

**SR 9**  
gas-cooled

Different modular switch  
units available:  
single push-button  
double push-button  
up/down ( 4 push-buttons )  
single push-button  
with potentiometer

**SR 9F**  
gas-cooled

**SR 9V**  
gas-cooled

**SR 9FV**  
gas-cooled

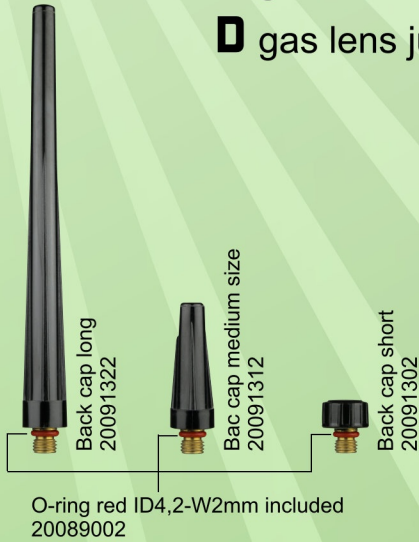


110 Amp./60% duty cycle (DC)  
95 Amp./60% duty cycle (AC)

# SR 9 / SR 9F / SR 9V / SR 9FV

gas-cooled

Equipment: **A** standard  
**B** gas lens  
**C** gas lens medium size  
**D** gas lens jumbo



Kir Royal argon nozzle fits equipment line **B** with firmly built-in sieves for perfect gas circulation



**A** **B** **C** **D**

Insulator gasket  
20089011

Insulator gasket  
20089011

Gas lens insulator medium size  
20089031

Gas lens insulator jumbo  
20089021

Collet L25mm  
20□2502 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Collet L25mm  
20□2502 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Collet L40mm  
20□4011 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Collet L40mm  
20□4011 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Collet body  
2096□02 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Gas lens  
2096□11 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Gas lens medium size  
2096□31 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Gas lens jumbo  
2096□21 for 1,0/1,6/2,4/3,2  
□ Please fill in size

Ceramic nozzle L30mm for standard collet body  
Please state size  
Also available in special lengths L48mm / L63mm / L89mm

Ceramic nozzle L25,5mm for gas lens  
Please state size  
Also available in special lengths L35mm / L72mm

Ceramic nozzle L42mm for gas lens medium size  
Please state size  
Also available in special length L76mm

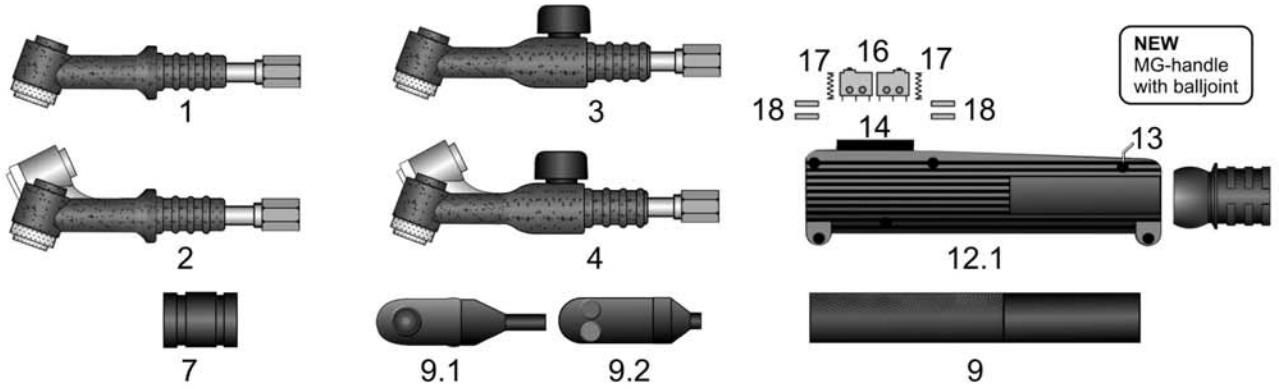
Ceramic nozzle L48mm for Gas lens jumbo  
Please state size

HSN 717AB-4

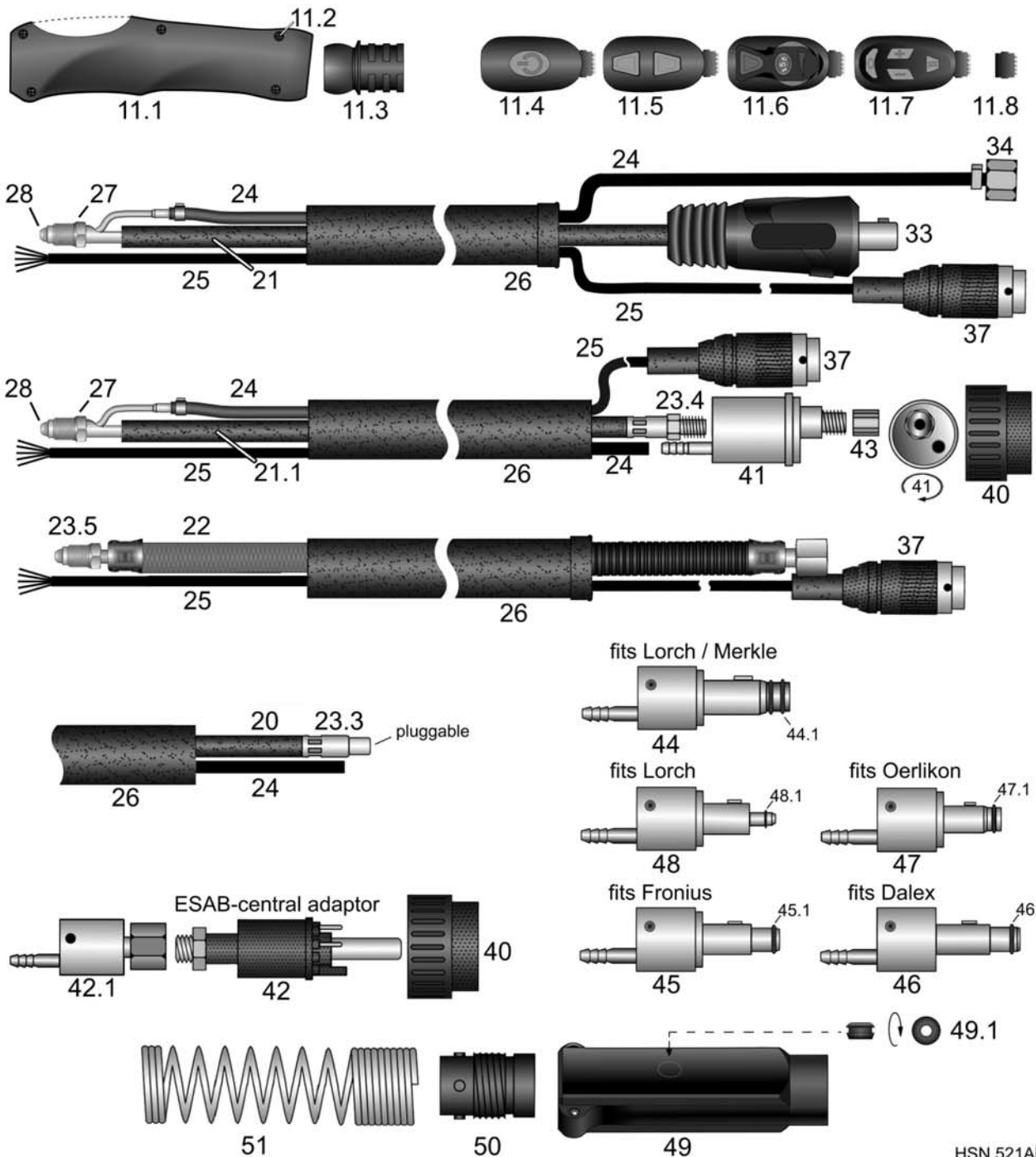
# SR 9 gas-cooled



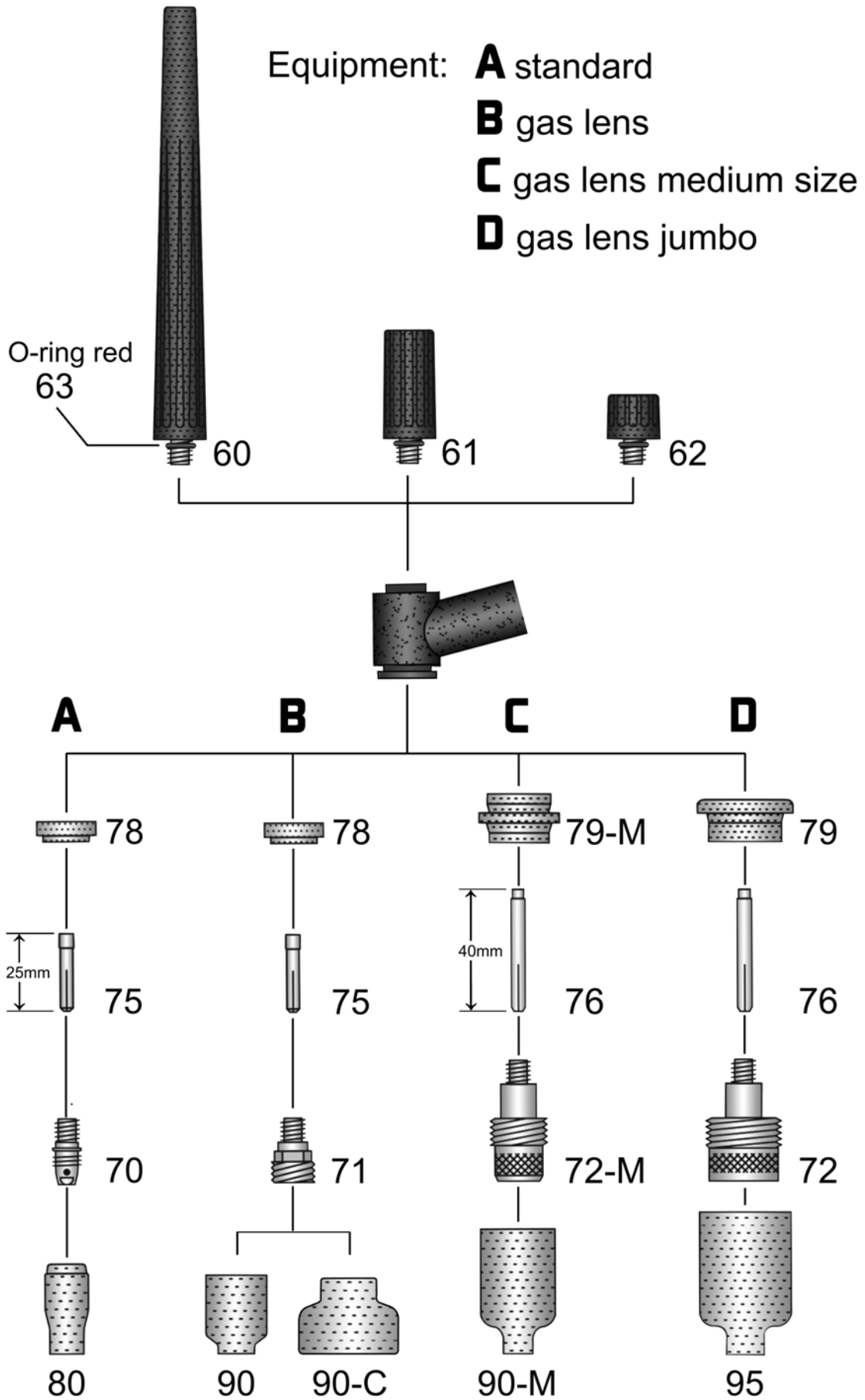
110 Ampere at 60% duty cycle (DC) - 95 Ampere at 60% duty cycle (AC)



**Forma WIG-handle with ball joint - different modular switch units - special switching modules on request**



HSN 521AB-1



## SR 9

### Welding-torch TIG gas-cooled with import torch body

110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)

#### Art.-No.

Torches with first meter leather hose. Machine side separate connections with Tuchel-plug.

In variation to the torches listed below, the torches can also be produced with other power/ gas cables (e.g. HT 180 silicone superflexible). This can also be combined with hoses in a lot of different qualities. Torches and cable assemblies can be produced in excess lengths. Please find the different options and surcharges in the appendix C "Custom made products". We produce torches for more than 40 different brands of machines with different connection systems.

90200401 Torch SR 9 / 4m

90200801 Torch SR 9 / 8m

90400401 FLEX-torch SR 9F / 4m neck flexible

90400801 FLEX-torch SR 9F / 8m neck flexible

90300401 Valve torch SR 9V / 4m

90300801 Valve torch SR 9V / 8m

90900401 FLEX-Valve torch SR 9FV / 4m neck flexible

90900801 FLEX-Valve torch SR 9FV / 8m neck flexible

TIG-spares cable assemblies, either with separate connections, or for the following connection systems.

wig92401 TIG-spares cable assembly gas-cooled 4m - please state desired design!

wig92801 TIG-spares cable assembly gas-cooled 8m - please state desired design!

The following machine side connections are only listed for fast price finding purposes. In our catalogue "TIG machine side connections" you'll find technical information specifying a machine side connection.

29000101 Surcharge: machine side with EURO central adapter

29002005 Surcharge: machine side power/gas plug fits Lorch/Merkle with 2 O-rings

29002004 Surcharge: machine side power/gas plug fits Fronius with 1 O-ring

29002006 Surcharge: machine side power/gas plug fits Dalex with 1 O-ring

29002107 Surcharge: machine side power/gas plug fits Oerlikon with 1 O-ring

29002002 Surcharge: machine side power/gas plug fits Lorch SK35 + gas-nipple

29000112 Surcharge: machine side fits ESAB central adapter, 4 pins installed at position 3,4,5,6

Please be aware that further surcharges may apply for some special control-line plugs. See appendix D.

1 90291001 Torch body SR 9 shaft Ø 15mm

2 90491001 Torch body SR 9F neck flexible (FLEX) shaft Ø 16,5mm

3 90391001 Valve-torch body SR 9V shaft Ø 15mm

4 90991001 Valve-torch body SR 9FV neck flexible (FLEX) shaft Ø 15mm

7 91914811 Rubber adapter fits Forma and MG handles for shaft Ø 15mm

N.i. 91914812 Rubber adapter fits Forma and MG handles for shaft Ø 16,5mm

9 17108802 Import handling-tube H-100 SR 9-17-20 ID15,0mm

N.i. 17108803 Import handling-tube H-100 SR 9-17-20 ID16,5mm

9.1 10089001 Single stroke button (rubber)

9.2 91921301 Doublepush button red/green

N.i. 17089001 One-hole shrinking hose switch sleeve ID39mm - min 13mm

N.i. 17089002 Two-hole shrinking hose switch sleeve ID39mm - min 13mm

## SR 9

### Welding-torch TIG gas-cooled with import torch body

110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)

Art.-No.	
11.1	91914601 Forma TIG handle with screws, ball joint, without modular switch unit
11.2	91914602 Forma screw for handle
11.3	91914603 Forma hose bracket with ball joint ID21,5mm (also fits MG-handle)
11.4	91914611 Forma modular switch unit: 1 button with connecting adapter
11.5	91914621 Forma modular switch unit: 2 buttons with connecting adapter
11.6	91914631 Forma modular switch unit: 1 button + potentiometer (10k) with connecting adapter
11.7	91914641 Forma modular switch unit: 2 buttons + up/down (4 switches) with connecting adapter
11.8	91914651 Forma connecting adapter fits control line to modular switch unit
N.i.	91914661 Forma switch module safety nipple
12.1	91914061 MG-handle with ball joint, push-button, 2 return springs, 2 microswitches and 4 cylindrical pins
13	91914421 MG-tapping screw
14	91915002 MG-push button
16	91914121 MG-microswitch
17	91914221 MG-return spring
18	91914321 MG-cylindrical pin
20	17941403 Powercable 25mm <sup>2</sup> SR 9-17 / 4m fits power/gas plugs + power gas junction (pgj)
20	17941803 Powercable 25mm <sup>2</sup> SR 9-17 / 8m fits power/gas plugs + power gas junction (pgj)
21	17941402 Power cable 25mm <sup>2</sup> SR 9-17 / 4m with SK25 or SK35 <--- please state!
21	17941802 Power cable 25mm <sup>2</sup> SR 9-17 / 8m with SK25 or SK35 <--- please state!
21.1	17941404 Powercable 25mm <sup>2</sup> SR 9-17 / 4m fits EURO central adapter (OT-M10x1)
21.1	17941804 Powercable 25mm <sup>2</sup> SR 9-17 / 8m fits EURO central adapter (OT-M10x1)
<b>The following power-/ gas cables are produced with an inner thread connection M10x1 to fit an Euro-central adapter</b>	
<b>For 4m long torches:</b>	
N.i.	17941411 ST 80 PVC-NIT power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
N.i.	17944413 HT 110 rubber fabric hose power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
N.i.	17941415 HT 130 TPE power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
N.i.	17941418 HT 180 silicone super flexible power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
<b>For 8m long torches:</b>	
N.i.	17941811 ST 80 PVC-NIT power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
N.i.	17944813 HT 110 rubber fabric hose power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
N.i.	17941815 HT 130 TPE power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
N.i.	17941818 HT 180 silicone super flexible power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
<b>Please state the machine side connection for the following power/ gas cables.</b>	
<b>For 4m long torches:</b>	
22	17941401 ST 80 PVC-NIT power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
22	17944403 HT 110 rubber fabric hose power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
22	17941405 HT 130 TPE power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
22	17941408 HT 180 silicone super flexible power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 4m
<b>For 8m long torches:</b>	
22	17941801 ST 80 PVC-NIT power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
22	17944803 HT 110 rubber fabric hose power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
22	17941805 HT 130 TPE power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m
22	17941808 HT 180 silicone super flexible power/gas conduit 17,31mm <sup>2</sup> SR 9-17 / 8m

**SR 9****Welding-torch TIG gas-cooled with import torch body****110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)**

<b>Art.-No.</b>		
23.3	22089056	TIG-Power cable connector pluggable ID7,2mm fits 25mm <sup>2</sup> for power/gas plugs + pgj
23.4	22089053	TIG-Power cable connector OT-M10x1 ID7,2mm fits 25mm <sup>2</sup>
23.5	90380002	Power connector AD9mm OT-3/8"UNF-rechts
<b>Reel goods:</b>		
Prices are given per meter and only valid for purchase of complete reels		
24	41500001	Meter ST 70 PVC hose ID4,0-W1,5mm black for gas (100m)
24	41500005	Meter HT 130 TPE hose ID4,0-W1,5mm grey for gas (100m)
N.i.	91902701	Meter control line 3x0,34mm <sup>2</sup> shielded black (100m)
N.i.	91902711	Meter control line 3x0,5mm <sup>2</sup> green (100m)
25	91902721	Meter control line 5x0,25mm <sup>2</sup> grey (100m)
26	20150002	Meter neoprene protective hose ID20mm black (40m)
27	91907701	Power cable connector separate lines SR 9-17 OT-3/8" UNF-right-hand thread
28	91907712	Hose connector long for separate lines SR 9-17
N.i.	91915004	Leather protective hose ID22mm / 1 meter long
N.i.	91915007	Leather protective hose ID22mm / 1 meter long with ball joint and hose connector
N.i.	91915013	Hose connector leather protective hose / protection hose ID22,5mm (black) with slot, OD with grooves
33	91918201	Powercable-plug SK-25 bayonet connection AD8mm
N.i.	91918321	Powercable plug SK25 with separate gas inlet, power-/gas connection OT-M12x1
33	91918301	Powercable-plug SK-35 bayonet connection AD13mm
N.i.	91918311	Powercable plug SK35 with separate gas inlet, power-/gas connection OT-M12x1
34	91901501	Coupling nut IT-G1/4"
N.i.	91901211	Hose connector 4mm fits coupling nut R1/4"
37	91904101	Plug 3-poles Tuchel with bayonet-catch
37	91904111	Plug 5-poles Tuchel with bayonet-catch
<b>More control line plugs please see appendix D.</b>		
40	91900701	Terminal nut insulated fits EURO central adapter
41	91900122	TIG central adapter EURO (fits separate lines)
N.i.	91900121	TIG-central adapter EURO central adapter with IT-M10x1 (fits power/gas conduit)
42	91900301	TIG central adapter identical ESAB, 4 contact pins at position 3,4,5,6
42.1	91918561	TIG power gas junction (pgj) fits ESAB central adapter
43	91900901	Swivel nut IT-M10x1 (rounded edges) fits EURO central adapter
44	9190411n	Power/gas plug fits Lorch / Merkle with 2 O-rings / power connection like pgj
44.1	81600001	O-ring ID8-W1,6mm fits Lorch/Merkle
45	91918326	Power/gas plug fits Fronius with 1 O-ring / power connection like pgj
45.1	62190001	O-ring ID6,2-W1,9mm fits Fronius
46	9190416e	Power/gas plug fits Dalex with 1 O-ring / power connection like pgj
46.1	63240001	O-ring ID6,3-W2,4mm fits Dalex
47	9190422n	Power/gas plug fits Oerlikon with 1 O-ring / power connection like pgj
47.1	60717801	O-ring ID6,07-W1,78mm fits Oerlikon
48	9190421n	Power/gas plug fits Lorch Sk35 + gas-nipple / power connection like pgj
48.1	91900801	O-ring ID4-W1mm fits gas-nipple EURO central adapter
49	91900556	TIG cable support short with screws (fits gas-cooled)
N.i.	91920702	Screw M3x11,5mm fits Ratio/Industry/RAUCH handle and cable support

**SR 9****Welding-torch TIG gas-cooled with import torch body****110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)**

<b>Art.-No.</b>		
N.i.	91920703	M3 mounting socket fits Ratio/Industry/RAUCH handle and cable support
N.i.	91900602	Screw M4x6mm fits TIG cable support short
49.1	91901012	Reduction-eyelet (rubber) from ID10,5mm to ID5mm fits TIG cable support short
50	91912801	Spring-socket fits cable support
51	91912601	Cable support spring
N.i.	91900552	TIG cable support long (like MIG-MAG) with screws fits ESAB central adapter
N.i.	91900554	Attachment screw M4x8mm fits ESAB central adapter
60	20091322	Import back cap 9-20 (with red O-ring) long
61	20091312	Import back cap 9-20 (with red O-ring) medium
62	20091302	Import back cap 9-20 (with red O-ring) short
63	20089002	O-ring ID4,2-W2mm red fits import back cap
70	20961002	Collet body 9-20 / 1,0 13N26
70	20961602	Collet body 9-20 / 1,6 13N27
71	20961011	Gas lens 9-20 / 1,0 45V42
71	20961611	Gas lens 9-20 / 1,6 45V43
72-M	20961031	Gas lens medium 9-20 / 1,0
72-M	20961631	Gas lens medium 9-20 / 1,6
72	20961021	Jumbo-Gas lens 9-20 / 1,0 45V0204S
72	20961621	Jumbo-Gas lens 9-20 / 1,6 45V116S
<b>Brazen collets L-25 mm for equipment line (A) standard collet for equipment line (B) gas lens</b>		
75	20102502	Collet L25mm 9-20 / 1,0 13N21
75	20162502	Collet L25mm 9-20 / 1,6 13N22
<b>Brazen collets L-40 mm for equipment line (C) gas lens midsize for equipment line (D) Jumbo gas lens</b>		
76	20104011	Collet L40mm 9-20 / 1,0 13N21L
76	20164011	Collet L40mm 9-20 / 1,6 13N22L
78	20089011	PTFE-isolator gasket 9-20
79-M	20089031	PTFE-gas lens isolator medium 9-20
79	20089021	PTFE-gas lens isolator Jumbo 9-20 54N63-20
<b>Ceramic gas nozzles in different lengths for equipment line (A) standard collet body</b>		
80	20930401	Ceramic gas nozzle L30mm / Gr. 4 13N08 (pu= 10pieces)
80	20930501	Ceramic gas nozzle L30mm / Gr. 5 13N09 (pu= 10pieces)
80	20930601	Ceramic gas nozzle L30mm / Gr. 6 13N10 (pu= 10pieces)
80	20930701	Ceramic gas nozzle L30mm / Gr. 7 13N11 (pu= 10pieces)
80	20930801	Ceramic gas nozzle L30mm / Gr. 8 13N12 (pu= 10pieces)
80	20930101	Ceramic gas nozzle L30mm / Gr.10 13N13 (pu= 10pieces)
N.i.	20930304	Ceramic gas nozzle L48mm / Gr. 3 796F70 (pu= 10pieces)

## SR 9

### Welding-torch TIG gas-cooled with import torch body

110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)

Art.-No.		
N.i.	20930404	Ceramic gas nozzle L48mm / Gr. 4 796F71 (pu= 10pieces)
N.i.	20930504	Ceramic gas nozzle L48mm / Gr. 5 796F72 (pu= 10pieces)
N.i.	20930604	Ceramic gas nozzle L48mm / Gr. 6 796F73 (pu= 10pieces)
N.i.	20930306	Ceramic gas nozzle L63mm / Gr. 3 796F74 (pu= 10pieces)
N.i.	20930406	Ceramic gas nozzle L63mm / Gr. 4 796F75 (pu= 10pieces)
N.i.	20930506	Ceramic gas nozzle L63mm / Gr. 5 796F76 (pu= 10pieces)
N.i.	20930606	Ceramic gas nozzle L63mm / Gr. 6 796F77 (pu= 10pieces)
N.i.	20930408	Ceramic gas nozzle L89mm / Gr. 4 796F79 (pu= 10pieces)
Ceramic gas nozzles in different lengths for equipment line (B) gas lens		
90	20931401	Ceramic gas nozzle for gas lens L25,5mm 9-20 / Gr.4 53N58 (pu= 10pieces)
90	20931501	Ceramic gas nozzle for gas lens L25,5mm 9-20 / Gr.5 53N59 (pu= 10pieces)
90	20931601	Ceramic gas nozzle for gas lens L25,5mm 9-20 / Gr.6 53N60 (pu= 10pieces)
90	20931701	Ceramic gas nozzle for gas lens L25,5mm 9-20 / Gr.7 53N61 (pu= 10pieces)
90	20931801	Ceramic gas nozzle for gas lens L25,5mm 9-20 / Gr.8 53N61-S (pu= 10pieces)
N.i.	20931404	Ceramic gas nozzle for gas lens L35mm 9-20 / Gr.4 53N58L (pu= 10pieces)
N.i.	20931504	Ceramic gas nozzle for gas lens L35mm 9-20 / Gr.5 53N59L (pu= 10pieces)
N.i.	20931604	Ceramic gas nozzle for gas lens L35mm 9-20 / Gr.6 53N60L (pu= 10pieces)
N.i.	20931704	Ceramic gas nozzle for gas lens L35mm 9-20 / Gr.7 53N61L (pu= 10pieces)
N.i.	20931804	Ceramic gas nozzle for gas lens L35mm 9-20 / Gr.8 53N61SL (pu= 10pieces)
N.i.	20931406	Ceramic gas nozzle for gas lens L72mm 9-20 / Gr.4 53N58XL (pu= 10pieces)
N.i.	20931506	Ceramic gas nozzle for gas lens L72mm 9-20 / Gr.5 53N59XL (pu= 10pieces)
N.i.	20931606	Ceramic gas nozzle for gas lens L72mm 9-20 / Gr.6 53N60XL (pu= 10pieces)
N.i.	20931706	Ceramic gas nozzle for gas lens L72mm 9-20 / Gr.7 53N61XL (pu= 10pieces)
N.i.	20931806	Ceramic gas nozzle for gas lens L72mm 9-20 / Gr.8 53N61SXL (pu= 10pieces)
90-C	20930016	Ceramic nozzle for gas lens Kir Royal 9-20 / fits tungsten electrode up to 3,2mm
Ceramic gas nozzles in different lengths for equipment line (C) midsize gas lens		
90-M	22093041	Gas nozzle for gas lens L42mm / Gr.4 54N18 (pu= 10pieces)
90-M	22093051	Gas nozzle for gas lens L42mm / Gr.5 54N17 (pu= 10pieces)
90-M	22093061	Gas nozzle for gas lens L42mm / Gr.6 54N16 (pu= 10pieces)
90-M	22093071	Gas nozzle for gas lens L42mm / Gr.7 54N15 (pu= 10pieces)
90-M	22093081	Gas nozzle for gas lens L42mm / Gr.8 54N14 (pu= 10pieces)
90-M	22093111	Gas nozzle for gas lens L42mm / Gr.11 54N19-11 (pu= 10pieces)
90-M	22093121	Gas nozzle for gas lens L42mm / Gr.12 54N19 (pu= 10pieces)
N.i.	22093054	Gas nozzle for gas lens L76mm / Gr.5 54N17L (pu= 10pieces)
N.i.	22093064	Gas nozzle for gas lens L76mm / Gr.6 54N16L (pu= 10pieces)
N.i.	22093074	Gas nozzle for gas lens L76mm / Gr.7 54N15L (pu= 10pieces)
Ceramic gas nozzles Jumbo in different lengths for equipment line (D) Jumbo gas lens		
95	22093066	Jumbo gas nozzle L48mm / Gr.6 57N75 (pu= 10pieces)
95	22093086	Jumbo gas nozzle L48mm / Gr.8 57N74 (pu= 10pieces)
95	22093106	Jumbo gas nozzle L48mm / Gr.10 53N88 (pu= 10pieces)
95	22093126	Jumbo gas nozzle L48mm / Gr.12 53N87 (pu= 10pieces)

## **SR 9**

**Welding-torch TIG gas-cooled with import torch body**

**110A at 60% duty cycle (DC) - 95A at 60% duty cycle (AC)**

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**Art.-No.**

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N.i. 22093067 Jumbo gas nozzle L73mm / Gr.6 57N75L (pu= 10pieces)

N.i. 22093087 Jumbo gas nozzle L73mm / Gr.8 57N74L (pu= 10pieces)

N.i. 22093107 Jumbo gas nozzle L73mm / Gr.10 53N88L (pu= 10pieces)

N.i. 22093127 Jumbo gas nozzle L73mm / Gr.12 53N87L (pu= 10pieces)

**Premium tungsten electrodes of 8 different kinds in the appendix A.**