



MAKE WORK  
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**INTELLIGENT**  
TORCH SOLUTIONS

ARC X SERIES



# A Passion for Technology & Innovation

To produce hand tools that reach the pinnacle of performance, durability and functionality you have to be passionate about what you do.

At Arc Torchology the research and development department is the beating heart of our company.

Every single component is conceived, developed, manufactured and tested in-house.

Our development and testing activities are loaded with cutting edge technologies, many of which have been developed specifically by us to meet the very stringent demands we place on our design solutions.

These specialized, bespoke solutions allow us to develop products that surpass the prerequisite of industry standards, inventing increasingly more beneficial products that deliver maximum results for the operator.

**This is not business as usual.**

FEATURING NEW TECHNOLOGIES



find out more [arctorchology.com](http://arctorchology.com)

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# The No - Compromise Solution to Welding Fume

## What is **Welding Fume?**

Welding fume is generated when metals are heated to high temperatures.

Its hazardous composition varies by metal and welding process, containing a range of dangerous substances including:

**Metals** such as iron, manganese, nickel, chromium, aluminium

**Gases** such as carbon monoxide, ozone, nitrogen oxides

**Particulates** such as metal oxides, silica, fluorides

Welding fume is increasingly being recognised as a serious health hazard both to the welder and those working nearby.

It is essential to protect workers from the short and long-term risks.

## **The Dangers**

Classified as carcinogenic to humans, welding fume poses both immediate (irritation, breathlessness, metal fume fever) and severe long-term health risks (cancer, COPD, other lung conditions) to welders from inhalation.

## **Prevention**

Efficient, multi-layered extraction methods are crucial in protecting welder's health.

Local Exhaust Ventilation (LEV) at the source, including the use of fume extraction welding torches, is highly effective at capturing harmful fumes directly at the welding arc.

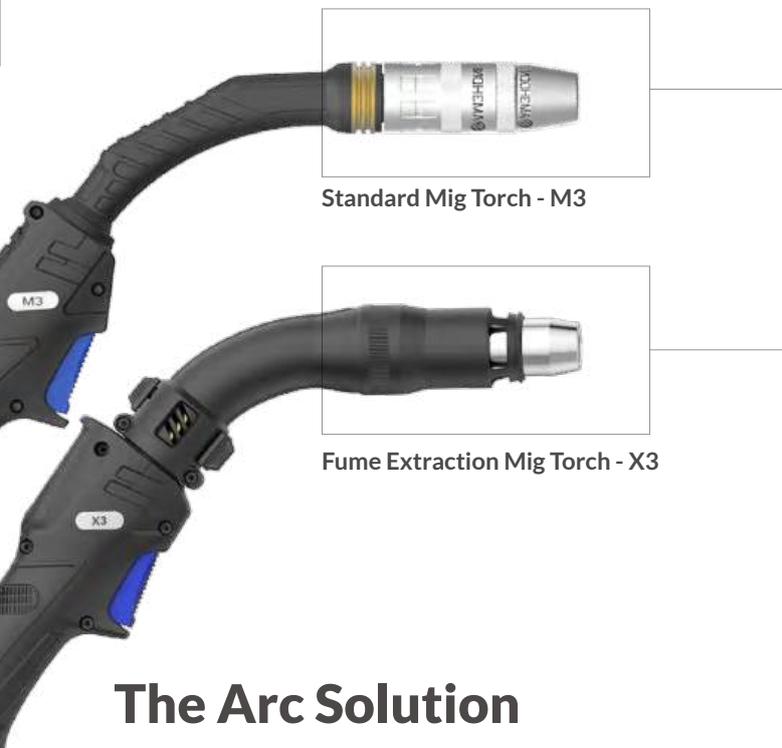
## The Problem

While extraction at the source is one of the most effective methods for mitigating the dangers of welding fume, welders have traditionally faced challenges with fume extraction torches.

Their bulkiness, awkwardness, and discomfort often cause fatigue and reduced control, creating a barrier to use.



**Arc Torchology** has changed that.

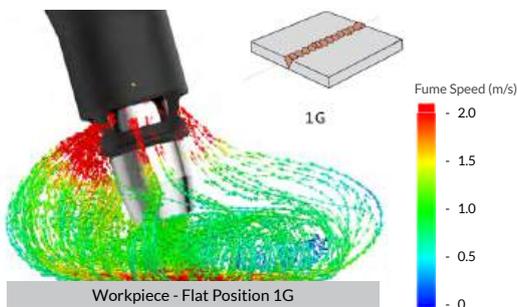


## Our Goal?

To replace a standard torch with a fume extraction torch **without compromising on performance or handling for the welder.**

## The Arc Solution

There is no need to sacrifice comfort, control or the quality of the weld in order to maintain a safe workplace.



Arc design solutions minimize the impact of fume extraction on the weld pool, effectively reducing turbulence whilst optimizing performance.

With Arc Torchology, there is no trade off between safety and performance – fume extraction torches provide both. Welders can achieve optimal weld quality while safeguarding their health.

# Key Features



## Unobstructed Visibility

Nozzles enable effective extraction from any angle without obstructing the view or access.



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Twist the nozzle and the spatter falls off

Prioritising both welder safety and weld quality, the Arc X Series delivers quantifiable benefits that extend beyond health protection, including enhanced productivity and reduced operational inefficiencies.



## Easy Airflow Adjustment

The slider is conveniently positioned for easy access, no matter how you hold the torch. It is designed to prevent fume and smoke residue from affecting performance and to minimize the buildup of fume particles.



With Fume Extraction

Without Fume Extraction

## High Performance Welds

Consistent, uniform suction across an expanded extraction area, coupled with optimized nozzle geometry, minimizes shielding gas turbulence, preserving weld quality.



## Reduced Welder Fatigue

Balanced weight distribution means less wrist strain and better control for all-day welder comfort, whatever the position.

Optimized grip comfort for reduced physical strain.

## High Durability Consumables

### Longevity

- Contact tips last up to **6 times** longer
- Nozzles last up to **3 times** longer
- Tip adaptors last up to **5 times** longer



## Light and Manoeuvrable

A lightweight cable and hose system combined with a knuckle joint and support eliminates the feeling of “dragging” the cable.

Extraction channels are designed for minimal weight and bulk.

## Plus Simplified Maintenance

- Easy disassembly and cleaning
- Easily remove and clean whilst sucking fume deposits away using the fume extraction unit



Maintenance Guide



# AIR-COOLED

## Arc Fume Series



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### TECHNICAL SPECIFICATIONS

Kilowattage (KW) represents the total power required for a welding application.

It can be linked with the published KW ratings of the ARC series torches for a more reliable method of checking the ratings of a torch for a given application.

$$\frac{\text{Welding Amperage} \times \text{Welding Voltage}}{1000} = \text{KW}$$

#### X1 IEC/EN 60974-7 ISO21904-1

Cooling Method	Air-Cooled	Max Load	
Rating:	CO <sub>2</sub>	180A	4.5KW
	Mixed Gas M21	150A	3.0KW
Duty Cycle	60%		
Wire Size	0.6-1.0mm		
Volume Flow Rate	Fume Nozzle	41 m <sup>3</sup> /h	
	Connector	50.9 m <sup>3</sup> /h	
Pressure Drop	5.26 kPa		
Shielding Gas Flow Rate	10-13 l/min		
Efficiency	93%		



#### X2 IEC/EN 60974-7 ISO21904-1

Cooling Method	Air-Cooled	Max Load	
Rating:	CO <sub>2</sub>	250A	8.0KW
	Mixed Gas M21	220A	6.0KW
Duty Cycle	60%		
Wire Size	0.8-1.2mm		
Volume Flow Rate	Fume Nozzle	48 m <sup>3</sup> /h	
	Connector	56.0 m <sup>3</sup> /h	
Pressure Drop	6.03 kPa		
Shielding Gas Flow Rate	10-15 l/min		
Efficiency	93%		



# LIQUID-COOLED

## Arc Fume Series



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### X3 IEC/EN 60974-7 ISO21904-1

Cooling Method		Air-Cooled	Max Load
Rating:	CO <sub>2</sub>	300A	11.3KW
	Mixed Gas M21	270A	8.9KW
Duty Cycle		60%	
Wire Size		0.9-1.2mm	
Volume Flow Rate	Fume Nozzle	52 m <sup>3</sup> /h	
	Connector	65 m <sup>3</sup> /h	
Pressure Drop		6.2 kPa	
Shielding Gas Flow Rate		16-18 l/min	
Efficiency		93%	



### X5W IEC/EN 60974-7 ISO21904-1

Cooling Method		Liquid-Cooled			
		Cooler Rating	Max. A	Pulse	Max. Load
Rating: CO <sub>2</sub>		1000W	500A	-	20.0KW
Rating: Mixed Gas M21		1000W	450A	300A	17.1KW
Duty Cycle		100%	100%		
Wire Size	Filler Wires	Fe, Fe-MC / FC		0.9-1.6mm	
	Filler Wires	Ss, Ss-MC / FC		0.9-1.6mm	
	Filler Wires			1.0-1.6mm	
Volume Flow Rate	Fume Nozzle	52 m <sup>3</sup> /h			
	Connector	66 m <sup>3</sup> /h			
Pressure Drop		10 kPa			
Shielding Gas Flow Rate		16-22 l/min			
Efficiency		93%			
Minimum Liquid Flow Rate		1.5 l/min	<b>Important:</b> Please note minimum inlet pressure and flow rate. Low pressure will affect torch performance		
Minimum Liquid Inlet Pressure		2.5 Bar			
Maximum Liquid Inlet Pressure		5.0 Bar			
Maximum Liquid Inlet Temperature		50°C			
Operating Temperature Range		-10...+40°C			



The design, manufacturing and quality systems of Arc Torchology are certified by **BVQI** in accordance with EN/ISO 9001:2015

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# X1 Air-Cooled X Industrial Mig Fume Torch

Ratings:	180A CO <sub>2</sub> , 150A mixed gas M21, EN60974-7 @ 60% duty cycle. 0.6mm-1.0mm wire
Technical specification:	Shielding Gas Flow Rate: 10-13 l/min Extraction Volume Rate at Nozzle: 41 m <sup>3</sup> /h



The Arc X1 is designed for semi-industrial settings with a 180A duty cycle. It effectively captures fumes at the source, minimizing dispersion and ensuring cleaner air.

## ARC X INDUSTRIAL MIG FUME TORCH PACKAGES

Arc X1 Torches are supplied with a front leather cover and Euro termination as standard and are supplied 'ready to weld' with all wear parts fitted.



	3mt	4mt	5mt
Fume X Torch c/w Front Leather	X1-3M	X1-4M	X1-5M
Fume X Torch c/w Front Leather, Air Flow and Gas Flow Meter	X1-3M-FM	X1-4M-FM	X1-5M-FM
Fume X Torch Full Leather	X1-3M-LE	X1-4M-LE	X1-5M-LE
Fume X Torch Full Leather c/w Air Flow and Gas Flow Meter	X1-3M-LE-FM	X1-4M-LE-FM	X1-5M-LE-FM

## Wear Parts

### A Fume Nozzles

Part Number	Description	Bore	Wall	Material
AX1FN	Fume Nozzle	18.4mm	1mm	Aluminium

### B Nozzles

Part Number	Description	Bore	Wall	Material
AM1TN	Tapered Nozzle Assembly	10.6mm	1.0mm	Copper
•AM1CN	Conical Nozzle Assembly	12mm	1.0mm	Copper

### C Fume Adaptors

Part Number	Description	Material
AX1002	Fume Nozzle Adaptor	Aluminium

### D Contact Tips

Part Number	Description	Size (mm)	Wire Size (mm-inch)	Material
AM1CT06	Contact Tip	M6*25.0	0.6 - 0.023	Copper
•AM1CT08	Contact Tip	M6*25.0	0.8 - 0.030	Copper
AM1CT09	Contact Tip	M6*25.0	0.9 - 0.035	Copper
AM1CT10	Contact Tip	M6*25.0	1.0 - 0.040	Copper
AM1CT12	Contact Tip	M6*25.0	1.2 - 0.045	Copper
AM1CT08A	Contact Tip	M6*25.0	0.8 - 0.030	Copper
AM1CT10A	Contact Tip	M6*25.0	1.0 - 0.040	Copper
AM1CT12A	Contact Tip	M6*25.0	1.2 - 0.045	Copper

### E Tip Adaptors

Part Number	Description	Material
•AM1TA	Tip Adaptor	Brass

### F Neck Insulator

Part Number	Description
•AX1003	Neck Insulator

### G Liners

Part Number	Description	Wire Size
•AM1535-30	Steel Liner x 3mt	0.6-0.9mm
•AM1535-40	Steel Liner x 4mt	0.6-0.9mm
•AM1535-50	Steel Liner x 5mt	0.6-0.9mm

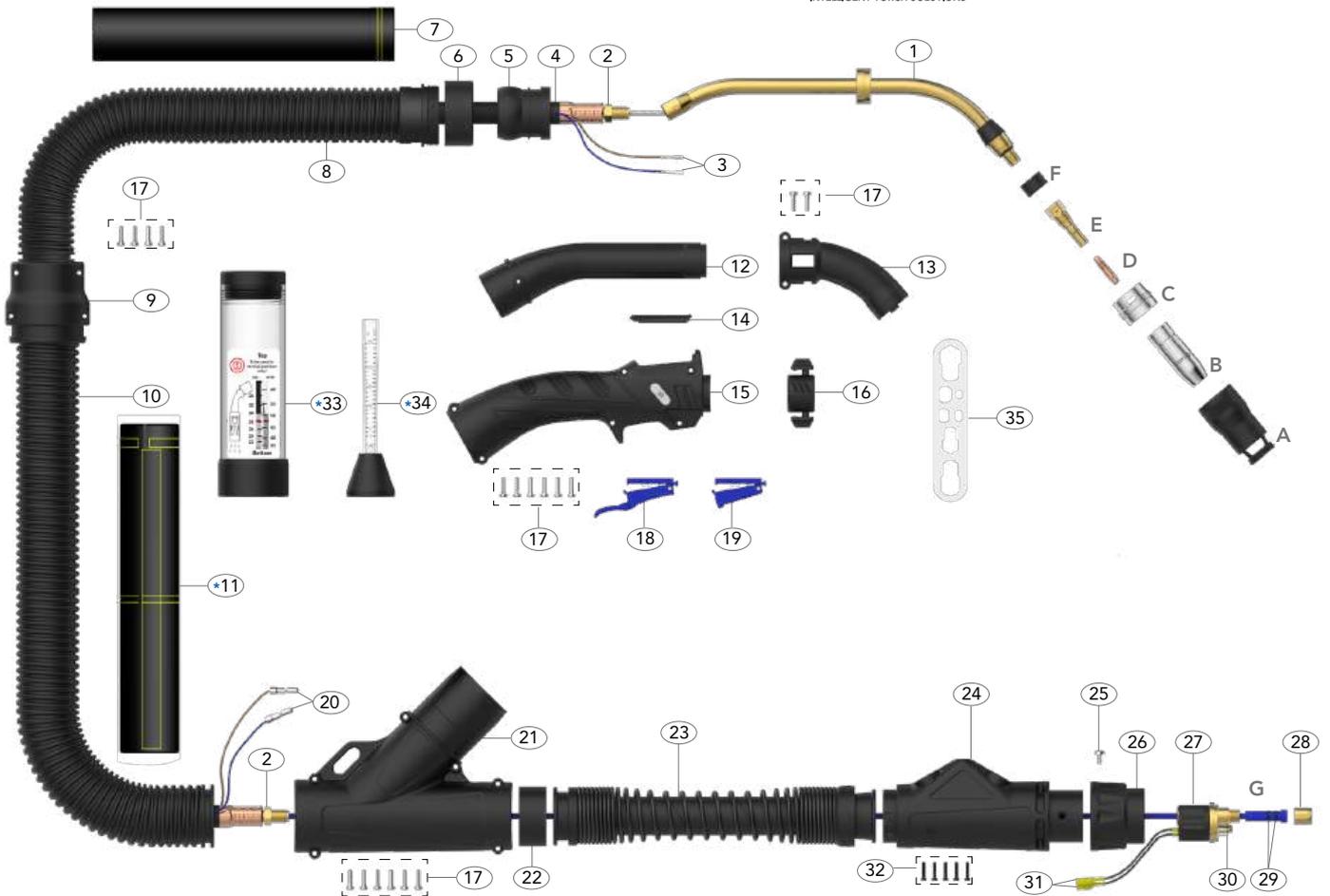
•Denotes torch package standard wear part set-up



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## Spare Parts

Part Number	Description	Part Number	Description
1	AX1001 Swan Neck Assembly	21	AX-YC Y' Connector
2	AM1505 Lock Nut	22	AX1-SR Sponge Seal Ring
3	AM1521 Cable Terminal	23	AX5019-CS Connect Spring Assembly
4	AX1517-30 Power Cable Assembly x 3mt	24	AM5022 Housing Assembly
	AX1517-40 Power Cable Assembly x 4mt	25	AML1541 Gun Plug Screw
	AX1517-50 Power Cable Assembly x 5mt	26	AM1519 Gun Plug Nut
5	AX8015-1 Ball Joint	27	AM1528 Hybrid Gun Plug Body c/w Spring Pins
6	AX8015-2 Ball Joint Nut	28	AM1826 Liner Retaining Nut
7	AXLC-30 x 1.5M Front Leather Cover 1.5mt	29	AMLOR Liner 'O' Ring
8	AX4019-1 Front Extract Hose Assembly	30	AM1524 Gun Plug 'O' Ring
9	AX-HRC30-40 Hose Connector	31	AM1523 Gun Plug Terminal Female
10	AX5019-2-30 Rear Extract Hose Assembly x 3mt	32	AMSP1-1 Screw Pack
	AX5019-2-40 Rear Extract Hose Assembly x 4mt	35	AMWS Wear Parts Spanner
	AX5019-2-50 Rear Extract Hose Assembly x 5mt		
12	AX3-IFC Inner Fume Chamber		
13	AX1-OFC Outer Fume Chamber		
14	AM2514-C Handle Control Cover		
15	AX2514 Fume Handle Assy		
16	AX3-AFR Air Flow Regulator		
17	AXSP1-1 Screw Pack		
18	AM2516L Microswitch Extended Trigger		
19	AM2516 Microswitch Standard Trigger		
20	AM1522 Cable Terminal Male		
		<b>Optional</b>	
		*11	AXLC-40 x 0.75M Rear Leather Cover 0.75mt
			AXLC-40 x 1.75M Rear Leather Cover 1.75mt
			AXLC-40 x 2.75M Rear Leather Cover 2.75mt
		+33	AX1-AFM Air Flow Meter
		+34	AX-GFM Gas Flow Meter

The design, manufacturing and quality systems of Arc Torchology are certified by **BVQI** in accordance with EN/ISO 9001:2015

# X2 Air-Cooled X Industrial Mig Fume Torch



Ratings:	250A CO <sub>2</sub> , 220A mixed gas M21, EN60974-7 @ 60% duty cycle. 0.8mm-1.2mm wire
Technical specification:	Shielding Gas Flow Rate: 10-15 l/min Extraction Volume Rate at Nozzle: 48 m <sup>3</sup> /h

The Arc X2 is perfect for 0.8-1.2mm hard wires and industrial settings, capturing fume at source to improve air quality and safety.

## ARC X INDUSTRIAL MIG FUME TORCH PACKAGES

Arc X2 Torches are supplied with a front leather cover and Euro termination as standard and are supplied 'ready to weld' with all wear parts fitted.



	3mt	4mt	5mt
Fume X Torch c/w Front Leather	X2-3M	X2-4M	X2-5M
Fume X Torch c/w Front Leather, Air Flow and Gas Flow Meter	X2-3M-FM	X2-4M-FM	X2-5M-FM
Fume X Torch Full Leather	X2-3M-LE	X2-4M-LE	X2-5M-LE
Fume X Torch Full Leather c/w Air Flow and Gas Flow Meter	X2-3M-LE-FM	X2-4M-LE-FM	X2-5M-LE-FM

## Wear Parts

### A Fume Nozzles

Part Number	Description	Bore	Wall	Material
AX2FN	Fume Nozzle	21.9mm	1mm	Aluminium

### B Nozzles

Part Number	Description	Bore	Wall	Material
AM2TN	Tapered Nozzle Assembly	12mm	1.9mm	Copper
•AM2CN	Conical Nozzle Assembly	15mm	1.9mm	Copper

### C Fume Adaptors

Part Number	Description	Material
AX2002	Fume Nozzle Adaptor	Aluminium

### D Contact Tips

Part Number	Description	Size (mm)	Wire Size (mm-inch)	Material
AM2CT08	Contact Tip	M6*25.0	0.6 - 0.023	Copper
AM2CT09	Contact Tip	M6*25.0	0.8 - 0.030	Copper
•AM2CT10	Contact Tip	M6*25.0	0.9 - 0.035	Copper
AM2CT12	Contact Tip	M6*25.0	1.0 - 0.040	Copper
AM2CT08A	Contact Tip	M6*25.0	1.2 - 0.045	Copper
AM2CT10A	Contact Tip	M6*25.0	0.8 - 0.030	Copper
AM2CT12A	Contact Tip	M6*25.0	1.0 - 0.040	Copper

### E Tip Adaptors

Part Number	Description	Material
•AM2TA	Tip Adaptor	Brass

### F Neck Insulator

Part Number	Description
•AX2003	Neck Insulator

### G Liners

Part Number	Description	Wire Size
•AM2524-30	Steel Liner x 3mt	1.0-1.2mm
•AM2524-40	Steel Liner x 4mt	1.0-1.2mm
•AM2524-50	Steel Liner x 5mt	1.0-1.2mm

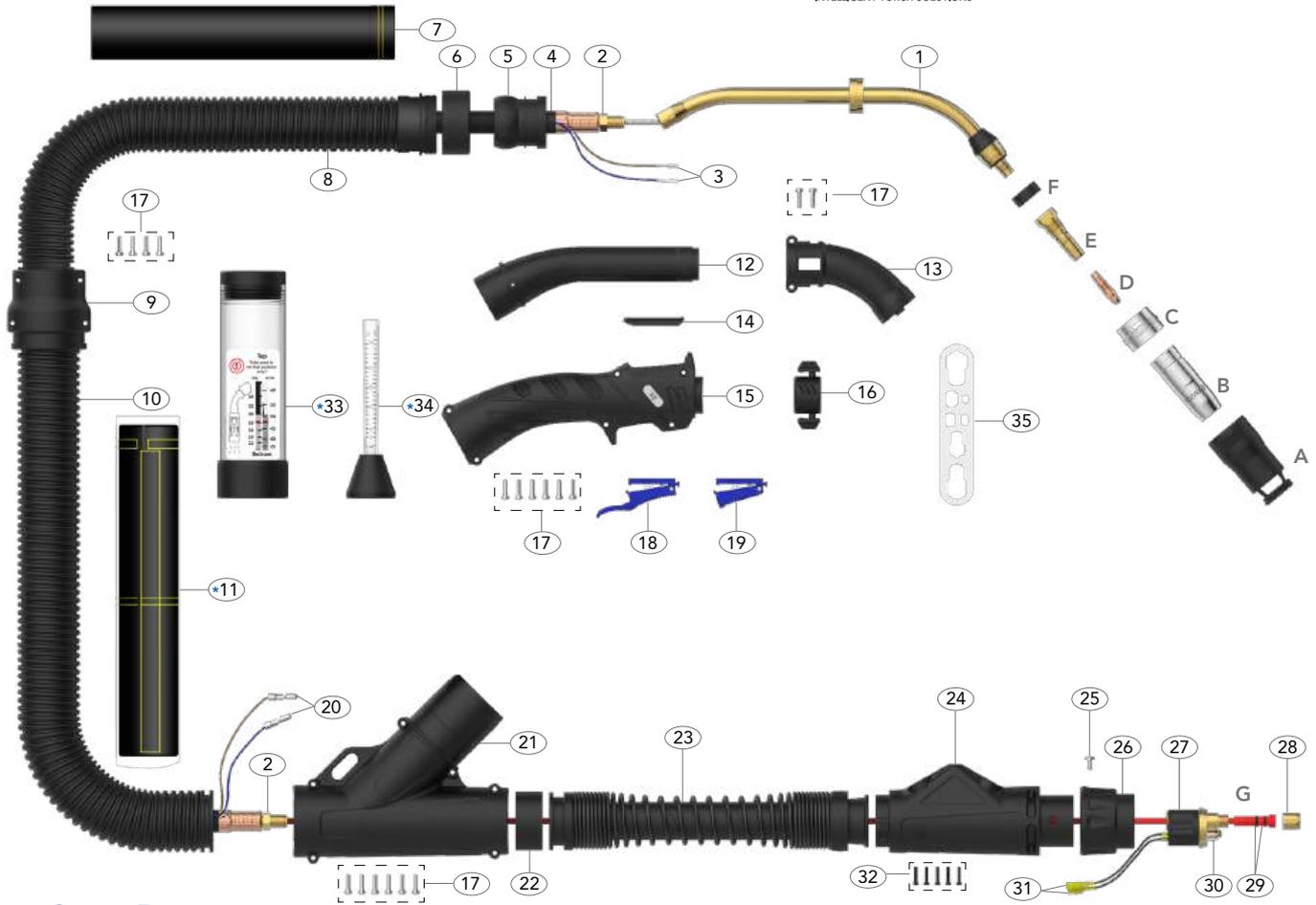
•Denotes torch package standard wear part set-up



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## Spare Parts

Part Number	Description	Part Number	Description
1	AX2001 Swan Neck Assembly	21	AX-YC Y' Connector
2	AM1505 Lock Nut	22	AX2-SR Sponge Seal Ring
3	AM1521 Cable Terminal	23	AX5019-CS Connect Spring Assembly
4	AX2503-30 Power Cable Assembly x 3mt	24	AM5022 Housing Assembly
	AX2503-40 Power Cable Assembly x 4mt	25	AML1541 Gun Plug Screw
	AX2503-50 Power Cable Assembly x 5mt	26	AM1519 Gun Plug Nut
5	AX8015-1 Ball Joint	27	AM1528 Hybrid Gun Plug Body c/w Spring Pins
6	AX8015-2 Ball Joint Nut	28	AM1826 Liner Retaining Nut
7	AXLC-30 x 1.5M Front Leather Cover 1.5mt	29	AMLOR Liner 'O' Ring
8	AX4019-1 Front Extract Hose Assembly	30	AM1524 Gun Plug 'O' Ring
9	AX-HRC30-40 Hose Connector	31	AM1523 Gun Plug Terminal Female
10	AX5019-2-30 Rear Extract Hose Assembly x 3mt	32	AMSP1-1 Screw Pack
	AX5019-2-40 Rear Extract Hose Assembly x 4mt	35	AMWS Wear Parts Spanner
	AX5019-2-50 Rear Extract Hose Assembly x 5mt		
12	AX3-IFC Inner Fume Chamber		
13	AX2-OFC Outer Fume Chamber		
14	AM2514-C Handle Control Cover		
15	AX2514 Fume Handle Assy		
16	AX3-AFR Air Flow Regulator		
17	AXSP1-1 Screw Pack		
18	AM2516L Microswitch Extended Trigger		
19	AM2516 Microswitch Standard Trigger		
20	AM1522 Cable Terminal Male		
		<b>Optional</b>	
		*11	AXLC-40 x 0.75M Rear Leather Cover 0.75mt
			AXLC-40 x 1.75M Rear Leather Cover 1.75mt
			AXLC-40 x 2.75M Rear Leather Cover 2.75mt
		*33	AX2-AFM Air Flow Meter
		*34	AX-GFM Gas Flow Meter

The design, manufacturing and quality systems of Arc Torchology are certified by **BVQI** in accordance with EN/ISO 9001:2015

# X3 Air-Cooled X High Performance Mig Fume Torch



Ratings:	300A CO <sub>2</sub> , 270A mixed gas M21, EN60974-7 @ 60% duty cycle. 0.9mm-1.2mm wire
Technical specification:	Shielding Gas Flow Rate: 16-18 l/min Extraction Volume Rate at Nozzle: 52 m <sup>3</sup> /h

The Arc X3 is the workhorse of the series, delivering a true 300 Amp torch with 98% fume capture at the source.

## ARC X HIGH PERFORMANCE MIG FUME TORCH PACKAGES

Arc X3 Torches are supplied with a front leather cover and Euro termination as standard and are supplied 'ready to weld' with all wear parts fitted.



	3mt	4mt	5mt
Fume X Torch c/w Front Leather	X3-3M	X3-4M	X3-5M
Fume X Torch c/w Front Leather, Air Flow and Gas Flow Meter	X3-3M-FM	X3-4M-FM	X3-5M-FM
Fume X Torch Full Leather	X3-3M-LE	X3-4M-LE	X3-5M-LE
Fume X Torch Full Leather c/w Air Flow and Gas Flow Meter	X3-3M-LE-FM	X3-4M-LE-FM	X3-5M-LE-FM

## Wear Parts

### A Fume Nozzles

Part Number	Description	Bore	Wall	Material
AX3FN	Fume Nozzle	23.4mm	1mm	Aluminium

### B Nozzles

Part Number	Description	Bore	Wall	Material
AX3TN	Tapered Nozzle	12mm	2.5mm	Copper
•AX3CN	Conical Nozzle	15mm	2.5mm	Copper
AX3CYN	Cylindrical Nozzle	18mm	2.5mm	Copper

### C Fume Adaptors

Part Number	Description	Material
AX3002	Fume Nozzle Adaptor	Aluminium

### D Contact Tips

Part Number	Description	Size (mm)	Wire Size (mm-inch)	Material
<b>Standard Series</b>				
AM5CT09	Contact Tip	M8*29.5	0.9-0.035	CuCrZr
AM5CT10	Contact Tip	M8*29.5	1.0-0.040	CuCrZr
•AM5CT12	Contact Tip	M8*29.5	1.2-0.045	CuCrZr
<b>A Series</b>				
AM5CT10A	Contact Tip	M8*29.5	1.0-0.040	CuCrZr
AM5CT12A	Contact Tip	M8*29.5	1.2-0.045	CuCrZr
AM2CT10A	Contact Tip	M8*29.5	1.0-0.040	Copper
AM2CT12A	Contact Tip	M8*29.5	1.2-0.045	Copper

### E Tip Adaptors

Part Number	Description	Material
•AM3TAB	Tip Adaptor	Brass
AM3TAC	Tip Adaptor High Performance	CuCrZr

### F Liners

Part Number	Description	Wire Size
•AM2524-30	Steel Liner x 3mt	1.0-1.2mm
•AM2524-40	Steel Liner x 4mt	1.0-1.2mm
•AM2524-50	Steel Liner x 5mt	1.0-1.2mm

•Denotes torch package standard wear part set-up

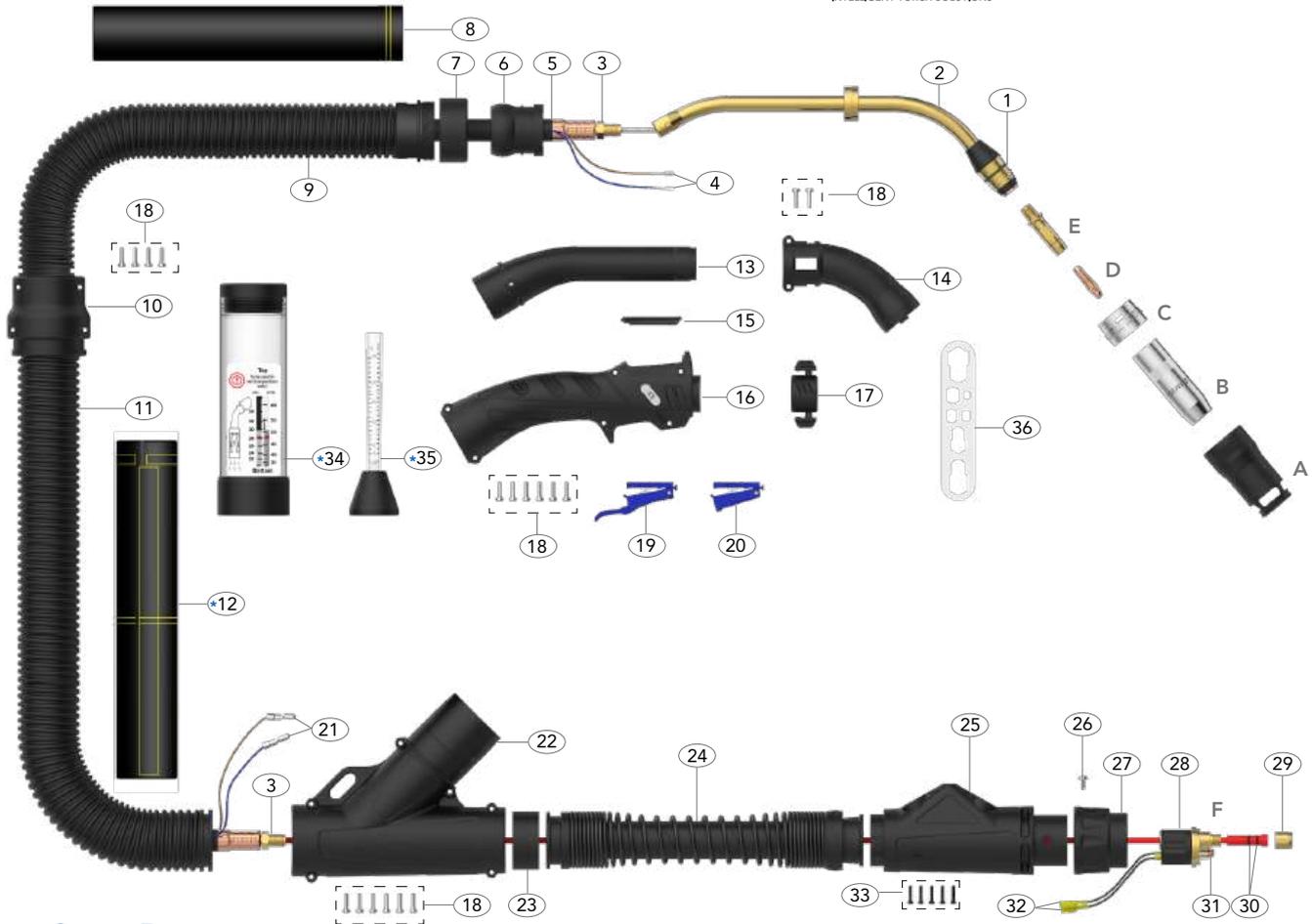


M10 Contact Tip and Tip Adaptors available please refer to Page 18-19

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## Spare Parts

Part Number	Description	Part Number	Description
1	AX3-NOR Neck 'O' Ring	22	AX-YC Y' Connector
2	AX3001 Swan Neck Assembly	23	AX3-SR Sponge Seal Ring
3	AM1505 Lock Nut	24	AX5019-CS Connect Spring Assembly
4	AM1521 Cable Terminal	25	AM5022 Housing Assembly
5	AX3003-30 Power Cable Assembly x 3mt	26	AML1541 Gun Plug Screw
	AX3003-40 Power Cable Assembly x 4mt	27	AM1519 Gun Plug Nut
	AX3003-50 Power Cable Assembly x 5mt	28	AM1528 Hybrid Gun Plug Body c/w Spring Pins
6	AX8015-1 Ball Joint	29	AM1826 Liner Retaining Nut
7	AX8015-2 Ball Joint Nut	30	AMLOR Liner 'O' Ring
8	AXLC-32 x 1.5M Front Leather Cover 1.5mt	31	AM1524 Gun Plug 'O' Ring
9	AX5019-1 Front Extract Hose Assembly	32	AM1523 Gun Plug Terminal Female
10	AX-HRC32-40 Hose Connector	33	AMSP1-1 Screw Pack
11	AX5019-2-30 Rear Extract Hose Assembly x 3mt	36	AMWS Wear Parts Spanner
	AX5019-2-40 Rear Extract Hose Assembly x 4mt		
	AX5019-2-50 Rear Extract Hose Assembly x 5mt		
13	AX3-IFC Inner Fume Chamber		
14	AX3-OFc Outer Fume Chamber		
15	AM2514-C Handle Control Cover		
16	AX2514 Fume Handle Assy		
17	AX3-AFR Air Flow Regulator		
18	AXSP1-1 Screw Pack		
19	AM2516L Microswitch Extended Trigger		
20	AM2516 Microswitch Standard Trigger		
21	AM1522 Cable Terminal Male		
		<b>Optional</b>	
		*12	AXLC-40 x 0.75M Rear Leather Cover 0.75mt
			AXLC-40 x 1.75M Rear Leather Cover 1.75mt
			AXLC-40 x 2.75M Rear Leather Cover 2.75mt
		*34	AX3-AFM Air Flow Meter
		*35	AX-GFM Gas Flow Meter

The design, manufacturing and quality systems of Arc Torchology are certified by **BVQI** in accordance with EN/ISO 9001:2015

# X5W Liquid-Cooled X High Performance Mig Fume Torch



Ratings:	500A CO <sub>2</sub> , 450A mixed gas M21,EN60974-7 @ 100% duty cycle. 0.9mm-1.6mm wire
Technical specification:	Shielding Gas Flow Rate: 16-22 l/min Extraction Volume Rate at Nozzle: 52 m <sup>3</sup> /h

Designed for heavy-duty, high-demand applications, it ensures high-efficiency fume capture at the generation point, minimizing airborne contaminants.

## ARC X HIGH PERFORMANCE MIG FUME TORCH PACKAGES

Arc X5W Torches are supplied with a front leather cover and Euro termination as standard and are supplied 'ready to weld' with all wear parts fitted.



	3mt	4mt	5mt
Fume X Torch c/w Front Leather	X5W-3M	X5W-4M	X5W-5M
Fume X Torch c/w Front Leather, Air Flow and Gas Flow Meter	X5W-3M-FM	X5W-4M-FM	X5W-5M-FM
Fume X Torch Full Leather	X5W-3M-LE	X5W-4M-LE	X5W-5M-LE
Fume X Torch Full Leather c/w Air Flow and Gas Flow Meter	X5W-3M-LE-FM	X5W-4M-LE-FM	X5W-5M-LE-FM

## Wear Parts

### A Fume Nozzles

Part Number	Description	Bore	Wall	Material
AX3FN	Fume Nozzle	23.4mm	1mm	Aluminium

### B Nozzles

Part Number	Description	Bore	Wall	Material
AX3TN	Tapered Nozzle	12mm	2.5mm	Copper
•AX3CN	Conical Nozzle	15mm	2.5mm	Copper
AX3CYN	Cylindrical Nozzle	18mm	2.5mm	Copper

### C Fume Adaptors

Part Number	Description	Material
AX3002	Fume Nozzle Adaptor	Aluminium

### D Contact Tips

Part Number	Description	Size (mm)	Wire Size (mm-inch)	Material
<b>Standard Series</b>				
AM5CT09	Contact Tip	M8*29.5	0.9 - 0.035	CuCrZr
AM5CT10	Contact Tip	M8*29.5	1.0 - 0.040	CuCrZr
•AM5CT12	Contact Tip	M8*29.5	1.2 - 0.045	CuCrZr
AM5CT14	Contact Tip	M8*29.5	1.4 - 0.055	CuCrZr
AM5CT16	Contact Tip	M8*29.5	1.6 - 0.063	CuCrZr
<b>A Series</b>				
AM5CT10A	Contact Tip	M8*29.5	1.0 - 0.040	CuCrZr
AM5CT12A	Contact Tip	M8*29.5	1.2 - 0.045	CuCrZr
AM5CT16A	Contact Tip	M8*29.5	1.6 - 0.063	CuCrZr
AM2CT10A	Contact Tip	M8*29.5	1.0 - 0.040	Copper
AM2CT12A	Contact Tip	M8*29.5	1.2 - 0.045	Copper

### E Tip Adaptors

Part Number	Description	Material
•AX5WTAC	Tip Adaptor High Performance	CuCrZr

### F Tip Adaptor Insulators

Part Number	Description
•AX5WTAI	Tip Adaptor Insulator

### G Liners

Part Number	Description	Wire Size
•AM2524-30	Steel Liner x 3mt	1.0-1.2mm
•AM2524-40	Steel Liner x 4mt	1.0-1.2mm
•AM2524-50	Steel Liner x 5mt	1.0-1.2mm
AM3631-30	Steel Liner x 3mt	1.6mm
AM3631-40	Steel Liner x 4mt	1.6mm
AM3631-50	Steel Liner x 5mt	1.6mm

•Denotes torch package standard wear part set-up

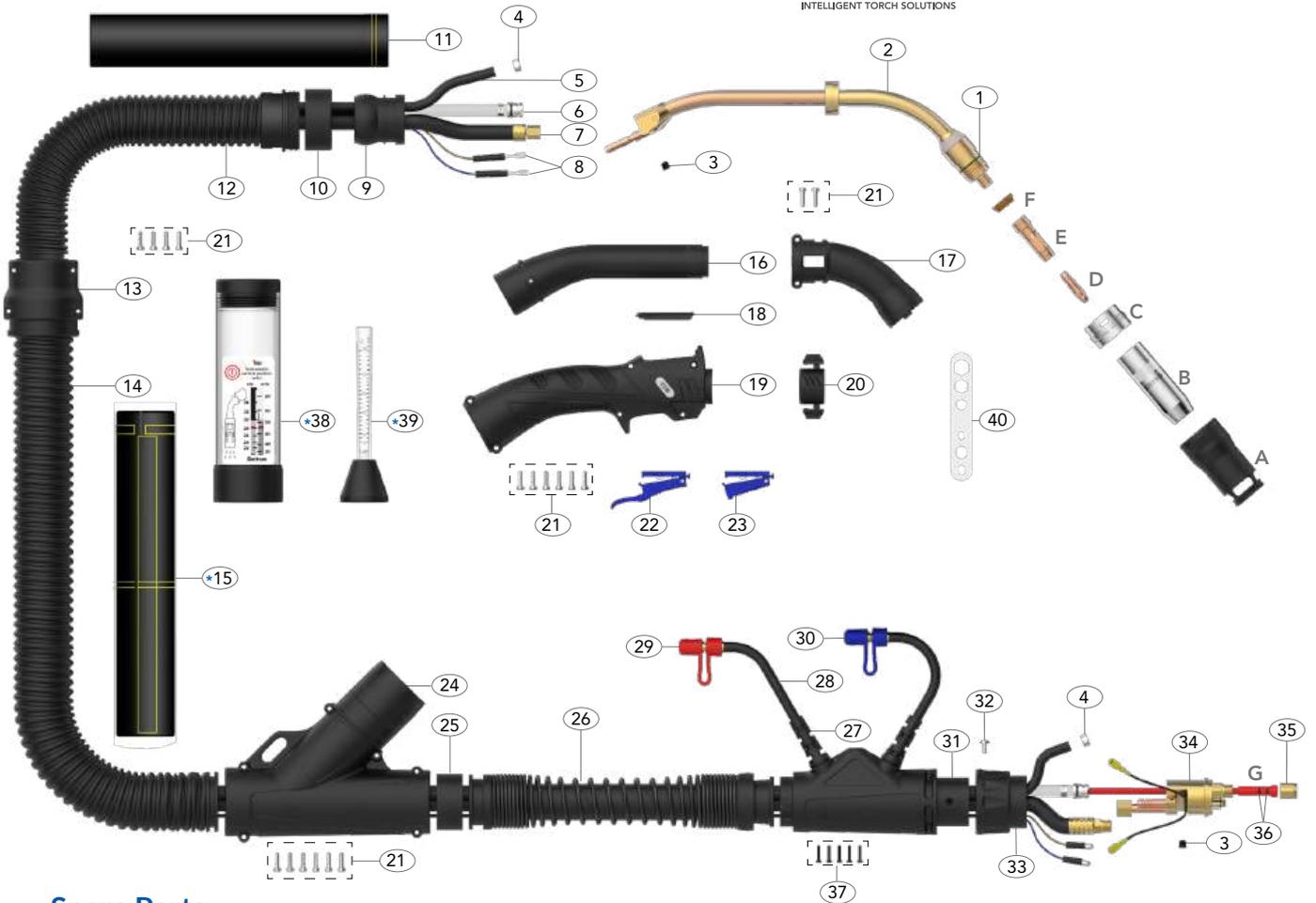


M10 Contact Tip and Tip Adaptors available please refer to Page 18-19

# FUME SERIES



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## Spare Parts

Part Number	Description
1	AX3-NOR Neck 'O' Ring
2	AX5002 Swan Neck Assembly
3	AM6X5 Outer Liner Retaining Screw
4	AM15400023 Water Hose Clamp 10mm
9	AX8015-1 Ball Joint
10	AX8015-2 Ball Joint Nut
11	AXLC-32 x 1.5M Front Leather Cover 1.5mt
12	AX5019-1 Front Extract Hose Assembly
13	AX-HRC32-40 Hose Connector
14	AX3-IFC Inner Fume Chamber
15	AX3-OFK Outer Fume Chamber
16	AX3-IFC Inner Fume Chamber
17	AX3-OFK Outer Fume Chamber
18	AM2514-C Handle Control Cover
19	AX3-AFR Air Flow Regulator
20	AX2514 Fume Handle Assy
21	AXSP1-1 Screw Pack
22	AM2516L Microswitch Extended TriggerA
23	M2516 Microswitch Standard Trigger
24	AX-YC 'Y' Connector
25	AX5-SR Sponge Seal Ring
26	AX5019-CS Connect Spring Assembly
27	AM1820 Hose Support
28	AM5017 Water Outlet Hose Assembly
29	AM80320 Red Cap Stopper
30	AM80310 Blue Cap Stopper

Part Number	Description
31	AM5022 Housing Assembly
32	AM1526 Gun Plug Screw (M4 x 0.7)
33	AM1519 Gun Plug Nut
34	AM5098 Water-Cooled Plug Body Assembly
35	AM1826 Liner Retaining Nut
36	AMLOR Liner 'O' Ring
37	AMSP1-1 Screw Pack
40	AMWS Wear Parts Spanner

Cable Parts	Description	Description		
		3m	4m	5m
5	Water Inlet Hose Assembly	AX5012-30	AX5012-40	AX5012-50
6	Outer Liner Assembly	AX5008-30	AX5008-40	AX5008-50
7	Power Cable Assembly	AX5015-30	AX5015-40	AX5015-50
8	Switch Lead Assembly	AX5010-30	AX5010-40	AX5010-50
14	Rear Extract hose Assembly	AX5019-30	AX5019-40	AX5019-50

Optional	
*15	AXLC-40 x 0.75M Rear Leather Cover 0.75mt
	AXLC-40 x 1.75M Rear Leather Cover 1.75mt
	AXLC-40 x 2.75M Rear Leather Cover 2.75mt
*38	AX3-AFM Air Flow Meter
*39	AX-GFM Gas Flow Meter

The design, manufacturing and quality systems of Arc Torchology are certified by **BVQI** in accordance with EN/ISO 9001:2015

# WEAR PARTS

## Fume Series



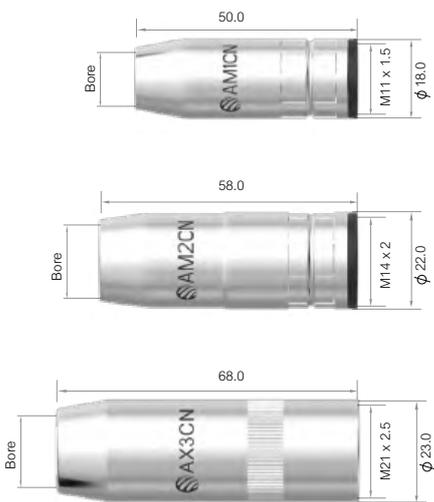
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### Fume Nozzles

Part No.	Description	Wall	Material	X1	X2	X3	X5W
AX1FN	Fume Nozzle	1.0mm	Aluminium	●	●	●	●
AX2FN	Fume Nozzle	1.0mm	Aluminium	●	●	●	●
AX3FN	Fume Nozzle	1.0mm	Aluminium	●	●	●	●

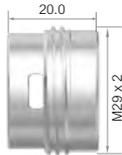
### Nozzles



Part No.	Description	Bore	Wall	Material	X1	X2	X3	X5W
AM1TN	Tapered Nozzle Assembly	10.6mm	1.0mm	Copper	●	●	●	●
AM1CN	Conical Nozzle Assembly	12.0mm	1.0mm	Copper	●	●	●	●
AM2TN	Tapered Nozzle Assembly	12.0mm	1.9mm	Copper	●	●	●	●
AM2CN	Conical Nozzle Assembly	15.0mm	1.9mm	Copper	●	●	●	●
AX3TN	Tapered Nozzle	12.0mm	2.5mm	Copper	●	●	●	●
AX3CN	Conical Nozzle	15.0mm	2.5mm	Copper	●	●	●	●
AX3CYN	Cylindrical Nozzle	18.0mm	2.5mm	Copper	●	●	●	●

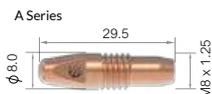
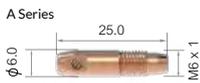
● Standard wear part range ● Torch package standard wear part set-up

### Fume Adaptors



Part No.	Description	Material	X1	X2	X3	X5W
AX1002	Fume Nozzle Adaptor	Aluminium	●	●	●	●
AX2002	Fume Nozzle Adaptor	Aluminium	●	●	●	●
AX3002	Fume Nozzle Adaptor	Aluminium	●	●	●	●

### Contact Tips



Part No.	Description	Size mm	Wire Size mm-Inch	Material	X1	X2	X3	X5W
<b>Standard Series</b> - Recommended for Fe, Fe-MG/FC Set-up								
AM1CT06	Contact Tip	M6*25.0	0.6-0.023	Copper	●	●	●	●
AM1CT08	Contact Tip	M6*25.0	0.8-0.030	Copper	●	●	●	●
AM1CT09	Contact Tip	M6*25.0	0.9-0.035	Copper	●	●	●	●
AM1CT10	Contact Tip	M6*25.0	1.0-0.040	Copper	●	●	●	●
AM1CT12	Contact Tip	M6*25.0	1.2-0.045	Copper	●	●	●	●
<b>Standard Series</b> - Recommended for Fe, Fe-MC/FC Set-up								
AM2CT08	Contact Tip	M8*29.5	0.8-0.030	Copper	●	●	●	●
AM2CT09	Contact Tip	M8*29.5	0.9-0.035	Copper	●	●	●	●
AM2CT10	Contact Tip	M8*29.5	1.0-0.040	Copper	●	●	●	●
AM2CT12	Contact Tip	M8*29.5	1.2-0.045	Copper	●	●	●	●
<b>A Series</b> - Recommended for Aluminium and SS Set-up								
AM1CT08A	Contact Tip	M6*25.0	0.8-0.030	Copper	●	●	●	●
AM1CT10A	Contact Tip	M6*25.0	1.0-0.040	Copper	●	●	●	●
AM1CT12A	Contact Tip	M6*25.0	1.2-0.045	Copper	●	●	●	●
<b>A Series</b> - Recommended for Aluminium and SS Set-up								
AM2CT08A	Contact Tip	M8*29.5	0.8-0.030	Copper	●	●	●	●
AM2CT10A	Contact Tip	M8*29.5	1.0-0.040	Copper	●	●	●	●
AM2CT12A	Contact Tip	M8*29.5	1.2-0.045	Copper	●	●	●	●

● Standard wear part range ● Torch package standard wear part set-up

## Contact Tips



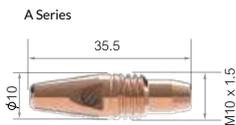
Part No.	Description	Size mm	Wire Size mm-inch	Material	Wire Type	X1	X2	X3	X5W
<b>Standard Series</b> - Recommended for Fe, Fe-MC/FC Set-up									
AM5CT09	Contact Tip	M8*29.5	0.9-0.035	CuCrZr		●	●	●	●
AM5CT10	Contact Tip	M8*29.5	1.0-0.040	CuCrZr	Fe, Fe-FC/MC	●	●	●	●
AM5CT12	Contact Tip	M8*29.5	1.2-0.045	CuCrZr	SS,SS-FC/MC	●	●	●	●
AM5CT14	Contact Tip	M8*29.5	1.4-0.055	CuCrZr	upto 1.2mm	●	●	●	●
AM5CT16	Contact Tip	M8*29.5	1.6-0.063	CuCrZr		●	●	●	●



<b>Standard Series</b> - Recommended for Fe, Fe-MC/FC Set-up									
AM6WCT09	Contact Tip	M10*35.5	0.9-0.035	CuCrZr		●	●	●	●
AM6WCT10	Contact Tip	M10*35.5	1.0-0.040	CuCrZr	Fe, Fe-FC/MC	●	●	●	●
AM6WCT12	Contact Tip	M10*35.5	1.2-0.045	CuCrZr	SS,SS-FC/MC	●	●	●	●
AM6WCT14	Contact Tip	M10*35.5	1.4-0.055	CuCrZr	upto 1.2mm	●	●	●	●
AM6WCT16	Contact Tip	M10*35.5	1.6-0.063	CuCrZr		●	●	●	●



<b>A Series</b> - Recommended for Aluminium and SS Set-up									
AM5CT10A	Contact Tip	M8*29.5	1.0-0.040	CuCrZr		●	●	●	●
AM5CT12A	Contact Tip	M8*29.5	1.2-0.045	CuCrZr	Aluminium	●	●	●	●
AM5CT16A	Contact Tip	M8*29.5	1.6-0.063	CuCrZr	SS,SS-FC/MC	●	●	●	●
AM2CT10A	Contact Tip	M8*29.5	1.0-0.040	Copper	upto 1.6mm	●	●	●	●
AM2CT12A	Contact Tip	M8*29.5	1.2-0.045	Copper		●	●	●	●



<b>A Series</b> - Recommended for Aluminium and SS Set-up									
AM6WCT10A	Contact Tip	M10*35.5	1.0-0.040	CuCrZr		●	●	●	●
AM6WCT12A	Contact Tip	M10*35.5	1.2-0.045	CuCrZr	Aluminium	●	●	●	●
AM6WCT16A	Contact Tip	M10*35.5	1.6-0.063	CuCrZr	SS,SS-FC/MC	●	●	●	●
AMC6WCT10A	Contact Tip	M10*35.5	1.0-0.040	Copper	1.6mm	●	●	●	●
AMC6WCT12A	Contact Tip	M10*35.5	1.2-0.045	Copper		●	●	●	●

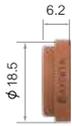
● Standard wear part range ● Torch package standard wear part set-up

## Tip Adaptors

Part No.	Description	Material	X1	X2	X3	X5W
 AM1TA	Tip Adaptor	Brass	●	●	●	●
 AM2TA	Tip Adaptor	Brass	●	●	●	●
 AM3TAB	Tip Adaptor	Brass	●	●	●	●
AM3TAC	Tip Adaptor High Performance	CuCrZr	●	●	●	●
 AM3TAB-M10	Tip Adaptor M10	Brass	●	●	●	●
AM3TAC-M10	Tip Adaptor High Performance M10	CuCrZr	●	●	●	●
 AX5WTAC	Tip Adaptor	CuCrZr	●	●	●	●
 AX5WTAC-M10	Tip Adaptor M10	CuCrZr	●	●	●	●

● Standard wear part range ● Torch package standard wear part set-up

**Insulators**



Part No.	Description	X1	X2	X3	X5W
AX5WTAI	Tip Adaptor Insulator	●	●	●	●
AX1003	Neck Insulator	●	●	●	●
AX2003	Neck Insulator	●	●	●	●

● Standard wear part range ● Torch package standard wear part set-up

### Liners

### Filler Metal

**Steel Liner** Recommended for: Fe, Fe-MC/FC. Light and medium duty applications

Part No.	Description	Nipple	Wire Size mm	X1	X2	X3	X5W
AM1535-30	Steel Liner x 3mt	Moulded Nipple	0.6-0.9	●	●	●	●
AM1535-40	Steel Liner x 4mt	Moulded Nipple	0.6-0.9	●	●	●	●
AM1535-50	Steel Liner x 5mt	Moulded Nipple	0.6-0.9	●	●	●	●



AM2524-30	Steel Liner x 3mt	Moulded Nipple	1.0-1.2	●	●	●	●
AM2524-40	Steel Liner x 4mt	Moulded Nipple	1.0-1.2	●	●	●	●
AM2524-50	Steel Liner x 5mt	Moulded Nipple	1.0-1.2	●	●	●	●



AM3631-30	Steel Liner x 3mt	Moulded Nipple	1.6	●	●	●	●
AM3631-40	Steel Liner x 4mt	Moulded Nipple	1.6	●	●	●	●
AM3631-50	Steel Liner x 5mt	Moulded Nipple	1.6	●	●	●	●



**Al - Combi Liner** Recommended for: Al, can be used for SS, SS-MC/FC

Part No.	Description	Contact Tip	Wire Size mm	X1	X2	X3	X5W
AM1564-30	Combi-Liner x 3mt	A Series	0.8-1.2	●	●	●	●
AM1564-40	Combi-Liner x 4mt	A Series	0.8-1.2	●	●	●	●
AM1564-50	Combi-Liner x 5mt	A Series	0.8-1.2	●	●	●	●
AM2564-30	Combi-Liner x 3mt	A Series	1.2-1.6	●	●	●	●
AM2564-40	Combi-Liner x 4mt	A Series	1.2-1.6	●	●	●	●
AM2564-50	Combi-Liner x 5mt	A Series	1.2-1.6	●	●	●	●



● Standard wear part range ● Torch package standard wear part set-up

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