working conditions darkenings one degree higher or lower is acceptable.

### Automatic welding filter F-11 MOST



- fixed darkening degree
- optical class: 1/1/1 EN 379
- open shade state: 3 DIN
- close shade state: 11 DIN
- viewing area: 95x46,5mm
- switching time (bright-dark): 0,5 ms
- clearing time (dark-bright): 200 ms
- protection UV/IR: UV 15 DIN / IR 14 DIN
- work tmp. range: -10°C to +60°C
- power source: solar panel
- weight: 75g.

Catalogue No: 72 00 990923

### Automatic welding filter V 913 MOST



- shade adjustment
- sensitivity adjustment
- optical class: 1/1/1 EN 379
- open state shade: 4 DIN
- close state shade: 9-13 DIN
- viewing area: 95x46,5mm
- switching time (bright-dark): 0,15 ms
- clearing time (dark-bright): 400 ms
- protection: UV/IR: UV 15 DIN / IR 14 DIN
- work tmp. range: -10°C do +60°C
- power source: solar panel
- weight: 95g.

Catalogue No: 72 00 990924

### Automatic welding filter V 913 DS MOST



- shade adjustment
- sensitivity adjustment
- delay adjustment
- optical class: 1/1/1 EN 379
- open state shade: 4 DIN
- close state shade: 9-13 DIN
- viewing area: 95x46,5mm
- switching time (bright-dark): 0,15 ms
- clearing time (dark-bright): 200-800 ms
- protection UV/IR: UV 15 DIN / IR 14 DIN
- work tmp. range: -10°C do +60°C
- power source: solar panel
- weight: 95g.

Catalogue No: 72 00 990925

### Automatic welding filter V 913 DS ADC MOST



■ Filter uses Angular Dependence Compensation (ADC) technology

- increases welder's work convenience,
- homogeneous shade level in +/-30 degrees of viewing angle,
- shade adjustment,
- sensitivity adjustment
- delay adjustment,
- optical class: 1/1/1/2 EN 379,
- open state shade: 4 DIN
- close state shade: 9-13 DIN
- viewing area: 95x46,5mm
- switching time (bright-dark): 0,15 ms
- clearing time (dark-bright): 200-800 ms,
- protection: UV/IR: UV 15 DIN / IR 14 DIN,
- work tmp. range -10°C do +60°C,
- power source: solar panel
- weight: 95g.

Catalogue No: 72 00 990926

## Welding filters with fixed darkening from 4 to 13 DIN

Passive welding filters MOST with the glass 3,0 mm thick, available in sizes:

- round 50 mm in diameter,
- rectangular: 50x100 mm, 80x100 mm, 90x110 mm.

### Catalogue no.:

73 00 05xxxx	welding filters MOST round $\varnothing$ 50 mm
73 00 50xxxx	welding filters MOST rectangular 50x100 mm
73 00 80xxxx	welding filters MOST rectangular 80x100 mm
73 00 90xxxx	welding filters MOST rectangular 90x110 mm



## Glass anti-spatter lenses

■ Lenses are available in the following dimensions:

- round: 50 mm in diameter,
- rectangular: 20x100 mm, 50x100 mm, 80x100 mm, 90x110 mm.

### Catalogue no.:

72 50 050099 - 72 50 800099  
72 50 900610



## Grinding shield OT-1

■ Light, useful, shield to put on the head. Polycarbonate 1 mm thick shield is designed for entire face protection. There is also a model available with 1,5 mm thick polycarbonate shield.

Catalogue no.: 72 01 040000



## Protective goggles 0036

■ Metal goggles with lifting lenses. Finished with soft fabric, colourless or shaded (DIN 4-11) glasses in a 50mm round style

Catalogue no.: 72 30 010048



### 3. HAND PROTECTION

#### 3.1 Welding gloves

##### MOST A 13

■ Durable gloves made of grain cow leather with a stiff cuff protecting the wrist.

**Catalogue no.:**  
76 10 130100



##### MOST A 14

■ Durable gloves made of thick cow split leather. Hidden seams considerably expand gloves durability.

**Catalogue no.:**  
76 10 140100



##### GODWIT

■ Gloves of welding type made of soft goat leather with a cuff. Distinguishable by unusually good quality and reasonable price.

**Catalogue no.:**  
77 54 031800



##### MOST HURON

■ Durable gloves made of cow split leather, recommended for simple welding procedures. Hidden seams, thick cow split leather protection wrists.

**Catalogue no.:**  
76 10 140110



##### MOST ALABAMA

■ Durable, good quality gloves made of cow split leather in top section and of grain cow leather in hand-pad section. It decides about higher comfort of work and increases resistance of gloves to impurities like oil, dust and other.

**Catalogue no.:**  
76 10 140112



##### MOST MARS

■ Welding type gloves made of select cow split leather of red colour. Resistant to high temperatures edged with Kevlar® threads. All-hand-pad of total length 35 cm.

**Catalogue no.:**  
77 54 031950



##### MOST LUX BLACK

■ Welding type gloves made of high quality cow split leather. Interior lined with a material, strengthened cuff. Sewed with non-flammable threads.

**Catalogue no.:**  
77 54 031930



##### MOST PUMA

■ Comfortable to use gloves made of cow split leather of brown color. Designed for welding works, high temperature resistant, Hidden seams, interior lined with cotton, stitched with flame-resistant thread. Common length is 35 cm.

**Catalogue no.:**  
76 10 140140



##### MOST BIZON

■ Comfortable to use high quality gloves made of cow split leather of black color. Designed for welding works. High temperature resistant. Gloves are stitched with flame-resistant thread. Interior lined with cotton. Common length is 35 cm.

**Catalogue no.:**  
76 10 140130



## 3.2 Leather gloves

### MOST BAHAMA

■ Gloves made of cow split leather of high quality. All-hand-pad. Both comfortable and durable. Strengthened cuff protects wrist. Differs from other gloves made of cow split leather because of better appearance.

**Catalogue No.:**  
77 55 016000



### MOST TOGO

■ Gloves made of grain cow leather of high quality. All-hand-pad. Both comfortable and durable. Strengthened cuff protects wrists.

**Catalogue No.:**  
77 55 020000



### MOST BERMUDA

■ Gloves made of high quality cow split leather. All-hand-pad. Soft and well tanned leather secures working comfort and gloves durability.

**Catalogue No.:**  
77 55 015000



### DOCKER

■ Denim gloves, strengthened in hand-pad section with cow split leather, designed for hard works. Soft and well tanned leather secures working comfort and gloves durability. Perfect for building works, for carrying rough but less sharp elements etc.

**Catalogue No.:**  
77 54 020730



### MOST LAGOS

■ Gloves made of furniture leather, dark coloured, with sectional internal hand. Characterized by high abrasion resistance at the same time providing large elasticity. Designed for hard works in dry interiors or temperate atmosphere conditions. Perfect for building works, for carrying rough or less sharp elements.

**Catalogue No.:**  
77 52 512221



### MOST OKLAHOMA

■ Strengthened gloves made of cow split leather with sectional internal hand. Soft and well tanned leather secures working comfort and gloves durability. Sewed with threads of increased toughness of mixture of polyester and cotton.

**Catalogue No.:**  
77 55 012311



### MOST MEXICO

■ Gloves made of multi-coloured furniture leather with sectional internal hand. Characterized by high abrasion resistance at the same time providing large elasticity. Designed for hard works in dry interiors or temperate atmosphere conditions. Perfect for building works, for carrying rough or less sharp elements.

**Catalogue No.:**  
77 52 612111



### Drill gloves enhanced with pig split leather

■ Light, grill gloves designed for heavy duty jobs. Internal section covered with pig split leather characterised by high abrasion resistance. Perfect for internal usage or dry weather. Not to be used in case of cut or burn danger.

**Catalogue No.:**  
77 53 013000



### 3.3 Latex and vinyl gloves

#### BI-COLOUR™ Plus Latex gloves



■ Latex gloves designed for anti-chemical protection. Specially processed internal surface minimizes threats of allergic reactions. Available sizes: 7-11.

**Catalogue No.:** 77 57 078510 size 10

#### GREIFER Gloves

■ Cotton gloves partly covered with latex and knitted cuffs. Best for cement works, gardening or construction works etc.

**Catalogue No.:** 77 53 130500



#### VAMPIRE gloves

■ Cotton gloves covered with rubber. Available in red, green or blue. For general purpose use

**Catalogue No.:**

76 10 200005 green, size L  
76 10 200007 red, size L  
76 10 200008 blue, size L



#### PEVEX Vinyl gloves

■ Swehand Pevex disposable vinyl gloves with powder. One pack contains 100 pcs. in blue or colourless version. Designed for food industry, medical services, laboratories, as well as painting and cleaning etc. Minimal threat of allergic reaction. Available sizes: 7, 8, 9.

**Catalogue No.:** 77 53 146010 size L/9

### 3.4. Other types of gloves

#### Aluminized gloves

■ Protect against high temperatures. Made of aramide fibre with aluminized external surface.

**Catalogue No.:**

77 53 144000 one finger gloves  
77 53 146000 three finger gloves  
77 53 145000 five finger gloves



#### CHIFFCHAFF kevlar gloves

■ Gloves made of high quality Kevlar du Pont, with a minimal weave. Extremely resistant to cuts and high temperatures. Available colours are: yellow with green spackles around the hand section to guarantee perfect grip. Available sizes: 7, 8, 9, 10.

**Catalogue No.:**

77 05 093010 size 10



# IV

# TECHNICAL CHEMISTRY









## Contents





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## 1. STAINLESS STEEL PICKLING AND PASSIVATION AGENTS

Danger symbols				
<b>C</b> caustic	<b>T</b> toxic	<b>T+</b> very toxic	<b>Xn</b> noxious	<b>Xi</b> irritating

Name	Description – application – properties	Index	Package
 <b>MOST BLUE</b>	Highly efficient transparent pickling and passivating paste designed for removing scale layers and weld discolouration formed in the processes of high-grade steel and nickel alloys Danger symbols: T, C Exposure time: steel: 15-60 min. Efficiency: (1 kg): 50-80 running meters Application method: pickling brush.	84 17 100002	2 kg 
 <b>MOST NEUTRALIZATOR</b>	Neutralising white paste designed to neutralize the action of pickling pastes MOST BLUE, MOST BLUE EXTRA, ANTOX 71E or CHEMARGAN. Efficiency: (1 kg): 50-80 running meters Application method: pickling brush.	84 17 000002	2 kg 
 <b>MOST ORANGE</b>	Highly efficient air-atomized gel designed for pickling welds and surfaces from acid resistant steels applied within a single working cycle. Acceptable use of pigments. Danger symbols: T, C Exposure time: steel: 30-90 min. Efficiency: (1 kg) 4-6 m <sup>2</sup> Application method: pump or pickling hand spray.	84 17 200010	10 kg 






















## 2. CLEANING AGENTS

Name	Description – application – properties	Index	Package
 <b>INOX KONSERWATOR SPRAY</b>	<ul style="list-style-type: none"> <li>high-grade steel protection and maintenance agent</li> <li>dirt and dust repellent</li> <li>leaves a sheen finish</li> <li>does not leave smudges</li> <li>anti-static action</li> <li>application: large kitchens, hospitals, catering industry, food processing industry, banks, laboratories, etc.</li> </ul>	84 22 705550	400 ml 
 <b>INOX KONSERWATOR (fluid)</b>	<ul style="list-style-type: none"> <li>consistent with DAB 10 requirements (clarity and purity)</li> <li>maintenance agent used with high-grade steel and chromed elements</li> <li>leaves a long lasting sheen finish</li> <li>removes organic fouling</li> <li>removes impurities due to footprints, hand sweat and dust</li> <li>does not contain any fluorine-hydrocarbon compounds</li> <li>suitable for cleaning of machinery used in food processing industry</li> </ul>	84 22 706500	5 l 

### 3. SUPPORTIVE AGENTS USED IN THE PROCESSES OF WELDING AND METALWORKING



Name	Form	Description – application – properties	Index	Package
  <b>UFO-1</b> <b>UFO-2</b> <b>UFO-3</b>	Spray	<ul style="list-style-type: none"> <li>• anti-spatter agent used as a parting and protective agent in the processes of electrical welding and gas-shielded welding;</li> <li>• facilitates removal of weld spatter and impurities from the surface of the welded steel construction as well as from the welding tools and blowpipe nozzle;</li> <li>• prevents formation and facilitates removal of carbon deposit from the surface of the blowpipe nozzle; considerably improves efficiency and life of the equipment.</li> <li>• UFO – 2 is non-flammable</li> <li>• UFO – 3 meets the requirements of the German DAB</li> </ul>	84 31 100400 84 32 100400 84 33 100400	400 ml 400 ml 400 ml 
  <b>PROTECTOR</b>	Liquid	<ul style="list-style-type: none"> <li>• liquid anti-spatter agent protects surfaces of welded elements against sticking of splinters</li> <li>• can be applied for shielding a blowpipe at MIG, MAG welding</li> <li>• non-flammable</li> <li>• non-silicone</li> <li>• application method: metallic pump 400ml (Catalogue No.: 84 23 749040)</li> </ul>	84 23 760010 84 23 760030	10 l 30 l 
  <b>PASTA DO DYSZ</b>	Paste	<ul style="list-style-type: none"> <li>• paste for nozzles</li> <li>• reliable blowpipe nozzle for protection against splinters formed at welding process</li> </ul>	84 23 710550 84 23 710300	250 g 300 g 
  <b>OVERCHEK RED</b> <b>OVERCHEK WHITE</b> <b>OVERCHEK CLEANER*</b>	Spray	<ul style="list-style-type: none"> <li>• set of visible in daylight dye penetrates (penetrate, developer and cleaner)</li> <li>• used in the process of detecting cracks and flaws on weld seam, metal surface and alloys</li> <li>• used with alloy and non-alloy steel, cast steel, malleable cast iron, grey cast iron, ceramics, sintered metal, brass, copper, etc</li> <li>• forms a protective, anticorrosive film on the surface of the material</li> <li>• *recommended for cleaning brakes and oil burners</li> <li>• *does not emit noxious vapours</li> <li>• *does not possess pickling properties</li> <li>• *does not leave deposit or residue</li> </ul>	84 23 709723 84 23 709702 84 23 709701	500 ml 500 ml 400 ml 
  <b>ZMYWACZ</b>	Spray	<ul style="list-style-type: none"> <li>• cleaner spray</li> <li>• efficiently removes greasy smudges of dirt.</li> <li>• especially recommended for clearing hydraulic breaks and torches</li> <li>• does not have caustic properties</li> <li>• does not produce any residues or remains</li> </ul>	84 23 709901	500 ml 
  <b>WB WELDER</b>	Liquid	<ul style="list-style-type: none"> <li>• anti – spatter liquid</li> <li>• incombustible based on water</li> <li>• it prevents adhesion of welding spatter to weld elements nozzles, holders and clips</li> <li>• it saves time, gives possibility to remove welding sparks from metallic surfaces</li> <li>• it doesn't contain silicon</li> <li>• reliably defends torch nozzle from sparks</li> <li>• used when cleaning or degreasing before final processing is needed (painting, galvanization)</li> <li>• application method: metallic pump 400ml (Catalogue No.: 84 26 749040)</li> </ul>	84 23 781010	10 l 

## 4. METALLIC SPRAYS

Name	Form/ Colour*	Description – application – properties	Index	Package
 <b>CYNK SREBRNO-SZARY SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>metal surface coating, primarily for interior surfaces and as a primer for surfaces before varnishing</li> <li>for repairing damaged zinc coatings, repairing defects after cutting and welding</li> <li>corrosion protection</li> <li>after drying leaves a smooth finish</li> <li>more than 90 % zinc after drying</li> <li>silver-grey colour</li> </ul>	84 24 704555	400 ml 
 <b>CYNK SREBRNO-JASNY SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>metal surface coating, primarily for interior surfaces and as a primer for surfaces before varnishing</li> <li>for repairing damaged zinc coatings after cutting and welding</li> <li>corrosion protection- after drying leaves a smooth finish</li> <li>more than 90 % zinc after drying</li> <li>light-silver colour</li> </ul>	84 24 704550	400 ml 
 <b>ALUMINIUM SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>metal, wood, plastic and other surfaces coating</li> <li>designed particularly for air conditioners, wheel rims, galvanised materials</li> <li>corrosion protection</li> <li>forms a quick drying and smooth coating with heat resistance up to 800°C</li> <li>electric conduction (for example: in spot welding)</li> </ul>	84 24 701650	400 ml 
 <b>ALU-CYNK SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>metal, wood, plastic and other surfaces coating</li> <li>coating after cutting places, repairing after welding galvanized surfaces</li> <li>corrosion protection</li> <li>electrically conducting (e.g. for spot welding)</li> <li>after drying doesn't leave scratches</li> </ul>	84 24 704250	400 ml 
 <b>STAL SZLACHETNA SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>adheres firmly to all metal, wood, plastic, ceramic, glass, and building paper surfaces</li> <li>corrosion resistant coating combines the quality of highly alloyed steel and weather resistant synthetic resin</li> <li>leaves a bright soft sheen finish</li> <li>forms a coating resistant to temperatures up to -40°C</li> <li>precious steel content: 62%</li> <li>stainless steel colour</li> </ul>	84 24 705650	400 ml 
 <b>MIEDŹ SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>adheres firmly to all metal, glass, paper, plastic, wood, ceramic and other surfaces</li> <li>designed for removing bloom discoloration spots and heat tint formed in the process of copper soldering</li> <li>corrosion protection</li> <li>leaves a metallic sheen finish</li> <li>weather and abrasion resistant</li> <li>copper colour</li> </ul>	84 24 705750	400 ml 
 <b>MOSIĄDZ SPRAY</b>	Spray 	<ul style="list-style-type: none"> <li>adheres firmly to all metal, glass, paper, plastic, wood, ceramic and other surfaces</li> <li>corrosion protection</li> <li>leaves a soft gold sheen finish</li> <li>weather and abrasion resistant</li> <li>brass colour</li> </ul>	84 24 705850	400 ml 

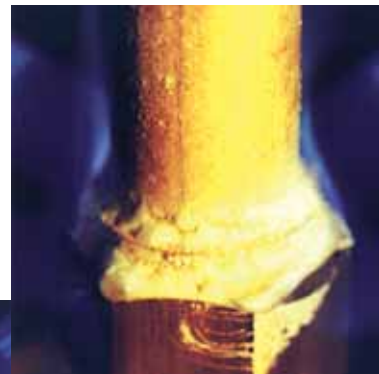
\*) The colours of presented in the table metals are similar to actual ones.

## 5. LUBRICANTS

Name	Description – application – properties	Index	Package
 <b>SILIKON SPRAY</b>	<ul style="list-style-type: none"> <li>pure silicone in spray</li> <li>diminishes friction, possesses preservation and impregnation properties as well as anti-electrostatic and anticorrosive properties</li> <li>used as a separative as well as a preservation and maintenance agent for chemical and thermohardening plastics; also used for rubber (except for silicone rubber), for injection moulding machines, in printing and horizontal transportation of packages, in the welding technology (separator) and for such materials as wood, rubber, paper, foam and textiles</li> <li>can be used at temperatures between -50°C and 250°C</li> </ul>	84 44 151915	400 ml 

# V

# BRAZING AND SOLDERING CONSUMABLES



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## 1. BRAZING

Name		Composi- tion (%)	Diameter (mm)	Form	Melting point (°C)	Joined materials	Major application	Recommended fluxes
DIN 8513	PN 70 / M-69413							
L-CuZn40	LM 60K	Cu=60 Zn=39,75 Si=0,25	2,0–5,0 2,0–6,0 2,0–5,0	coils rods coated rods	860–900	steel, cast iron, copper alloys	welding of brass, soldering of pipelines and apparatus, pro- duction of steel heaters and any type construction tubes	powder: D-50, Borax, HKM, paste: D-54
L-CuZn39Sn	LM 60 C	Cu=59 Zn=39,75 Si=0,25 Sn=1	2,0–4,0 2,0–4,0 2,0–4,0		870–890	steel, cast iron, copper alloys	welding of brass apparatus and pipelines, soldering of ele- ments in machinery construc- tions, production of bikes, motorcycles, steel heaters and any type construction tubes	powder: D-50, Borax, HKM, paste: D-54
L-CuZn39Ag	LM 60 S	Cu=58 Zn=39,35 Si=0,15 Sn=0,2 Mn=0,3 Ag=0,1	2,0–3,0 2,0–3,0	rods coated rods	850–870	steel, cast iron, copper alloys, galva- nized steel	soldering of precision mecha- nism, production of steel heaters, soldering of galvanized tubes	powder: D-50, Borax, HKM, paste: D-54 gel: POLYFLUX

Table 1. Brass alloys



Name		Composi- tion (%)	Diameter (mm)	Form	Melting point (°C)	Joined materi- als	Major application	Recom- mended fluxes
DIN 8513	PN 80 / M-69411							
L-CuP6	LMF 6	Cu=94 P=6	1,5–3,0	rods	710–880	copper and copper alloys	systems of: hot and cold water, liquefied and natural gas, chlorinated fluoride hydrocarbons; assembly of pipe laterals, soldering machines open to dynamic loads	copper: without flux copper alloys: D-26, HS
L-CuP7Sn	LMF 7 C	Cu=86 P=7 Sn=7	1,5–3,0	rods	645–695		systems of: hot and cold water, liquefied and natural gas, chlorinated fluoride hydrocarbons; soldering of sleeves and machines not open to dynamic loads	copper: without flux copper alloys: D-26, HS
L-CuP8	LMF 8	Cu=92 P=8	1,5–3,0	rods	710–750		systems of: hot and cold water, liquefied and natural gas, chlorinated fluoride hydrocarbons; soldering of gas water-heaters and other devices not open to dynamic loads	copper: without flux copper alloys: D-26, HS
L-Ag2P	LS 2F	Cu=91,8 P=6,2 Ag=2	1,5–3,0	rods	645–800		in refrigeration industry plants, for refrigeration devices and installations and for joints with brass and bronze; the silver content in filler metal increases fluidity, durability, resistance to corrosion and lowers the melting point	copper: without flux copper alloys: D-26, HS
L-Ag5P	LS 5F	Cu=88,8 P=6,7 Ag=5	1,5–3,0	rods	645–810			
L-Ag15P	LS 15F	Cu=80,3 P=4,7 Ag=15	1,5–3,0	rods	645–800			

Table 2. Copper-phosphorus and silver-copper-phosphorus alloys

Name		Composition (%)	Diameter (mm)	Form	Melting point (°C)	Joined materials	Major application	Recommended fluxes
DIN 8513	PN 80 / M-69411							
L-Ag 20	LS 20	Cu=44; Zn=36 Ag=20	0,5-3,0 1,0-3,0 1,5-3,0	wire rods coated rods	690-810	cast iron, carbon and low-alloy steels, acid resistant steel, copper, copper alloys, nickel and nickel alloys	soldered joints of thermal load up to 200°C, thin-layer soldering, braze welding	D-26, HS
L-Ag 25	LS 25	Cu=41; Zn=34 Ag=25	0,5-3,0 1,0-3,0 1,5-3,0		700-800		soldered joints of thermal load up to 200°C, thin-layer soldering, braze welding	D-26, HS
L-Ag 34 Sn	LS 34C	Cu=36; Zn=32 Ag=34 Sn=2	0,5-3,0 1,0-3,0 1,5-3,0		630-730		soldered joints of thermal load up to 200°C	D-26, HS
L-Ag 40 Sn	LS 40C	Cu=30; Zn=28 Ag=40; Sn=2	0,5-3,0 1,0-3,0 1,5-3,0		640-700	cast iron, carbon and low-alloy steels, acid resistant steel, copper, copper alloys, nickel and nickel alloys	in refrigerating machines production	D-26, HS
L-Ag 44	LS 45	Cu=30; Zn=26 Ag=44	0,5-3,0 1,0-3,0 1,5-3,0		675-735		shipbuilding industry	D-26, HS
L-Ag 55 Sn	LS 55 C	Cu=21; Zn=22 Ag=55; Sn=2	0,5-3,0 1,0-3,0 1,5-3,0		620-660		particularly fits for metals under hazard of solder brittleness, for sintered carbides, thin-layer soldering, braze welding	D-26, HS

Table 3. Silver alloys



Name		Composition (%)	Diameter (mm)	Form	Melting point (°C)	Joined materials	Major application	Recommended fluxes
DIN 8513	PN 80 / M-69411							
L-Ag 20 Cd	LS 20K	Cu=40; Zn=25 Ag=20; Cd=15	0,5-3,0 1,0-3,0 1,5-3,0	wire rods coated rods	605-765	elements susceptible to overheating, cast iron, steel, copper, copper alloys, nickel, nickel alloys	wherever required low melting point, in soldered joints of thermal load up to 150°C, thin-layer soldering, braze welding	D-26, HS
L-Ag 30 Cd	LS 30K	Cu=28; Zn=21 Ag=30; Cd=15	0,5-3,0 1,0-3,0 1,5-3,0		600-690			D-26, HS
L-Ag 40 Cd	LS 40K	Cu=19; Zn=21 Ag=40; Cd=20	0,5-3,0 1,0-3,0 1,5-3,0		595-630	elements susceptible to overheating, high-alloy steels, copper, precious metals and their alloys	wherever required low melting point, in soldered joints of thermal load up to 150°C, for sintered carbides, thin-layer soldering	D-26, HS
L-Ag 45 Cd	LS 45K	Cu=17; Zn=18 Ag=45; Cd=20	0,5-3,0 1,0-3,0 1,5-3,0		620-635			D-26, HS

Table 4. Silver alloys cadmium containing

Name	Composition (%)	Dimensions (mm)	Form	Melting point (°C)	Joined materials	Major application
Ag50CdNi TR	Ag=50; Cu=15 Zn=16; Cd=16 Ni=3	0,1–1,0/ 2,0–65	foil (thick- ness/width)	635–655	joining fittings made of sintered carbides up to 19 mm with steel; tungsten with molybdenum	Flux AG7 Flux AG8
Ag49MnNi / 1 TR	Ag=49; Cu=27,5 Zn=20,5; Mn=2,5 Ni=0,5	0,1–1,0/ 2,0–65	foil (thick- ness/width)	670–690	joining large elements of tungsten carbide, contains central copper coin, which prevents the carbide from cracking after soldering or during application	Flux AG7 Flux AG8

Table 5. Silver brazing alloys for tungsten carbide

Name	DIN 8511	Form	Package	Application with solders
BORAKS	–	powder	loose by weight	brazing brass
HKM	F-SH 2	powder	100 g, 500 g	brazing brass
D-54	F-SH 2	paste	1 kg, 8 kg	brazing brass
D-50	F-SH 2	powder	250 g, 500 g, 1 kg, 5 kg	brazing brass
HS	F-SH 2	paste	100 g, 500 g	silver, copper-phosphorus solders
D-26	F-SH 1	powder	250 g, 500 g, 1 kg, 5 kg	silver, copper-phosphorus solders
POLYFLUX	F-SH 2	gel, powder	400 g, 1 kg, 5 kg	brazing brass

Table 6. Brazing fluxes

## 2. SOFT SOLDERING



Name PN 76/ M-69400	Composition (%)	Diameter (mm)	Form	Melting point (°C)	Joined materials	Major application	Recommended fluxes
LC 30	Sn=30 Pb=70	-	bars	183-260	copper, brass, steel, zinc	filler metal of common use, for soldering of steel sheets, galvanized sheets and zinc, bath soldering and tinning, soldering of coolers	ZWN, ZWS, C-65, C-66, paste FT, SOFT UNIGEL ECO, SOFT Cu-LIQUID ECO
LC 40	Sn=40 Pb=60	-	bars	183-238	copper, brass, steel, zinc	for soldering of steel and galvanized sheets, soldering and tinning of electrical engineering apparatus, coolers and other parts of machines	
LC 50	Sn=50 Pb=50	-	bars	183-216	copper, brass, steel	electronics industry with application of soldering tools with durable and non-durable tips, precision elements in machines construction	
LC 60	Sn=60 Pb=40	0,25-4,0 0,25-4,0	bars, wire, wire with flux	183-190	copper, brass, steel	soldering and tinning of small elements of machines and in electrical engineering	
LC 90	Sn=90 Pb=10	-	bars	183-220	copper, brass, steel	soldering and tinning of inside parts of packages and groceries equipment, soldering of medical apparatus	

Table 7. Soft tin-lead alloys

### Tin soldering for copper connections



Name PN 76/ M-69400	Composition (%)	Diameter (mm)	Form	Melting point (°C)	Joined materials	Major application	Package
SnCu3	Cu=3 Sn=97	2,0 2,5 3,0	wire	230-250	copper	in drinking water systems, soldering of electronics and equipment for food industry, thermal resistant up to 110°C, recommended with flux - paste LF no. 3, paste SOFT SnCu3	250g 
SnAg3	Sn=97 Ag=3	2,0 2,5 3,0	wire	221	copper	in drinking water systems, soldering of electronics and equipment for food industry, thermal resistant up to 175°C, higher strength of joint, recommended with flux - paste LF no. 4	250g 

Table 8. Tin soldering

### Fluxes for soft soldering








Name	DIN 8511	Form	Application	Package
C-66	3.1.1.A	gel	universal, active flux: copper, brass, steel, zinc, galvanized sheets	125 g 500 g 
 SOFT UNIGEL EKO*	2.1.2.C	gel	universal, environmentally friendly flux for joining: copper, brass, steel, galvanized steel	100 g 
GREASE FOR SOLDERING	3.1.1.C	paste	universal: copper, brass, steel, zinc, galvanized sheets	75 g 250 g 1 kg 
 SOFT UNIPASTA EKO*	3.1.1.A	paste	universal, environmentally friendly flux for joining: copper, brass, steel, galvaniser	125 g 
RST	3.2.2.A	liquid	stainless steel	100 g 250 g 1 kg 

Table 9. Universal fluxes (joining of brass, steel, copper and galvaniser)



Name	DIN 8511	Form	Application	Package
ZWN	3.2.2.A	fluid	galvanized steel sheets, titanium galvaniser, technically pure zinc	250 g 1 kg 
ZWS	3.2.2.A	fluid	galvanized steel sheets, strongly oxidized titanium galvaniser, technically pure zinc	250 g 1 kg 

Table 10. Solderings for galvaniser connections










Name	DIN 8511	Form	Application	Package
C-65	3.1.1.A	fluid	copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C)	125 g 500 g 
 SOFT Cu-LIQUID EKO*	3.1.1.A	fluid	joining: copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C); brass	100 g 450 g 
FT	3.1.1.C	paste	copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C)	75 g 125 g 
LF No. 3	3.1.1.C	paste 40% flux 60% filter metal	alongside with solder SnCu3 for joining copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C)	100 g 250 g 
LF No. 4	3.1.1.C	paste 40% flux 60% filter metal	alongside with solder SnAg3 for joining copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C)	100 g 250 g 
 SOFT SnCu3	3.1.1.C	paste 40% flux 60% filter metal	alongside with solder SnCu3 for joining copper (pipes, fittings in hot and cold drinking and central heating water systems of working temperature up to 110°C)	250 g 
WSN 25% Sn WSN 40% Sn WSN 60% Sn WSN 99% Sn	3.1.1.C	80% flux 20% filter metal	finning of copper and other metals, igneous or by adhesive brushing and uniform heating	100 g 250 g 500 g 1 kg 

Table 11. Fluxes for soft soldering cuprous metals

\* ENVIRONMENTALLY FRIENDLY: does not contain zinc chloride; non-corrosive flux residue; atoxic; non-irritant

### 3. SOLDERING EQUIPMENT AND AUXILIARY MATERIALS

#### Salmiak stone

■ **Salmiak stone** removes oxides of copper soldering chisels.

Simply press a hot chisel to the stone to melt it cleaning the chisel even if very dirty and overheated. After cooling down, salmiak comes back to its solid-state of aggregation.

Advantages: quick and easy cleaning of soldering chisels, high efficiency.

**Package:** 1 block 65x45x20 mm

Catalogue No.: 39 00 006050

**Box diameter:** 75 mm

Catalogue No.: 39 00 006000



#### Soldering cleanser

■ Non-metal fibre of multiple usage designed for precise cleaning of materials destined for soldering. Designed specially for pipe cleaning. Leaves no scratches or splinters which prevents corrosion. The fibre is also solvent proof. It is therefore capable of removing grease stains. The fibre can be effectively cleaned by shaking it out or rinsing it.

Package: 10 sheets.

Catalogue No.: 94 40 907608



Additional equipment for soldering and brazing – see Polish version of Catalogue 2008

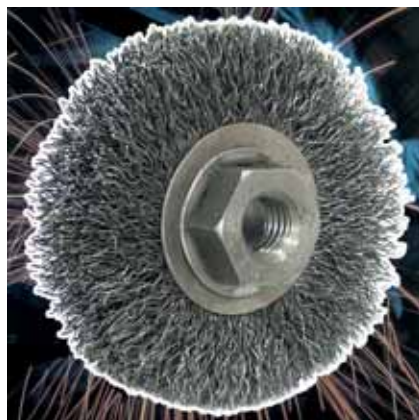
LECKSUCHER SPRAY – tightness testing agent – description p. VI-15

COPPER SPRAY – description p. VI-11

PROPALINE Heating and soldering programme– description p. III-27

PERUN Soldering torches – description p. III-26

# VI ABRASIVES



## Contents

1. Grinding and cutting wheels	68
2. Abrasive tools with vitrified bonds	81
3. Technical brushes	82

## 1. GRINDING AND CUTTING WHEELS

### Advantages of grinding and cutting wheels MOST:

- **Modern production technology** – developed as a result of laboratory and marketing research.
- **Selected raw materials** – specially selected raw materials for production process
- **Control at every production stage** – quality is controlled during mixture preparing, forming, pressing and hardening process
- **Constant high quality** – affirmed on the basis of carried out tests and users opinions.

### Abrasive tools marking



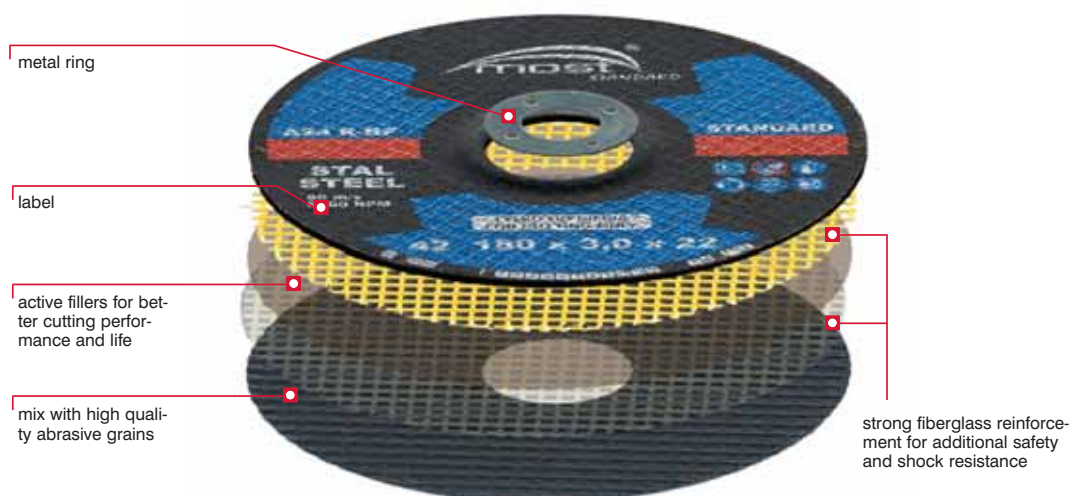
### Safe use of abrasive tools

While working with application of MOST grinding wheels it is necessary to follow industrial safety rules. Products of this group are marked with appropriate working safety pictograms.

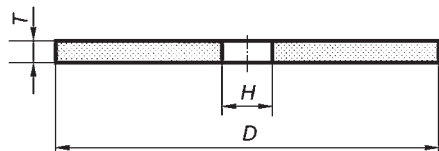
### Safety pictograms

- Please read the instruction carefully
- Use ear protection
- Use protective gloves
- Use a safety shield or protective eyewear
- Use a dust mask
- Only cut-off wheel, do not use for grinding

### Abrasive tools construction



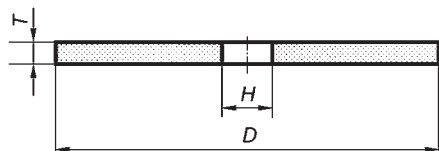
**Cutting wheels for steel - Shape 41  
MOST SPEED**



- application: steel,
- extra thin cutting wheels,
- for thin-walled profiles and sheets,
- particularly fast cutting action, long service life, vibration-free cutting.

Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 1,0 x 22	A46RBF SPEED	13 300	80	50	94 14 315100
2	115 x 1,6 x 22	A46RBF SPEED	13 300	80	50	94 14 315160
3	125 x 1,0 x 22	A46RBF SPEED	12 200	80	50	94 14 325100
4	125 x 1,6 x 22	A46RBF SPEED	12 200	80	50	94 14 325160
5	180 x 1,6 x 22	A46RBF SPEED	8 500	80	25	94 14 380160

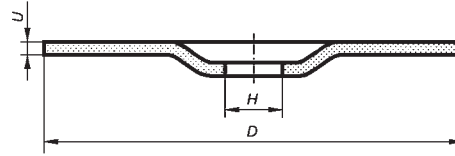
**Cutting wheels for steel - Shape 41  
MOST STANDARD PREMIUM**



- application: steel,
- universal, for sheets, rods, profiles, etc.,
- hard cutting wheels, high cutting speed,
- very good quality/price ratio.

Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 2,0 x 22	A36RBF PREMIUM	13 300	80	25	94 16 011500
2	115 x 2,5 x 22	A36RBF PREMIUM	13 300	80	25	94 16 115000
3	125 x 2,0 x 22	A36RBF PREMIUM	12 200	80	25	94 16 012500
4	125 x 2,5 x 22	A36RBF PREMIUM	12 200	80	25	94 16 125000
5	180 x 2,0 x 22	A36RBF PREMIUM	8 500	80	25	94 16 018000
6	180 x 2,5 x 22	A36RBF PREMIUM	8 500	80	25	94 16 180000
7	230 x 2,0 x 22	A36RBF PREMIUM	6 600	80	25	94 16 023000
8	230 x 2,5 x 22	A36RBF PREMIUM	6 600	80	25	94 16 230000
9	300 x 3,2 x 32	A24RBF PREMIUM	5 100	80	10	94 16 300000
10	350 x 3,5 x 32	A24RBF PREMIUM	4 350	80	10	94 16 350000
11	400 x 4,0 x 32	A24RBF PREMIUM	3 800	80	10	94 16 400000

## Cutting wheels for steel - Shape 42 MOST STANDARD

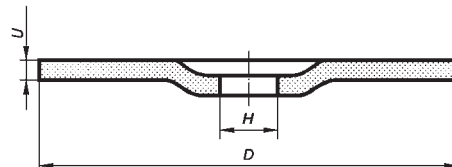


- application: steel,
- universal, for sheets, rods, profiles, etc.,
- medium cutting wheels, high cutting speed,
- good service life at a reasonable price.

### Technical specification

No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 3,0 x 22	A24RBF STANDARD	13 300	80	25	94 20 115000
2	125 x 3,0 x 22	A24RBF STANDARD	12 200	80	25	94 20 125000
3	180 x 3,0 x 22	A24RBF STANDARD	8 500	80	25	94 20 180000
4	230 x 3,0 x 22	A24RBF STANDARD	6 600	80	25	94 20 230000

## Grinding wheels for steel - Shape 27 MOST STANDARD

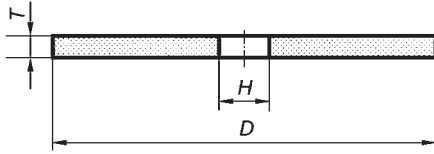


- application: steel,
- all purpose, for surface grinding, edge beveling, smoothing welding seams,
- hard grinding wheels, high stock removal rate, long service life.

### Technical specification

No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 6,5 x 22	A24RBF STANDARD	13 300	80	10	94 21 115000
2	125 x 6,5 x 22	A24RBF STANDARD	12 200	80	10	94 21 125000
3	180 x 6,5 x 22	A24RBF STANDARD	8 500	80	10	94 21 180000
4	180 x 8,0 x 22	A24RBF STANDARD	8 500	80	10	94 21 180001
5	230 x 6,5 x 22	A24RBF STANDARD	6 600	80	10	94 21 230000
6	230 x 8,0 x 22	A24RBF STANDARD	6 600	80	10	94 21 230001

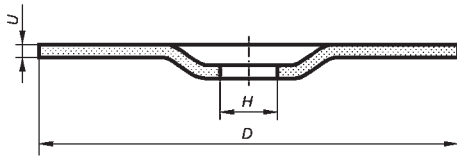
**Cutting wheels for steel - Shape 41**  
**MOST PROFESSIONAL**



- application: steel,
- highly efficient, for profiles, pipes, sheets, etc.,
- hard cutting wheels, very long service life, high cutting speed,
- top quality with best value for money.

Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 2,5 x 22	A30SBF PRO	13 300	80	25	94 16 511500
2	125 x 2,5 x 22	A30SBF PRO	12 200	80	25	94 16 512500
3	180 x 2,5 x 22	A30SBF PRO	8 500	80	25	94 16 518000
4	230 x 2,5 x 22	A30SBF PRO	6 600	80	25	94 16 523000
5	300 x 3,2 x 32	A24TBF PRO	5 100	80	10	94 16 530000
6	350 x 3,5 x 32	A24TBF PRO	4 350	80	10	94 16 535000
7	400 x 4,0 x 32	A24TBF PRO	3 800	80	10	94 16 540000

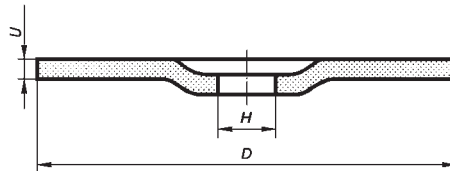
**Cutting wheels for steel - Shape 42**  
**MOST PROFESSIONAL**



- application: steel
- multi-purpose wheel for metal sheets, rods, profiles, etc.,
- medium-hard for very fast cutting.

Technical specification						
No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 2,5 x 22	A30SBF PRO	13 300	80	25	94 20 311500
2	125 x 2,5 x 22	A30SBF PRO	12 200	80	25	94 20 312500
3	150 x 2,5 x 22	A30SBF PRO	10 200	80	25	94 20 315000
4	180 x 2,5 x 22	A30SBF PRO	8 500	80	25	94 20 318000
5	230 x 2,5 x 22	A30SBF PRO	6 600	80	25	94 20 323000

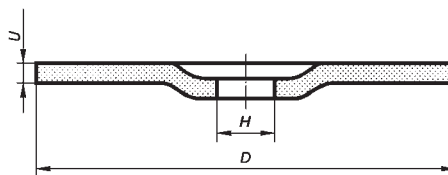
## Grinding wheels for steel - Shape 27 MOST PROFESSIONAL



- application: steel,
- special-purpose, so-called „shipbuilding” for rough grinding, flame cut edge beveling, weld grinding
- very hard grinding wheels, high stock removal rate, very long service life
- additional fiberglass reinforcement
- top quality with the best possible price to performance ratio.

Technical specification						
No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 6,8 x 22	A24SBF PRO	13 300	80	10	94 21 311500
2	125 x 6,8 x 22	A24SBF PRO	12 200	80	10	94 21 312500
3	150 x 6,8 x 22	A24SBF PRO	10 200	80	10	94 21 315001
4	180 x 6,8 x 22	A24SBF PRO	8 500	80	10	94 21 318000
5	180 x 8,0 x 22	A24SBF PRO	8 500	80	10	94 21 318001
6	230 x 6,8 x 22	A24SBF PRO	6 600	80	10	94 21 323000
7	230 x 8,0 x 22	A24SBF PRO	6 600	80	10	94 21 323001

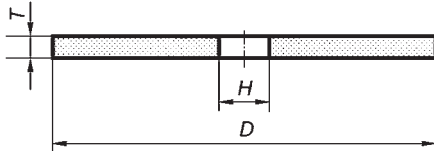
## Grinding wheels for steel - Shape 27 MOST SPECIAL



- application: steel,
- all purpose, for surface grinding, smoothing welding seams
- soft grinding wheels, very high removal rate, medium service life,
- provides highest working comfort.

Technical specification						
No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 6,5 x 22	A24PBF SPECIAL	13 300	80	10	94 21 511500
2	125 x 6,5 x 22	A24PBF SPECIAL	12 200	80	10	94 21 512500
3	180 x 6,5 x 22	A24PBF SPECIAL	8 500	80	10	94 21 518000
4	230 x 6,5 x 22	A24PBF SPECIAL	6 600	80	10	94 21 523000

**Cutting wheels for stainless steel - Shape 41  
MOST TURBO INOX**



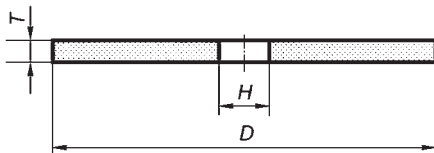
- application: stainless steel,
- extra thin cutting wheels,
- for thin-walled elements profiles and sheets,
- particularly fast cutting action, long service life, vibration-free cutting,
- does not contain iron-sulphuric compounds (Fe + S + CL <0,1%).



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Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 1,0 x 22	A60TBF TURBO INOX	13 300	80	50	94 14 115100
2	115 x 1,6 x 22	A60TBF TURBO INOX	13 300	80	50	94 14 115160
3	125 x 1,0 x 22	A60TBF TURBO INOX	12 200	80	50	94 14 125100
4	125 x 1,6 x 22	A60TBF TURBO INOX	12 200	80	50	94 14 125160
5	180 x 1,6 x 22	A60TBF TURBO INOX	8 500	80	25	94 14 180160

**Cutting wheels for stainless steel - Shape 41  
MOST INOX**

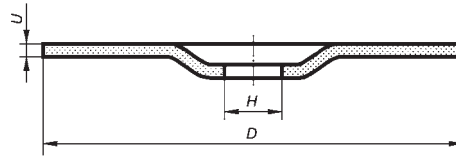


- application: stainless steel,
- for profiles, pipes, sheets, etc.,
- hard cutting wheels, very long service life, high cutting speed.



Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 2,0 x 22	A46TBF INOX	13 300	80	25	94 16 711500
2	125 x 2,0 x 22	A46TBF INOX	12 200	80	25	94 16 712500
3	180 x 2,0 x 22	A46TBF INOX	8 500	80	25	94 16 718000
4	230 x 2,0 x 22	A46TBF INOX	6 600	80	25	94 16 723000

## Grinding wheels for stainless steel - Shape 42 MOST INOX

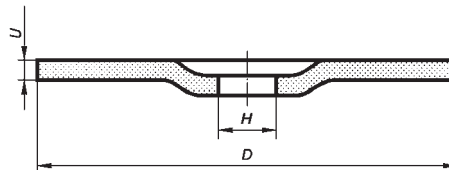


- multi-purpose wheel for metal sheets, rods, profiles, etc.,
- very hard, particularly fast cutting action, long service life, vibration-free cutting
- does not contain iron-sulphuric compounds ( $Fe + S + CL < 0,1\%$ )

### Technical specification

No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 2,5 x 22	A36TBF INOX	13 300	80	25	94 20 411500
2	125 x 2,5 x 22	A36TBF INOX	12 200	80	25	94 20 412500
3	180 x 2,5 x 22	A36TBF INOX	8 500	80	25	94 20 418000
4	230 x 2,5 x 22	A36TBF INOX	6 600	80	25	94 20 423000

## Grinding wheels for stainless steel - Shape 27 MOST INOX

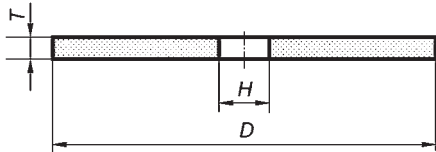


- application: stainless steel,
- top quality with the best possible price to performance ratio,
- hard grinding wheels, high stock removal rate, long service life,
- does not contain iron-sulphuric compounds ( $Fe + S + CL < 0,1\%$ ).

### Technical specification

No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 6,5 x 22	A30RBF INOX	13 300	80	10	94 21 411500
2	125 x 6,5 x 22	A30RBF INOX	12 200	80	10	94 21 412500
3	180 x 6,5 x 22	A30RBF INOX	8 500	80	10	94 21 418000
4	230 x 6,5 x 22	A30RBF INOX	6 600	80	10	94 21 423000

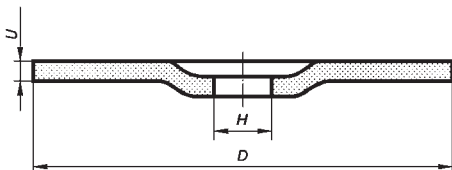
**Cutting wheels for aluminium and non-ferrous metals - Shape 41 MOST ALU**



- application: aluminium, non-ferrous metals,
- for profiles, pipes, sheets, etc.,
- soft cutting wheels, high cutting speed,
- the special composition of this wheels prevents it from clogging.

Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 3,0 x 22	A30PBF ALU	13 300	80	25	94 16 811500
2	125 x 3,0 x 22	A30PBF ALU	12 200	80	25	94 16 812500
3	180 x 3,0 x 22	A30PBF ALU	8 500	80	25	94 16 818000
4	230 x 3,0 x 22	A30PBF ALU	6 600	80	25	94 16 823000

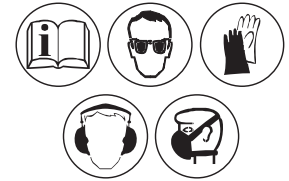
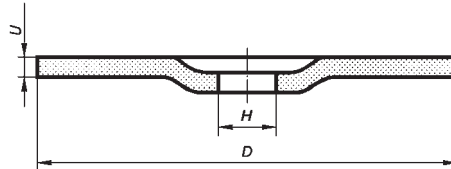
**Grinding wheels for aluminium and non-ferrous metals - Shape 27 MOST ALU**



- profiles: aluminium, non-ferrous metals,
- for surface grinding, smoothing welding seams,
- soft grinding wheels, very high removal rate, medium service life,
- the special composition of this wheels prevents it from clogging.

Technical specification						
No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	125 x 6,5 x 22	A30PBF ALU	12 200	80	10	94 21 612500
2	180 x 6,5 x 22	A30PBF ALU	8 500	80	10	94 21 618000

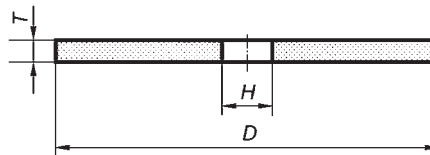
## Grinding wheels for cast iron - Shape 27 MOST FONTE



- profiles: cast iron, cast steel,
- for surface grinding, smoothing welding seams, root reinforcement removal,
- hard grinding wheels, high stock removal rate, long service life.

Technical specification						
No.	Dimension D x U x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	180 x 6,5 x 22	A24RBF FONTE	8 500	80	10	94 21 518000
2	230 x 6,5 x 22	A24RBF FONTE	6 600	80	10	94 21 523000

## Cutting wheels for stone and concrete - Shape 41 MOST PREMIUM STONE



- application: stone, concrete,
- general purpose wheels for concrete and building materials,
- hard cutting wheels, very long service life, high cutting speed.

Technical specification						
No.	Dimension D x T x H (mm)	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.
1	115 x 3,0 x 22	C30RBF PREMIUM STONE	13 300	80	25	94 16 611500
2	125 x 3,0 x 22	C30RBF PREMIUM STONE	12 200	80	25	94 16 612500
3	180 x 3,0 x 22	C30RBF PREMIUM STONE	8 500	80	25	94 16 618000
4	230 x 3,0 x 22	C30RBF PREMIUM STONE	6 600	80	25	94 16 623000

## Flap grinding wheels - shape 29 MOST FLAP FUTURA

Single disc Most Flap Futura has the effectiveness of 3-4 standard-type disc. Using just one disc saves time normally needed for exchanging worn abrasives.

New and reserved type of lam shape:

- more of active grinding grains
- incredibly effective stripping abilities
- surprising durability
- strong fibreglass base

**Application:**

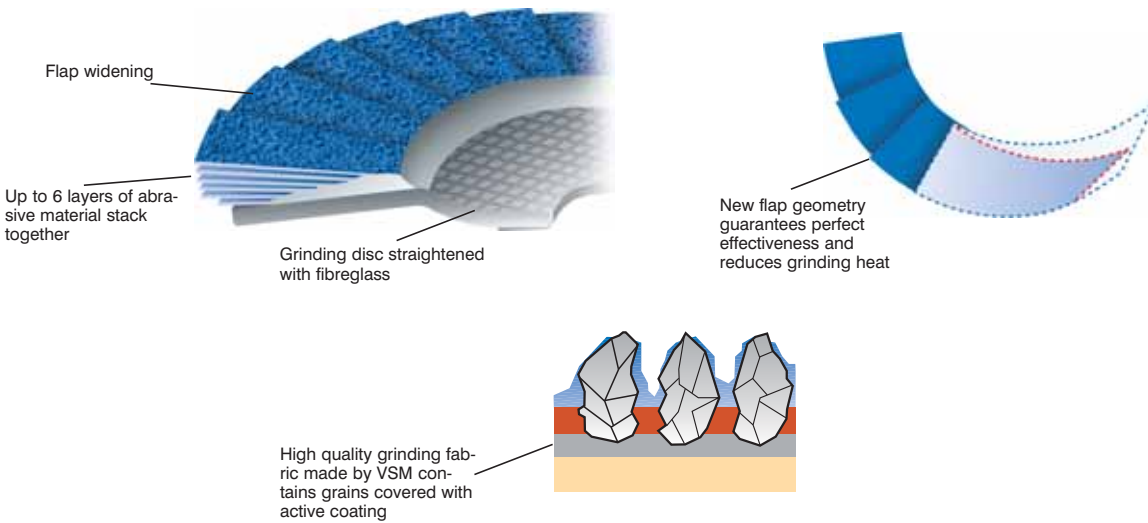
- construction steel
- stainless steel
- alloy steel
- aluminium.

**Perfect for:**

- welds processing
- evening
- cleaning.



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Technical specification						
No.	Granulation	Characteristics	Rotational speed [rpm.]	Peripheral speed [m/s]	Packet [pcs.]	Catalogue No. shape 29
FUTURA 115 x 22						
1	40	FUTURA	13 300	80	10	94 17 311504
2	60	FUTURA	13 300	80	10	94 17 311506
FUTURA 125 x 22						
5	40	FUTURA	12 200	80	10	94 17 312504
6	60	FUTURA	12 200	80	10	94 17 312506

## Flap discs for stainless and black steel grinding MOST LAM PROFESSIONAL Ceramic



- flap discs, shape 27 (N41A - fiat) and 29 (N41B - convex),
- made of corundum or zirconium grain,
- various granulations of abrasive grains enable qualitative surface treatment,
- cooler and smoother, cushioned grinding, due to open leaf design, according to the ventilation principle
- popular for processing small areas
- extended service life,
- 3 sorts available - Corundum, Zirconium and Professional.
- application: black steel, stainless steel, aluminium, flap discs with ceramic grain.



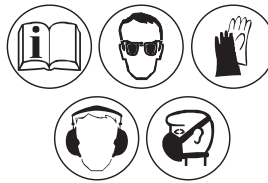
shape 29



shape 27

Technical specification							
No.	Granulation	Characteristics	Rotational speed [r.p.m.]	Peripheral speed [m/s]	Pack [pcs.]	Catalogue No.	
						shape 29	shape 27
<b>CERAMIC 115 x 22</b>							
1	40	PROFESSIONAL - CERAMIC	13 300	80	5	94 17 211504	94 17 211505
2	60	PROFESSIONAL - CERAMIC	13 300	80	5	94 17 211506	94 17 211507
3	80	PROFESSIONAL - CERAMIC	13 300	80	5	94 17 211508	94 17 211509
4	120	PROFESSIONAL - CERAMIC	13 300	80	5	94 17 211512	94 17 211513
<b>CERAMIC 125 x 22</b>							
5	40	PROFESSIONAL - CERAMIC	12 200	80	5	94 17 212504	94 17 212505
6	60	PROFESSIONAL - CERAMIC	12 200	80	5	94 17 212506	94 17 212507
7	80	PROFESSIONAL - CERAMIC	12 200	80	5	94 17 212508	94 17 212509
8	120	PROFESSIONAL - CERAMIC	12 200	80	5	94 17 212512	94 17 212513
<b>CERAMIC 180 x 22</b>							
9	40	PROFESSIONAL - CERAMIC	8 500	80	5	94 17 218504	94 17 218005
10	60	PROFESSIONAL - CERAMIC	8 500	80	5	94 17 218506	94 17 218007
11	80	PROFESSIONAL - CERAMIC	8 500	80	5	94 17 218508	94 17 218009
12	120	PROFESSIONAL - CERAMIC	8 500	80	5	94 17 218512	94 17 218013

**Flap discs for steel**  
**MOST LAM STANDARD Corundum**



shape 29

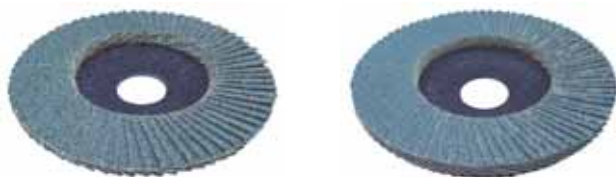
shape 27



- application: black steel,
- flap discs with corundum grain (TAF, NORTON)

Technical specification							
No.	Granulation	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.	
						shape 29	shape 27
<b>Corundum 115 x 22</b>							
1	40	STANDARD - CORUNDUM	13 300	80	5	94 18 115040	94 18 115041
2	60	STANDARD - CORUNDUM	13 300	80	5	94 18 115060	94 18 115061
3	80	STANDARD - CORUNDUM	13 300	80	5	94 18 115080	94 18 115081
4	120	STANDARD - CORUNDUM	13 300	80	5	94 18 115120	94 18 115121
<b>Corundum 125 x 22</b>							
5	40	STANDARD - CORUNDUM	12 200	80	5	94 18 125040	94 18 125041
6	60	STANDARD - CORUNDUM	12 200	80	5	94 18 125060	94 18 125061
7	80	STANDARD - CORUNDUM	12 200	80	5	94 18 125080	94 18 125081
8	120	STANDARD - CORUNDUM	12 200	80	5	94 18 125120	94 18 125121
<b>Corundum 180 x 22</b>							
9	40	STANDARD - CORUNDUM	8 500	80	5	94 18 180040	94 18 180041
10	60	STANDARD - CORUNDUM	8 500	80	5	94 18 180060	94 18 180061
11	80	STANDARD - CORUNDUM	8 500	80	5	94 18 180080	94 18 180081
12	120	STANDARD - CORUNDUM	8 500	80	5	94 18 180120	94 18 180121

**Flap discs for stainless steel and black steel**  
**MOST LAM STANDARD Zirconium**



shape 29

shape 27



- application: black steel, stainless steel,
- flap discs with zirconium grain (TAF, NORTON)

Technical specification							
No.	Granulation	Characteristics	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Packet (pcs.)	Catalogue no.	
						shape 29	shape 27
<b>Zirconium 115 x 22</b>							
1	40	STANDARD - ZIRCONIUM	13 300	80	5	94 19 115040	94 19 115041
2	60	STANDARD - ZIRCONIUM	13 300	80	5	94 19 115060	94 19 115061
3	80	STANDARD - ZIRCONIUM	13 300	80	5	94 19 115080	94 19 115081
4	120	STANDARD - ZIRCONIUM	13 300	80	5	94 18 115120	94 19 115121
<b>Zirconium 125 x 22</b>							
5	40	STANDARD - ZIRCONIUM	12 200	80	5	94 19 125040	94 19 125041
6	60	STANDARD - ZIRCONIUM	12 200	80	5	94 19 125060	94 19 125061
7	80	STANDARD - ZIRCONIUM	12 200	80	5	94 19 125080	94 19 125081
8	120	STANDARD - ZIRCONIUM	12 200	80	5	94 19 125120	94 19 125121
<b>Zirconium 180 x 22</b>							
9	40	STANDARD - ZIRCONIUM	8 500	80	5	94 19 180040	94 19 180041
10	60	STANDARD - ZIRCONIUM	8 500	80	5	94 19 180060	94 19 180061
11	80	STANDARD - ZIRCONIUM	8 500	80	5	94 19 180080	94 19 180081
12	120	STANDARD - ZIRCONIUM	8 500	80	5	94 19 180120	94 19 180121

## Flap grinding wheels for black steel MOST LAM RED LINE HEAVY-DUTY Corundum



shape 29



shape 27



- application: black steel,
- flap discs with corundum grain, (VSM, KLINGSPOR)

Technical specification							
No.	Granulation	Characteristic	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Pack [pcs.]	Catalogue no.	
						shape 29	shape 27
<b>Corundum 115 x 22</b>							
1	40	RED LINE - CORUNDUM	13 300	80	5		
2	60	RED LINE - CORUNDUM	13 300	80	5		
3	80	RED LINE - CORUNDUM	13 300	80	5		
4	120	RED LINE - CORUNDUM	13 300	80	5		
<b>Corundum 125 x 22</b>							
5	40	RED LINE - CORUNDUM	12 200	80	5		
6	60	RED LINE - CORUNDUM	12 200	80	5		
7	80	RED LINE - CORUNDUM	12 200	80	5		
8	120	RED LINE - CORUNDUM	12 200	80	5		
<b>Corundum 180 x 22</b>							
9	40	RED LINE - CORUNDUM	8 500	80	5		
10	60	RED LINE - CORUNDUM	8 500	80	5		
11	80	RED LINE - CORUNDUM	8 500	80	5		
12	120	RED LINE - CORUNDUM	8 500	80	5		

## Flap grinding wheels for stainless steel and black steel MOST LAM RED LINE HEAVY-DUTY Zirconium



shape 29



shape 27

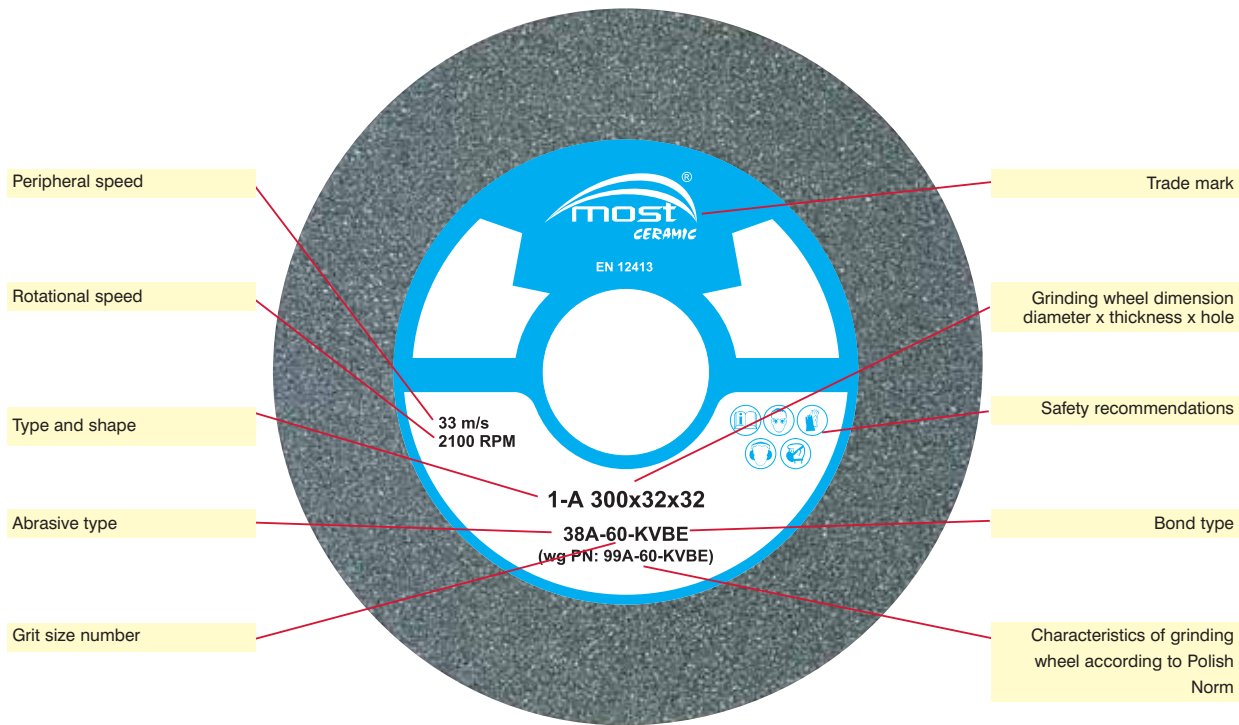


- application: black steel,
- flap discs with zirconium grain, (VSM, KLINGSPOR)

Technical specification							
No.	Granulation	Characteristic	Rotational speed (r.p.m.)	Peripheral speed (m/s)	Pack [pcs.]	Catalogue no.	
						shape 29	shape 27
<b>Zirconium 115 x 22</b>							
1	40	RED LINE - ZIRCONIUM	13 300	80	5		
2	60	RED LINE - ZIRCONIUM	13 300	80	5		
3	80	RED LINE - ZIRCONIUM	13 300	80	5		
4	120	RED LINE - ZIRCONIUM	13 300	80	5		
<b>Zirconium 125 x 22</b>							
5	40	RED LINE - ZIRCONIUM	12 200	80	5		
6	60	RED LINE - ZIRCONIUM	12 200	80	5		
7	80	RED LINE - ZIRCONIUM	12 200	80	5		
8	120	RED LINE - ZIRCONIUM	12 200	80	5		
<b>Zirconium 180 x 22</b>							
9	40	RED LINE - ZIRCONIUM	8 500	80	5		
10	60	RED LINE - ZIRCONIUM	8 500	80	5		
11	80	RED LINE - ZIRCONIUM	8 500	80	5		
12	120	RED LINE - ZIRCONIUM	8 500	80	5		

## 2. ABRASIVE TOOLS WITH VITRIFIED BONDS

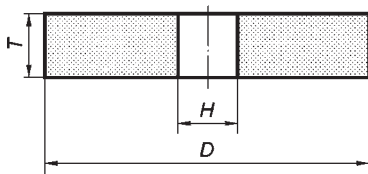
### Markings of bond abrasive tools



GRIT SIZE NUMBER		
thick	medium	fine
8	30	70
10	36	80
12	40	90
14	46	100
16	54	120
20	60	150
24		180

SIGNATURE	
According to norton	According to PN-84/m-59100
A - brown aluminium oxide 38	95A
A - white aluminium oxide 37	99A
C - black silicon carbide	98C

BOND TYPE	
V	V, VBE, VK
B	B3, B7H



No.	Dimension D x T x H [mm]	Characteristics	Rotational speed [r.p.m.]	Peripheral speed [m/s]	Catalogue No.
Shape 1 type A – brown aluminium oxide					
1	150 x 20 x 20	A60KVBE	4 200	33	92 20 152000
2	200 x 20 x 32	A60KVBE	3 150	33	92 20 202000
3	200 x 25 x 32	A60KVBE	3 150	33	92 20 202500
4	250 x 25 x 32	A60KVBE	2 500	33	92 20 252500
5	300 x 32 x 32	A60KVBE	2 100	33	92 20 303200
Shape 1 type 38 A – white aluminium oxide					
6	150 x 20 x 20	38A60KVBE	4 200	33	92 20 152001
7	200 x 20 x 32	38A60KVBE	3 150	33	92 20 202001
8	200 x 25 x 32	38A60KVBE	3 150	33	92 20 202501
9	250 x 25 x 32	38A60KVBE	2 500	33	92 20 252501
10	300 x 32 x 32	38A60KVBE	2 100	33	92 20 303201
Shape 1 type 37 C – black silicone carbide					
11	150 x 20 x 20	37C60KVK	4 200	33	92 20 152002
12	200 x 20 x 32	37C60KVK	3 150	33	92 20 202002
13	200 x 25 x 32	37C60KVK	3 150	33	92 20 202502
14	250 x 25 x 32	37C60KVK	2 500	33	92 20 252502
15	300 x 32 x 32	37C60KVK	2 100	33	92 20 303202

### 3. TECHNICAL BRUSHES

#### Wheel brushes with 6 mm shank, crimped wire

#### Wheel brushes with 6 mm shank, knotted wire



■ They are perfectly suitable for working with drills and grinders with flexible shaft. Small diameters of brushes enable cleaning and treatment of different to access elements; for removal of rust, varnishes, paint coatings; preparing surfaces for painting. Acid resistant wire, applied in brushes, is designed to clean materials made of acid resistant or stainless steels, whereas brass wire most frequently is used for polishing works with purpose of gaining suitable surface texture.

No.	Name	Catalogue no.		
		steel	inox	brass
<b>Wheel brushes with 6 mm shank, crimped wire</b>				
1	Wheel brushes $\varnothing$ 40	93 33 170400	93 33 170401	93 33 170402
2	Wheel brushes $\varnothing$ 50	93 33 170500	93 33 170501	93 33 170502
3	Wheel brushes $\varnothing$ 60	93 33 170600	93 33 170601	93 33 170602
4	Wheel brushes $\varnothing$ 70	93 33 170700	93 33 170701	93 33 170702
5	Wheel brushes $\varnothing$ 80	93 33 170800	93 33 170801	93 33 170802
6	Wheel brushes $\varnothing$ 90	93 33 170900	93 33 170901	93 33 170902
7	Wheel brushes $\varnothing$ 100	93 33 171000	93 33 171001	93 33 171002
8	Wheel brushes $\varnothing$ 110	93 33 171100	93 33 171101	93 33 171102
9	Wheel brushes $\varnothing$ 120	93 33 171200	93 33 171201	93 33 171202
10	Wheel brushes $\varnothing$ 130	93 33 171300	93 33 171301	93 33 171302
11	Wheel brushes $\varnothing$ 140	93 33 171400	93 33 171401	93 33 171402
12	Wheel brushes $\varnothing$ 150	93 33 171500	93 33 171501	93 33 171502
<b>Wheel brushes with 6 mm shank, knotted wire</b>				
1	Wheel brushes $\varnothing$ 80	93 33 170803	93 33 170804	93 33 170805
2	Wheel brushes $\varnothing$ 100	93 33 171003	93 33 171004	93 33 171005
3	Wheel brushes $\varnothing$ 125	93 33 171253	93 33 171254	93 33 171255

#### Wheel brushes with arbor hole, crimped wire



■ Wheel brushes with arbor hole are applied to clean elements which have uneven, formed surfaces. The shape and fitting appropriate diameter of a brush (small diameters) allows working in places difficult to access. Wheel brushes are designed for removal of light corrosive impurities, edges bevelling, trimming, etc. They can be used in stationary grinders. Brushes of acid resistant wire are suitable to clean elements made of acid resistant steels, whereas brushes of brass wire are designed for polishing with purpose of gaining suitable surface texture.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Wheel brush $\varnothing$ 80 x 22	93 33 120800	93 33 120801	93 33 120802
2	Wheel brush $\varnothing$ 100 x 22	93 33 121000	93 33 121001	93 33 121002
3	Wheel brush $\varnothing$ 120 x 22	93 33 121200	93 33 121201	93 33 121202
4	Wheel brush $\varnothing$ 140 x 22	93 33 121400	93 33 121401	93 33 121402
5	Wheel brush $\varnothing$ 150 x 22	93 33 121500	93 33 121501	93 33 121502
6	Wheel brush $\varnothing$ 150 x 32	93 33 151500	93 33 151501	93 33 151502
7	Wheel brush $\varnothing$ 180 x 22	93 33 121800	93 33 121801	93 33 121802
8	Wheel brush $\varnothing$ 200 x 22	93 33 122000	93 33 122001	93 33 122002
9	Wheel brush $\varnothing$ 200 x 32	93 33 152000	93 33 152001	93 33 152002
10	Wheel brush $\varnothing$ 250 x 32	93 33 152500	93 33 152501	93 33 152502
11	Wheel brush $\varnothing$ 250 x 53	93 33 162500	93 33 162501	93 33 162502
12	Wheel brush $\varnothing$ 280 x 32	93 33 152800	93 33 152801	93 33 152802
13	Wheel brush $\varnothing$ 300 x 32	93 33 153000	93 33 153001	93 33 153002

### Wheel brushes with arbor hole, knotted wire

■ For their construction they are perfectly suitable for rough removal of welds, welding scales, corrosive tarnishes, old paints, varnishes, enamel coatings, etc. Shape of knots makes the brushes very wear-resistant. They are applied in stationary and angular grinders with following safety rules regarding rotational speed limit. Brushes of acid resistant wire are fit for cleaning elements made of stainless steel. For construction of knotted wheel brushes with arbor hole brass wire is not applied.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Wheel brush ø 115 x 22	93 33 121153	93 33 121154	-
2	Wheel brush ø 125 x 22	93 33 121253	93 33 121254	-
3	Wheel brush ø 150 x 22	93 33 121503	93 33 121504	-
4	Wheel brush ø 150 x 32	93 33 151503	93 33 151504	-
5	Wheel brush ø 180 x 22	93 33 121803	93 33 121804	-
6	Wheel brush ø 180 x 32	93 33 151803	93 33 151804	-
7	Wheel brush ø 200 x 22	93 33 122003	93 33 122004	-
8	Wheel brush ø 200 x 32	93 33 152003	93 33 152004	-
9	Wheel brush ø 180 x 32	93 33 151806	93 33 151807	-



### Wheel brushes with thread, crimped wire

■ Wheel brushes with thread are applied to clean elements which have uneven, formed surfaces. Shape of brushes allows brushing in places difficult to access. Wheel brushes are designed for removal of any corrosive impurities and preparing surfaces for painting. Brushes of acid resistant wire are applied in cleaning elements made of acid resistant steel, whereas brushes of brass wire are suitable for polishing with purpose of gaining suitable surface texture.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Wheel brush ø 100 x M14	93 33 181000	93 33 181001	93 33 181002
2	Wheel brush ø 110 x M14	93 33 181100	93 33 181101	93 33 181102
3	Wheel brush ø 120 x M14	93 33 181200	93 33 181201	93 33 181202



### Wheel brushes with thread, knotted wire

■ Knotted wheel brushes with thread are applied to clean elements which have uneven, formed surfaces. Shape of brushes allows brushing in places difficult to access. Knotted wheel brushes are suitable for removal of hard rough impurities, such as welds, welding scales, old paints and varnishes, etc. They are designed for working in angular grinders. Brushes of acid resistant wire are applied in cleaning elements made of stainless steel. For construction of wheel brushes with thread brass wire is not applied.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Wheel brush ø 100 x M14	93 33 181003	93 33 181004	-
2	Wheel brush ø 125 x M14	93 33 181253	93 33 181254	-
3	Wheel brush ø 150 x M14	93 33 181503	93 33 181504	-
4	Wheel brush ø 180 x M14	93 33 181803	93 33 181804	-



### Cup brushes with 6 mm shank, crimped wire and knotted wire



■ Cup brushes are applied in any works regarding cleaning of machine elements, metal bodies, removal of rust, trim, old varnish and paint surfaces. Small diameters of brushes allow working in places difficult to access (e.g. open sections), whereas bigger diameters of brushes enable cleaning of large surfaces. Acid resistant wire, applied in brushes, is designed for cleaning materials made of acid resistant or stainless steels, while brass wire is most frequently used for polishing works aiming at gaining appropriate surface texture.

No.	Name	Catalogue No.		
		steel	inox	brass
<b>Cup brushes with 6 mm shank, crimped wire</b>				
1	Cup brush ø 50	93 33 270500	93 33 270501	93 33 270502
2	Cup brush ø 60	93 33 270600	93 33 270601	93 33 270602
3	Cup brush ø 70	93 33 270700	93 33 270701	93 33 270702
4	Cup brush ø 80	93 33 270800	93 33 270801	93 33 270802
5	Cup brush ø 90	93 33 270900	93 33 270901	93 33 270902
6	Cup brush ø 100	93 33 271000	93 33 271001	93 33 271002
<b>Cup brushes with 6 mm shank, knotted wire</b>				
1	Cup brush ø 75	93 33 270753	93 33 270754	93 33 270755

### Cup brushes with thread, crimped wire



■ Due to their specific construction and shaping of working part are applied to clean large and flat surfaces. They are perfectly suitable for removal of corrosive tarnishes, old paint and varnish coatings. They prove to be efficient in preparing of flat surfaces for painting, e.g. outside parts of machines, bodies, etc. They are designed for working in angle grinders. Small diameters of brushes allow working at high rotational speeds. Brushes made of acid resistant wire are fit for cleaning elements of acid resistant steels, while brushes of brass wire are suitable for polishing works.

No.	Name	Catalogue No.		
		steel	inox	brass
1	Cup brush ø 70 x M14	93 33 280700	93 33 280701	93 33 280702
2	Cup brush ø 80 x M14	93 33 280800	93 33 280801	93 33 280802
3	Cup brush ø 100 x M14	93 33 281000	93 33 281001	93 33 281002

### Cup brushes with thread, knotted wire



■ Cup brushes are designed for cleaning of large surfaces. For specific kind of filling in the form of knots of steel or acid resistant wire with a section diameter of ø 0,5 [mm] they are applied to remove hard rough impurities, such as removal of welding scales, cleaning of welds, trimming, etc. This group of brushes is designed for working in angle grinders for possibility to use of high rotational speeds. Brushes made of acid resistant wire are fit for cleaning elements of stainless steel. For construction of cup brushes brass wire is not applied.

No.	Name	Catalogue No.		
		steel	inox	brass
1	Cup brush ø 70 x M14	93 33 280753	93 33 280754	–
2	Cup brush ø 80 x M14	93 33 280803	93 33 280804	–
3	Cup brush ø 100 x M14	93 33 281003	93 33 281004	–

### Bevel brushes with thread, crimped wire

■ Bevel brushes with thread are applied to clean elements of uneven, formed surfaces. Shape of brushes allows cleaning in places difficult to access, inside edges of elements, parts of machines, bodies, etc. Bevel brushes are designed for working in angle grinders. Brushes made of acid resistant wire are fit for cleaning elements of acid resistant steel, whereas brushes of brass wire are used for polishing works with the purpose of gaining appropriate surface texture.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Bevel brush ø 105 x M14	93 33 481050	93 33 481051	93 33 481052
2	Bevel brush ø 120 x M14	93 33 481200	93 33 481201	93 33 481202



### Bevel brushes with thread, knotted wire

■ Bevel knotted brushes with thread are applied to clean elements of uneven, formed surfaces. Shape of brushes allows cleaning in places difficult to access. Bevel brushes are suitable to remove hard rough impurities, such as welds, welding scales, old paints, varnishes, etc. Bevel brushes with thread are useful for working in angle grinders. Brushes made of acid resistant wire are suitable to clean elements of stainless steel. For construction of bevel brushes with thread brass wire is not applied.

No.	Name	Catalogue no.		
		steel	inox	brass
1	Bevel brush ø 100 x M14	93 33 481003	93 33 481004	-
2	Bevel brush ø 115 x M14	93 33 481153	93 33 481154	-
3	Bevel brush ø 125 x M14	93 33 481253	93 33 481254	-



### End brushes with 6 mm, crimped wire

■ Irreplaceable in case of cleaning of any kind of impurities in places difficult to access: holes, hollows, open section and inside parts of cleaned elements. They are used in drills and grinders with flexible shafts. In particular, end brushes are characterized by work at high rotational speeds, which combined with specifics of knotted end brush enables cleaning of hard impurities: excess metals, trims, welding scales.

No.	Name	Catalogue no.		
		steel	inox	brass
1	End brush ø 12	93 33 370120	93 33 370121	93 33 370122
2	End brush ø 20	93 33 370200	93 33 370201	93 33 370202
3	End brush ø 25	93 33 370250	93 33 370251	93 33 370252



## Hand brushes, straight or crimped wire

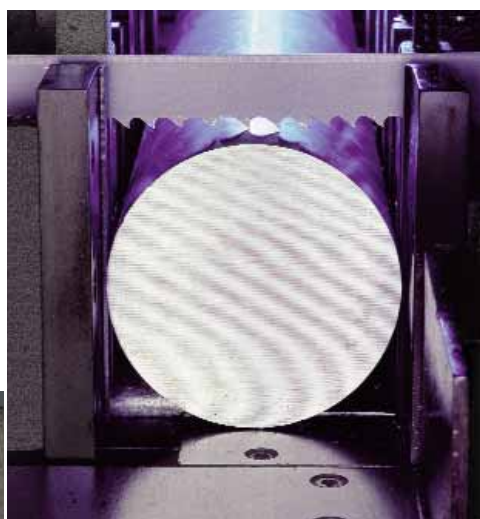
■ Hand brushes are designed for hand works. Brushes in wooden mounting are applied to clean various sorts of surfaces from light impurities, e.g. before painting. Brushes in metal mounting are used for removal of harder impurities, such as trimming or removal of scales. Hand brushes are applied in case of limited access of rotational brushes. Brushes made of acid resistant wire are suitable to clean elements of acid resistant steel, whereas brushes of brass wire are used for polishing works with the purpose of gaining appropriate surface texture.



No.	Name	Catalogue no.		
		steel	inox	brass
1	1-row hand brush	93 33 000010	93 33 000011	93 33 000012
2	2-row hand brush	93 33 000020	93 33 000021	93 33 000022
3	3-row hand brush	93 33 000030	93 33 000031	93 33 000032
4	4-row hand brush	93 33 000040	93 33 000041	93 33 000042
5	5-row hand brush	93 33 000050	93 33 000051	93 33 000052
6	6-row hand brush	93 33 000060	93 33 000061	93 33 000062

# VII

## SUPPORTING EQUIPMENT



### Contents

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## 1. BAND SAWS

Light sawing machines for workshops

UE-120 SV  
UE-712 C  
WE-210 SH



WE-210 SH



UE-120 SV



UE-712 C

UE-120 SV Technical specification

[mm]	[Volt/Hz]	[kW]				[kg]
			0°	45°		
1550x13x0,6	230/50-60	0,75	120	90	20	

UE-712 C Technical specification

[mm]	[kW]	[m/min]	[kW]	[m/min]				[kg]
					0°	45°		
2360x19x0,9	0,75	22/33 45/65	0,75	22/33 45/65	178	110	178x280 180x110	130

WE-210 SH Technical specification

[mm]	[kW]	[m/min]				[kg]
			0°	45°	60°	
2110x20x0,9	0,75	40/80	170	120	70	210x70 156

Semi automatic saws with hydraulic brake

WE-260 SH  
WE-270 DS



WE-260 SH



WE-270 DS

WE-260 SH Technical specification							
[mm]	[kW]	[m/min]		[mm]	[mm]	[mm]	[kg]
2460x27x0,9	1,1	32/72	0°	227	220	260x110	216
			45°	150	145	200x125	
			60°	90	85	-	

WE-270 DS Technical specification							
[mm]	[kW]	[m/min]		[mm]	[mm]	[mm]	[kg]
2460x27x0,9	1,1	36/72	0°	227	220	260x110	280
			45°	150	145	200x125	
			60°	90	85	-	
			45°	110	110	160x110	

## Semi automatic saws with hydraulic break

WE-310 DS  
WE-350 DS










WE-310 DS










WE-350 DS

WE-310 DS Technical specification

							
				[mm]	[mm]	[mm]	[kg]
2725x27x0,9	1,1	36/72	0°	250	240	310x210	310
			45°	200	180	200x140	
			60°	120	120	120x95	
			45°	150	150	170x90	

WE-350 DS Technical specification

							
				[mm]	[mm]	[mm]	[kg]
3160x27x0,9	1,5	34/68	0°	270	260	350x220	360
			45°	240	220	240x160	
			60°	160	150	-	
			45°	210	180	-	

Semi automatic hydraulic saws

UE-331 DSA  
UE-460 DSA

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WE-331 DSA



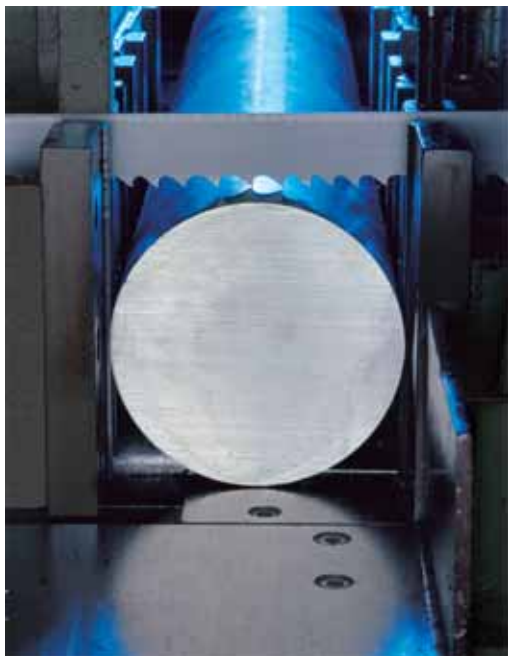
WE-460 DSA

UE-331 DSA Technical specification							
[mm]	[kW]	[m/min]		[mm]	[mm]	[mm]	[kg]
4180x34x1,1	2,2	26-80	0°	331	320	510x260	850
			45°	315	315	-	
			60°	215	195	-	
			45°	315	315	-	

UE-460 DSA Technical specification							
[mm]	[kW]	[m/min]		[mm]	[mm]	[mm]	[kg]
5330x41x1,3	3,7	26-80	0°	460	460	600x440	1320
			45°	460	460	-	
			60°	330	330	-	
			45°	460	460	-	

## 2. ACCESORIES FOR BAND SAWS

### 2.1 Highly efficient bimetal band saw MOST Multicat



Universal and perfect for cutting carbon steel, stainless steel, alloy steel, tool steel etc.

- teeth tops made of high-speed steel M42 guarantee a long-term durability
- special shape of teeth prevents their tops from being teared off.
- shape of the space between teeth provides precise cutting
- accurate teeth positioning guarantees perfectly even surface after cutting
- the main body made of carefully selected, high quality steel provides the best quality and guarantees longevity.

Width x thickness [mm]	Available types of pitch							
	Pitch (teeth per inch)							
	2/3	3/4	4/6	5/8	6/8	6/10	8/12	10/14
13 x 0,6						•	•	•
19 x 0,9			•	•	•	•	•	•
27 x 0,9	•	•	•	•	•	•	•	•
34 x 1,1	•	•	•	•	•	•	•	
41 x 1,3	•	•	•	•				
54 x 1,3	•	•	•					
54 x 1,6	•	•	•					

### 2.2 Cooling liquid COOLMAX

**MOST COOLMAX** is semisynthetic metalworking fluid concentrate. It does not cause the nitrosoamines formation. It is made with highly refined mineral oils. The product does not contain chlorine, secondary amines, sodium nitride, PCB and heavy metals. The concentrate is practically sulfur-free.

**MOST COOLMAX** fluid concentrate is formulated for wide range of metalworking operation (turning, milling, drilling, threading, grinding and others) and for wide range of materials machined (cast iron, steel including alloy steel, and yellow metals).

Emulsions made with **MOST COOLMAX** concentrate are stable and do not form deposits or separate thick phase even after long period of using. In many cases (if the proper and stable concentration is kept and with using of filtering system excluding high contamination of emulsion) even two years change period is possible. Emulsions at proper concentration give good surface smoothness and high durability of instrument. Emulsions do not perform the foaming tendency.



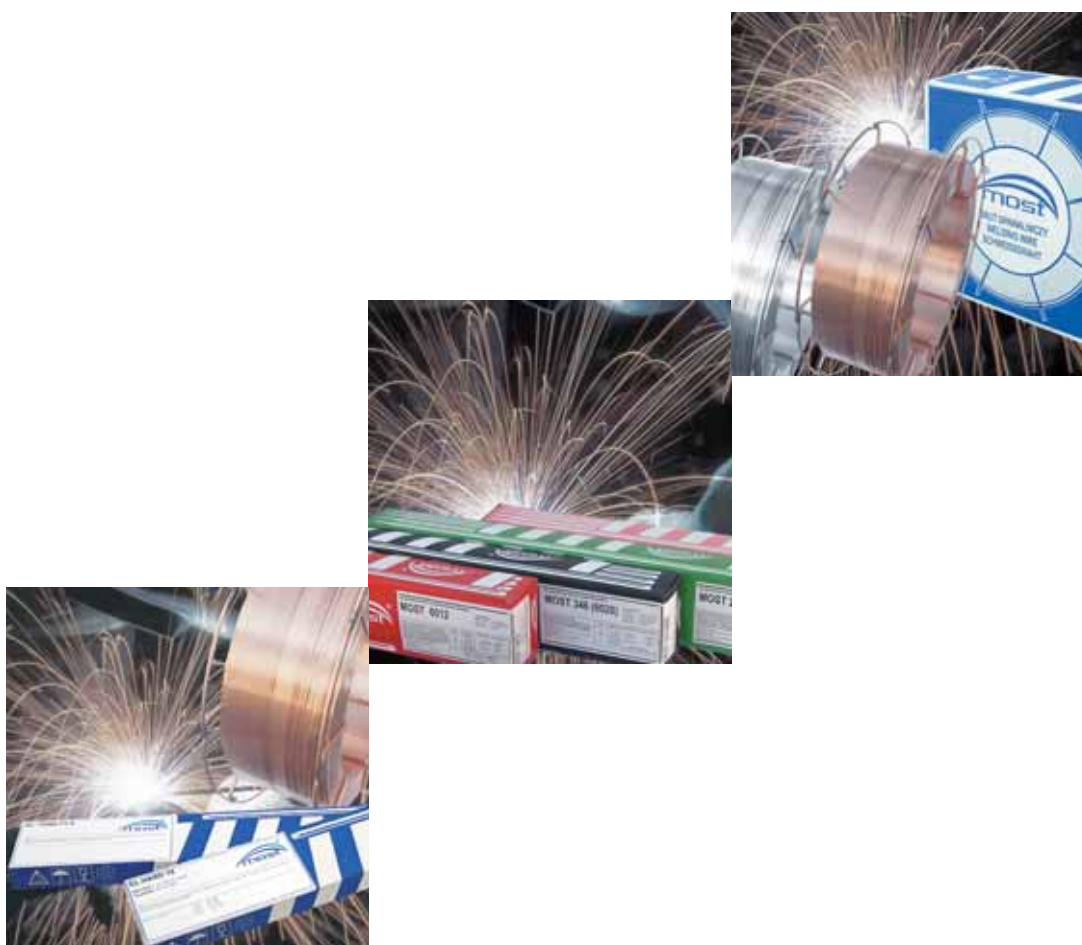
Properties	Test method	Unit	MOST COOLMAX
Color	-	-	Brown
Aspect	-	-	Clear fluid
Density@ 20°C	PN-C-04004	g/cm <sup>3</sup>	1,0
The viscosity@ 40°C	PN-C-04011	mm <sup>2</sup> /s	305
The mineral oil content	-	%	35

#### Packages and catalogue number

Drum 205l – 94 53 99 9205  
 Canister 20l – 94 53 99 9020  
 Canister 5l – 94 53 99 9005  
 Canister 1l – 94 53 99 9001

Another package according the agreement with customer

# VIII WELDING CONSUMABLES




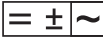


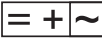



	Contents
1. Coated electrodes for manual welding	95
2. Wires and rods for MIG/MAG and TIG welding	103
3. Flux cored wires for arc welding	113
4. Other welding consumables	115























There are many abbreviations and symbols used in the chapter:

Abbr.	Explanation	Abbr.	Explanation
ABS	American Bureau of Shipping	KV	impact resistance, ISO V-notch
AC	alternating current	LR	Lloyds Register of Shipping
AWS	American Welding Society	MAG	metal active gas welding
A <sub>4</sub> , A <sub>5</sub>	unit elongation	MIG	metal inert gas welding
BV	Bureau Veritas	O.C.	heat treatment
CO	Controlas	R <sub>e</sub>	yield point
DB	Deutsche Bahn	R <sub>m</sub>	tensile strength
DC	direct current	RS	Russian Sea Register of Shipping
DNV	Det Norske Veritas	TIG	tungsten inert gas welding
FN	ferrite number	TÜV (-D)	Technischer Überwachungs Verein
GL	Germanischer Lloyd	TÜV (-Ö)	Technischer Überwachungs Verein – Austria
HB	Brinell hardness number	UDT	Office of Technical Inspection
HV	Vickers hardness number	Ü	Übereinstimmungszertifikat
HRC	Rockwell hardness number		

**Tabela 1.** Abbreviations and symbols

Symbol	Welding current and polarity	Symbol	Welding current and polarity
	direct – plus side to the electrode		direct – minus side to the electrode or alternating
	direct – minus side to the electrode		direct or alternating
	alternating		alternating or direct – plus side to the electrode
	direct – plus side to the electrode or alternating		alternating or direct – minus side to the electrode

**Table 2.** Symbols of welding currents and polarity

Symbol	Welding position	Symbol	Welding position
	all positions		all positions, except vertical up and vertical down
	all vertical down positions only fillet weld		downhand, horizontal and vertical up
	all positions, except vertical down		horizontal
	downhand, horizontal, vertical and vertical up		downhand, horizontal and vertical down
	downhand, horizontal		downhand, horizontal, vertical and overhead
	downhand		downhand, vertical and vertical down
	vertical down		downhand, vertical, overhead and vertical up
	downhand, horizontal, and vertical		downhand, flat, vertical and vertical down
	vertical up and vertical down		all positions, except vertical up
	vertical up		downhand and vertical
	all positions, except overhead		downhand, vertical and vertical up

**Table 3.** Symbols of welding positions



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