

ALPHA FLUX FCAW Welding torches gas cooled



ABICOR BINZEL For Outdoor- Professionals

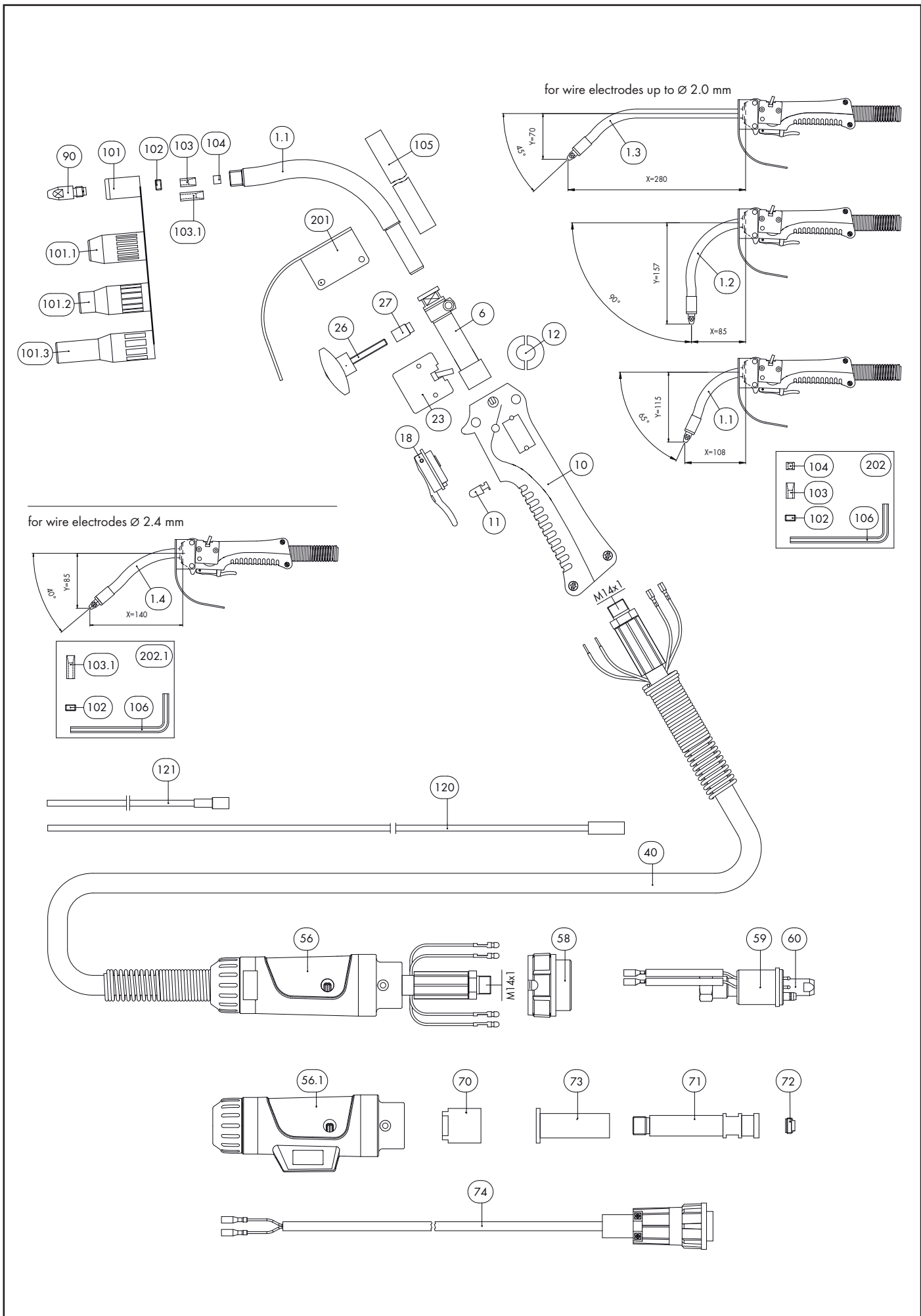
ALPHA FLUX – the new generation of Flux-Cored Self Shielding Welding Torches – suitable for extreme applications in pipeline construction, cladding and rail joint welding as well as at repair work. Equipped with quick-change torch neck, fixable at all angles as well as with the heavy duty highly flexible coaxial cable BIKOX® R for applications up to -30°C , the ALPHA FLUX offers optimal handling.

- Quick-change torch neck, fixable at all angles.
- Silver-plated contact tips – low spatter adhesion.
- Optional additional switch for adjustment of welding current.
- Highly flexible coaxial cable BIKOX R for applications up to -30°C .
- Changeable liner.
- Torch protection caps for different wire sizes.

Technical Data (IEC EN 60 974-7):

Rating: 330 A with self shielding Flux-Cored Wire
60% ED
Wire-Ø: 1.2 - 2.4





Build group	Pos.	Description	Specifications	Part no.
Torch		ALPHA FLUX 350 KZ-2	3.00 m Standard	013.D160
		ALPHA FLUX 350 KZ-2	4.50 m Standard	013.D161
		ALPHA FLUX 350 LN	3.00 m Standard ¹⁾	013.D152
		ALPHA FLUX 350 LN	4.50 m Standard ¹⁾	013.D153
		ALPHA FLUX 350 KZ-2	3.00 m with welding current switch ²⁾	013.D158
		ALPHA FLUX 350 KZ-2	4.50 m with welding current switch ²⁾	013.D159
		ALPHA FLUX 350 LN	3.00 m with welding current switch ^{1) 2)}	013.D164
		ALPHA FLUX 350 LN	4.50 m with welding current switch ^{1) 2)}	013.D165
Swan neck	1.1	Swan neck ALPHA FLUX 350	M8 65° X = 108 Y = 115 ³⁾	013.D144 •
	no pict.	Swan neck ALPHA FLUX 350	5/16" 65° X = 108 Y = 115 ³⁾	013.D162
	1.2	Swan neck ALPHA FLUX 350	M8 90° X = 85 Y = 157 ³⁾	013.D136
	no pict.	Swan neck ALPHA FLUX 350	5/16" 90° X = 85 Y = 157 ³⁾	013.D140
	1.3	Swan neck ALPHA FLUX 350	M8 45° X = 280 Y = 70 ³⁾	013.D169
	1.4	Swan neck ALPHA FLUX 350	M8 40° X = 140 Y = 85	Wire Ø 2.4 ⁴⁾ 013.D210.1
	no pict.	Swan neck ALPHA FLUX 350	5/16" 40° X = 140 Y = 85	Wire Ø 2.4 ⁴⁾ 013.D212.1
	Handle	6	Torch body M14x1 FLUX	
10		Handle FLUX cpl.		180.D051
		Handle FLUX cpl. for welding current switch		180.D052
11		Trigger guard with stopper		400.D252
12		Cover disc Ø 16 mm, seperated	VE 2	013.D199
18		Trigger switch long		185.D065
o.Abb.		Trigger switch short		185.D074
23		Switch assembly (switch)		185.D085
26		Wing screw M5x31 mm cpl.		013.D166
27		Sleeve, insulated		013.D167
Cable assembly KZ-2	40	BIKOX RF 35 4-wire 3.00 m		160.D806
		BIKOX RF 35 4-wire 4.50 m		160.D808
	56	Connector housing, small		501.D508
	56.1	Connector housing, small for trigger wire for welding current switch		501.D507
	58	Connector nut M33x2		500.0213
	59	Central plug KZ-2 M14x1		501.D342
	60	Fixing bush M14x1 cap nut		501.0129
Cable assembly LN	40	BIKOX RF 35 4-wire 3.00 m		160.D806
		BIKOX RF 35 4-wire 4.50 m		160.D808
	56.1	Connector housing, small for trigger wire for welding current switch		501.D501
	70	Uni-Plug M14x1		501.D347
	71	Intermediate connector LN		501.9241
	72	Clamp screw LN		331.9002
	73	Insulating tube LN		501.9192
	74	Trigger wire LN cpl.		501.D556.1
	Other trigger wire adaptors on request			
Wear parts	90	Contact tip M8; Ø 1.2 (10x30) CuCrZr silver plated	VE 10	147.0445
		Contact tip M8; Ø 1.4 (10x30) CuCrZr silver plated	VE 10	147.0536
		Contact tip M8; Ø 1.6 (10x30) CuCrZr silver plated	VE 10	147.0590
		Contact tip M8; Ø 2.0 (10x30) CuCrZr silver plated	VE 10	147.0656 •
		Contact tip M8; Ø 2.4 (10x30) CuCrZr silver plated	VE 10	147.0679
	101	Insulator 1 ALPHA FLUX		013.D132
	101.1	Torch protection cap, gas nozzle recess 2 mm		145.D359
	101.2	Torch protection cap, gas nozzle recess 13 mm		145.D362
	101.3	Torch protection cap, gas nozzle recess 34 mm		145.D365

Build group	Pos.	Description	Specifications	Part no.
Wear parts	102	Threaded pin M8; 4 mm	VE 5	013.D139•
		Threaded pin 5/16", 4 mm	VE 5	013.D141
	103	Sleeve Ø 3.5 mm, L = 12 mm, for wire electrodes up to Ø 2.0	VE 5	013.D138
	103.1	Sleeve Ø 3.5 mm, L = 18 mm, for wire electrodes up to Ø 2.4	VE 5	013.D211.5
	104	Ceramic sleeve Ø 3.5 mm, for wire electrodes up to Ø 2.0	VE 5	013.D137
	105	Insulating tube 141 mm for 60° and for 40°		013.D146•
		Insulating tube 178 mm for 90°		013.D128
		Insulating tube 274 mm for 45°		013.D171
	120	Cable liner 2.8x6.3 for wire electrodes up to Ø 2.0 for 3.00 m		122.D106•
		Cable liner 2.8x6.3 for wire electrodes up to Ø 2.0 for 4.50 m		122.D107
		Cable liner 3.5x7.0 for wire electrodes Ø 2.4 for 3.00 m		122.D114
		Cable liner 3.5x7.0 for wire electrodes Ø 2.4 for 4.50 m		122.D115
	121	Neck liner 3.0 for Pos. 1.1 and 1.2 for wire electrodes up to Ø 2.0		122.D116
		Neck liner 3.0 for Pos. 1.3 for wire electrodes up to Ø 2.0		122.D112
		Neck liner 3.4 for Pos. 1.4 for wire electrodes Ø 2.4		122.D111
		Wear parts-Set:		
	202	consisting of: Pos. 102 (1x), 103 (1x), 104 (5x), 106 - hexagon spanner SW4 (1x) for M8, wire electrodes up to Ø 2.0		013.D201
	for 5/16", wire electrodes up to Ø 2.0		013.D205	
202.1	consisting of: Pos. 102 (1x), 103.1 (1x), 106 - hexagon spanner SW4 (1x) for M8, wire electrodes Ø 2.4		013.D213.1	
	for 5/16", wire electrodes Ø 2.4		013.D214.1	
Miscellaneous	201	Hand shield for ALPHA FLUX		400.D386.1

- standard equipment

¹⁾ LN = applicable for wire feeding devices LINCOLN®

²⁾ Control lead without plug for additional switch

³⁾ Contains Pos. 102, 103, 104 and 105

⁴⁾ Contains Pos. 102, 103.1, and 105

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On request:

- Other rear connectors
- Other geometries of swannecks
- Trigger wire plugs for additional switches
- Wire conducting tip for welding in narrow gaps:
 - M8 or 5/16"
 - Length: 90 mm and 180 mm
 - Entire length insulated



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