

TIGWARE TIGWARE TIGWARE TIGWARE TIGWARE TIGWARE TIGWARE TIGWARE

[www.tigware.com.au](http://www.tigware.com.au)

## TIGWARE Ti Units

### Product Information Sheet

TIGWARE Titanium Units Melbourne Australia

Sizes #12 - #16 - #20

TIGWARE'S Triple Diffuser System Compensates for Intermediary Cup sizes

### DC Application.

**Do Not Cross Thread the Adapters**



Aussie Inovation

Material: Titanium / Teflon

## Welding Parameters: DC Use Product

Tungsten Ø = 1.6mm (1/16") / 2.4mm (3/32")

Stick Out: **25mm**. (Greater Stick Out can be Achieved with Higher Gas Flow)

MAX 180 amps rated **None Continuous**

Gas Diffuser = TIGWARE'S Triple Diffuser System

Standard GAS Flow Rates listed below for optimal Product Performance.

**Note: Grind Each end of the TUNGSTEN Rod to a point and remove the Painted section as the Ceramic Insulator is designed to have a Sliding Fit.**

**Any remaining paint will interfere with the Ceramic Insulator during TUNGSTEN insertion and or Removal.**

#### GAS Flow Rates

Size: #12	23CFH / 11 > L / Min
Size: #16	32 CFH / 15 > L / Min
Size: #20	40 CFH / 19 > L / Min

**TIGWARE recommends a 10 second POST-Flow to protect the O-rings and Adapter from excessive HEAT...!**

## Nozzle use and Installation.

It's very important to **REMOVE** the original Torch insulator before installing any TIGWARE Ti Teflon Adapter. Always **EXCHANGE** the Original Teflon Insulator from the Torch head and install any of the TIGWARE products so it's in contact with the BLACK Rubber of the Torch Head.

**Never over Tighten any TIGWARE Products**



#12

Teflon Adapter



#16

Teflon Adapter



#20

Teflon Adapter

**PTO**



Exchange Original Teflon Insulator with TIGWARE's Adapter

Minimum 25mm Tungsten Stick-Out



Remove the Original Teflon Insulator And Thread TIGWARE's Assembly onto the Torch Head.

**WARNING:**  
Should the Tungsten Rod become lodged in the weld pool and unable free it.  
Do Not FLEX the Tungsten Rod in Any way to dislodge it.  
Simply release the Tungsten from the torch and slide the assembly and Ceramic Insulator from the lodged Tungsten. Then free the Tungsten from the work and Re-insert the Tungsten into the Torch.

Always Protect Your TIGWARE Gear

Enjoy your new product and please let me know if you have any problems.

Regards John +61 (0) 448527996 / [info@tigware.com.au](mailto:info@tigware.com.au)

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