

# GRASP THE BENEFIT OF VERSATILITY AND MANEUVERABILITY

## PRO-TORCH™ TIG TORCHES



### KEY FEATURES

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

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

**Processes »**  
TIG

**Product Number »**  
See back for details

## KEY FEATURES Continued

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

### Gas Control Valve Models



Manual Gas Valve

### Flexible Head Models



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



### Ultra-Flex Cable Models



## Recommended Accessories

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

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

## Available Torches



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



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



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



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



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



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



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

## What You Need To Get Started

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

### TIG Torch Adapter

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

### Collets

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

### Collet Bodies and Gas Lens Collet Bodies

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

### Alumina Nozzles

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

### Back Cap

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

### Tungsten Electrode

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

### Parts Kits

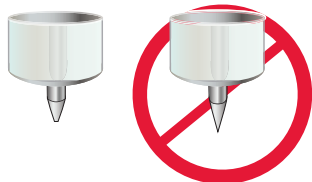
Parts Kits conveniently provide all the torch accessories you need to start welding. Parts Kits provide collets, collet bodies, a back cap, alumina nozzles and tungstens in a variety of sizes, all packaged in an easy to carry reclosable box.

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

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

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

### TUNGSTEN SHAPING



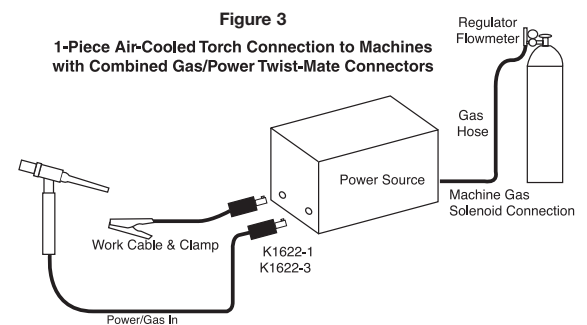
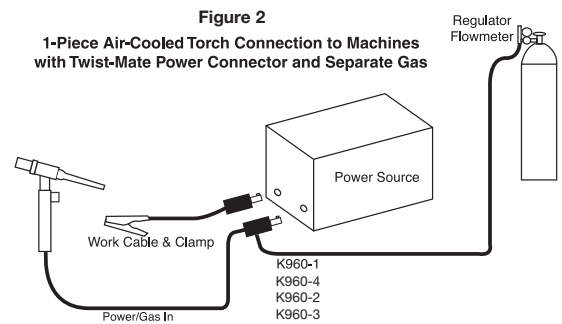
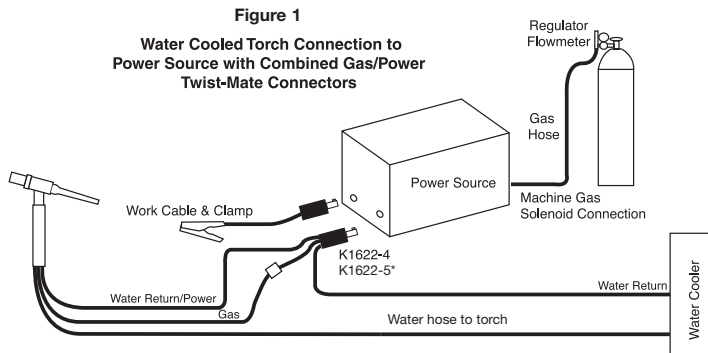
Tungsten should have a slightly blunted tip.

## TIG TORCH CONNECTION ADAPTERS

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

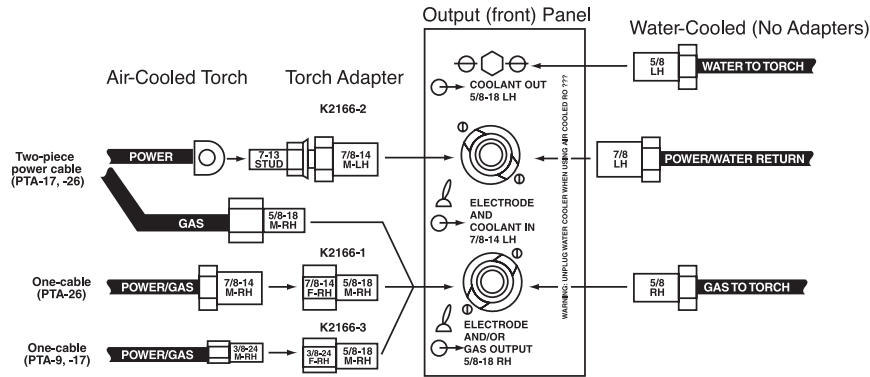
DESCRIPTION	PART NO.	FIGURE
<b>PRECISION TIG 275 &amp; 375 POWER SOURCES</b>		
PTA-9, 9F, 17F, 17V, 17FV one piece cable	K2166-3	4
PTA-17V, -26V two piece cable	K2166-2	4
PTA-26, 26V, 26F, 26FV one piece cable	K2166-1	4
PTW-18, 20 and 20H-320	No adapter required	-
<b>FOR POWER SOURCES WITH 1/2 IN OUTPUT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

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



## TIG TORCH CONNECTION ADAPTERS

Figure 4  
Precision TIG 275 & 375



## PARTS KITS

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

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



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-2B1	13N21	Collet	0.040 [1.0]
1	KP2029-3B1	13N22	Collet	1/16 [1.6]
1	KP2031-2B1	13N26	Collet Body	0.040 [1.0]
1	KP2031-3B1	13N27	Collet Body	1/16 [1.6]
1	KP2017-1B1	13N08	Alumina Nozzle	1/4 [6.0]
1	KP2017-2B1	13N09	Alumina Nozzle	5/16 [8.0]
1	KP2017-3B1	13N10	Alumina Nozzle	3/8 [10.0]
1	Tungsten Electrode, 2% Ceriated 0.040 x 7.0 in [1.0 x 178 mm]			
1	Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in [1.6 x 178 mm]			

### KP508 (For PTA-17 Series Torches)



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2036-2B1	57Y04	Back Cap	Short
1	KP2030-2B1	10N22	Collet	0.040 [1.0]
1	KP2030-3B1	10N23	Collet	1/16 [1.6]
1	KP2030-4B1	10N24	Collet	3/32 [2.4]
1	KP2032-2B1	10N30	Collet Body	.040 [1.0]
1	KP2032-3B1	10N31	Collet Body	1/16 [1.6]
1	KP2032-4B1	10N32	Collet Body	3/32 [2.4]
1	KP2016-6B1	10N50	Alumina Nozzle	1/4 [6.0]
	KP2016-5B1	10N49	Alumina Nozzle	5/16 [8.0]
	KP2016-4B1	10N48	Alumina Nozzle	3/8 [10.0]
1	Tungsten Electrode, 2% Ceriated .040 x 7.0 in [1.0 x 178 mm]			
1	Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in [1.6 x 178 mm]			
1	Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in [2.4 x 178 mm]			

**PARTS KITS**

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



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2036-2B1	57Y04	Back Cap	Short
1	KP2030-3B1	10N23	Collet	1/16 (1.6)
1	KP2030-4B1	10N24	Collet	3/32 (2.4)
1	KP2030-5B1	10N25	Collet	1/8 (3.2)
1	KP2032-3B1	10N31	Collet Body	1/16 (1.6)
1	KP2032-4B1	10N32	Collet Body	3/32 (2.4)
1	KP2032-5B1	10N28	Collet Body	1/8 (3.2)
1	KP2016-5B1	10N49	Alumina Nozzle	5/16 (8.0)
	KP2016-4B1	10N48	Alumina Nozzle	3/8 (10.0)
	KP2016-2B1	10N46	Alumina Nozzle	1/2 (12.5)
1	Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in (1.6 x 178 mm)			
1	Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in (2.4 x 178 mm)			
1	Tungsten Electrode, 2% Ceriated 1/8 x 7.0 in (3.2 x 178 mm)			

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



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-3B1	13N22	Collet	1/16 (1.6)
1	KP2029-4B1	13N23	Collet	3/32 (2.4)
1	KP2029-5B1	13N24	Collet	1/8 (3.2)
1	KP2031-3B1	13N27	Collet Body	1/16 (1.6)
1	KP2031-4B1	13N28	Collet Body	3/32 (2.4)
1	KP2031-5B1	13N29	Collet Body	1/8 (3.2)
1	KP2017-2B1	13N09	Alumina Nozzle	5/16 (8.0)
	KP2017-3B1	13N10	Alumina Nozzle	3/8 (10.0)
	KP2017-4B1	13N11	Alumina Nozzle	1/2 (12.5)
1	Tungsten Electrode, 2% Ceriated 1/16 x 7.0 in (1.6 x 178 mm)			
1	Tungsten Electrode, 2% Ceriated 3/32 x 7.0 in (2.4 x 178 mm)			
1	Tungsten Electrode, 2% Ceriated 1/8 x 7.0 in (3.2 x 178 mm)			

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



Qty	Part No.	Industry Ref. No.	Description	Size in (mm)
1	KP2035-4B1	41V24	Back Cap	Long
1	KP2029-2B1	13N21	Collet	0.040
1	KP2029-3B1	13N22	Collet	1/16 (1.6)
1	KP2029-4B1	13N23	Collet	3/32 (2.4)
1	KP2033-2B1	45V42	Gas Lens Collet Body	0.040
1	KP2033-3B1	45V43	Gas Lens Collet Body	1/16 (1.6)
1	KP2033-4B1	45V44	Gas Lens Collet Body	3/32 (2.4)
1	KP2019-2B1	53N59	Gas Lens Nozzle	#5
	KP2019-3B1	53N60	Gas Lens Nozzle	#6
	KP2019-4B1	53N61	Gas Lens Nozzle	#7
1	Tungsten Electrode, 2% Ceriated 0.040 (1.0 mm)			
1	Tungsten Electrode, 2% Ceriated 1/16 in (1.6 mm)			
1	Tungsten Electrode, 2% Ceriated 3/32 in (2.4 mm)			

Parts shown are not actual size.

**EXPENDABLE PARTS**

**COLLET**



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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP2029-1B1	13N20	0.020 (0.5)
	KP2029-2B1	13N21	0.040 (1.0)
	KP2029-3B1	13N22	1/16 (1.6)
	KP2029-4B1	13N23	3/32 (2.4)
	KP2029-5B1	45V24	1/8 (3.2)

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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet	KP2030-1B1	10N21	0.020 (0.5)
	KP2030-2B1	10N22	0.040 (1.0)
	KP2030-3B1	10N23	1/16 (1.6)
	KP2030-4B1	10N24	3/32 (2.4)
	KP2030-5B1	10N25	1/8 (3.2)
	KP2030-6B1	54N20	5/32 (4.0)

**COLLET BODY**



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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP2031-1B1	13N25	0.020 (0.5)
	KP2031-2B1	13N26	0.040 (1.0)
	KP2031-3B1	13N27	1/16 (1.6)
	KP2031-4B1	13N28	3/32 (2.4)
	KP2031-5B1	13N29	1/8 (3.2)

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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Collet Body	KP2032-1B1	10N29	0.020 (0.5)
	KP2032-2B1	10N30	0.040 (1.0)
	KP2032-3B1	10N31	1/16 (1.6)
	KP2032-4B1	10N32	3/32 (2.4)
	KP2032-5B1	10N28	1/8 (3.2)
	KP2032-6B1	406488	5/32 (4.0)

**ALUMINA NOZZLES**



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

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP2017-1B1	13N08	1/4 (6)	4	1-5/32 in (29.3 mm)
	KP2017-2B1	13N09	5/16 (8)	5	
	KP2017-3B1	13N10	3/8 (10)	6	
	KP2017-4B1	13N11	7/16 (11)	7	
	KP2017-5B1	13N12	1/2 (12.5)	8	
	KP2017-6B1	13N13	5/8 (16)	10	

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

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Nozzle	KP2016-6B1	10N50	1/4 (6)	4	1-5/32 in (29.3 mm)
	KP2016-5B1	10N49	5/16 (8)	5	
	KP2016-4B1	10N48	3/8 (10)	6	
	KP2016-3B1	10N47	7/16 (11)	7	
	KP2016-2B1	10N46	1/2 (12.5)	8	
	KP2016-1B1	10N45	5/8 (16)	10	

Parts shown are not actual size.

## EXPENDABLE PARTS

### GAS LENS COLLET BODIES



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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body	KP2033-1B1	45V41	0.020 (0.5)
	KP2033-2B1	45V42	0.040 (1.0)
	KP2033-3B1	45V43	1/16 (1.6)
	KP2033-4B1	45V44	3/32 (2.4)
	KP2033-5B1	45V45	1/8 (3.2)

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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Gas Lens Collet Body <sup>1</sup>	KP2034-1B1	45V29	0.020 (0.5)
	KP2034-2B1	45V24	0.040 (1.0)
	KP2034-3B1	45V25	1/16 (1.6)
	KP2034-4B1	45V26	3/32 (2.4)
	KP2034-5B1	45V27	1/8 (3.2)
	KP2034-6B1	45V28	5/32 (4.0)

### ALUMINA GAS LENS NOZZLES



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

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle	KP2019-1B1	53N58	1/4 (6)	4	1 in (25.4 mm)
	KP2019-2B1	53N59	5/16 (8)	5	
	KP2019-3B1	53N60	3/8 (10)	6	
	KP2019-4B1	53N61	7/16 (11)	7	

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

Name	Part No.	Industry Ref. No.	Nozzle Orifice Dia. in (mm)	Size (16th of an inch)	Length
Alumina Gas Lens Nozzle <sup>2</sup>	KP2018-5B1	54N18	1/4 (6)	4	1-5/8 in (41.3 mm)
	KP2018-4B1	54N17	5/16 (8)	5	
	KP2018-3B1	54N16	3/8 (10)	6	
	KP2018-2B1	54N15	7/16 (11)	7	
	KP2018-1B1	54N14	1/2 (12.5)	8	
	KP2018-6B1	54N19	11/16 (17)	Short	1-1/8 in (28.5 mm)

### BACK CAPS



(1) Note: Use of these Gas Lens Collet Bodies requires a KP2037-3B1 (54N01) Gas Lens Insulator

(2) Note: Use of these Alumina Gas Lens Nozzles requires a KP2037-3B1 (54N01) Gas Lens Insulator

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

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Back Caps	KP2035-1B1	41V33	Short
	KP2035-2B1	41V35	Medium
	KP2035-4B1	41V24	Long

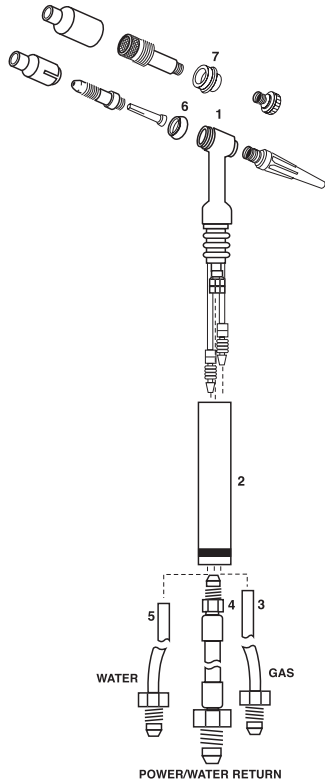
#### FOR PTA-17, PTA-26 & PTW-18 SERIES TORCHES

Name	Part No.	Industry Ref. No.	Tungsten Diameter in (mm)
Back Caps	KP2036-1B1	57Y02	Long
	KP2036-2B1	57Y04	Short

Parts shown are not actual size.

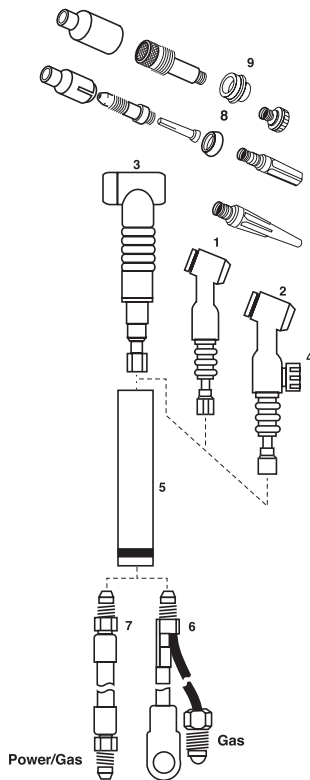


## REPLACEMENT PARTS



### FOR PTW-18 SERIES & PTW-20 SERIES TORCHES

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



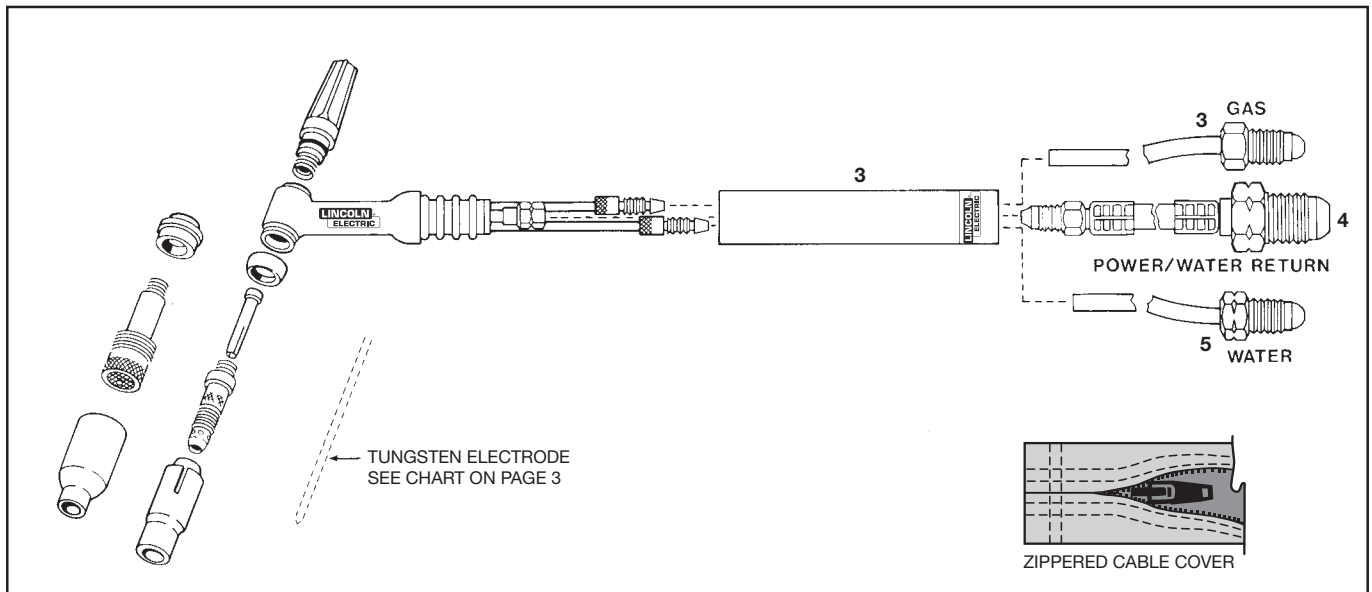
### PTA-9, -17, -26 SERIES AIR-COOLED REPLACEMENT PARTS

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

## REPLACEMENT PARTS

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

Item No.	Part No.	Industry Ref No.	Description ft. (m)
1	S31183-4	-	Torch body, red silicone
2	S31183-5	-	Torch handle, fluted
3	S31183-2	45V10R	Gas hose, 25 (7.6)
4	S31183-1	45V04HR	Power cable, 25 (7.6)
5	S31183-3	45V08HR	Water hose, 25 (7.6)
6	KP2035-2B1	41V35	Medium cap
7	-	18CG	Cup gasket



## RECOMMENDED GENERAL OPTIONS



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



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



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



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



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



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



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

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

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

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

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

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

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

For best welding results with Lincoln Electric<sup>®</sup> equipment, always use Lincoln Electric consumables. Visit [www.lincolnelectric.com](http://www.lincolnelectric.com) for more details.

**CUSTOMER ASSISTANCE POLICY**

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