


TIGZONE®
TORCHES

TIGZONE SERIES

AUTOMATION

Air and watercooled TIG-Torches

The TIGZONE Automation series combines maximum performance and great flexibility in automated TIG welding. Welders can choose between different sizes even for hard-to-reach components - at amperages from 150 to 500 amps.

- Tungsten changeover by using the front or back
- A and B models available
- Available for all standard welding machines
- Super-Flex cables and Super-Soft leather remains flexible and ease to handle with a significant cable lifetime
- CE EN 60 974-7



Torch (model)	A DC (EN 60974-7)	A AC (EN 60974-7)	WØ (in mm)	Page
AE-23	150	120	1.0 - 3.2	2
AE-27	350	280	1.6 - 6.4	*

* model available on request



Torch (model)	A DC (EN 60974-7)	A AC (EN 60974-7)	WØ (in mm)	Page
AQ-22	250	180	1.0 - 3.2	5
AQ-27	500	350	1.6 - 6.4	8

AUTOMATION SERIES

AE-23

TIGZONE®
TORCHES



60
%DC



WØ
1,0
—
3,2
mm

150
A DC
—
120
A AC

TIGZONE AE-23 – aircooled TIG-Torch

The Torch

Tungsten changeover by using the front or back tungsten loading areas

The Cable

Super-Flex® cables and Super-Soft® leather remains flexible and ease to handle with a significant cable lifetime

The End-Connector

Available for all standard welding machines

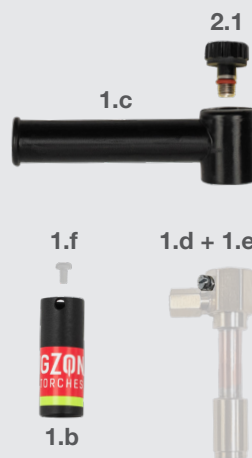
Variants

A and B Model size

DIN Norm

CE EN 60 974-7

TIGZONE AE-23 – Torch / Back End Consumables



Torch Front Group

1	Torch Body incl. insulator (10) and backcap	
.1	AE-23A	AE23A
.2	AE-23B	AE23B
.a	Barrel long 7"	22-8A
.b	Barrel short 3"	22-8B
.c	Insulating Boot	22-9
.d	Screw	27-10
.e	Washer	27-11
.f	Screw Nylon	18R-1

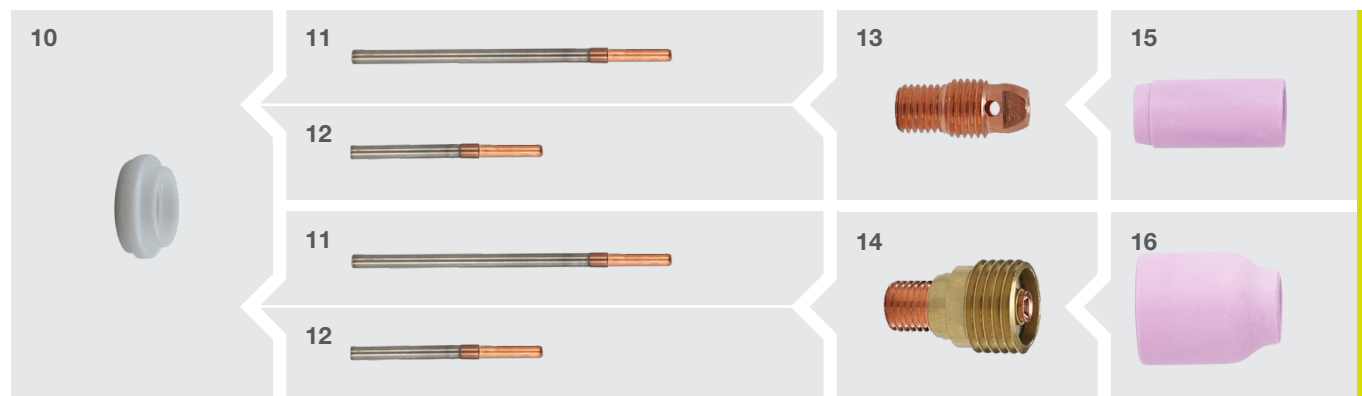
2	Backcap	
.1	standard	22-7

Cable Group

4	Cable cover leather	TZ-1022R-TIG
5	Cable cover 22x1.5mm	RS-22
6	Power Cable	
	4m	57Y01R-*
	4m SF	57Y01R-SF-*
	8m	57Y03R-*
	8m SF	57Y03R-SF-*

* Please specify machine connections e.g. 1/4, 3/8 etc.

TIGZONE AE-23 – Front End Consumables



Size	10 Insulator (std.)	11 Collet	12 Collet Wedge	13 Collet Body	14 Gas Lens
Ø .020" (0.5 mm)		-	-	-	-
Ø .040 " (1.0 mm)		22N21A	22N21B	13N26	45V42
Ø 1/16" (1.6 mm)	22-10	22N22A	22N22B	13N27	45V43
Ø 3/32" (2.4 mm)		22N23A	22N23B	13N28	45V44
Ø 1/8" (3.2 mm)		22N24A	22N24B	13N29	45V45

i Cup Sizes

Have a look at the different sizes of the same cup.



Size	15 Cup (29,35 mm)	15 Super Cup (Sil.Nitride)	15 Cup L (48 mm)	15 Cup XL (63 mm)	16 Cup (25.40 mm)	16 Super Cup (Sil.Nitride)	16 Cup L (35 mm)	16 Cup XL (72 mm)
#3 Ø 4.75 mm	-	-	A796F70	A796F74	-	-	-	-
#4 Ø 6.35 mm	13N08	13N08SC	A796F71	A796F75	53N58	53N58SC	53N58L	53N58XL
#5 Ø 7.93 mm	13N09	13N09SC	A796F72	A796F76	53N59	53N59SC	53N59L	53N59XL
#6 Ø 9.52 mm	13N10	13N10SC	A796F73	A796F77	53N60	53N60SC	53N60L	53N60XL
#7 Ø 11.11 mm	13N11	13N11SC	-	-	53N61	53N61SC	53N61L	53N61XL
#8 Ø 12.70 mm	13N12	13N12SC	-	-	53N61S	53N61SSC	53N61SL	-
#10 Ø 15.87 mm	13N13	13N13SC	-	-	53N61S-10	-	-	-

i Parts

These parts come in different **materials**, **variants** and **sizes**.

For additional information see above.

i TIGZONE eVo - FLO

For greater gas coverage you can use our eVo FLO gas nozzle.

Fits on Gas Lens (14).



AUTOMATION SERIES

AQ-22

TIGZONE®

TORCHES



100
%DC



WØ
1,0
–
3,2
mm

250
A DC
180
A AC

TIGZONE AQ-22 – watercooled TIG-Torch

The Torch

Tungsten changeover by using the front or back tungsten loading areas

The Cable

Super-Flex® cables and Super-Soft® leather remains flexible and ease to handle with a significant cable lifetime

The End-Connector

Available for all standard welding machines

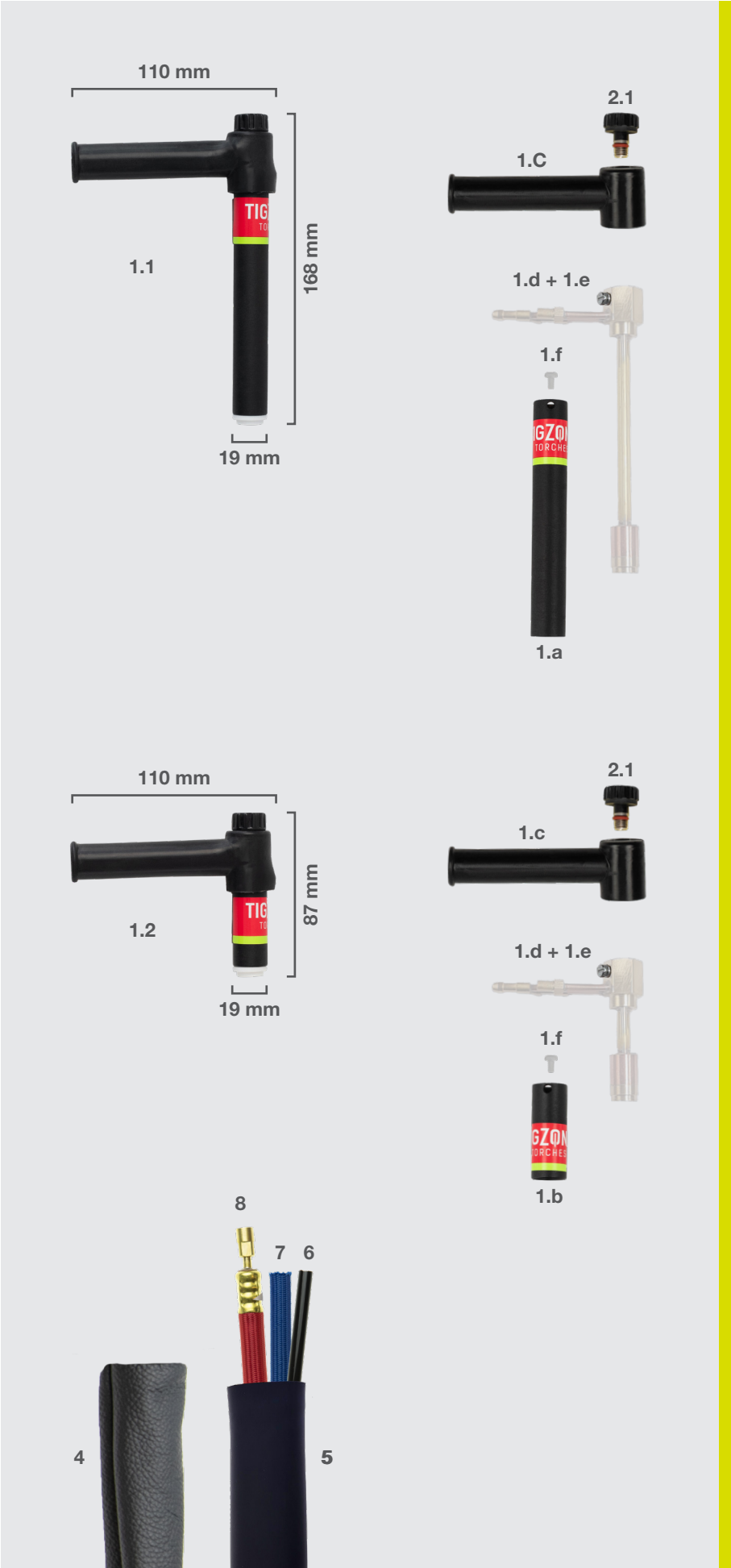
Variants

A and B Model size

DIN Norm

CE EN 60 974-7

TIGZONE AQ-22 – Torch / Back End Consumables



Torch Front Group

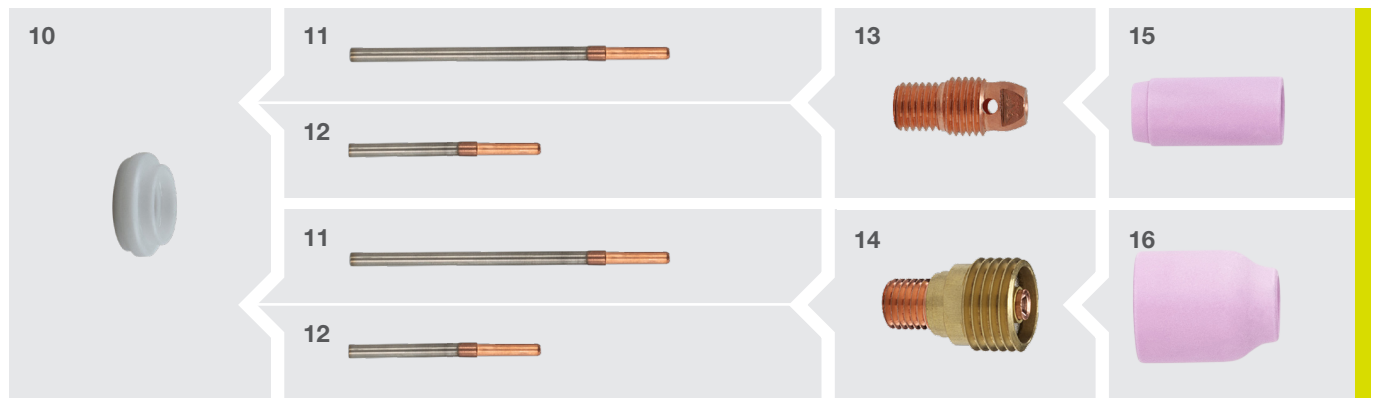
1	Torch Body incl. insulator (10) and backcap	
.1	AQ-22A	AQ22A
.2	AQ-22B	AQ22B
.a	Barrel long	7" 22-8A
.b	Barrel short	3" 22-8B
.c	Insulating Boot	22-9
.d	Screw	27-10
.e	Washer	27-11
.f	Screw Nylon	18R-1

Cable Group

4	Cable cover leather	TZ-1022R-TIG
5	Cable cover 25x1.5mm	RS-25
6	Gas Hose	
	4m	45V09R-*
	4m SF	45V09R-SF-*
	8m	45V10R-*
	8m SF	45V10R-SF-*
7	Water Hose	
	4m	45V07R-*
	4m SF	45V07R-SF-*
	8m	45V08R-*
	8m SF	45V08R-SF-*
8	Power Cable	
	4m	G45V03-*
	4m SF	G45V03-SF-*
	8m	G45V04-*
	8m SF	G45V04-SF-*

* Please specify machine connections e.g. 1/4, 3/8 etc.

TIGZONE AQ-22 – Front End Consumables



Size	10 Insulator (std.)	11 Collet	12 Collet Wedge	13 Collet Body	14 Gas Lens
Ø .020" (0.5 mm)		-	-	-	-
Ø .040 " (1.0 mm)		22N21A	22N21B	13N26	45V42
Ø 1/16" (1.6 mm)	22-10	22N22A	22N22B	13N27	45V43
Ø 3/32" (2.4 mm)		22N23A	22N23B	13N28	45V44
Ø 1/8" (3.2 mm)		22N24A	22N24B	13N29	45V45

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Size	15 Cup (29,35 mm)	15 Super Cup (Sil.Nitride)	15 Cup L (48 mm)	15 Cup XL (63 mm)	16 Cup (25.40 mm)	16 Super Cup (Sil.Nitride)	16 Cup L (35 mm)	16 Cup XL (72 mm)
#3 Ø 4.75 mm	-	-	A796F70	A796F74	-	-	-	-
#4 Ø 6.35 mm	13N08	13N08SC	A796F71	A796F75	53N58	53N58SC	53N58L	53N58XL
#5 Ø 7.93 mm	13N09	13N09SC	A796F72	A796F76	53N59	53N59SC	53N59L	53N59XL
#6 Ø 9.52 mm	13N10	13N10SC	A796F73	A796F77	53N60	53N60SC	53N60L	53N60XL
#7 Ø 11.11 mm	13N11	13N11SC	-	-	53N61	53N61SC	53N61L	53N61XL
#8 Ø 12.70 mm	13N12	13N12SC	-	-	53N61S	53N61SSC	53N61SL	-
#10 Ø 15.87 mm	13N13	13N13SC	-	-	53N61S-10	-	-	-

i Parts

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The End-Connector

Available for all standard welding machines

Variants

A and B Model size

DIN Norm

CE EN 60 974-7

TIGZONE AQ-27 – Torch / Back End Consumables



Torch Front Group

1	Torch Body	
.1	AQ-27A	AQ27A
.2	AQ-27B	AQ27B
.a	Barrel short	9" 27-10A
.b	Barrel long	20" 27-10B
.c	Screw Nylon one piece	27-19
.d	Screw Brass	27-10
.e	Washer Brass	27-11
.f	O-Ring (brass body)	27-2-4
2	Shaft Assembly	
.1	Short (A) Complete with O-Rings	27-13A
.2	Long (A) Complete with O-Rings	27-13B
.3	O-Ring (outer)	27-13-2
.4	O-Ring (inner)	27-13-3

Cable Group

4	Cable cover	
	leather	TZ-1028R-TIG
5	Cable cover	
	25x1.5mm	RS-25
6	Gas Hose	
	4m	40V82R-*
	4m SF	40V82R-SF-*
	8m	40V82RL-*
	8m SF	40V82RL-SF-*
7	Water Hose	
	4m	40V83R-*
	4m SF	40V83R-SF-*
	8m	40V83RL-*
	8m SF	40V83RL-SF-*
8	Power Cable	
	4m	40V84R-*
	4m SF	40V84R-SF-*
	8m	40V84RL-*
	8m SF	40V84RL-SF-*

* Please specify machine connections e.g. 1/4, 3/8 etc.

TIGZONE AQ-27 – Front End Consumables

i

Parts

These parts come in different **ma-terials, variants** and **sizes**.

For additional information see below.

10



11



14



i

The gas lens comes with preinstalled O-Ring and Gasket. On the right are the ordering numbers for the replacement parts.

12

O-Ring

Standard

181W89

13

Gasket

Standard

57N56

		
Size	10 Collet	11 Gas Lens
Ø 1/16" (1.6 mm)	57N46	49V23
Ø 3/32" (2.4 mm)	57N47	49V24
Ø 1/8" (3.2 mm)	57N48	49V25
Ø 5/32" (4.0 mm)	57N49	49V26
Ø 3/16" (4.8 mm)	57N50	49V27
Ø 1/4" (6.4 mm)	57N51	49V28

					
Size	14 Cup (47,62 mm)	14 Super Cup (Sil.Nitride)	14 Cup L (70 mm)	14 Cup XL (84 mm)	14 Cup XXL (122 mm)
#3	Ø 4.75 mm	-	-	-	-
#4	Ø 6.35 mm	-	-	-	-
#5	Ø 7.93 mm	-	-	-	-
#6	Ø 9.52 mm	57N75	57N75SC	57N75L	57N75XL
#7	Ø 11.11 mm	-	-	-	-
#8	Ø 12.70 mm	57N74	57N74SC	57N74L	57N74XL
#10	Ø 15.87 mm	53N88	53N88SC	53N88L	53N88XL
#12	Ø 19.05 mm	53N87	53N87SC	53N87L	53N87XL