



# WORKSTATION ACCESSORIES



# MOBILE WORKSTATION

MOBILE WORKSTATION



Item number

**Your business card:** The mobile orbital workstation

## MOBILE ORBITAL WORKSTATION

- Electrical supply integrated for auxiliary equipment: 5 x 230 V, 10 A (not suitable for the power source!)
- 2 swivel castors, Ø 160 mm, with full lock
- 2 trestle castors, Ø 280 mm
- Pull-out cylinder bracket with fixing chain above the cylinder's centre of gravity
- High-quality powder-coated finish
- Sturdy stainless steel work top, tilted
- Platform for oxygen analyser
- Fixing for bench vice with 'V' block
- Holder for open weld head
- Holder for manual hose package
- Storage space for inverter, cooling unit, etc.

1.2.0128



Dimensions (excluding mounted brackets):

(L x W x H): 1,110 x 710 x 850 mm

Weight: unloaded approx. 70 kg



## MOBILE ORBITAL WORKSTATION WITHOUT CYLINDER RACK

1.2.0146



## HOLDERS FOR MOBILE WORKSTATIONS

- OSK C, CS AND CW HOLDER FOR MOBILE WORKSTATIONS
- OSK S, SW AND G HOLDER FOR MOBILE WORKSTATIONS

1.0.5504

1.0.5503



## HOLDER FOR WORK BENCH

- OSK 13 S HOLDER FOR WORK BENCH
- OSK C, CS AND CW HOLDER FOR WORK BENCH
- OSK S, SW AND G HOLDER FOR WORK BENCH

1.3.4002

1.0.5502

1.0.5501



Item number



### BENCH VICE, NICKEL-PLATED

Parallel bench vice, size 100, suitable for use in clean rooms

1.2.0132

### 'V' BLOCKS

For securing tubes when tacking before welding  
 • Surface-treated aluminium

Orbital  
welding systems

Welding  
tools

### 'V' BLOCKS FOR MINI FITTINGS

'V' BLOCK for mini fittings

OD 6 – 6.35 mm | 0.236" – 0.250"

1.2.0141

'V' BLOCK for mini fittings

OD 8 – 10 mm | 0.315" – 0.394"

1.2.0142

'V' BLOCK for mini fittings

OD 12 – 13.5 mm | 0.472" – 0.531"

1.2.0143

Welding  
accessories

Joint  
preparation

### 'V' BLOCKS FOR LARGER TUBE Ø

'V' BLOCK OD 5 – 30 mm

| 0.197" – 1.181"

1.2.0129

'V' BLOCK OD 10 – 65 mm

| 0.394" – 2.559"

1.2.0130

'V' BLOCK OD 20 – 115 mm

| 0.787" – 4.528"

1.2.0131

### SMALL TOOL KIT

Package includes:  
 • NINE-piece Allen key set  
 • Feeler gauge, 21 blade  
 • Tweezers  
 • Slotted screwdriver  
 • Case

1.2.0133

Purging  
accessories

### OSK 13 S SMALL TOOL KIT

Package includes:  
 • SIX-piece Allen key set  
 • Feeler gauge, 13 blade  
 • Tweezers  
 • Various screwdrivers  
 • Case

1.3.0133

Measuring  
devices

### TELESCOPE MIRROR SET (24 MM, 30 MM, 40 MM)

incl. inspection lamp and case

1.1.4132

Service/  
general

# TUNGSTEN ELECTRODES



## TABLE OF LENGTHS

Item number

SuperArc: Precision-machined disposable tungsten electrodes for reproducible orbital welding. **Cut your costs, because each new manual sharpening operation costs time and money.** Standard quality WC 20 to DIN EN ISO 6848.

Finished dimensions for all ORBITEC weld heads as a function of the tube outer diameter.

Ø	Length	Ø Tip surface	Polished section
1.0 mm	All lengths available	0.1 mm	30°
1.6 mm	All lengths available	0.2 mm	18°
2.4 mm	All lengths available	0.4 mm	30°



SuperArc tungsten electrode Ø 1.0 mm  
 SuperArc tungsten electrode Ø 1.6 mm  
 SuperArc tungsten electrode Ø 2.4 mm

**1.2.0202 + length**  
**1.2.0200 + length**  
**1.2.0201 + length**

Weld head		OSK 13 S*	OSK 21 CS/CW	OSK 38 CS/CW	OSK 53 S/SW	OSK 53 G/GW	OSK 76 S/SW	OSK 115 S/SW	OSK 170 GW									
Tube Ø		Electrode length																
mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	
3.17	0.125	14	0.551	26	1.024	40	1.575											
6.00	0.236	12	0.472	25	0.984	39	1.535	48	1.889	54	2.126	64	2.520					
6.35	0.250	12	0.472	25	0.984	39	1.535	47	1.850	53	2.087	63	2.480					
8.00	0.315	11	0.433	24	0.945	38	1.496	47	1.850	53	2.087	63	2.480					
9.53	0.375	10	0.394	23	0.906	37	1.457	46	1.811	52	2.047	62	2.441	82	3.228			
10.00	0.394	10	0.394	23	0.906	37	1.457	46	1.811	52	2.047	62	2.441	82	3.228			
10.20	0.402	10	0.394	22	0.866	36	1.417	46	1.811	51	2.008	61	2.402	81	3.189			
12.00	0.472	9	0.354	22	0.866	36	1.417	45	1.771	51	2.008	61	2.402	81	3.189			
12.70	0.500	9	0.354	21	0.827	35	1.378	44	1.732	50	1.969	60	2.362	80	3.150			
13.00	0.512			21	0.827	35	1.378	44	1.732	50	1.969	60	2.362	80	3.150			
13.50	0.531			21	0.827	35	1.378	44	1.732	50	1.969	60	2.362	80	3.150			
15.88	0.625			20	0.787	34	1.339	43	1.692	49	1.929	59	2.323	79	3.110			
16.00	0.630			20	0.787	34	1.339	43	1.692	49	1.929	59	2.323	79	3.110			
17.20	0.677			19	0.748	33	1.299	42	1.653	48	1.889	58	2.283	78	3.071			
18.00	0.709			18	0.709	32	1.260	41	1.614	47	1.850	57	2.244	77	3.031			
19.00	0.748			17	0.669	31	1.220	40	1.574	46	1.811	56	2.205	76	2.992			
19.05	0.750			17	0.669	31	1.220	40	1.574	46	1.811	56	2.205	76	2.992			
20.00	0.787			17	0.669	31	1.220	39	1.535	46	1.811	56	2.205	76	2.992			
21.30	0.839			16	0.630	30	1.181	39	1.535	45	1.771	55	2.165	75	2.953			
22.00	0.866					30	1.181	39	1.535	45	1.771	55	2.165	75	2.953			
23.00	0.906					29	1.142	38	1.496	44	1.732	54	2.126	74	2.913			
25.40	1.000					28	1.102	37	1.456	43	1.692	53	2.087	73	2.874			
26.90	1.059					27	1.063	36	1.417	42	1.653	52	2.047	72	2.835			
28.00	1.102					27	1.063	36	1.417	42	1.653	52	2.047	72	2.835			
29.00	1.142					26	1.024	35	1.377	41	1.614	51	2.008	71	2.795			
30.00	1.181					26	1.024	35	1.377	41	1.614	51	2.008	71	2.795			
33.70	1.327					24	0.945	33	1.299	39	1.535	49	1.929	69	2.717			
35.00	1.378					23	0.906	32	1.259	38	1.496	48	1.890	68	2.677			
38.10	1.500					21	0.827	31	1.220	36	1.417	46	1.811	66	2.598			
40.00	1.575							30	1.181	36	1.417	46	1.811	66	2.598			
41.00	1.614							29	1.141	35	1.378	45	1.772	65	2.559			
42.40	1.669							28	1.102	34	1.339	44	1.732	64	2.520			
44.50	1.752							27	1.062	33	1.299	43	1.693	63	2.480			
48.30	1.902							25	0.984	31	1.220	41	1.614	61	2.402			
50.80	2.000							24	0.944	30	1.181	40	1.575	60	2.362	90	3.543	
51.00	2.008							24	0.944	30	1.181	40	1.575	60	2.362	90	3.543	
52.00	2.047							24	0.944	30	1.181	40	1.575	60	2.362	90	3.543	
53.00	2.087							23	0.905	29	1.142	39	1.535	59	2.323	89	3.504	
54.00	2.126											39	1.535	59	2.323	89	3.504	
60.30	2.374											35	1.378	55	2.165	85	3.346	
63.50	2.500											34	1.339	54	2.126	84	3.307	
70.00	2.756											31	1.220	51	2.008	81	3.189	
76.10	2.996											27	1.063	47	1.850	78	3.071	
76.20	3.000											27	1.063	47	1.850	78	3.071	
85.00	3.346													43	1.693	74	2.913	
88.90	3.500													41	1.614	71	2.795	
101.60	4.000													35	1.378	65	2.559	
104.00	4.094													34	1.339	64	2.520	
108.00	4.252													32	1.260	64	2.520	
114.30	4.500													28	1.102	58	2.283	
127.00	5.000															53	2.087	
129.00	5.079															52	2.047	
141.30	5.563															46	2.811	
152.40	6.000															40	1.575	
154.00	6.063															39	1.535	
168.28	6.625															32	1.260	

### Electrode lengths for:

OSW 40 open weld head:	20 – 35 mm		0.787" – 1.378"
OSW 80 – 275 open weld heads:	35 – 50 mm		1.378" – 1.968"
RBK tube-to-tubesheet weld heads:	35 – 46 mm		1.378" – 1.811"

\* Only electrodes measuring 1.0 mm in diameter must be used for the OSK 13 S. Special lengths available on request.

Portable tungsten grinders for precise and swift machining of tungsten electrodes for TIG orbital and manual welding.

- Quick and easy to use
- High precision and thus reproducibility
- Longitudinal grinding
- A tip surface can be attached to the electrode



### TUNGSTEN GRINDERS S-TGS\_C AND S-TGS\_CL

- Fixed grinding angle
- Sharpen without collet
- Separate the electrode
- Optionally battery-powered or 230 V device
- Grinding wheel can be used on both sides
- Very light and easy to handle



Technical data	S-TGS_C (230 V)	S-TGS_CL (battery)
Output:	170 W	
Mains connection:	220-240 V / 50-60 Hz	10,8 V / 1500 mA
Speed:	Variable from 8,000 to 35,000 rpm	Variable from 8,000 to 35,000 rpm
Grinding angel:	15°, 18°, 22,5° and 30°	15°, 18°, 22,5° and 30°
Electrode diameter:	1.0 mm, 1.6 mm, 2.0 mm, 2.4 mm, 3.2 mm	1.0 mm, 1.6 mm, 2.0 mm, 2.4 mm, 3.2 mm
Diamont grinding wheel:	Ø 38 mm	Ø 38 mm
Weight:	0.79 kg	0.48 kg
<b>Item number</b>	<b>1.1.0215</b>	<b>1.1.0219</b>

#### Package includes:

- Tungsten grinder
- Diamond grinding wheel
- T-key, 3 mm hexagon socket
- Transport case
- Charging cable (only for battery-powered device)



#### DIAMOND GRINDING WHEEL S-TGS MEDIUM GRIT

Can be used on both sides

1.1.0216

Orbital  
welding systems

Welding  
tools

Welding  
accessories

Joint  
preparation

Purging  
accessories

Measuring  
devices

Service /  
general





### WAG 40.1 TUNGSTEN GRINDER, 230 V

Portable tungsten grinder for precise and swift machining of tungsten electrodes for TIG orbital and manual welding.

- Quick and easy to use
- High precision and thus reproducibility
- Inspection window for controlled grinding
- Longitudinal grinding
- Grinding angle can be steplessly adjusted
- Grinding disc can be used three ways due to adjustment
- A tip surface can be attached to the electrode
- Fine dust filtering
- Even short electrodes measuring 15 mm and less can be sharpened
- Base or wall bracket available as an option

1.2.6000



#### Technical data:

Output:	850 W
Mains connection:	230 V / 50 – 60 Hz
Speed:	Variable from 8,000 to 22,000 rpm
Sound pressure:	88.8 dB(A)
Vibration level:	5 m/s <sup>2</sup>
Electrode diameter:	1.0 to 4.0 mm
Filter cassette:	Disposable filter
Diamond grinding wheel:	Ø 40 mm
Weight:	2.8 kg

#### Package includes:

- Tungsten grinder
- Collet holder
- Collet for an electrode Ø of 1.6 mm, 2.4 mm and 3.2 mm
- Tool set
- Transport case



### WAG 40.1 TUNGSTEN GRINDER, 110 V

1.2.6001



**COLLET FOR TUNGSTEN GRINDER Ø 1.6 mm**

1.2.6002

**COLLET FOR TUNGSTEN GRINDER Ø 2.4 mm**

1.2.6003

**COLLET FOR TUNGSTEN GRINDER Ø 3.2 mm**

1.2.6004

Collets for Ø of 1.0 mm, 2.0 mm, 3.0 mm and 4.0 mm available on request.



### DIAMOND GRINDING WHEEL

1.2.6005



### FILTER CASSETTE

1.2.6006



### INSPECTION WINDOW

1.2.6007

Base or wall bracket for tungsten grinder available on request.

Item number



### TORCH CAPS

**OSW 40 TORCH CAP** for water-cooled burner and glass gas nozzle on OSW  
**OSW TORCH CAP**  
**TURN TORCH CAP**  
**MANUAL TORCH CAP**

**1.0.1615S**  
**1.3.1147**  
**1.2.1817**  
**1.3.1910**

Orbital  
welding systems



### CLAMP SLEEVES

**OSW 40 CLAMP SLEEVE** for torch, gas-cooled, Ø 1.6 mm, length 16 mm  
**OSW 40 CLAMP SLEEVE** for torch, gas-cooled, Ø 2.4 mm, length 16 mm  
**OSW 40 CLAMP SLEEVE** for torch, water-cooled, Ø 1.6 mm, length 17 mm  
**OSW 40 CLAMP SLEEVE** for torch, water-cooled, Ø 2.4 mm, length 17 mm  
**OSW 80 – 275 CLAMP SLEEVE**, manual torch, Ø 1.6 mm  
**OSW 80 – 275 CLAMP SLEEVE**, manual torch Ø 2.4 mm  
**CLAMP SLEEVE, TURN**, Ø 1.6 mm  
**CLAMP SLEEVE, TURN**, Ø 2.4 mm  
**CLAMP SLEEVE, RBK 60 S**, Ø 2.4 mm  
**CLAMP SLEEVE, RBK 60 S**, Ø 3.2 mm

**1.0.1616**  
**1.0.1623**  
**1.0.1640**  
**1.0.1641**  
**1.0.1626**  
**1.0.1627**  
**1.2.1818**  
**1.2.1819**  
**1.3.3076**  
**1.3.3089**

Welding  
tools



### TEFLON INSULATORS

**OSW 40 TEFLON INSULATOR**  
**OSW 80 – 275 TEFLON INSULATOR**  
**TEFLON INSULATOR** for glass gas nozzle  
**TURN TEFLON INSULATOR**, manual torch  
**RBK 60 S TEFLON INSULATOR**

**1.0.1618**  
**1.0.1629**  
**1.0.1051**  
**1.2.1820**  
**1.3.3078**

Welding  
accessories

Joint  
preparation



### GAS LENSES

**OSW 40 GAS LENS**, Ø 1.6 mm  
**OSW 40 GAS LENS**, Ø 2.4 mm  
**OSW 80 – 275 GAS LENS, TURN**, manual torch, Ø 1.6 mm  
**OSW 80 – 275 GAS LENS, TURN**, manual torch, Ø 2.4 mm  
**GAS LENS** for glass gas nozzle OSW 80-275, TURN, Ø 2.4 mm  
**RBK 60 S GAS LENS**, Ø 2.4 mm  
**RBK 60 S GAS LENS**, Ø 3.2 mm

**1.0.1620**  
**1.0.1624**  
**1.0.1631**  
**1.0.1632**  
**1.3.1049**  
**1.3.3079**  
**1.3.3096**

Purging  
accessories



**GAS LENS HOLDER** for glass gas nozzle

**1.0.1050**

Measuring  
devices



### CERAMIC NOZZLES

**CERAMIC NOZZLES** OSW 40  
**CERAMIC NOZZLES** OSW 80 - 275, TURN, size 8  
**CERAMIC NOZZLES** RBK 60 S, size 7  
**CERAMIC NOZZLES** manuel torch, size 6

**1.3.1046**  
**1.3.1146**  
**1.3.3077**  
**1.3.1911**

Service/  
general



**GLASS GAS NOZZLES** OSW 80-275, TURN

**1.3.1048**



Item number



### IGNITION AIDS

**IGNITION AID, TURN, Ø 15 mm, length 150 mm**

**RBK 60 S IGNITION AID, TURN, Ø 16 mm, length 180 mm**

**RBK 60 S IGNITION AID, TURN, Ø 24 mm, length 160 mm**

**1.2.1803**

**1.3.3088**

**1.3.3073**



### OSW TORCH CONSUMABLES BOXES

**CONSUMABLES BOX** with torch original equipment for OSW 40, Ø 1.6 mm

**CONSUMABLES BOX** with torch original equipment for OSW 40, Ø 2.4 mm

**CONSUMABLES BOX** with torch original equipment for OSW 80 – 275, Ø 1.6 mm

**CONSUMABLES BOX** with torch original equipment for OSW 80 – 275, Ø 2.4 mm

**1.3.1623**

**1.3.1624**

**1.3.1621**

**1.3.1622**



### CONSUMABLES BOXES GLASS-GAS NOZZLE

- 1 torch cap
- 1 clamping sleeve
- 1 Teflon insulator
- 1 gas lens
- 1 gas lens holder
- 1 glass gas nozzle

**1.0.1052**



### RBK 60 S TORCH CONSUMABLES BOXES

**CONSUMABLES BOX** with torch original equipment, Ø 2.4 mm

**CONSUMABLES BOX** with torch original equipment, Ø 3.2 mm

**1.3.1641**

**1.3.1642**



### PACKAGE INCLUDES:

- 1 torch cap (for OSW only)
- 1 clamp sleeve
- 1 Teflon insulator
- 1 gas lens
- 1 ceramic nozzle