



TBi PP-TX

Push-Pull welding torch

Compact and ergonomic handle

Powerful wire transport

TX quick-change system for torch neck

Rating

TBi PP-TX 360
Gas cooled
60% (10 min.)
Mix: 260 A
CO₂: 310 A

TBi PP-TX 411
Water cooled
100% (10 min.)
Mix: 350 A
CO₂: 400 A

TBi PP-TX 511-CC
Water cooled
100% (10 min.)
Mix: 450 A
CO₂: 500 A

The torch neck TBi 511-CC-TX provides additional cooling of the gas nozzle. It is the recommended choice for aluminum welding.

Torch rating will be reduced when using pulsed-arc power sources.

Technical Data

Wire diameter	0.8 - 1.6 mm
Wire feed speed	approx. 2.5 to 18 m/min (depends on electrical connection of the torch)
Gas flow	16 l/min
Technical specification	according to IEC 60974-7
Weight with 1.5 m cable	2.65 kg
Connection	Euro-Central connector Other connectors are available upon request.



Options

- 2 potentiometers (each 10 kOhm). Other versions with 1, 2.2, 4.7 kOhm are available upon request.
- Connection via TBi Syntronic for even better feeding properties.

TBi PP-TX

Ordering information for torches

TBi PP-TX 360	without poti	2 potis (10 kOhm)
straight neck	185PB710_0*	185PB711_0*
40° bent	185PB720_0*	185PB721_0*

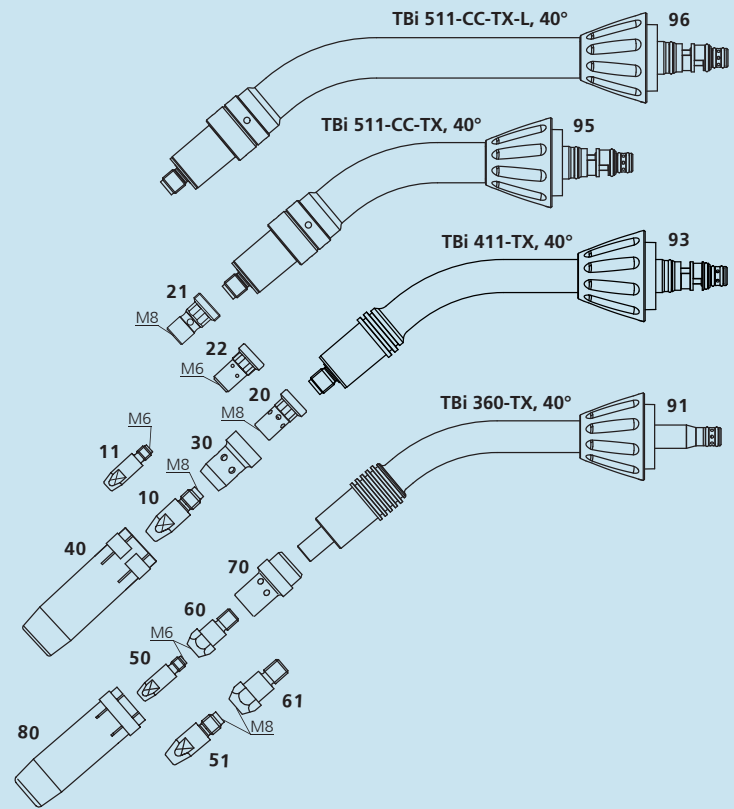
TBi PP-TX 411	without poti	2 potis (10 kOhm)
straight neck	195PB710_0*	195PB711_0*
40° bent	195PB720_0*	195PB721_0*

TBi PP-TX 511-CC	without poti	2 potis (10 kOhm)
straight neck	195PB730_0*	195PB731_0*
40° bent	195PB740_0*	195PB741_0*

* At the blank, please insert 6, 8, A or C for a torch length of 6 m, 8 m, 10 m or 12 m.



The torch comes equipped for aluminum wire Ø 1.2 mm and with P/C board (Pos. 120). Please order other required parts separately.



Consumables TBi 411/511-CC

Contact tips

	Pos.	Part no.
	10	Alu, ECu, M8 x 30 341P__1262**
		ECu, M8x30 340P__1262**
		CuCrZr, M8x30 340P__3262**
	Pos.	Part no.
	11	Alu, ECu, M6x28 341P__1069**
		ECu, M6x28 340P__1069**
		CuCrZr, M6x28 340P__3069**

Tip holder

	Pos.	Part no.
	20	for contact tip M8 342P008033
		for contact tip M8, Ms 4 mm longer version 342P008133
	21	for contact tip M8, CuCrZr, 342P008171
		for heavy duty use
	Pos.	Part no.
	22	for contact tip M6 342P006033
		for contact tip M6, 4 mm longer version 342P006133

Consumables TBi 360

Contact tips

	Pos.	Part no.
	50	Alu, ECu, M6 x 28 341P__1069**
		ECu, M6x28 340P__1069**
		CuCrZr, M6x28 340P__3069**
	Pos.	Part no.
	51	Alu, ECu, M8x30 341P__1262**
		ECu, M8x30 340P__1262**
		CuCrZr, M8x30 340P__3262**

Tip holder

	Pos.	Part no.
	60	for contact tip M6 342P006014
		for contact tip M6, 4 mm longer version 342P006114
	Pos.	Part no.
	61	for contact tip M8 342P008014
		for contact tip M8, 6 mm longer version 342P008114

** At the blank, please insert suitable information for wire diameter, e.g. 08 for 0.8 mm.

Torch necks

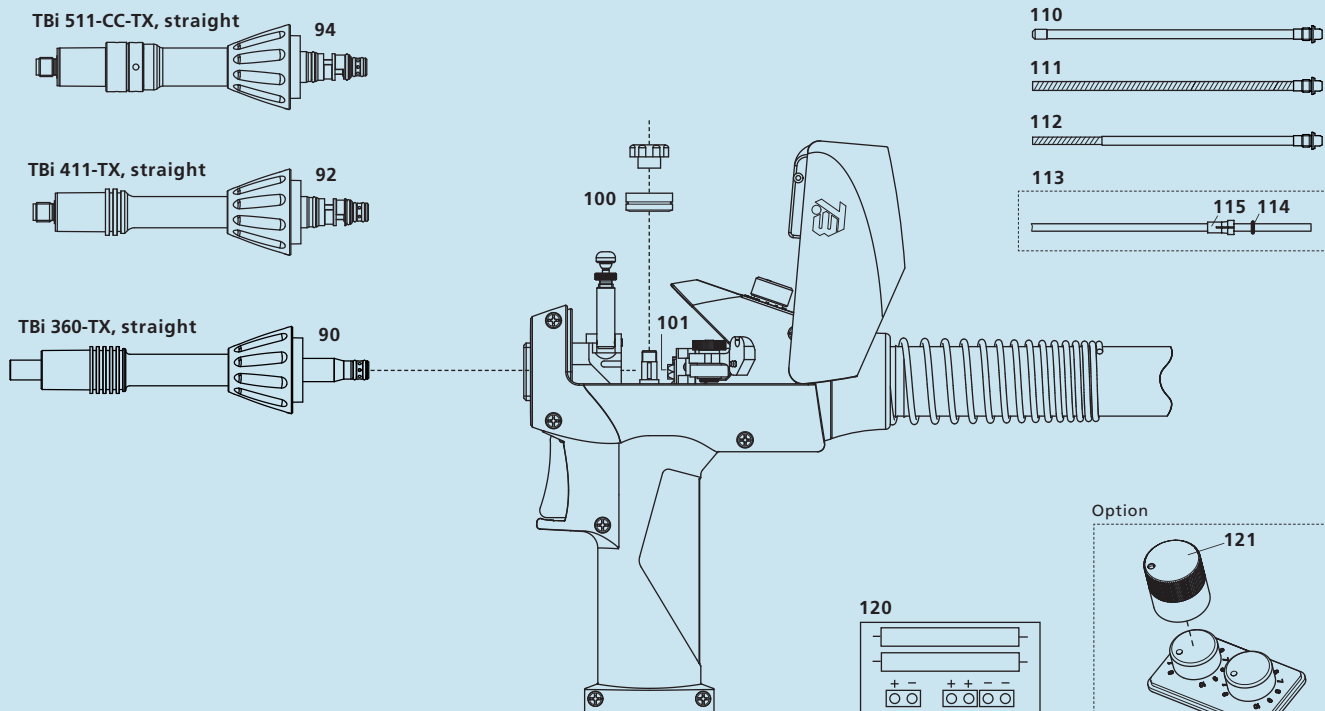
Pos.	Description	Part no.
90	Torch neck TBi 360-TX, straight	185P001001
91	Torch neck TBi 360-TX, 40° bent	185P001002
92	Torch neck TBi 411-TX, straight	195P001001
93	Torch neck TBi 411-TX, 40° bent	195P001002
94	Torch neck TBi 511-CC-TX, straight	195P001003
95	Torch neck TBi 511-CC-TX, 40° bent	195P001004
96	Torch neck TBi 511-CC-TX-L, 40° bent, long version	195P001005

► = Standard equipment

■ = Includes tip holder M8, CuCrZr, part no. 342P008171

Spare parts and accessories

Pos.	Description	Part no.
100	Feed roll for wire 0.8 mm	185P101030
100	Feed roll for wire 0.9 mm	185P101034
100	Feed roll for wire 1.0 mm	185P101031
► 100	Feed roll for wire 1.2 mm 185P101032	
100	Feed roll for wire 1.4 mm	185P101035
100	Feed roll for wire 1.6 mm	185P101033
101	Wire guide 0.8 – 1.6 mm	195P102052
120	P/C board for connection to main drive motor	181P001016
121	Extension for pot. knob (1 piece)	195P102086

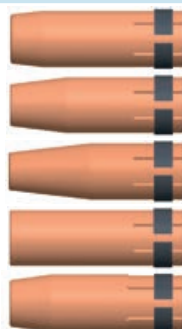


Gas diffuser



Pos.		Part no.
▶ 30	thermoset, black, very robust	130P002026
	ceramic, white, extremely heat resistant	130P002019

Gas nozzle



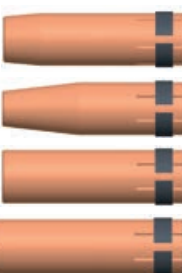
Pos.		Part no.
▶ 40	conical, NW 16 mm L= 75.5 mm	345P012030
41	conical, NW 14 mm L= 75.5 mm	345P013030
42	conical, NW 12 mm only for M6, L= 75.5 mm	345P016030
43	zylindrisch, NW 20 mm L= 75.5 mm	345P011030
	conical, NW 16 mm Heavy Duty, L= 75.5 mm	345P012032

Gas diffuser



Pos.		Part no.
▶ 70	thermoset, black, very robust	114P002007
	ceramic, white, extremely heat resistant	114P002005

Gas nozzle



Pos.		Part no.
▶ 80	conical, NW 16 mm L= 83.5 mm	345P012010
81	conical, NW 12 mm L= 83.5 mm	345P013010
82	cylindrical, NW 20 mm L= 83.5 mm	345P011010
83	spot welding nozzle NW 20 mm, L= 90 mm	345P015010

Wire guide sets for torch neck

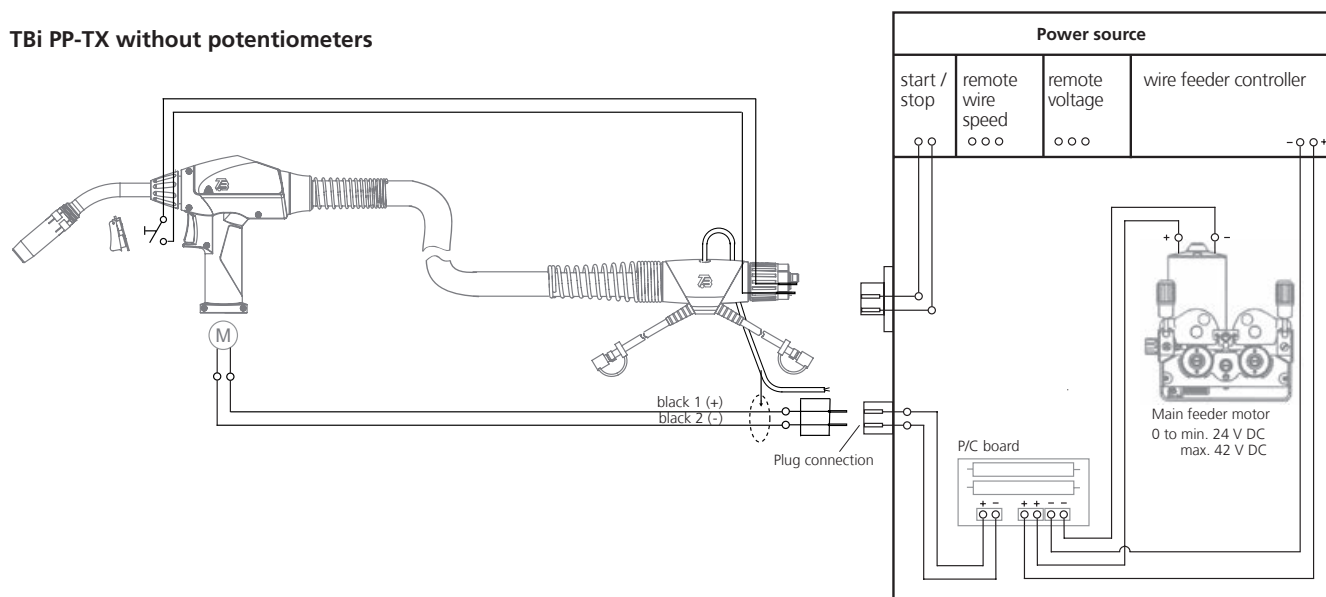
Pos.	Description	for wire	colour of end fitting	Part no.
▶ 110	PA liners, anthracite for alu-/stainless steel wire assembled, 300 mm	0.8 - 1.0 mm	white	185P101025
		1.2 mm	black	185P101018
		1.6 mm	yellow	185P101024
111	bronze liner, not insul. for alu-/stainless steel wire assembled, 300 mm	0.8 - 1.0 mm	white	185P101017
		1.2 mm	black	185P101019
		1.6 mm	yellow	185P101022
112	insulated liners for steel wire assembled, 300 mm	0.8 - 1.0 mm	blue	185P101027
		1.2 mm	red	185P101028
		1.6 mm	yellow	185P101023

Wire guides for cable assembly

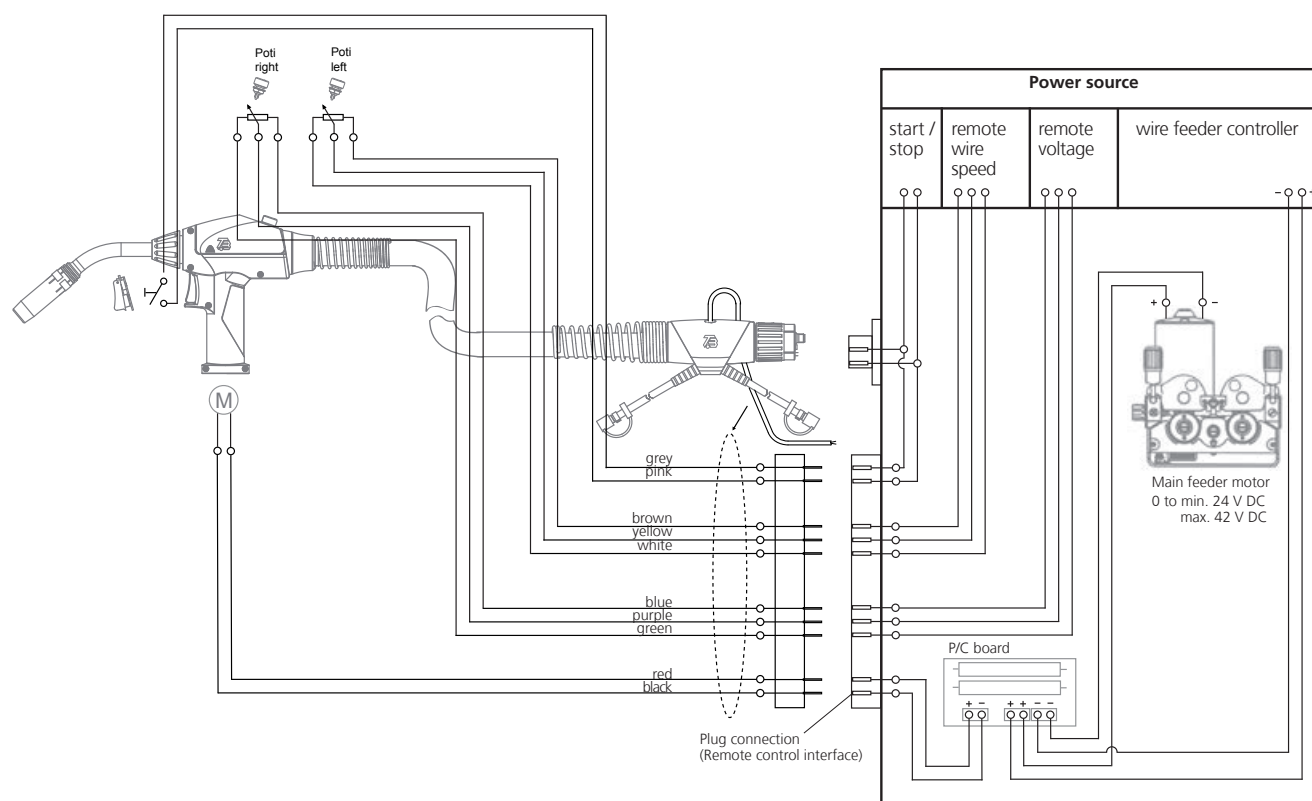
Pos.	Description	for wire	length	Part no.
▶ 113	PA liners, anthracite for all types of wire assembled	0.8 - 1.6 mm	6.5 m	328P294765
			8.5 m	328P294785
			10.5 m	328P2947A5
			12.5 m	328P2947C5
114	O-ring 3.50x1.50 mm (for PTFE-liner)			365P150035
115	Collet for liner 4.7 mm			331P027047

Connection Diagrams

TBi PP-TX without potentiometers



TBi PP-TX with potentiometers



For very high demands regarding the wire feeding quality, we recommend to install the optional TBi Syntronic. This unit allows to precisely adjust the wire feeding speed of main and push-pull motors over a wide range of wire feed speeds.